

Milling Tools

Indexable milling tools





FMA12 series

High Performance Face Mill with 16 edges for outstanding economy





Milling

Indexable Milling Tools • B1-B216
Indexable milling tools B3-B177
Indexable milling inserts B178-B209
Technical information B210-B216

Solid Carbide End Mills B217-B480
Solid carbide end mills B217-B476
Technical information B477-B480





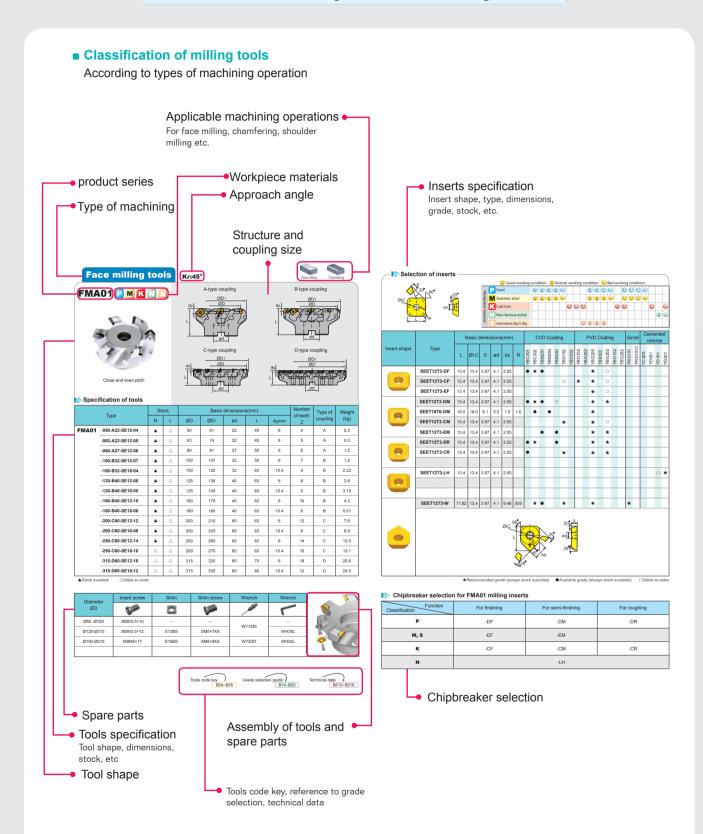






How to choose the right indexable milling tools

How to choose the right indexable milling tools

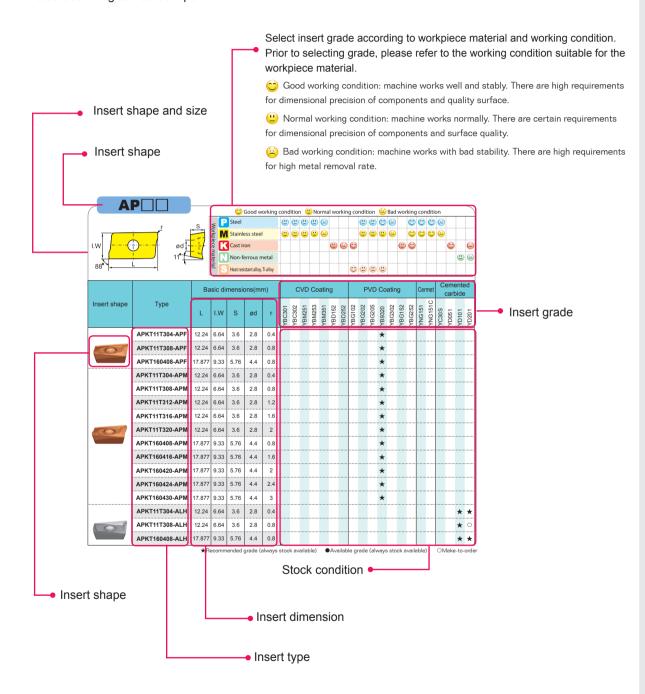


How to choose indexable milling inserts

How to choose indexable milling inserts

■ Detailed information for indexable milling inserts

