

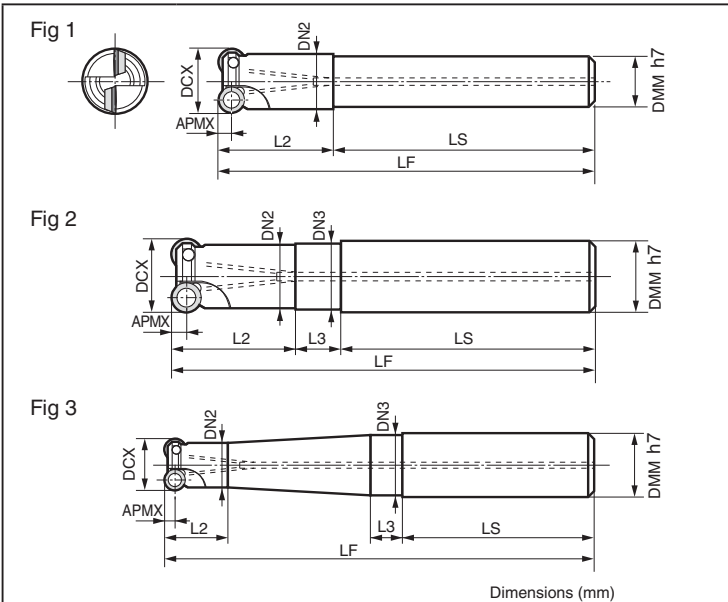
Rake Angle	Radial	0°
	Axial	0°



■ General Features

- High speed, high efficiency milling of hardened mold material.
- Cost effective with full-top CBN inserts, multiple corner usage.
- Strong clamping with conical insert screw hole design.

■ Bodies (Endmill Type)



Cat. No.	Stock	Max. Dia. DCX	Shank Dia. DMM	Diameter DN2	Diameter DN3	Max. Depth APMX	Length L2	Length L3	Shank Length LS	Length LF	No. of teeth	Fig	Group No.
BRC 071207ES10	▲	12	10	11.0	—	3.5	23	—	52	75	2	1	1
071207ES12	▲	12	12	11.0	11.5	3.5	22	8	45	75	2	2	
071208ES16	▲	12	16	11.0	15.5	3.5	16	8	48	88	2	3	
071210ES16	▲	12	16	11.0	15.5	3.5	16	8	48	108	2	3	1
071212ES16	▲	12	16	11.0	15.5	3.5	16	8	48	128	2	3	
071507ES12	▲	15	12	12.5	—	3.5	16	—	59	75	3	1	
071507ES16	▲	15	16	12.5	13.0	3.5	19	11	48	78	3	2	2
BRC 071508ES16	▲	15	16	13.5	15.5	3.5	20	8	48	88	2	2	
071510ES16	▲	15	16	13.5	15.5	3.5	20	8	48	108	2	2	
071513ES20	▲	15	20	13.5	19.5	3.5	22	8	50	130	2	2	3
071515ES20	▲	15	20	13.5	19.5	3.5	22	8	50	150	2	2	
071517ES25	▲	15	25	13.5	24.5	3.5	22	8	56	176	2	2	
BRC 102009ES20	▲	20	20	17.0	19.5	5.0	20	8	50	90	2	2	3
102011ES20	▲	20	20	17.0	19.5	5.0	22	8	50	110	2	2	
102012ES25	▲	20	25	17.0	24.5	5.0	24	8	56	136	2	2	
102015ES25	▲	20	25	17.0	24.5	5.0	24	8	56	156	2	2	
102017ES25	▲	20	25	17.0	24.5	5.0	24	8	56	176	2	2	

Inserts are not included.

■ Recommended Cutting Conditions

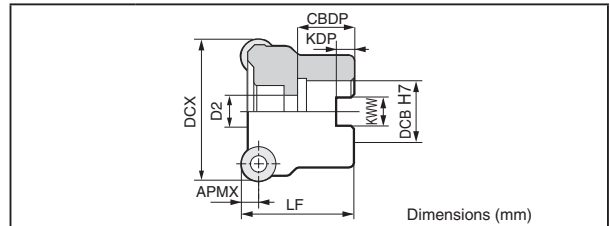
ISO	Work material	Hardness	Depth of cut a_p (mm)	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
H	Hardened Steel	40 to 45HRC	Up to 0.5	200-500-800	0.1-0.25-0.4	BN7000
		47 to 55HRC	Up to 0.5	150-275-400	0.1-0.2-0.3	BN7000
		58 to 62HRC	Up to 0.5	80-140-200	0.1-0.15-0.2	BN350
K	Gray Cast Iron	—	Up to 0.5	300-900-1500	0.1-0.25-0.4	BN7000

Use BRC Type cutter/endmill and RDHX Type inserts in combination with the applicable group number.

- Dry cut (Air Blow) and Down cut are recommended.

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

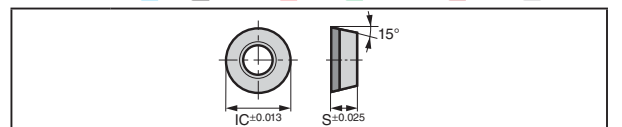
■ Bodies (Shell Type)



Cat. No.	Stock	Max. Dia. DCX	Dia. DCB	Bolt Dia. D2	Max. Depth APMX	Height LF	Depth CDBP	Groove width KWW	Groove depth KDP	No. of teeth	Group No.
BRC 10042R	▲	42	16	9	5	44	20	8.5	6	6	3
10052R	▲	52	22	11	5	50	30	10.5	7	7	
BRC 12042R	▲	42	16	9	6	42	20	8.5	6	5	4
12052R	▲	52	22	11	6	52	30	10.5	7	5	
12066R	▲	66	27	13	6	52	30	12.5	7	6	

Inserts are not included.

■ Inserts



Application	Grade		CBN	
	High Speed/Light	K	K	
	General Purpose	S	S	
Roughing	H			

Cat. No.	BN350	BN700	BN700	I. C.	Thickness	Applicable Endmill (Using Group No.)
				IC	S	
RDHX 0701MOT				7	1.99	1
0702MOT				7	2.38	2
1003MOT				10	3.18	3
12T3MOT				12	3.97	4

■ Parts

Screws	Wrenches	Applicable Endmill (Using Group No.)
BFTB 025048	1.0 TRD07	1
BFTB 02505	1.0 TRD07	2
BFTB 035074	3.4 TRD15	3, 4

Recommended Tightening Torque (N·m)

■ Application Example

Coated Carbide

BRC (BN350)

BRC has higher efficiency at half the machining cost!

Cost/workpiece

Tool: BRC12052R
Work material: SNCM435 (Machine components) 55 to 60HRC Grade: BN350
 $v_c=250$ m/min $f_z=0.1$ mm/t $a_p=0.5$ mm $a_e=50$ mm