

INSERTS FOR BFC TYPE

Machining Materials	GRADE			
	OM4025			
P	△			
M	△			
K	△			
N				
S				
H				

TYPE	GRADE		DIMENSION			
	OM4025		d	i	s	r
BR08S(P3204-D08)	V		8	3	2	-
BR10S(P3204-D10)	V		10	4	2.5	-
BR12S(P3204-D12)	V		12	5	2.5	-
BR16S(P3204-D16)	V		16	5	3	-
BR20S(P3204-D20)	V		20	5	3	-
BR25S(P3204-D25)	V		25	6	4	-

Cutting Conditions

Machining Materials		Grade	Vc(m/min)	fz(mm/rev)
P	Low-Alloy Steels	OM4025	180 ~ 220	0.08 ~ 0.19
	Alloy Steels	OM4025	100 ~ 120	0.06 ~ 0.12
M	Stainless Steels	OM4025	155 ~ 190	0.08 ~ 0.12
K	Cast Iron	OM4025	110 ~ 143	0.09 ~ 0.11

Product information:

- ▶ Spindle Revolution = (1000 × cutting speed) ÷ (3.14 × the external dia. of cutting tool)
- ▶ Table feed(mm/min) = table feed of each tooth × total teeth of cutting tool × spindle revolution