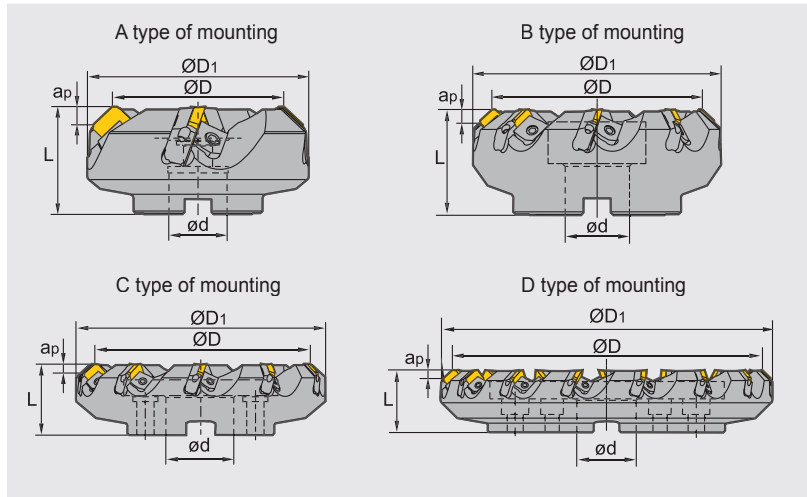


Face milling tools **Kr:45°**









FMA03 **P** **M** **K**



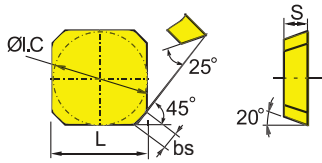
Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMA03	-3.00"-A1.00"-SE12-04	3.000	1.000	2.000	0.217	4	A
	-4.00"-B1.25"-SE12-05	4.000	1.250	2.000	0.217	5	B
	-5.00"-B1.50"-SE12-06	5.000	1.500	2.500	0.217	6	B
	-6.00"-B1.50"-SE12-08	6.000	1.500	2.500	0.217	8	B
	-8.00"-C2.50"-SE12-10	8.000	2.500	2.500	0.217	10	C
	-10.0"-C2.50"-SE12-12	10.00	2.500	2.500	0.217	12	C
	-12.0"-D2.50"-SE12-15	12.00	2.500	2.500	0.217	15	D
	-3.00"-A1.00"-SE15-04	3.000	1.000	2.000	0.295	4	A
	-4.00"-B1.25"-SE15-05	4.000	1.250	2.000	0.295	5	B
	-5.00"-B1.50"-SE15-06	5.000	1.500	2.500	0.295	6	B
	-6.00"-B1.50"-SE15-08	6.000	1.500	2.500	0.295	8	B
	-8.00"-C2.50"-SE15-10	8.000	2.500	2.500	0.295	10	C
	-10.0"-C2.50"-SE15-12	10.00	2.500	2.500	0.295	12	C
	-12.0"-D2.50"-SE15-15	12.00	2.500	2.500	0.295	15	D

Spare parts

Locator	Wedge	Wedge screw	Locator screw	Wrench	Sketch of installation
 LSE 12R/L (Suitable for 12mm inserts) LSE 15R/L (Suitable for 15mm inserts)	 W01R/L	 DM8×21X	 LOM5×15.1	 WT20T WH40T	

