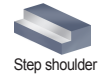
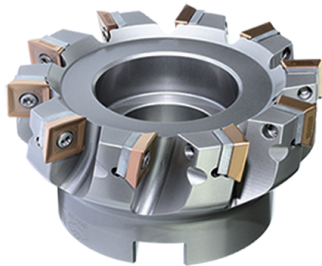


Face milling tools

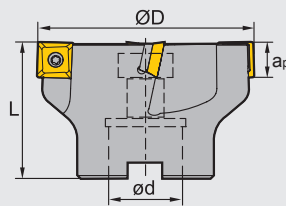
Kr:90°



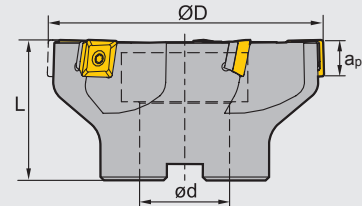
FMP02 P M K S



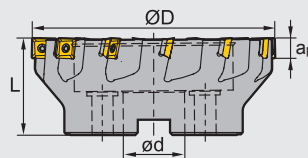
A-type coupling



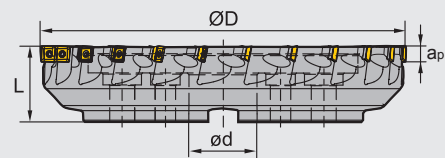
B-type coupling



C-type coupling



D-type coupling



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Type of coupling	Weight (kg)
		$\varnothing D$	$\varnothing d$	L	a_{pmax}			
FMP02 -040-A16-SE09-04	△	40	16	40	6.7	4	A	0.2
-040-A16-SE09-06	△	40	16	40	6.7	6	A	0.22
-050-A22-SE09-05	▲	50	22	40	6.7	5	A	0.3
-050-A22-SE09-07	△	50	22	40	6.7	7	A	0.313
-063-A22-SE09-06	▲	63	22	40	6.7	6	A	0.5
-063-A22-SE09-08	△	63	22	40	6.7	8	A	0.479
-080-A27-SE09-08	▲	80	27	50	6.7	8	A	0.9
-080-A27-SE09-10	△	80	27	50	6.7	10	A	1.079
-100-B32-SE09-08	▲	100	32	50	6.7	8	B	1.7
-100-B32-SE09-10	△	100	32	50	6.7	10	B	1.7
-125-B40-SE09-12	△	125	40	63	6.7	12	B	2.6

▲ Stock available △ Make-to-order

Indexable milling tools

Face milling tools






Specification of tools

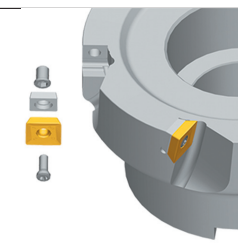
Type	Stock	Basic dimensions(mm)				Number of teeth Z	Type of coupling	Weight (kg)
		ØD	ød	L	apmax			
FMP02 -050-A22-SE12-03	▲	50	22	40	10.8	3	A	0.3
-063-A22-SE12-04	▲	63	22	40	10.8	4	A	0.4
-080-A27-SE12-04	▲	80	27	50	10.8	4	A	0.9
-100-B32-SE12-05	▲	100	32	50	10.8	5	B	1.2
-125-B40-SE12-06	▲	125	40	63	10.8	6	B	3.1
-160-C40-SE12-08	▲	160	40	63	10.8	8	C	4.1
-200-C60-SE12-10	△	200	60	63	10.8	10	C	5.718
-250-C60-SE12-12	▲	250	60	63	10.8	12	C	11.1
-050-A22-SE12-04	▲	50	22	40	10.8	4	A	0.3
-063-A22-SE12-05	▲	63	22	40	10.8	5	A	0.4
-080-A27-SE12-06	▲	80	27	50	10.8	6	A	0.8
-100-B32-SE12-07	▲	100	32	50	10.8	7	B	1.2
-125-B40-SE12-08	▲	125	40	63	10.8	8	B	3.0
-160-C40-SE12-12	▲	160	40	63	10.8	12	C	3.9
-050-A22-SE12-05	▲	50	22	40	10.8	5	A	0.2
-063-A22-SE12-06	▲	63	22	40	10.8	6	A	0.4
-080-A27-SE12-08	▲	80	27	50	10.8	8	A	0.8
-100-B32-SE12-10	▲	100	32	50	10.8	10	B	1.2
-125-B40-SE12-12	▲	125	40	63	10.8	12	B	2.9
-160-C40-SE12-15	△	160	40	63	10.8	15	C	4.061
-200-C60-SE12-16	▲	200	60	63	10.8	16	C	6.1
-250-C60-SE12-18	▲	250	60	63	10.8	18	C	10.9
-315-D60-SE12-24	▲	315	60	63	10.8	24	D	21.6

