

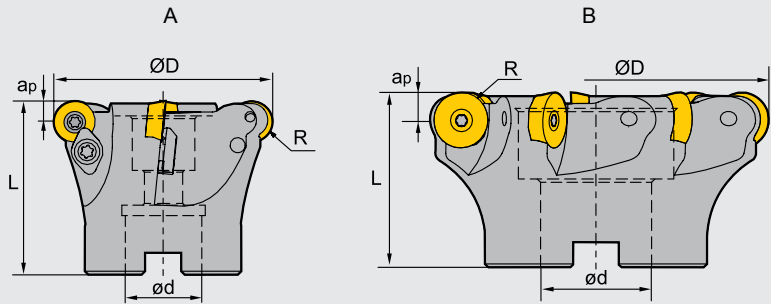
Face Milling Tools · Planfräser



FMR04 P M K



Walter-System








Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimension (mm) Abmessung					No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)
		Ø D	Ø d	L	R	apmax			
FMR04 050-A22-RD12-03	●	50	22	40	6	6	3	A	0.3
050-A22-RD12-03C	●	50	22	40	6	6	3	A	0.3
063-A22-RD12-04	●	63	22	50	6	6	4	A	0.5
063-A22-RD12-04C	●	63	22	50	6	6	4	A	0.5
080-B27-RD16-05	●	80	27	50	8	8	5	B	1.2
080-B27-RD16-05C	●	80	27	50	8	8	5	B	1.2
100-B32-RD16-06	●	100	32	50	8	8	6	B	1.0
100-B32-RD16-06C	●	100	32	50	8	8	6	B	1.0
125-B40-RD20-06	○	125	40	63	10	10	6	B	1.9
125-B40-RD20-06C	○	125	40	63	10	10	6	B	1.9
160-B40-RD20-07	○	160	40	63	10	10	7	B	3.7
160-B40-RD20-07C	○	160	40	63	10	10	7	B	3.7

Inserts · WSP : RDKW1204MO**/ RDKW1605MO**/ RDKW2006MO

Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Clamp Pratze	Clamp Screw Schraube (Pratze)	Wrench Schlüssel	
					
Ø50-Ø63	I60M3.5×10	WD-204	I60M4×10	WT15IP	--
Ø80 -Ø100	I60M5×13	--	--	--	WT20IT
Ø125 -Ø160	I43M6×16	--	--	--	WT25IT

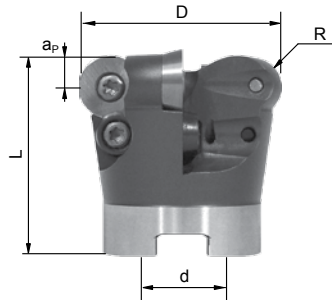


● Ex Stock / ab Lager ○ On demand / auf Anfrage

Face Milling Tools · Planfräser



FMR04 P M K



Depo-System

Type Typ	Stock Lager	Dimension (mm) Abmessung					No. of teeth Zähne	
		Ø D	Ø d	L	R	a _{pmax}		
FMR04	042-A16-RD1003-06	•	42	16	44	5	5	6
	042-A16-RD1003-06C	•	42	16	44	5	5	6
	052-A22-RD1003-07	•	52	22	50	5	5	7
	052-A22-RD1003-07C	•	52	22	50	5	5	7

Inserts · WSP: RDKW1003MO**

Type Typ	Stock Lager	Dimension (mm) Abmessung					No. of teeth Zähne	
		Ø D	Ø d	L	R	a _{pmax}		
FMR04	042-A16-RD12T3-05	•	42	16	42	6	6	5
	042-A16-RD12T3-05C	•	42	16	42	6	6	5
	052-A22-RD12T3-05	•	52	22	50	6	6	5
	052-A22-RD12T3-05C	•	52	22	50	6	6	5
	066-A27-RD12T3-06	•	66	27	50	6	6	6
	066-A27-RD12T3-06C	•	66	27	50	6	6	6
	080-A27-RD12T3-07	•	80	27	50	6	6	7
	080-A27-RD12T3-07C	•	80	27	50	6	6	7

Inserts · WSP: RDKW12T3MO**













Type Typ	Stock Lager	Dimension (mm) Abmessung					No. of teeth Zähne	
		Ø D	Ø d	L	R	a _{pmax}		
FMR04	*052-A22-RD1604-04	•	52	22	50	8	8	4
	*052-A22-RD1604-04C	•	52	22	50	8	8	4
	*052-A22-RD1604-05	•	52	22	50	8	8	5
	*052-A22-RD1604-05C	•	52	22	50	8	8	5
	066-A27-RD1604-05	•	66	27	50	8	8	5
	066-A27-RD1604-05C	•	66	27	50	8	8	5
	080-A27-RD1604-06	•	80	27	52	8	8	6
	080-A27-RD1604-06C	•	80	27	52	8	8	6
	100-B32-RD1604-07	•	100	32	52	8	8	7
	100-B32-RD1604-07C	•	100	32	52	8	8	7
	125-B40-RD1604-08	•	125	40	52	8	8	8
	125-B40-RD1604-08C	•	125	40	52	8	8	8
	160-B40-RD1604-09	•	160	40	52	8	8	9
160-B40-RD1604-09C	○	160	40	52	8	8	9	

