

### Face Milling Tools · Planfräser

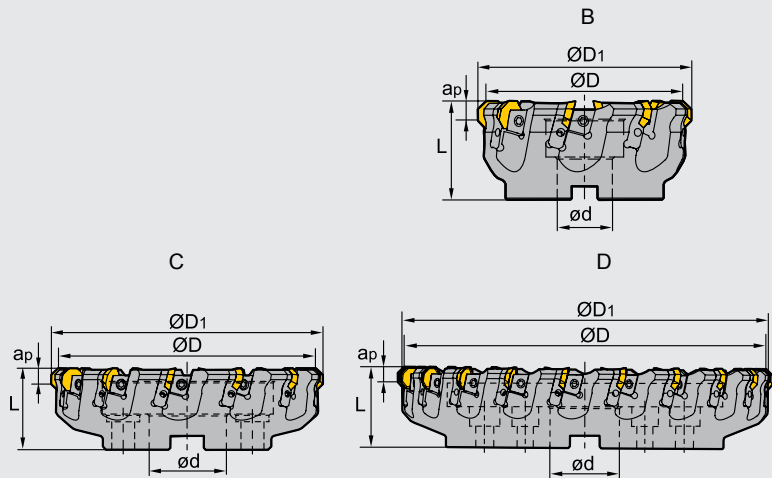
Kr:45°



**FMA04** P M K



Wedge  
Keil



#### Specification of tools · Werkzeug Beschreibung

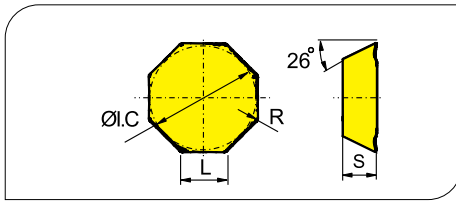
Type Typ	Stock Lager	Dimension (mm) Abmessung						No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)
		R	L	Ø D	Ø D <sub>1</sub>	Ø d	L			
<b>FMA04</b>										
-125-B40-OF07-08	● ○	● ○	125	136	40	63	5	8	B	3.9
-160-B40-OF07-10	● ○	● ○	160	171	40	63	5	10	B	5.9
-200-C60-OF07-12	● ○	● ○	200	211	60	63	5	12	C	7.6
-250-C60-OF07-16	● ○	● ○	250	261	60	63	5	16	C	13.3
-315-D60-OF07-20	○ ○	○ ○	315	321	60	63	5	20	D	20.3

#### Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Cassette Kassette	Wedge Keil	Wedge screw Keilschraube	Locator screw Einstellschraube	Wrench Schlüssel	
Ø125-Ø315	LOF07R/L	W02R/L	DM8×21X	LOM5×15.1	WT20T WH40T	

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

### Applicable inserts · Wendeschneidplatten



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

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

Insert shape / Plattenform	Type / Typ	Dimension (mm) / Abmessung				CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.				Cermet / Cermet	Carbide uncoat. / unbe. Hartmetall								
		L	I.C.	S	R	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	OFKR0704-DF	7.45	17.94	4.76	0.8				○						●										
	OFKR0704-DM	7.45	17.94	4.76	0.8	●	●	●		●	●	●	●	○		●									
	OFKR0704W-DM <i>wiper</i>	7.45	17.94	4.76		○						○			●	●									
	OFKR0704-LH	7.45	19.94	4.76																				○	

### Chipbreaker Selection FMA04 · Spanbrecher Auswahl FMA04

Application / Anwendung	Finishing / Schlichten	Semi-Finishing / Mittlere Bearbeitung
<b>P</b>		
<b>M</b>	-DF	-DM
<b>K</b>		
<b>N</b>	LH	LH

Applicable tool / Werkzeug: **B11-B18**

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

Grade selection guide / Sortenauswahl: **B19-B23**

Technical data / Technische Daten: **B215-B220**

## Recommended cutting data · Empfohlene Schnittdaten

Workpiece material Werkstückstoff	Hardness HB Härte	Grade Sorte	Cutting data Schnittdaten			
			V (m/min)	f (mm/z)		
				-DF	-DM	
<b>P</b> 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 (0.1-0.3)	0.25 (0.1-0.4)	
		YBG202 YBG205	270 (200-360)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBM351	220 (180-300)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBG302	230 (170-350)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
	180-280	YBM251 YBC301	240 (200-320)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBG202 YBG205	240 (180-350)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBM351	200 (160-280)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBG302	220 (150-330)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
	280-350	YBM251 YBC301 YBD252	220 (180-300)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBG202 YBG205	220 (170-340)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBM351	180 (150-250)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBG302	190 (130-300)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
<b>M</b> Stainless steel Rostfreier Stahl	≤270	YBG202 YBG205	160 (110-270)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBG302	140 (100-250)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
		YBM251	150 (120-250)	0.15 (0.1-0.3)	0.2 (0.1-0.4)	
<b>K</b> Cast iron Gusseisen	180-250	YBG102	210 (120-300)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBD152	240 (180-300)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	
		YBD252	200 (150-250)	0.2 (0.1-0.3)	0.25 (0.1-0.4)	

**B**

Milling Tools  
Fräser