Catalogue

Version 2019

2019

EN

ZCC Cutting Tools Europe GmbH

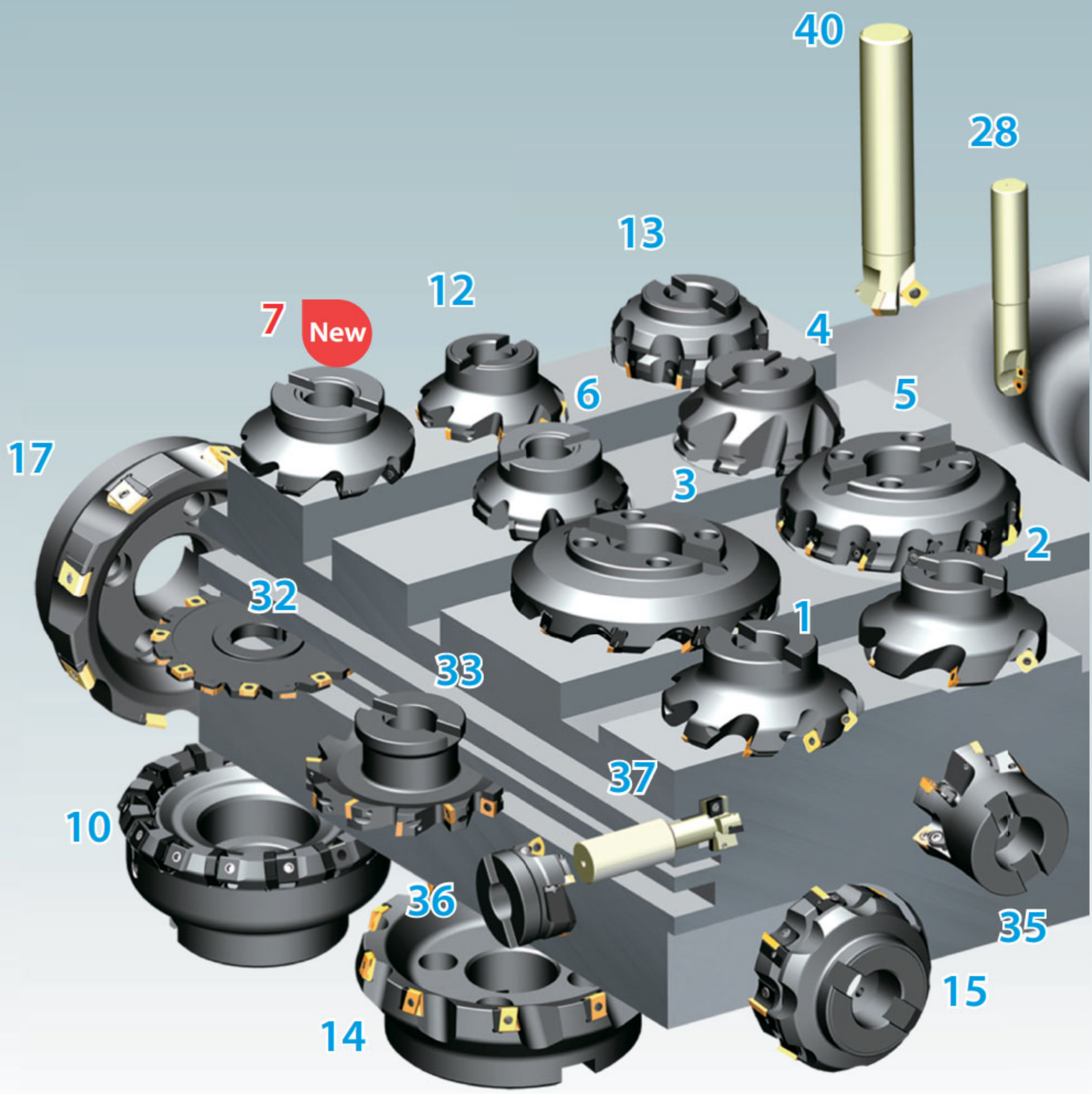
your Partner your Value

ZCC·CT

Indexable milling

B

Indexable inserts milling tool program



No.	Tool category	Page	No.	Tool category	Page	No.	Tool category	Page
1	FMA01	B31	9	FMD02 (PN11)	B60	17	FMP03	B82
2	FMA02	B34	10	FMD02 (HN09)	B66	-	FMP12	B86
3	FMA03	B37	11	FMD03	B68	18	FMR01	B90
4	FMA04 (OFKT05**)	B40	12	FME02	B70	19	FMR02	B93
5	FMA04 (OFKR07**)	B40	13	FME03	B72	20	FMR03	B96
6	FMA07	B46	14	FME04	B75	21	FMR04	B100
7	FMA11	B52	15	FMP01	B77	22	EMP01	B104
8	FMA12	B56	16	FMP02	B79	23	EMP02	B110

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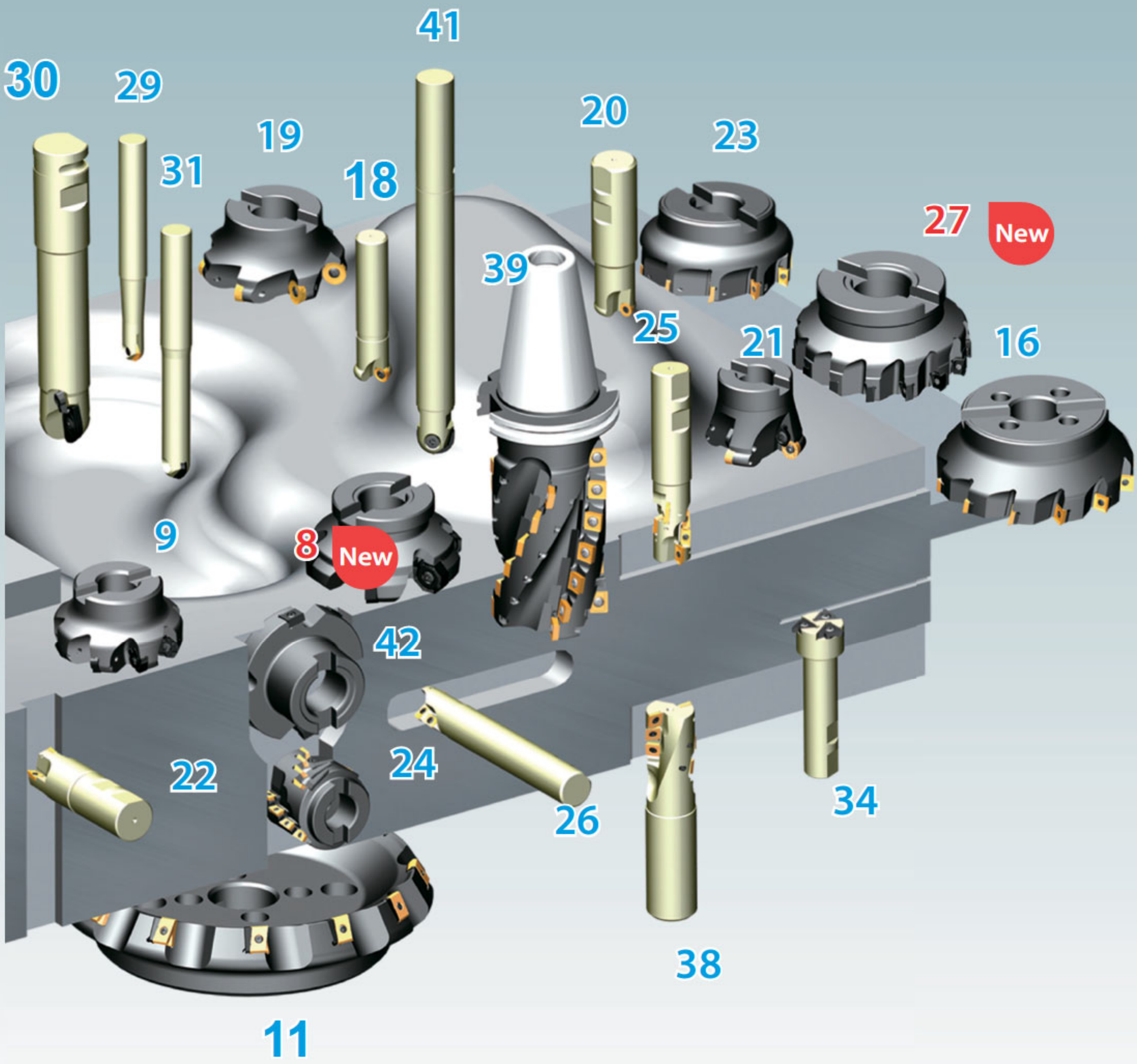


No.	Tool category	Page	No.	Tool category	Page	No.	Tool category	Page
24	EMP03	B113	31	BMR04	B149	39	HMP01-EC	B182
25	EMP04	B115	32	SMP01	B153	40	CM*01	B184
26	EMP05	B117	33	SMP03	B157	41	QCH	B198
-	EMP09	B120	34	SMP05	B161	42	XMP01	B174
27	EMP13	B126	35	XMR01 (SDMT**)	B166			
28	BMR01	B136	36	XMR01 (WPGT**)	B170			
29	BMR02	B139	37	TMP01	B176			
30	BMR03	B141	38	HMP01	B178			

A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

ANGX-GM	ANGX-LH	APKT-ALH	APKT-APF	APKT-APM	APKT-KM	APKT-LH	APKT-PF	
11 15	11 15	11 16	11 16	07 11 16	15	11 16	11 16	Edge length
B127, B129, B131, B133, B135	B127, B129, B131, B133, B135	B105, B108, B111, B114, B116, B205	B105, B108, B111, B114, B116, B205	B105, B108, B111, B114, B116, B205	B179, B181, B183	B105, B108, B111, B114, B116, B205	B105, B108, B111, B114, B116, B205	Page

APKT-PM	APKT-PR	APMT	CNE-A/B	HNEX-DM	HNEX-DR	HNGX-HDR	HNGX-MR	
11 15 16	11	11 16	12	09	09	09	09	Edge length
B105, B108, B111, B114, B116, B205	B105, B108, B111, B114, B116, B205	B118	B175	B67	B67	B212	B212	Page

LNCX	LNE32.534	LNKT-GM	LNKT-ZR	MPHT-DM	OFKR-DF	OFKR-DM	OFKT-DF	
18		08 12 16	12 15 20 25	06 08 12	07	07	05	Edge length
B214	B213	B121, B123	B69, B76, B83	B158, B160, B177	B43	B43	B41	Page

OFKT-DM	OFKT-LH	ONHU-GM	ONHU-PF	ONHU-PM	PNEG-CF	PNEG-CM	PNEG-CR	
05	05	08	06 08	06 08	11	11	11	Edge length
B41	B41	B57	B47, B49	B47, B49	B61, B64	B61, B64	B61, B64	Page

PNEG-PF	PNEG-PM	PNEG-PR	RCKT-DM	RCKT-DR	RCKT-ER	RCKT-NM	RDKW	
11	11	11	10 12 16 20	12 16 20	12 16 20	12 16 20	07 08 10 12 16 20	Edge length
B62, B64	B62, B64	B62, B64	B91, B95	B91, B95	B91, B95	B91, B95	B99, B103, B207, B209	Page

ROHX	SDMT	SDMT-DM	SDMT-PM	SEEN	SEET-APF	SEET-APM	SEET-APR	
12 16 20	09	06 09 12 15	06 09 12 15	12	09 12	09 12	09 12	Edge length
B140	B138	B167, B169, B201	B167, B169, B201	B38	B80	B80	B80	Page

SEET-CF	SEET-CM	SEET-CR	SEET-DF	SEET-DM	SEET-DR	SEET-EF	SEET-EM	
12	12	12	12	12 18	12	12	12	Edge length
B32, B35	B32, B35	B32, B35	B32, B35	B32, B35	B32, B35	B32, B35	B32, B35	Page

Milling inserts

SEET-LH	SEET-PF	SEET-PM	SEET-PR	SEET-W	SEKN	SEKR	SNEG-E	
12	09 12	09 12	09 12	12	12 15	12	15	Edge length
B80	B80	B80	B80	B33, B36	B39	B39	B53	Page

SNEG-GM	SNEG-GR	SNEG-W	SNKN	SPCN	SPGN	SPKN	SPKR	
12 15	12 15 19	12	12 15	12 15	12	12 15	12	Edge length
B53	B53	B54	B215	B216	B219	B73	B74	Page