Listed according to insert shape



MILLING

Indexable Milling Tools

Indexable milling tools family

Indexable milling tools overview

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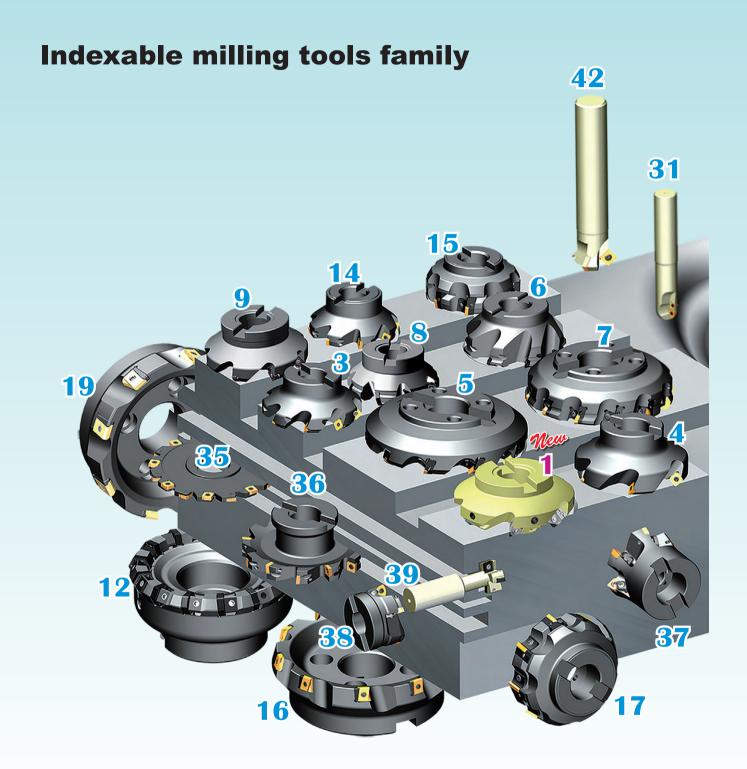
B173-B177 Chamfer milling tool series

B178-B179 Indexable milling inserts overview

B180-B181 Indexable milling inserts code key

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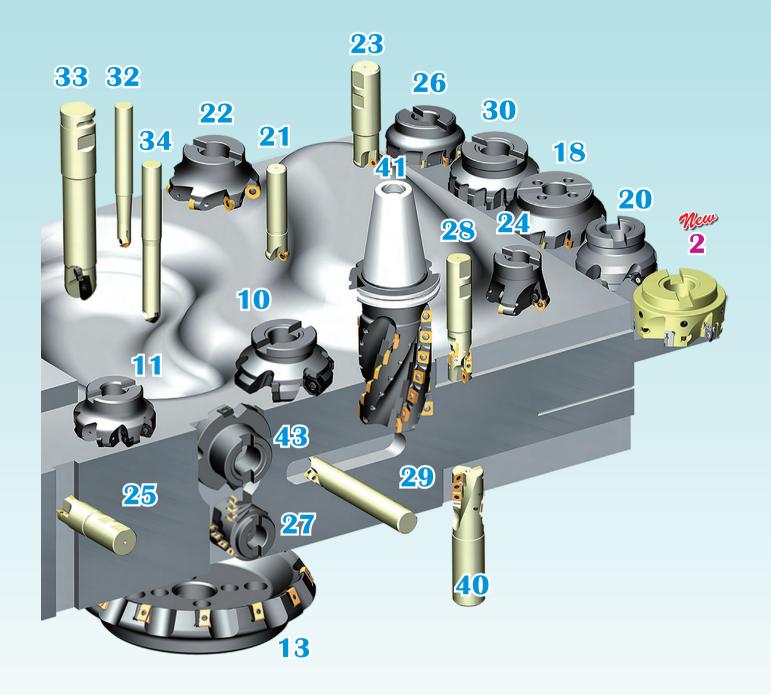
B210-B216 Technical information



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Number	Number Tool category	
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Heavy mill cutter series
FMD03 FME04 FMP03

