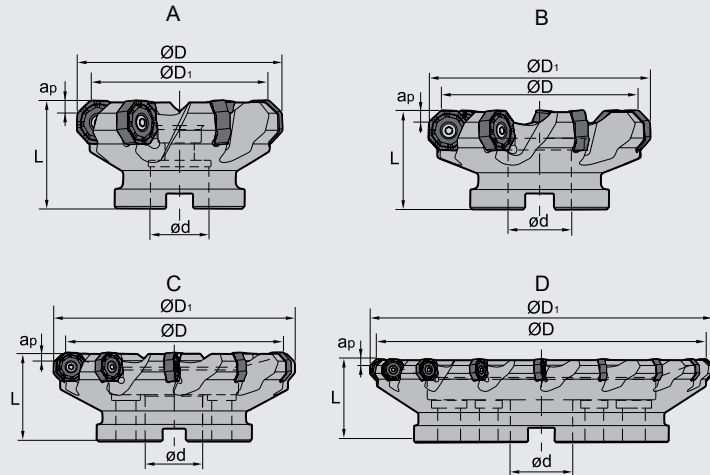


Face Milling Tools · Planfräser

Kr:45°



FMA12 P K







Specification of tools · Werkzeug Beschreibung

Type Typ	*	Stock Lager		Dimension (mm) Abmessung					No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)
		R	L	ØD	ØD ₁	Ød	L	a _{pmax}			
FMA12											
-063-A22-ON08-05	*	●		63	78	22	50	5.0	5	A	0,6
-080-A27-ON08-06	*	●		80	95	27	50	5.0	6	A	0.97
-100-B32-ON08-07		●		100	115	32	50	5.0	7	B	1.28
-100-B32-ON08-07C	*	●		100	115	32	50	5.0	7	B	1.28
-125-B40-ON08-08		●		125	140	40	63	5.0	8	B	2.59
-125-B40-ON08-08C	*	●		125	140	40	63	5.0	8	B	2.59
-160-C40-ON08-10		●		160	175	40	63	5.0	10	C	4.10
-200-C60-ON08-12		○		200	215	60	63	5.0	12	C	5.68
-250-C60-ON08-14		○		250	265	60	63	5.0	14	C	11.90
-315-D60-ON08-18		○		315	330	60	80	5.0	18	D	20.41

* Internal coolant · Innenkühlung

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

Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Drehmoment Torque	Wrench Schlüssel	
Ø80-Ø315	 ONHU08T624R-GM	 I60M5X13	5 Nm	 WT20IT	

We recommend to use torque wrenches · Wir empfehlen den Einsatz von Drehmomentschlüsseln

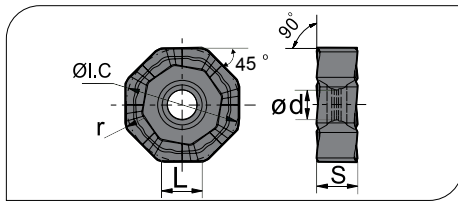
B

Milling Tools
Fräser

Milling - Fräsen

Indexable Milling Tools - Wendepplattenfräser

Applicable inserts - Wendeschneidplatten



- 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-ferrous material / Nichteisenmetalle	●	●	●	●	●
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	bs	Ø d	r	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202			YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YCG30S	YD101
	ONHU08T624R-GM	6.38	20.2	6.3	5.3	2.4	0.8						●	●			●										

Recommended cutting data - Empfohlene Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten		
			V (m/min)	f (mm/z)	a _{max}
P Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl	≤180	YBM253	270 (220-350)	0.2 (0.1-0.3)	5
		YBG205			
	180-350	YBM253	240 (180-320)	0.15 (0.1-0.3)	5
		YBG205			
M Stainless steel / Rostfreier Stahl	≤270	YBM253	230 (180-300) 160 (110-270)	0.15 (0.1-0.3)	5
		YBG205			
K Cast iron / Gusseisen	180-250	YBD152	270 (150-300)	0.2 (0.1-0.3)	5

B

Milling Tools / Fräser