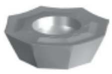
SPKR-GM	SPKT	SPKW	SPMR	SPMT	SPMT-HT	SPMT-KM	SPMT-KT	
12 15	12	12	09 12	06 09 12	09 12	12	06	Edge length
B74	B71	B71	B217	B138, B185, B187, B189, B191, B193, B195	B218	B179, B181, B183	B138, B218	Page

SPMT-PM	SPUN	TPCN	TPKN	TPMR	TPUN	WNHU-GM	WPGT	
12	12 15	22	16 22	09 11 16 22	11 16 22	06 08	05 06 08 09	Edge length
B179, B181, B183	B219	B220	B78, B221	B222	B222	B87, B89	B171, B173, B203	Page

WPGT-PM	XSEQ	XPHT-GM	ZDET	ZDET-PM	ZOHX-GF	ZOHX-GM	ZPNT	
05 06 08 09	12	16 20 25 30 32 40 50	08 11 13	13	12 16 20 25 30 32	12 16 20 25 30 32	22	Edge length
B171, B173, B203	B154, B156	B142, B144, B146, B148, B199	B137	B137	B150, B152, B211	B150, B152, B211	B137	Page

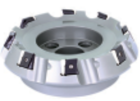
A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
FMA01		 SEET12T3 SEET18T6	45°	✔	✔	✓	✔	✔		• Diameter range Ø50 – 315 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Milling cutter with positive, soft cutting geometry • Wiper inserts for good surface quality	B31
FMA02		 SEET12T3	45°	✔	✔	✓	✔	✔		• Diameter range Ø50 – 125 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Milling cutter with positive, soft cutting geometry • Wide pitch	B34
FMA03		 SEEN1203 SEKN1203 SEKR1203 SEKN1504 SEKR1504	45°	✔	✔	✔	✓			• Diameter range Ø80 – 315 mm • For steel, stainless steel and cast iron • Milling cutter with positive, soft cutting geometry • Wedge clamping	B37
FMA04		 OFKT05T3	45°	✔	✔	✓	✔			• Diameter range Ø50 – 160 mm • For steel, stainless steel, cast iron and non-ferrous metals • Inserts with eight cutting edges • Screw clamping	B40
FMA04		 OFKR0704	45°	✔	✔	✓	✔			• Diameter range Ø125 – 315 mm • For steel, stainless steel, cast iron and non-ferrous metals • Inserts with eight cutting edges • Wedge clamping	B42
FMA07		 ONHU0604 ONHU08T5	45°	✔		✔			✓	• Diameter range Ø25 – 50 mm • For steel and cast iron • Inserts with 16 cutting edges	B46

✔ Very suitable ✓ Suitable

Face milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
FMA07		 ONHU0604 ONHU08T5	45°	✔		✔			✓	• Diameter range Ø40 – 315 mm • For steel and cast iron • Inserts with 16 cutting edges	B48
FMA11		 SNEG1205 SNEG1506 SNEG1907	45°	✔	✔	✓		✓		• Diameter range Ø63 – 315 mm • For steel, stainless steel and cast iron • Inserts with eight cutting edges • Double sided, thicker inserts for high stability and deeper cutting depths • Wiper geometry for good surface quality • Normal and fine pitch	B52
FMA12		 ONHU08T6	45°	✔	✔	✓		✓		• Diameter range Ø63 – 315 mm • For steel, stainless steel and cast iron • Inserts with 16 cutting edges	B56
FMD02		 PNEG1105	67°	✔	✔	✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Inserts with ten cutting edges • Wedge clamping or screw clamping • Normal and fine pitch	B60 B63
FMD02		 HNEX0905	55°			✔				• Diameter range Ø80 – 315 mm • For cast iron • Wedge clamping • Inserts with twelve cutting edges	B66
FMD03		 LNKT2007-ZR LNKT2510-ZR	60°	✔		✔				• Diameter range Ø100 – 400 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Heavy duty machining for high cutting depths• Screw clamping	B68

✔ Very suitable ✓ Suitable

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

Series	Milling body	Inserts	Kr	Application						Features	Page
				P	M	K	N	S	H		
FME02		 SPKT1204 SPKW1204	75°	✔	✔	✔				• Diameter range Ø50 – 125 mm • For steel and cast iron • Screw clamping	B70
FME03		 SPKN1203 SPKR1203 SPEX1203 SPKN1504 SPKR1504 SPEX1504	75°	✔	✔	✔				• Diameter range Ø80 – 400 mm • For steel and cast iron • Wedge clamping	B72
FME04		 LNKT1506-ZR	75°	✔		✔				• Diameter range Ø125 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Heavy duty machining for high cutting depths • Screw clamping	B75
FMP01		 TPKN2204	90°	✔	✔	✔		✓		• Diameter range Ø80 – 315 mm • For steel, stainless steel and cast iron • Milling cutter with positive, soft cutting geometry • Wedge clamping	B77
FMP02		 SEET09T3 SEET1203	90°	✔	✔	✓	✔	✔		• Diameter range Ø50 – 315 mm • For steel, stainless steel, cast iron an non-ferrous metals • Screw clamping	B79
FMP03		 LNKT120608-ZR LNKT1506EN-ZR LNKT2007DN-ZR LNKT2510-ZR	89°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Heavy duty machining for high cutting depths • Screw clamping	B82

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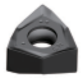
Face milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
FMP12		 WNHU0604 WNHU0806	90°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Heavy duty machining for high cutting depths • Screw clamping	B86
FMP12		 WNHU0604	90°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Heavy duty machining for high cutting depths • Screw clamping	B88
FMR01		 RCKT10T3 RCKT1204 RCGX1204		✔	✔	✔	✔	✔		• Diameter range Ø25 – 63 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Screw clamping	B90
FMR02		 RCGX1204 RCKT1204 RCMW1204 RCKT1606 RCKT2006		✔	✔	✔	✔	✔		• Diameter range Ø50 – 250 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Screw clamping	B93
FMR03		 RDKW0803 RDKW10T3 RDKW1204		✔	✓	✓			✓	• Diameter range Ø15 – 50 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry	B96
FMR03		 RDKW0702 RDKW1003		✔	✓	✓			✓	• Diameter range Ø15 – 50 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry	B98

✔ Very suitable ✓ Suitable

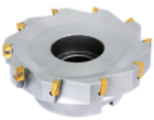
A Turning
B Milling
C Drilling
D Technical Information
E Index

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

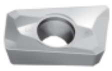
Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
FMR04		 RDKW1204 RDKW1605 RDKW2006		✔	✔	✔			✔	• Diameter range Ø50 – 200 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry	B100
FMR04		 RDKW1003 RDKW12T3 RDKW1604		✔	✔	✔			✔	• Diameter range Ø42 – 200 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry	B102

Square shoulder milling

Series	Milling body	Inserts	Kr	P	M	K	N	S	H	Features	Page
EMP01		 APKT0702 APKT11T3 APKT1604	90°	✔	✔	✔	✔	✔		• Diameter range Ø12 – 63 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Weldon shank • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges	B104
EMP01		 APKT11T3 APKT0702 APKT1604	90°	✔	✔	✔	✔	✔		• Diameter range Ø12 – 63 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Weldon shank • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges	B107
EMP02		 APKT0702 APKT11T3 APKT1604	90°	✔	✔	✔	✔	✔		• Diameter range Ø40 – 250 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges	B110

✔ Very suitable ✔ Suitable

Square shoulder milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
EMP03		 APKT11T3	90°	✔	✔	✔	✔			• Diameter range Ø50 – 100 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • For square shoulder milling, slot milling and ramping • Milling cutter with a positive, soft cutting geometry • Inserts with two cutting edges	B113
EMP04		 APKT11T3	90°	✔	✔	✔	✔			• Diameter range Ø20 – 40 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges	B115
EMP05		 APMT1135 APMT1604	90°	✔	✔	✔				• Diameter range Ø25 – 40 mm • For steel, stainless steel and cast iron • Straight shank • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges • Machining in z-direction possible	B117
EMP09		 LNKT0804PNR-GM LNKT1206PNR-GM LNKT1607PNR-GM	90°	✔	✓	✔				• Diameter range Ø40 – 125 mm • Sharp cutting edge geometry combined with robust tangential inserts • First choice for large cutting depths with high feed rates. • Specially designed cutting edge with high precision control for high quality 90 degree square shoulder milling	B120
EMP13		 ANGX1105 ANGX1506	90°	✔	✓	✔	✔			• Diameter range Ø40 – 250 mm • For steel, cast iron and non-ferrous metals • Double sided, thicker inserts for high stability and deeper cutting depths • Inserts with four cutting edges	B126
EMP13		 ANGX1105 ANGX1506	90°	✔	✓	✔	✔			• Diameter range Ø25 – 40 mm • For steel, cast iron and non-ferrous metals • Double sided, thicker inserts for high stability and deeper cutting depths • Inserts with four cutting edges	B128

✔ Very suitable ✓ Suitable

Square shoulder milling

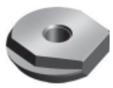
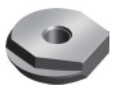
Series	Milling body	Inserts	Kr	Application						Features	Page
				P	M	K	N	S	H		
EMP13		 ANGX1105 ANGX1506	90°	✔	✓	✔	✔			• Diameter range Ø50 – 80 mm • For steel, cast iron and non-ferrous metals • Double sided, thicker inserts for high stability and deeper cutting depths • Inserts with four cutting edges	B132
EMP13		 ANGX1105 ANGX1506	90°	✔	✓	✔	✔			• Diameter range Ø25 – 40 mm • For steel, cast iron and non-ferrous metals • Double sided, thicker inserts for high stability and deeper cutting depths • Inserts with four cutting edges	B134

Profile milling

Series	Milling body	Inserts	Kr	P	M	K	N	S	H	Features	Page
BMR01		 ZDET08T2 & SPMT0603 ZDET1103 & SPMT0603 ZDET13T2 & SDMT0903 ZPNT2204 & SPMT1204		✔	✓	✔				• Diameter range Ø20 – 63 mm • For steel, stainless steel and cast iron • Very suitable for roughing of big moulds • Inserts with three cutting edges	B136
BMR02		 ROHX1203 ROHX1604 ROHX2005		✔	✓	✔				• Diameter range Ø12 – 20 mm • For steel, stainless steel and cast iron • Very suitable for finishing in mould and die industry • Inserts with two cutting edges	B139
BMR03		 XPHT16 XPHT20 XPHT25 XPHT30 XPHT32 XPHT40		✔	✓	✔				• Diameter range Ø16 – 40 mm • For steel and cast iron • Very suitable for roughing in mould and die industry • Tool with high stability	B141

✔ Very suitable ✓ Suitable

Profile milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
BMR03		 XPHT20 XPHT25 XPHT30 XPHT32 XPHT40 XPHT50		✔	✓	✔				• Diameter range Ø16 – 40 mm • For steel and cast iron • Very suitable for roughing in mould and die industry • Tool with high stability	B145
BMR03		 XPHT16 XPHT20 XPHT25 XPHT30 XPHT32 XPHT40 XPHT50		✔	✓	✔				• Diameter range Ø16 – 40 mm • For steel and cast iron • Very suitable for roughing in mould and die industry • Tool with high stability	B143
BMR03		 XPHT40 XPHT50		✔	✓	✔				• Diameter range Ø16 – 40 mm • For steel and cast iron • Very suitable for roughing in mould and die industry • Tool with high stability	B147
BMR04		 ZOHX12 ZOHX16 ZOHX20 ZOHX25 ZOHX30 ZOHX32		✔	✓	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Very suitable for finishing in mould and die industry • Inserts with two cutting edges	B149
BMR04		 ZOHX12 ZOHX16 ZOHX20 ZOHX25 ZOHX30 ZOHX32		✔	✓	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Very suitable for finishing in mould and die industry • Inserts with two cutting edges	B151

✔ Very suitable ✓ Suitable

A Turning
B Milling
C Drilling
D Technical Information
E Index

Slot milling

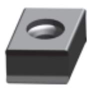
Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
SMP01		 XSEQ1202 XSEQ1203 XSEQ12T3 XSEQ1204 XSEQ12T4	90°	✔	✔	✔				• Diameter range Ø100 – 250 mm • For steel, stainless steel and cast iron • Bore with keyway • Groove widths 4, 5, 6, 7, 8 mm	B153
SMP01		 XSEQ1202 XSEQ1203 XSEQ12T3 XSEQ1204 XSEQ12T4	90°	✔	✔	✔				• Diameter range Ø63 – 160 mm • For steel, stainless steel and cast iron • Groove widths 4, 5, 6, 7, 8 mm	B155
SMP03		 MPHT0603 MPHT0803 MPHT1204	90°	✔	✔	✔				• Diameter range Ø80 – 200 mm • For steel, stainless steel and cast iron • Bore with keyway • Groove widths 8, 10, 12, 16, 18, 20 mm	B157
SMP03		 MPHT0603 MPHT0803 MPHT1204	90°	✔	✔	✔				• Diameter range Ø80 – 200 mm • For steel, stainless steel and cast iron • Groove widths 8, 10, 12, 16, 18, 20 mm	B159
SMP05		 QC16L QC22L	90°	✔	✔	✔				• Diameter range Ø25 – 44 mm • For steel, stainless steel and cast iron • Groove widths range 1,1 – 4,8 mm	B161