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
High-speed high-precision milling tools	AMA01 Allew	Kr=45° a _p max=6.6	SEHT12T3AFFN-AL		
		Kr=45° a _{pmax} =2.0	SEHT12T308AFFN-CBN		
d high-	B27	Kr=45° a _p max=2.5	SEHT12T308AFFN-PCD	High-speed high-	Diameter range Ø50-Ø500 Aluminum alloy body with high strength, light weight Unique tool clamping design
precis	AMP01	Kr=90° a _p max=12	APHT12T304PPFR-AL	of Aluminum alloy, alloy steel, cast iron,	Elastic runout adjustment structure, high pressure internal cooling, and high-precision cutting inserts enable high-quality, high-
ion mi		Kr=90° a _p max=1.0	APHT12T304-W	hardened steel.	precision, high-efficiency, and high-stability machining of various materials.
ling to		Kr=90° a _p max=2.0	APHT12T304PPFR-CBN		
ols	B29	Kr=90° a _p max=3.0	APHT12T304PPFR-PCD		
	FMA01	Kr=45° a _p max=6.0	SEET12T3-DF/DM/DR SEET12T3-CF/CM/CR SEET12T3-EF/EM SEET12T3-LH/W	General face milling of the following materials: steel, alloy steel, stainless steel, cast iron, aluminum alloy,	Diameter range Ø50-Ø315. Large rake angle makes cutting easier and faster. Wide applications can be achieved by using available inserts with different chipbreakers.
	B31	Kr=45° a _p max=10.4	SEET18T6-DM	high-temperature alloy	Adopting inserts with wiper can improve surface quality.
	FMA02	Kr=45° a _p max =6.0	SEET12T3-DF/DM/DR SEET12T3-CF/CM/CR SEET12T3-EF/EM SEET12T3-LH/W	General face milling of the following materials: steel, alloy steel, stainless steel, cast iron, aluminum alloy, high-temperature alloy	 Diameter range Ø50-Ø125. Large rake angle makes cutting easier and faster. Wide applications can be achieved by using available inserts with different chipbreakers. Coarse and differential pitch, reducing vibration.
	FMA03	Kr=45° a _p max=5.5	SE□N1203AF□□ SE□R1203AF□□	General face milling of steel, stainless steel,	Diameter range Ø80-Ø315. large rake angle makes cutting easier and faster.
Face	B36	Kr=45° a _p max=7.5	SE□N1504AF□□ SE□R1504AF□□	cast iron	Top clamping achieves better vibration resistance.
e milling	FMA04	Kr=45° a _{pmax} =3.5	OFKT05T3-DF/DM OFKT05T3-LH	Face milling of steel, alloy steel, cast iron, aluminum alloy	Diameter range Ø50-Ø160. High-economy milling tool with 8 cutting edges. Screw clamping, high precision.
	F F P P P P B 43	Kr=45° a _p max =5.0	OFKR0704-DF/DM	Face milling of steel, alloy steel and cast iron	Diameter range Ø125-Ø315. High-economy milling tool with 8 cutting edges. Top clamping makes it easy to assemble and disassemble.
	FMA07	Kr=45° a _{pmax} =4.0	ONHU060408-PF/PM/W	General face milling of steel and cast iron	Diameter range Ø25-Ø50. High-economy milling tool with 16 cutting edges.
	6 B47	Kr=45° a _{pmax} =5.0	ONHU08T508-PF/PM/W	General face milling of steel and cast iron	Diameter range Ø50-Ø315. High-economy milling tool with 16 cutting edges.

