

Fräsen Milling 90°

boehlerit

ISO 90P



Anzahl Schneidkanten /
Wendeschneidplatte: 2
Number of cutting edges / insert: 2
In INCH verfügbar / available in INCH
Seite 84, see page 84

BETAtec 90P Feed



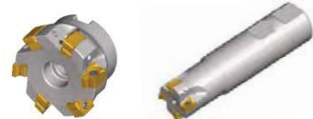
Anzahl Schneidkanten /
Wendeschneidplatte: 2
Number of cutting edges / insert: 2
In INCH verfügbar / available in INCH
Seite 96, see page 96

DELTAtec 90P Feed



Anzahl Schneidkanten /
Wendeschneidplatte: 4
Number of cutting edges / insert: 4
In INCH verfügbar / available in INCH
Seite 113, see page 113

DELTAtec 90N



Anzahl Schneidkanten /
Wendeschneidplatte: 4
Number of cutting edges / insert: 4
Seite 128, see page 128

DELTAtec 90N Tang



Anzahl Schneidkanten /
Wendeschneidplatte: 4
Number of cutting edges / insert: 4
Seite 134, see page 134

ZETAtec 90N



Anzahl Schneidkanten /
Wendeschneidplatte: 6
Number of cutting edges / insert: 6
In INCH verfügbar / available in INCH
Seite 138, see page 138



THETAtec 88N



Anzahl Schneidkanten /
Wendeschneidplatte: 8
Number of cutting edges / insert: 8
Seite 144, see page 144

DELTAtec 90N

www.boehlerit.com

Ausführung Execution	Aufsteckfräser 90° Face milling cutter 90°	
		
Durchmesserbereich metrisch Diameter range metric	Ø 40 - 160 mm	Ø 20 - 40 mm
Plattengröße Insert size	LN..10, LN..15	LN..10, LN..15

Besondere Merkmale:

- Stabiles Werkzeugsystem durch negatives Geometriegrundkonzept
- Effektiv positiver Spanwinkel für leichten Schnitt
- Produktivität ist gewährleistet durch 4 Schneidkanten
- Verfügbar in 2 Plattengrößen
- Schafffräser in Überlänge verfügbar
- Artikel mit Status "Lieferzeit auf Anfrage" in fünf Arbeitstagen lieferbar

Special features:

- Stable tool system through negative geometry basic design
- Effective positive chip angle for smooth cut
- Productivity guaranteed through 4 cutting edges
- Available in 2 insert sizes
- End milling cutter in excess length available
- Article with status "Delivery time on request" are deliverable in five working days

WSP Geometrie Insert geometry	LNMX 10		LNMX 15	
	Schnitttiefe* Cutting depth* [mm] a _p max	Vorschub* Feed* [mm] f _z	Schnitttiefe* Cutting depth* [mm] a _p max	Vorschub* Feed* [mm] f _z
RP	1,0 4,0 9,0	0,2 0,3 0,4	1,0 6,5 14,0	0,2 0,3 0,4
RM	1,0 4,0 9,0	0,2 0,2 0,3	1,0 6,5 12,0	0,2 0,2 0,3
RK	1,0 4,0 9,0	0,2 0,2 0,3	1,0 6,5 14,0	0,2 0,3 0,4

Schnittwertempfehlungen siehe Seite 148
Cutting data recommendations page 148

* Angegebene Schnittdaten sind als Richtwert zu sehen, welche durch Versuche für jeden Anwendungsfall separat optimiert werden können.
* Recommended cutting data has to be seen as a reference which can be optimised for each application through trials separately.

Schnittwertempfehlung für Fräser 90°
Cutting data recommendations for Milling Cutter 90°

www.boehlerit.com



ISO 513	BZG	Kühlung Cooling			Schnittdaten v _c [m/min] Cutting data v _c [m/min]			
		MMS/Luft MMS/Air	Trocken Dry	Nass Wet	BCP20M BCP25M	BCP30M BCP35M BCP40M	BCM35M	BCM40M
V _c = m/min								
P	P1	●	●		210 - 290	180 - 260	---	200 - 260
	P2	●	●		170 - 250	160 - 200	---	160 - 220
	P3	●	●		140 - 190	120 - 160	---	130 - 170
	P4	●	●		120 - 160	110 - 150	---	120 - 150
	P5	●	●		140 - 200	120 - 170	---	130 - 190
M	M1	●	●	●	100 - 150	---	120 - 180	110 - 160
	M2	●	●	●	70 - 110	---	80 - 130	70 - 120
K	K1	●	●		200 - 280	---	---	---
	K2	●	●		130 - 180	---	---	---
	K3	●	●		160 - 210	---	---	---
N	N1	●	●	●	---	---	---	---
	N2	●	●	●	---	---	---	---
	N3	●	●	●	---	---	---	---
	N4	●	●	●	---	---	---	---
S	S1	●	●	●	---	---	70 - 90	55 - 70
	S2	●	●	●	---	---	35 - 45	25 - 35
	S3	●	●	●	---	---	50 - 100	30 - 70
	S4	●	●	●	---	---	30 - 80	25 - 50
H	H1	45 - 54 HRC	●	●	---	---	100 - 140	---
	H2	55 - 63 HRC	●	●	---	---	80 - 120	---
	H3	64 - 66 HRC	●	●	---	---	---	---
	H4	50 - 60 HRC	●	●	---	---	90 - 130	---

		Schnittdaten v _c [m/min] Cutting data v _c [m/min]				
		BCK15M BCK20M	BWN10M	BCN10M	BCS35M BCS40M	BCH05M BCH10M
		220 - 280	---	---	---	240 - 350
		190 - 240	---	---	---	200 - 300
		150 - 190	---	---	---	160 - 250
		---	---	---	---	---
		140 - 200	---	---	---	160 - 260
		---	---	---	100 - 150	---
		---	---	---	70 - 110	---
		220 - 360	---	---	---	280 - 490
		150 - 190	---	---	---	160 - 300
		170 - 240	---	---	---	220 - 340
		---	1200 - 2400	1500 - 3000	---	---
		---	240 - 550	310 - 750	---	---
		---	120 - 380	160 - 480	---	---
		---	400 - 500	600 - 800	---	---
		---	---	---	65 - 80	---
		---	---	---	30 - 45	---
		---	---	---	40 - 90	---
		---	---	---	30 - 70	---
		100 - 140	---	---	---	110 - 160
		80 - 120	---	---	---	90 - 130
		---	---	---	---	70 - 110
		90 - 130	---	---	---	100 - 150

- empfohlene Anwendung recommended application
- alternative Anwendung um 30 - 50 % reduzieren
alternative application reduced by 30 - 50 %