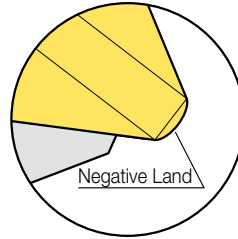


A multifunction cutter capable of both spot drilling and chamfering.

- Prevents chipping during spot drilling.
- Immediate chip evacuation with coolant.

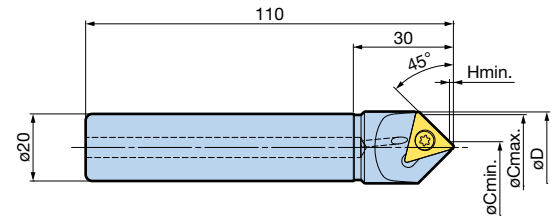


As the nose radius on the insert forms negative land, it has high chipping resistance, and the tool life is significantly extended.

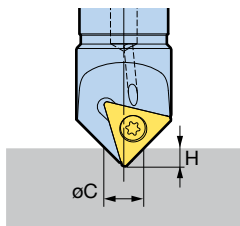
● Model Description

ST20 - **CN** **02** **20** - **45** - **110**

- Total length
- Chamfering angle
- Max. chamfer diameter
- Min. bore
- C-CENTERING CUTTER
- Shank type



● Spot Drilling Depth Calculation Method



$$H = (\phi C - \phi C_{min}) \div 2 + H_{min}$$

Model	øD	Min. bore øCmin.	Max. chamfer diameter øCmax.	Hmin.	Insert Model
ST20-CN0220-45-110	22	2	20	0.3	CN0906

1. A wrench and screws are included. Inserts must be ordered separately.
2. As the insert has a nose radius, spot drilled tip is not acute.
3. Use with hand feed is not recommended.

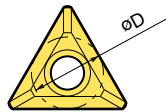
<Insert> (optional)



● Model Description

CN **09** **06** **ACM250F**

- Grade
- Corner radius
- Insert size
- C-CENTERING CUTTER



Model	Inscribed Circle øD	Insert Grade		Insert Clamp Screw Set Model
		ACM250F ^{NEW} (for steel/cast iron/stainless steel)	DS20 ^{NEW} (for aluminum)	
CN0906	9.525	○	○	S4S-15IP

1. Inserts are available in packets of 10 pcs. Please specify the insert model number and grade when ordering.
Example: CN0906 ACM250F... 10 Pcs
2. The insert clamping screw set contains 10 screws and 1 wrench.
3. Insert clamp screws and tightening wrench are consumables. Order periodically for replacement or spares.

Insert Grade Description

ACM250F	DS20
For steel/cast iron/stainless steel	For aluminum
PVD-coated carbide with excellent smoothness and resistance to welding and chipping, due to the ultra-multilayered thin film structure made of AlTiN and TiAlCrN.	DLC-coated carbide exclusive for aluminum and non-ferrous metals, ultra-smooth with a low wear coefficient and superior welding resistance.

Cutting Conditions

Workpiece Material	Cutting Speed Vc (m/min)	Feed (mm/rev)	
		Spot Drilling	Traverse Chamfering
Carbon Steel, Alloy Steel	50 - 150	0.02 - 0.08	0.05 - 0.2
Stainless Steel	50 - 120	0.02 - 0.05	
Cast Iron	70 - 200	0.02 - 0.08	
Aluminum, Non-ferrous	100 - 300		

1. This table is a guideline for selecting cutting parameters. Adjust them as needed according to the machine and workpiece conditions.
2. Be sure to use water-soluble cutting fluid during spot drilling.
3. For traverse chamfering, dry cutting (including air blowing) is recommended. However, if severe built-up edge occurs in aluminum machining, use water-soluble cutting fluid.

[Triple Insert Type]

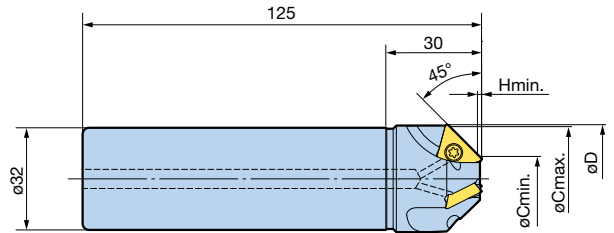
- Effective for traverse chamfering!
- Immediate chip evacuation with coolant



● Model Description

ST32 - **CN** **14** **33** - **45** - **125**

- Total length
- Chamfering angle
- Max. chamfer diameter
- Min. bore
- C-CENTERING CUTTER
- Shank type



Model	øD	Min. bore øCmin.	Max. chamfer diameter øCmax.	Hmin.	Insert Model
ST32-CN1433-45-125	34	14	33	0.6	CN0906

1. A wrench and screws are included. Inserts must be ordered separately.



Caution

Spot drilling (centering) is not available.

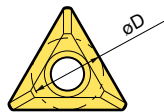
<Insert> (optional)



● Model Description

CN **09** **06** **ACM250F**

- Grade
- Corner radius
- Insert size
- C-CENTERING CUTTER



Model	Inscribed Circle øD	Insert Grade		Insert Clamping Screw Set Model
		ACM250F ^{NEW} (for steel/cast iron/stainless steel)	DS20 ^{NEW} (for aluminum)	
CN0906	9.525	○	○	S4S-15IP

1. Inserts are available in packets of 10 pcs. Please specify the insert model number and grade when ordering.
Example: CN0906 ACM250F... 10 Pcs
2. The insert clamping screw set contains 10 screws and 1 wrench.
3. Insert clamp screws and tightening wrench are consumables. Order periodically for replacement or spares.

Insert Grade Description

ACM250F	DS20
For steel/cast iron/stainless steel	For aluminum
PVD-coated carbide with excellent smoothness and resistance to welding and chipping, due to the ultra-multilayered thin film structure made of AlTiN and TiAlCrN.	DLC-coated carbide exclusive for aluminum and non-ferrous metals, ultra-smooth with a low wear coefficient and superior welding resistance.

Cutting Conditions

Workpiece Material	Cutting Speed Vc (m/min)	Feed (mm/tooth)
		Traverse Chamfering
Carbon Steel, Alloy Steel	50 - 150	0.05 - 0.2
Stainless Steel	50 - 120	
Cast Iron	70 - 200	
Aluminum	100 - 300	

1. This table is a guideline for selecting cutting parameters. Adjust them as needed according to the machine and workpiece conditions.
2. For traverse chamfering, dry cutting (including air blowing) is recommended. However, if severe built-up edge occurs in aluminum machining, use water-soluble cutting fluid.