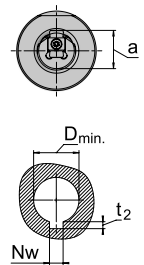
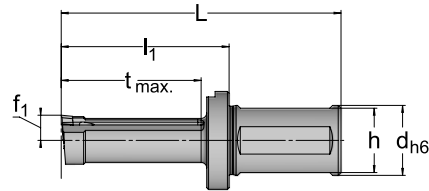


BROACHING TOOLS

BR20

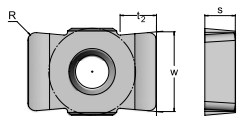


Double-cutting edge indexable insert
 Best cutting and gliding characteristics
 High cutting values even at low machine performance levels
 Highly stable cutting edge support
 Polished precision indexable inserts
 Internal cooling



BR20													INS
Article	Nw	t ₂	d _{h6}	h	L	l ₁	t _{max}	D _{min}	f ₁	a	lc	kg	
17BR.1604.001	4C11	2.1	25	23	80	40	30	14	7.0	14.05	yes	0.2	BR.15T3.007.01
17BR.2206.001	6C11	2.6	25	23	100	60	50	18	9.0	16.85	yes	0.28	BR.15T3.007.02
17BR.2707.001	7C11	3.3	25	23	100	60	50	19	9.0	18.15	yes	0.3	BR.15T3.007.03
17BR.3208.001	8C11	3.4	25	23	100	60	50	24	11.25	22.0	yes	0.3	BR.2005.007.01
17BR.4010.001	10C11	4.2	32	30	102	62	52	26.5	13.0	25.21	yes	0.5	BR.2504.007.01
17BR.5012.001	12C11	5.1	32	30	102	62	52	30.5	14.95	29.2	yes	0.6	BR.2504.007.02

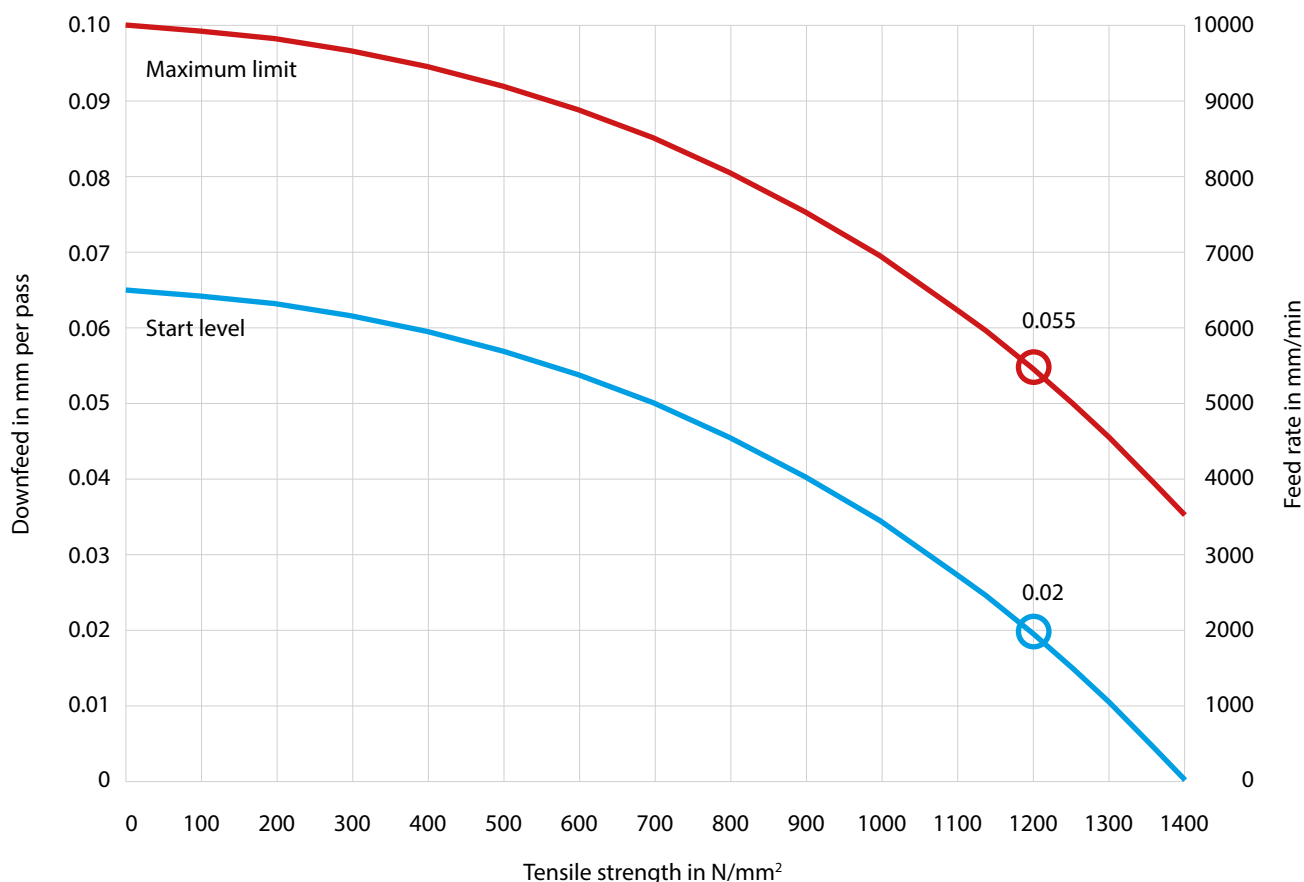
INS SHAPE BR





		BR					
Article		AS	Nw	w	s	t ₂	R
BR.15T3.007.01	NERO ² 77	2	4C11	4.11	3.97	2.1	0.5
BR.15T3.007.02	NERO ² 77	2	6C11	6.11	3.97	2.6	0.8
BR.15T3.007.03	NERO ² 77	2	7C11	7.12	3.97	3.3	0.8
BR.2005.007.01	NERO ² 77	2	8C11	8.12	5.00	3.4	1.0
BR.2504.007.01	NERO ² 77	2	10C11	10.12	4.76	4.2	1.0
BR.2504.007.02	NERO ² 77	2	12C11	12.15	4.76	5.1	1.2

Chart showing feed rate and downfeed in relation to the material's tensile strength. The values depend on the usage/machine conditions and may vary. The machine conditions significantly influence the cutting speed.

Example: In case of a material with 1200 N/mm² tensile strength, the downfeed per stroke can be between 0.02-0.055 mm – depending on feed rate and machine performance.



INS		
BR.15T3...	08B.0309.7991	TX208
BR.2005...	08B.3511.7991	TX215
BR.2504...	08B.4511.7991	TX220