Selection of inserts



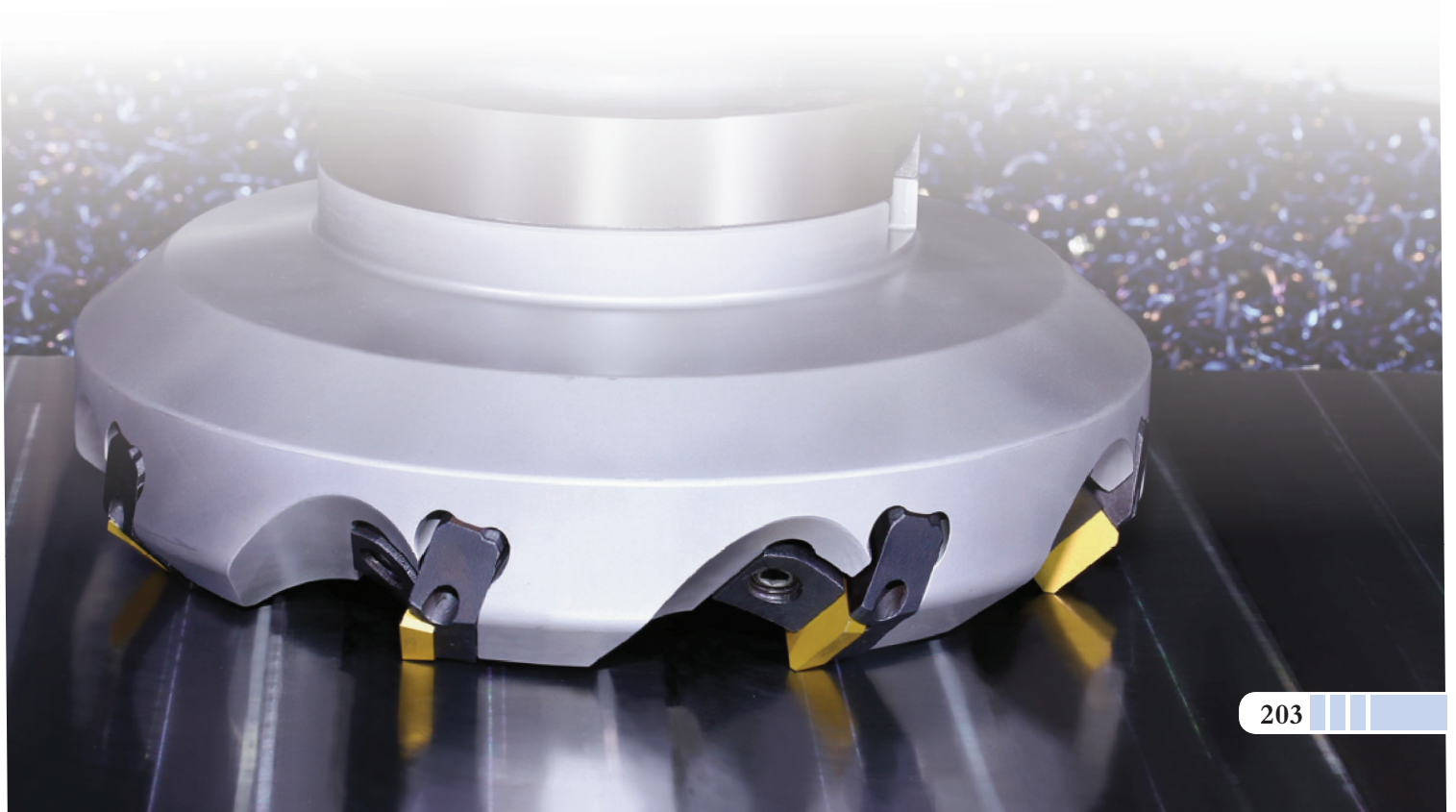
😊 Good working conditions 😐 General working conditions 😞 Adverse working conditions

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

Insert shape	Type	Dimensions (inch)				Coated grade										Cermets	Cemented carbide						
		L	ØI.C	bs	S	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302		YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	SEEN1203AFTN	0.500	0.500	0.071	0.125								○					●					
	SEKN1203AFFN	0.500	0.500	0.071	0.125								●										
	SEKN1203AFN	0.500	0.500	0.071	0.125								○			○					●		○
	SEKN1203AFTN	0.500	0.500	0.071	0.125		●		●					●		○					●		●
	SEKR1203AFN	0.500	0.500	0.071	0.125								○		○								
	SEKN1504AFN	0.625	0.625	0.063	0.187		●															●	
	SEKN1504AFTN	0.625	0.625	0.063	0.187		●		●							○					●		●
	SEKR1504AFN	0.625	0.625	0.063	0.187						●												

● Always stock available ○ Produce according to order

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Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters		
			V(SFPM)	f(in/z)	
P	Low-carbon steel, Soft steel	≤ 180	YNG151	1400 (1100 -1600)	0.008(0.004-0.016)
			YBM251	900 (700 -1100)	0.008(0.004-0.016)
			YBM351	700 (600 -1000)	0.01(0.006-0.012)
			YBG202	900 (650 -1200)	0.008(0.004-0.012)
			YC30S	450 (300 -700)	0.011(0.004-0.016)
	High-carbon steel, Alloy steel	180—280	YNG151	1300 (1000 -1600)	0.008(0.004-0.016)
			YBM251	800 (650 -1000)	0.008(0.006-0.016)
			YBM351	650 (500 -900)	0.010(0.006-0.012)
			YBG202	800 (600 -1100)	0.008(0.004-0.012)
			YC30S	400 (260 -650)	0.011(0.004-0.016)
	Alloy tool steel	280—350	YNG151	1100 (1000 -1500)	0.008(0.004-0.016)
			YBM251	700 (600 -1000)	0.008(0.004-0.016)
			YBM351	600 (500 -800)	0.01(0.006-0.012)
			YBG202	700 (550 -1100)	0.008(0.004-0.012)
			YC30S	300 (200 -600)	0.011(0.004-0.016)
M	Stainless steel	≤270	YNG151	700 (500 -900)	0.008(0.004-0.016)
			YBM251	400 (300 -700)	0.008(0.004-0.016)
			YBM351	450 (300 -800)	0.01(0.006-0.012)
			YBG202	450 (300 -800)	0.008(0.004-0.012)
K	Cast iron	180-250	YBG102	700 (400 -1000)	0.008(0.004-0.012)
			YD201	300 (260 -500)	0.01(0.004-0.016)

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