

KERFOLG® HELICAL MILLS FOR HEAVY-DUTY CHAMFERING

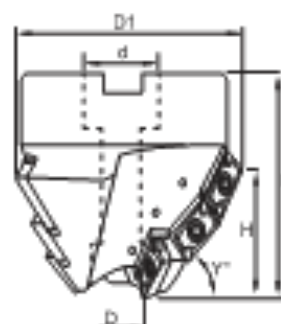
Helix

ITEM: B4F20

Heavy-duty chamfering end mills

Coupling type Bore
Applicable inserts APKT 1003
Application Chamfering

Ø17 - 65 mm

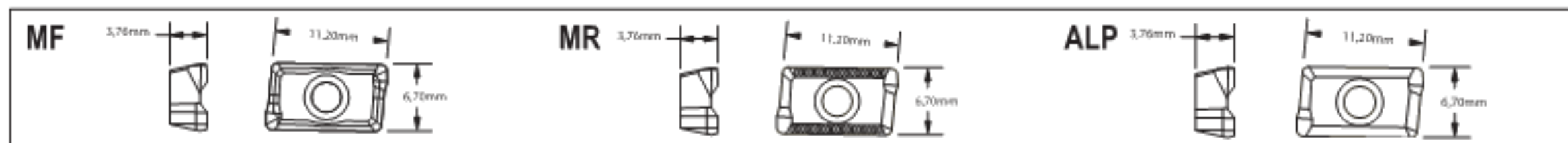


	Tech. Code	Z	D mm	D1 mm	d mm	Y°	H mm	L mm	K	Air hole	Insert
Bore	B4F2015	9	17	70	22	15	7	50	3	With	APKT1003
	B4F2030			65		30	13				
	B4F2045			56		45	19				
	B4F2060			45		60	24				
	B4F2075		19	33	16	75	27	60			

KERFOLG®

GEOMETRY AND CUTTING CONDITIONS

Wall



• RECOMMENDED FOR... ◦ USABLE FOR...

		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
FINISH	MF	APKT 1003PDER - MF	MT35	B4E1110MFMT35	●	○		●	●	○				
MEDIUM CUT	MR	APKT 1003PDR - MR	PT25	B4E2110MRPT25	○	○	●			●	●			○
		APKT 1003PDTR - MR	PT30	B4E2110MRPT30	●	●	●			●	○			○
		APKT 1003PDR - MR	PT35	B4E2110MRPT35	●	●	○	○	○	○	○		○	
	ALP	APKT 1003PDPR - ALP	K10	B4E2210ALPK10								●		
	MR	APKT 1003PDPR - MR	PT35	B4E2410MRPT35	●	●	○	○	○	○	○		○	

Tech. Code	Version	Description	Denomination
BRICA001	All diameters	Clamping insert screw	BRICA001
BRICA002		Wrench	BRICA002
BRICA084		B4F20 bur's fastening screw Ø d16	BRICA084
BRICA116		B4F20 bur's fastening screw Ø d22	BRICA116

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed (m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	P30	150 - 200	0.08 - 0.20
	~ 180	P35	90 - 150	0.08 - 0.25
High carbon content steel (C45E, C55E, etc.)	~ 300	P30	150 - 200	0.08 - 0.20
	~ 300	P35	90-150	0.08 - 0.25
Tool steel (X155CrMo 12 1, etc.)	~ 300	P30	150 - 200	0.08 - 0.20
	~ 300	P35	90-150	0.08 - 0.25
Stainless steel (X5CrNi 18-9, etc.)	-	M35	80-180	0.06 - 0.10
Cast iron (GG25, GG30, etc.) Spheroidal cast iron (GGG40, etc.)	150 - 250	P25	130 - 230	0.08 - 0.15
Non ferrous alloys (Si < 13%)	-	K10	200-1000	0.06 - 0.18
Hardened steel < 55 HRC	-	P25	30 - 50	0.05 - 0.08