

Chamfer milling

Kr:30°



Chamfering

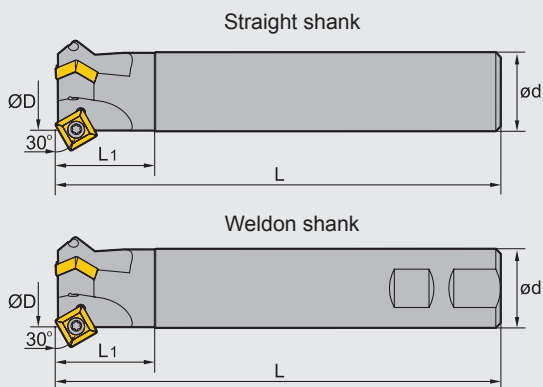


Face milling



Hole stomata chamfer

CMZ01 **P** **M** **K**



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)	
		ØD	ød	L	L ₁			
Straight shank	-012-G20-SP12-01	△	12	20	100	40	1	0.2
	-025-G25-SP12-02	△	25	25	120	40	2	0.8
	-032-G32-SP12-03	△	32	32	180	40	3	1.1
Weldon shank	-012-XP20-SP12-01	△	12	20	100	40	1	0.2
	-025-XP25-SP12-02	△	25	25	120	40	2	0.6
	-032-XP32-SP12-03	△	32	32	180	40	3	1.0

▲Stock available △Make-to-order

Indexable milling tools

Chamfer milling

Spare parts

Diameter ØD	Screw	Wrench	
	Ø12-Ø32	I43M5×11	

Tools code key **B24-B25**

Grade selection guide **B19-B23**

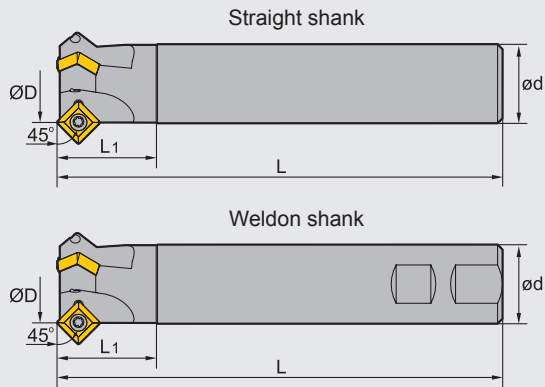
Technical data **B234-B240**

Chamfer milling

Kr:45°



CMA01 P M K



Specification of tools

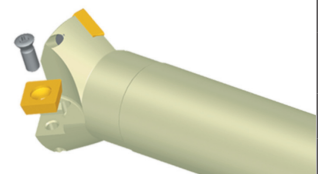
Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
		ØD	ød	L	L ₁		
Straight shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.8
	▲	32	32	180	40	3	1.1
Weldon shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.6
	▲	32	32	180	40	3	1.0

▲Stock available △Make-to-order

Indexable milling tools
Chamfer milling

Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø32	I43M5×11	WT20IS



Tools code key
B24-B25

Grade selection guide
B19-B23

Technical data
B234-B240

Chamfer milling tools

Kr:60°



Chamfering



Face milling

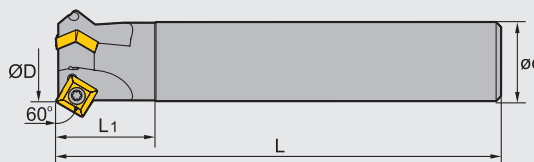


Hole stomata chamfer

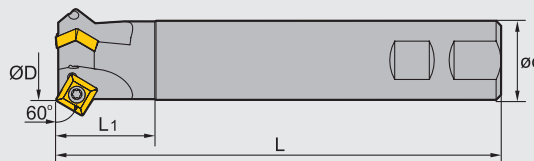
CMD01 P M K



Straight shank



Weldon shank



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
		ØD	ød	L	L ₁		
Straight shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.8
	▲	36	32	180	40	3	1.0
Straight shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.6
	▲	36	32	180	40	3	1.0

