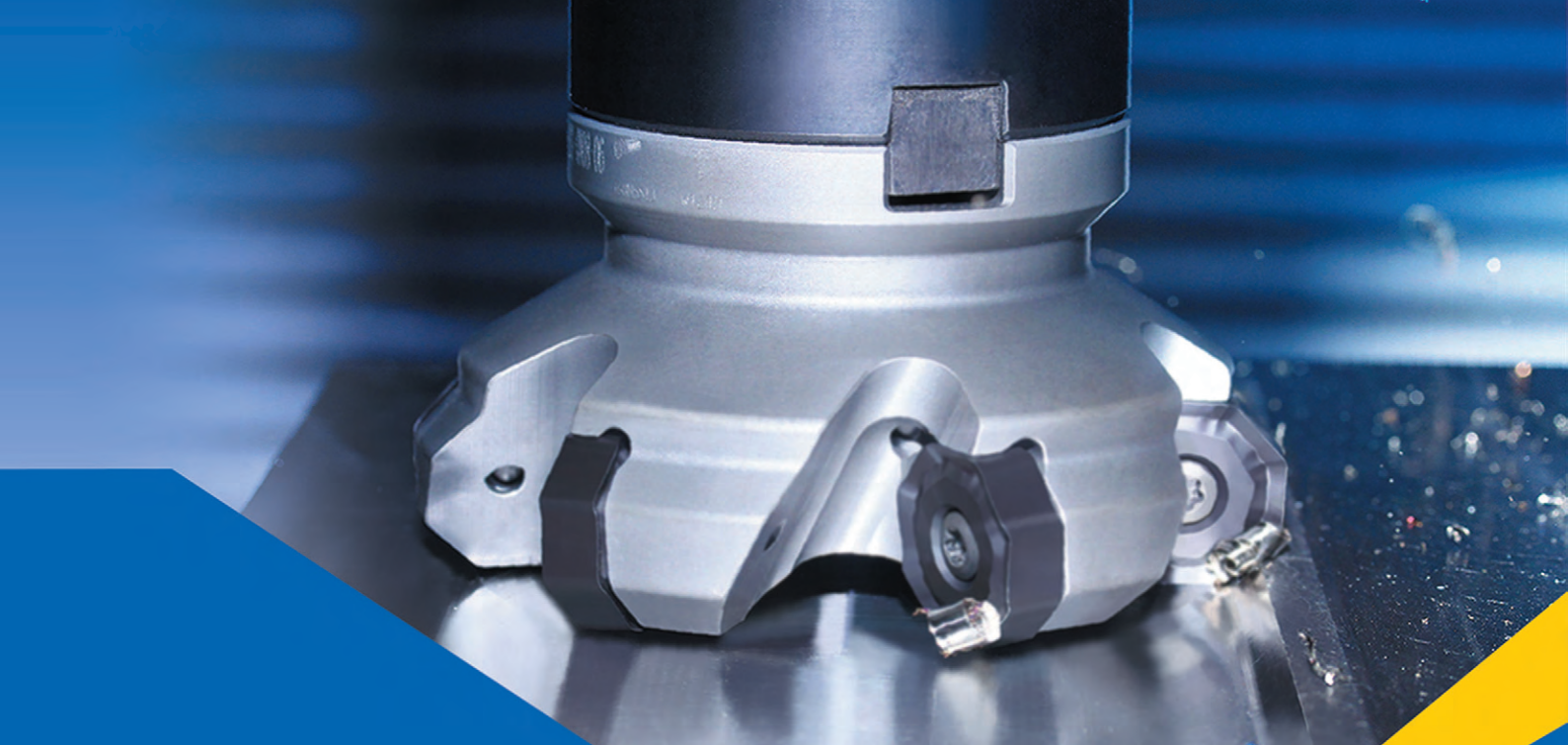




FMA 12 Series Kr:45°

High Performance Face Mill with 16 edges for outstanding economy

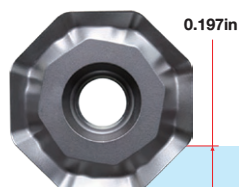


Unique 3-dimentional edge

Double negative rake angle, in combination with helical insert structure, achieves double positive axial angle, which will help reduce cutting resistance and improve chip evacuation.

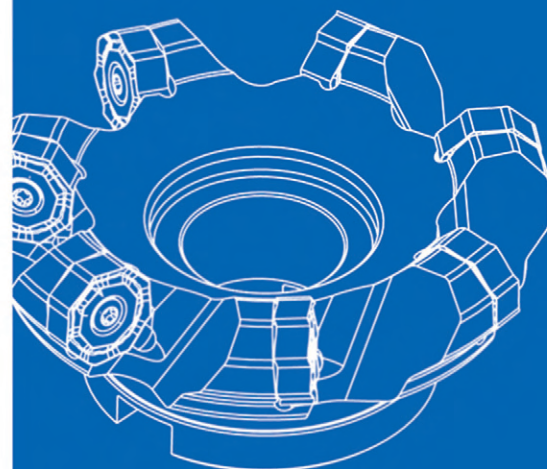


8 × 2 = 16 edges



ONHU08T624R-GM

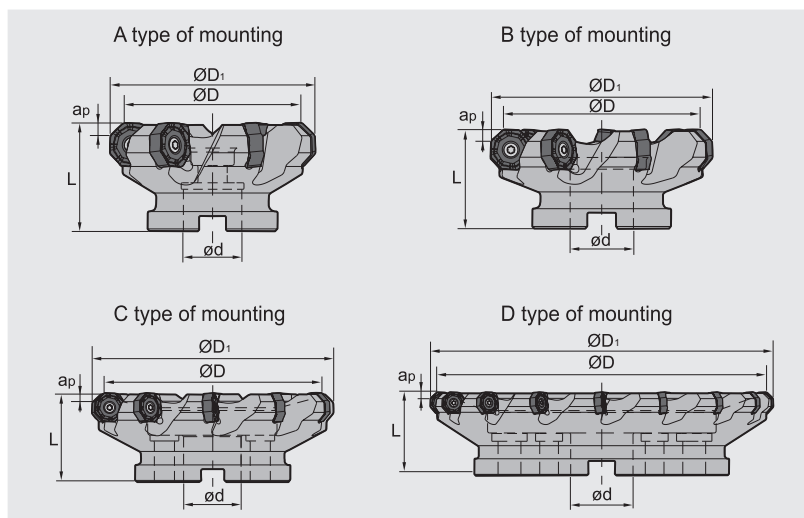
Maximum cutting depth



Face milling tools **Kr:45°**



FMA12 **P** **M** **K**



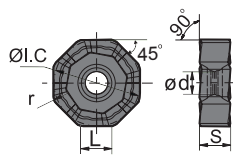
Specification of tools

Type		Basic dimensions (inch)					Z	Interface form
		ØD	ØD ₁	Ød	L	a _{pmax}		
FMA12	-2.50"-A0.75"-ON08-05	2.500	3.091	0.750	1.750	0.197	5	A
	-3.00"-A1.00"-ON08-06	3.000	3.591	1.000	2.000	0.197	6	A
	-4.00"-B1.25"-ON08-07	4.000	4.591	1.250	2.500	0.197	7	B
	-5.00"-B1.50"-ON08-08	5.000	5.591	1.500	2.500	0.197	8	B
	-6.00"-B2.00"-ON08-10	6.000	6.591	2.000	2.500	0.197	10	B
	-8.00"-C2.50"-ON08-12	8.000	8.591	2.500	2.500	0.197	12	C
	-10.00"-C2.50"-ON08-14	10.000	10.591	2.500	2.500	0.197	14	C
	-12.00"-D2.50"-ON08-16	12.000	12.591	2.500	2.500	0.197	16	D

Spare parts

Diameter ØD	Insert specification	Insert screw	Wrench	
		 I60M5X13	 WT20IT	
Ø2.50"-Ø12.00"	ONHU08T624R-GM			

Selection of inserts



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

[illegible][illegible]

● Always stock available ○ Produce according to order

Note: ONHU08T508-PF、ONHU08T508-PM also compatible.

