

Accurate positioning of drill holes and chamfering can be performed simultaneously.

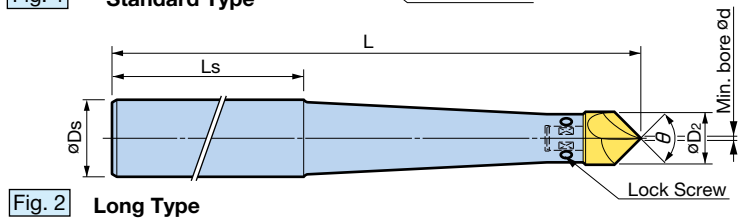
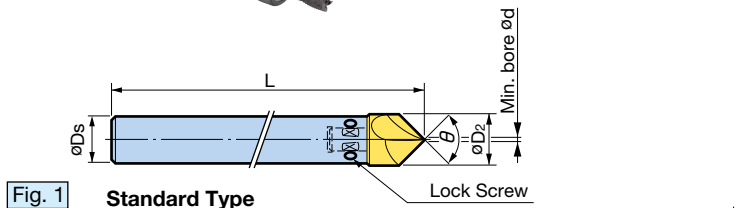
- Uses high-precision throwaway bit with superb sharpness.
- Since the cutting edge can be replaced, there is no need for regrinding and the performance remains stable at all times.
- Long shank type with less workpiece interference.



Chamfering angles 90° & 120°

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

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



The ● mark in the table indicates **long type**.

Chamfering angle $\theta$	Model	Fig.	$\phi D_s$	$\phi D_2$	$\phi d$	L	Ls	Compatible Bit Model	Spare Lock Screw (Optional)	
90°	ST10-CBY09010	1	10	10	0.9	150	-	CBY09010-5P	H0403-5P	
	ST12-CBY09013		12	13				CBY09013-5P		
	ST16-CBY09016		16	16	1.0	180		CBY09016-5P	H0504-5P	
	ST20-CBY09022		20	22				CBY09022-5P	H0505-5P	
	ST20-CBY09013-220 ●	2	20	13	0.9	220		120	CBY09013-5P	H0403-5P
	-260 ●					260			CBY09022-5P	
ST32-CBY09022-260 ●	260					1.5	300		CBY09022-5P	
-300 ●	32	22	CBY12013-5P	H0403-5P						
120°	ST12-CBY12013	1	12	13	0.9	150	-	CBY12013-5P	H0403-5P	

1. 2 throwaway bits are included.

2. Lock Screw is included. 5-piece sets are sold under the above model number for spare part orders.

⚠ Use with hand feed is not recommended.

### <Throwaway Bit>

Precision-finished cutting edge with superb sharpness.

Since the bit can be replaced, there is no need for regrinding and the performance remains stable at all times.



Chamfering angle $\theta$	Model	Compatible Body Model
90°	CBY09010-5P	ST10-CBY09010
	CBY09013-5P	ST12-CBY09013/ST20-CBY09013
	CBY09016-5P	ST16-CBY09016
	CBY09022-5P	ST20-CBY09022/ST32-CBY09022
120°	CBY12013-5P	ST12-CBY12013

· Bits are sold as 5-piece sets.

(Bit material) High-speed steel/TiN coating

### Cutting Conditions

Model	Chamfering						Centering					
	Steel		Cast Iron		Aluminum		Steel		Cast Iron		Aluminum	
	Vc	f	Vc	f	Vc	f	Vc	f	Vc	f	Vc	f
CBY09010...	20	0.1	20	0.12	45	0.15	25	0.08	30	0.1	50	0.15
CBY09013...	25		25		50		30		35		55	
CBY12013...	30		35		55		45		40		60	
CBY09016...	30		35		55		45		40		60	
CBY09022...	35		40		60		50		45		65	

1. Vc: Cutting speed (m/min) f: Feed (mm/rev).

2. The values in this table are only for reference and should be adjusted based on workpiece hardness, rigidity, and chamfering amount.

3. Lower the cutting speed Vc if chatter occurs.

4. Keep the projection length as short as possible.