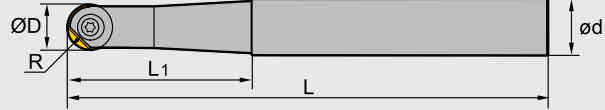




Profile milling tools · Profilfräser

BMR02 P M K



Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen					Weight Gewicht (kg)	
		R	Ø D	ø d	L	L ₁		
BMR02	●	-012-G16-S	6	12	16	110	40	0.1
	●	-012-G16-M	6	12	16	130	50	0.2
	●	-012-G16-L	6	12	16	160	50	0.2
	●	-016-G20-S	8	16	20	140	45	0.3
	●	-016-G20-M	8	16	20	170	65	0.3
	●	-016-G20-L	8	16	20	200	65	0.4
	●	-020-G25-S	10	20	25	160	60	0.5
	●	-020-G25-M	10	20	25	200	80	0.6
	●	-020-G25-L	10	20	25	240	80	0.8

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

Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Wrench Schlüssel
Ø12	I90M4×09TT	WT10S
Ø16	I90M5×11TT	WT15S
Ø20	I90M5×13.5TT	WT15S



Applicable tool
Werkzeug B11-B18

Tools code key
Werkzeug ISO B26-B27

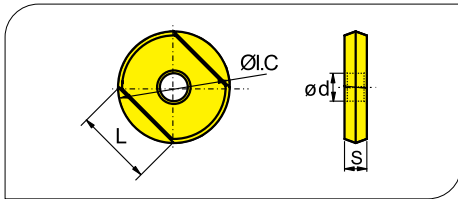
Grade selection guide
Sortenauswahl B19-B23

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 / Werkstoff	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. / unbe. Hartmetall								
		I.C	L	S	d	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	ROHX1203	12	8.5	3	4						○			○	●				●						
	ROHX1604	16	11.3	4	5						○				●				●						
	ROHX2005	20	14.1	5	5						●				●				●						

Recommended Cutting data - Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten	Diameter / Durchmesser Ø D		
				Ø12	Ø16	Ø20
P	carbon steel / leg. Kohlenstoff-stahl HB≤180	YBG202 YBG252	V(m/min)	100~200	100~200	100~200
			f _z (mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
			a _{pmax} (mm)	0.8	1	1.25
			a _{emax} (mm)	0.8	1	1.25
	Alloy steel / Leg. Stahl HB180~280		V(m/min)	80~180	80~180	80~180
			f _z (mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
			a _{pmax} (mm)	0.8	1	1.25
			a _{emax} (mm)	0.8	1	1.25
	Hardened steel / gehärteter Stahl HRC55~65		V(m/min)	60~100	60~100	60~100
f _z (mm/z)		0.15~0.25	0.2~0.3	0.2~0.3		
a _{pmax} (mm)		0.4	0.5	0.6		
a _{emax} (mm)		0.4	0.5	0.6		
M Stainless steel / Rostfreier Stahl HB≤270	V(m/min)	70~150	70~150	70~150		
	f _z (mm/z)	0.1~0.2	0.1~0.25	0.1~0.25		
	a _{pmax} (mm)	0.6	0.8	1		
	a _{emax} (mm)	0.6	0.8	1		
K Cast iron / Gusseisen HB180-250	V(m/min)	160~300	160~300	160~300		
	f _z (mm/z)	0.2~0.3	0.25~0.35	0.25~0.35		
	a _{pmax} (mm)	1	1.5	1.8		
	a _{emax} (mm)	1	1.5	1.8		

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