Recommended cutting parameters

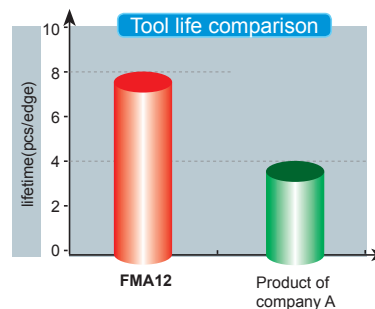
Workpiece material		Hardness HB	Grade	Cutting data		
				Cutting speed (SFPM)	Feed per tooth (in)	a _{pmax} (in)
P	Low carbon steel	≤180	YBM253 YBG205	900(700-1100)	0.008(0.004-0.012)	0.197
	Alloy steel	180-350	YBM253 YBG205	800(600-1000)	0.006(0.004-0.012)	0.197
M	Stainless steel	≤270	YBM253 YBG205	750 (600-950) 500 (360-900)	0.006 (0.004-0.012)	0.197
K	Cast iron	180-260	YBD152	900(500-950)	0.008(0.004-0.012)	0.197

Case for FMA12

Case (Cast iron machining)



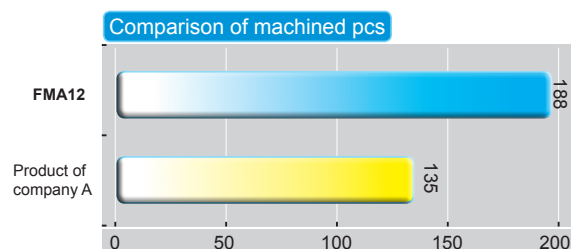
Workpiece: Cylinder
Workpiece material: Gray cast iron (HB250)
Machining location: Milling 4 sides
Tool: FMA12-6.00"-C1.50"-ON08-10
Insert: ONHU08T624R-GM/YBD152
Cutting data: $V_c=500$ SFPM, $f_z=0.01$ in/z,
 $a_p=0.12$ in, $a_e=6$ in
System of cooling: External



Doubled tool life of FMA12 series compared to similar product of company A.

Case (Steel machining)

A36(HB180~220)
Operation: Face milling
Tool: FMA12-8.00"-C2.50"-ON08-12
Insert: ONHU08T624R-GM/YBM253
Cutting data: $V_c=820$ SFPM, $f_z=0.006$ in/z,
 $a_p=0.12$ in, $a_e=5$ in





High strength
screw clamping



67° approach angle



Wiper

Each insert has 10
cutting edges



Whirl wind

FMD02

milling cutter series

- ▶ New generation of milling cutter for face milling mainly in automotive industry.
- ▶ Open chipbreaker and large rake angle design, suitable for machines of different power.
- ▶ Wiper insert guarantees stable good surface quality at different feed rates.
- ▶ The high precision insert pocket design, ensures high accuracy insert positioning and strong clamping of inserts for a stable machining process.
- ▶ The Pentagon insert with 10 cutting edges and offers outstanding machining economy.

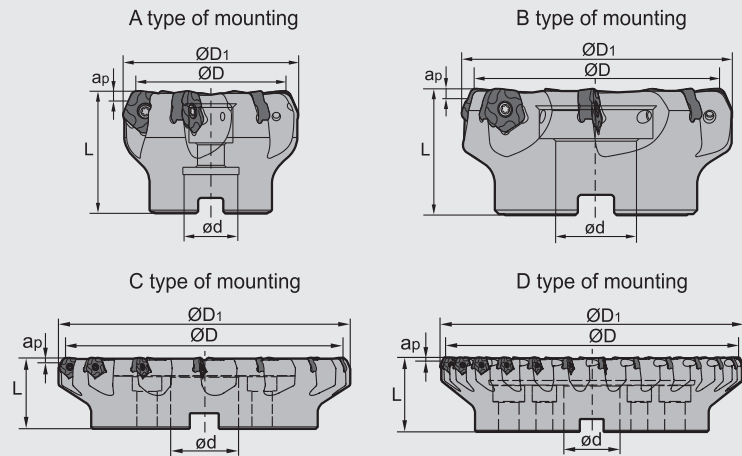


Face milling tools

Kr:67°



FMD02 P K



Specification of tools

Type		Dimensions(inch)						
		ØD	ØD1	Ød	L	apmax	Z	Interface form
FMD02 Coarse pitch (unequal pitch)	-2.00"-A0.75"-PN11-04	2.00	2.398	0.750	1.750	0.197/0.276	4	A
	-2.50"-A0.75"-PN11-05	2.50	2.898	0.750	1.750	0.197/0.276	5	A
	-3.00"-A1.00"-PN11-06	3.00	3.398	1.000	2.000	0.197/0.276	6	A
	-4.00"-B1.25"-PN11-07	4.00	4.398	1.250	2.000	0.197/0.276	7	B
	-5.00"-B1.50"-PN11-08	5.00	5.398	1.500	2.500	0.197/0.276	8	B
	-6.00"-B1.50"-PN11-10	6.00	6.398	1.500	2.500	0.197/0.276	10	B
	-8.00"-C2.50"-PN11-12	8.00	8.398	2.500	2.500	0.197/0.276	12	C
	-10.00"-C2.50"-PN11-14	10.00	10.398	2.500	2.500	0.197/0.276	14	C
Close pitch	-2.00"-A0.75"-PN11-05	2.00	2.398	0.750	1.750	0.197/0.276	5	A
	-2.50"-A0.75"-PN11-06	2.50	2.898	0.750	1.750	0.197/0.276	6	A
	-3.00"-A1.00"-PN11-08	3.00	3.398	1.000	2.000	0.197/0.276	8	A
	-4.00"-B1.25"-PN11-10	4.00	4.398	1.250	2.000	0.197/0.276	10	B
	-5.00"-B1.50"-PN11-12	5.00	5.398	1.500	2.500	0.197/0.276	12	B
	-6.00"-B1.50"-PN11-14	6.00	6.398	1.500	2.500	0.197/0.276	14	B
	-8.00"-C2.50"-PN11-16	8.00	8.398	2.500	2.500	0.197/0.276	16	C
	-10.00"-C2.50"-PN11-18	10.00	10.398	2.500	2.500	0.197/0.276	18	C
	-12.00"-D2.50"-PN11-26	12.00	12.398	2.500	2.500	0.197/0.276	26	D

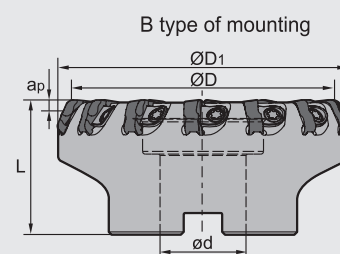
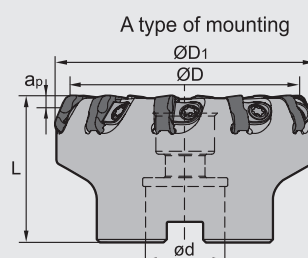
Spare parts

