

KERFOLG® TOOLHOLDERS FOR GROOVING AND CUTTING

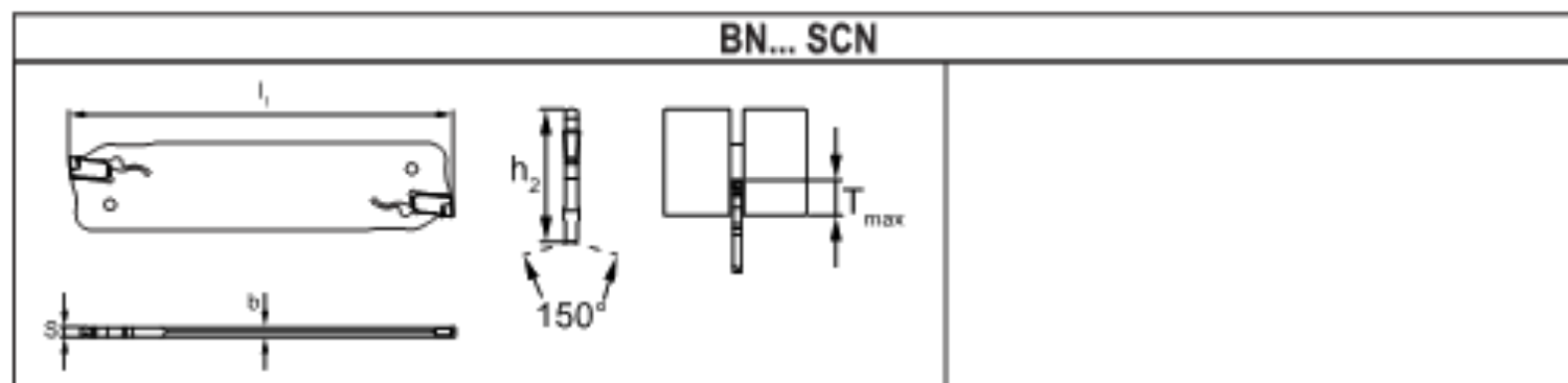
SCN...



ITEM: B2U25

Type
Dimension
Clamping system
Application

SCN...
3 - 4 mm
Flexible
Grooving and parting



								SPARE PARTS	
	Tech. Code	Description	h2 mm	b mm	s mm	l1 mm	T max mm	Inserts	Wrench
BN... SCN	B2U2526N03	BN3-26 SCN	26	2,4	3	110	35	SCN 3...	BRICA215
	B2U2526N04	BN4-26 SCN		3,2	4		40	SCN 4...	
	B2U2532N03	BN3-32 SCN	32	2,4	3	150	50	SCN 3...	
	B2U2532N04	BN4-32 SCN		3,2	4			SCN 4...	

KERFOLG® INSERTS FOR GROOVING AND PARTING - SINGLE SIDE



			Description	Degree	Tech. Code		s mm	a max mm	l mm	r mm	Tool Holders
PARTING	G1	SCN 3.00-0.20-G1	G135	B2T2503G101		3			11,3	0,2	BN3...SCN
			G145	B2T2503G102							
		SCN 4.00-0.30-G1	G135	B2T2504G101	4	13,3			0,3	BN4...SCN	
			G145	B2T2504G102							
	G2	SCN 3.00-0.30-G2	G135	B2T2603G201	3	2,0	11,3	BN3...SCN			
			G145	B2T2603G202							
		SCN 4.00-0.40-G2	G135	B2T2604G201	4	2,5	13,3	0,4	BN4...SCN		
			G145	B2T2604G202							
	S1		SCN 3.00-0.30-S1	G010	B2T2703S101		3		11,3	0,3	BN3...SCN
			SCN 4.00-0.40-S1		B2T2704S101		4		13,3	0,4	BN4...SCN

KERFOLG® RECOMMENDED CUTTING CONDITIONS

			P			M		K		N	S	H
Degree			<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
G135			110 - 190	110 - 180	70 - 160			90 - 180	80 - 150			
G145			80 - 150	70 - 120	60 - 110	70 - 120	50 - 100				25 - 50	
G010										200 - 2000		
Geometry for grooving and parting.			<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
G1 - First choice in parting steels and cast irons.			○	●	●	○		●	●			
G2 - Soft cut. First choice in case of varying materials.			●	●	○	●	●	○	○		●	
S1 - Very sharp geometry. For aluminum alloys.										●		

● RECOMMENDED FOR... ○ USABLE FOR...

	Geometry	Width of cut mm	Grooving infeed mm/rev						
GROOVING	G1	3							
		4							
	G2	3							
		4							
	S1	3							
		4							
			0	0.05	0.10	0.15	0.20	0.25	0.30

	Geometry	Width of cut mm	Max depth of cut mm	Turning infeed mm/rev						
	G2	3	2,0							
		4	2,5							
				0	0.05	0.10	0.15	0.20	0.25	0.30