

ITEM: B7F30

Indexable mills for chamfering and centering

Coupling type

Weldon shank

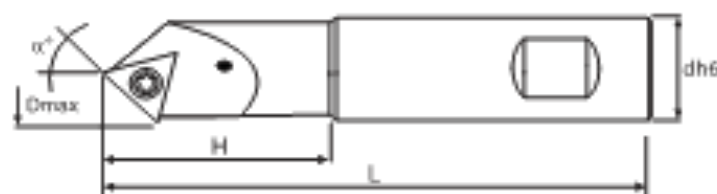
Insert type

TCMX16T3...

Application

Chamfering, centering 45° V grooving

Ø0,2 ~ 35 mm


WELDON SHANK

B7F30	Tech. Code	Z	D min mm	D max mm	L mm	H mm	d mm	α° mm	Air hole	Insert
TCMX	B7F3020115	1	0,4	20	115	40	20	45	With	TCMX16T3ZR
	B7F3020150				150	60				
	B7F3020200				200	80				

KERFOLG GEOMETRY AND CUTTING CONDITIONS

Cross

TCMX 16T3ZR



M. CUT.	ML	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
M. CUT.	ML	TCMX 16T3ZR-ML	P35	B1T22TCZR010	1,50	0,20	180	130	100	80						
					2,00	0,25										
					2,50	0,30										

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 (X155CrVMo 12 1, etc.)	~ 300	P35	160	0,12 - 0,16 - 0,21
Stainless steel (X5CrNi 18-19, etc.)	-	2125	200	0,08 - 0,11 - 0,15