Diameter ØD	Insert screw	Wrench	Sketch of installation
Ø2.00"-Ø12.00"	I60M4x10	WT15IS	

Face milling tools **Kr:67°**



FMD02 **P** **K**



Specification of tools

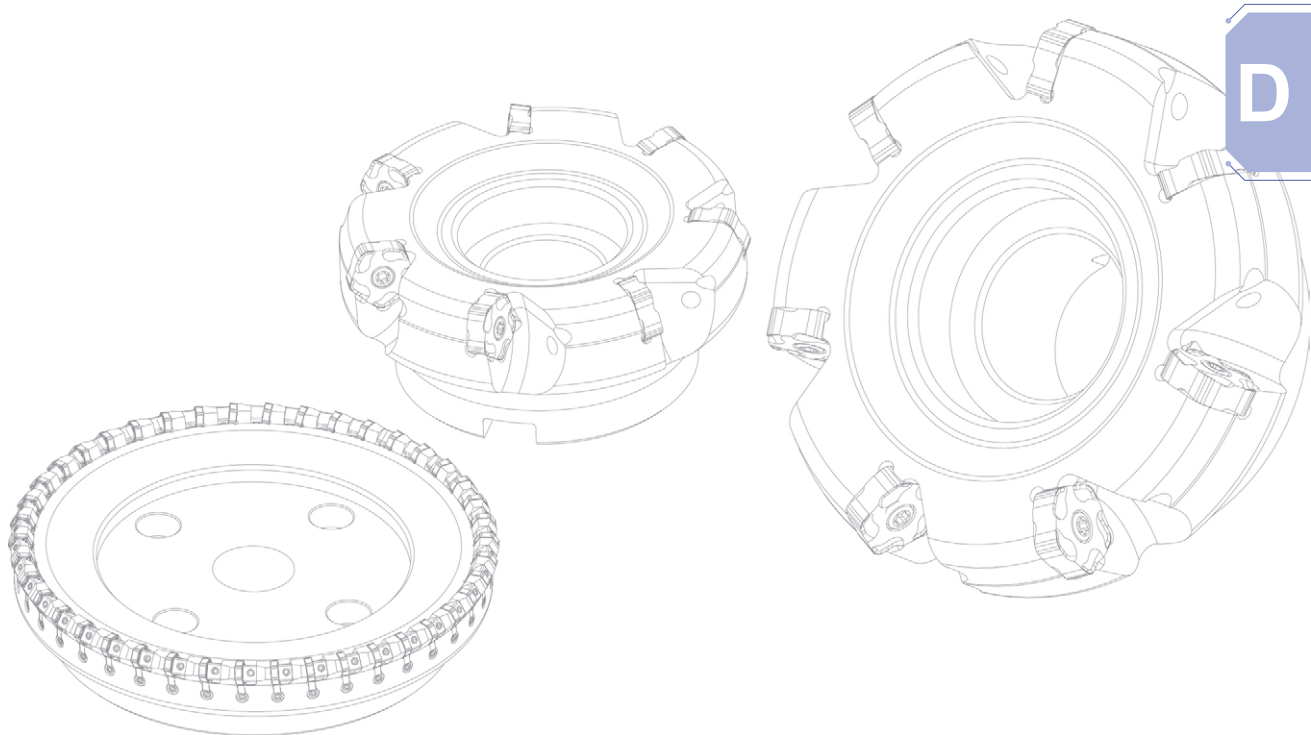
Type		Dimension(inch)						
		ØD	ØD ₁	Ød	L	a _p max	Z	Interface form
FMD02 Extra close pitch	-3.00"-A1.00"-PN11-10	3.00	3.398	1.000	1.750	0.197	10	A
	-4.00"-B1.25"-PN11-14	4.00	4.398	1.250	2.000	0.197	14	B
	-5.00"-B1.50"-PN11-18	5.00	5.398	1.500	2.500	0.197	18	B
	-6.00"-B1.50"-PN11-22	6.00	6.398	1.500	2.500	0.197	22	B

Spare parts

Diameter ØD	Wedge	Insert screw	Wrench	Sketch of installation
Ø3.00"-Ø6.00"	W18N	DM6x20A	WT15IT	

Recommended cutting parameters

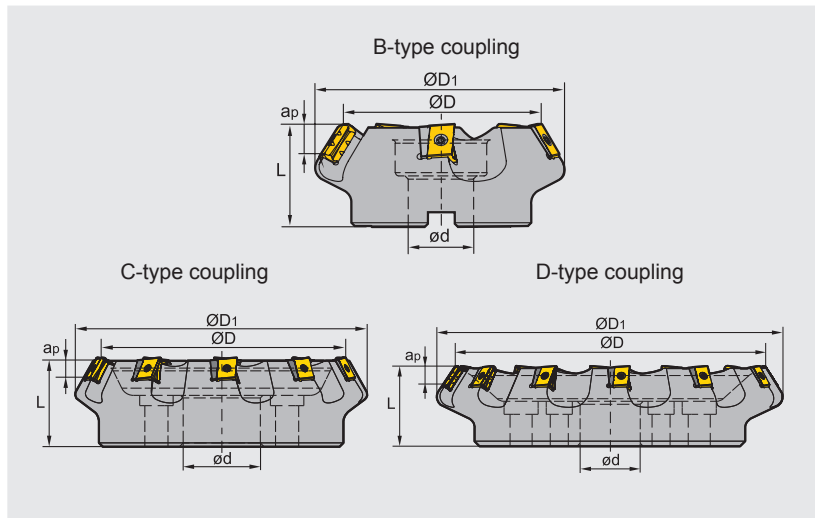
Workpiece material		Hardness HB	Insert grade	Cutting parameters			
				V(SFPM)	f(in/z)		
					PF	PM	PR
P	Low carbon steel, Soft steel	≤ 180	YBC302 YBM253	900(700-1100)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)
	High-carbon steel, Alloy steel	180-280		850(650-1000)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)
	Alloy tool steel	280-350		800(600-950)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)
K	Cast iron	180-250	YBD152	900(500-1000)	CF	CM	CR
					0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)



Face milling tools **Kr:60°**



FMD03 **P** **M** **K**



Specification of tools

Type		Dimensions(inch)						
		ØD	ØD ₁	Ød	L	a _p max	Z	Interface form
FMD03	-5.00"-B1.5"-LN20-06	5.000	6.053	1.500	2.500	0.472	6	B
	-6.00"-C1.5"-LN20-08	6.000	7.053	1.500	2.500	0.472	8	C
	-8.00"-C2.5"-LN20-10	8.000	9.053	2.500	2.500	0.472	10	C
	-10.00"-C2.5"-LN20-12	10.000	11.053	2.500	2.500	0.472	12	C
	-12.00"-D2.5"-LN20-15	12.000	13.053	2.500	2.500	0.472	15	D
	-5.00"-B1.5"-LN25-05	5.000	6.172	1.500	2.500	0.669	5	B
	-6.00"-C1.5"-LN25-06	6.000	7.172	1.500	2.500	0.669	6	C
	-8.00"-C2.5"-LN25-08	8.000	9.172	2.500	2.500	0.669	8	C
	-10.00"-C2.5"-LN25-10	10.000	11.172	2.500	2.500	0.669	10	C
	-12.00"-D2.5"-LN25-12	12.000	13.172	2.500	2.500	0.669	12	D

