

Fräsen Milling 3D

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BALLtec / TORROtec



Anzahl Schneidkanten /
Wendeschneidplatte: 2
Number of cutting edges / insert: 2

Seite 152, see page 152

RHOMBICtec 95P



Anzahl Schneidkanten /
Wendeschneidplatte: 2
Number of cutting edges / insert: 2

Seite 169, see page 169

ISO Plunge 90P



Anzahl Schneidkanten /
Wendeschneidplatte: 2
Number of cutting edges / insert: 2

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ISO 00P



Anzahl Schneidkanten /
Wendeschneidplatte: variabel
Number of cutting edges / insert: various
In INCH verfügbar / available in INCH
Seite 177, see page 177

VARIOtec 00P



Anzahl Schneidkanten /
Wendeschneidplatte: variabel
Number of cutting edges / insert: various

Seite 195, see page 195

ISO Plunge 90P

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Ausführung Execution	Aufsteckfräser Face milling cutter	Einschraubfräser Screw on type
		
Durchmesserbereich metrisch Diameter range metric	Ø 42 - 80 mm	Ø 32 - 42 mm
Plattengröße Insert size	VC.. 22	VC.. 22

Besondere Merkmale:

- Tauchfräswerkzeug speziell abgestimmt auf die Bearbeitung von NE-Metallen
- Hohe Eintauchwinkel durch spezielles Grundkörper Design realisierbar

Special features:

- Plunge milling tool specially adapted to the machining of non-ferrous metals
- High ramping in angels possible trough special design of cutter bodies

Eintauchwinkel Ramping angle



WSP Geometrie Insert geometry	VCGT 22	
	Schnitttiefe* Cutting depth* [mm] a _p max	Vorschub* Feed* [mm] f _z
MN	1,0 7,5 15,0	0,06 0,18 0,35

Durchmesser Fräser Diameter Milling cutter	Eintauchwinkel max. α Ramping angle α max. VCGT 22
Ø 32	35°
Ø 42	23°
Ø 52	17°
Ø 66	12,5°
Ø 80	10°

Abbildung der Wendeschneidplatten können vom Lagerartikel in Ausführung und Farbe abweichen!
Colours and execution of the original indexable inserts, may deviate from the illustration!

Schnittwertempfehlungen siehe Seite 202

Cutting data recommendations page 202

* 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°

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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 BCH30M
	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 %