

Covers wide range of chamfering diameters and reduces the number of tools and ATC required.

- With design exclusive for chamfering, the insert has a large rake angle and produces clean chamfering surface.
- Wide machining range reduces the number of tools in the magazine and is especially effective for reducing ATC time loss.

Cylindrical Shank Registered Design

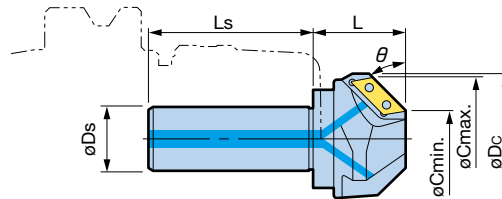
[30°/45°/60° Type]

We recommend the **BIG** NEW BABY CHUCK for chucking.

We recommend the **BIG** NEW HI- POWER MILLING CHUCK for chucking.



Center through



● Model Description

ST32 - **C** **16** **52** **C** - **30**

- Chamfering angle (Blank for 45°)
- Center through
- Max. chamfering diameter
- Min. bore
- C-CUTTER
- Shank type

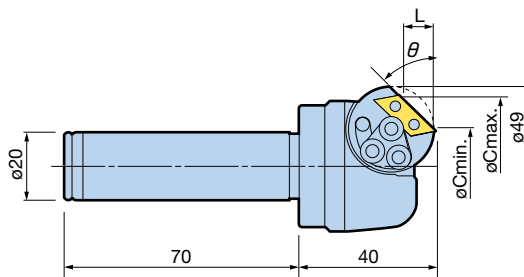
Chamfering angle θ	Model	ϕD_s	Min. hole $\phi C_{min.}$	Max. chamfer diameter $\phi C_{max.}$	Outer diameter ϕD_c	L	Ls	Number of inserts	Applicable Insert
30°	ST32-C1652C-30	32	16	52	68	48	80	2	CW1909A
	ST42-C5085C-30	42	50	85	96	52	80	3	
45°	ST20-C0525C	20	5	25	33	25	60	1	CW1206A
	ST25-C1040C	25	10	40	45	35	70	2	CW1909A
	ST32-C3060C	32	30	60	65	45	80	3	
	ST42-C50100C	42	50	100	106	70	80	3	CW3115A
60°	ST25-C1434C-60	25	14	34	38	37	70	2	CW1909A
	ST32-C3050C-60	32	30	50	54	45	80	3	
	ST32-C4565C-60	32	45	65	69	50	80	3	

1. Inserts must be ordered separately.
2. Insert clamping screws and wrench are included.

For inserts, **J37**

[Universal Type]

Handles chamfering angles from 5° to 85°.



Model **ST20-C5/85A-40**

Compatible insert: **CW1206A**

For inserts, **J37**

● Model Description

ST20 - **C** **5 / 85** **A** - **40**

- Chamfering angle adjustment amount
- C-CUTTER
- Shank type

[Chamfering Range]

Chamfering angle θ	Min. hole $\phi C_{min.}$	Max. chamfer diameter $\phi C_{max.}$	L	Chamfering angle θ	Min. hole $\phi C_{min.}$	Max. chamfer diameter $\phi C_{max.}$	L
5°	5.5	33.5	1.2	50°	24.0	42.2	10.8
10°	7.3	34.7	2.4	55°	26.4	42.4	11.4
15°	9.0	36.2	3.6	60°	28.5	42.5	12.1
20°	11.2	37.4	4.7	65°	30.7	42.4	12.5
25°	13.0	38.6	5.9	70°	32.9	42.1	12.6
30°	15.2	39.6	7.0	75°	34.9	41.7	12.7
35°	17.4	40.5	8.0	80°	36.9	41.1	11.9
40°	19.6	41.2	9.0	85°	38.8	40.3	8.6
45°	21.8	41.8	10.0				

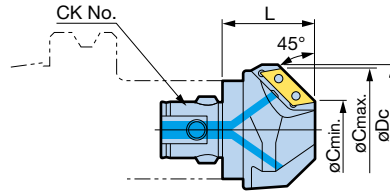
Chamfering range and L are reference only.
Measure accurate values with a presetter.

CHAMFERING TOOL C-CUTTER

CKB SHANK **BIG** + KAISER
BIG DASHIWA



Center through



● Model Description

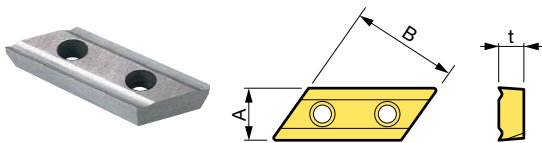
CKB2 - **C** **05** **25** **C**

- Center through
- Max. chamfering diameter
- Min. bore
- C-CUTTER
- CK No.