Spare parts

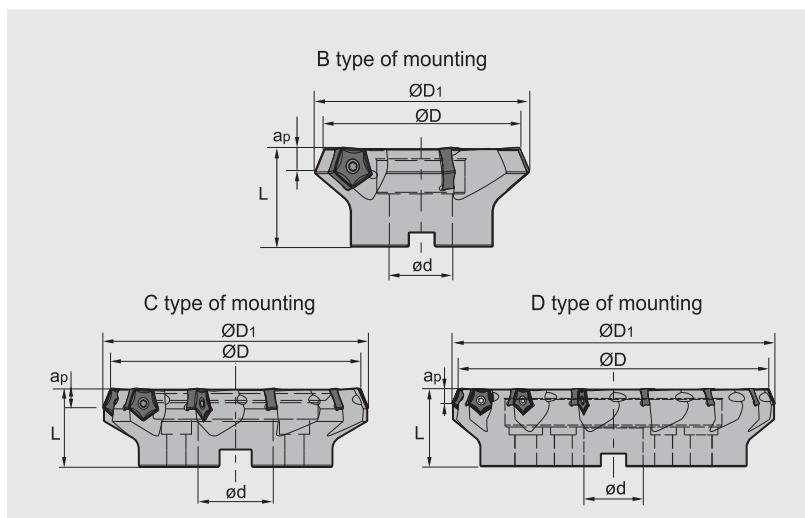
Inserts	Shim	Shim screw	Insert screw	Wrench		Sketch of installation
LNKT2007DN-ZR	LLN20R-ZR	I60M3×7	I60M4×15	WT15IS	WT09IS	
LNKT2510-ZR	LLN25R-ZR	I60M3.5×10.4	I60M5×17	WT20IT	WT15IS	

Face milling tools

Kr:67°



FMD04



Specification of tools

Type		Dimensions(inch)						
		ØD	ØD ₁	Ød	L	a _{pmax}	Z	Interface form
FMD04	-5.00"-B1.50"-PN17-06	5.000	5.496	1.500	2.500	0.472	6	B
	-6.00"-B2.00"-PN17-08	6.000	6.496	2.000	2.500	0.472	8	B
	-8.00"-C2.50"-PN17-10	8.000	8.496	2.500	2.500	0.472	10	C
	-10.00"-C2.50"-PN17-12	10.000	10.496	2.500	2.500	0.472	12	C
	-12.00"-D2.50"-PN17-14	12.000	12.496	2.500	2.500	0.472	14	D

Spare parts

Diameter ØD	Insert screw	Wrench	Sketch of installation
Ø5.00" -Ø12.00"	I43M6×16	WT25IT	

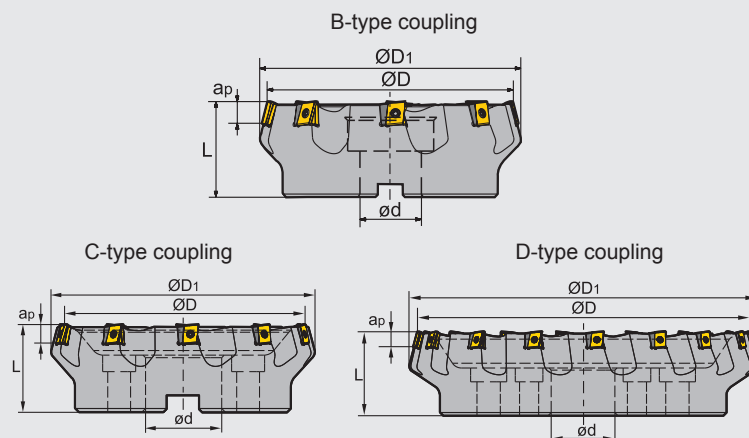
Face milling tools

Kr:75°



FME04

P M K



Specification of tools

Type		Dimensions(inch)						Interface form
		$\varnothing D$	$\varnothing D_1$	$\varnothing d$	L	a_{pmax}	Z	
FME04	-5.00"-B1.5"-LN15-06	5.000	5.388	1.500	2.500	0.472	6	B
	-6.00"-B1.5"-LN15-08	6.000	6.388	1.500	2.500	0.472	8	B
	-8.00"-C2.5"-LN15-10	8.000	8.388	2.500	2.750	0.472	10	C
	-10.00"-C2.5"-LN15-12	10.000	10.388	2.500	2.750	0.472	12	C
	-12.00"-D2.5"-LN15-16	12.000	12.388	2.500	3.150	0.472	16	D

Spare parts

Diameter $\varnothing D$	Shim	Shim screw	Insert screw	Wrench	Sketch of installation
$\varnothing 5.00''$ - $\varnothing 12.00''$	LLN15-ZR	I60M3×7	I60M4×12	WT15IS, WT09IS	

Face milling tools

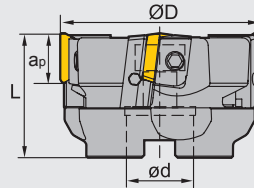
Kr:90°



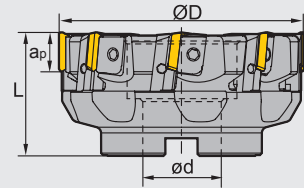
FMP01 **P** **M** **K**



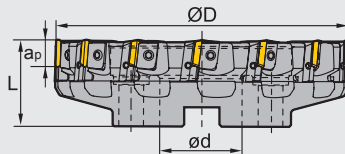
A type of mounting



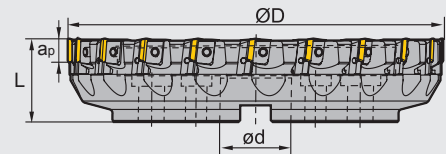
B type of mounting



C type of mounting



D type of mounting



Specification of tools

Type		Dimensions(inch)				
		ØD	Ød	L	apmax	Z
FMP01	-3.00"-A1.00"-TP22-04	3.000	1.000	2.500	0.709	4
	-4.00"-B1.25"-TP22-06	4.000	1.250	2.500	0.709	6
	-5.00"-B1.50"-TP22-08	5.000	1.500	2.500	0.709	8
	-6.00"-B1.50"-TP22-10	6.000	1.500	2.500	0.709	10
	-8.00"-C2.50"-TP22-12	8.000	2.500	2.500	0.709	12
	-10.00"-C2.50"-TP22-16	10.00	2.500	2.500	0.709	16
	-12.00"-D2.50"-TP22-20	12.00	2.500	2.750	0.709	20

