

ITEM: B7F30

Indexable mills for chamfering and centering

Coupling type

Weldon shank

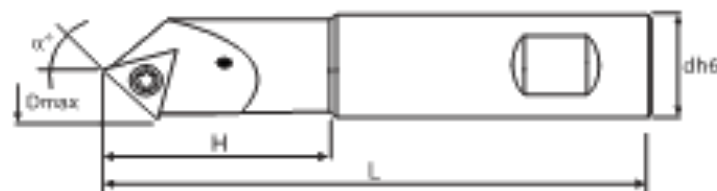
Insert type

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

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