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
	FMA11	Kr=45° a _p max=5.5	SNEG1205ANR-GM/HGR/W		Diameter range Ø63- Ø315. Double-sided chipbreaker milling insert has eight cutting edges and high economy. Large rake angle design and unique chip
		Kr=45° a _p max=7.0	SNEG1506ANR-GM/HGR/W	General face milling of steel and cast iron	breaker structure of insert lead to low power consumption. Double negative rake angle structure and super thick insert has higher safety and outstanding toughness, which can realize
	B52-B53	Kr=45° a _p max=9.0	SNEG1907ANR-HGR		outstanding toughness, which can realize great depth cutting. Insert has excellent machining performance with wiper edge.
	FMA12	Kr=45° a _{pmax} =5.0	ONHU08T624R-GM	General face milling of steel and cast iron	Diameter rangeØ80-Ø315. Igh Performance Face Mill with 16 edges for outstanding economy. Double negative rake angle, in combination with helical insert structure, achieves double positive axial angle, which will help reduce cutting resistance and improve chip evacuation. Unique 3-dimentional edge.
	FMD02	Kr=67° a _p max=5.0~7.5	PNEG110512R/L-CF/ CM/CR PNEG110512R/L-PF/ PM/PR	General face milling of steel and cast iron	Diameter range Ø50-Ø315. High-economy milling tool with 10 cutting edges.
Face milling	B64	Kr=55° a _{pmax} =6.0	HNEX090512-DF/DM HNEX090512-DR	Face milling of cast iron	Diameter range Ø80-Ø315. High-economy milling tool with 12 cutting edges. Top clamping makes it easy to assemble and disassemble.
В	Kr=60°	Kr=60° a _p max=12.0	LNKT2007DN-ZR	Heavy-duty face milling of steel and alloy steel	Diameter range Ø125-Ø400. Double positive rake angles can reduce cutting forces.
		Kr=60° a _p max=17.0	LNKT2510-ZR		 Inserts are mounted upright, suitable for heavy machining with high cutting depth. Easy to assemble and clamp inserts.
	FME02	Kr=75° a _p max=6.0	SPKW1204EDFR SPKW1204EDSR SPKT1204EDR	Face milling of steel, alloy steel and cast iron	 Diameter range Ø50-Ø125. Kr 75°, general face milling. Wide applications can be achieved by using inserts with different chipbreakers.
	FME03	Kr=75° a _p max=6.0	SP□N1203(1504)ED□□ SP□R1203(1504)ED□□	Face milling of steel,	 Diameter range Ø80-Ø315. Kr 75°, general face milling.
	B71	Kr=75° a _p max=8.0	SP□N1504ED□□ SP□R1504ED□□	alloy steel and cast iron	Top clamping makes it easy to assemble and disassemble.

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
	FME04 B75	Kr=75° a _p max=12.0	LNKT1506EN-ZR	Heavy-duty face milling of steel and alloy steel	Diameter range Ø125-Ø315. Double positive rake angles can reduce the cutting force. Inserts are mounted upright, suitable for heavy machining at high cutting depth. Easy to assemble and clamp inserts.
	FMP01	Kr=90° a _p max=18.0	TP□N2204PD□ TPKN2204PDF□ TPKN2204PDT□	Face milling of steel, alloy steel and cast iron	Diameter range Ø80-Ø315. Kr 90°, for square shoulder milling. Top clamping makes it easy to assemble and disassemble.
	FMP02	Kr=90° a _p max=6.7	SEET09T308PER-APF/APM SEET09T308PER-APR	Face milling of steel, alloy steel, stainless	 Diameter range Ø50-Ø315. Kr 90°, for square shoulder milling. Different pitches: coarse pitch, close pitch and extra close pitch. High precision insert, high work-piece
	B79	Kr=90° a _p max=10.8	SEET120308PER-APF/APM SEET120308PER-APR	steel and cast iron	surface quality. Optimized chipbreaker and grade, suitable for finishing, semi-finishing and roughing.
	FMP03	Kr=90° a _p max=13.0	LNKT1506EN-ZR		Diameter range Ø125-Ø315.
	B85	Kr=90° a _p max=17.0	LNKT2007DN-ZR	Heavy-duty face milling of steel and	Double positive rake angles can reduce the cutting force. Inserts are mounted upright, suitable for heavy machining at high cutting depth. Easy to assemble and clamp inserts.
Face		Kr=90° a _p max=22.0	LNKT2510-ZR	alloy steel	
Face milling	FMP12	Kr=90° a _p max=5.7	WNHU060404PNR-GM WNHU060408PNR-GM		Diameter range Ø50-Ø315 90° approach angle can be used for shoulder milling, face milling, groove
		Kr=90° a _p max=7.7	WNHU080608PNR-GM WNHU080616PNR-GM	Steel, alloy steel,	milling, etc.; -Six-flute double-sided groove milling inserts with wiper for large feed machining; double negative angle of the tool body combined with unique insert structure to achieve double positive tool angle, reducing cutting forces.
	FMP12	Kr=90° a _p max=5.7	WNHU060404PNR-GM WNHU060408PNR-GM	cast iron	Diameter range Ø25-Ø50 one of the process of the second
	FMR01	a _p max=5.0	RCKT10T3MO-DM	Cavity profile milling of steel, alloy steel,	Diameter range Ø25-Ø50. R-type inserts have extra-strong cutting edges. Suitable for machining of curved surface
	B91	а _р тах=6.0	RCKT1204MO-DM/DR/ER	stainless steel and cast iron	of die. • Economical milling tools with screw clamping.
	FMR02	a _p max=6.0	RCKT1204MO-DM/DR /ER/PCBN		Diameter range Ø50-Ø160. R-type inserts have extra-strong cutting
		a _p max=8.0	RCKT1606MO-DM/DR/ER	Face milling and cavity profile milling of steel, alloy steel, stainless steel and cast iron	edges. • Suitable for machining of curved surface of die.
	B94	a _p max=10.0	RCKT2006MO-DR/ER		Economical milling tools with screw clamping.