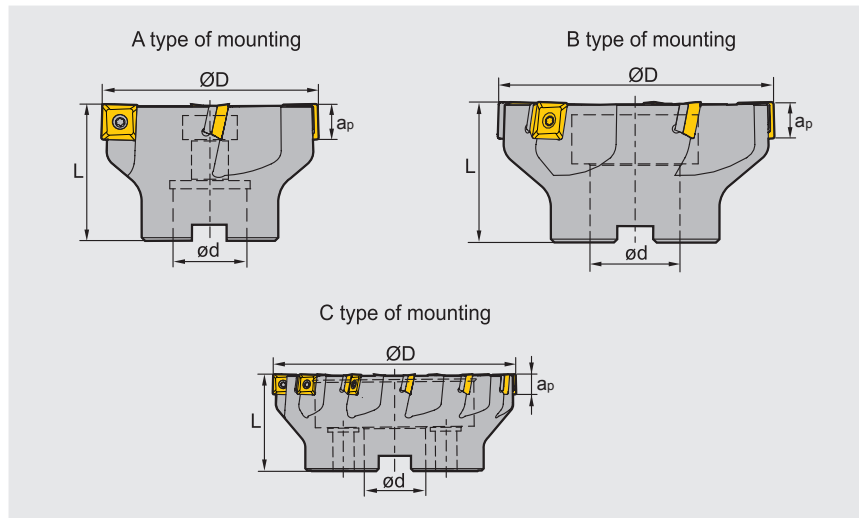
Spare parts

Diameter ØD	Locator	Wedge	Wedge screw	Locator Screw	Wrench	Sketch of installation
ØD3.00"~ØD4.00"	LTP4R1/L1	W04R/L	WM8×17	LOM5×15.1	WT20T	
ØD5.00"~ØD12.00"	LTP4R/L	W04R/L	WM8×22	LOM5×15.1	WT25T	

Face milling tools



FMP02 P M K



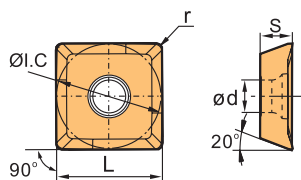
Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	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	10.00	2.500	2.500	0.425	12	C
	-10.00"-C2.50"-SE12-18	10.00	2.500	2.500	0.425	18	C

Spare parts

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

Selection of inserts



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

Workpiece material	Temperature											
	20 °C	100 °C	200 °C	300 °C	400 °C	500 °C	600 °C	700 °C	800 °C	900 °C	1000 °C	1100 °C
P Steel	😬	😬	😬	😬			😬	😬	😊	😬	😊	😊
M Stainless steel	😬	😬	😬	😬			😬	😬	😬		😊	😊
K Cast iron					😬	😬	😊			😊	😊	😬
N Ferrite materials												😬
S Heat-resistant steel					😊	😬	😬					

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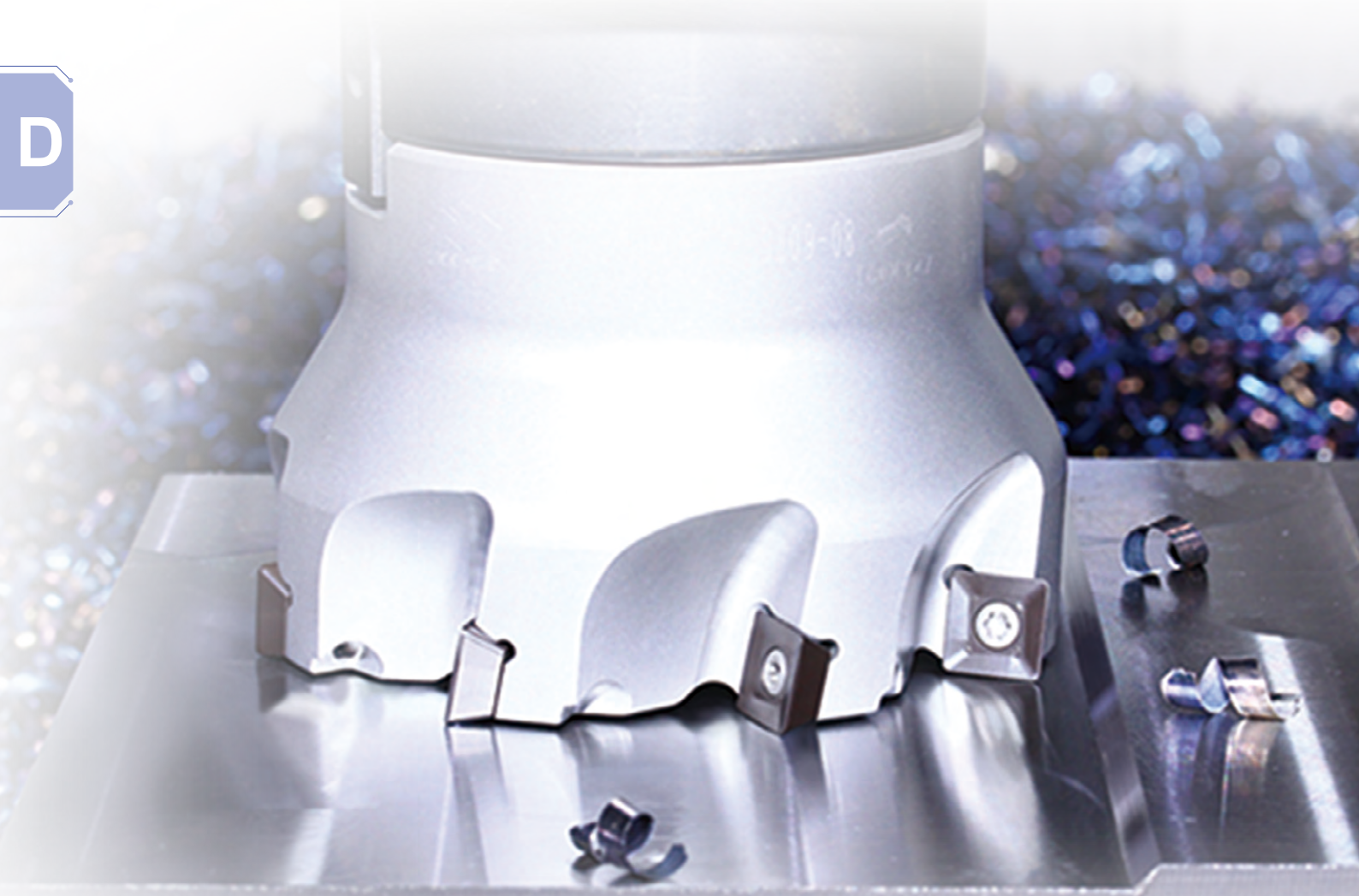
☒ Always stock available ☐ Produce according to order

Chipbreaker selection for FMP02 milling inserts

Classification \ Function		For finishing	For semi-finishing	For roughing
P		-APF 	-APM 	-APR 
M				
K				

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting data			
				V(SFPM)	f(in/z)		
					-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)
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)

