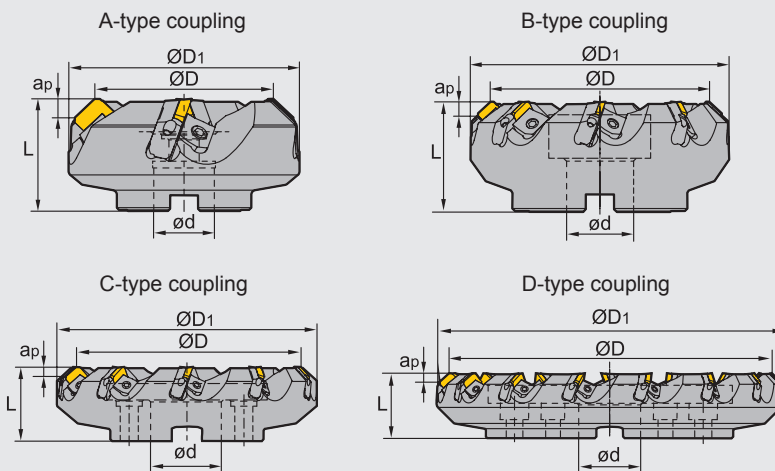


Face milling tools

Kr:45°



FMA03 P M K



Specification of tools

Type	Stock		Basic dimensions(mm)					Number of teeth Z	Type of coupling	Weight (kg)
	R	L	ØD	ØD ₁	ød	L	ap _{max}			
FMA03 -080-A27-SE12-04	▲	△	80	103	27	50	5.5	4	A	1.8
-100-B32-SE12-05	▲	△	100	122	32	50	5.5	5	B	2.4
-125-B40-SE12-06	▲	△	125	147	40	63	5.5	6	B	4.4
-160-B40-SE12-08	▲	△	160	181	40	63	5.5	8	B	6.4
-200-C60-SE12-10	▲	△	200	221	60	63	5.5	10	C	8.5
-250-C60-SE12-12	▲	△	250	270	60	63	5.5	12	C	14.1
-315-D60-SE12-15	▲	△	315	353	60	63	5.5	15	D	22.2
-080-A27-SE15-04	▲	△	80	103	27	50	7.5	4	A	1.7
-100-B32-SE15-05	▲	△	100	122	32	50	7.5	5	B	2.3
-125-B40-SE15-06	▲	△	125	147	40	63	7.5	6	B	4.2
-160-B40-SE15-08	▲	△	160	181	40	63	7.5	8	B	6.1
-200-C60-SE15-10	▲	△	200	221	60	63	7.5	10	C	8.3
-250-C60-SE15-12	▲	△	250	270	60	63	7.5	12	C	13.6
-315-D60-SE15-15	▲	△	315	353	60	63	7.5	15	D	21.8

▲ Stock available △ Make-to-order

Spare parts

Diameter ØD	Inserts	Locator	Wedge	Wedge screw	Locator screw	Wrench
Ø80-Ø315	SE12	LSE12R/L	W05R/L	DM8×21X	LOM5×15.1	WT20T WH40T
Ø80-Ø315	SE15	LSE15R/L	W01R/L			

Tools code key → B24-B25

Grade selection guide → B19-B23

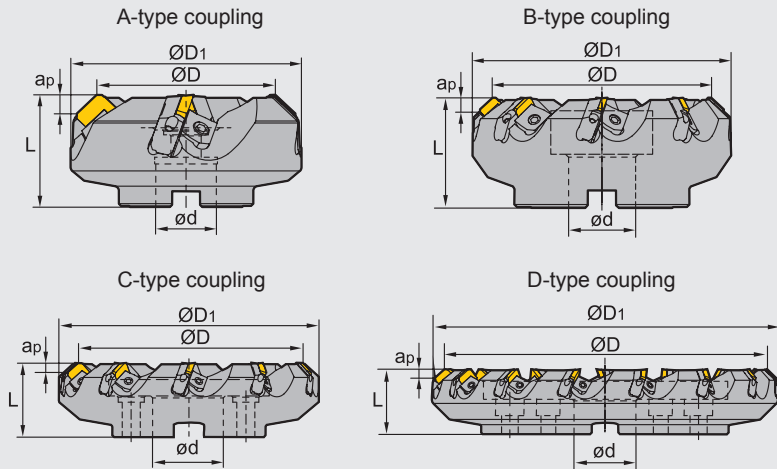
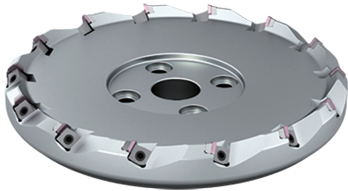
Technical data → B234-B240

