

ITEM: B3F08

High productivity face milling of steel and stainless steel

Ø40 ~ 125 mm



S

Coupling type

Bore

Insert type

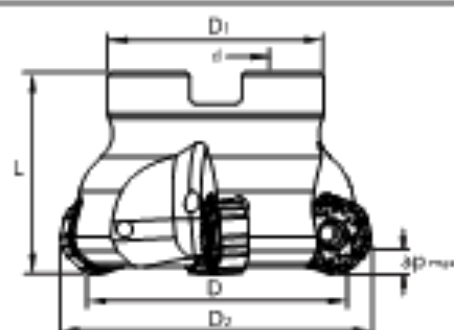
HNKU 08...

Application

Face milling on steel and stainless steel

Cutting angle

45°



SHELL MILL

B3F08	Tech. Code	Z	D mm	D2 mm	d mm	L mm	D1 mm	Ap max mm	Air hole	Insert
Bore	B3F084008Z4	4	40	52	16	40	38	4,0	With	HNKU0806AZER...
	B3F085008Z4		50	62	22		43			
	B3F086308Z5		63	75			48			
	B3F088008Z6	6	80	92	27	50	58			
	B3F0810008Z7	7	100	112	32		78			
	B3F0810008Z8	8								
	B3F0812508Z8		125	137	40	63	88			
	B3F0812508Z9	9								

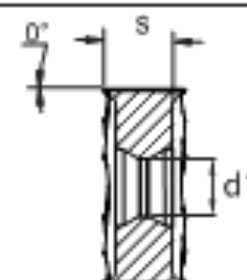
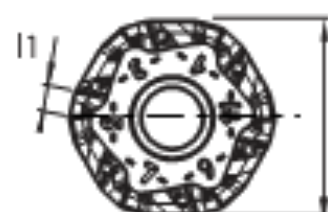
SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA196	HNKU0806AZER...	Clamping insert screw	BRICA196

KERFOLG® GEOMETRY AND CUTTING CONDITIONS

Face

HNKU 0806...

l=14,7mm
l1=1,5mms=5,3mm
d1=5,24mm

		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	MM	HNKU0806AZER-MM	PH35	B3P1008HNMM10	●	●	●	○	●	○				
			MT35	B3P1008HNMM15	●	○		●	●				○	
			ST35	B3P1008HNMM20	●			○	●				●	

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed (m/min.)	Geometry MM
Low carbon content steel (C15E, etc.)	~ 200	PH35	180 - 260	0.08 - 0.50
High carbon content steels (C45E, C55E etc.)	200 ~ 300	PH35	120 - 200	0.08 - 0.45
Alloyed steel (42CRMn4, 17Cr3 etc.)	200 ~ 300	PH35	60 - 160	0.08 - 0.40
Stainless steels (X5CrNi 18-9, etc.)	-	MT35	75 - 180	0.08 - 0.40
Heat resistant alloys (Inconel 718, Ti-6Al-4V etc.)	-	ST35	25 - 75	0.08 - 0.25