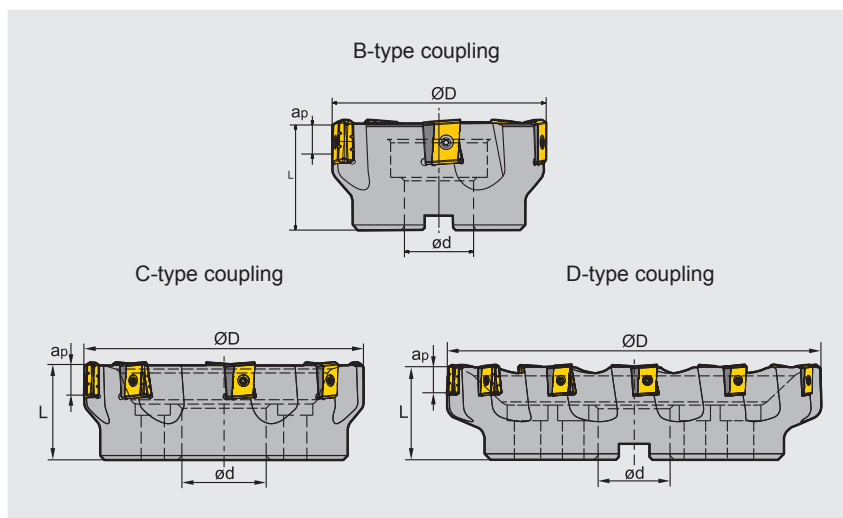


Face milling tools

Kr:90°



FMP03 P M K



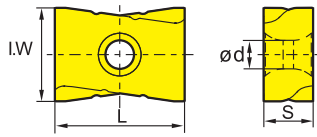
Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMP03	-5.00"-B1.5"-LN15-06	5.00	1.50	2.50	0.512	6	B
	-6.00"-C1.5"-LN15-08	6.00	1.50	2.50	0.512	8	C
	-8.00"-C2.5"-LN15-10	8.00	2.50	2.75	0.512	10	C
	-10.00"-C2.5"-LN15-12	10.00	2.50	2.75	0.512	12	C
	-12.00"-D2.5"-LN15-16	12.00	2.50	3.15	0.512	16	D
	-5.00"-B1.5"-LN20-06	5.00	1.50	2.50	0.669	6	B
	-6.00"-C1.5"-LN20-08	6.00	1.50	2.50	0.669	8	C
	-8.00"-C2.5"-LN20-10	8.00	2.50	2.75	0.669	10	C
	-10.00"-C2.5"-LN20-12	10.00	2.50	2.75	0.669	12	C
	-12.00"-D2.5"-LN20-15	12.00	2.50	3.15	0.669	15	D
	-5.00"-B1.5"-LN25-05	5.00	1.50	2.50	0.866	5	B
	-6.00"-C1.5"-LN25-06	6.00	1.50	2.50	0.866	6	C
	-8.00"-C2.5"-LN25-08	8.00	2.50	2.75	0.866	8	C
	-10.00"-C2.5"-LN25-10	10.00	2.50	2.75	0.866	10	C
	-12.00"-D2.5"-LN25-12	12.00	2.50	3.15	0.866	12	D

Spare parts

Diameter ØD	Shim	Shim screw	Insert screw	Wrench		Sketch of installation
LNKT1506EN-ZR	LLN15-ZR	I60M3×7	I60M4×12	WT15IS	WT09IS	
LNKT2007DN-ZR	LLN20R-ZR	I60M3×7	I60M4×15	WT15IS	WT09IS	
LNKT2510-ZR	LLN25R-ZR	I60M3.5×10.4	I60M5×17	WT20IT	WT15IS	

Selection of inserts



😊 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	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
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						
		L	ØI.C	S	Ød	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	LNKT1506EN-ZR	0.625	0.551	0.25	0.181				○	○						●								
	LNKT2007DN-ZR	0.787	0.669	0.313	0.181				○							●								
	LNKT2510-ZR	0.984	0.709	0.375	0.217				○	○						●								

● Always stock available ○ Produce according to order

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				V(SFPM)	f(in/z)
P	Low-carbon steel, Soft steel	≤ 180	YBG302	600 (500-1000)	0.02 (0.008-0.031)
			YBM351	600 (500-1000)	0.02 (0.008-0.031)
	High-carbon steel, Alloy steel	180-280	YBG302	500(400-900)	0.02 (0.008-0.031)
			YBM351	450(400-900)	0.02 (0.008-0.031)
	Alloy tool steel	280-350	YBG302	400 (250-800)	0.018 (0.008-0.024)
			YBM351	300(250-800)	0.018 (0.008-0.024)
M	Stainless steel	≤ 270	YBG302	400(250-650)	0.018 (0.008-0.024)
			YBM351	300 (250-650)	0.018 (0.008-0.024)
K	Cast iron	180-250	YBD152	700 (500-1000)	0.02 (0.008-0.031)
			YBD252	680 (500-1000)	0.02 (0.008-0.031)
			YBG302	650 (500-1000)	0.02 (0.008-0.031)

Note: Cutting parameters can be adjusted according to the Max. power of machine.

Case for FMP03



Tool type: FMP03-8"-C2.5"-LN25-08

Insert type/grade: LNKT2510-ZR/YBG302

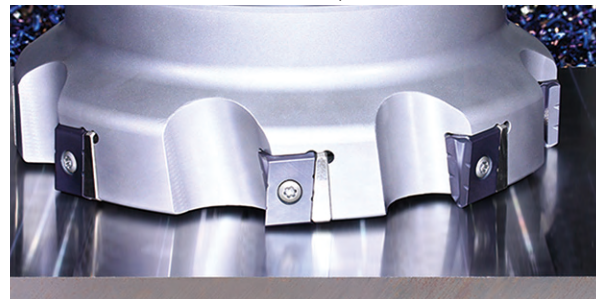
The tool operates easily and fast at high cutting depth with good chip breaking performance. Cutting efficiency is doubled, and tool life increases to 1-2 times that of the original.

Workpiece material: 45[#]

Hardness(HB): 190

Cooling system: Dry cutting

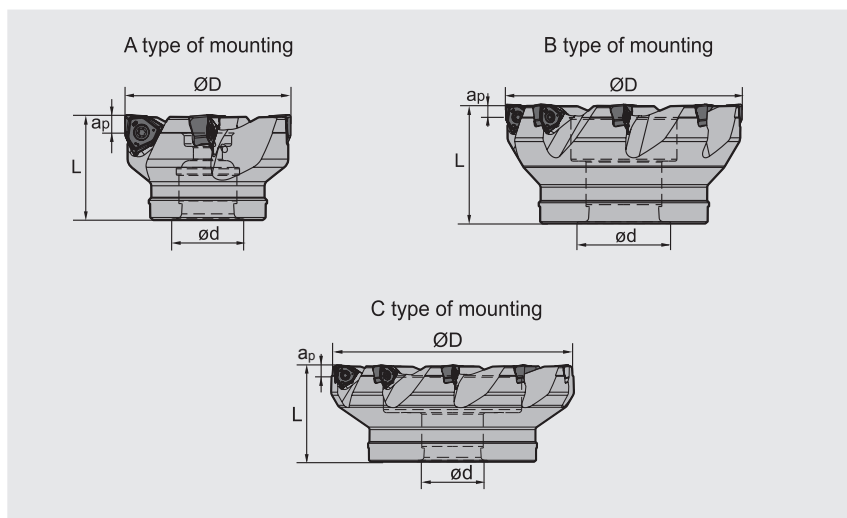
Cutting parameters: Vc=420SFPM, ap=0.047in, fz=0.02in/z, ae=5.51in



Face milling tools



FMP12 P K



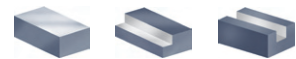
Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMP12	-2.00"-A0.75"-WN06-05C	2.00	0.75	1.75	0.224	5	A
	-2.50"-A0.75"-WN06-06C	2.50	0.75	1.75	0.224	6	A
	-2.50"-A1.00"-WN06-06C	2.50	1.00	2.00	0.224	6	A
	-3.00"-A1.00"-WN06-07C	3.00	1.00	2.00	0.224	7	A
	-4.00"-B1.25"-WN06-09	4.00	1.25	2.00	0.224	9	B
	-5.00"-B1.50"-WN06-11	5.00	1.50	2.50	0.224	11	B
	-6.00"-C1.50"-WN06-14	6.00	1.50	2.50	0.224	14	C
	-2.50"-A0.75"-WN08-05C	2.50	0.75	1.75	0.303	5	A
	-2.50"-A1.00"-WN08-05C	2.50	1.00	2.00	0.303	5	A
	-3.00"-A1.00"-WN08-06C	3.00	1.00	2.00	0.303	6	A
	-4.00"-B1.25"-WN08-08	4.00	1.25	2.00	0.303	8	B
	-5.00"-B1.50"-WN08-10	5.00	1.50	2.50	0.303	10	B
	-6.00"-C1.50"-WN08-12	6.00	1.50	2.50	0.303	12	C