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MILLING (Indexable Milling Tools

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
	FMR03	a _p max=4.0	RDKW0803MO		• Diameter range Ø16-Ø50.
		a _p max=5.0	RDKW10T3MO	Cavity profile milling of steel, alloy steel, stainless steel and cast iron	R-type inserts have extra-strong cutting edges. Suitable for machining of curved surface of die.
	B97	a _p max=6.0	RDKW1204MO		Economical milling tools with screw clamping.
	FMR04	a _p max=6.0	RDKW1204MO	Face milling and	Diameter range Ø50-Ø160.
Face milling		a _p max=8.0	RDKW1605MO	cavity profile milling of steel, alloy steel, stainless steel and	R-type inserts have extra-strong cutting edges. Suitable for machining of curved surface
lling	B99	а _р мах=10.0	RDKW2006MO	cast iron	of die.
	EMP01	Kr=90° a _p max=10.5	APKT11T3□□-APF/APM APKT11T3□□-ALH	Multi-function milling of steel, alloy steel, stainless steel, cast	Two mounting styles: Straight shank and Weldon shank, diameter range Ø12-Ø63. Kr 90°, for square shoulder milling, slot milling, ramp milling, etc.
	B102-103	Kr=90° a _p max=15.5	APKT160408- APF/PM APKT160408-ALH	iron and aluminum alloy	Inserts with wiper, also suitable for face milling. Inserts with 3D helical cutting edge, less cutting force.
	EMP02	Kr=90° a _p max=11.5	APKT11T3□□- APF/APM APKT11T3□□-ALH	Face milling of steel,	Diameter range Ø50-Ø160. Kr 90°, for square shoulder milling, slot
	B109	Kr=90° a _p max=15.5	APKT160408- APF/APM APKT160408-ALH	alloy steel, stainless steel, cast iron and aluminum alloy	milling, ramp milling, etc. Inserts with wiper, also suitable for face milling. Inserts with 3D helical cutting edge, less cutting force.
Square shoulder milling	EMP03 B112	Kr=90° a _p max=39.0	APKT11T3□□-APF/APM APKT11T3□□-ALH	Milling of steel, alloy steel, stainless steel, cast iron and aluminum alloy at high cutting depth	 Diameter range Ø50-Ø100. End mills with positive helical angle, good chip removal. For side face milling and slot machining. Close pitch, high machining efficiency.
er milling	EMP04 B113	Kr=90° a _{pmax} =29.4~58.0	APKT11T3□□-APF/APM APKT11T3□□-ALH	Multi-function drilling and milling of steel alloy steel, stainless steel and cast iron	 Diameter range Ø20-Ø40. End mills with positive helical angle, good chip removal. For side face milling and slot machining. Close pitch, high machining efficiency.
	EMP05 B117	Kr=90° a _p max=20~40	APMT1135PDR APMT160408PDER	Face milling of steel, alloy steel, stainless steel, cast iron and Al alloy	 Diameter range Ø25-Ø40. End edge over center, for drilling directly.