Face milling tools

Kr:45°



FMA03A P M K



Specification of tools

Type	Stock		Basic dimensions(mm)						Number of teeth Z	Type of coupling	Weight (kg)
	R	L	ØD	ØD ₁	ød	L	apmax				
FMA03A -160-B2.00"-SE12-08R/L	▲	△	160	177	2.00"	63	5.5	8	B	6.9	
-200-C1.875"-SE12-10R/L	▲	△	200	217	1.875"	63	5.5	10	C	9.1	
-250-C1.875"-SE12-12R/L	▲	△	250	267	1.875"	63	5.5	12	C	14.6	
-315-C1.875"-SE12-14R/L	▲	△	315	332	1.875"	63	5.5	14	C	22.7	
-350-C1.875"-SE12-16R/L	▲	△	350	367	1.875"	63	5.5	16	C	28.9	
-250-C1.875"-SE15-12R/L	▲	△	250	267	1.875"	63	7.5	12	C	7.3	
-315-C1.875"-SE15-14R/L	▲	△	315	340	1.875"	63	7.5	14	C	9.5	
-350-C1.875"-SE15-16R/L	▲	△	350	370	1.875"	63	7.5	16	C	15.1	

▲Stock available △Make-to-order

1.875"=47.625mm 2.00"=50.8mm

Cutter diameter Insert type Left cutter
FMA03A - 160 - B2.00" - SE12 - 08R/L
 Cutter type Coupling type Right cutter

Spare parts

Diameter ØD	Inserts	Shim	Wedge	Wedge screw	Insert screw	Wrench
Ø160-Ø350	SE□□12□□□□ SE□□15□□□□	S15BSX	W27R/L	DM10X21X	M4X10-S12B	WH50T

Tools code key
B24-B25

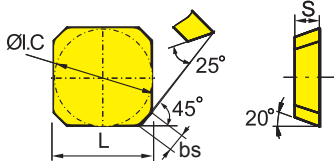
Grade selection guide
B19-B23

Technical data
B234-B240

Indexable milling tools

Face milling tools

Selection of inserts



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201	
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							
		L	Ø.C	S	bs	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SEEN1203AFTN	12.7	12.7	3.18	1.8								○									●					
	SEKN1203AFFN	12.7	12.7	3.18	1.8							★															
	SEKN1203AFN	12.7	12.7	3.18	1.8	●							○											●		○	
	SEKN1203AFTN	12.7	12.7	3.18	1.8	●	●	●				★		○										●		●	
	SEKR1203AFN	12.7	12.7	3.18	1.8	●							○		○												
	SEMR1203AN-M	12.7	12.7	3.3	-									●													
	SEKR1203AN-M	12.7	12.7	3.3	-										●												
	SEKN1504AFN	15.875	15.875	4.76	1.6	●	●																		●		
	SEKN1504AFTN	15.875	15.875	4.76	1.6	○	●	●						○										●		●	
	SEKR1504AFN	15.875	15.875	4.76	1.6												★						●				
	SEMR1504AN-M	15.875	15.875	4.9	-									●													
	SEKR1504AN-M	15.875	15.875	4.9	-										●												

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

Indexable milling tools
Face milling tools

➤ Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters		
			V _c (m/min)	f _z (mm/z)	
P	Low-carbon steel, Soft steel	YNG151	430 (340-500)	0.2 (0.1-0.4)	
		YBM251 YBC301 YBG205	270 (220-350)	0.2 (0.1-0.4)	
		YBM351	220 (180-300)	0.25 (0.15-0.3)	
		YBG202 YBG302	270 (200-360)	0.2 (0.1-0.3)	
		YC30S	140 (100-220)	0.27 (0.1-0.4)	
	High-carbon steel, Alloy steel	180-280	YNG151	400 (320-480)	0.2 (0.1-0.4)
			YBM251 YBC301 YBG205	240 (200-320)	0.2 (0.1-0.4)
			YBM351	200 (160-280)	0.25 (0.15-0.3)
			YBG202 YBG302	240 (180-350)	0.2 (0.1-0.3)
			YC30S	120 (80-200)	0.27 (0.1-0.4)
	Alloy tool steel	280-350	YNG151	350 (300-450)	0.2 (0.1-0.4)
			YBM251 YBC301 YBG205	220 (180-300)	0.2 (0.1-0.4)
			YBM351	180 (150-250)	0.25 (0.15-0.3)
			YBG202 YBG302	220 (170-340)	0.2 (0.1-0.3)
			YC30S	100 (60-180)	0.27 (0.1-0.4)
M	Stainless steel	YNG151	220 (160-280)	0.2 (0.1-0.4)	
		YBM251 YBG205	130 (100-220)	0.2 (0.1-0.4)	
		YBM351	140 (100-240)	0.25 (0.15-0.3)	
		YBG202 YBG302	140 (100-250)	0.2 (0.1-0.3)	
		YBG102	210 (120-300)	0.2 (0.1-0.3)	
K	Cast iron	YBD252	200 (150-250)	0.2 (0.1-0.4)	
		YD201	100 (80-160)	0.25 (0.1-0.4)	