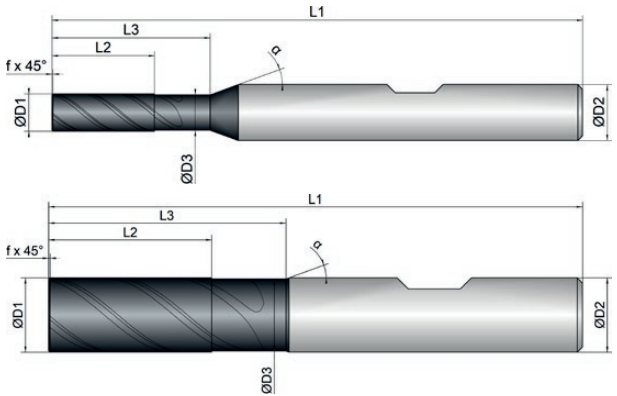


Cooling	   
Tolerance	e8
Coating	BetaUni Iron

Strategy	HPC	UNI		
Application				
Features	HB	≠		



- Adapted clearance angle for reliable machining
- Unequal tooth pitch for smooth running
- Large chip chambers for good chip evacuation

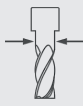
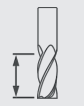
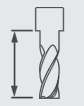
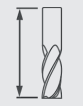
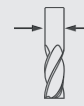
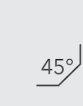


Roughing



Finishing



BCU1-M01-0214	D1  mm Ø	D3  mm Ø	L2  mm	L3  mm	L1  mm	D2  mm Ø	z  #	 mm	 °	 °
3	3.0	2.8	8.0	13.0	57.0	6.0	4	0.10	40	20
4	4.0	3.8	11.0	17.0	57.0	6.0	4	0.10	40	20
5	5.0	4.8	13.0	20.0	57.0	6.0	4	0.20	40	20
6	6.0	5.8	13.0	20.0	57.0	6.0	4	0.20	40	20
8	8.0	7.7	19.0	25.0	63.0	8.0	4	0.20	40	20
10	10.0	9.7	22.0	32.0	72.0	10.0	4	0.20	40	20
12	12.0	11.6	26.0	38.0	83.0	12.0	4	0.20	40	20
16	16.0	15.5	32.0	44.0	92.0	16.0	4	0.30	40	20
20	20.0	19.5	41.0	54.0	104.0	20.0	4	0.30	40	20



Download Catalog
Pages (PDF)

 Download Catalog Pages (PDF)			Dimension		Ø3		Ø4		Ø5		Ø6		Ø8		Ø10		
			Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD
				ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD
				Application													
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz		
P			Vc (m/min)														
1.1-1.3	Steel, unalloyed	<850	170	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065		
2.1-2.2	Steel, low-alloyed	<950	160	0.012	0.015	0.012	0.015	0.022	0.028	0.03	0.035	0.04	0.05	0.045	0.06		
3.1-3.2	Steel, high-alloyed	<1100	150	0.01	0.012	0.01	0.012	0.02	0.025	0.028	0.032	0.038	0.048	0.042	0.055		
K			Vc (m/min)														
1.1-1.2	Grey cast iron	<1000	190	0.012	0.015	0.012	0.015	0.022	0.028	0.03	0.035	0.04	0.05	0.045	0.06		
M			Vc (m/min)														
1.1	Inox, ferritic/martensitic	<850	75		0.015		0.018		0.025		0.032		0.048		0.055		
2.1	Inox, austenitic	<650	65		0.012		0.015		0.022		0.03		0.045		0.05		
N			Vc (m/min)														
1.1-2.3	Alu, alloyed, casted	<600	360	0.015	0.02	0.02	0.035	0.035	0.04	0.04	0.06	0.06	0.08	0.08	0.1		
3.1-3.3	Cooper, alloyed	<600	170	0.012	0.015	0.015	0.025	0.025	0.03	0.03	0.05	0.05	0.07	0.07	0.09		
T			Vc (m/min)														
2.1-2.2	Titanium, pure, alloyed	<1000	50		0.012		0.015		0.022		0.028		0.04		0.05		
S			Vc (m/min)														
1.1-1.3	Super alloys	<1450	25		0.01		0.012		0.018		0.022		0.035		0.045		
			Dimension	Ø12		Ø16		Ø20									
			Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD								
				ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD	ap= 1xD								
			Application														
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz									
P			Vc (m/min)														
1.1-1.3	Steel, unalloyed	<850	170	0.055	0.075	0.065	0.085	0.08	0.1								
2.1-2.2	Steel, low-alloyed	<950	160	0.05	0.07	0.055	0.075	0.07	0.09								
3.1-3.2	Steel, high-alloyed	<1100	150	0.045	0.065	0.05	0.07	0.065	0.08								
K			Vc (m/min)														
1.1-1.2	Grey cast iron	<1000	190	0.05	0.07	0.055	0.075	0.07	0.09								
M			Vc (m/min)														
1.1	Inox, ferritic/martensitic	<850	75		0.06		0.065		0.08								
2.1	Inox, austenitic	<650	65		0.055		0.06		0.07								
N			Vc (m/min)														
1.1-2.3	Alu, alloyed, casted	<600	360	0.1	0.12	0.11	0.13	0.12	0.14								
3.1-3.3	Cooper, alloyed	<600	170	0.09	0.11	0.1	0.12	0.11	0.13								
T			Vc (m/min)														
2.1-2.2	Titanium, pure, alloyed	<1000	50		0.055		0.06		0.07								
S			Vc (m/min)														
1.1-1.3	Super alloys	<1450	25		0.05		0.055		0.065								
NOTE The values marked in turquoise are side applications!																	