Inserts · WSP: RDKW1604MO**

*= WX16N (außer für FMP04-052) (except for FMP04-052)

**= nur ab (Ø 052) from (Ø 052)

■ Spare Parts · Ersatzteile

Type Typ	Screw Schraube	Clamp Klemmscheibe	Clamp Screw Klemmschraube	Wrench Schlüssel
FMR04**RD1003	 I60M3,5 x 7,7	 -	 -	 WT15P
FMR04**RD12T3	 I60M3,5 x 7,7	 -	 **LOM 3,5 x 7,1	 WT15P
FMR04**RD1604	 I60M4,5 x 1,0	 *WX16N	 -	 WT20T

Applicable tool
Werkzeug **B11-B18**

Tools code key
Werkzeug ISO **B26-B27**

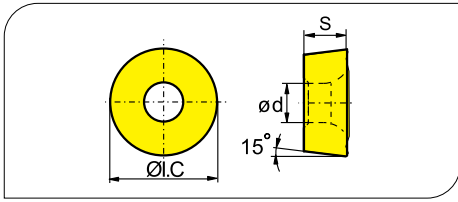
Grade selection guide
Sortenauswahl **B19-B23**

Technical data
Technische Daten **B215-B220**

Milling - Fräsen

Indexable Milling Tools - Wendeschleiffräser

Applicable inserts - Wendeschleifplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoff	P	M	K	N	S	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●	●	●	●	●	●	●	●	●	●
M	●	●	●	●	●	●	●	●	●	●
K	●	●	●	●	●	●	●	●	●	●
N	●	●	●	●	●	●	●	●	●	●
S	●	●	●	●	●	●	●	●	●	●

Insert shape / Plattenform	Type / Typ	Dimension (mm) / Abmessung			CVD Coating / CVD Beschicht.				PVD Coating / PVD Beschicht.				Cermets / Cermet	Carbide uncoat. / unbe. Hartmetall											
		I.C	S	d	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252		YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201	
	RDKW1003MO	10.0	3.18	3.9				●	●			●	●												
	RDKW10T3MO	10.0	3.97	4.4	○	●				●		●	●												
	RDKW1204MO	12.0	4.76	4.4	○	●		●	●	●		●	●	●	○										
	RDKW12T3MO	12.0	3.97	3.9			○	●	●	●		●	●											○	
	RDKT12T3MO-EM	12.0	3.97	3.9						●															
	RDKW1604MO	16.0	4.76	5.2						●		●	●												
	RDKW1605MO	16.0	5.56	5.5						●			●	●			●								
	RDKW2006MO	20.0	6.35	6.5	●					●		○													

Recommended cutting data - Empfohlene Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten	
			V (m/min)	f (mm/z)
P Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl / Baustahl High-carbon steel / Alloy steel / Hochleg. Kohlenstoffstahl Alloy tool steel / Leg. Werkzeugstahl	≤180	YBM251 YBC301	270 (220-350)	0.2 (0.08-0.45)
		YBM351 YBG302	220 (180-300)	0.25 (0.15-0.45)
		YBG202	270 (200-360)	0.2 (0.1-0.45)
	180-280	YBM251 YBC301	240 (200-320)	0.2 (0.08-0.45)
		YBM351 YBG302	200 (160-280)	0.25 (0.15-0.45)
		YBG202	240 (180-350)	0.2 (0.1-0.45)
	280-350	YBM251 YBC301	220 (180-300)	0.2 (0.08-0.45)
		YBM351 YBG302	180 (150-250)	0.25 (0.15-0.45)
		YBG202	220 (170-340)	0.2 (0.1-0.45)
M Stainless steel / Rostfreier Stahl	≤270	YBM251	150 (120-240)	0.2 (0.08-0.45)
		YBM351 YBG302	150 (100-220)	0.25 (0.1-0.45)
		YBG202	160 (110-270)	0.2 (0.1-0.45)
K Cast iron / Gusseisen	180-250	YBG102	210 (120-300)	0.2 (0.1-0.45)

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Case study for FMR04 Bearbeitungsbeispiel für FMA04



- Tool · Werkzeug: FMR04-063-A22-RD12-04
- Inserts · WSP: RDKW1204MO/YBG202

Workpiece material
Werkstückstoff: 42CrMo (HRC35)
Cooling system: dry cutting
Kühlsystem: trocken

Machine: vertical machining center
Maschine: vertikales Maschinen-Center

Cutting data
Schnittdaten:
Vc=200m/min
ap=3mm
fz=0.3mm/z



● Wear comparison after 90 min Verschleißvergleich nach 90 min

ZCC-CT



**Competitor A
Wettbewerber A**



Applicable tool
Werkzeug **B11-B18**

Tools code key
Werkzeug ISO **B26-B27**

Grade selection guide
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