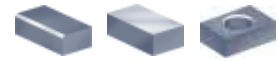
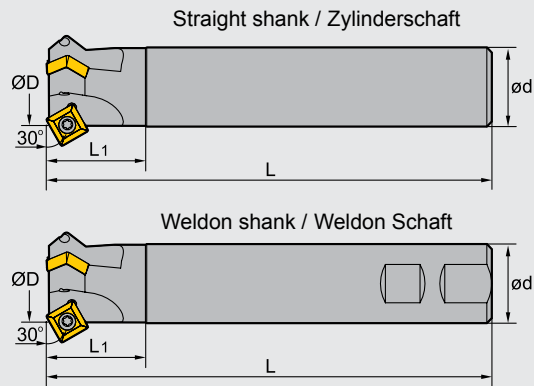


Chamfer milling tools · Fasfräser

Kr:30°



CMZ01 P M K



■ Specification of tools · Werkzeug-Beschreibung

| | Type Typ | Stock Lager | Dimensions (mm) Abmessungen | | | | No. of teeth Zähne | Weight Gewicht (kg) |
|-------------------------------------|-------------------|----------------|--------------------------------|-----|-----|----------------|-----------------------|---------------------------|
| | | | Ø D | ø d | L | L ₁ | | |
| CMZ01 Zylinder- schaft | -012-G20-SP12-01 | ● | 12 | 20 | 100 | 40 | 1 | 0.2 |
| | -025-G25-SP12-02 | ● | 25 | 25 | 120 | 40 | 2 | 0.8 |
| | -032-G32-SP12-03 | ● | 32 | 32 | 180 | 40 | 3 | 1.1 |
| Weldon Schaft | -012-XP20-SP12-01 | ● | 12 | 20 | 100 | 40 | 1 | 0.2 |
| Weldon Schaft | -025-XP25-SP12-02 | ● | 25 | 25 | 120 | 40 | 2 | 0.6 |
| | -032-XP32-SP12-03 | ● | 32 | 32 | 180 | 40 | 3 | 1.0 |

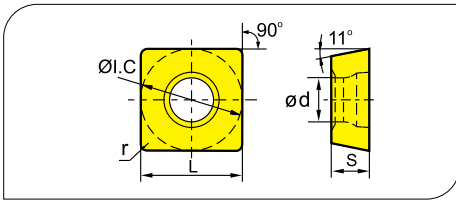
■ Spare parts · Ersatzteile

| Diameter Durchmesser Ø D | Screw Schraube | Wrench Schlüssel |
|--------------------------------|-------------------|---------------------|
| Ø12-Ø32 | I43M5×11 | WT20IS |



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

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 |
|---|---|---|---|---|---|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---------|-------|-------|-------|
| Steel / Stahl | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Stainless Steel / Rostfreier Stahl | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Cast iron / Gusseisen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Non-ferrous material / Ne Metalle | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 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 | r | S | d | YBC301 | YBC302 | YBC401 | YBM251 | YBM253 | YBM351 | YBD152 | YBD252 | YBG102 | YBG202 | | YBG205 | YBG302 | YBG152 | YBG252 | YNG151 | YNG151C | YC30S | YD101 |
| | SPMT120408 | 12.7 | 12.7 | 0.8 | 4.76 | 5.5 | ● | ○ | ● | | | | | | | | | ● | | | | | | | |

Recommended Cutting data · Schnittdaten

| Workpiece material / Werkstückstoff | Hardness HB / Härte | Grade / Sorte | Cutting data / Schnittdaten | | |
|-------------------------------------|---|----------------------------|--|------------------------------|---------------|
| | | | Cutting speed / Schnittgeschw. (m/min) | Feed speed / Vorschub (mm/z) | |
| P | Low-carbon steel / Soft steel / niedriglegierter Kohlenstoffstahl / Baustahl | YBM251 YBC301 | 180(100—250) | 0.25 (0.1-0.4) | |
| | | YBM351 YBG302 YBC401 | 150(100—200) | 0.3 (0.1-0.5) | |
| | | YC30S | 120(80—150) | 0.4 (0.1-0.5) | |
| | High-carbon steel / hochlegierter Kohlenstoffstahl / Alloy steel / Leg. Stahl | 180—280 | YBM251 YBC301 | 160(100—220) | 0.3 (0.1-0.4) |
| | | | YBM351 YBG302 YBC401 | 130(100—180) | 0.3 (0.1-0.5) |
| | | | YC30S | 100(60—150) | 0.4 (0.1-0.5) |
| | Alloy tool steel / Leg. Werkzeugstahl | 280—350 | YBM251 YBC301 | 120(80—180) | 0.3 (0.1-0.4) |
| | | | YBM351 YBG302 | 100(80—150) | 0.3 (0.1-0.5) |
| | | | YC30S | 80(60—120) | 0.4 (0.1-0.5) |
| M | Stainless steel / Rostfreier Stahl | ≤270 | YBM251 YBC301 | 120(80—180) | 0.3 (0.1-0.4) |
| | | | YBM351 YBG302 YBC401 | 100(80—150) | 0.3 (0.1-0.5) |
| | | | YC30S | 80(60—120) | 0.4 (0.1-0.5) |
| K | Cast iron / Gusseisen | 180-250 | YBG302 | 130(100—180) | 0.4 (0.1-0.5) |

Applicable tool / Werkzeug **B11-B18**

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

Grade selection guide / Sortenauswahl **B19-B23**

Technical data / Technische Daten **B215-B220**