

Carbide C Chamfering Cutter "Front/Back"

Solid Carbide Front/Back Chamfering Series

BCM / WCM

Uncoated Carbide C Chamfering Cutter for Aluminum BCM/WCM ※ << Resin >> machining is possible ※

Model number		Tip diameter	Tip length	Recess diameter	Recess length	Effective blade length	Number of flutes	Shank diameter	Overall length	Applicable range
		D1	L1	D2	L2	H		D S	L	
①	BCM45-1.05-0.35-3.5	1.05	1.05	0.35	3.5	0.3	3	3	50	M1.4
②	BCM45-1.2-0.45-3.5	1.2	1.2	0.45	3.5	0.325	3	3	50	M1.6 ~ M1.7
③	BCM45-1.2-0.45-5				5					
④	BCM45-1.3-0.5-3.5	1.3	1.3	0.5	3.5	0.35	3	3	50	M1.7 ~ M2.
⑤	BCM45-1.3-0.5-5				5					
⑥	BCM45-1.8-0.8-5	1.8	1.8	0.8	5	0.45	3	3	50	M2.3 ~ M2.6
⑦	BCM45-2.4-1.0-10	2.4	2.4	1	10	0.65	3	3	50	M3. ~ M4.
⑧	BCM45-4.0-2.0-15	4	4	2	15	0.95	3	4	50	M5. ~ M6.
⑨	WCM45-5.0-2.8-20	5	5	2.8	20	1.05	3 (Staggered blades)	6	60	M7. ~
⑩	WCM45-8.0-4.8-25	8	8	4.8	25	1.55	3 (Staggered blades)	8	70	M10. ~



Recommended cutting conditions

Model number	Cutting speed (m/min)	Number of revolutions (min^-1)	Feed rate (mm/blade)	Feeding speed (mm/min)	Cut direction
BCM45-1.05-0.35-3.5	10	S4200	0.010	F130	Downward
BCM45-1.2-0.45-3.5/5	20	S7700	0.010	F231	Downward
BCM45-1.3-0.5-3.5/5	20	S7000	0.015	F315	Downward
BCM45-1.8-0.8-5	30	S7300	0.015	F329	Downward
BCM45-2.4-1.0-10	40	S7500	0.015	F338	Downward
BCM45-4.0-2.0-15	15 ~ 35	×	~ 0.02	×	Downward
WCM45-5.0-2.8-20	15 ~ 35	×	~ 0.02	×	Downward
WCM45-8.0-4.8-25	15 ~ 35	×	~ 0.02	×	Downward

TITAN-BCM / WCM

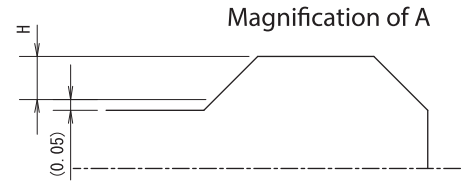
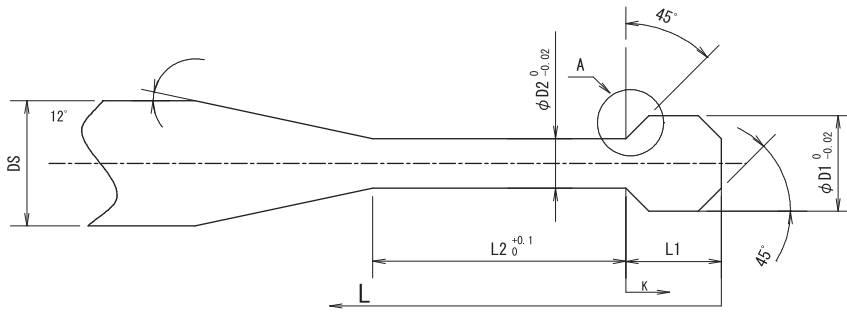
Uncoated Carbide C Chamfering Cutter for Titanium TITAN-BCM/WCM

Model number		Tip diameter	Tip length	Recess diameter	Recess length	Effective blade length	Number of flutes	Shank diameter	Overall length
		D1	L1	D2	L2	H		D S	L
①	TITAN-BCM45-1.3-0.8-3.5	1.3	1.3	0.8	3.5	0.2	3	3	60
②	TITAN-BCM45-1.3-0.8-5				5				
③	TITAN-BCM45-2.3-1.2-4	2.3	2.3	1.2	4	0.5	3	3	60
④	TITAN-BCM45-2.3-1.2-6				6				
⑤	TITAN-WCM45-3.8-2.0-5	3.8	2.3	2	5	0.85	3 (Staggered blades)	4	60
⑥	TITAN-WCM45-3.8-2.0-10				10				
⑦	TITAN-WCM45-5.0-2.8-10	5	4	2.8	10	1.05	3 (Staggered blades)	6	60
⑧	TITAN-WCM45-5.0-2.8-15				15				
⑨	TITAN-WCM45-5.0-2.8-20				20				
⑩	TITAN-WCM45-8.0-4.8-15	8	6	4.8	15	1.55	3 (Staggered blades)	8	60
⑪	TITAN-WCM45-8.0-4.8-20				20				70
⑫	TITAN-WCM45-8.0-4.8-25				25				



