

Cooling

Tolerance -

Coating BetaUni Iron

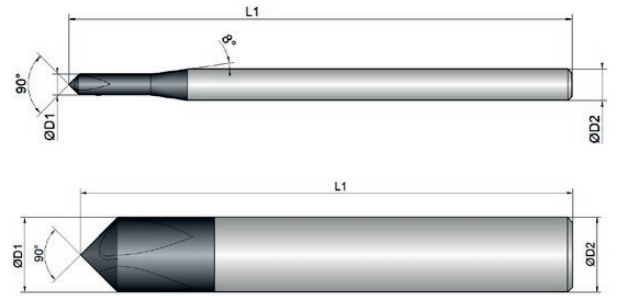
Strategy **UNI**

Application

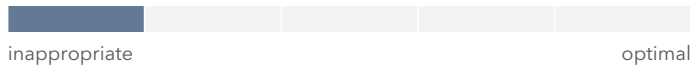
Features **HA**

Basic

■ For universal chamfering of work pieces



Roughing











Finishing



	D1 mm ∅	L1 mm	D2 mm ∅	z #
BCU1-M09-0153				
2	2.0	50.0	3.0	3
3	3.0	50.0	3.0	3
4	4.0	50.0	4.0	4
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
16	16.0	82.0	16.0	4



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		Dimension	Ø2	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø16		
		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	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 ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz		
P			Vc (m/min)									
1.1-1.3	Steel, unalloyed	<850	110	0.014	0.018	0.024	0.035	0.045	0.055	0.065	0.09	
2.1-2.2	Steel, low-alloyed	<950	100	0.012	0.015	0.02	0.03	0.04	0.05	0.06	0.08	
3.1-3.2	Steel, high-alloyed	<1100	70	0.01	0.012	0.016	0.025	0.035	0.045	0.055	0.07	
K			Vc (m/min)									
1.1-1.2	Grey cast iron	<1000	95	0.012	0.015	0.02	0.03	0.04	0.05	0.06	0.08	
M			Vc (m/min)									
1.1	Inox, ferritic/martensitic	<850	75	0.01	0.011	0.015	0.023	0.032	0.042	0.05	0.065	
2.1	Inox, austenitic	<650	55	0.009	0.01	0.014	0.021	0.03	0.04	0.048	0.062	
N			Vc (m/min)									
1.1-2.3	Alu, alloyed, casted	<600	280	0.022	0.025	0.03	0.04	0.05	0.06	0.07	0.1	
3.1-3.3	Cooper, alloyed	<600	150	0.012	0.015	0.02	0.03	0.04	0.05	0.06	0.08	
T			Vc (m/min)									
2.1-2.2	Titanium, pure, alloyed	<1000	40	0.009	0.01	0.014	0.021	0.03	0.04	0.048	0.062	
S			Vc (m/min)									
1.1-1.3	Super alloys	<1450	30	0.007	0.008	0.012	0.018	0.026	0.035	0.042	0.055	

NOTE | The values marked in turquoise are side applications!