✔ Very suitable ✔ Suitable

High-feed milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
XMR01		 SDMT06T2 SDMT09T3 SDMT1204 SDMT1505	15°	✔	✓	✔				• Diameter range Ø20 – 40 mm • For steel, stainless steel and cast iron • Inserts with four cutting edges • Ramping possible • Double clamping system for inserts	B166
XMR01		 SDMT09T3 SDMT06T2 SDMT1204 SDMT1505	15°	✔	✓	✔				• Diameter range Ø40 – 125 mm • For steel, stainless steel and cast iron • Inserts with four cutting edges • Ramping possible • Double clamping system for inserts	B168
XMR01		 WPGT0503 WPGT0604	11°- 22°	✔	✓	✔				• Diameter range Ø20 – 40 mm • For steel, stainless steel and cast iron • Inserts with three cutting edges • Ramping possible • Double clamping system for inserts	B170
XMR01		 WPGT0604 WPGT0806 WPGT0907	11°- 22°	✔	✓	✔				• Diameter range Ø42 – 160 mm • For steel, stainless steel and cast iron • Inserts with three cutting edges • Ramping possible • Double clamping system for inserts	B172

Bore milling

Series	Milling body	Inserts	Kr	P	M	K	N	S	H	Features	Page
XMP01		 CNE12	90°	✔	✓	✔				• Diameter range Ø80 – 400 mm • For steel, stainless steel and cast iron • Also for face and square shoulder milling	B174

✔ Very suitable ✓ Suitable

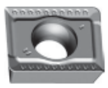
A Turning
B Milling
C Drilling
D Technical Information
E Index

A Turning
B Milling
C Drilling
D Technical Information
E Index

T-slot milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
TMP01		 MPHT0603 MPHT0803 MPHT1204	90°	✔	✔	✔				• Diameter range Ø21 – 60 mm • For cast iron • Groove widths 9, 11, 14, 18, 22, 28 mm	B176

Helical milling

Series	Milling body	Inserts	Kr	P	M	K	N	S	H	Features	Page
HMP01		 APKT1504 & SPMT1204	90°	✔	✔	✔				• Diameter range Ø40 – 50 mm • For steel and cast iron • Weldon shank	B178
HMP01		 APKT1504 & SPMT1204	90°	✔	✔	✔				• Diameter range Ø50 – 80 mm • For steel and cast iron • With JT coupling	B180
HMP01-EC		 APKT1504 & SPMT1204	90°	✔	✔	✔				• Diameter range Ø50 – 80 mm • For steel and cast iron • With JT coupling • With indexable head	B182

✔ Very suitable ✔ Suitable

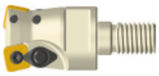
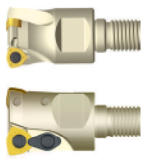
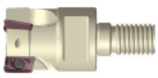
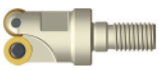
Chamfer milling

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
CMZ01		 SPMT1204	30°	✔	✔	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Chamfer milling cutter 30°	B184 B186
CMA01		 SPMT1204	45°	✔	✔	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Chamfer milling cutter 45° • Weldon shank	B188
CMA01		 SPMT1204	45°	✔	✔	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Chamfer milling cutter 45° • Weldon shank	B190
CMD01		 SPMT1204	60°	✔	✔	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Chamfer milling cutter 60° • Weldon shank	B192
CMD01		 SPMT1204	60°	✔	✔	✔				• Diameter range Ø12 – 32 mm • For steel, stainless steel and cast iron • Chamfer milling cutter 60° • Weldon shank	B194

✔ Very suitable ✔ Suitable

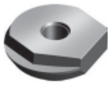
A Turning
B Milling
C Drilling
D Technical Information
E Index

Indexable heads - QCH series

Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
QCH-XPHT		 XPHT16 XPHT20 XPHT25 XPHT30 XPHT32		✓	✔	✓				• Diameter range Ø16 – 32 mm • For steel and cast iron • Very suitable for roughing in mould and die industry	B198
QCH-SDMT		 SDMT06T2 SDMT09T3 SDMT1204	15°	✓	✔	✓				• Diameter range Ø20 – 40 mm • For steel, stainless steel and cast iron • Inserts with four cutting edges • Ramping possible • Double clamping system for inserts	B200
QCH-WPGT		 WPGT0503 WPGT0604 WPGT0806	11°- 22°	✓	✔	✓				• Diameter range Ø16 – 42 mm • For steel, stainless steel and cast iron • Inserts with three cutting edges • Ramping possible • Double clamping system for inserts	B202
QCH-APKT		 APKT11T3 APKT1604	90°	✓	✓	✓	✓	✔		• Diameter range Ø16 – 40 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • For square shoulder milling, slot milling and ramping • Milling cutter with positive, soft cutting geometry • Inserts with two cutting edges	B204
QCH-RD		 RDKW0702 RDKW10T3 RDKW1605		✓	✔	✔			✔	• Diameter range Ø15 – 42 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry • For two different thicknesses of inserts	B206

✓ Very suitable ✔ Suitable

Indexable heads - QCH series

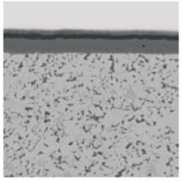
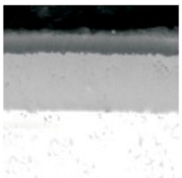
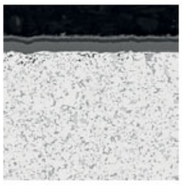
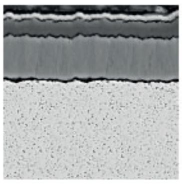
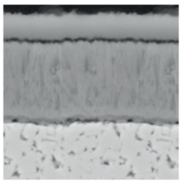
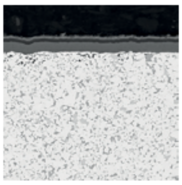
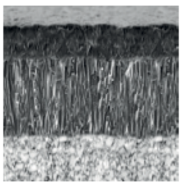
Series	Milling body	Inserts	Kr	Application P	M	K	N	S	H	Features	Page
QCH-RD		 RDKW0702 RDKW1003 RDKW12T3 RDKW1604		✔	✓	✓			✓	• Diameter range Ø15 – 42 mm • For steel, stainless steel and cast iron • Screw clamping • Mould and die industry • For two different thicknesses of inserts	B208
QCH-ZOHX		 ZOHX16 ZOHX20 ZOHX25 ZOHX30 ZOHX32		✔	✓	✔				• Diameter range Ø16 – 32 mm • For steel, stainless steel and cast iron • Very suitable for finishing in mould and die industry • Inserts with two cutting edges	B210

✔ Very suitable ✓ Suitable

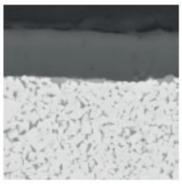
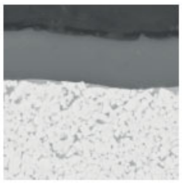
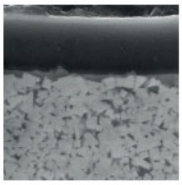
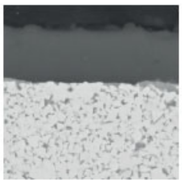
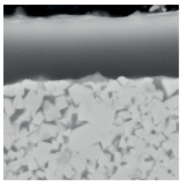
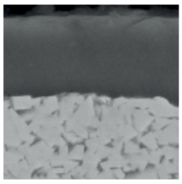
Chip breakers overview

	Finishing	Medium machining	Roughing
P	DF	DM	DR
	APF	APM	–
	PF	PM	PR
	GF	GM	GR
	–	–	ZR
	MO-2	MO-1	MO-3
M	EF	EM	–
	APF	APM	–
	DF	DM	–
	PF	PM	PR
	GF	GM	GR
	E	E	–
	–	–	ZR
K	CF	CM	CR
	DF	DM	DR
	EDFR	DER	DER
	PF	PM	PR
	GF	GM	GR
	–	–	ZR
	MO-2	MO-1	MO-3
S	EF	EM	–
	NM	NM	–
N	LH	LH	LH
	ALH	ALH	ALH

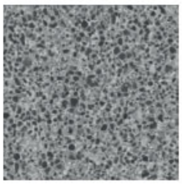
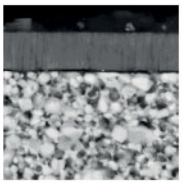
Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YBC301	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel at lower cutting speed.
YBC302	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel at higher cutting speed. Optimal performance of wear resistance and toughness for a wide application field.
YBC401	P30 - P50 M30 - M40		CVD coated P30–P50/M30–M40 carbide grade for roughing operation of steel at lower cutting speed and unstable condition.
YBM251	P20 - P30 M15 - M35		CVD coated P20–P30/M15–M35 carbide grade for medium to roughing operation in stainless steel and steel with wide application field. Good wear resistance and capability against plastic deformation at normal cutting speed.
YBM253	M15 - M35		CVD coated M15–M35 carbide grade for medium to roughing operation in stainless steel with wide application field. High wear resistance and capability against plasctic deformation at higher cutting speed.
YBM351	P25 - P40 M20 - M40		CVD coated P25–P40/M25–M40 carbide grade for roughing operation in stainless steel and steel. Good wear resistance and edge stability at normal cutting speed.
YBD152	K10 - K25		CVD coated K10–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Good wear resistance and toughness at higher cutting speed.
YBD252	K20 - K35		CVD coated K20–K35 carbide substrate. Optimized for medium to roughing operation of cast iron and Steel. Good wear resistance and toughness at higher cutting speed.

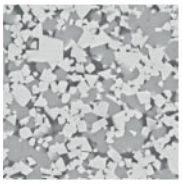
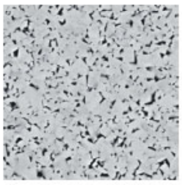
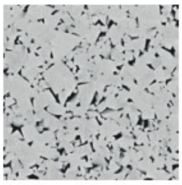
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG102	S05 - S15		PVD coated S05–S15 carbide substrate for finishing to medium application of super alloy material, stainless steel and aluminum. Good wear resistance in a wide application field.
YBG202	P10 - P30 M10-M25		PVD coated P10–P30/M10–M25 carbide substrate for finishing to medium application of stainless steel and steel (milling). Good wear resistance in a wide application field.
YB9320	P10 - P30 M10-M25		PVD multilayer coated P10–P30/M20–M40 carbide substrate for finishing to medium application of stainless steel, super alloy and steel (grooving/milling). Optimized coating stability for higher wear resistance and thermal stability in a wide application fi
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated P10–P30/M20–M40/S15–S25 carbide substrate for finishing to medium application of stainless steel, super alloy and steel (milling). Good wear resistance and thermal stability in a wide application field.
YBG302	P15 - P30 M25 - M40		PVD coated P15–P30/M25–M40 carbide substrate for medium roughing application of stainless steel and steel (milling). Good wear resistance and toughness.
YBG152	K20 - K35		PVD coated K20–K35 carbide substrate for medium roughing application of cast iron. Good wear resistance and toughness.
YBG252	P10 - P20 M10 - M20 K10 - K20		PVD coated P10–P20/M10–M20/K10–K20 carbide grade for finishing to medium operation of steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

Cermet

Grade	ISO	Micro structure	Grade description
YNG151	P05 - P15		Uncoated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good resistance against plastic deformation for good surface finishing.
YNG151C	P05 - P15		PVD coated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good wear resistance and capability against plastic deformation for good surface roughness.

Uncoated cemented carbide

Grade	ISO	Micro structure	Grade description
YC30S	P25 - P40 M25 - M40		Uncoated P25–P40/M25–M40 carbide substrate for roughing operation of steel and stainless steel.
YD101	N05 - N25 K05 - K20		Uncoated K05–K20/N05–N20 carbide substrate for fine to medium application in aluminum and other material.
YD201	K10 - K30 N10 - N30		Uncoated K10–K30/N10–N30 carbide substrate for medium application in aluminum and other material.

