

ITEM: B8F20

Indexable mills for chamfering and countersinking

Coupling type

Weldon

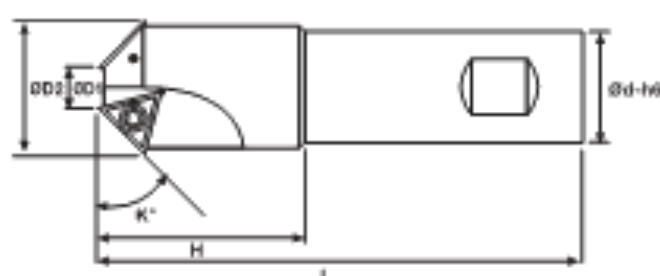
Insert type

TCMT1102... TCMT16T3...

Application

Chamfering, centering, 45° V grooving

Ø1,2 ~ 20 mm



WELDON

B8F20	Tech. Code	Z	D1 mm	D2 mm	L mm	H mm	d h6 mm	k°	Air hole	Insert
TCMT	B8F20161,2	1	1.2	16	70	20	12	45°	With	TC...1102
	B8F20216,2	2	6.2	21	90	35	20			TC...16T3
	B8F203210,4		10.4	32,5	100	42	25			

WELDON

B8F23	Tech. Code	Z	D1 mm	D2 mm	L mm	H mm	d h6 mm	k°	Air hole	Insert
TCMT	B8F23165,4	1	5.4	16	70	20	12	60°	With	TC...1102
	B8F232615,8	2	15.8	26	90	35	20			TC...16T3
	B8F233520		20	35	100	39	25			

SPARE PARTS

Tech. Code	Description	Insert	Tech. Code	Description	Insert
BRICA003	Insert screw	TCMX16T3ZR...	BRICA004	Screwdriver	TCMX16T3ZR...
BRICA001		TCMT1102...	BRICA002		TCMT1102...
BRICA003		TCMT16T3...	BRICA004		TCMT16T3...

KERFOLG® GEOMETRY AND CUTTING CONDITIONS

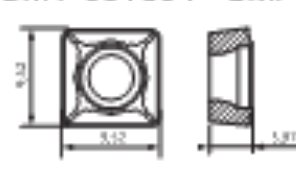
TCMT 110204 - CMP



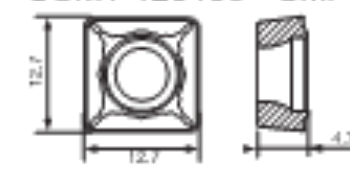
TCMT 16T304 - CMP



SCMT 09T304 - CMP



SCMT 120408 - CMP



		Description	Grade	Tech. Code	Dep. mm	Feed mm/rev	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
							240	180	160	140	110	210	150			
MEDIUM CUTTING	CMP	TCMT 110204-CMP	4125	B1T56TCCMP10	1,00 1,50 2,50	0,12 0,18 0,25	200	160	120	140	100					
			4135	B1T56TCCMP11			240	180	160	140	110	210	150			
			4125	B1T56TCCMP12			240	180	160	140	110	210	150			
			4135	B1T56TCCMP13			200	160	120	140	100					
		TCMT 16T304-CMP	4125	B1S55SCCMP10			240	180	160	140	110	210	150			
			4135	B1S55SCCMP13			240	180	160	140	110	210	150			
			4125	B1S55SCCMP10			240	180	160	140	110	210	150			
			4135	B1S55SCCMP14			200	160	120	140	100					
		SCMT 09T304-CMP	4125	B1S55SCCMP10			240	180	160	140	110	210	150			
			4135	B1S55SCCMP13			240	180	160	140	110	210	150			
			4125	B1S55SCCMP10			240	180	160	140	110	210	150			
			4135	B1S55SCCMP14			200	160	120	140	100					

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Vc (m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	P35	240	0,08 - 0,11 - 0,15
High carbon content steel (C45, C55, etc.)	~ 300	P35	180	0,08 - 0,11 - 0,15
Tool steel (X155CrV Mo 12 1, etc.)	~ 300	P35	160	0,12 - 0,16 - 0,21
Stainless steel (X5CrNi 18-10, etc.)	-	2125	200	0,08 - 0,11 - 0,15
Cast Iron (GG25, GG30, GGG40 etc.)	150 ~ 250	P35	210	0,12 - 0,16 - 0,21