

KERFOLG SINGLE SIDE SQUARE SHOULDERING SHELL MILLS

Triple

ITEM: B4F52

General multifunctional shouldering mills

Coupling type

Bore

Insert type

TOKX0703...

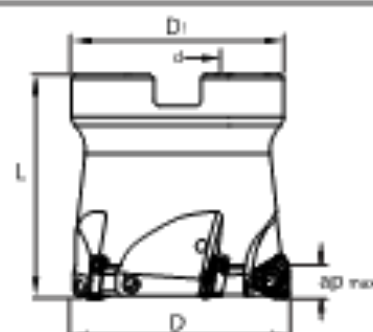
Application

Square shouldering on steel, stainless steel and super alloys.

Cutting angle

90°

Ø40 ~ 50 mm



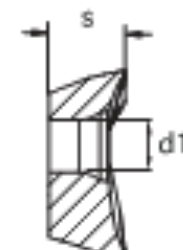
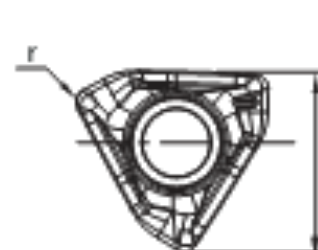
SHELL CUTTER

B4F52	Tech. Code	Z	D mm	D1 mm	d mm	L mm	Ap max mm	Air hole	Insert
Bore	B4F524007Z5	5	40	38	16	40	5	With	TOKX070305PDER
	B4F525007Z6	6	50	43	22				

KERFOLG GEOMETRY AND CUTTING CONDITIONS

Triple

TOKX 070305... l=14,7mm
d1=5,24mm s=5,3mm



		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	ML	TOKX070305PDER-ML	MT35	B4T0707TOML10	●	○	○	●	●				○	
	MM	TOKX070305PDER-MM	PH35	B4T0807TOMM10	●	●	●	○	○	○	○			○

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed (m/min.)	Feed fz/mm
Low carbon content steel (C15E, etc.)	~ 200	PH35	180 - 260	0.08 - 0.15
High carbon content steels (C45E, C55E etc.)	200 - 300	PH35	120 - 200	0.08 - 0.13
Alloyed steel (42CRMo4, 17Cr3 etc.)	200 - 300	PH35	60 - 160	0.08 - 0.12
Stainless steels (X5CrNi 18-9, etc.)	-	MT35	75 - 180	0.08 - 0.12
Cast irons (GG25, GG30 etc.)	150 - 250	PH35	180 - 260	0.08 - 0.15
Spheroidal cast irons (GGG40 etc.)	150 - 250	PH35	120 - 200	0.08 - 0.13
Heat resistant alloys (Inconel 718, Ti-6Al-4V etc.)	-	MT35	25 - 75	0.08 - 0.10