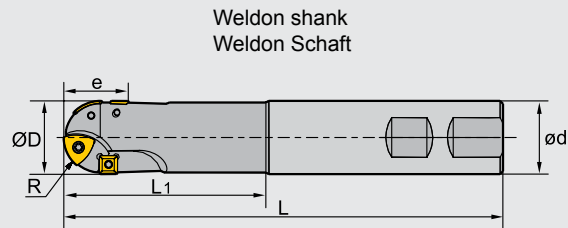




Profile milling tools · Profilfräser

BMR01 P M K






Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen							Inserts WSP				Weight Gewicht (kg)
		R	Ø D	e	ø d	L	L ₁	Type Typ	Quantity Anzahl	Type Typ	Quantity Anzahl		
BMR01	-020-XP20-S	○	10	20	20	20	125	50	ZDET08T2CYR10	2	SPMT060304	2	0.3
	-020-XP20-M	○	10	20	20	20	150	75	ZDET08T2CYR10	2	SPMT060304	2	0.3
	-020-XP20-L	○	10	20	20	20	200	100	ZDET08T2CYR10	2	SPMT060304	2	0.4
	-025-XP25-S	○	12.5	25	23	25	150	70	ZDET1103CYR12.5	2	SPMT060304	2	0.5
	-025-XP25-M	●	12.5	25	23	25	175	95	ZDET1103CYR12.5	2	SPMT060304	2	0.6
	-025-XP25-L	○	12.5	25	23	25	200	100	ZDET1103CYR12.5	2	SPMT060304	2	0.7
	-032-XP32-S	○	16	32	31	32	175	85	ZDET13T3CYR16	2	SDMT090308	2	0.9
	-032-XP32-M	○	16	32	31	32	200	100	ZDET13T3CYR16	2	SDMT090308	2	1.1
	-032-XP32-L	○	16	32	31	32	250	150	ZDET13T3CYR16	2	SDMT090308	2	1.4
	-040-XP40-S	○	20	40	41	40	175	85	ZPNT2204CY(R20)	3	SPMT120408	2	1.4
	-040-XP40-M	○	20	40	41	40	200	100	ZPNT2204CY(R20)	3	SPMT120408	2	1.7
	-040-XP40-L	○	20	40	41	40	250	150	ZPNT2204CY(R20)	3	SPMT120408	2	2.1
	-050-XP40-S	○	25	50	45	40	200	100	ZPNT2204CY(R25)	3	SPMT120408	2	1.8
	-050-XP40-M	○	25	50	45	40	300	100	ZPNT2204CY(R25)	3	SPMT120408	2	2.8
	-063-XP40-S	○	31.5	63	52	40	200	100	ZPNT2204CY(R31)	4	SPMT120408	2	3.0
	-063-XP40-M	○	31.5	63	52	40	300	100	ZPNT2204CY(R31)	4	SPMT120408	2	3.5

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Wrench Schlüssel	
			
Ø20-Ø25	I43M2.5×5.7	WT07IP	--
Ø32	I43M4×8	--	WT15IS
Ø40-Ø63	I43M5×11	--	WT20IS



Applicable tool
Werkzeug **B11-B18**

Tools code key
Werkzeug ISO **B26-B27**

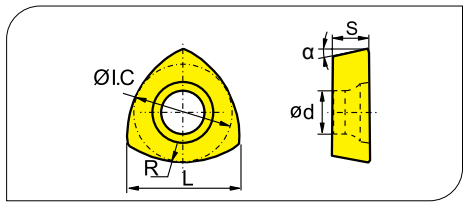
Grade selection guide
Sortenauswahl **B19-B23**

Technical data
Technische Daten **B215-B220**

Milling · Fräsen

Indexable Milling Tools · Wendepplattenfräser

Applicable inserts · Wendeschneidplatten

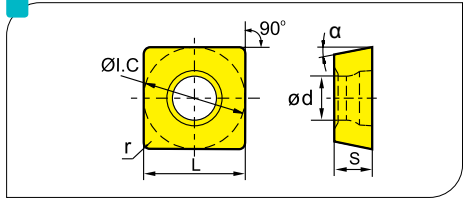


- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert WSP	Type Typ	Dimensions (mm) / Abmessungen						CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.						Cermet / Cermet	Carbide uncoat. / unbee. Hartmetall				
		R	L	I.C.	S	d	α	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302		YBG152	YBG252	YNG151	YNG151C	YC30S
	ZDET08T2CYR10	10	8.4	6.75	2.78	2.8	14°				●														
	ZDET1103CYR12.5	12.5	10.6	8.5	3.18	2.8	14°				●														
	ZDET13T3CYR16	16	13.2	10.5	3.97	4.4	14°				●														
	ZPNT2204CY(R20)	20	16.1	12.7	4.76	5.56	11°				○														
	ZPNT2204CY(R25)	25	16.9	12.7	4.76	5.56	11°				●														
	ZPNT2204CY(R31)	31.5	17.6	12.7	4.76	5.56	11°				●														

Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert WSP	Type Typ	Dimensions (mm) / Abmessungen						CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.						Cermet / Cermet	Carbide uncoat. / unbee. Hartmetall				
		r	L	I.C.	S	d	α	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302		YBG152	YBG252	YNG151	YNG151C	YC30S
	SPMT060304	0.4	6.35	6.35	3.18	2.8	11°				●														
	SDMT090308	0.8	9.525	9.525	3.18	4.4	15°				●	○													
	SPMT120408	0.8	12.7	12.70	4.76	5.5	11°	●		○	●														

Recommended Cutting data · Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten	
			V(m/min)	f(mm/z)
P Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl / Baustahl	≤180	YBM251	180(120-220)	0.25(0.1-0.4)
		YBC301		
	180-280	YBG302	160(120-220)	0.25(0.1-0.4)
		YBC401		
M High-carbon steel / Alloy steel / Hochleg. Kohlenstoffstahl / Leg. Stahl	280-350	YBM251	150(100-200)	0.2(0.1-0.4)
		YBC301		
	180-250	YBG302	120(100-200)	0.2(0.1-0.4)
		YBC401		
K Alloy tool steel / Leg. Werkzeugstahl	280-350	YBM251	100(80-150)	0.2(0.1-0.3)
		YBC301		
	180-250	YBG302	100(80-150)	0.2(0.1-0.3)
		YBM251		
280-350	YBM251	100(80-150)	0.2(0.1-0.3)	
	YBG302			
M Stainless steel / Rostfreier Stahl	≤270	YBM251	100(80-150)	0.2(0.1-0.3)
		YBC401		
K Cast iron / Gusseisen	180-250	YBM251	150(100-180)	0.3(0.2-0.5)
		YBC401		

● Ex Stock / ab Lager ○ On demand / auf Anfrage