A Turning
B Milling
C Drilling
D Technical Information
E Index

Application fields of grades – Indexable milling

ISO		HC[1] (CVD)	HC[1] (PVD)	HT	HC[2]	HW	PCBN/PCD
P	P01, P10, P20, P30, P40	YBC301, YBC302, YBC401, YBM351, YBM253	YBG102, YBG202, YBG205, YBG252, YBG302, YB9320	YNG151	YNG151C	YC30S	
M	M01, M10, M20, M30, M40	YBM251, YBM253, YBM351, YBC401	YBG102, YBG202, YBG205, YBG252, YBG302, YB9320	YNG151	YNG151C	YC30S	
K	K01, K10, K20, K30, K40	YBD152, YBD252	YBG102, YBG152, YBG202, YBG252			YD201	
N	N01, N10, N20, N30		YBG101, YBG202			YD051, YD101, YD201	
S	S01, S10, S20, S30		YBG102, YBG202, YBG205				
H	H01, H10, H20, H30		YBG102				

P	Steel	N	Non-ferrous metals
M	Stainless steel	S	Heat-resistant alloys
K	Cast iron	H	Hardened materials

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated carbide
HW Uncoated carbide

ZCC·CT


New
EMP13

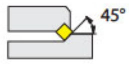
FM	E	03	100	–	B32	S	–	P	12	–	06	(L)	(C)
1	2	3	4		5	6		7	8		9	10	11

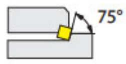
Type

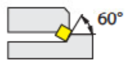
Code	Description
BM	Profile milling
CM	Chamfer milling
EM	Square shoulder milling
FM	Face milling
HM	Helical milling
SM	Slot milling
TM	T-slot milling
XM	Special

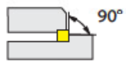
1

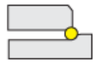
Entering angle

A 

E 

D 

P 

R 

2

Nominal diameter [mm]

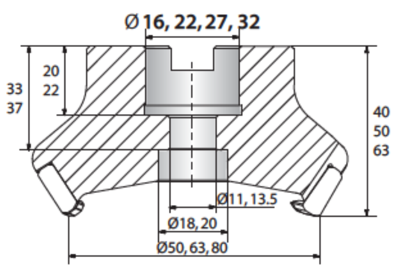
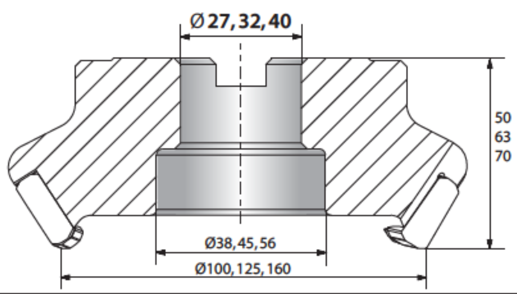
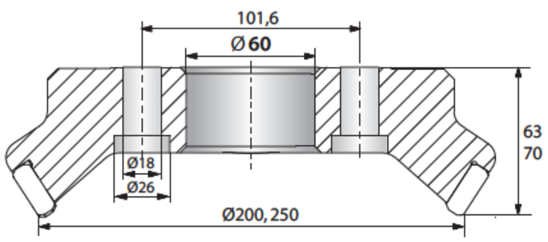
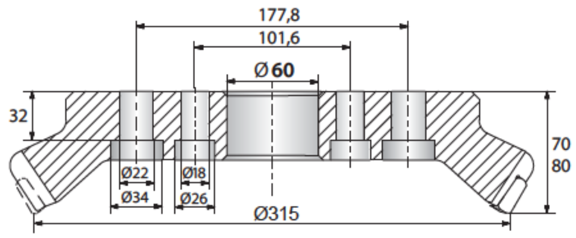
Code	Description
025	25
050	50
160	160
315	315
...	

4

Serial number

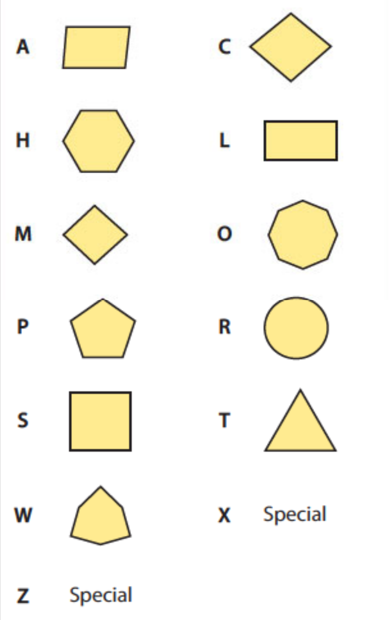
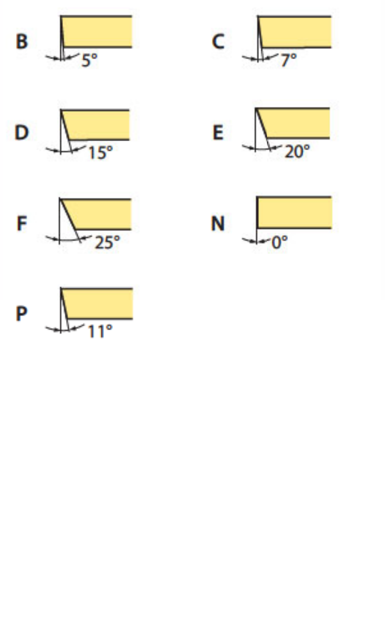
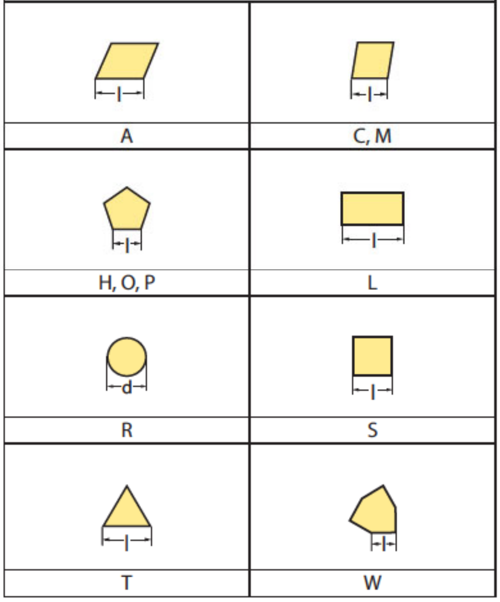
3

Type and size of tool holders

Code	Type	Code	Type
A	Nominal diameter Ø50–80 mm 	B	Nominal diameter Ø100–160 mm 
C	Nominal diameter Ø200–250 mm 	D	Nominal diameter Ø315 mm 
G	Straight shank	XP	Weldon shank
K	Bore with keyway		

5

With respect to mounting please adhere to the information provided by the tool holder manufacturer.

Insert shape	Clearance angle	Cutting edge length l [mm]
		
6	7	8

Number of teeth	Cutting direction	With inner cooling
	Code: **L** – Description: Left	
9	10	11

Tools with B coupling and inner coolant supply require the following spare parts:

Coolant clamp screw

Coolant shower plate

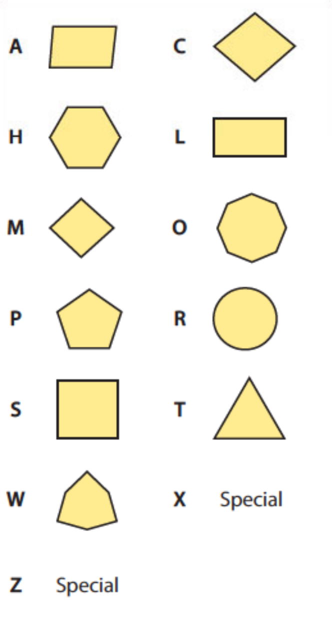
Spare parts (B coupling with inner coolant supply)

		B27	B32	B40	B40
	Ø	**80**	**100**	**125**	**160**
	**Coolant clamp screw**	LDB27C	LDB32C	LDB40C	LDB40C
	**Coolant shower plate**	B27-002-CP	B32-002-CP	B40-002-CP	B40-003-CP

When purchasing tools with inner coolant supply and B coupling these spare parts are included in delivery.

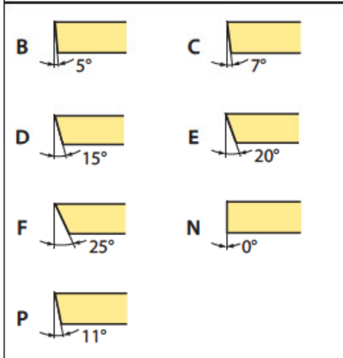
S	P	K	N	12	04	ED	T21K	R	–	DM
1	2	3	4	5	6	7	8	9		10

Insert shape



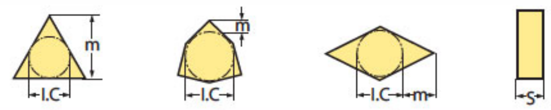
1

Clearance angle



2

Tolerance class

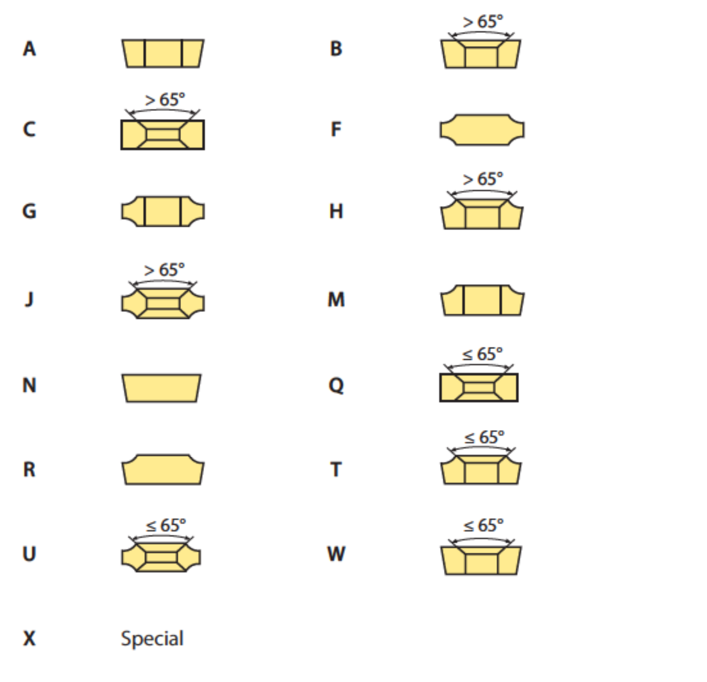


Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,13	±0,005	±0,025
K	±0,05–0,13	±0,013	±0,025
L	±0,05–0,13	±0,025	±0,025
M	±0,05–0,13	±0,08–0,18	±0,130
N	±0,05–0,13	±0,08–0,18	±0,025
U	±0,08–0,25	±0,13–0,38	±0,130

3

Fastening features (metric)

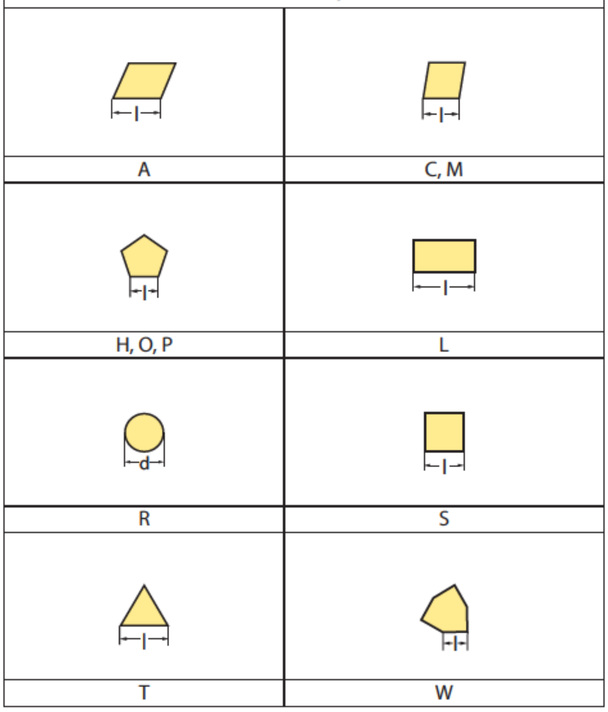
Insert shape



4

Cutting edge length l [mm]

Insert shape

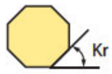


5

ZCC·CT

Insert thickness S [mm]			
			
