

High Feed Chamfer Milling Heads - 3BC

- Toolholders P. 161 -164
- Cutting Data P. 188

Dimensions (mm)					
D	L2	d	AP	C	Angle Chamfer
10	5	6	3.4	4.0	30°
			2.0	2.7	45°
			1.15	2.3	60°
13		9	3.4	4.0	30°
			2.0	2.7	45°
			1.15	2.3	60°
16		11	4.3	5.0	30°
			2.5	3.5	45°
			1.4	2.8	60°



5 flutes
D: 10mm



7 flutes
D: 13mm



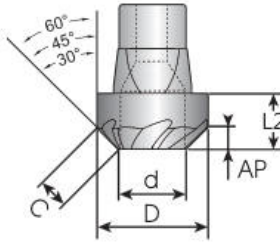
9 flutes
D: 16mm



D:10~15 D:16~25

Taper Polygon

3BC



Tolerances (mm)

D : +0.0
-0.01~-0.02 L2 : ± 0.03

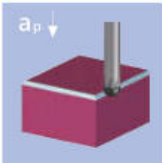
Milling Heads	Part No.	Grades								
		Carbide					Metal permet		Uncoated	
		B100	C200	C250	F20	F30	CE25	CE60	K10	CE
	3BC1005-30°-ME	★								
	3BC1005-45°-ME	★								
	3BC1005-60°-ME	★								
	3BC1305-30°-ME	★								
	3BC1305-45°-ME	★								
	3BC1305-60°-ME	★								
	3BC1605-30°-ME	★								
	3BC1605-45°-ME	★								
	3BC1605-60°-ME	★								
										 Inserts 6 PCS / Box

★ Applicable to all Materials

- Correct price and stock are based on current situation
- Please specify model number and grade of insert, ie.: 3BC1005-30° -ME,B100



Cutting Parameter **3BC**

3BC	Materials	D (mm)	Z	Vc (m/min)	fz (mm/tooth)	a _p (mm)	S (rev/min)	F (mm/min)
	Steel 24-32 HRC 	10	5	230	0.07	1C	7400	2600
		13	7	230	0.07	1C	5700	2800
		16	9	230	0.07	1C	4600	2900
	Steel 32-42 HRC 	10	5	130	0.06	1C	4200	1260
		13	7	130	0.06	1C	3250	1360
		16	9	130	0.06	1C	2650	1460
	Stainless steel 	10	5	180	0.06	1C	5800	1740
		13	7	180	0.06	1C	4500	1800
		16	9	180	0.06	1C	3600	1950
	Titanium alloy 	10	5	70	0.06	1C	2250	670
		13	7	70	0.06	1C	1750	730
		16	9	70	0.06	1C	1400	750
	Aluminum 	10	5	500	0.07	1C	16000	5600
		13	7	500	0.07	1C	12500	6100
		16	9	500	0.07	1C	10200	6400
	Cast iron 	10	5	75	0.07	1C	2400	840
		13	7	75	0.07	1C	1900	920
		16	9	75	0.07	1C	1500	950