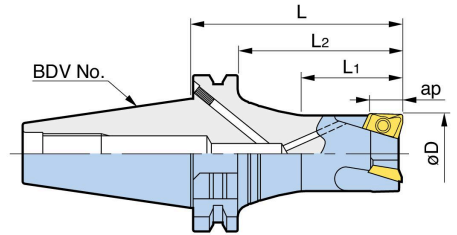
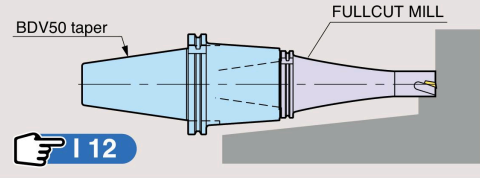


BDV Standard type

DIN 69871 A/B (BIG-PLUS)



Adapter for SK50 taper shank (FCR & FCM)



BIG-PLUS tools can be used in machining centers with conventional spindles.

Cutter Dia. øD	Model	ap	L	L ₁	L ₂	No. of Insert	Insert Size	Weight (kg)
16	BDV40-FCR16082- 85	8	85	25	65	2	BRG16	1.3
	-120		120	30	100			1.5
	-135		135	25	115			1.6
20	-FCR20083- 85	8	85	35	65	3	BRG20	1.2
	-120		120	30	100			1.6
	-135		135	30	115			1.7
25	-FCR25083- 85	8	85	40	65	3	BRG25	1.3
	-120		120	45	100			1.6
	-135		135	35	115			1.8
32	-FCR32103- 85	10	85	45	65	3	BRG32	1.4
	-120		120	50	100			1.7
	-135		135	40	115			1.9

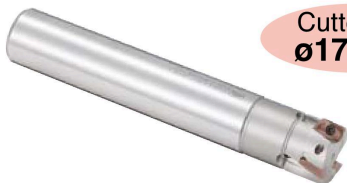
1. Wrench and Anti-seizure Lubricant are included. Inserts are ordered separately.
2. Long nose type shown below is recommended for medium-heavy or heavy slot milling with long projection, exceeding L=120mm for 16 & 20mm diameters / L=135mm for 25 or larger diameters.

For Insert : I 7

For Cutting Condition : I 8

Note The integral version of the FULLCUT MILL provides increased rigidity as a result of the reduced gage length. It is particularly recommended for use in machines having a small spindle taper. Additionally, there is a cost saving as no chuck is necessary.

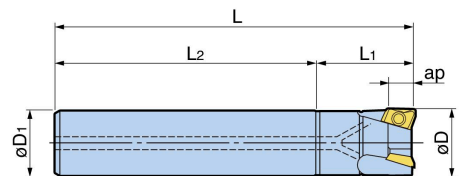
[OVER SIZE]



Cutter Dia
ø17-ø33

POINT $\text{ø}D = \text{ø}D1 + 1\text{mm}$

1mm larger Cutter Dia. than shank Dia. avoids any interference with work-piece.



Cutter dia øD	Model	øD ₁	ap	L	L ₁	L ₂	No. of Insert	Insert Size	Weight (kg)
17	ST16-FCR17082-120	16	8	120	25	95	2	BRG16	0.2
21	ST20-FCR21082-165	20	8	165	30	135	2	BRG20	0.4
	-FCR21083-135			135		105	3		0.3
26	ST25-FCR26082-165	25	8	165	38	127	2	BRG25	0.6
	-FCR26083-150			150		112	3		0.6
33	ST32-FCR33102-180	32	10	180	48	132	2	BRG32	1.1
	-FCR33103-180			180		132	3		1.0

1. Wrench and Anti-seizure Lubricant are included. Inserts are ordered separately.
2. Lower cutting parameters appropriately for applications with either long projection or 3-flutes models.
3. 2-flutes models are recommended for medium-heavy or heavy milling of slot or pocket.
4. For medium-heavy or heavy slot milling or ramping with projection longer than 2.5 times of diameter, 2-flutes models are recommended.

For Insert : I 7

For Cutting Condition : I 8