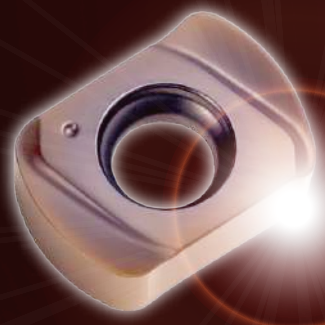
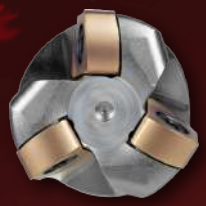
CMTéc



4 Corners Double-Sided

超快桿



BNMX HIGH FEED MILLING

EFFICIENCY | LONG LIFE | DOUBLE-SIDED

Features

1 Productivity- High feed rates with axial depth of cut up to 1mm.

2 High Feed Milling- Increase chip removal capability and productivity.

3 Low cutting resistance and outstanding anti-vibration for high efficiency milling.

4 Taiwan self-made low friction coefficient inserts feature excellent chip disposal.

5 Diameter 16~100mm are offered, for all components and mold high feed machining.

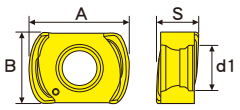
Performance Test

BNMX INSERT

HIGH EFFICIENCY & HIGH FEED MILLING INSERT

CARBIDE INSERT SIZE

P	Alloy Steels	◎	◎	◎	◎	◎	◎ : First Recommend ○ : Second Recommend – : NO Recommend
M	Stainless Steels	◎	◎	◎	◎	◎	
K	Cast Iron	◎	◎	◎	◎	◎	
N	Aluminum Alloys	–	–	–	–	–	F : Finishing S : Semi Finishing M : Medium R : Roughing
S	High Temp Alloys	○	◎	○	◎	◎	
H	Hardened Steels	◎	◎	○	◎	–	

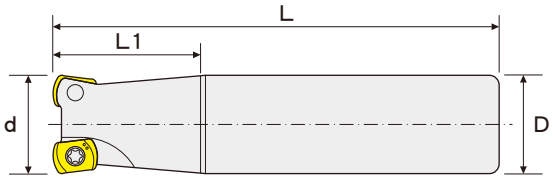
Insert	Order No.	Grade					Dimension (mm)					Drawing
		CM6322	CM6223	CM6332	CM6233	CM6243	A	B	S	r	d1	
T	BNMX0603-SG	●	●	●	●	●	9.00	6.38	3.75	–	3.20	
F S M R												
T	BNMX0603-MG	●	●	●	●	●	9.00	6.38	3.75	–	3.20	
F S M R												
T	BNMX0603-RG	●	●	●	●	●	9.00	6.38	3.75	–	3.20	
F S M R												
T NEW	BNMX0904-MG	●	●	●	●	●	11.9	9.18	4.80	–	4.20	
F S M R												

MILLING INSERT GRADES

Grade Type	Coating Type	Features	Application	Work Material						Industry Area
				P	M	K	N	S	H	
CM6322	PVD	· High wear resistance.	· Continuous finishing cutting. · For hardened steel and cast iron.	◎	◎	◎	–	○	◎	· Mold & die. · Hardened parts. · Aircraft parts.
CM6223 Upgrade				◎	◎	◎	–	◎	◎	
CM6332	PVD	· Wear resistance . · Impact resistance.	· Medium finishing. · For carbon steel, alloy steel, stainless steel and high temperature alloy.	◎	◎	◎	–	○	○	· Auto parts. · Machinery parts. · Aircraft parts.
CM6233 Upgrade				◎	◎	◎	–	◎	◎	
CM6243	PVD	· High impact resistance. · High toughness.	· Roughing or interrupted cutting. · For carbon steel, alloy steel, stainless steel and high temperature alloy.	◎	◎	◎	–	◎	–	· Auto parts. · Machinery parts. · Aircraft parts.

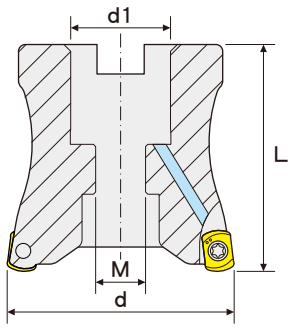
◎ : First Recommend ○ : Second Recommend – : NO Recommend

