

## Face milling tools **Kr:45°**

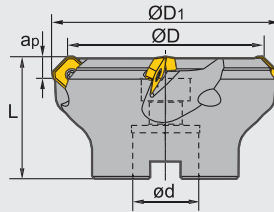


### FMA02 **P M K N S**

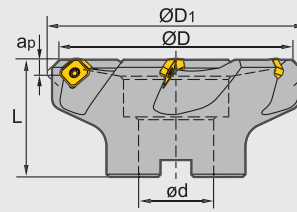


Coarse pitch differential

A type of mounting






B type of mounting

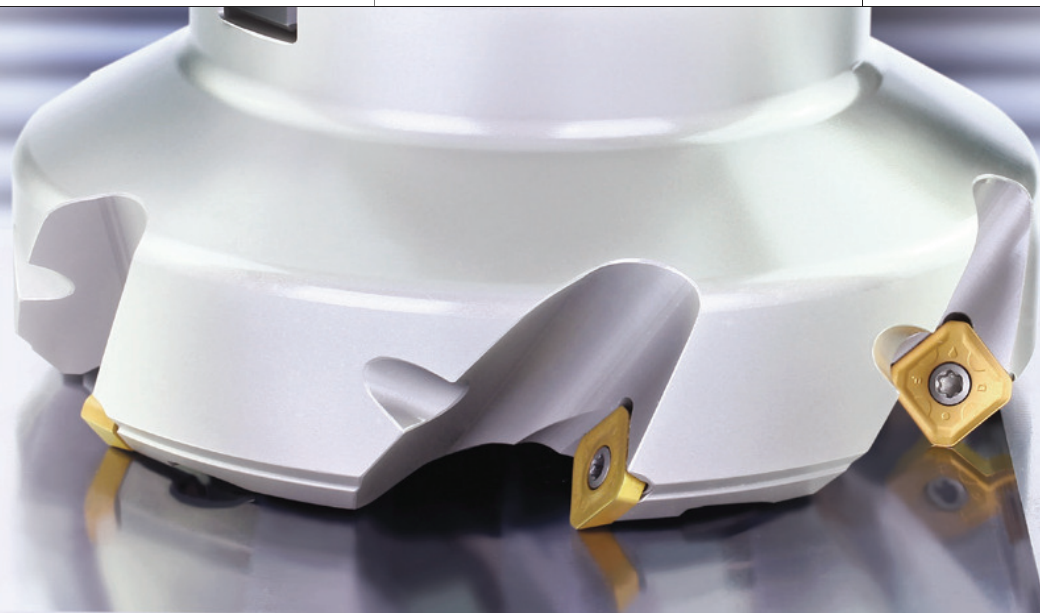


### Specification of tools

Type		Dimensions (inch)					
		ØD	Ød	L	apmax	Z	Interface form
<b>FMA02</b>	-2.00"-A0.75"-SE12-04	2.000	0.750	1.500	0.236	4	A
	-2.50"-A0.75"-SE12-05	2.500	0.750	1.500	0.236	5	A
	-3.00"-A1.00"-SE12-05	3.000	1.000	2.000	0.236	5	A
	-4.00"-B1.25"-SE12-07	4.000	1.250	2.000	0.236	7	B
	-5.00"-B1.50"-SE12-08	5.000	1.500	2.500	0.236	8	B

### Spare parts

Insert screw	Wrench	Sketch of installation
		
I60M3.5×10	WT15IS	





## Chipbreaker selection for FMA01

Classification \ Function	For finishing	For semi-finishing	For roughing
<b>P</b>	-DF	-DM	-DR
<b>M,S</b>	-EF	-EM	
<b>K</b>	-CF	-CM	-CR
<b>AL</b>		-LH	

## Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters					
			V(SFPM)	f(in/z)				
				-DF	-DM	-DR		
<b>P</b>	Low-carbon steel, Soft steel	≤ 180	YBM251	900(700-1200)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBC302	900(700-1200)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBG202	900(650-1200)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBG302	750(550-1200)	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	YBM251	800(700-1000)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBG202	800(600-1200)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBG302	700(500-1100)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
	Alloy tool steel	280-350	YBM251	700(600-1000)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
			YBG202	700(550-1100)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
YBG302			600(400-1000)	0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)		
<b>M</b>	Stainless steel	≤ 270			-EF	-EM		
			YBM251	500(400-800)	0.006(0.004-0.008)	0.008(0.004-0.012)		
			YBG202	500(360-900)	0.006(0.004-0.008)	0.008(0.004-0.012)		
			YBG302	450(300-800)	0.006(0.004-0.008)	0.008(0.004-0.012)		
<b>K</b>	Cast iron	180-250	YBG102	700(400-1000)	-CF	-CM	-CR	
					0.006(0.004-0.008)	0.008(0.004-0.012)	0.012(0.008-0.016)	
<b>N</b>	Al alloy steel	-	YD101	1000-	-LH			
			YD201	1000-	0.010(0.004-0.016)			
<b>S</b>	High-temperature alloy	≤ 400			-EF	-EM		
			YBG102	150(60-200)	0.004(0.004-0.008)	0.006(0.004-0.012)		
			YBG202	130(60-160)	0.004(0.004-0.008)	0.006(0.004-0.012)		

