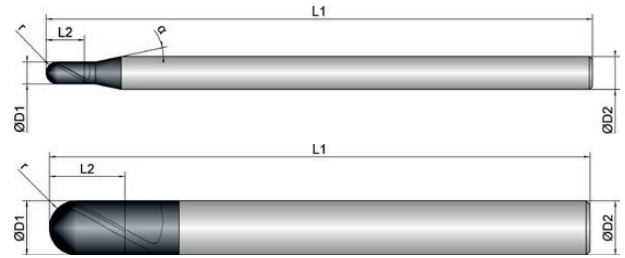
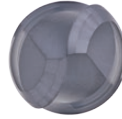


Cooling	
Tolerance	f8
Coating	BetaUni Iron

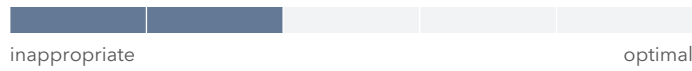
Strategy	HSC	UNI
Application		
Features	HA	



- 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
- 
- Overlong version



**Roughing**



**Finishing**



BCU1-M08-0073	D1 mm ∅	L2 mm	L1 mm	D2 mm ∅	z #	r mm		α °
1	1.0	2.0	100.0	6.0	2	0.50	30	12
1,5	1.5	3.0	100.0	6.0	2	0.75	30	12
2	2.0	4.0	100.0	6.0	2	1.00	30	12
2,5	2.5	5.0	100.0	6.0	2	1.25	30	12
3	3.0	6.0	100.0	6.0	2	1.50	30	12
4	4.0	7.0	100.0	6.0	2	2.00	30	12
5	5.0	8.0	100.0	6.0	2	2.50	30	12
6	6.0	10.0	100.0	6.0	2	3.00	30	0
8	8.0	12.0	100.0	8.0	2	4.00	30	0
10	10.0	14.0	100.0	10.0	2	5.00	30	0
12	12.0	16.0	120.0	12.0	2	6.00	30	0



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		Dimension	Ø1	Ø1.5	Ø2	Ø2.5	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	
		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 <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
P		Vc (m/min)											
1.1-1.3	Steel, unalloyed	<850	240	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.75	0.11	0.12
2.1-2.2	Steel, low-alloyed	<950	200	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
3.1-3.2	Steel, high-alloyed	<1100	195	0.01	0.015	0.025	0.03	0.035	0.045	0.055	0.065	0.08	0.09
K		Vc (m/min)											
1.1-1.2	Grey cast iron	<1000	260	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
M		Vc (m/min)											
1.1	Inox, ferritic/martensitic	<850	80	0.012	0.015	0.02	0.025	0.03	0.04	0.045	0.055	0.065	0.08
2.1	Inox, austenitic	<650	68	0.01	0.012	0.015	0.02	0.025	0.035	0.04	0.05	0.06	0.07
N		Vc (m/min)											
1.1-2.3	Alu, alloyed, casted	<600	440	0.012	0.015	0.018	0.02	0.025	0.03	0.045	0.055	0.065	0.075
3.1-3.3	Cooper, alloyed	<600	180	0.008	0.01	0.012	0.015	0.018	0.022	0.035	0.045	0.055	0.06
T		Vc (m/min)											
2.1-2.2	Titanium, pure, alloyed	<1000	40	0.01	0.01	0.012	0.012	0.015	0.02	0.022	0.025	0.035	0.05
S		Vc (m/min)											
1.1-1.3	Super alloys	<1450	20	0.008	0.008	0.01	0.01	0.012	0.015	0.018	0.022	0.03	0.045

		Dimension	Ø12	
		Infeed in mm	ae=0.05xD ap=0.05xD	
		Application		
Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	
P		Vc (m/min)		
1.1-1.3	Steel, unalloyed	<850	240	0.13
2.1-2.2	Steel, low-alloyed	<950	200	0.12
3.1-3.2	Steel, high-alloyed	<1100	195	0.1
K		Vc (m/min)		
1.1-1.2	Grey cast iron	<1000	260	0.12
M		Vc (m/min)		
1.1	Inox, ferritic/martensitic	<850	80	0.09
2.1	Inox, austenitic	<650	68	0.08
N		Vc (m/min)		
1.1-2.3	Alu, alloyed, casted	<600	440	0.085
3.1-3.3	Cooper, alloyed	<600	180	0.07
T		Vc (m/min)		
2.1-2.2	Titanium, pure, alloyed	<1000	40	0.06
S		Vc (m/min)		
1.1-1.3	Super alloys	<1450	20	0.05

**NOTE** | The values marked in turquoise are side applications!