

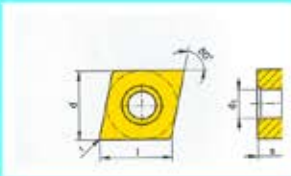


BF SERVICE
UTENSILERIA MECCANICA

WM+

**NEW GRADE
BFC125H!!**

ROMPITRUCCIOLO
CHIP BREAKER
BRISE COPEAUX
SPANBRECHER
SPAANBREKER

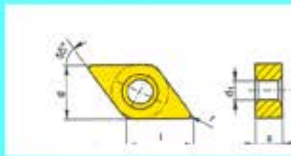
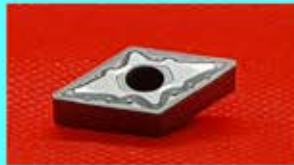


CNMG 120408 WM+ BFC125H

d=12,70 I=12,90 s=4,76 r=0,8 d1=5,16

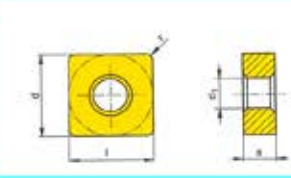
CNMG 120412 WM+ BFC125H

d=12,70 I=12,90 s=4,76 r=1,2 d1=5,16



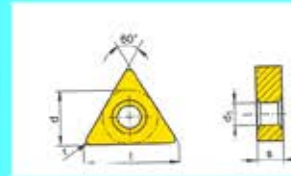
DNMG 150608 WM+ BFC125H

d=12,70 I=15,50 s=6,35 r=0,8 d1=5,16



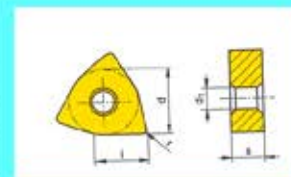
SNMG 120408 WM+ BFC125H

d=12,70 I=12,70 s=4,76 r=0,8 d1=5,16



TNMG 160408 WM+ BFC125H

d=9,52 I=16,50 s=4,76 r=0,8 d1=3,81



WNMG 080408 WM+ BFC125H

d=12,70 I=8,69 s=4,76 r=0,8 d1=5,16

WNMG 080412 WM+ BFC125H

d=12,70 I=8,69 s=4,76 r=1,2 d1=5,16

Work piece material	Type of treatment/alloy	Hardness HB	v _c [m/min]	Application	Depth of cut and feed rate	
				Chip groove	a _p [mm]	f [mm]
P Steel	Non alloyed steel 0 - 0.45 % C	150 - 250	170 - 270	WM+	1 to 4	0.44 to 0.22
	Low alloyed steel	250 - 300	100 - 210	Ex: CNMG 120408-WM+ for CK80 Different in each application		
	High alloyed steel	200	130 - 230			
	Corrosion resistant steel	200	130 - 230			
M Stainless steel	Ferritic	200	140 - 210			
	Austenitic	180	100 - 210			
	Duplex	230 - 260	-			
	Martensitic	330	70 - 100			
N Cast iron	Grey cast iron	180	130 - 210			
	Spheroidal	180	120 - 240			
	Malleable/Tempered iron	130	150 - 250			

GRADE BFC125H