

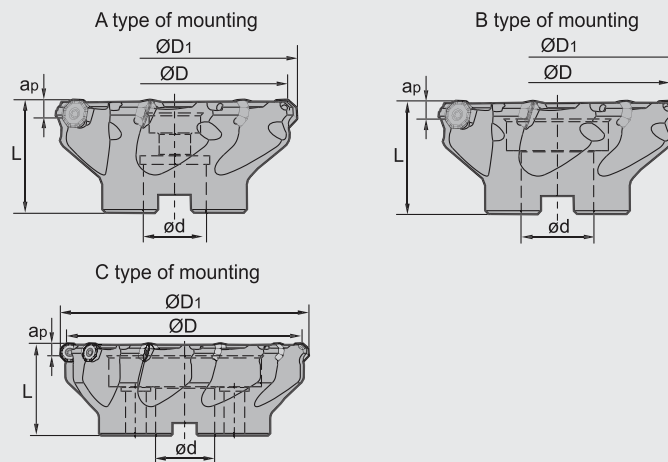
Face milling tools **Kr:45°**



FMA04 **P** **M** **K** **N**



Screw clamping



Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMA04	-2.00" -A0.75" -OF05-04	2.000	0.750	1.500	0.138	4	A
	-2.00" -A0.75" -OF05-05	2.000	0.750	1.500	0.138	5	A
	-2.50" -A0.75" -OF05-05	2.500	0.750	2.000	0.138	5	A
	-3.00" -A1.00" -OF05-06	3.000	1.000	2.000	0.138	6	A
	-4.00" -B1.25" -OF05-07	4.000	1.250	2.000	0.138	7	B
	-5.00" -B1.50" -OF05-08	5.000	1.500	2.500	0.138	8	B
	-6.00" -B1.50" -OF05-10	6.000	1.500	2.500	0.138	10	B
	-6.00" -C1.50" -OF05-10	6.000	1.500	2.500	0.138	10	C

Spare parts

Adaptable tool holders	Insert screw	Wrench	Sketch of installation
Ø2", Ø2.5"	I60M4×8.4	WT15iS	
Ø3", Ø4", Ø5", Ø6"	I60M4×10	WT15iS	

Selection of inserts

[illegible]

☒ Always stock available ☐ Produce according to order

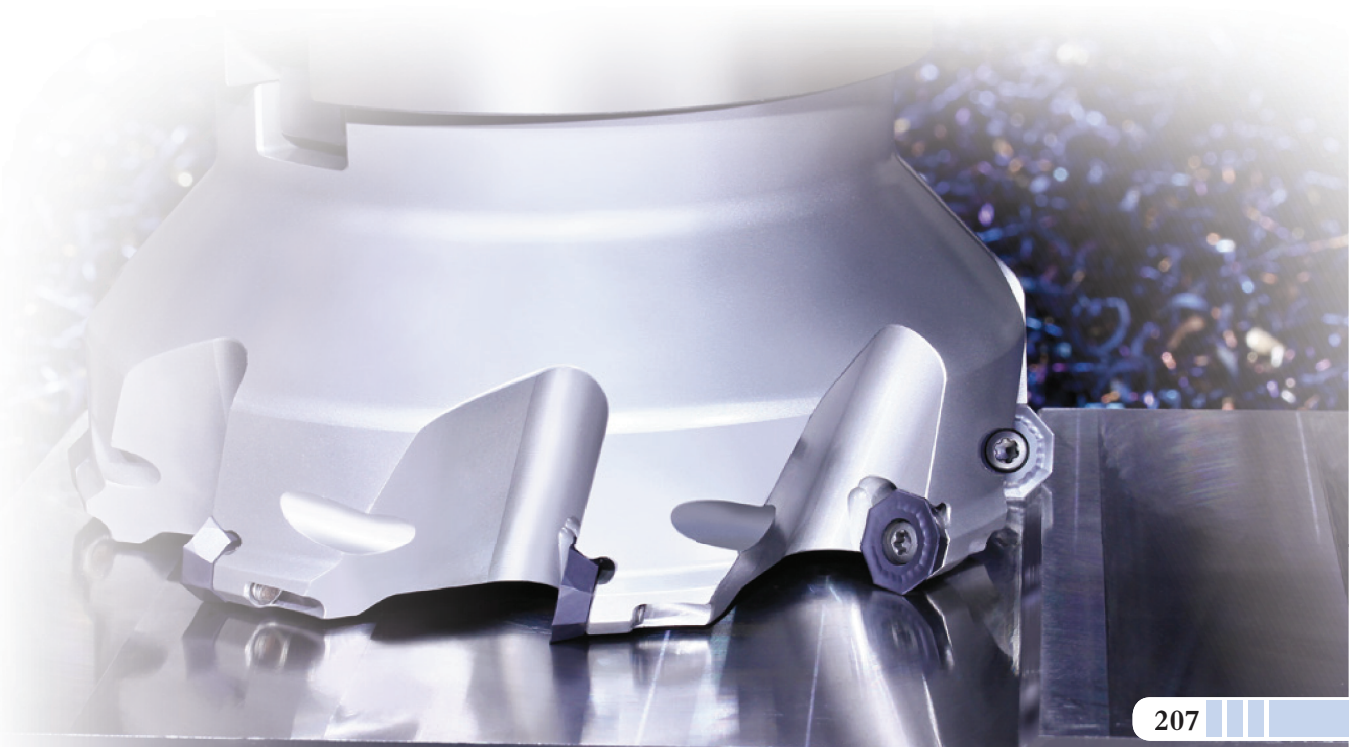
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Chipbreaker selection for FMA04 milling inserts