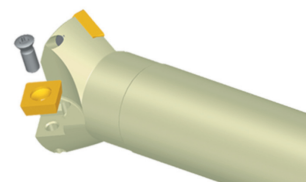
▲Stock available △Make-to-order

Indexable milling tools

Chamfer milling tools

Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø36	I43M5×11	WT20IS

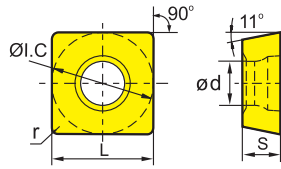


Tools code key → B24-B25

Grade selection guide → B19-B23

Technical data → B234-B240

Selection of inserts



😊 Good working condition 🙄 Normal working condition 😞 Bad working condition

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, Ti alloy
Steel	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Stainless steel	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Cast iron	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Non-ferrous metal	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Heat resistant alloy, Ti alloy	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊

Insert shape	Type	Basic dimensions(mm)					CVD Coating				PVD Coating				Cermet	Cemented carbide														
		ØI.C	L	r	S	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201		
	SPMT120408	12.7	12.7	0.8	4.76	5.5	●		●	●								★												

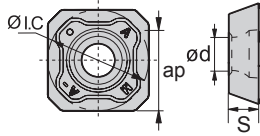
★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters		
			Cutting speed(m/min)	Feed speed(mm/z)	
P Low-carbon steel, Soft steel	≤ 180	YBM251 YBC301	180(100-250)	0.25 (0.1-0.4)	
		YBM351 YBG302	150(100-200)	0.3 (0.1-0.5)	
		YC30S	120(80-150)	0.4 (0.1-0.5)	
	High-carbon steel, Alloy steel	180-280	YBM251 YBC301	160(100-220)	0.3 (0.1-0.4)
			YBM351 YBG302	130(100-180)	0.3 (0.1-0.5)
			YC30S	100(60-150)	0.4 (0.1-0.5)
	Alloy tool steel	280-350	YBM251 YBC301	120(80-180)	0.3 (0.1-0.4)
			YBM351 YBG302	100(80-150)	0.3 (0.1-0.5)
			YC30S	80(60-120)	0.4 (0.1-0.5)
M Stainless steel	≤ 270	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)	
		YBM351 YBG302	100(80-150)	0.3 (0.1-0.5)	
		YC30S	80(60-120)	0.4 (0.1-0.5)	
K Cast iron	180-250	YBG302	130(100-180)	0.4 (0.1-0.5)	

Indexable milling tools
Chamfer milling tools

SE □ □



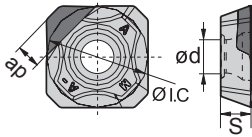
😊 Good working condition ☹️ Normal working condition 😞 Bad working condition

Workpiece material			
K Cast iron		😊	😞
N Non ferrous metal	☹️		☹️

Insert shape	Type	Basic dimensions(mm)				PCD	PCBN	Cemented carbide
		ØI.C	S	ød	apmax			
	SEHT12T3AFFN-AL	12.7	3.97	4.4	6.6	DN1021	BK1021	YD201

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

SE □ □



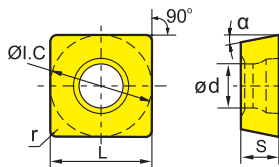
😊 Good working condition ☹️ Normal working condition 😞 Bad working condition

Workpiece material			
K Cast iron		😊	😞
N Non ferrous metal	☹️		☹️

Insert shape	Type	Basic dimensions(mm)				PCD	PCBN	Cemented carbide
		ØI.C	S	ød	apmax			
	SEHT12T308AFFN-PCD	12.7	3.97	4.4	2.5	★		YD201
	SEHT12T308AFFN-CBN	12.7	3.97	4.4	2		○	

CBN insert edge can be treated as per machining requirements ★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

SP □ □



😊 Good working condition ☹️ Normal working condition 😞 Bad working condition

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, Ti alloy												
	😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊😊												

Insert shape	Type	Basic dimensions(mm)						CVD Coating						PVD Coating						Cermet	Cemented carbide								
		r	L	ØI.C	S	ød	α	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302			YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051
	SPMT060304	0.4	6.35	6.35	3.18	2.8	11°												○										
	SPMT120408	0.8	12.7	12.70	4.76	5.5	11°	●	●	●								★							○				
	SPMT120408-PM	0.8	12.7	12.70	4.76	5.5	11°			★								●											
	SPMT120408-KM	0.8	12.7	12.70	4.76	5.5	11°											●	○										
	SPKT1204EDR	--	12.7	12.7	4.76	5.56	11°								★														

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order