HIGH FEED MILLING CUTTERS



EBN

Order No.	Dimensions (mm)				Teeth	Insert	Screw	Wrench
	d	L1	L	D				
EBN06-02016-150L	16	30	150	16	2	BNMX0603..	TS3016	ETF08
EBN06-02016-200L	16	30	200	16	2			
EBN06-02017-150L	17	30	150	16	2			
EBN06-02017-200L	17	30	200	16	2			
EBN06-03020-150L	20	30	150	20	3			
EBN06-03020-200L	20	30	200	20	3			
EBN06-03021-150L	21	30	150	20	3			
EBN06-03021-200L	21	30	200	20	3			
EBN06-04025-150L	25	35	150	25	4			
EBN06-04025-200L	25	35	200	25	4			
EBN06-04026-150L	26	35	150	25	4			
EBN06-04026-200L	26	35	200	25	4			
EBN06-05032-150L	32	40	150	32	5			
EBN06-05032-200L	32	40	200	32	5			
EBN06-05033-150L	33	40	150	32	5			
EBN06-05033-200L	33	40	200	32	5			
EBN06-05035-150L	35	40	150	32	5			
EBN06-05035-200L	35	40	200	32	5			
EBN09-03025-150L	25	40	150	25	3	BNMX0904..	TS4009	ETF15
EBN09-03032-150L	32	40	150	32	3			

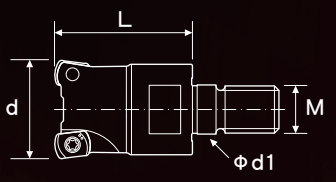


FBN

Order No.	Dimensions (mm)				Teeth	Insert	Screw	Wrench
	d	L	d1	M				
FBN06-07050-2200-C	50	50	22.00	–	7	BNMX0603..	MS2506E	ETF08
FBN06-07052-2200-C	52	50	22.00	–	7			
FBN09-06050-2200-C	50	50	22.00	–	6	BNMX0904..	TS3504	ETF15
FBN09-06052-2200-C	52	50	22.00	–	6			
FBN09-07063-2200-C	63	50	22.00	–	7		TS4009	
FBN09-07063-2700-C	63	50	27.00	–	7		TS3504	
FBN09-07066-2700-C	66	50	27.00	–	7			
FBN09-08080-2700-C	80	50	27.00	–	8			
FBN09-10100-3200-C	100	50	32.00	–	10			

※ Product number end in -C are coolant-through design.

HIGH FEED MILLING CUTTERS



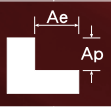
HBN

Order No.	Dimensions (mm)				Teeth	Insert	Screw	Wrench
	d	L	d1	M				
HBN06-02016	16	25	8.5	M8	2	BNMX0603..	TS3016	ETF08
HBN06-02017	17	25	8.5	M8	2			
HBN06-03020	20	30	10.5	M10	3			
HBN06-03021	21	30	10.5	M10	3			
HBN06-04025	25	35	12.5	M12	4			
HBN06-04026	26	35	12.5	M12	4			
HBN06-04032	32	40	17.0	M16	4			
HBN06-05032	32	40	17.0	M16	5			
HBN06-04035	35	43	17.0	M16	4			
HBN06-05035	35	43	17.0	M16	5			
HBN06-06040	40	43	17.0	M16	6			
HBN06-06042	42	43	17.0	M16	6			
HBN09-03025-C	25	35	12.5	M12	3	BNMX0904..	TS4009	ETF15
HBN09-04032-C	32	40	17.0	M16	4			
HBN09-04035-C	35	43	17.0	M16	4			
HBN09-05042-C	42	43	17.0	M16	5			

※ Product number end in -C are coolant-through design.

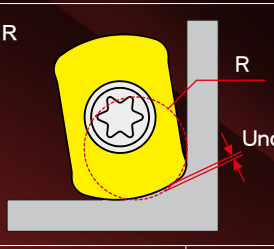
CUTTING CONDITION TABLE

Material	Carbon Steels	Hardened Steels	Stainless Steels	Cast Iron	High Temp Alloys
Material Code	S35C,S45C,S50C	SKT,SKD	SUS304	FC,FCD	Ti-6Al-4V
Hardness	HRC<40	HRC40~55	—	HRC<30	HRC<30
Vc	120~250m/min	50~120m/min	100~180m/min	120~250m/min	50~100m/min
fz (mm)	0.3~1.6	0.3~1.0	0.3~1.2	0.3~1.6	0.3~0.8
Ap (mm)	0.3~0.9	0.3~0.7	0.3~0.9	0.3~0.9	0.3~0.7
Remarks	※ Recommended cutting width(Ae) for face milling is less than 80% of diameter.				

