

ITEM: B7F11

Disk end mills for grooving and cutting works

Coupling type

Bore

Insert type

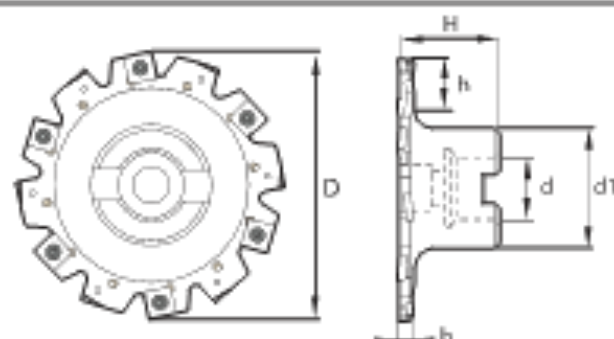
SNHX11... - SNHX12...

Application

Slotting and cutting on all materials

Ø63 ~ 100 mm

P M K N



SHELL CUTTER

B7F11	Tech. Code		Z	D mm	b mm	h mm	H mm	d mm	d1 mm	Air hole	Insert
BORE COUPLING	B7F11634		8	63	4	10.5	50	22	40	Without	SNHX 1102T
	B7F11635				5						SNHX 1103T
	B7F11636				6						SNHX 1203T
	B7F11804		10	80	4	SNHX 1102T					
	B7F11805				5	SNHX 1103T					
	B7F11806				6	SNHX 1203T					
	B7F111004		12	100	4	24.2		27	48		SNHX 1102T
	B7F111005				5						SNHX 1103T
	B7F111006				6						SNHX 1203T
	B7F1110010		10	SNHX 1205T							
	B7F111256		12	125	6			23,7	40		70
	B7F1112510				10	SNHX 1205T					
	B7F111606				6	SNHX 1203T					
	B7F1116010		16	160	10	41,2					

KERFOLG GEOMETRY AND CUTTING CONDITIONS

Groove

SNHX 1102T MM
SNHX 1103T MM
SNHX 1102 AL
SNHX 1103 AL



SNHX 1203T MM
SNHX 1205T MM
SNHX 1203 AL
SNHX 1205 AL



		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	MM	SNHX 1102T MM	PT30	B7A2111SNMM01	●	●	○	○		○			○	
		SNHX 1103T MM		B7A2111SNMM02	●	●	○	○		○			○	
		SNHX 1203T MM		B7A2112SNMM10	●	●	○	○		○			○	
		SNHX 1205T MM		B7A2112SNMM13	●	●	○	○		○			○	
	AL	SNHX 1102 AL	HT15	B7A4111SNAL01								●		
		SNHX 1103 AL		B7A4111SNAL02								●		
		SNHX 1203 AL		B7A4112SNAL10								●		
		SNHX 1205 AL		B7A4112SNAL13								●		

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnell HB	Degrees Recommended	Cutting speed Speed (m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	PT30	140 - 220	0.08 - 0.16
High carbon content steel (C45E, C55E, etc.)	~ 300	PT30	110 - 160	0.06 - 0.15
Tool steel (X155CrVMo 12 1, etc.)	~ 300	PT30	90 - 130	0.05 - 0.10
Stainless steel (X5CrNi 18-9, etc.)	-	PT30	80 - 120	0.05 - 0.10
Grey cast iron (GG25, GG30, etc.) Spheroidal cast iron (GGG40, etc.)	150 - 250	PT30	100 - 180	0.08 - 0.16
Heat-resistant alloys (Inconel 718, Ti-6Al-4V, etc.)	-	PT30	40 - 60	0.05 - 0.10

Cutting conditions relating to ae = 10% x D. Apply adjustment factor if ae different from 10%.