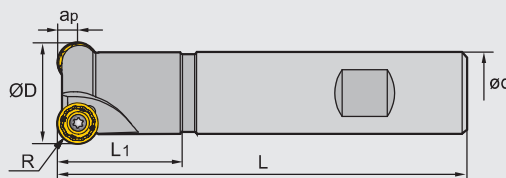


Face milling tools



FMR01



Specification of tools

Type		Dimensions(inch)						
		ØD	R	ød	L ₁	L	a _{pmax}	Z (Number of teeth)
FMR01	-1.00"-XP0.75" -RC10-02	1.00	0.197	0.75	1.75	4.00	0.197	2
	-1.25"-XP1.00" -RC10-02	1.25	0.197	1.00	2.50	4.75	0.197	2
	-1.50"-XP1.25" -RC12-03	1.50	0.236	1.25	2.50	4.75	0.236	3
	-2.00"-XP1.25" -RC12-03	2.00	0.236	1.25	2.50	4.75	0.236	3

D

Spare parts

Diameter ØD	Insert specification	Insert screw	Wrench	Sketch of installation
				
Ø1.00"~Ø1.25"	RCKT10T3MO-DM	I60M4×8.4	WT15S	
Ø1.50"~Ø2.00"	RCKT1204MO-□□	I60M3.5×10	WT15S	

😊 Good working conditions 😐 General working conditions 😞 Adverse working conditions

Workpiece material

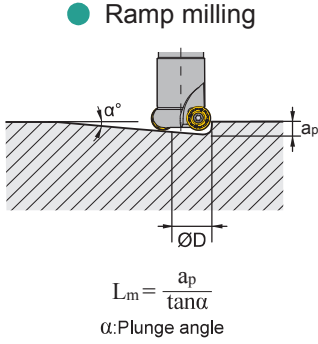
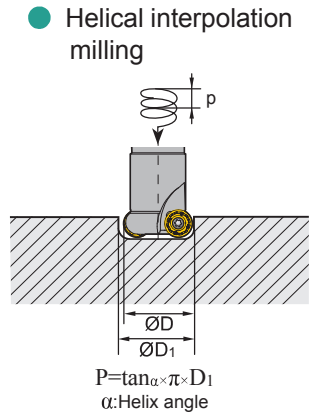
P Steel	   	   		  
M Stainless steel	   	   		  
K Cast iron		  	 	 
N Ferrite materials				 
S Heat-resistant steel		  	 	

Insert shape	Type	Dimensions(inch)			Coated grade										Cermet	Cemented carbide									
		ØI.C	S	ød	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG302	YBG205	YB9320		YBG302	YBG152	YBG252	YBS202	YBS303	YNG151	YNG151C	YC30S	YD051	YD101
	RCKT10T3MO-DM	0.394	0.156	0.173				●				●	●												
	RCKT1204MO-DM	0.472	0.187	0.157		●		●	○			●	●		●										
	RCKT1204MO-DR	0.472	0.187	0.157		○		○					●												
	RCKT1204MO-ER	0.472	0.187	0.157			○	●																	
	RCKT1204MO-NM	0.472	0.187	0.157			○											○	○						

☒ Always stock available ☐ Produce according to order

Recommended cutting parameters							
Workpiece material		Hardness HB	Insert grade	Cutting parameters			
				V(SFPM)	f(IPT)		
					-DM	-DR	-ER
P	Low-carbon steel, Soft steel	≤180	YBM251	900(700-1100)	0.008(0.004-0.02)	0.012(0.008-0.032)	
			YBM351	700(600-1000)	0.01(0.004-0.02)	0.012(0.008-0.032)	
			YBG302	900(650-1200)	0.008(0.004-0.02)	0.012(0.008-0.032)	
	High-carbon steel, Alloy steel	180-280	YBG202	800(650-1000)	0.008(0.004-0.02)	0.012(0.008-0.032)	
			YBM251 YBG302	650(500-900)	0.01(0.004-0.02)	0.012(0.008-0.032)	
			YBM351	800(600-1100)	0.008(0.004-0.02)	0.012(0.008-0.032)	
	Alloy tool steel	280-350	YBC302	700(600-1000)	0.008(0.004-0.016)	0.012(0.008-0.032)	
			YBG202	600(500-800)	0.008(0.004-0.02)	0.012(0.008-0.032)	
			YBM251 YBC301	700(550-1100)	0.008(0.004-0.016)	0.012(0.008-0.032)	
M	Stainless steel	≤270	YBM251	500(400-800)	0.008(0.004-0.016)	0.012(0.008-0.024)	
			YBM253	500(300-800)	0.008(0.004-0.016)	0.012(0.008-0.024)	0.012(0.008-0.024)
			YBG351	500(300-700)	0.008(0.004-0.016)	0.012(0.008-0.024)	
			YBG202 YBG205	500(360-900)	0.008(0.004-0.016)	0.012(0.008-0.024)	
K	Cast iron	180-250	YBG302	700(400-1000)	0.008(0.004-0.02)	0.012(0.008-0.032)	
S	High-temperature alloy	≤400			-NM		
			YBS203 YBS303	300(200-400)	0.006(0.004-0.012)		

Ramp milling, helical interpolation milling

	Insert	Diameter ØD(in)	Max.cutting depth ap(in)	Max.cutting depth α°	Min.length Lm(in)	Min.diameter ØD1(in)	Max.diameter (in)
● Ramp milling  $L_m = \frac{a_p}{\tan \alpha}$ α: Plunge angle ● Helical interpolation milling  $P = \tan \alpha \times \pi \times D_1$ α: Helix angle	RCKT10**	1.00"	0.197	14.4	0.768	1.575	0.197
		1.25"	0.197	8.4	1.339	2.126	0.197
	RCKT12**	1.50"	0.236	10.3	1.307	2.677	0.236
		2.00"	0.236	7.1	1.890	3.465	0.236

Reduce the feed rate when plunging and circular milling.
"Attention"—drilling can form long chips.