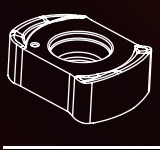


※ Cutting formula：S = Vc × 1000 / D / π (3.14)　　F = fz × Z × S

Programming- Corner R



Insert	nput. R	Uncut
BNMX0603	2.0 mm	0.42 mm
BNMX0904	2.5 mm	0.61 mm



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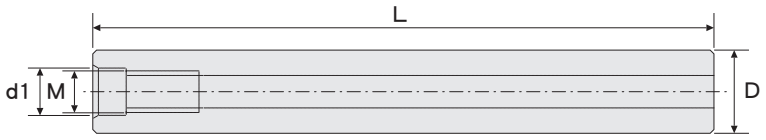
鎢鋼抗震刀桿

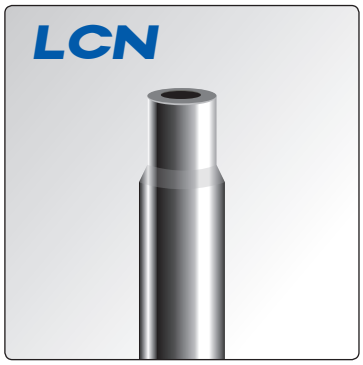
CARBIDE ANTI-VIBRATION HOLDER

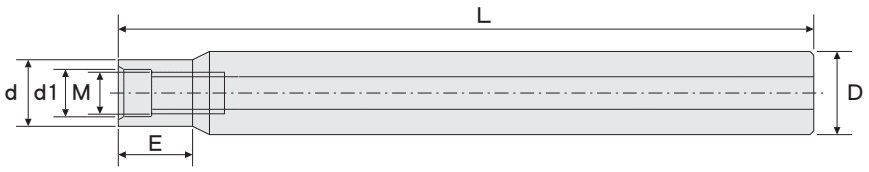


訂購編號 Order No.	尺寸 Dimensions (mm)			
	螺紋 Thread	柄徑 D	d1	全長 L
LCL008-060L	M4 × 0.7	8	4.5	60
LCL008-100L	M4 × 0.7	8	4.5	100
LCL008-120L	M4 × 0.7	8	4.5	120
LCL010-075L	M5 × 0.8	10	5.5	75
LCL010-100L	M5 × 0.8	10	5.5	100
LCL010-150L	M5 × 0.8	10	5.5	150
LCL012-075L	M6 × 1.0	12	6.5	75
LCL012-100L	M6 × 1.0	12	6.5	100
LCL012-150L	M6 × 1.0	12	6.5	150
LCL012-200L	M6 × 1.0	12	6.5	200
LCL016-100L	M8 × 1.25	16	8.5	100
LCL016-150L	M8 × 1.25	16	8.5	150
LCL016-200L	M8 × 1.25	16	8.5	200
LCL016-250L	M8 × 1.25	16	8.5	250
LCL020-100L	M10 × 1.5	20	10.5	100
LCL020-150L	M10 × 1.5	20	10.5	150
LCL020-200L	M10 × 1.5	20	10.5	200
LCL020-250L	M10 × 1.5	20	10.5	250
LCL020-300L	M10 × 1.5	20	10.5	300
LCL025-100L	M12 × 1.75	25	12.5	100
LCL025-150L	M12 × 1.75	25	12.5	150
LCL025-200L	M12 × 1.75	25	12.5	200
LCL025-250L	M12 × 1.75	25	12.5	250
LCL025-300L	M12 × 1.75	25	12.5	300
LCL032-100L	M16 × 2.0	32	17.0	100
LCL032-150L	M16 × 2.0	32	17.0	150
LCL032-200L	M16 × 2.0	32	17.0	200
LCL032-250L	M16 × 2.0	32	17.0	250
LCL032-300L	M16 × 2.0	32	17.0	300

鎢鋼抗震刀桿 - 頸型

CARBIDE ANTI-VIBRATION HOLDER- NECK





訂購編號 Order No.	尺寸 Dimensions (mm)					
	螺紋 Thread	刃徑 d	d1	有效長 E	全長 L	柄徑 D
LCN011-075L-030E	M6 × 1.0	11.7	6.5	30	75	12
LCN011-100L-040E	M6 × 1.0	11.7	6.5	40	100	12
LCN011-150L-050E	M6 × 1.0	11.7	6.5	50	150	12
LCN015-100L-040E	M8 × 1.25	15.7	8.5	40	100	16
LCN015-150L-050E	M8 × 1.25	15.7	8.5	50	150	16
LCN019-100L-040E	M10 × 1.5	19.5	10.5	40	100	20
LCN019-150L-050E	M10 × 1.5	19.5	10.5	50	150	20
LCN019-200L-060E	M10 × 1.5	19.5	10.5	60	200	20
LCN024-100L-040E	M12 × 1.75	24.5	12.5	40	100	25
LCN024-150L-050E	M12 × 1.75	24.5	12.5	50	150	25
LCN024-200L-060E	M12 × 1.75	24.5	12.5	60	200	25
LCN024-250L-080E	M12 × 1.75	24.5	12.5	80	250	25
LCN031-100L-040E	M16 × 2.0	31.5	17.0	40	100	32
LCN031-150L-050E	M16 × 2.0	31.5	17.0	50	150	32
LCN031-200L-060E	M16 × 2.0	31.5	17.0	60	200	32
LCN031-250L-080E	M16 × 2.0	31.5	17.0	80	250	32