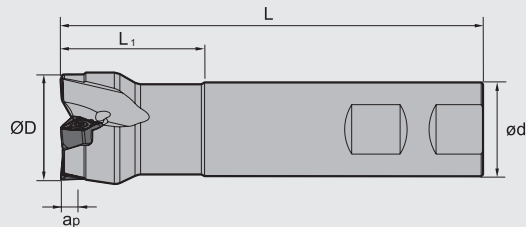
Spare parts

Inserts	Insert tightening screw	Wrench	Sketch of installation
			
WNHU06	I60M3×9	WT09IS	
WNHU08	I60M4×10	WT15IS	

Face milling tools



FMP12 P K



Specification of tools

Type		Dimensions(inch)					
		ØD	ød	L	L ₁	a _p max	Z
FMP12	-1.00"-XP1.00"-WN06-02C	1.00	1.00	4.0	1.25	0.224	2
	-1.25"-XP1.00"-WN06-03C	1.25	1.00	4.5	1.50	0.224	3
	-1.50"-XP1.25"-WN06-04C	1.50	1.25	4.5	1.50	0.224	4
	-2.00"-XP1.50"-WN06-05C	2.00	1.50	4.5	1.50	0.224	5

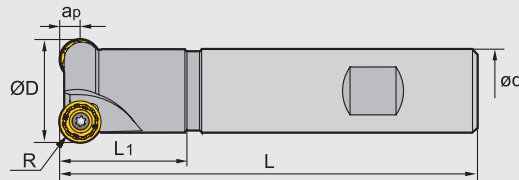
Spare parts

Inserts	Insert tightening screw	Wrench	Sketch of installation
WNHU06	I60M3×9	WT09IS	
WNHU08	I60M4×10	WT15IS	

Face milling tools



FMR01 P M K



Specification of tools

Type		Dimensions(inch)						
		ØD	R	ød	L ₁	L	a _p max	Z
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

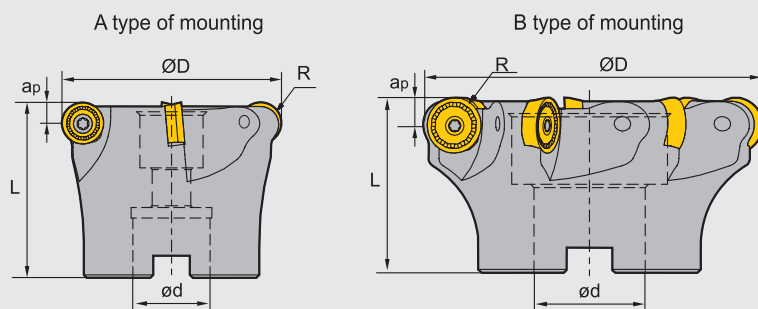
Spare parts

Diameter ØD	Insert specification	Insert screw	Wrench	Sketch of installation
ØD=1.00",1.25"	RCKT10T3MO-DM	I60M4×8.4	WT15S	
ØD=1.50",2.00"	RCKT1204MO-□□	I60M3.5×10	WT15S	

Face milling tools



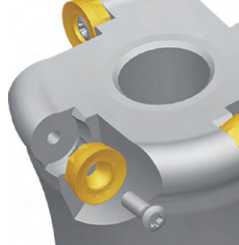
FMR02 P M K S



Specification of tools

Type		Dimensions(inch)						
		ØD	R	ød	L	apmax	Z	Interface form
FMR02	-2.50"-A0.75"-RC12-04	2.50	0.236	0.75	2.00	0.236	4	A
	-3.00"-B1.00"-RC16-05	3.00	0.315	1.00	2.00	0.315	5	B
	-4.00"-B1.25"-RC16-06	4.00	0.315	1.25	2.50	0.315	6	B
	-5.00"-B1.50"-RC20-07	5.00	0.394	1.50	2.50	0.394	7	B
	-6.00"-B1.50"-RC20-08	6.00	0.394	1.50	2.50	0.394	8	B

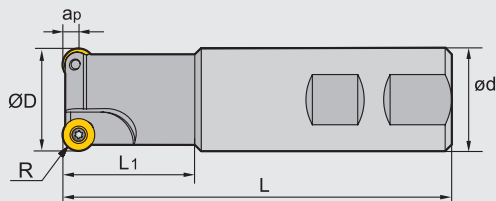
Spare parts

Diameter ØD	Insert specification	Insert screw	Wrench	Sketch of installation
				
ØD=2.50"	RC□□1204MO-□□	I60M3.5×10	WT15IS	
ØD=3.00", 4.00"	RC□□1606MO-□□	I60M5×13	WT20IT	
ØD=5.00", 6.00"	RC□□2006MO-□□	I43M6×16	WT25IT	

Face milling tools



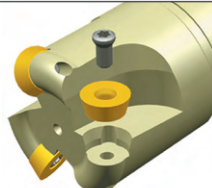
FMR03 P M K

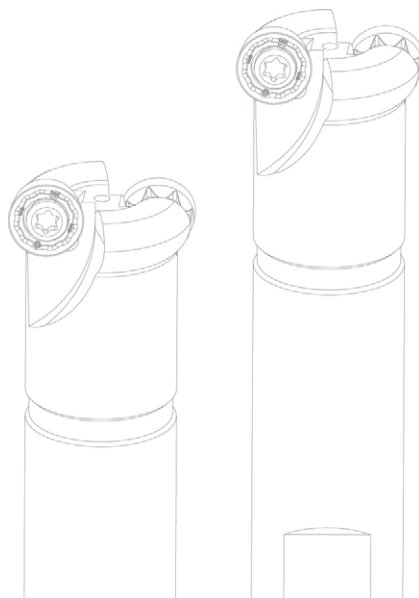


Specification of tools

Type		Dimensions(inch)						
		ØD	R	ød	L1	L	apmax	Z
FMR03	-1.00"-XP1.00" -RD08-02	1.00	0.157	1.00	1.75	4.00	0.157	2
	-1.25"-XP1.25" -RD10-02	1.25	0.197	1.25	2.50	4.75	0.197	2
	-1.50"-XP1.25" -RD12-03	1.50	0.236	1.25	2.50	4.75	0.236	3
	-2.00"-XP1.25" -RD12-03	2.00	0.236	1.25	2.50	4.75	0.236	3

