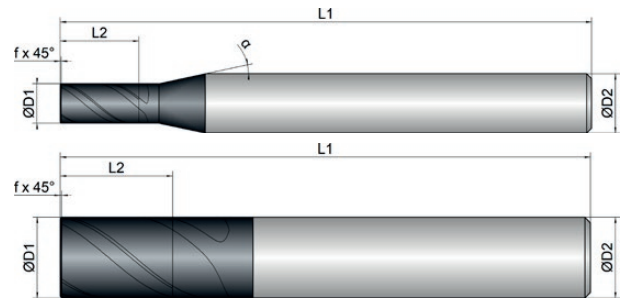
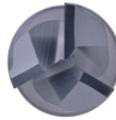


Cooling	
Tolerance	e8
Coating	BetaUni Iron

Strategy	HPC	UNI		
Application				
Features	HA	≠		



- Adapted clearance angle for reliable machining
- Unequal tooth pitch for smooth running
- Large chip chambers for good chip evacuation



Roughing



Finishing



BCU1-M01-0103	D1 mm ø	L2 mm	L1 mm	D2 mm ø	z #	45° mm	 °	α °
3	3.0	6.0	54.0	6.0	3	0.10	45	12
4	4.0	8.0	54.0	6.0	3	0.10	45	12
5	5.0	9.0	54.0	6.0	3	0.20	45	12
6	6.0	10.0	54.0	6.0	3	0.20	45	0
8	8.0	12.0	58.0	8.0	3	0.20	45	0
10	10.0	14.0	66.0	10.0	3	0.20	45	0
12	12.0	16.0	73.0	12.0	3	0.20	45	0
16	16.0	22.0	82.0	16.0	3	0.30	45	0
20	20.0	26.0	92.0	20.0	3	0.30	45	0



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Material	Strength (N/mm ²)	Dimension	Ø3		Ø4		Ø5		Ø6		Ø8		Ø10		
			ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	
Application		ap=1xD		ap=1xD		ap=1xD		ap=1xD		ap=1xD		ap=1xD			
Application															
Feed (mm/Z)		fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz		
Vc (m/min)															
P															
1.1-1.3	Steel, unalloyed	<850	170	0.02	0.025	0.02	0.025	0.03	0.035	0.04	0.045	0.05	0.06	0.055	0.07
2.1-2.2	Steel, low-alloyed	<950	160	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
3.1-3.2	Steel, high-alloyed	<1100	150	0.012	0.018	0.012	0.018	0.022	0.028	0.032	0.038	0.042	0.052	0.045	0.06
K															
1.1-1.2	Grey cast iron	<1000	190	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
M															
1.1	Inox, ferritic/martensitic	<850	75	0.018		0.02		0.028		0.035		0.052		0.06	
2.1	Inox, austenitic	<650	65	0.015		0.018		0.025		0.032		0.048		0.055	
N															
1.1-2.3	Alu, alloyed, casted	<600	360	0.02	0.025	0.025	0.04	0.04	0.045	0.045	0.065	0.065	0.085	0.085	0.11
3.1-3.3	Cooper, alloyed	<600	170	0.015	0.02	0.02	0.03	0.03	0.035	0.035	0.055	0.055	0.075	0.075	0.1
T															
2.1-2.2	Titanium, pure, alloyed	<1000	50	0.015		0.018		0.025		0.03		0.045		0.055	
S															
1.1-1.3	Super alloys	<1450	25	0.01		0.013		0.02		0.025		0.04		0.05	

Material	Strength (N/mm ²)	Dimension	Ø12		Ø16		Ø20							
			ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD						
Application		ap=1xD		ap=1xD		ap=1xD		ap=1xD		ap=1xD		ap=1xD		
Application														
Feed (mm/Z)		fz	fz	fz	fz	fz	fz							
Vc (m/min)														
P														
1.1-1.3	Steel, unalloyed	<850	170	0.06	0.08	0.07	0.09	0.09	0.11					
2.1-2.2	Steel, low-alloyed	<950	160	0.055	0.075	0.06	0.08	0.08	0.1					
3.1-3.2	Steel, high-alloyed	<1100	150	0.05	0.07	0.055	0.075	0.075	0.09					
K														
1.1-1.2	Grey cast iron	<1000	190	0.055	0.075	0.07	0.08	0.08	0.1					
M														
1.1	Inox, ferritic/martensitic	<850	75	0.07		0.075		0.09						
2.1	Inox, austenitic	<650	65	0.065		0.07		0.08						
N														
1.1-2.3	Alu, alloyed, casted	<600	360	0.11	0.13	0.12	0.14	0.13	0.15					
3.1-3.3	Cooper, alloyed	<600	170	0.1	0.12	0.11	0.13	0.12	0.14					
T														
2.1-2.2	Titanium, pure, alloyed	<1000	50	0.065		0.07		0.08						
S														
1.1-1.3	Super alloys	<1450	25	0.06		0.065		0.075						

NOTE | The values marked in turquoise are side applications!