206

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters		
				V(SFPM)	f(in/z)	
					-DF	-DM
P	Low-carbon steel, Soft steel	≤ 180	YBM251	900(700-1100)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG202	900(650-1200)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBM351	700(600-1000)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG302	750(550-1200)	0.008(0.004-0.012)	0.01(0.004-0.016)
	High-carbon steel, Alloy steel	180-280	YBM251	800(650-1100)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBG202	800(600-1100)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBM351	650(500-900)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG302	700(500-1100)	0.008(0.004-0.012)	0.01(0.004-0.016)
	Alloy tool steel	280-350	YBM251	700(600-1000)	0.008(0.004-0.012)	0.008(0.004-0.016)
			YBG202	700(550-1100)	0.008(0.004-0.012)	0.008(0.004-0.016)
			YBM351	600(500-800)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG302	600(400-1000)	0.008(0.004-0.012)	0.01(0.004-0.016)
M	Stainless steel	≤ 270	YBG202	450(300-800)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBM251	500(400-800)	0.006(0.004-0.012)	0.008(0.004-0.016)
K	Cast iron	180-250	YBG102	700(400-1000)	0.008(0.004-0.012)	0.01(0.004-0.016)
N					-LH	
	Aluminium alloy	-	YD101	1000-	0.006(0.002-0.012)	



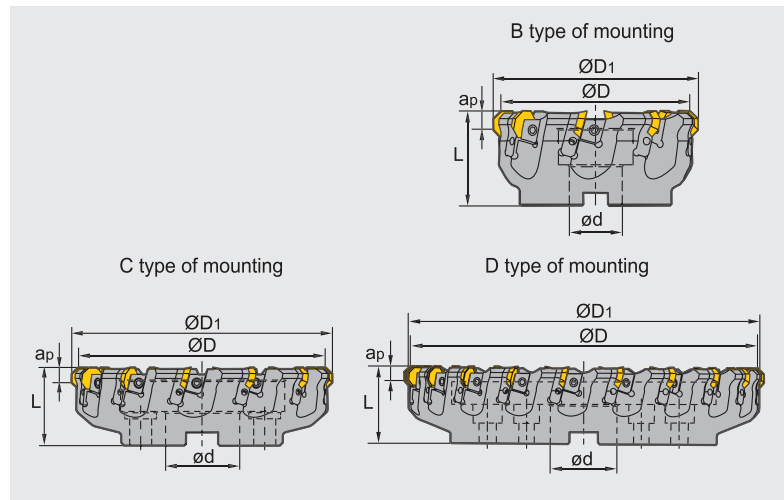
Face milling tools **Kr:45°**



FMA04 **P** **M** **K**



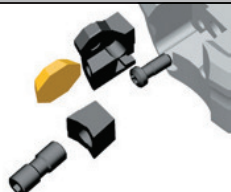
Top clamping



Specification of tools

Type		Dimensions(inch)					
		ØD	Ød	L	apmax	Z	Interface form
FMA04	-5.00"-B1.50"-OF07-08	5.000	1.500	2.500	0.197	8	B
	-6.00"-B1.50"-OF07-10	6.000	1.500	2.500	0.197	10	B
	-8.00"-C2.50"-OF07-12	8.000	2.500	2.500	0.197	12	C
	-10.0"-C2.50"-OF07-16	10.00	2.500	2.500	0.197	16	C
	-12.5"-D2.50"-OF07-20	12.50	2.500	2.500	0.197	20	D

Spare parts

Locator	Wedge	Wedge screw	Locator screw	Wrench	Sketch of installation
 LOF07R/L	 W02R/L	 DM8×21X	 LOM5×15.1	 WH20T WH40T	

Recommended cutting parameters

	Workpiece material	Hardness HB	Insert grade	Cutting parameters		
				V(SFPM)	f(in/z)	
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			YBG202	900(650-1200)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBM351	700(600-1000)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG302	750(550-1100)	0.008(0.004-0.012)	0.01(0.004-0.016)
	High-carbon steel, Alloy steel	180-280	YBM251	800(650-1000)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBG202	800(600-1100)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBM351	650(500-900)	0.008(0.004-0.012)	0.01(0.004-0.016)
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	Alloy tool steel	280-350	YBM251	700(600-1000)	0.006(0.004-0.012)	0.008(0.004-0.016)
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			YBM351	600(500-800)	0.008(0.004-0.012)	0.01(0.004-0.016)
			YBG302	600(400-1000)	0.008(0.004-0.012)	0.01(0.004-0.016)
M	Stainless steel	≤ 270	YBG202	500(360-900)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBG302	450(300-800)	0.006(0.004-0.012)	0.008(0.004-0.016)
			YBM251	500(400-800)	0.006(0.004-0.012)	0.008(0.004-0.016)
K	Cast iron	180-250	YBG102	700(400-1000)	0.008(0.002-0.012)	0.01(0.004-0.016)

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