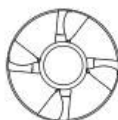


High Feed Milling Heads - 3BH

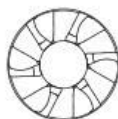
- Toolholders P. 161 -164
- Cutting Data P. 186



4 flutes
D:10-11mm



5 flutes
D:12-13mm



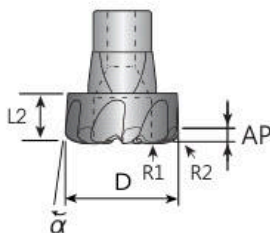
6 flutes
D:16-25mm



D:10~15 D:16~25

Taper Polygon

3BH



Tolerances (mm)

D : $\begin{matrix} +0.0 \\ -0.01 \sim -0.02 \end{matrix}$ L2 : ± 0.03

Dimensions (mm)						
D	L2	R1	R2	AP	α	
10	5	4	0.6	0.8	3°	
11						
12		5		0.9		
13						
16		6	0.8			
17						
20		8		1.2		
21						
25		12				

- $\varnothing 10-11$ Maximum AP 0.8mm
- $\varnothing 12-13$ Maximum AP 0.9mm
- $\varnothing 16-25$ Maximum AP 1.2mm

UFO MILL

Milling Heads	Part No.	Grades									
		Carbide					Metal cermet		Uncoated		
		B100	C200	C250	F20	F30	CE25	CE60	K10	CE	
	3BH1005-M										
	3BH1105-M										
	3BH1205-M										
	3BH1305-M										
	3BH1605-M										
	3BH1705-M										
	3BH2005-M										
	3BH2105-M										
	3BH2505-M										
											
Inserts 6 PCS / Box											

Inserts 6 PCS / Box

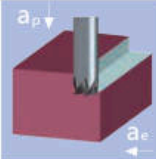
-  Steel /  Stainless steel /  Titanium alloy   
- Correct price and stock are based on current situation
- Please specify model number and grade of insert, ie.: 3BH1005-M, B100

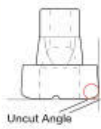


YIH TROUN ENTERPRISE CO., LTD

Cutting Parameter - 3BH

- Keep $Fz \geq 0.02\text{mm}$

3BH	Materials	D (mm)	Z	Vc (m/min)	fz (mm/tooth)	a _p (mm)	a _e (mm)	S (rev/min)	F (mm/min)
	Steel 24-32 HRC	10	4	200	0.25	0.3	6	6450	6400
		12	5	300	0.25	0.3	7	7900	9800
		16	6	300	0.25	0.3	10	6000	9000
		20	6	300	0.25	0.3	13	4800	8400
		25	6	300	0.25	0.3	16	3850	6700
	Steel 32-42 HRC 	10	4	100	0.25	0.3	6	3200	3200
		12	5	130	0.25	0.3	7	3400	4200
		16	6	130	0.25	0.3	10	2600	3900
		20	6	130	0.25	0.3	13	2100	3700
		25	6	130	0.25	0.3	16	1650	1900
	Stainless steel	10	4	160	0.25	0.3	6	5160	5160
		12	5	180	0.25	0.3	7	4700	5800
		16	6	180	0.25	0.3	10	3600	5400
		20	6	180	0.25	0.3	13	2900	5000
		25	6	180	0.25	0.3	16	2300	4000
	Titanium alloy 	10	4	60	0.3	0.3	6	1900	2280
		12	5	60	0.3	0.3	7	1600	2400
		16	6	60	0.3	0.3	10	1200	2160
		20	6	60	0.3	0.3	13	950	2000
		25	6	60	0.3	0.3	16	770	1600

3BH	Part No.	Max (mm)	r _p (mm)	Uncut Angle (mm)
	3BH1005-M	0.8	0.9	0.21
	3BH1105-M	0.8	0.9	0.21
	3BH1205-M	0.9	1.15	0.29
	3BH1305-M	0.9	1.15	0.29
	3BH1605-M	1.2	1.30	0.37
	3BH1705-M	1.2	1.30	0.37
	3BH2005-M	1.2	1.35	0.41
	3BH2105-M	1.2	1.35	0.41
	3BH2505-M	1.2	1.45	0.51

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



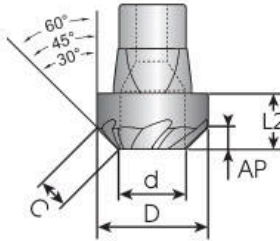
9 flutes
D: 16mm



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 cermet		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