Recommended cutting conditions

Model number	Cutting speed (m/min) front/back	Number of revolutions (min^-1) front/back	Feed rate (mm/blade) front/back	Feeding speed (mm/min) front/back	Cut direction
TITAN-BCM45-1.3-0.8-3.5/5	5/10	S1500/S3000	0.030	F135/F270	Downward
TITAN-BCM45-2.3-1.2-4/6	10/15	S1800/S2700	0.030	F162/F243	Downward
TITAN-WCM45-3.8-2.0-5/10	15	S1600	0.020	F100	Downward
TITAN-WCM45-5.0-2.8-10/15/20	15	S1200	0.020	F72	Downward
TITAN-WCM45-8.0-4.8-15/20/25	15	S750	0.020	F45	Downward



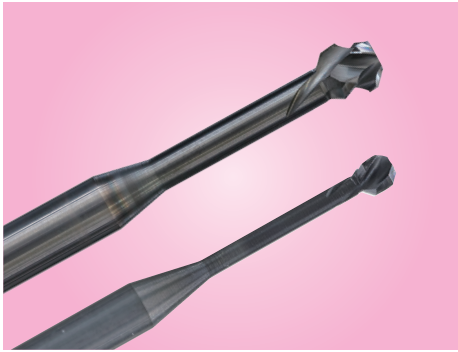
K = Cutting Edge

Coated

Carbide C Chamfering Cutter for Stainless Steel SUS-BCM/WCM

SUS-BCM / WCM

Model number		Tip diameter D1	Tip length L1	Recess diameter D2	Recess length L2	Effective blade length H	Number of flutes	Shank diameter D S	Overall length L
①	SUS-BCM45-1.3-0.8-3.5	1.3	1.3	0.8	3.5	0.2	3	3	50
②	SUS-BCM45-1.3-0.8-5				5				
③	SUS-BCM45-2.3-1.2-6	2.3	2.3	1.2	6	0.5	3	3	50
④	SUS-BCM45-2.3-1.2-8				8				
⑤	SUS-BCM45-2.3-1.2-10				10				
⑥	SUS-BCM45-3.8-2.0-8	3.8	3.8	2	8	0.85	3	4	50
⑦	SUS-BCM45-3.8-2.0-10				10				
⑧	SUS-BCM45-3.8-2.0-15				15				
⑨	SUS-WCM45-5.0-2.8-10	5	5	2.8	10	1.05	3 (Staggered blades)	6	50
⑩	SUS-WCM45-5.0-2.8-15				15				60
⑪	SUS-WCM45-5.0-2.8-20				20				60
⑫	SUS-WCM45-8.0-4.8-15	8	8	4.8	15	1.55	3 (Staggered blades)	8	60
⑬	SUS-WCM45-8.0-4.8-20				20				70
⑭	SUS-WCM45-8.0-4.8-25				25				70



Recommended cutting conditions

Model number	Cutting speed (m/min) front/back	Number of revolutions (min ⁻¹) front/back	Feed rate (mm/blade) front/back	Feeding speed (mm/min) front/back	Cut direction
SUS-BCM45-1.3-0.8-3.5/5	5/10	S1500/S3000	0.015	F70/F135	Downward
SUS-BCM45-2.3-1.2-6/8/10	10/15	S1800/S2700	0.015	F80/F125	Downward
SUS-BCM45-3.8-2.0-8/10/15	10/20	S1100/S2200	0.015	F50/F100	Downward
SUS-WCM45-5.0-2.8-10/15/20	20	S1600	0.015	F75	Downward
SUS-WCM45-8.0-4.8-15/20/25	20	S1000	0.015	F45	Downward

Coated

Carbide C Chamfering Cutter for General Steel STEEL-BCM/WCM

STEEL-BCM / WCM

Model number		Tip diameter D1	Tip length L1	Recess diameter D2	Recess length L2	Effective blade length H	Number of flutes	Shank diameter D S	Overall length L
①	STEEL-BCM45-1.3-0.8-3.5	1.3	1.3	0.8	3.5	0.2	3	3	60
②	STEEL-BCM45-1.3-0.8-5				5				
③	STEEL-BCM45-2.3-1.2-4	2.3	2.3	1.2	4	0.5	3	3	60
④	STEEL-BCM45-2.3-1.2-6				6				
⑤	STEEL-WCM45-3.8-2.0-5				5	0.85	3 (Staggered blades)	4	60
⑥	STEEL-WCM45-3.8-2.0-10	3.8	2.8	2	10				
⑦	STEEL-WCM45-3.8-2.0-10				10				
⑧	STEEL-WCM45-5.0-2.8-15				15	1.05	3 (Staggered blades)	6	60
⑨	STEEL-WCM45-5.0-2.8-20	5	5	2.8	20				
⑩	STEEL-WCM45-8.0-4.8-15				15	1.55	3 (Staggered blades)	8	60
⑪	STEEL-WCM45-8.0-4.8-20	8	8	4.8	20				
⑫	STEEL-WCM45-8.0-4.8-25				25				70



Recommended cutting conditions

Model number	Cutting speed (m/min)	Number of revolutions (min ⁻¹)	Feed rate (mm/blade) front/back	Feeding speed (mm/min) front/back	Cut direction
STEEL-BCM45-1.3-0.8-3.5/5	7.5	S2170	0.03 / 0.05	F195 / F326	Downward
STEEL-BCM45-2.3-1.2-4/6	15	S2700	0.03 / 0.05	F243 / F405	Downward
STEEL-WCM45-3.8-2.0-5/10	15	S1600	0.100	F480	Downward
STEEL-WCM45-5.0-2.8-10/15/20	30	S2417	0.050	F363	Downward
STEEL-WCM45-8.0-4.8-15/20/25	30	S1480	0.050	F222	Downward