Code	S	Code	S
00	0,79	**05**	5,56
T0	0,99	**T5**	5,95
01	1,59	**06**	6,35
T1	1,98	**T6**	6,75
02	2,38	**07**	7,94
T2	2,58	**09**	9,52
03	3,18	**T9**	9,72
T3	3,97	**11**	11,11
04	4,76	**12**	12,70
T4	4,96		

6

Angle			
			
Code	Kr	Code	an
A	45°	**A**	3°
D	60°	**B**	5°
E	75°	**C**	7°
F	85°	**D**	15°
P	90°	**E**	20°
Z	Special	**F**	25°
		G	30°
		N	0°
		P	11°
		Z	Special

7

Chamfer							
Code	Type	Code	Angle	Code	Width [mm]	Code	Position
F		**0**	5°	**0**	0,10	**K**	
E		**1**	10°	**1**	0,15	**P**	
T		**2**	15°	**2**	0,20	**W**	
S		**3**	20°	**3**	0,25	**–**	
		4	25°	**4**	0,30		
		5	30°	**5**	0,35		
				6	0,40		
				7	0,45		

8

Cutting direction	
Code	Description
R	Right
L	Left
N	Right and left

9

Chip breaker overview (on page B20)

10

A Turning
B Milling
C Drilling
D Technical Information
E Index

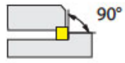
SM	P	03	–	160 ×	16	–	K	40	–	M	P	12	–	12	L
1	2	3		4	5		6	7		8	9	10		11	12

Type

Code	Description
SM	Slot milling cutter

1

Entering angle

P 

2

Serial number

3

Nominal diameter [mm]

4

Cutting width [mm]

5

Tool holder type

Code	Description	Code	Description
A	A type	B	B type
C	C type	D	D type
K	With feather key		

6

Diameter of mounting hole [mm]

7

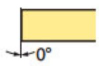
Insert shape

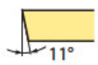
M 

S 

8

Clearance angle

N 

P 

9

Insert size [mm]

10

Number of teeth

11

Cutting direction

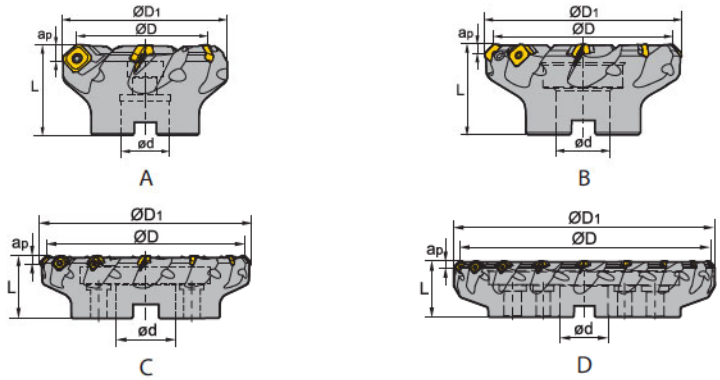
Code	Description
R	Right
L	Left

12

Face milling

FMA01 Kr: 45°

Fine pitch



Article	✲	Stock R	Stock L	Dimensions [mm] ØD	ØD1	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMA01-050-A22-SE12-04		●	○	50	61	22	40	6	4	A	0.3	
FMA01-050-A22-SE12-04C	✲	●	○	50	61	22	40	6	4	A	0.3	
FMA01-063-A22-SE12-05		●		63	74	22	40	6	5	A	0.5	
FMA01-063-A22-SE12-05C	✲	●	○	63	74	22	40	6	6	A	1.2	
FMA01-080-A27-SE12-06		●	●	80	91	27	50	6	6	A	1.2	
FMA01-080-A27-SE12-06C	✲	●	○	80	91	27	50	6	6	A	1.2	
FMA01-100-B32-SE12-07		●	○	100	107	32	50	6	7	B	1.2	
FMA01-100-B32-SE12-07C	✲	○	○	100	107	32	50	6	7	B	1.2	SEET12T3
FMA01-125-B40-SE12-08		●	●	125	136	40	63	6	8	B	2.6	
FMA01-125-B40-SE12-08C	✲	○		125	136	40	63	6	8	B	2.6	
FMA01-160-B40-SE12-10		●	●	160	170	40	63	6	10	B	4.3	
FMA01-160-B40-SE12-10C	✲	○		160	170	40	63	6	10	B	4.3	
FMA01-200-C60-SE12-12		●	○	200	210	60	63	6	12	C	7.6	
FMA01-250-C60-SE12-14		●	○	250	260	60	63	6	14	C	13.5	
FMA01-315-D60-SE12-18		●	○	315	325	60	70	6	18	D	20.8	
FMA01-100-B32-SE18-04		○	○	100	120	32	63	10	4	B	1.2	
FMA01-125-B40-SE18-05		○	○	125	145	40	63	10	5	B	2.6	
FMA01-160-C40-SE18-06		○	○	160	180	40	63	10	6	C	4.3	SEET18T6
FMA01-200-C60-SE18-08		●	○	200	220	60	63	10	8	C	7.6	
FMA01-250-C60-SE18-10		●		250	270	60	63	10	10	C	13.5	
FMA01-315-D60-SE18-12		○	○	315	335	60	80	10	12	D	20.8	

● Ex stock ○ On demand

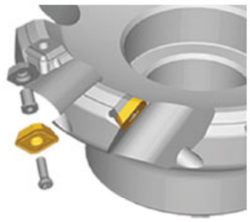
✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning | B Milling | C Drilling | D Technical Information | E Index

Spare parts

	Insert	SEET12T3	SEET12T3	SEET18T6
	ØD	50-100	125 - 315	100- 315
	Screw (insert)	I60M3.5*10 (2.7 Nm)	I60M3.5*12 (2.7 Nm)	I60M5*17 (6.7 Nm)
	Screw (shim)		SM5*7XA	SM8*9XA
	Shim		S13BS	S18BS
	Wrench (insert)	WT15IS	WT15IS	
	Wrench (insert)			WT20IT
	Wrench (shim)		WH35L	WH50L

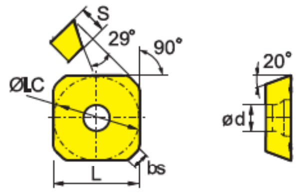


Milling inserts

○ Ideal machining conditions
⊛ Normal machining conditions
✻ Unfavourable machining conditions

SEET	L	I.C	S	d
12 T3	13.4	13.4	3.97	4.1
18 T6	18	18	6.1	5.5

SE** milling insert



ISO	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P		⊛	⊛	✻	⊛	⊛	✻		⊛			⊛	⊛	⊛	✻	✻		○	○	○		
M			⊛	✻	⊛	⊛	✻					⊛	⊛	⊛	✻	✻		○	○	○		
K								⊛	✻		○						⊛	○				✻
N										⊛											⊛	✻
S					✻		✻				○	⊛	⊛	⊛								
H																						
SEET12T3-CF	2.55							●			●											
SEET12T3-CM	2.55							●			●											
SEET12T3-CR	2.55							●	●		○											
SEET12T3-DF	2.55	●	●			●	●							●		○			○	○		
SEET12T3-DM	2.55	●	●	●	●	●	●					●		●		●						
SEET18T6-DM	2.29	●			●																	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

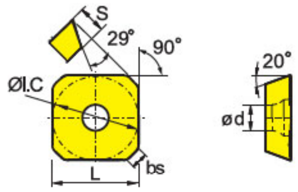
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Milling inserts

◎ Ideal machining conditions
✲ Normal machining conditions
✺ Unfavourable machining conditions

SEET	L	I.C	S	d
12 T3	13.4	13.4	3.97	4.1
18 T6	18	18	6.1	5.5

SE** milling insert



		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P		✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◎	◎	◎		
M			✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◎	◎	◎		
K								✲	✺		◎						✲	◎				✺
N										✲											✲	✺
S					✺		✺				◎	✲	✲	✲								
H																						
ISO	bs																					
 SEET12T3-DR	2.55		●	●			●		○					○		○						
 SEET12T3-EF	2.55													○		●						
 SEET12T3-EM	2.55					●	●							○		●						
 SEET12T3-LH	2.55									○											●	●

● Ex stock ○ On demand

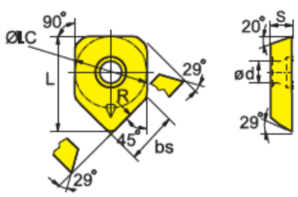
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Milling inserts

◎ Ideal machining conditions
✲ Normal machining conditions
✺ Unfavourable machining conditions

SEET	L	I.C	S	d
12 T3	17.82	13.4	3.97	4.1

SE** milling insert



			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
			YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P			✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◎	◎	◎		
M				✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◎	◎	◎		
K									✲	✺		◎						✲	◎				✺
N											✲											✲	✺
S						✺		✺				◎	✲	✲	✲								
H																							
ISO	R	bs																					
 SEET12T3-W	500	9.46							○						●					○	○		

● Ex stock ○ On demand

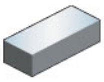
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

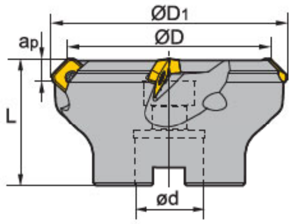
A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

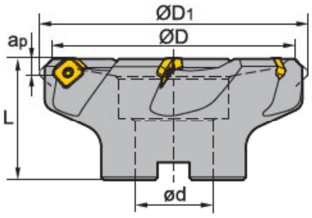
FMA02 Kr: 45°



Coarse and differential pitch



A



B

Article	✻	Stock	Dimensions [mm] ØD	ØD1	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts 
FMA02-050-A22-SE12-03		●	50	61	22	40	6	3	A	0.4	SEET12T3
FMA02-063-A22-SE12-04		●	63	74	22	40	6	4	A	0.6	
FMA02-080-A27-SE12-04		●	80	91	27	50	6	4	A	1.3	
FMA02-100-B32-SE12-05		●	100	107	32	50	6	5	B	1.3	
FMA02-125-B40-SE12-06		○	125	131	40	63	6	6	B	2.6	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	SEET12T3
	ØD	50-125
	Screw (insert)	I60M3.5*10 (2.7 Nm)
	Wrench (insert)	WT15IS

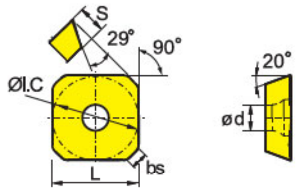
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
✱ Unfavourable machining conditions

SEET	L	I.C	S	d
12 T3	13.4	13.4	3.97	4.1

SE** milling insert



ISO		bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
		P	✿	✿	✱	✿	✿	✱		✿			✿	✿	✿	✱	✱		◯	◯	◯		
		M		✿	✱	✿	✿	✱					✿	✿	✿	✱	✱		◯	◯	◯		
		K							✿	✱		◯						✿	◯				✱
		N									✿											✿	✱
		S				✱		✱				◯	✿	✿	✿								
		H																					
	SEET12T3-CF	2.55							●			●											
	SEET12T3-CM	2.55							●			●											
	SEET12T3-CR	2.55							●	●		○											
	SEET12T3-DF	2.55	●	●			●	●							●		○			○	○		
	SEET12T3-DM	2.55	●	●	●	●	●	●					●		●		●						
	SEET12T3-DR	2.55		●	●			●		○					○		○						
	SEET12T3-EF	2.55													○		●						
	SEET12T3-EM	2.55					●	●							○		●						
	SEET12T3-LH	2.55									○											●	●

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

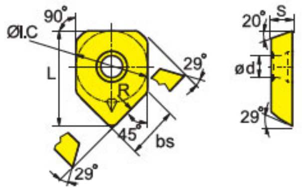
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SEET	L	I.C	S	d
12 T3	17.82	13.4	3.97	4.1

SE** milling insert



	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
Group	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	R	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SEET12T3-W	500	9.46							○						●					○	○		

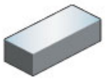
● Ex stock ○ On demand

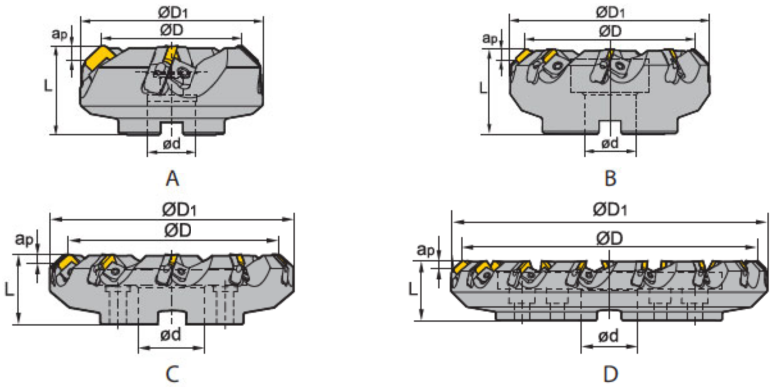
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Face milling

