



Cooling 

Tolerance -

Coating BetaUni Iron

Strategy **UNI**

Application 

Features **HB**

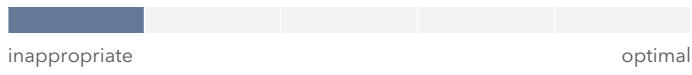
  
Basic



■ For universal chamfering of work pieces



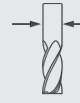



**Roughing**



**Finishing**



	D1  mm ∅	L1  mm	D2  mm ∅	z  #
BCU1-M09-0104				
6	6.0	50.0	6.0	4
8	8.0	58.0	8.0	4
10	10.0	66.0	10.0	4
12	12.0	73.0	12.0	4



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		Dimension	Ø6	Ø8	Ø10	Ø12						
		Infeed in mm	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max						
		Application										
Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz						
<b>P</b>		<b>Vc (m/min)</b>										
1.1-1.3	Steel, unalloyed	<850	110	0.035	0.045	0.055	0.065					
2.1-2.2	Steel, low-alloyed	<950	100	0.03	0.04	0.05	0.06					
3.1-3.2	Steel, high-alloyed	<1100	70	0.025	0.035	0.045	0.055					
<b>K</b>		<b>Vc (m/min)</b>										
1.1-1.2	Grey cast iron	<1000	95	0.03	0.04	0.05	0.06					
<b>M</b>		<b>Vc (m/min)</b>										
1.1	Inox, ferritic/martensitic	<850	75	0.023	0.032	0.042	0.05					
2.1	Inox, austenitic	<650	55	0.021	0.03	0.04	0.048					
<b>N</b>		<b>Vc (m/min)</b>										
1.1-2.3	Alu, alloyed, casted	<600	280	0.04	0.05	0.06	0.07					
3.1-3.3	Cooper, alloyed	<600	150	0.03	0.04	0.05	0.06					
<b>T</b>		<b>Vc (m/min)</b>										
2.1-2.2	Titanium, pure, alloyed	<1000	40	0.021	0.03	0.04	0.048					
<b>S</b>		<b>Vc (m/min)</b>										
1.1-1.3	Super alloys	<1450	30	0.018	0.026	0.035	0.042					

**NOTE** | The values marked in turquoise are side applications!

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