

➤ 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)	--

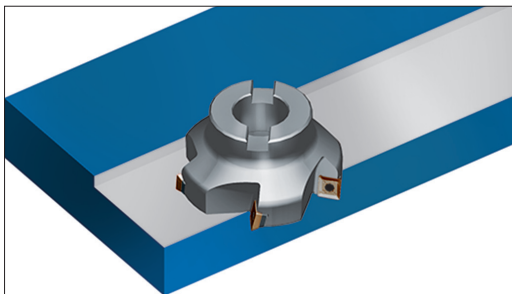
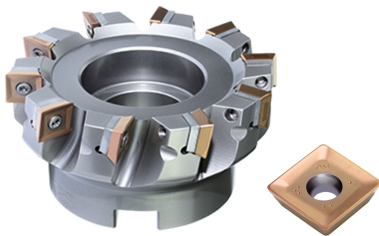
Indexable milling tools

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.