FMA03 Kr: 45°





Article	With internal cooling	Stock R	Stock L	ØD	ØD$_1$	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMA03-080-A27-SE12-04		○	○	80	103	27	50	5.5	4	A	1.8	SEEN1203 SEKN1203 SEKR1203
FMA03-100-B32-SE12-05		○	○	100	122	32	50	5.5	5	B	2.4	
FMA03-125-B40-SE12-06		○	○	125	147	40	63	5.5	6	B	4.4	
FMA03-160-B40-SE12-08		○	○	160	181	40	63	5.5	8	B	6.4	
FMA03-200-C60-SE12-10		○	○	200	221	60	63	5.5	10	C	8.5	
FMA03-250-C60-SE12-12		○	○	250	270	60	63	5.5	12	C	14.1	
FMA03-315-D60-SE12-15		○	○	315	353	60	63	5.5	15	D	22.2	
FMA03-080-A27-SE15-04		○		80	103	27	50	7.5	4	A	1.7	SEKN1504 SEKR1504
FMA03-100-B32-SE15-05		○		100	122	32	50	7.5	5	B	2.3	
FMA03-125-B40-SE15-06		○		125	147	40	63	7.5	6	B	4.2	
FMA03-160-B40-SE15-08		○		160	181	40	63	7.5	8	B	6.1	
FMA03-200-C60-SE15-10		○		200	221	60	63	7.5	10	C	8.3	
FMA03-250-C60-SE15-12		○		250	270	60	63	7.5	12	C	13.6	
FMA03-315-D60-SE15-15		○	○	315	353	60	63	7.5	15	D	21.8	

● Ex stock ○ On demand

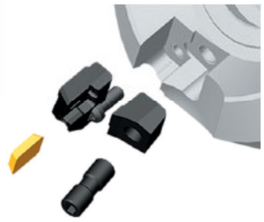
✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Spare parts

	Insert	SEEN1203 SEKN1203 SEKR1203	SEKN1504 SEKR1504
	ØD	**80- 315**	**80- 315**
	Adjustable screw	LOM5*15.1	LOM5*15.1
	Cassette (left)	LSE12L	LSE15L
	Cassette (right)	LSE12R	LSE15R
	Screw (wedge)	DM8*21X (10.2 Nm)	DM8*21X (10.2 Nm)
	Wedge (left)	W01L	W01L
	Wedge (right)	W01R	W01R
	Wrench (locator)	WT20T	WT20T
	Wrench (wedge)	WH40T	WH40T

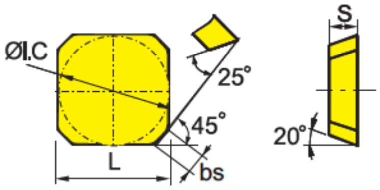


Milling inserts

◯ Ideal machining conditions
❂ Normal machining conditions
✻ Unfavourable machining conditions

SEEN	L	I.C	S
12 03	12.7	12.7	3.18

SE** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	❂	❂	✻	❂	❂	✻		❂			❂	❂	❂	✻	✻		◯	◯	◯		
M		❂	✻	❂	❂	✻					❂	❂	❂	✻	✻		◯	◯	◯		
K							❂	✻		◯						❂	◯				✻
N									❂											❂	✻
S				✻		✻				◯	❂	❂	❂								
H																					

	ISO	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SEEN1203AFTN	1.8																		●			

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

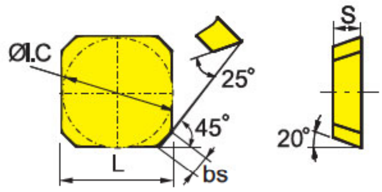
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- ● (plain) Ideal machining conditions
- ● (patterned) Normal machining conditions
- ● (dense pattern) Unfavourable machining conditions

SEKN	L	I.C	S
12 03	12.7	12.7	3.18
15 04	15.875	15.875	4.76

SE** milling insert



SE** milling insert		HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
	N									Normal											Normal	Unfavourable
	S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
	H																					
ISO	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
SEKN1203AFN	1.8		○																			
SEKN1203AFTN	1.8		●		●	●	●							○					●	●		○
SEKN1504AFTN	1.6		●	○		●	●					●										
SEKN1504AZ	1.6		●																			○

● Ex stock ○ On demand

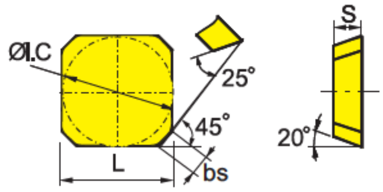
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Milling inserts

- ● (plain) Ideal machining conditions
- ● (patterned) Normal machining conditions
- ● (dense pattern) Unfavourable machining conditions

SEKR	L	I.C	S
12 03	12.7	12.7	3.18

SE** milling insert



SE** milling insert		HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
	N									Normal											Normal	Unfavourable
	S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
	H																					
ISO	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
SEKR1203AFN	1.8		●											○								

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

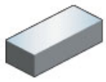
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning | B Milling | C Drilling | D Technical Information | E Index

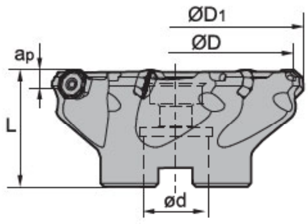
A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

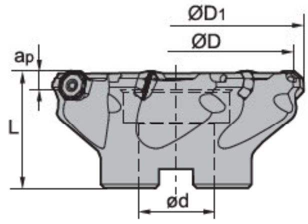
FMA04 Kr: 45°



Screw Clamping



A



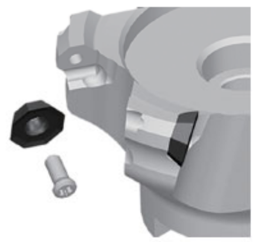
B

Article	✲	Stock		Dimensions [mm]					Teeth	Coupling	kg	Inserts
		R	L	ØD	$ØD_1$	ød	L	$a_{p\,max}$				
FMA04-050-A22-OF05-04		●		50	56	22	40	3.5	4	A	0.3	OFKT05T3
FMA04-050-A22-OF05-05		●		50	56	22	40	3.5	5	A	0.4	
FMA04-050-A22-OF05-05C	✲	○		50	56	22	40	3.5	5	A	0.4	
FMA04-063-A22-OF05-05		●		63	69	22	40	3.5	5	A	0.5	
FMA04-063-A22-OF05-05C	✲	○		63	69	22	40	3.5	5	A	0.5	
FMA04-080-A27-OF05-06		●	○	80	86	27	50	3.5	6	A	0.8	
FMA04-080-A27-OF05-06C	✲	●		80	86	27	50	3.5	6	A	0.8	
FMA04-100-B32-OF05-07		●	○	100	106	32	50	3.5	7	B	1.2	
FMA04-100-B32-OF05-07C	✲	○		100	106	32	50	3.5	7	B	1.2	
FMA04-125-B40-OF05-08		●		125	130	40	63	3.5	8	B	2.7	
FMA04-125-B40-OF05-08C	✲	○		125	130	40	63	3.5	8	B	2.7	
FMA04-160-B40-OF05-10		●		160	165	40	63	3.5	10	B	5.1	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts			
	Insert	OFKT05T3	OFKT05T3
	ØD	50-63	80-160
	Screw (insert)	I60M4*8.4 (3.4 Nm)	I60M4*10 (3.4 Nm)
	Wrench (insert)	WT15IS	WT15IS



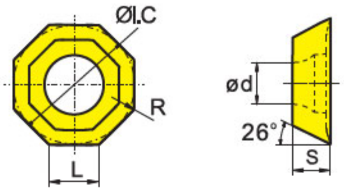
System code B26 Grade selection B24 Technical info B463 Cutting data B224

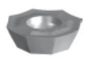
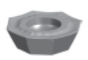
Milling inserts

○ Ideal machining conditions
❂ Normal machining conditions
✱ Unfavourable machining conditions

OFKT	L	I.C	S	d
05 T3	5.26	12.7	3.97	4.4

OF** milling insert



		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	❂	❂	✱	❂	❂	✱		❂			❂	❂	❂	✱	✱		○	○	○		
	M		❂	✱	❂	❂	✱					❂	❂	❂	✱	✱		○	○	○		
	K							❂	✱		○						❂	○				✱
	N									❂											❂	✱
	S				✱		✱				○	❂	❂	❂								
	H																					
ISO	R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
 **OFKT05T3-DF**	0.5										●			●								
 **OFKT05T3-DM**	0.5					○		●			●			●		●						
 **OFKT05T3-LH**	0.5																				●	

● Ex stock ○ On demand

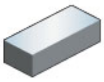
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

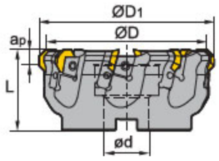
ZCC·CT

Face milling

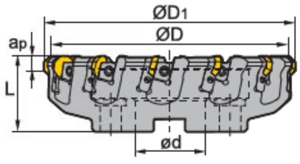
FMA04 Kr: 45°



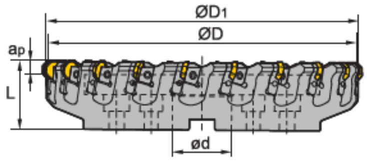
Wedge



B



C



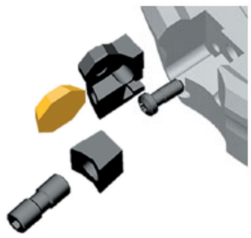
D

Article	✻	Stock		Dimensions [mm]					Teeth	Coupling	kg	Inserts
		R	L	ØD	$ØD_1$	ød	L	$a_{p\,max}$				
FMA04-125-B40-OF07-08		●		125	136	40	63	5	8	B	3.9	OFKR0704
FMA04-160-B40-OF07-10		●		160	171	40	63	5	10	B	5.9	OFKR0704
FMA04-200-C60-OF07-12		●		200	211	60	63	5	12	C	7.6	OFKR0704
FMA04-250-C60-OF07-16		●		250	261	60	63	5	16	C	13.3	OFKR0704
FMA04-315-D60-OF07-20		○	○	315	321	60	63	5	20	D	20.3	OFKR0704

● Ex stock ○ On demand

✻ With internal cooling

Spare parts	
Insert	**OFKR0704**
ØD	**125 - 315**
Adjustable screw	LOM5*15.1
Cassette (left)	LOF07L
Cassette (right)	LOF07R
Screw (wedge)	DM8*21X (10.2 Nm)
Wedge (left)	W02L
Wedge (right)	W02R
Wrench (locator)	WT20T
Wrench (wedge)	WH40T



System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

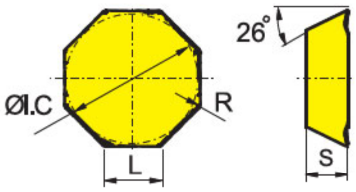
ZCC·CT

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

OFKR	L	I.C	S
07 04	7.45	17.94	4.76

OF** milling insert



ISO	R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
	N									Normal											Normal	Unfavourable
	S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
	H																					
 **OFKR0704-DF**	0.8					○								●								
OFKR0704-DM 	0.8		●	●		●	●		●					○		●						
OFKR0704W-DM	0.8		○						○				●									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Notes

FMA07 Kr: 45°

Face mill

- High cost-benefit factor due to 16 cutting edges.
- Thick insert for best stability and break resistance.
- Different chip breakers for best chip breaking.
- Two insert sizes available.