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features	
	EMP13	Kr=90° a _p max=11.2	ANGX1105□□PNR-GM/ LH			
Square s	B121	Kr=90° a _p max=14.5	ANGX1506□□PNR- GM/LH	Multi-functional milling of steel, alloy steel,	 Diameter range Ø25-Ø160. Designed with extra thick insert in combination with double negative tool body, achieving double positive cutting angle, reducing cutting force, as well as 	
Square shoulder milling	B122	Kr=90° a _p max=43~64	ANGX1105□□PNR-GM/ LH	stainless steel and cast iron	greatly improving impact resistance. • Properly designed cutting edge with high precision control can achieve high quality 90°square shoulder milling.	
Q	B123	Kr=90° a _p max=43~53	ANGX1506□□PNR- GM/LH			
	BMR01	Cutting depth: see the detailed	ZDET□□CYR□□ ZPNT2204CYR□□ SPMT060304 SDMT□□	Profile machining of steel, stainless steel and cast iron	 Diameter range Ø20-Ø63. Very suitable for rough machining large mold. Ball nose cutter with 3-cutting-edge inserts, perfect economical efficiency. 	
	BMR02	information about tool specifications	ROHX□□	Profile machining of steel, stainless steel and cast iron	Diameter range Ø12-Ø20. For profile finish machining. Stable assembly. Insert with two cutting edges, perfect economical efficiency.	
Profile milling	BMR03					
	B130	Cutting depth: see the detailed information about tool specifications	depth: see the detailed information about tool	XPHT□□R□□- GM	Profile machining of steel, stainless steel and cast iron	 Diameter range Ø16-Ø50. For profile finish machining. Stable assembly. Insert with two cutting edges, perfect economical efficiency.
	B131					
	B132					

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MILLING (Indexable Milling Tools

Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
	BMR04				
Profile milling	B141	Cutting depth: see the detailed information about tool specifications	ZOHX□□	Profile machining of steel, stainless steel and cast iron	 Diameter range Ø12-Ø32. High precision, for finish profile machining Two types of chipbreaker, used in different machining conditions. High assembling precision, good stability.
Side and	SMP01 B148	Cutting depth: see the detailed	XSEQ12□□	Slot milling of steel, stainless steel and cast iron	 Diameter range Ø63-Ø250. Two mounting styles: mounting by keyway and arbor mounting. Groove width range: 8, 10, 12, 16, 18, 20mm.
Side and face milling	B151	information about tool specifications	MPHT□□	Slot milling of steel, stainless steel and cast iron	 Diameter range Ø80-Ø200. Two mounting styles: mounting by keyway and arbor mounting. Groove width range: 8, 10, 12, 16, 18, 20mm.
	XMR01				
Special millir	B154	Cutting depth: see the detailed	SDMT□□-DM/PM	Slot milling of steel, stainless steel and cast iron	 Diameter range Ø20-Ø160. Two mounting types: straight shank and arbor mounting. Cutting forces are resolved effectively, achieving cutting with high feed rate. For plunge milling. Double clamping, firm and reliable.
Special milling (high feed)	B157	information about tool specifications	WPGT□□ZSR WPGT□□ZSR-PM	Face and cavity profile milling of steel, stainless steel and cast iron in cavity applications	 Diameter range Ø20-Ø160. Two mounting types: straight shank and arbor mounting. Cutting forces are resolved effectively, achieving cutting with high feed rate. Double clamping, firm and reliable.

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Operating pattern	Series/Shape	Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
Boring millers	XMP01 B164	Kr=90° ap _{max} =18~36	CNE121006A/B	Flat Milling, Side Milling, Flute Milling, and Bored Hole-making for Steel/ Alloy Steel/ Cast Iron.	Diameter range Ø80-Ø400. Inserts are vertically loaded with 90 degrees approach angle. Both axial and radical cutting width could be adjusted according to customers' demands. Opened chip pocket, which lead to unobstructed chip removal. It has large width of bottom edges, which helps to strengthen the capability of helical interpolation milling holes. It is generally loaded inserts for two kinds chipbreaker, while fits for different machining conditions.
T-slot milling	TMP01 B166	Kr=90°	MPHT□□	Machining T slot in cast iron	 Diameter range Ø21-Ø60. Machining T-slot with nominal size 12, 14, 18, 22, 28, 36. 86° rhombic inserts with positive angle.
	HMP01	Kr=90° a _p max=55			
Helical end mills	B169	Kr=90° a _p max=74~144	APKT150412-PM/KM SPMT120408-PM/KM	Milling of steel, alloy steel and cast iron at high cutting depth.	Diameter range Ø40、Ø80. Coarse and differential pitch, less vibration. Holistic structure with good rigidity, interchangeable heads achieve high economical efficiency.
	HMP01 EC	Kr=90° a _p max=74~144			