▲Stock available △Make-to-order

Indexable milling tools
Face milling tools

Spare parts

Diameter ØD	Inserts	Shim	Insert screw	Shim screw	Wrench	Wrench
						
Ø50 ~ Ø125	SE09	--	I60M3×7	--	WT09IS	--
Ø50	SE12	--	I60M3.5×10	--	WT15IS	--
Ø63 ~ Ø315		S12BSX	I60M3.5×12	SM5×7×A		WH35L



Tools code key
B24-B25

Grade selection guide
B19-B23

Technical data
B234-B240



Features of

FMP02

Series Milling Tools



Inserts designed with new geometries and coated grades for optimized high efficiency machining in different working conditions.



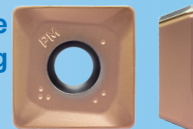
Unique geometric design resulting in true 90° square shoulder cutting.



Upgraded insert structure, greatly improves tool life.



Large positive rake angle resulting in easier cutting with less tool pressure.



Screw down clamping resulting in better chip evacuation.

➤ Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters				
			Vc(m/min)	fz(mm/z)			
				-APF	-APM	-APR	
P Low-carbon steel, Soft steel	≤ 180	YBG202	270(200-360)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
		YB9320	270(200-360)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
	High-carbon steel, Alloy steel	180-280	YBM351	240 (200-320)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)
			YBG202	240 (180-350)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)
			YB9320	240 (180-350)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)
	Alloy tool steel	280-350	YBM351	220 (180-300)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)
YBG202			220 (170-340)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
YB9320			220 (170-340)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
M Stainless steel	≤ 270	YBM351	150 (120-240)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
		YBG202	160 (110-270)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
		YB9320	160 (110-270)	0.1(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
K Cast iron	180-250	YBG202	160 (120-200)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
		YBD152	270 (150-300)	0.15(0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	
S Difficult-to-machine materials	≤ 400	YBS303	100 (60-120)	0.1(0.08-0.2)	0.15 (0.1-0.25)	--	

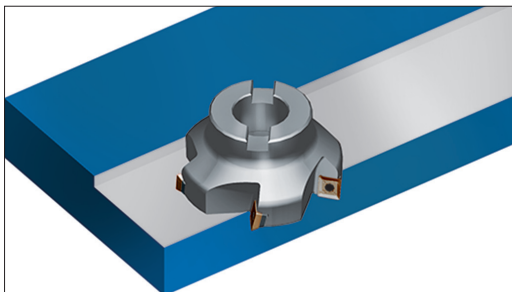
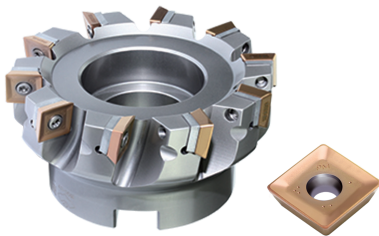
Indexable milling tools

Face milling tools

Case for FMP02

Workpiece material: 45#
 Hardness: 175-190 (HB)
 Cooling: Air cooling
 Tool: FMP02-100-B32-SE12-10
 Insert: SEET120308PER-APM (YB9320)
 Data:

Data 1: Vc=200m/min, fz=0.15mm/z,
 Ap=7mm, Ae=5mm
 Data 2: Vc=200m/min, fz=0.25mm/z,
 Ap=7mm, Ae=5mm



● SEET120308PER-APM inserts tests

Chipbreaker	Data 1: Vc=200m/min, fz=0.15mm/z Ap=7mm, Ae=5mm		Data 2: Vc=200m/min, fz=0.25mm/z Ap=7mm, Ae=5mm	
	Runout value	Surface machined	Runout value	Surface machined
-APM	0.006		0.006	
Products of company A	0.012		0.012	
Products of company B	0.013		0.015	



-APM



Product of company B

Results:

Comparing with competitors, SEET120308PER-APM inserts can get better surface quality and longer tool life.