Insert grades

YBC302	YBG202	YBM253	YBM351
CVD *P15–P35*	*PVD* *P10–P30*	*CVD* *P20–P40*	*CVD* *P25–P40*

YBG205	YB9320	YBD152
PVD *P10–P30* *M20–M30*	*PVD* *P15–P25* *M20–M30*	*CVD* *K05–K25*

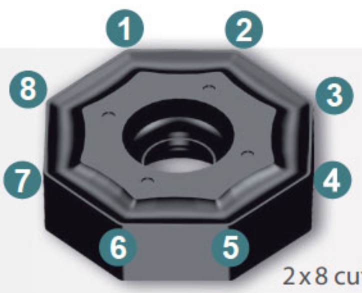
Chip breakers

-PF

- Low cutting forces
- Very sharp

-PM

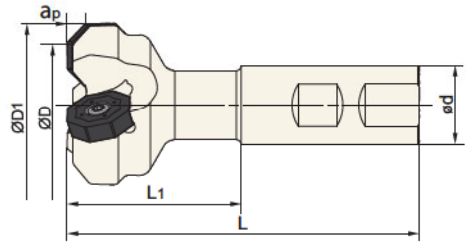
- General application
- Good balance between stability and sharpness



2 x 8 cutting edges

Face milling

FMA07 Kr: 45°



Weldon shank

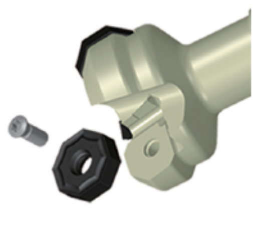
Article	✻	Stock	Dimensions [mm]						Teeth	kg	Inserts
			ØD	$ØD_1$	ød	L_1	L	$a_{p\,max}$			
FMA07-025-XP20-ON06-02		○	25	37	20	45	95	4	2	0.2	ONHU0604
FMA07-025-XP20-ON06-02C	✻	○	25	37	20	45	95	4	2	0.2	ONHU0604
FMA07-032-XP25-ON06-02C	✻	●	32	44	25	55	111	4	2	0.4	ONHU0604
FMA07-040-XP25-ON06-03		○	40	52	25	50	106	4	3	0.4	ONHU0604
FMA07-032-XP25-ON08-02		●	32	47	25	55	111	5	2	0.4	ONHU08T5
FMA07-040-XP25-ON08-03		●	40	55	25	55	111	5	3	0.5	ONHU08T5
FMA07-040-XP25-ON08-03C	✻	●	40	55	25	55	111	5	3	0.5	ONHU08T5
FMA07-050-XP25-ON08-04		●	50	65	25	55	111	5	4	0.6	ONHU08T5

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

Insert	ONHU0604	ONHU08T5
ØD	**25-40**	**32-50**
Screw (insert)	I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)
Wrench (insert)	WT15IS	
Wrench (insert)		WT20IT



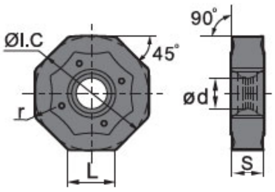
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- ◯ Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

ONHU	L	I.C	S	d
06 04	6.58	15.875	4.76	4.4
08 T5	8.39	20.2	5.77	5.3

ON** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfav.	Normal	Normal	Unfav.		Normal			Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
M		Normal	Unfav.	Normal	Normal	Unfav.					Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
K							Normal	Unfav.		Ideal						Normal	Ideal				Unfav.
N									Normal											Normal	Unfav.
S				Unfav.		Unfav.				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ONHU060408-PF**	0.8	○			○			●						●								
	ONHU08T508-PF	0.8	●			●			○				●		●								
	**ONHU060408-PM**	0.8	●			●		●	●					●									
	ONHU08T508-PM	0.8	●			●		●	●														

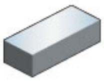
● Ex stock ○ On demand

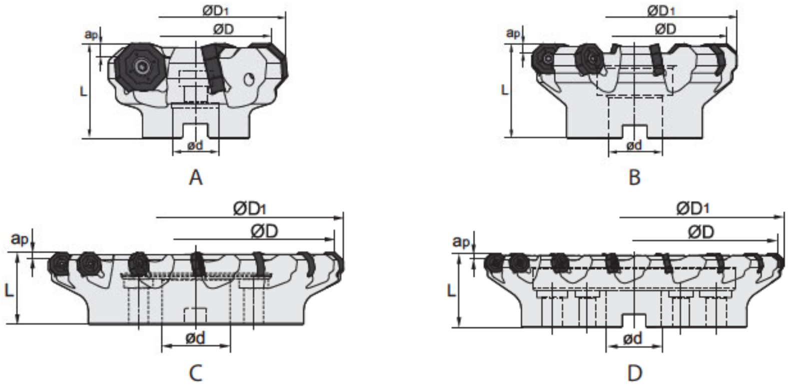
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Face milling

FMA07 Kr: 45°





Article	✲	Stock R	Stock L	ØD	$ØD_1$	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMA07-050-A22-ON06-05		●	○	50	62	22	40	4	5	A	0.3	ONHU0604
FMA07-050-A22-ON06-05C	✲	●		50	62	22	40	4	5	A	0.3	ONHU0604
FMA07-063-A22-ON06-06		○		63	75	22	40	4	6	A	0.5	ONHU0604
FMA07-063-A22-ON06-06C	✲	●		63	75	22	40	4	6	A	0.5	ONHU0604
FMA07-080-A27-ON06-07C	✲	●		80	92	27	50	4	7	A	1	ONHU0604
FMA07-080-B27-ON06-07		●		80	92	27	50	4	7	B	1	ONHU0604
FMA07-100-B32-ON06-08		●		100	112	32	63	4	8	B	1.9	ONHU0604
FMA07-100-B32-ON06-08C	✲	●		100	112	32	63	4	8	B	1.9	ONHU0604
FMA07-125-B40-ON06-09		●		125	137	40	63	4	9	B	3.5	ONHU0604
FMA07-125-B40-ON06-09C	✲	●		125	137	40	63	4	9	B	3.5	ONHU0604
FMA07-160-C40-ON06-11		○	○	160	172	40	63	4	11	C	4.3	ONHU0604
FMA07-200-C60-ON06-13		○		200	212	60	63	4	13	C	6.4	ONHU0604
FMA07-250-C60-ON06-15		○		250	262	60	63	4	15	C	13.4	ONHU0604
FMA07-315-D60-ON06-17		○		315	327	60	80	4	17	D	21.9	ONHU0604
FMA07-063-A22-ON08-05		●		63	78	22	40	5	5	A	0.5	ONHU08T5
FMA07-063-A22-ON08-05C	✲	●		63	78	22	40	5	5	A	0.5	ONHU08T5
FMA07-080-A27-ON08-06C	✲	●		80	95	27	50	5	6	A	0.9	ONHU08T5
FMA07-080-B27-ON08-06		●	○	80	95	27	50	5	6	B	0.9	ONHU08T5
FMA07-100-B32-ON08-07		●		100	115	32	63	5	7	B	1.8	ONHU08T5
FMA07-100-B32-ON08-07C	✲	●		100	115	32	63	5	8	B	3.1	ONHU08T5
FMA07-125-B40-ON08-08		●	○	125	140	40	63	5	8	B	3.1	ONHU08T5
FMA07-125-B40-ON08-08C	✲	●		125	140	40	63	5	8	B	3.1	ONHU08T5
FMA07-160-C40-ON08-10		●	○	160	175	40	63	5	10	C	4.1	ONHU08T5
FMA07-200-C60-ON08-12		●	○	200	215	60	63	5	12	C	6.1	ONHU08T5
FMA07-250-C60-ON08-14		●	○	250	265	60	63	5	14	C	12	ONHU08T5
FMA07-315-D60-ON08-16		●	○	315	330	60	80	5	16	D	21	ONHU08T5

● Ex stock ○ On demand

✲ With internal cooling

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

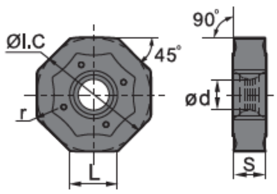
ZCC·CT

Spare parts	Insert	ONHU0604	ONHU08T5
	ØD	**50- 315**	**63- 315**
	Screw (insert)	I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT15IS	
	Wrench (insert)		WT20IT

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

ONHU	L	I.C	S	d
06 04	6.58	15.875	4.76	4.4
08 T5	8.39	20.2	5.77	5.3

ON** milling insert			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
		P	✿	✿	❋	✿	✿	❋		✿			✿	✿	✿	❋	❋		◯	◯	◯		
		M		✿	❋	✿	✿	❋					✿	✿	✿	❋	❋		◯	◯	◯		
		K							✿	❋		◯						✿	◯				❋
		N									✿											✿	❋
		S				❋		❋				◯	✿	✿	✿								
		H																					
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ONHU060408-PF**	0.8	○			○			●						●								
	ONHU08T508-PF	0.8	●			●			○				●		●								
	**ONHU060408-PM**	0.8	●			●		●	●					●									
	ONHU08T508-PM	0.8	●			●		●	●														

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Notes

FMA11 Kr: 45°

New face mill generation

- Double sided, extra thick insert with 8 cutting edges.
- Large rake angle reduces cutting forces.
- More stability for larger cutting depths.
- Wiper geometry for better surface quality.

Insert grades

YBC302	YBM253	YBD152
CVD *P15 – P35*	*CVD* *P20 – P40*	*CVD* *K05 – K25*
YBD252	**YBG205**	**YB9320**
CVD *K15 – K35*	*PVD* *P10 – P30* *M20 – M30*	*PVD* *P15 – P25* *M20 – M30*

8 cutting edges

Chip breakers

-GM

- General machining

-GR

- Stable cutting edge

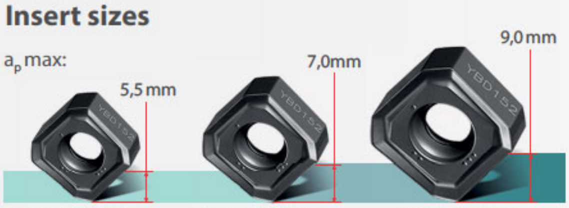
-E

- Sharp cutting edge
- First choice for stainless steel

-W

- Wiper geometry for best surface quality

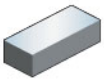
Insert sizes

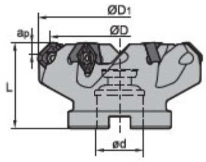


SNEG1205ANR-GM/GR
SNEG1506ANR-GM/GR
SNEG1907ANR-GR

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

FMA11 Kr: 45° 



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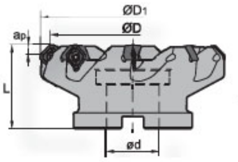
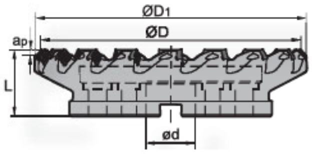


B



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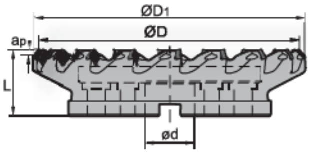


D

Article	✲	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ØD$_1$	ød	L	$a_{p\,max}$				
FMA11-063-A22-SN12-05		●	63	74.47	22	40	5.5	5	A	0.55	
FMA11-063-A22-SN12-06		●	63	74.47	22	40	5.5	6	A	0.58	
FMA11-080-A27-SN12-06		●	80	91.47	27	50	5.5	6	A	1.14	
FMA11-100-B32-SN12-07		●	100	111.47	32	50	5.5	7	B	1.42	
FMA11-100-B32-SN12-07C	✲	○	100	111.47	32	50	5.5	7	B	1.42	
FMA11-100-B32-SN12-10C	✲	●	100	111.47	32	50	5.5	10	B	1.42	SNEG1205
FMA11-125-B40-SN12-08		●	125	136.47	40	63	5.5	8	B	2.86	
FMA11-125-B40-SN12-08C	✲	○	125	136.47	40	63	5.5	8	B	2.86	
FMA11-125-B40-SN12-12C	✲	●	125	136.47	40	63	5.5	12	B	2.86	
FMA11-160-C40-SN12-10		●	160	171.47	40	63	5.5	10	C	4.06	
FMA11-160-C40-SN12-15		●	160	171.47	40	63	5.5	15	C	4.06	
FMA11-200-C60-SN12-14		●	200	212.08	60	63	5.5	14	C	6.89	
FMA11-063-A22-SN15-05		●	63	77.4	22	40	7	5	A	0.56	
FMA11-080-A27-SN15-06		●	80	94.4	27	50	7	6	A	1.06	
FMA11-100-B32-SN15-07		●	100	114.4	32	50	7	7	B	1.47	
FMA11-100-B32-SN15-07C	✲	○	100	114.4	32	50	7	7	B	1.47	
FMA11-100-B32-SN15-09C	✲	●	100	114.4	32	50	7	9	B	1.47	
FMA11-125-B40-SN15-08		●	125	139.4	40	63	7	8	B	2.7	
FMA11-125-B40-SN15-08C	✲	○	125	139.4	40	63	7	8	B	2.7	SNEG1506
FMA11-125-B40-SN15-10C	✲	●	125	140.25	40	63	7	10	B	3.1	
FMA11-160-C40-SN15-10		●	160	174.4	40	63	7	10	C	3.92	
FMA11-160-C40-SN15-13		●	160	175.25	40	63	7	13	C	4.14	
FMA11-200-C60-SN15-12		●	200	214.4	60	63	7	12	C	5.46	
FMA11-250-C60-SN15-14		●	250	264.4	60	63	7	14	C	11.26	
FMA11-315-D60-SN15-18		○	315	329.4	60	80	7	18	D	20	
FMA11-125-B40-SN19-07		●	125	142.63	40	63	9	7	B	3	
FMA11-125-B40-SN19-07C	✲	●	125	142.63	40	63	9	7	B	3	SNEG1907
FMA11-160-C40-SN19-09		●	160	167.63	40	63	9	9	C	4.25	
FMA11-200-C60-SN19-11		●	200	217.63	60	63	9	11	C	6.18	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 Grade selection B24 Technical info B463 Cutting data B224