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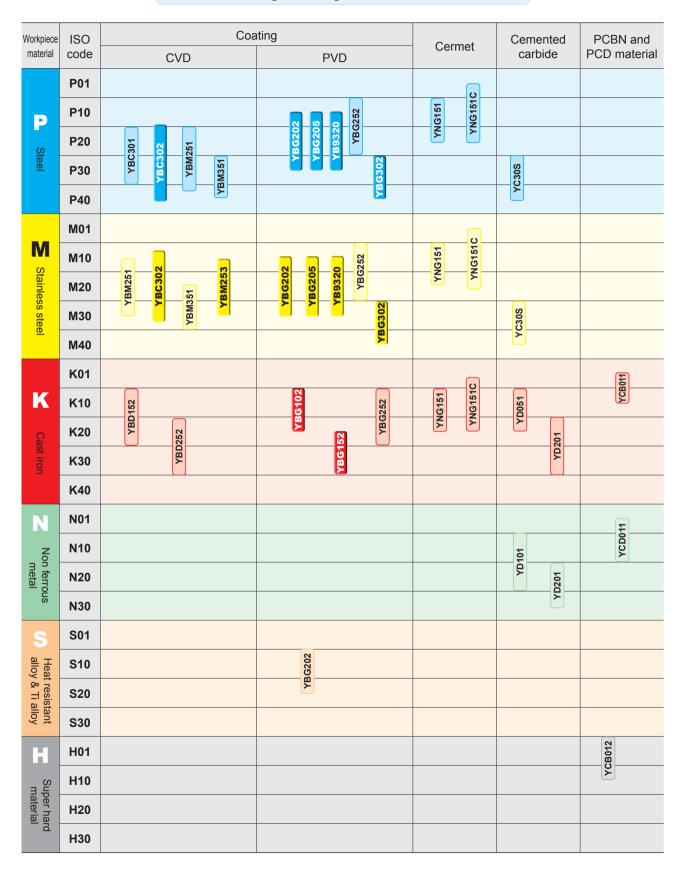
MILLING (Indexable Milling Tools

Operating pattern		Approach angle / Max. cutting depth.	Applicable insert	Application overview	Features
	CMZ01	Kr=30°			
Chamfer milling	CMA01	Kr=45°	SPMT120408	Chamfer machining of steel, alloy steel, stainless steel and cast iron	Diameter range Ø12、Ø25、Ø32、Ø36. With the function of milling small surface.
	CMD01	Kr=60°			



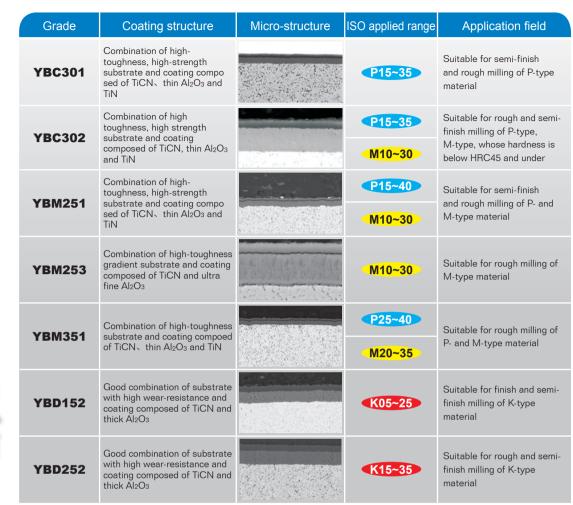


Milling insert grades overview



Grade classification for milling inserts

Coated Cemented Carbide





Application case

Component shape



Vertical machining center, dry

ZCC CT



Machine and cooling			
Workpiece material and hardness			
Type of machining			
Applicable tool			

NC plane milling machine, wet machining

machining Casting stainless steel HB220-260

45# Forged steel HB240-270

Horizontal machining center, dry

machining

Milling surface FMA04-200-C60-OF07-12

Number of workpiece machined

FMA01-125-B40-SE12-08

Milling surface

HT250 HB220 Milling surface FMP02-100-B32-SE12-07

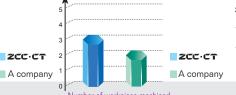
YBM251/OFKR0704-DM Applicable insert Vc=120m/min, fz=0.15mm/z, **Cutting parameters**

