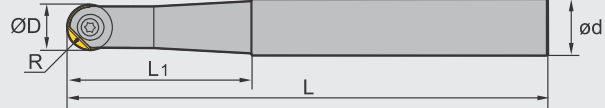




### Profile milling tools · Profilfräser

**BMR02** P M K



### Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen					Weight Gewicht (kg)
		R	Ø D	ø d	L	L <sub>1</sub>	
<b>BMR02</b>	●	6	12	16	110	40	0.1
	●	6	12	16	130	50	0.2
	●	6	12	16	160	50	0.2
	●	8	16	20	140	45	0.3
	●	8	16	20	170	65	0.3
	●	8	16	20	200	65	0.4
	●	10	20	25	160	60	0.5
	●	10	20	25	200	80	0.6
	●	10	20	25	240	80	0.8

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

### Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Wrench Schlüssel
Ø12	I90M4×09TT	WT10S
Ø16	I90M5×11TT	WT15S
Ø20	I90M5×13.5TT	WT15S



Applicable tool  
Werkzeug B11-B18

Tools code key  
Werkzeug ISO B26-B27

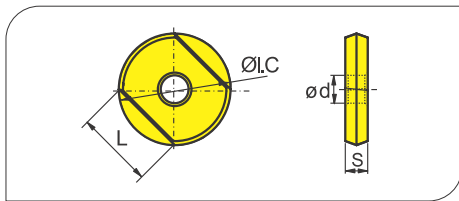
Grade selection guide  
Sortenauswahl B19-B23

Technical data  
Technische Daten B215-B220

# Milling · Fräsen

## Indexable Milling Tools · Wendepplattenfräser

### Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S
<b>P</b> Steel / Stahl	●	●	●	●	●
<b>M</b> Stainless Steel / Rostfreier Stahl	●	●	●	●	●
<b>K</b> Cast iron / Gusseisen	●	●	●	●	●
<b>N</b> Non-ferrous material / Ne Metalle	●	●	●	●	●
<b>S</b> 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	S	d	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152		YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201	
	<b>ROHX1203</b>	12	8.5	3	4																					
	<b>ROHX1604</b>	16	11.3	4	5																					
	<b>ROHX2005</b>	20	14.1	5	5																					

### Recommended Cutting data · Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten	Diameter / Durchmesser Ø D		
				Ø12	Ø16	Ø20
<b>P</b>	carbon steel / leg. Kohlenstoffstahl	YBG202 YBG252	V(m/min)	100~200	100~200	100~200
			fz(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
			apmax(mm)	0.8	1	1.25
	Alloy steel / Leg. Stahl		V(m/min)	80~180	80~180	80~180
			fz(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
			apmax(mm)	0.8	1	1.25
	Hardened steel / gehärteter Stahl		V(m/min)	60~100	60~100	60~100
			fz(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
			apmax(mm)	0.4	0.5	0.6
<b>M</b>	Stainless steel / Rostfreier Stahl	V(m/min)	70~150	70~150	70~150	
		fz(mm/z)	0.1~0.2	0.1~0.25	0.1~0.25	
		apmax(mm)	0.6	0.8	1	
		aemax(mm)	0.6	0.8	1	
<b>K</b>	Cast iron / Gusseisen	V(m/min)	160~300	160~300	160~300	
		fz(mm/z)	0.2~0.3	0.25~0.35	0.25~0.35	
		apmax(mm)	1	1.5	1.8	
		aemax(mm)	1	1.5	1.8	

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