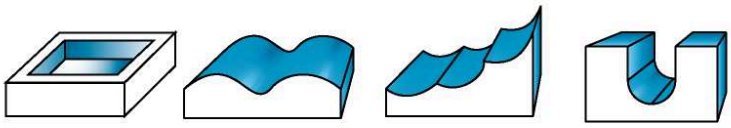
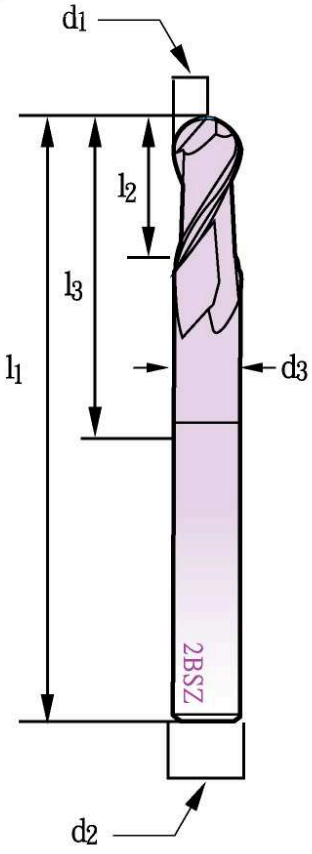
# 2BSZ

mm

| Order Code | ⌀ $d_1$ (e8/h10) | $l_2$ | $l_3$ | $l_1$ | ⌀ $d_3$ | ⌀ $d_2$ (h6) |
|---|---|---|---|---|---|---|
| 2BSZ010 | R0.5 | 1.0 | 2.5 | 38 | 0.8 | 3.0 |
| 2BSZ015 | R0.75 | 1.5 | 4 | 38 | 1.3 | 3.0 |
| 2BSZ020 | R1 | 2.0 | 5 | 38 | 1.8 | 3.0 |
| 2BSZ030 | R1.5 | 3.0 | 8 | 50 | 2.8 | 6.0 |
| 2BSZ040 | R2 | 4.0 | 10 | 50 | 3.8 | 6.0 |
| 2BSZ050 | R2.5 | 5.0 | 13 | 50 | 4.8 | 6.0 |
| 2BSZ060 | R3 | 6.0 | 15 | 50 | 5.8 | 6.0 |
| 2BSZ070 | R3.5 | 7.0 | 16 | 60 | 6.8 | 8.0 |
| 2BSZ080 | R4 | 8.0 | 20 | 60 | 7.7 | 8.0 |
| 2BSZ100 | R5 | 10.0 | 25 | 75 | 9.7 | 10.0 |
| 2BSZ120 | R6 | 12.0 | 30 | 75 | 11.7 | 12.0 |
| 2BSZ160 | R8 | 16.0 | 40 | 100 | 15.7 | 16.0 |

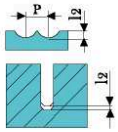



| $d_1$ | tol |
|---|---|
| 0.2-2.0 | e8 |
| 2.0-16.0 | h10 |

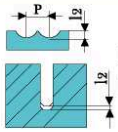
## 2BSZ Recommendations for Cutting Conditions

| WORK Material | S45C,P20S,FCD | | SUS403,SKD11,SCr | | Ti-6A1-4V PRE/HARDENED STEELS | |
|---|---|---|---|---|---|---|
| Order Code | <HRC30 | | <HRC30-45 | | <HRC45-65 | |
| | R.P.M. | Feed | R.P.M. | Feed | R.P.M. | Feed |
| 2BSZ010 | 35000 | 1400 | 32000 | 1280 | 30000 | 1200 |
| 2BSZ015 | 30000 | 1930 | 29000 | 1870 | 28000 | 1800 |
| 2BSZ020 | 28000 | 2150 | 27000 | 2070 | 26000 | 2000 |
| 2BSZ030 | 26000 | 3030 | 25000 | 2910 | 24000 | 2800 |
| 2BSZ040 | 22000 | 3300 | 21000 | 3150 | 20000 | 3000 |
| 2BSZ050 | 21000 | 3150 | 20000 | 3000 | 19000 | 2850 |
| 2BSZ060 | 20000 | 3330 | 19000 | 3160 | 18000 | 3000 |
| 2BSZ070 | 19000 | 3160 | 18000 | 3000 | 17000 | 2830 |
| 2BSZ080 | 18000 | 4500 | 17000 | 4250 | 16000 | 4000 |
| 2BSZ100 | 16000 | 4570 | 15000 | 4280 | 14000 | 4000 |
| 2BSZ120 | 15500 | 4420 | 14500 | 4140 | 13500 | 3850 |
| 2BSZ160 | 9000 | 1900 | 8800 | 1860 | 8500 | 1800 |

Max Milling Volume




$l_2$<0.02R
P<0.02R




$l_2$<0.02R
P<0.025R