YBM351/SEET12T3-DR Vc=212m/min, fz=0.2mm/z, a_p=3mm

YBD252/SEET120308PER-APM Vc=160m/min, fz=0.2mm/z,

a_p=1.5mm

a_p=2mm





Application results

Grade classification for milling inserts

Coated Cemented Carbide PVI

Grade	Coating structure	ISO applied range	Application field
YBG102	fine carbide substrate + Nano coating	₹ 05~ K 20	Suitable for finish and semi-finish milling of K-type material
YBG202	Substrate with excellent deformation resistance + Nano coating	P10~30 M10~30 S05~20	PVD grade with wide application, widely applied in semi-finish milling of P-, M- and S-type material
YBG205	Ultra fine carbide substrate + Nano coating	P10~30 M10~30	Suitable for finishing and semi-finish milling of P- and M- material
YBG302	Substrate with good toughness and strength + Nano coating	P25~40 M25~40	Suitable for rough milling of P- and M-type material
YBG152	Substrate with moderate hardness and strength + Nano coating	K20~35	Suitable for rough and semi-finish milling of K-type material
YB9320	Substrate with high toughness + TiAIN based multi Nano coating	P10~30 M10~30	PVD grade with wide application, widely applied in finishing and semi- finish milling of P-, M- and S- material

Application case

Component shape





Machine and cooling Machining center, dry cutting Plane milling machine, dry cutting

Workpiece material and Nodular cast iron HB 220 7CrSiMoV HRC25 hardness

Type of machining Milling surface Cavity milling

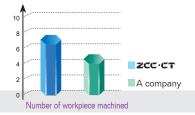
Applicable tool EMP02-050-A22-AP11-06 BMR03-050-MT5-M

Applicable insert YBG102/APKT11T308-APM YBG302/XPHT50R2507- GM

 $Vc=235m/min, fz=0.15mm/z, a_p=1~3mm$ Vc=120m/min, fz=0.25mm/z, a_p=8mm **Cutting parameters**

200 Application results 100 ZCC CT A company

Number of workpiece machined



Grade classification for milling inserts



Grade	Coating structure	ISO applied range	Application field	
		P05~20		
YNG151		M05~20	Wide application in finish milling of P-, M-, and K-type material	
		K05~20		
		P01~20		
YNG151C		M01~20	Wide application in finish milling of P-, M-, and K-type material	
		K01~20		

Application case

Component shape





Machine	and	coo	ling
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Machining center, dry cutting

Machining center, dry cutting

Workpiece	material	and
hard	Iness	

45[#] HB 170~220 NAK80 HRC42~48

Type of machining

Finish milling surface

Finish milling surface

Applicable tool

FMA03-160-B40-SE12-08

FME03-160-B40-SP12-10

Applicable insert

YNG151/SEEN1203AFTN

YNG151C/SPEN1203EDER

Cutting parameters

Vc=400m/min, fz=0.1mm/z,

Vc=420m/min, fz=0.12mm/z,

a_p=0.35mm







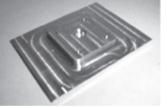
Grade classification for milling inserts



Grade	Coating structure	ISO applied range	Application field
YC30S		P25~40 M25~40	Suitable for rough milling of P- and M-type material
YD051		K05~20	Suitable for finish milling of K-type material
YD101		N05~25	Suitable for rough milling of N-type material
YD201		K15~35 N15~30	Suitable for rough and semi-finish milling of K-type material, and for rough milling of N-type material



Component shape



Vertical machining center, wet machining



Plane milling machine, wet machining



plane milling machine, dry cutting

Workp	iece m hardn	and

Machine and cooling

Aluminum alloy HB100

40CrMnMo HB240

HT250 HB220

Type of machining

Milling surface

Milling surface

Milling surface

Applicable tool Applicable insert

YD101/SEET12T3-LH

FMA01-100-B32-SE12-07

YC30S/TPKN2204PDR

FMP01-100-B32-TP22-06

FME03-160-B40-SP15-10 YD201/SPKN1504EDTR

Cutting parameters

Vc=300-350m/min, ap=1~2mm, fz=0.2mm/z

Vc=170m/min, ap=5~7mm fz=0.3mm/z

Vc=100-130m/min, ap=7mm, fz=0.35mm/z





