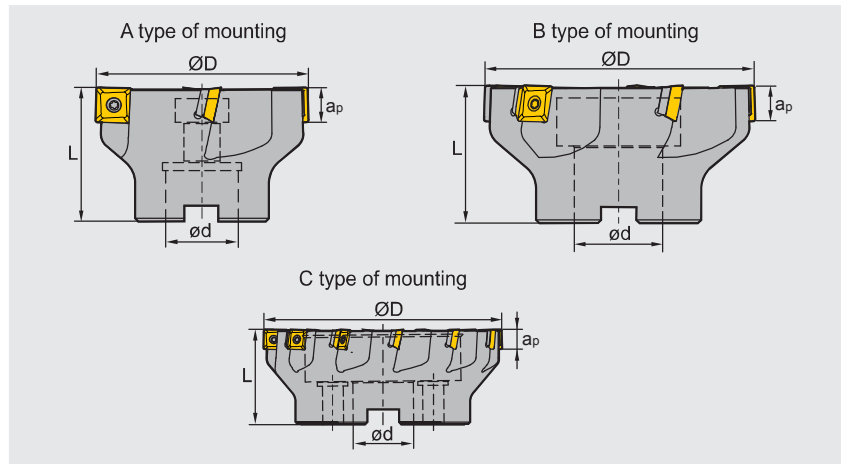


Face milling tools



FMP02



Specification of tools

| Type | | Dimensions(inch) | | | | | |
|------------------------|------------------------|------------------|-------|-------|-------|------------------------|----------------|
| | | ØD | ød | L | apmax | Z (Number of teeth) | Interface form |
| FMP02 | -2.00"-A0.75"-SE09-05 | 2.000 | 0.750 | 1.500 | 0.285 | 5 | A |
| | -2.50"-A1.00"-SE09-06 | 2.500 | 1.000 | 1.500 | 0.285 | 6 | A |
| | -3.00"-A1.00"-SE09-08 | 3.000 | 1.000 | 2.000 | 0.285 | 8 | A |
| | -4.00"-B1.25"-SE09-10 | 4.000 | 1.250 | 2.000 | 0.285 | 10 | B |
| | -5.00"-B1.50"-SE09-12 | 5.000 | 1.500 | 2.500 | 0.285 | 12 | B |
| | -6.00"-C1.50"-SE09-14 | 6.000 | 1.500 | 2.500 | 0.285 | 14 | C |
| | -2.00"-A0.75"-SE12-03 | 2.000 | 0.750 | 1.500 | 0.425 | 3 | A |
| | -2.00"-A1.00"-SE12-04 | 2.000 | 1.000 | 1.500 | 0.425 | 4 | A |
| | -2.50"-A1.00"-SE12-04 | 2.500 | 1.000 | 1.500 | 0.425 | 4 | A |
| | -2.50"-A1.00"-SE12-05 | 2.500 | 1.000 | 1.500 | 0.425 | 5 | A |
| | -2.50"-A1.00"-SE12-06 | 2.500 | 1.000 | 1.500 | 0.425 | 6 | A |
| | -3.00"-A1.00"-SE12-08 | 3.000 | 1.000 | 2.000 | 0.425 | 8 | B |
| | -4.00"-B1.25"-SE12-10 | 4.000 | 1.250 | 2.000 | 0.425 | 10 | B |
| | -5.00"-B1.50"-SE12-08 | 5.000 | 1.500 | 2.500 | 0.425 | 8 | B |
| | -5.00"-B1.50"-SE12-12 | 5.000 | 1.500 | 2.500 | 0.425 | 12 | C |
| | -6.00"-C1.50"-SE12-12 | 6.000 | 1.500 | 2.500 | 0.425 | 12 | C |
| | -6.00"-C1.50"-SE12-15 | 6.000 | 1.500 | 2.500 | 0.425 | 15 | C |
| | -8.00"-C2.50"-SE12-10 | 8.000 | 2.500 | 2.500 | 0.425 | 10 | C |
| | -8.00"-C2.50"-SE12-16 | 8.000 | 2.500 | 2.500 | 0.425 | 16 | C |
| | -10.00"-C2.50"-SE12-12 | 10.000 | 2.500 | 2.500 | 0.425 | 12 | C |
| -10.00"-C2.50"-SE12-18 | 10.000 | 2.500 | 2.500 | 0.425 | 18 | C | |



Spare parts

| Diameter ØD | Insert specification | Shim | Insert screw | Shim screw | Wrench | | Sketch of installation |
|----------------|-------------------------|--------|--------------|------------|--------|-------|------------------------|
| | | | | | | | |
| Ø2.00"~Ø6.00" | SE09 | --- | I60M3×7 | --- | WT09IS | --- | |
| Ø2.00" | SE12 | --- | I60M3.5×10 | --- | WT15IS | --- | |
| Ø2.50"~Ø10.00" | | S12BSX | I60M3.5×12 | SM5×7XA | | WH35L | |

Recommended cutting parameters

| | Workpiece material | Hardness HB | Insert grade | Cutting data | | | |
|----------|----------------------------------|-------------|----------------|--------------------|---------------------|---------------------|---------------------|
| | | | | V(SFPM) | f(IPT) | | |
| | | | | | -APF | -APM | -APR |
| P | Low carbon steel soft steel | ≤ 180 | YBG202 | 900(650-1200) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YB9320 | 900(650-1200) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | High carbon steel alloy steel | 180-280 | YBM351 | 750 (660-1000) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YBG202 | 800 (600-1150) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YB9320 | 800 (600-1150) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | Alloy tool steel | 280-350 | YBM351 | 700 (600-1000) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| YBG202 | | | 700 (550-1100) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) | |
| YB9320 | | | 700 (550-1100) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) | |
| M | Stainless steel | ≤ 270 | YBM351 | 500 (400-800) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YBG202 | 500 (350-900) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YB9320 | 500 (350-900) | 0.004(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| K | Cast iron | 180-250 | YBG202 | 500 (400-650) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| | | | YBD152 | 900 (500-1000) | 0.006(0.004-0.008) | 0.008 (0.004-0.012) | 0.012 (0.008-0.016) |
| N | Al alloy steel | -- | YD101 | 1000- | -LH | | |
| | | | | | 0.01 (0.004-0.016) | | |

