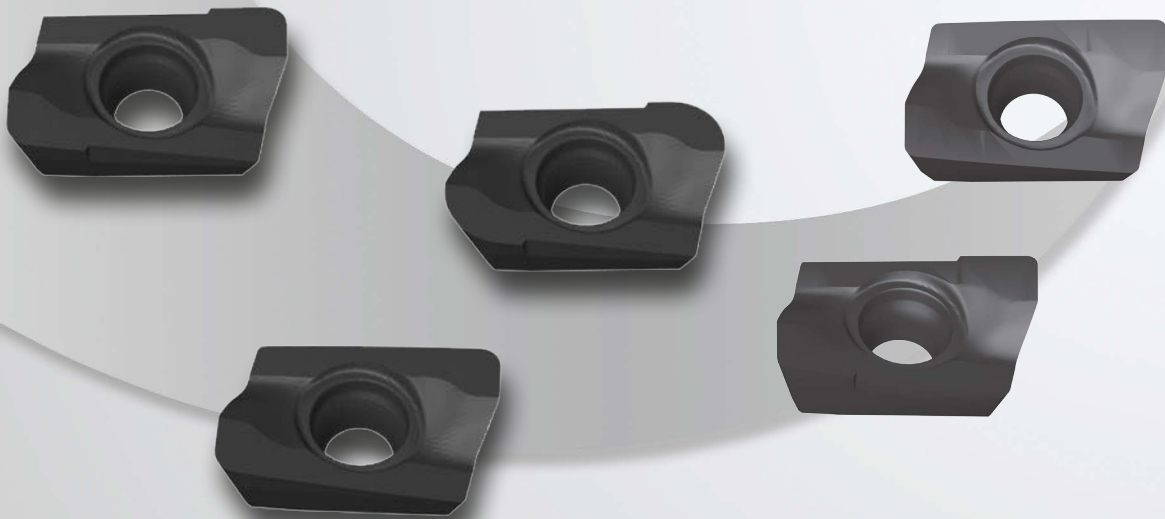


NEW

INNOTOOL

LOOK FORWARD



HIPOS PLUS

GROUND PRECISION INSERT BODT09T3...

- Excellent surface finishes due to an all ground precision insert •*
- Fits all existing HiPos+ standard cutters for BOMT09 •*
- New carbide grade IN2504 for hard machining •*

HIPOS PLUS PRECISION INSERT BODT09T3...

Product overview

To expand the application range of the popular HiPos+ series for BOMT09T3__R, Innotool developed the **all ground precision insert BODT09T3...**

This insert is now part of our standard offering and can be used for finishing operations when **face or shoulder milling**.

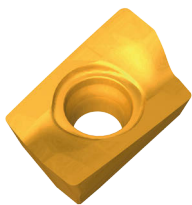
Best face milling results can be obtained when using the axially adjustable **shoulder mill series EB09D10A**, although **BODT09** fits all existing standard cutters for BOMT09.

For finishing of shoulders and contours in hardened steels, like the ones commonly used in die and mould accounts, the new carbide grade **IN2504** and a recessed insert for a **max. depth of cut of 3 mm** have been developed.

The reduced depth of cut minimizes radial deflections so a **step-free shoulder** is achieved much easier, although there are many parameters that will have an impact on the result.

High-precision cutters can be produced upon request.

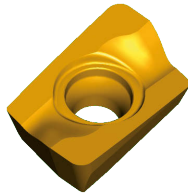
Insert geometries



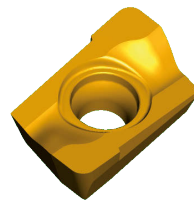
BODT09T304R
R0.4
ap max = 8.9 mm



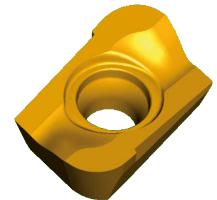
BODT09T304R-001
R0.4
ap max = 3 mm



BODT09T308R
R0.8
ap max = 8.9 mm



BODT09T308R-001
R0.8
ap max = 3 mm



BODT09T320R-001
R2.0
ap max = 3 mm

Recommended cutting data for hard machining with IN2504 at 55...63 HRC:

| | Vc [m/min] | fz [mm] | ap [mm] | ae [mm] |
|------------------------------|------------|-------------|-----------|-----------|
| Finishing of plane surfaces: | 50 - 100 | 0.05 - 0.07 | 0.2 | 0.5 - 1xD |
| Finishing of shoulders: | 130 - 200 | 0.05 - 0.10 | 0.5 - 2.0 | < 0.2 |

Tips:

- The worse the material machinability, the smaller the tool engagement should be chosen.
- The smaller the cutting tool diameter, the higher the cutting speed can be.

Advantages

- Excellent surface finishes due to an all ground precision insert
- Fits all existing HiPos+ standard cutters for BOMT09
- New carbide grade IN2504 for hard machining