

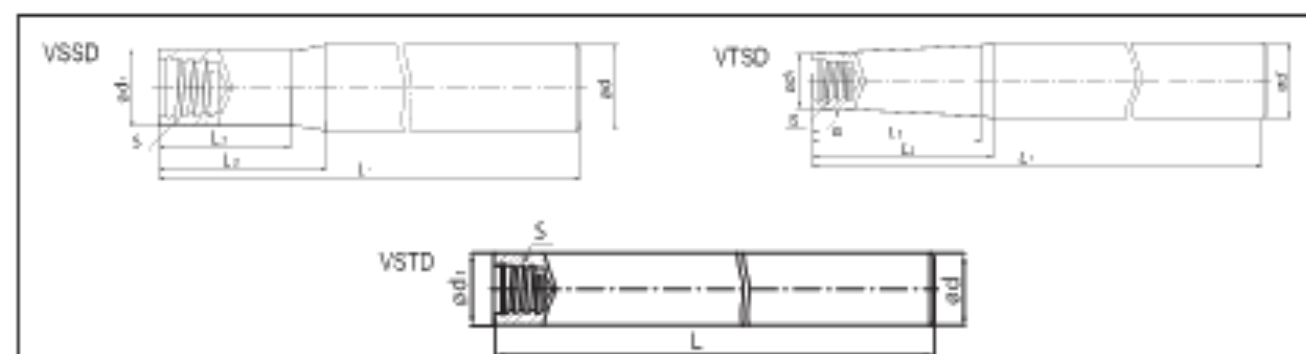
ITEM: B6F40 - B6F41 - B6F42

Multifunctional milling for different material

Coupling type Cylindrical screw on
Insert type Interchangeable heads
Application Multifunctional

Ø6 - 25 mm

P M K S H N



SHANKS FOR INTERCHANGEABLE HEADS VSSD

VSSD	Tech. Code	Denomination	Ød mm	Ød1 mm	L1 mm	L2 mm	L3 mm	S mm	Shank material
Cylindrical	B6F4008060S	VSSD08L060S05-S	8	7,6	60	15	15	S05	Steel
	B6F4010075S	VSSD10L075S06-S	10	9,6	75	20	20	S06	
	B6F4012090S	VSSD12L090S08-S	12	11,5	90	16	16	S08	
	B6F4016100S	VSSD16L100S10-S	16	15,2	100	20	20	S10	
	B6F4020120S	VSSD20L120S12-S	20	18,3	120	25	25	S12	

SHANKS FOR INTERCHANGEABLE HEADS VTSD

VTSD	Tech. Code	Denomination	Ød mm	α° mm	Ød1 mm	L1 mm	L2 mm	L3 mm	S mm	Shank material
Cylindrical	B6F4112100S	VTSD12L100S05-S	12	89°	7,6	100	35	29	S05	Steel
	B6F4116160S	VTSD16L160S06-S	16		9,6	160	55	46,5	S06	
	B6F4120170S	VTSD20L170S08-S	20		11,5	170	80	69,5	S08	
	B6F4120190S	VTSD20L190S10-S	20		15,2	190	80	73	S10	
	B6F4125210S	VTSD25L210S12-S	25		18,3	210	100	94,5	S12	

SHANKS FOR INTERCHANGEABLE HEADS VSTD

VSTD	Tech. Code	Denomination	Ød mm	Ød1 mm	L mm	S mm	Shank material
Cylindrical	B6F4208070S	VSTD08L070S05-S	8	8	70	S05	Steel
	B6F4210080S	VSTD10L080S06-S	10	10	80	S06	
	B6F4212090S	VSTD12L090S08-S	12	12	90	S08	
	B6F4216100S	VSTD16L100S10-S	16	16	100	S10	

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Recommended grades	Cutting speed VC (m/min)	SIDE SLOTS Cutting speed	SIDE SLOTS Feed
Low carbon content steels (C15 etc.)	~ 200	AH725 - GH130	100 - 200	110 - 140	0,05 - 0,15
Carbon steels (C45-C55 etc.)	200 - 300	AH725 - GH130	80 - 180	100 - 120	0,05 - 0,15
Alloyed steel (42CRMo4, 17Cr3 etc.)	150 - 300	AH725 - GH130	80 - 160	100 - 120	0,05 - 0,15
Stainless steels (ex. X5CrNi 18-9, etc.)	-	AH725 - GH130	60 - 100	60 - 120	0,03 - 0,12
Cast irons (GG25, GG30 etc.)	150 - 200	AH725 - GH130	100 - 220	90 - 160	0,03 - 0,12
Spheroidal cast irons (GGG40 etc.)	150 - 200	AH725 - GH130	100 - 220	90 - 160	0,03 - 0,12
Aluminium alloys (Si<13%)	-	AH725 - GH130	200 - 700	700 - 900	0,05 - 0,15
High hardened steels	55HRC	AH725 - GH130	40 - 80	-	-

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA230	S05	Wrench	KEYV-S05
BRICA231	S06		KEYV-S06
BRICA232	S08		KEYV-S08
BRICA233	S10		KEYV-S10
BRICA234	S12		KEYV-S12
BRICA235	S08		KEYV-217