

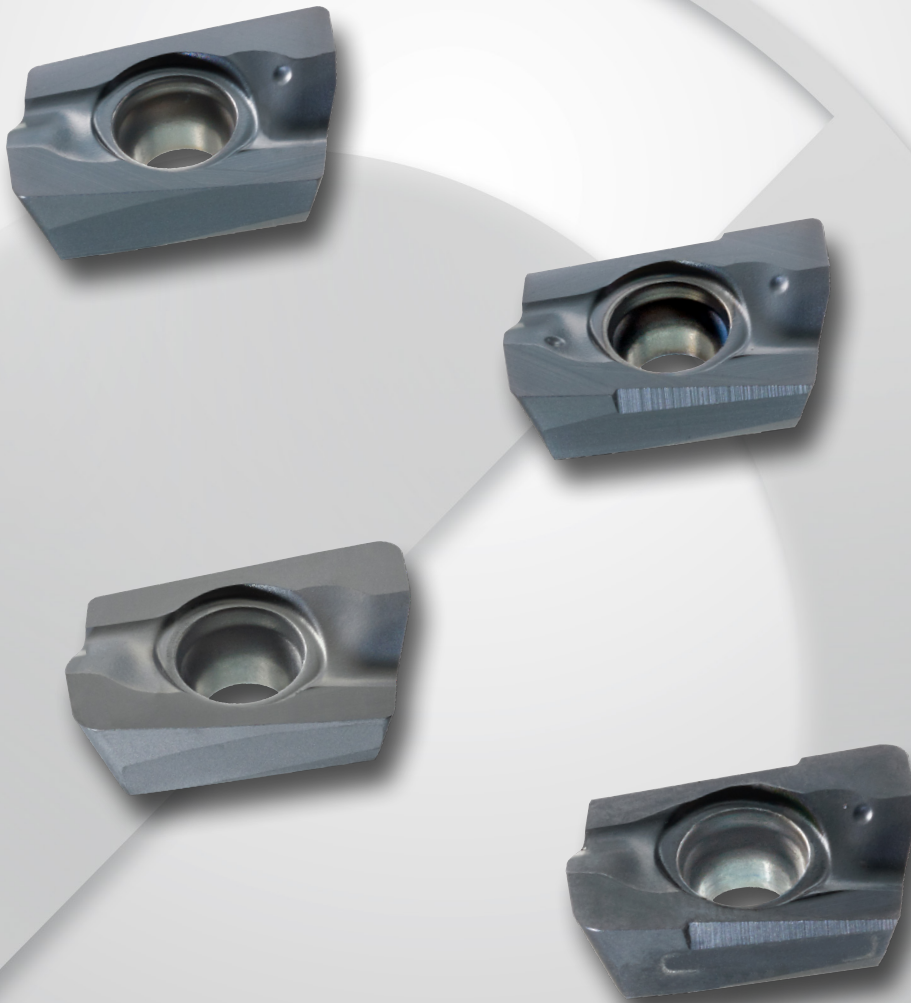


HIPOPOS⁺

PRECISION INSERT BODT1304_

GROUND PRECISION INSERT BODT1304_

- Excellent surface due to ground precision insert
- Grade IN2504 for hard machining
- Fits in existing cutting tools for BOMT13



Product Overview

For some time, the BODT09 finishing insert has been part of the Ingersoll standard program and is becoming increasingly popular. Reason enough for us to offer a suitable finishing insert for the BOMT13 range with the new **BODT13**.

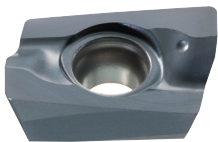
Since the **BODT13** fits into existing milling tools, significantly finer surfaces can now be produced when milling flat surfaces and 90 ° shoulders.

For finishing flat surfaces and shoulders in hardened steels up to 63 HRC, which are common in die & mould industry, our grade **IN2504** and different insert versions were developed.

Due to the reduced cutting depth of max. 4 mm of the recessed insert version (-001), the radial displacement of the milling cutter is lower hence step-free machining of shoulders is easier to achieve. However, there are many factors that have an effect on the achieved result.

On request **high-precision tools** can be produced.

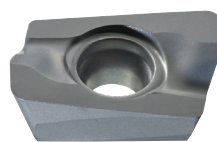
Insert Geometries



BODT130404R
R0,4
ap max = 11 mm



BODT130404R-001
R0,4
ap max = 4 mm



BODT130408R
R0,8
ap max = 11 mm



BODT130408R-001
R0,8
ap max = 4 mm

Recommended Cutting Data for Hard Milling with Grade IN2504 in 55...63 HRC:

	Vc [m/min]	fz [mm]	ap [mm]	ae [mm]
Finishing of flat surfaces:	50 - 100	0,05 - 0,07	0,2	0,5 - 1xD
Finishing of shoulders:	130 - 200	0,05 - 0,10	0,5 - 3,0	< 0,2

Tips:

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

Advantages

- Excellent surfaces due to ground precision inserts
- Grade IN2504 for hard machining and Cermet grade IN0560 for finishing of steels and nodular iron
- Suitable for existing BOMT13 cutter bodies

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