

# KERFOLG® FACE MILLS FOR SINGLE-SIDE SQUARE INSERTS

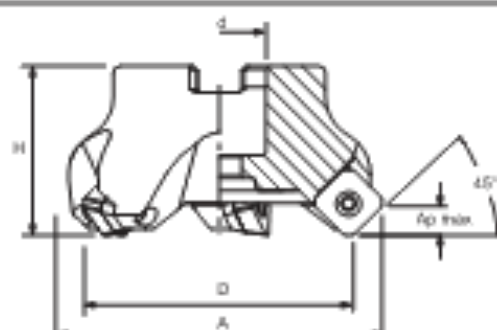
Face

ITEM: B3F06

General, multifunctional face mills

Coupling type Bore  
Applicable inserts SEHX 1204  
Application Face milling

Ø40 ~ 125 mm



## SCREW INSERT CLAMPING SHELL END MILL

| B3F06 | Tech. Code |  | Z | D<br>mm | d<br>mm | A<br>mm | H<br>mm | Max Op.<br>mm | Air hole | Insert    |
|-------|------------|--|---|---------|---------|---------|---------|---------------|----------|-----------|
| Bore  | B3F0640Z3  |  | 3 | 40      | 16      | 53      | 40      | 6             | With     | SEHX 1204 |
|       | B3F0650Z4  |  | 4 | 50      | 22      | 63      | 48      |               |          |           |
|       | B3F0663Z5  |  | 5 | 63      |         | 76      |         |               |          |           |
|       | B3F0680Z6  |  | 6 | 80      | 27      | 93      | 50      |               |          |           |
|       | B3F06100Z8 |  | 8 | 100     | 32      | 113     |         |               |          |           |
|       | B3F06125Z9 |  | 9 | 125     | 40      | 138     | 63      |               |          |           |

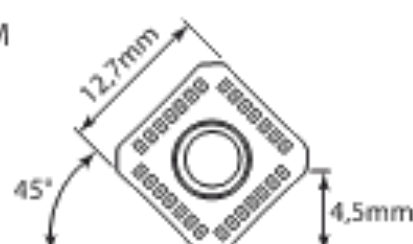
## SPARE PARTS

| Tech. Code | Version       | Description  | Denomination |
|------------|---------------|--------------|--------------|
| BRICA130   | All diameters | Insert screw | BRICA130     |
| BRICA004   |               | Wrench       | BRICA004     |

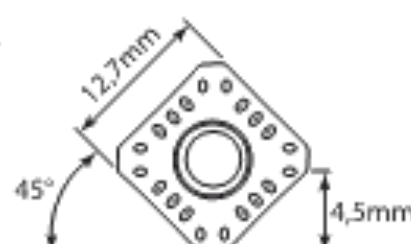
## KERFOLG® GEOMETRY AND CUTTING CONDITIONS

Face

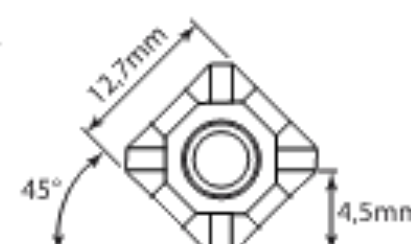
SEHX 1204...MM



SEHX 1204...ML



SEHX 1204...AL



|          |    | Description       | Grade | Tech. Code    | P             |               | M             |               | K          |            | N   | S   | H          |
|----------|----|-------------------|-------|---------------|---------------|---------------|---------------|---------------|------------|------------|-----|-----|------------|
|          |    |                   |       |               | <500<br>N/mm² | <850<br>N/mm² | <600<br>N/mm² | <850<br>N/mm² | <240<br>HB | <300<br>HB | Alu | HTA | <60<br>HRC |
|          |    |                   |       |               | ●             | ●             | ○             | ○             | ○          | ○          | ●   | ○   | ○          |
| MED. CUT | MM | SEHX 1204 AFSN MM | PT30  | B3B2112SNMM01 | ●             | ●             | ○             | ○             | ○          | ○          | ●   | ○   | ○          |
|          |    |                   |       |               |               |               |               |               |            |            |     |     |            |
|          | ML | SEHX 1204 AFSN ML | MT30  | B3B2212SNML05 | ●             | ○             | ○             | ●             | ●          |            |     | ○   | ○          |
|          |    |                   |       |               |               |               |               |               |            |            |     |     |            |
|          | AL | SEHX 1204 AFFN AL | K10   | B3B2312SNAL10 |               |               |               |               |            |            | ●   |     |            |
|          |    |                   |       |               |               |               |               |               |            |            |     |     |            |

● RECOMMENDED FOR... ○ USABLE FOR...

## RECOMMENDED CUTTING DATA

| Material                                   | Hardness<br>Brinell HB | Recommended<br>Grades | Geometry | Cutting speed<br>Vc (m/min.) | Feed<br>lz/mm |
|--------------------------------------------|------------------------|-----------------------|----------|------------------------------|---------------|
| Low carbon content steel (C15, etc.)       | ~ 200                  | PT30                  | MM       | 180 - 250                    | 0.08 - 0.25   |
| High carbon content steel (C45, C55, etc.) | 200 ~ 300              | PT30                  | MM       | 150 - 200                    | 0.08 - 0.25   |
| Alloy steel 42CRMo4, 17Cr3, etc.           | 200 ~ 300              | PT30                  | MM       | 150 - 230                    | 0.08 - 0.25   |
| Tool steel (X155CrVMo 12 1, etc.)          | ~ 300                  | PT30                  | MM       | 130 - 180                    | 0.06 - 0.20   |
| Stainless steel (X5CrNi 18-9, etc.)        | -                      | MT30                  | ML       | 100 - 150                    | 0.06 - 0.20   |
| Grey cast iron (GG25, GG30, etc.)          | 150 ~ 250              | PT30                  | MM       | 120 - 180                    | 0.08 - 0.25   |
| Spheroidal cast iron (GGG40, etc.)         | 150 ~ 250              | PT30                  | MM       | 100 - 150                    | 0.06 - 0.20   |
| Non ferrous alloys (SI < 13%)              | -                      | K10                   | AL       | 200 - 500                    | 0.04 - 0.35   |
| Non ferrous alloys (SI > 13%)              | -                      | K10                   | AL       | 200 - 350                    | 0.04 - 0.28   |