

## B.F. SERVICE



TORNITURA  
TURNING  
TOURNAGE  
DREHEN  
DRAAIEN

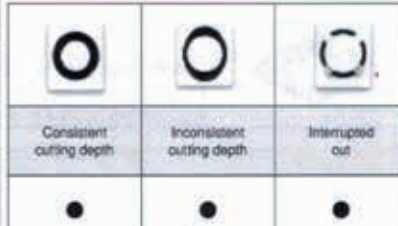

ROMPITRUCCIOLO  
CHIP BREAKER  
BRISE COPEAUX  
SPANBRECHER  
SPAANBREKER

# HD8



● = A MAGAZZINO \ IN STOCK

DESCRIZIONE	GRADO BFC115N	GRADO BFC125N	GRADO BFC135N
			
CNMM 190616SN HD8		●	
CNMM 190624SN HD8		●	
CNMM 250924SN HD8		●	
CNMM 250932SN HD8		●	
			
SNMM 190616SN HD8		●	
SNMM 190624SN HD8		●	
SNMM 250924SN HD8		●	
SNMM 250932SN HD8		●	

General cutting parameters depending on the application									
Work piece material	Type of treatment/ally	Hardness HB	Coated carbide			Application	Depth of cut and feed rate		
			BFC115N	BFC125N	BFC135N		Chip groove	ap [mm]	f (mm)
P	Non alloyed steel 0 - 0.45 % C	150 – 250	220 – 400	170 – 240	170 – 190	HD8	2.5 to 12.0	1.20 to 0.35	
	Low alloyed steel	250 – 300	200 – 320	100 – 190	90 • 150				
	High alloyed steel	200	180 – 320	130 – 210	120 – 200				
	Corrosion resistant steel	200	200 – 320	130 – 210	140 – 180				
M	Ferritic	200	220 – 320	140 – 210	140 – 200				
	Austenitic	180	–	100 – 210	110 – 190				
	Duplex	230 – 260	–	–	80 – 150				
	Martensitic	330	–	70 – 100	55 – 75				
K	Grey cast iron	180	140 – 370	130 – 210	–				
	Spheroidal	160	190 – 430	120 – 240	–				
	Malleable/Tempered iron	130	180 – 520	150 – 250	–				