

Concave Corner Round End Mills



Cutter Series/Diameter:

15R1V: 0.75-1.00

15R4H: 1.00

Insert Series / Radii:

BEEW12 Inch: .03, .06, .09 & .12

BEEW12 Metric: 1.0, 2.0, 2.5 & 3.0

FEEW25 Inch: .15, .18 & .25

FEEW25 Metric: 4.0, 5.0 & 6.0

Materials:

Iron

Steel

Stainless Steel

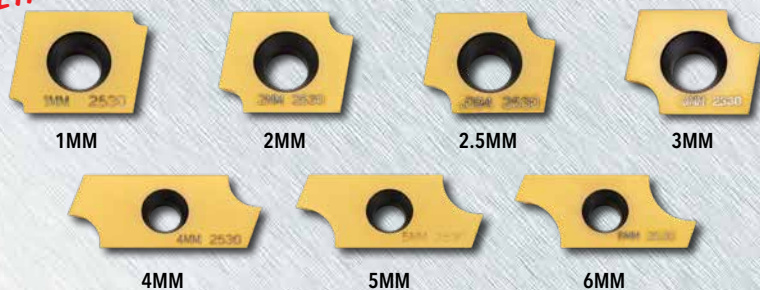
High Temp Alloys

Non-Ferrous

INCH!



METRIC!



Features and Benefits

- Multiple corner radii fit the same cutter body
- Integral tools for stubby applications; modular for long reach
- Indexable inserts feature 2 edges each
- Inserts equipped with tapered tangencies to promote smooth blend of 90 degree corners (avoid gouging)
- Two of each insert offered in convenient Paks

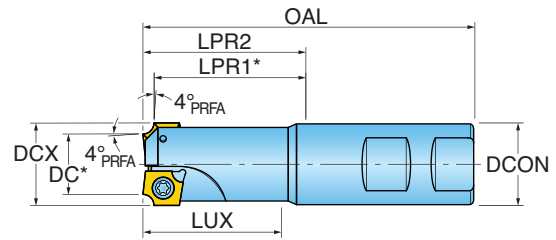
**PRODUCT
ANNOUNCEMENT**

• UPDATE •

2018

SERIES 15R1V

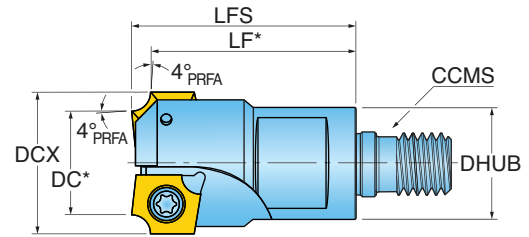
CORNER ROUND END MILL



* See technical page for DC and LPR1 programming dimensions per insert radius.

Part Number	DCX Cutting Dia. Max.	LUX Usable Length Max.	LPR2 Protruding Length	OAL Overall Length	ZEFF No. of Eff. Teeth	DCON Bore Diameter	CSP Coolant
15R1V-0702084R01	0.750	1.70	2.00	4.25	1	Weldon .750"	Yes
15R1V-1002080R01	1.000	1.90	2.00	4.25	2	Weldon 1.000"	Yes

MODULAR CORNER ROUND END MILL

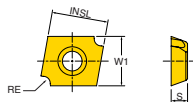


* See technical page for DC and LF programming dimensions per insert radius.

Part Number	DCX Cutting Dia. Max.	LFS Functional Length Secondary	ZEFF No. of Eff. Teeth	CCMS Connection Code	DHUB Hub Diameter	CSP Coolant
15R1V-10015X7R01	1.000	1.50	2	TopOn M12	0.81	No

INSERTS

BEEW



Part Number	Application	RE Corner Radius	INSL Insert Length	W1 Insert Width	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2530
BEEW120308R-CR		0.031	0.500	0.438	0.145	2	Right	•	
BEEW120310R-CR		1.00 mm	12.70 mm	11.10 mm	3.68 mm	2	Right	•	
BEEW120316R-CR		0.062	0.500	0.438	0.145	2	Right	•	
BEEW120320R-CR		2.00 mm	12.70 mm	11.10 mm	3.68 mm	2	Right	•	
BEEW120325R-CR		2.50 mm	12.70 mm	11.10 mm	3.68 mm	2	Right	•	
BEEW120330R-CR		3.00 mm	12.70 mm	11.10 mm	3.68 mm	2	Right	•	
BEEW120332R-CR		0.125	0.500	0.438	0.145	2	Right	•	

SERIES 15R4H

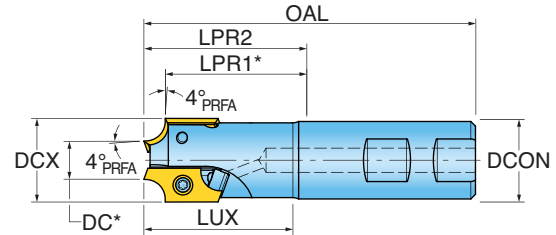
CORNER ROUND END MILL



Corner Rounding



Coolant

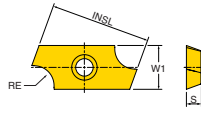


* See technical page for DC and LPR1 programming dimensions per insert radius.

