

KERFOLG® DISK END MILLS FOR THIN-LAYER CUTTING

Slot

ITEM: B7F13

Disk end mills for thin-layer cutting and grooving

Coupling type

with hole

Insert type

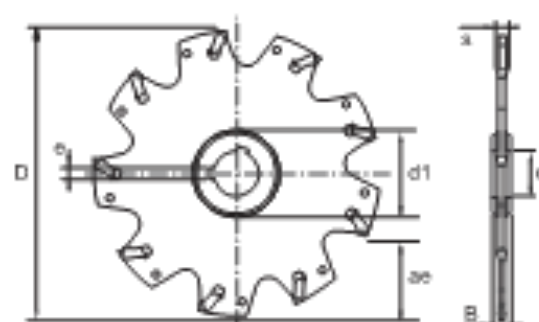
GCOM...

Application

Thin-layer cutting and grooving

Ø80 ~ 100 mm

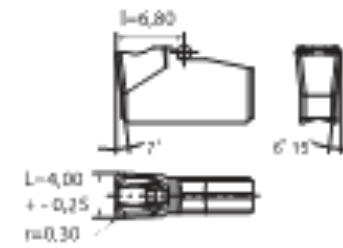
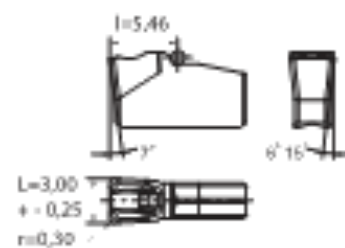
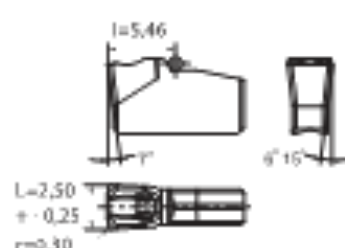
P M K N



CUTTER

B7F13	Tech. Code		Z	D mm	s mm	d mm	d1 mm	e mm	B mm	Max Ae mm	Air hole	Insert
Shaft	B7F138025		7	80	2.50	27	56	7	8	17	Without	B2T0025
	B7F138030				3.12							B2T0030
	B7F138040				4.12							B2T0040
	B7F1310030		8	100	3.12	32	52	8		24		B2T0030
	B7F1310040				4.12							B2T0040

KERFOLG® PARTING AND GROOVING INSERTS



CUT	MM	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
		GCOM0025	PT30	B2T0025	200	160	110	90	75	160	140			
		GCOM0030		B2T0030	200	160	110	90	75	160	140			
		GCOM0040		B2T0040	200	160	110	90	75	160	140			

• RECOMMENDED FOR... ◦ USABLE FOR...

RECOMMENDED CUTTING DATA

Materiale	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed (m/min.)	Feed fz/mm
Low carbon content steel (C15E, etc.)	~ 180	P30	140 - 220	0.08 - 0.16
High carbon content steel (C45E, C55E, etc.)	~ 300	P30	110 - 160	0.06 - 0.15
Tool steel (X155CrVMo 12 1, etc.)	~ 300	P30	90 - 130	0.05 - 0.10
Stainless steel (X5CrNi 18-9, etc.)	-	P30	80 - 120	0.05 - 0.10
Grey cast iron (GG25, GG30, etc.) Spheroidal cast iron (GGG40, etc.)	150 - 250	P30	100 - 180	0.08 - 0.16

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA140	All diameters	Assembly & disassembly key	BRICA140