Spare parts

Diameter ØD	Insert specifiration	Insert screw	Wrench	Sketch of installation
				
ØD=1.00"	RDKW0803MO	I60M3×7	WT09IP	
ØD=1.25",1.50",2.00"	RDKW1073MO RDKW1204MO	I60M4×10	WT15IP	



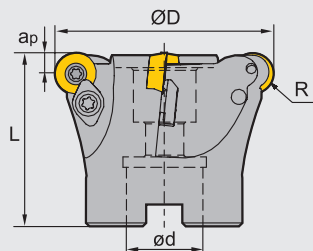
Face milling tools



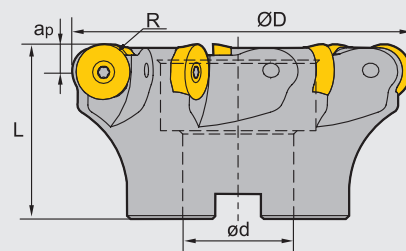
FMR04 P M K



A type of mounting



B type of mounting



Specification of tools

Type		Dimensions(inch)						
		ØD	R	ød	L	apmax	Z	Interface form
FMR04	-2.00"-A0.75"-RD12-04	2.00	0.236	0.75	2.00	0.236	4	A
	-2.50"-A0.75"-RD12-04	2.50	0.236	0.75	2.00	0.236	4	A
	-3.00"-A1.00"-RD16-05	3.00	0.315	1.00	2.00	0.315	5	A
	-4.00"-B1.25"-RD16-06	4.00	0.315	1.25	2.00	0.315	6	B
	-5.00"-B1.50"-RD20-06	5.00	0.394	1.50	2.50	0.394	6	B
	-6.00"-B1.50"-RD20-07	6.00	0.394	1.50	2.50	0.394	7	B

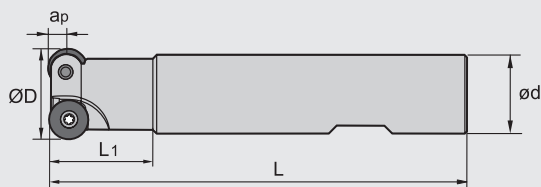
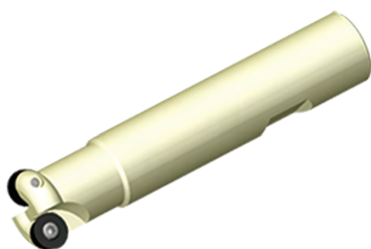
Spare parts

Diameter ØD	Insert screw	Wedge	Wedge Screw	Wrench	Sketch of installation
ØD=2.00" ØD=2.50"	 I60M3.5×10	 WD-204	 I60M4×10	 WT15IT	
ØD=3.00", 4.00"	I60M5×13	WD-207	I60M5×13	WT20IT	
ØD=5.00", 6.00"	I43M6×16	--	--	WT25IT	

Face milling tools



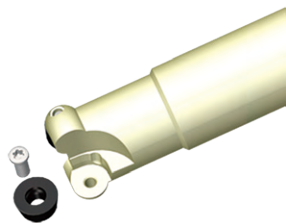
FMR05 P M K



Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L1	L	apmax	Z
FMR05	-0.625"-XP0.75"-RP06-02	0.625	0.75	1.75	4	0.125	2
	-0.750"-XP0.75"-RP06-02	0.750	0.75	1.75	4	0.125	2
	-0.875"-XP0.75"-RP06-03	0.875	0.75	1.75	4	0.125	3
	-0.875"-XP0.75"-RP09-02	0.875	0.75	1.75	4	0.180	2
	-1.000"-XP0.75"-RP09-02	1.000	0.75	1.75	4	0.180	2
	-1.250"-XP1.00"-RP09-03	1.250	1.00	2.75	5	0.180	3
	-1.250"-XP1.00"-RP12-02	1.250	1.00	2.75	5	0.250	2
	-1.500"-XP1.25"-RP12-03	1.500	1.25	2.75	5	0.250	3
	-1.750"-XP1.50"-RP12-04	1.750	1.50	2.75	5	0.250	4

Spare parts

Diameter ØD	Insert specification	Insert screw	Wrench	Sketch of installation
				
Ø0.625"-Ø0.875"	RPMW06T200	I60M2.2×5.5	WT07IP	
Ø0.875"-Ø1.250"	RPMW09T300	I60M3×7	WT09IP	
Ø1.250"-Ø1.750"	RPMW120400	I60M4×8.4	WT15IP	

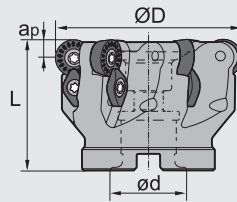
Face milling tools



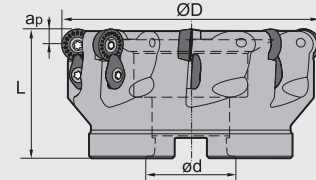
FMR05 P M K



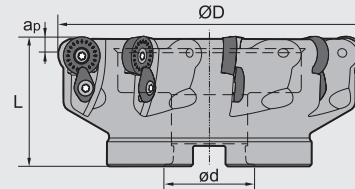
A type of mounting



B type of mounting



C type of mounting



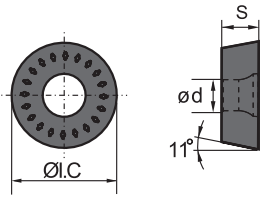
Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMR05	-2.00"-A0.75"-RP12-05	2.0	0.75	1.75	0.250	5	A
	-2.50"-A0.75"-RP12-06	2.5	0.75	1.75	0.250	6	A
	-3.00"-A1.00"-RP12-07	3.0	1.00	2.00	0.250	7	A
	-3.00"-A1.00"-RP16-05	3.0	1.00	2.00	0.315	5	A
	-4.00"-B1.50"-RP16-07	4.0	1.50	2.50	0.315	7	B
	-5.00"-B1.50"-RP16-08	5.0	1.50	2.50	0.315	8	B
	-5.00"-B1.50"-RP19-07	5.0	1.50	2.50	0.375	7	B
	-6.00"-B2.00"-RP19-08	6.0	2.00	2.50	0.375	8	B
	-8.00"-C2.50"-RP19-09	8.0	2.50	2.50	0.375	9	C

Spare parts

Diameter ØD	Insert specification	Insert screw	Wedge	Wedge Screw	Wrench	Sketch of installation
						
Ø2.00"-Ø3.00"	RPMW120400	I60M4×8.4	WD-204	I60M4×10	WT15IP	
Ø3.00"-Ø5.00"	RPMW160500	I60M5×13	WD-208	I60M5×13	WT20IP	
Ø5.00"-Ø8.00"	RPMW190600					

Selection of inserts



😊 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	YBG302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
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	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	RPMW06T200	0.250	0.101	0.098								○	●		○								
	RPMW09T300	0.375	0.156	0.134								○	●		○								
	RPMW120400	0.500	0.187	0.173								○	●		○								
	RPMW160500	0.625	0.219	0.217								○	●		○								
	RPMW190600	0.750	0.250	0.256								○	●		○								

● Always stock available ○ Produce according to order

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				V(SFPM)	f(in/z)
P	Low-carbon steel、Soft steel	≤180	YBG202	900(650-1200)	0.008(0.004-0.018)
			YBG302	700(600-1000)	0.010(0.006-0.018)
	High-carbon steel、Alloy steel	180-280	YBG202	800(600-1200)	0.008(0.004-0.018)
			YBG302	650(500-1000)	0.010(0.006-0.018)
	Alloy tool steel	280-350	YBG202	700(550-1100)	0.008(0.004-0.018)
			YBG302	600(500-800)	0.010(0.006-0.018)
M	Stainless steel	≤270	YBG302	500(300-700)	0.010(0.004-0.018)
			YBG202	500(350-900)	0.008(0.004-0.018)
			YBG205		
K	Cast iron	180-250	YBG302	700(400-1000)	0.008(0.004-0.018)