

Cooling

Tolerance f8

Coating BetaUni Iron

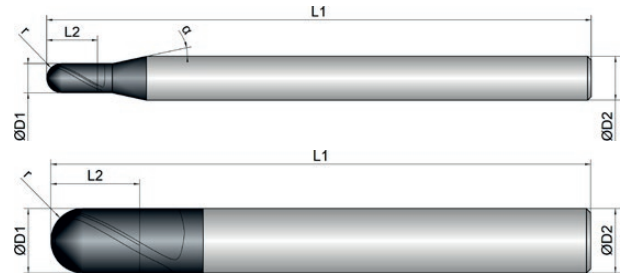
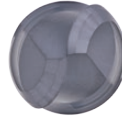
Strategy **HSC** **UNI**

Application

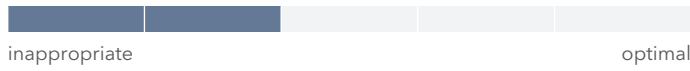
Features **HA**

Basic

- Geometry of the face cutting edge designed for a soft and even cut
 - Adapted chip chambers for roughing and finishing
-
- Suitable for wet and dry machining
-
- Long version



Roughing



Finishing



BCU1-M08-0063	D1 mm ø	L2 mm	L1 mm	D2 mm ø	z #	r mm	 °	α °
0,5	0.5	1.5	75.0	6.0	2	0.25	30	12
1	1.0	2.0	75.0	6.0	2	0.50	30	12
1,5	1.5	3.0	75.0	6.0	2	0.75	30	12
2	2.0	4.0	75.0	6.0	2	1.00	30	12
2,5	2.5	5.0	75.0	6.0	2	1.25	30	12
3	3.0	6.0	75.0	6.0	2	1.50	30	12
4	4.0	7.0	75.0	6.0	2	2.00	30	12
5	5.0	8.0	75.0	6.0	2	2.50	30	12
6	6.0	10.0	75.0	6.0	2	3.00	30	0
8	8.0	12.0	75.0	8.0	2	4.00	30	0
10	10.0	14.0	85.0	10.0	2	5.00	30	0
12	12.0	16.0	100.0	12.0	2	6.00	30	0



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		Dimension	Ø0.5	Ø1	Ø1.5	Ø2	Ø2.5	Ø3	Ø4	Ø5	Ø6	Ø8	
		Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	
		Application											
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
P		Vc (m/min)											
1.1-1.3	Steel, unalloyed	<850	270	0.01	0.02	0.03	0.04	0.045	0.05	0.06	0.07	0.085	0.12
2.1-2.2	Steel, low-alloyed	<950	220	0.008	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.08	0.11
3.1-3.2	Steel, high-alloyed	<1100	210	0.006	0.012	0.022	0.03	0.035	0.04	0.05	0.06	0.075	0.09
K		Vc (m/min)											
1.1-1.2	Grey cast iron	<1000	280	0.008	0.015	0.025	0.035	0.045	0.05	0.055	0.065	0.08	0.11
M		Vc (m/min)											
1.1	Inox, ferritic/martensitic	<850	90	0.01	0.015	0.02	0.025	0.03	0.035	0.045	0.05	0.06	0.075
2.1	Inox, austenitic	<650	75	0.008	0.012	0.015	0.02	0.025	0.03	0.04	0.045	0.055	0.07
N		Vc (m/min)											
1.1-2.3	Alu, alloyed, casted	<600	470	0.01	0.015	0.018	0.02	0.022	0.025	0.03	0.05	0.06	0.07
3.1-3.3	Cooper, alloyed	<600	200	0.008	0.01	0.012	0.015	0.018	0.02	0.026	0.04	0.05	0.06
T		Vc (m/min)											
2.1-2.2	Titanium, pure, alloyed	<1000	45	0.008	0.012	0.012	0.015	0.015	0.018	0.022	0.025	0.03	0.04
S		Vc (m/min)											
1.1-1.3	Super alloys	<1450	25	0.006	0.01	0.01	0.012	0.012	0.015	0.018	0.02	0.025	0.035

		Dimension	Ø10	Ø12								
		Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD								
		Application										
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz								
P		Vc (m/min)										
1.1-1.3	Steel, unalloyed	<850	270	0.13	0.14							
2.1-2.2	Steel, low-alloyed	<950	220	0.12	0.13							
3.1-3.2	Steel, high-alloyed	<1100	210	0.1	0.11							
K		Vc (m/min)										
1.1-1.2	Grey cast iron	<1000	280	0.12	0.13							
M		Vc (m/min)										
1.1	Inox, ferritic/martensitic	<850	90	0.09	0.1							
2.1	Inox, austenitic	<650	75	0.08	0.09							
N		Vc (m/min)										
1.1-2.3	Alu, alloyed, casted	<600	470	0.08	0.09							
3.1-3.3	Cooper, alloyed	<600	200	0.065	0.075							
T		Vc (m/min)										
2.1-2.2	Titanium, pure, alloyed	<1000	45	0.055	0.065							
S		Vc (m/min)										
1.1-1.3	Super alloys	<1450	25	0.045	0.055							

NOTE | The values marked in turquoise are side applications!