Chamfering angle θ	Model	CK No.	Min. hole $\phi C_{min.}$	Max. chamfer diameter $\phi C_{max.}$	Outer diameter ϕD_c	L	Number of inserts	Applicable Insert
45°	CKB2-C0525C	2	5.0	25.0	28.5	25	1	CW1206A
	CKB4-C1040C	4	10.0	40.0	45	35	2	CW1909A
	CKB5-C3060C	5	30.0	60.0	65	40	3	CW1909A
	CKB6-C50100C	6	50.0	100.0	106	65	3	CW3115A

1. Inserts must be ordered separately.
2. Insert clamping screws and wrench are included.

<Insert>



1 pcs

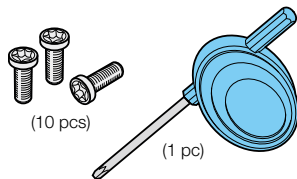
Model			A	B	t
Non-Coating	ZX Coating	DLC Coating			
CW1206A	CW1206A(ZX)	CW1206A(DLC)	6.35	12.7	2.7
CW1909A	CW1909A(ZX)	CW1909A(DLC)	9.525	19.05	4.5
CW3115A	CW3115A(ZX)	CW3115A(DLC)	15.875	31.75	7.0

10 pcs

Model		A	B	t
Non-Coating	ZX Coating			
CW1206A-10P	CW1206A(ZX)-10P	6.35	12.7	2.7
CW1909A-10P	CW1909A(ZX)-10P	9.525	19.05	4.5
CW3115A-10P	CW3115A(ZX)-10P	15.875	31.75	7.0

Non-Coating	Adopts P30-equivalent carbide material with emphasis on toughness for versatile use with materials from steel to aluminum.
ZX Coating	TiN and AlN multilayer coating increases speeds and extends insert life in chamfering of steel or cast iron.
DLC Coating	The exclusive substrate is treated with a thin DLC coating to prevent welding during aluminum machining. It retains sharpness and achieves a clean surface finish.

<Insert Clamping Screw Set>



Insert	Set Model	Wrench
CW1206A	S2S-B	FLR-13S
CW1909A	S3S	FLR-20S
CW3115A	S5S	FLR-28S

1. The set contains 10 screws and 1 wrench.
- ※ Wrenches are also available separately.

Cutting Conditions

Model	Max. chamfering amount	Chamfering mode	General Steels		Stainless Steel		Cast Iron		Aluminum	
			Vc	f	Vc	f	Vc	f	Vc	f
ST20-C5/85A-40	※ 2mm	Plunge	50	0.1	30	0.08	40	0.1	80	0.1
		Side	80	0.15	60	0.1	50	0.15	100	0.2
ST20-C0525C	C2	Plunge	50	0.1	30	0.08	40	0.1	80	0.1
		Side	80	0.15	60	0.1	50	0.15	100	0.15
ST25-C1040C	C3	Plunge	90	0.15	40	0.12	60	0.15	100	0.2
ST25-C1434C-60 ST32-C1652C-30	※ 3mm	Side	120	0.3	60	0.2	90	0.3	150	0.3
ST32-C3060C	C4	Plunge	120	0.3	60	0.18	90	0.25	150	0.3
ST32-C3050C-60 ST32-C4565C-60 ST42-C5085C-30	※ 4mm	Side	150	0.45	60	0.3	120	0.6	200	0.6
ST42-C50100C	C4	Plunge	150	0.4	80	0.25	120	0.35	180	0.4
		Side	150	0.45	60	0.36	120	0.6	240	0.6

Vc: Cutting speed (m/min), f = Feed per revolution (mm/rev)

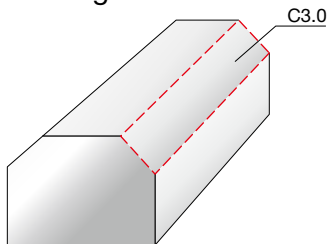
- Cutting conditions are the same for coated and non-coated inserts.
The use of coated inserts enables better surface finish and extended insert life.
- Lower the cutting speed if the maximum chamfering amount is exceeded.
- If plunge cutting produces long chips, use step feed.

- We recommend the use of a high-rigidity holder for chucking. (HMC, MEGA-D etc.)
- Max. chamfering amount for the 30°, 60° and Universal Types marked with ※ is the chamfering length of the longer side.

APPLICATION EXAMPLES

■ C3 traverse chamfering

S55C



A clean surface with no chatter was achieved even in traverse chamfering, under high cutting conditions.

C-Cutter Model	ST25-C1040C
Insert Model	CW1909A
Spindle speed n	3,000 min ⁻¹
Feed Vf	1,800mm/min