

ITEM: B6F20

Toroidal end mills with round inserts for face milling and pocketing.

Coupling type

Bore

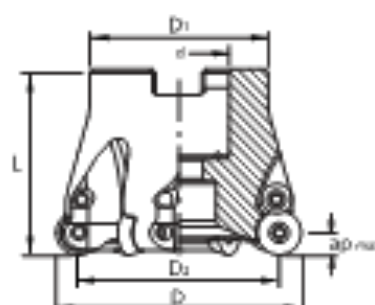
Insert type

RD...1003MO - RD...12T3MO

Application

Profiling and pocketing.

Ø40 ~ 66 mm

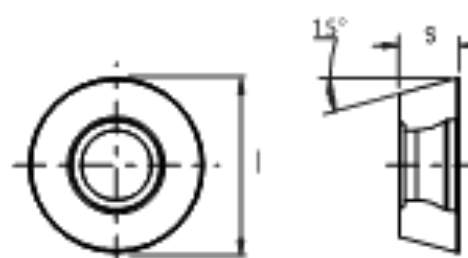


SHELL CUTTER

B6F20	Tech. Code	Z	D mm	D2 mm	d mm	L mm	D1 mm	Ap max mm	Air hole	Insert
Bore	B6F204010Z5	5	40	30	16	40	37	5	With	RDPX1003MO
	B6F205010Z6	6	50	40	22		50			
	B6F205210Z6		52	42		44				
	B6F204012Z4	4	40	28	16	40	37	6		RDPX12T3MO
	B6F205012Z5	5	50	38	22		50			
	B6F205212Z5		52	40						
	B6F206312Z6	6	63	51	27	50	60			
	B6F206612Z6		66	54						

KERFOLG GEOMETRY AND CUTTING CONDITIONS

RDPX 0702... l=7mm s=2,38mm
 RDPX 1003... l=10mm s=3,18mm
 RDPX 12T3... l=12mm s=3,97mm



		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
Roughing	MR	RDPX 0702MOSN MR	PH20	B6A2207RDMR01	○	●	●			●	○			●
		RDPX 1003MOSN MR		B6A2210RDMR02	○	●	●			●	○			●
		RDPX 12T3MOSN MR		B6A2212RDMR03	○	●	●			●	○			●
		RDPX 0702MOSN MR	PT20	B6A2207RDMR04		●	●	○		○				
		RDPX 1003MOSN MR		B6A2210RDMR05		●	●	○		○				
		RDPX 12T3MOSN MR		B6A2212RDMR06		●	●	○		○				

• RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnell HB	Priority	Recommended grades	Geometry	Cutting speed Vc (m/min.)	Insert r = 3.5 mm P.D.T. - fz	Insert r = 5 mm P.D.T. - fz	Insert r = 6 mm P.D.T. - fz
Alloyed steel (42CRMo4, 17Cr3 etc.)	~ 300HB	Roughing	PT20	MR	215 - 250	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
Hardened and tempered steels (NAK80, PX5 etc.)	30 ~ 40HRC	Roughing	PT20	MR	185 - 215	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
Hardened steels	40 ~ 50HRC	Roughing	PH20	MR	140 - 175	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80
	50 ~ 56HRC	Roughing	PH20	MR	115 - 140	0.25 - 0.40	0.30 - 0.50	0.65 - 0.80

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA192	RDPX 0702MOSN...	Clamping insert screw	BRICA192
BRICA193	RDPX 1003MOSN... - RDPX 12T3MOSN...		BRICA193
BRICA195	RDPX 12T3MOSN...	Clamping screw	BRICA195