

ITEM: B4F29

General multifunctional shouldering mills

Coupling type

Bore

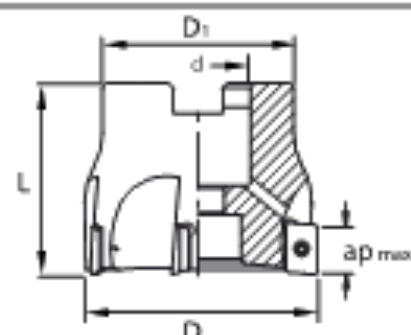
Insert type

APKT060204

Application

Square shouldering on carbon steel and stainless steel

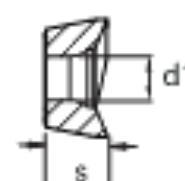
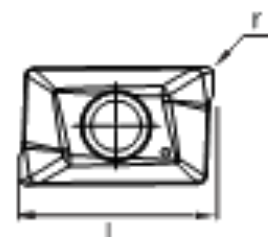
Ø32 ~ 50 mm



CYLINDRICAL SHANK CUTTERS

B4F29	Tech. Code	Z	D mm	d mm	L mm	D1 mm	Ap max mm	Air hole	Insert
	B4F293206Z8	8	32	16	40	31,5	5,2	With	APKT060204PDTR...
	B4F294006Z10	10	40	16	40	38,0	5,2	With	APKT060204PDTR...
	B4F295006Z11	11	50	22	40	48,0	5,2	With	APKT060204PDTR...

APKT 060204... l=6,0mm s=2,16mm
d1=2,06mm r=0,4mm



		Description	Grade	Tech. Code	P			M		K		N	S	H
					<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MEDIUM CUTTING	MR	APKT 060204PDR MR	PT35	B4E1206APMR10	●	●	○	○	○	○	○		○	

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Geometry	Cutting speed Vc (m/min)	Feed fz mm
Carbon steels (C45-C55 etc.)	~ 300HB	PT35	MR	160 - 230	0.05 - 0.12
Alloyed steel (42CRMo4, 17Cr3 etc.)	~ 300HB	PT35	MR	90 - 180	0.05 - 0.12
Hardened and tempered steels (NAK80, PX5 etc.)	30 ~ 40HRC	PT35	MR	80 - 160	0.05 - 0.12
Stainless steels (X5CrNi 18-9, etc.)	~ 200HB	PT35	MR	75 - 130	0.05 - 0.09