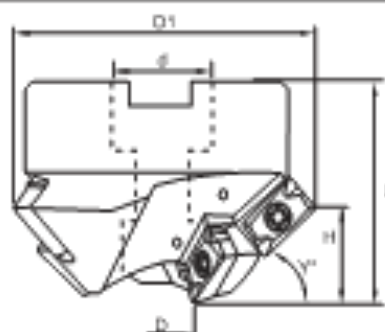


ITEM: B4F43

Multifunctional general purpose milling cutters for heavy chamfers

Coupling type Bore
Applicable inserts APKT1604...
Application Chamfering

Ø35 ~ 94 mm



	Tech. Code	Z	D mm	D1 mm	d mm	Y°	H mm	L mm	K	Air hole	Insert
Bore	B4F4315	6	35	94	27	15	8	50	3	With	APKT 1604...
	B4F4330			88		30	15				
	B4F4345			77,8		45	21,5				
	B4F4360			65		60	26,5				
	B4F4375			50,7	22	75	29,5	60			

RECOMMENDED GEOMETRIES AND APPLICATIONS



• RECOMMENDED FOR... ◦ USABLE FOR...

• RECOMMENDED FOR... ◦ USABLE FOR...

							P			M		K		N	S	H
			Description	Grade	Tech. Code		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
FINISH	MF		APKT 1604PDR - MF	MT35	B4F1116MFMT35			◦		●	●	◦				
				PT35	B4F1116MFPT35			●	◦	◦	◦	◦		◦		
MEDIUM CUT	MR		APKT 1604PDR - MR	PT25	B4F2116MRPT25		◦	◦	●			●	●			◦
				PT30	B4F2116MRPT30		●	●	●			●	◦		◦	
				PT35	B4F2116MRPT35		●	●	◦	◦	◦	◦	◦		◦	
	ALP		APKT 1604PDR - ALP	K10	B4F2216ALPK10								●			
	MR		APKT 1604PDR - MR	PT35	B4F2410MRPT35		●	●	◦	◦	◦	◦	◦		◦	

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed(m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	P30	150 - 200	0.10 - 0.25
	~ 180	P35	90 - 150	0.12 - 0.30
High carbon content steel (C45E, C55E, etc.)	~ 300	P30	150 - 200	0.10 - 0.25
	~ 300	P35	90-150	0.12 - 0.30
Tool steel (X155CrVMo 12 1, etc.)	~ 300	P30	150 - 200	0.10 - 0.25
	~ 300	P35	90-150	0.12 - 0.30
Stainless steel (X5CrNi 18-9, etc.)	-	M35	80-180	0.08 - 0.15
Cast iron (GG25, GG30, etc.) Spheroidal cast iron (GGG40, etc.)	150 - 250	P25	130 - 230	0.10 - 0.20
Non ferrous alloys (SI < 13%)	-	K10	200-1000	0.10 - 0.25
Hardened steel < 55 HRC	-	P25	30 - 50	0.06 - 0.10

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA003	All diameters	Clamping insert screw	BRICA003
BRICA004		Wrench	BRICA004
BRICA116		B4F20 bur's fastening screw Ø d22	BRICA116
BRICA238		B4F43 bur's fastening screw Ø d27	BRICA238