



# BHJ Products, Inc.

## Parts List & Instructions

Product Name: **Flycutter Head**  
BHJ Part#: **FCH-2**

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Carbide (left) CBN (right)

### Description

The FCH-2 Flycutter Head makes fast work of surfacing cylinder heads and blocks while also adding versatility and value to milling machines for all types of general machining operations.

Both a Carbide cutter insert for machining aluminum and a CBN insert for use on cast iron are supplied with dedicated tool holders. The CBN Cutter Insert enables speeds and feeds of more than three times that of carbide inserts when used on cast iron. The single-cutter design allows quick changing from carbide to CBN cutting without losing the ability to cut quickly and accurately.

The 7" diameter Body can be adjusted to cut from 9" to 12" diameters and the 15-pound weight of the Head acts to dampen the cutting operation, resulting in a smooth, chatter-free cut.

An R-8 style Arbor is included standard, which allows the Cutter will fit the spindle of most vertical mills and other arbor styles are available as well.

### Kit Contents:

**1x** Flycutter Head with Arbor

**1x** Carbide Insert with Tool Holder

**1x** CBN Insert with Tool Holder

### Installation

Install the arbor into the mill's spindle and tighten into place using the draw bar in the same manner used to install a typical collet.

### Cutter Selection

Install either the carbide or CBN tool holder with insert, based on the material being machined. The carbide insert is designed for machining aluminum only and the CBN is for cast iron work.

### Cutter Head Diameter Set-Up

Establish and set the amount of cutter protrusion necessary for the diameter of cut needed and securely tighten the two Allen head bolts in the Cutter Head, using a 5/32" hex wrench.

### Speed and Feed Starting Point

The recommended starting point for machining is .005" depth of cut, 5 inches per minute feed and 500RPM speed. Settings may be increased from that point, based on condition of equipment, rigidity of setup and desired finish.