

BETAtec 90P Feed

Multifunktional Multifunctional



90° Fräsparameter
90° Milling parameter

WSP Geometrie Insert geometry	LP.. 06		LD.. 10		LD.. 18	
	Schnitttiefe* Cutting depth* [mm] a_p max	Vorschub* Feed* [mm] f_z	Schnitttiefe* Cutting depth* [mm] a_p max	Vorschub* Feed* [mm] f_z	Schnitttiefe* Cutting depth* [mm] a_p max	Vorschub* Feed* [mm] f_z
MP	0,5 2,0 5,2	0,1 0,13 0,17	1,0 3,0 9,0	0,1 0,18 0,25	1,0 6,0 17,0	0,1 0,19 0,25
MM	0,5 2,0 5,2	0,08 0,10 0,15	1,0 3,0 9,0	0,1 0,15 0,20	1,0 6,0 17,0	0,1 0,15 0,22
MK	-	-	1,0 3,0 9,0	0,15 0,20 0,27	1,0 6,0 17,0	0,15 0,21 0,26
MN	-	-	1,0 3,0 9,0	0,1 0,14 0,26	1,0 6,0 17,0	0,1 0,14 0,26
MS	-	-	1,0 3,0 9,0	0,1 0,15 0,20	-	-
MH	0,3 2,0 5,2	0,08 0,10 0,15				
RP	-	-	-	-	1,0 6,0 17,0	0,15 0,22 0,28
RK	-	-	-	-	1,0 6,0 17,0	0,15 0,24 0,30

HFC Hochvorschub Fräsparameter
HFC High feed cutting parameter

WSP Geometrie Insert geometry	LP.. 06		LD.. 10	
	Schnitttiefe* Cutting depth* [mm] a_p max	Vorschub* Feed* [mm] f_z	Schnitttiefe* Cutting depth* [mm] a_p max	Vorschub* Feed* [mm] f_z
MPH	0,2 0,4 0,7	0,2 0,5 0,8	0,4 0,9 1,4	0,6 1,0 1,5
MMH	0,2 0,4 0,7	0,2 0,4 0,7	0,4 0,9 1,4	0,5 0,9 1,3
MKH	-	-	0,4 0,9 1,4	0,6 1,2 1,5
MHH	0,2 0,4 0,7	0,2 0,5 0,8	0,4 0,9 1,4	0,6 1,2 1,5

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.

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HFC Eintauchwinkel
HFC Ramping angle

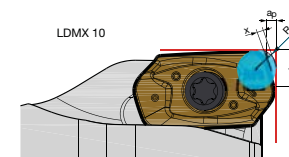


Durchmesser Fräser Diameter Milling cutter	Eintauchwinkel HFC-Fräser Ramping angle HFC milling cutter LP.. 06	Eintauchwinkel HFC-Fräser Ramping angle HFC milling cutter LD.. 10
Ø 10	6,3°	-
Ø 12	4,5°	-
Ø 16	3,5°	8,8°
Ø 18	-	7,3°
Ø 20	1,8°	6,1°
Ø 25	1,5°	4,4°
Ø 32	1,1°	3,2°
Ø 40	0,8°	2,4°
Ø 50	0,6°	1,9°
Ø 63	-	1,4°
Ø 80	-	1,1°

90° Eintauchwinkel
90° Ramping angle



Durchmesser Fräser Diameter Milling cutter	Eintauchwinkel 90°-Fräser Ramping angle 90° milling cutter LP.. 06	Eintauchwinkel 90°-Fräser Ramping angle 90° milling cutter LD.. 10	Eintauchwinkel 90°-Fräser Ramping angle 90° milling cutter LD.. 18
Ø 10	8,4°	-	-
Ø 12	6,3°	-	-
Ø 16	5,0°	18,0°	-
Ø 18	-	15,5°	-
Ø 20	2,3°	12,2°	-
Ø 25	1,8°	8,7°	-
Ø 32	1,3°	6,2°	-
Ø 40	1,0°	4,6°	5,0°
Ø 50	0,8°	3,5°	4,0°
Ø 63	-	2,7°	3,2°
Ø 66	-	-	2,9°
Ø 80	-	2,1°	2,5°
Ø 100	-	-	2,0°
Ø 125	-	-	1,6°
Ø 160	-	-	1,2°



Größe WSP Insert size	Abmessungen [mm] Dimensions [mm]		
L.M..	R_{th}	x	b
6	1,2	0,2	1,4
10	2,2	0,4	3,52

Schnittwertempfehlungen siehe Seite 148
Cutting data recommendations page 148

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
	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 %