

KERFOLG® FACE MILLS FOR SINGLE-SIDE SQUARE INSERTS

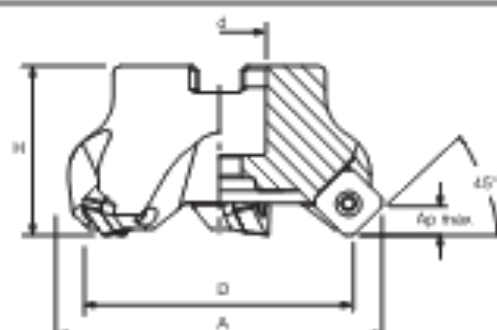
Face

ITEM: B3F06

General, multifunctional face mills

Coupling type Bore
Applicable inserts SEHX 1204
Application Face milling

Ø40 ~ 125 mm



SCREW INSERT CLAMPING SHELL END MILL

B3F06	Tech. Code		Z	D mm	d mm	A mm	H mm	Max Op. mm	Air hole	Insert
Bore	B3F0640Z3		3	40	16	53	40	6	With	SEHX 1204
	B3F0650Z4		4	50	22	63	48			
	B3F0663Z5		5	63		76				
	B3F0680Z6		6	80	27	93	50			
	B3F06100Z8		8	100	32	113				
	B3F06125Z9		9	125	40	138	63			

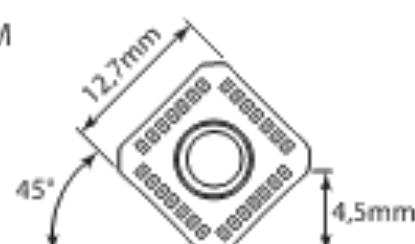
SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA130	All diameters	Insert screw	BRICA130
BRICA004		Wrench	BRICA004

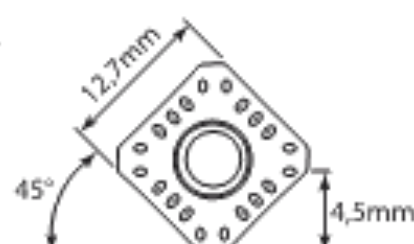
KERFOLG® GEOMETRY AND CUTTING CONDITIONS

Face

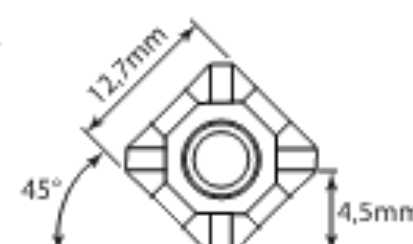
SEHX 1204...MM



SEHX 1204...ML



SEHX 1204...AL



							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
MED. CUT	MM		SEHX 1204 AFSN MM	PT30	B3B2112SNMM01		●	●	○	○		○				
	ML		SEHX 1204 AFSN ML	MT30	B3B2212SNML05		●	○	○	●	●			○		
	AL		SEHX 1204 AFFN AL	K10	B3B2312SNAL10								●			

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Recommended Grades	Geometry	Cutting speed Vc (m/min.)	Feed lz/mm
Low carbon content steel (C15, etc.)	~ 200	PT30	MM	180 - 250	0.08 - 0.25
High carbon content steel (C45, C55, etc.)	200 ~ 300	PT30	MM	150 - 200	0.08 - 0.25
Alloy steel 42CRMo4, 17Cr3, etc.	200 ~ 300	PT30	MM	150 - 230	0.08 - 0.25
Tool steel (X155CrVMo 12 1, etc.)	~ 300	PT30	MM	130 - 180	0.06 - 0.20
Stainless steel (X5CrNi 18-9, etc.)	-	MT30	ML	100 - 150	0.06 - 0.20
Grey cast iron (GG25, GG30, etc.)	150 ~ 250	PT30	MM	120 - 180	0.08 - 0.25
Spheroidal cast iron (GGG40, etc.)	150 ~ 250	PT30	MM	100 - 150	0.06 - 0.20
Non ferrous alloys (SI < 13%)	-	K10	AL	200 - 500	0.04 - 0.35
Non ferrous alloys (SI > 13%)	-	K10	AL	200 - 350	0.04 - 0.28