Part Number	DCX Cutting Dia. Max.	LUX Usable Length Max.	LPR2 Protruding Length	OAL Overall Length	ZEFF No. of Eff. Teeth	DCON Bore Diameter	CSP Coolant
15R4H-1002080R01	1.000	1.90	2.00	4.25	2	Weldon 1.000"	Yes

INSERTS

FEEW



Part Number	Application	RE Corner Radius	INSL Insert Length	W1 Insert Width	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN2530
FEEW250340R-CR		4.00 mm	25.40 mm	11.10 mm	3.68 mm	2	Right	•	
FEEW250348R-CR		0.187	1.000	0.438	0.145	2	Right	•	
FEEW250350R-CR		5.00 mm	25.40 mm	11.10 mm	3.68 mm	2	Right	•	
FEEW250360R-CR		6.00 mm	25.40 mm	11.10 mm	3.68 mm	2	Right	•	
FEEW250364R-CR		0.250	1.000	0.438	0.145	2	Right	•	

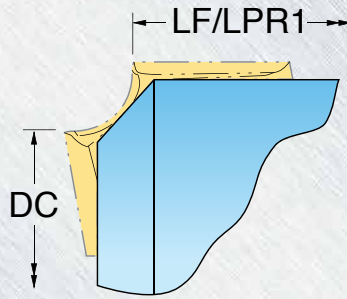
HARDWARE

Cutter Number					
	Screw	Driver Handle	Driver Blade	Torx Screw Driver	Wrench
15R1V-0702084R01	SE06-028-00	DS-A00T	DS-T156B	DS-T15T	-
15R1V-1002080R01	SE06-028-00	DS-A00T	DS-T156B	DS-T15T	-
15R1V-10015X7R01	SE06-028-00	DS-A00T	DS-T156B	DS-T15T	617MM
15R4H-1002080R01	SE06-028-00	DS-A00T	DS-T156B	DS-T15T	-

TECHNICAL INFORMATION

Series 15R1V, 15R4H					Grade	IN2530	Coolant
Material		Brinnell Hardness	SFM	Feed per Tooth			
Aluminum	6061-T6, 7075-T6	-	1500-8000	.004-.008	1		Yes
Cast Iron	Gray	150 - 250	700-1500	.004-.008	1		No
	Nodular						
Steel	Low Carbon 1018-8620	150 - 250	600-1200	.004-.008	1		No
	High Carbon F-6180	250 - 400					
	Alloyed Steel 4140, 4340, 6150	150 - 300					
	Tool Steel A6, D-1, D-2, P20	Up to 300					
Stainless Steel	300 Series, 304, 316	-	300 - 800	.004-.008	1		May not be required at high speeds
	400 Series 15-5 PH, 17-4 PH	Up to 320					
	13-8 PH	-					Yes
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.004-.008	1		Yes
Titanium	6AL-4V	-	100 - 150	.004-.008	1		Yes

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.



PROGRAM SPECS

DCX Cutting Dia. Max.	Cutter Body	RE Corner Radius	Insert	DC Program Diameter	LF/LPR1 Program Length
0.750	15R1V-0702084R01	0.031"	BEEW120308R-CR	0.684	1.985
		0.062"	BEEW120316R-CR	0.623	1.949
		0.094"	BEEW120325R-CR	0.552	1.909
		0.125"	BEEW120332R-CR	0.495	1.876
		1.0 mm	BEEW120310R-CR	0.670	1.976
		2.0 mm	BEEW120320R-CR	0.589	1.930
		3.0 mm	BEEW120330R-CR	0.512	1.885
1.000	15R1V-1002080R01	0.031"	BEEW120308R-CR	0.934	1.984
		0.062"	BEEW120316R-CR	0.873	1.949
		0.094"	BEEW120325R-CR	0.802	1.909
		0.125"	BEEW120332R-CR	0.745	1.875
		1.0 mm	BEEW120310R-CR	0.920	1.976
		2.0 mm	BEEW120320R-CR	0.839	1.930
		3.0 mm	BEEW120330R-CR	0.762	1.885
1.000	15R1V-10015X7R01	0.031"	BEEW120308R-CR	0.934	1.484
		0.062"	BEEW120316R-CR	0.873	1.449
		0.094"	BEEW120325R-CR	0.802	1.409
		0.125"	BEEW120332R-CR	0.745	1.375
		1.0 mm	BEEW120310R-CR	0.920	1.476
		2.0 mm	BEEW120320R-CR	0.839	1.430
		3.0 mm	BEEW120330R-CR	0.762	1.385
1.000	15R4H-1002080R01	.156"	FEEW250340R-CR	0.697	1.881
		.187"	FEEW250348R-CR	0.644	1.846
		.250"	FEEW250364R-CR	0.500	1.750
		4.0 mm	FEEW250340R-CR	0.697	1.881
		5.0 mm	FEEW250350R-CR	0.611	1.825
		6.0 mm	FEEW250360R-CR	0.530	1.771