ZCC·CT

Article	✲	Stock	Dimensions [mm] ØD	ØD1	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMA11-250-C60-SN19-13		●	250	267.63	60	63	9	13	C	11.55	SNEG1907
FMA11-315-D60-SN19-16		○	315	332.63	60	80	9	16	D	20.9	SNEG1907

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

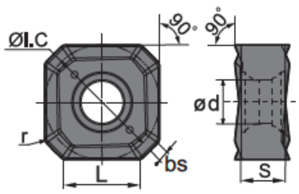
	Insert	SNEG1205	SNEG1506	SNEG1907
	ØD	63-200	63-315	125-315
	Screw (insert)	I60M3.5*10 (2.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)
	Wrench (insert)	WT15IS		
	Wrench (insert)		WT20IT	WT25IT

Milling inserts

◯ Ideal machining conditions
✪ Normal machining conditions
❋ Unfavourable machining conditions

SNEG	L	I.C	S	d
12 05	7.6	12	4.76	4.6
15 06	9.4	15	5.6	5.5
19 07	12.1	19	7	7.2

SN** negative insert



	HC1 (CVD) YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	HC1 (PVD) YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	HT YNG151	HC2 YNG151C	HW YD101	YD201
P	✪	✪	❋	✪	✪	❋		✪			✪	✪	✪	❋	❋		◯	◯	◯		
M		✪	❋	✪	✪	❋					✪	✪	✪	❋	❋		◯	◯	◯		
K							✪	❋		◯						✪	◯				❋
N									✪											✪	❋
S				❋		❋				◯	✪	✪	✪								
H																					

	ISO	r	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SNEG1506ANR-E**	0.9	1.3												●									
	**SNEG1205ANR-GM**	0.8	1.05	●			●			●				●										
	SNEG1506ANR-GM	0.9	1.3	●			●			●					●									
	**SNEG1205ANR-GR**	0.8	1.05	●			●			●														
	SNEG1506ANR-GR	0.9	1.3	●			●			●														
	SNEG1907ANR-GR	1	1.67	●			●			●	●													

● Ex stock ○ On demand

HC1 Coated carbide
HT Uncoated cermet
HC2 Coated cermet
HW Uncoated carbide

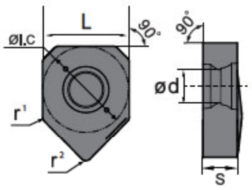
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Milling inserts

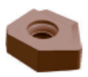
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNEG	L	I.C	S	d
12 05	12	12	4.76	4.6

SN** negative insert



	HC1 (CVD)								HC1 (PVD)									HT	HC2	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r1	r2	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SNEG1205ANR-W**	0.6	0.8												●									

● Ex stock ○ On demand

HC1 Coated carbide
HT Uncoated cermet
HC2 Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

FMA12 Kr: 45°

Face mill

- High cost-benefit factor due to 16 cutting edges.
- Three-dimensional chip breaker for tough materials.
- Smooth cut due to positive and sharp cutting edge.

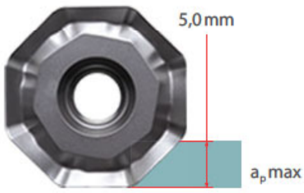
Insert grades

YBM253	YBG205	YBD152	YBD252
CVD	*PVD*	*CVD*	*CVD*
P20 – P40	*P10 – P30*	*K05 – K25*	*K15 – K35*
M10 – M30	*M10 – M30*		

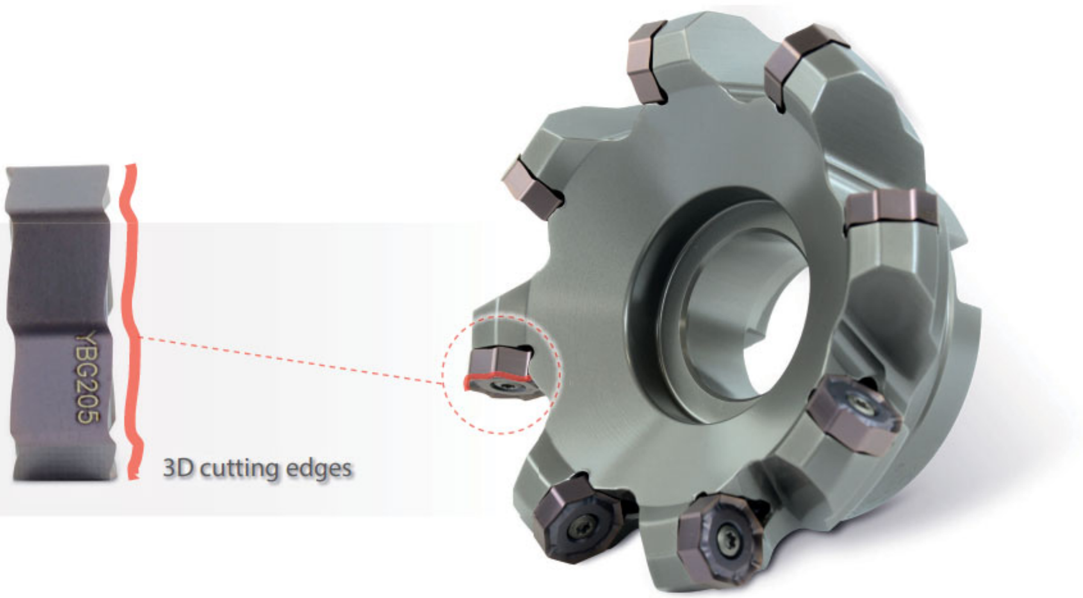
16 cutting edges

Chip breakers

-GM

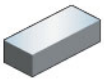


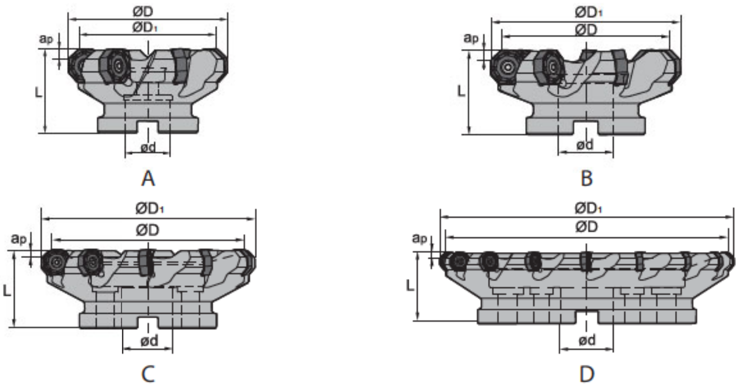
ONHU08T624R-GM



A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

FMA12 Kr: 45° 



Article	✲	Stock	Dimensions [mm] ØD	ØD₁	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts 
FMA12-063-A22-ON08-05		●	63	78	22	50	5	5	A	0.6	
FMA12-080-A27-ON08-06		○	80	95	27	50	5	6	A	0.97	
FMA12-100-B32-ON08-07		●	100	115	32	50	5	7	B	1.28	
FMA12-100-B32-ON08-07C	✲	●	100	115	32	50	5	7	B	1.28	
FMA12-125-B40-ON08-08		●	125	140	40	63	5	8	B	2.59	
FMA12-125-B40-ON08-08C	✲	●	125	140	40	63	5	8	B	2.59	ONHU08T6
FMA12-160-C40-ON08-10		●	160	175	40	63	5	10	C	4.1	
FMA12-200-C60-ON08-12		●	200	215	60	63	5	12	C	5.68	
FMA12-250-C60-ON08-14		○	250	265	60	63	5	14	C	11.9	
FMA12-315-D60-ON08-18		○	315	330	60	80	5	18	D	20.41	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	ONHU08T6
	ØD	63- 315
	Screw (insert)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT20IT

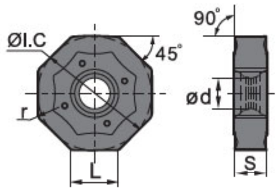
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
✱ Unfavourable machining conditions

ONHU	L	I.C	S	d
08 T6	6.38	20.2	6.3	5.3

ON** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	✿	✿	✱	✿	✿	✱		✿			✿	✿	✿	✱	✱		◯	◯	◯		
	M		✿	✱	✿	✿	✱					✿	✿	✿	✱	✱		◯	◯	◯		
	K							✿	✱		◯						✿	◯				✱
	N									✿											✿	✱
	S				✱		✱				◯	✿	✿	✿								
	H																					
 **ONHU08T624R-GM**	2.4				●			○					○									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Notes

FMD02 Kr: 67°

Face mill

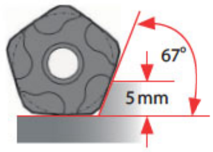
- Smooth-cutting inserts due to trough-shaped chip breaker.
- Chamfer with wiper for best surface quality.
- Wide selection of inserts with 6 different chip breakers.
- Milling body available in wide, normal and close pitch (wedge clamping).

Insert grades

YBC302	YBM253	YBD152	YBD252
CVD	*CVD*	*CVD*	*CVD*
P15 – P35	*P10 – P40*	*K05 – K25*	*K15 – K35*

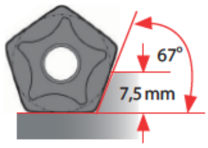
Chip breakers

-CF -CM -CR

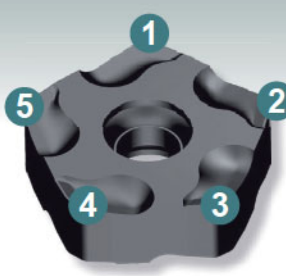


- Cast iron machining
  $a_p$max = 5 mm

-PF -PM -PR



- Steel
  $a_p$max = 7.5 mm



2 x 5 cutting edges

- Entry angle Kr = 67°

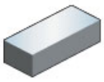
- Screw clamping

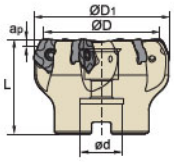
- Wedge clamping

- Wiper

Face milling

FMD02 Kr: 67°





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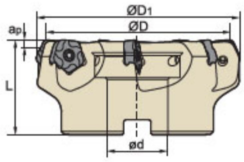

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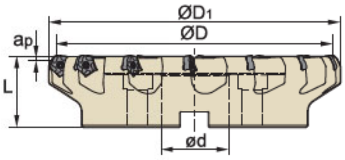

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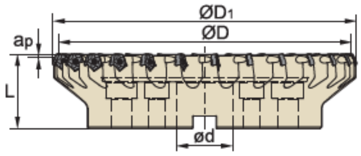


D

Article	✲	Stock		Dimensions [mm]					Teeth	Coupling	kg	Inserts
		R	L	ØD	ØD$_1$	ød	L	$a_{p\,max}$				
FMD02-050-A22-PN11-04		●	○	50	60.1	22	50	5	4	A	0.6	
FMD02-050-A22-PN11-04C	✲	○		50	60.1	22	50	5	4	A	0.6	
FMD02-050-A22-PN11-05		●		50	60.1	22	50	5	5	A	0.6	
FMD02-050-A22-PN11-05C	✲	●		50	60.1	22	50	5	5	A	0.6	
FMD02-063-A22-PN11-05		●	○	63	73.1	22	50	5	5	A	0.8	
FMD02-063-A22-PN11-05C	✲	○		63	73.1	22	50	5	5	A	0.8	
FMD02-063-A22-PN11-06		●		63	73.1	22	50	5	6	A	0.9	
FMD02-063-A22-PN11-06C	✲	●		63	73.1	22	50	5	6	A	0.9	
FMD02-080-A27-PN11-06		●		80	90.1	27	50	5	6	A	1.1	
FMD02-080-A27-PN11-08		●		80	90.1	27	50	5	8	A	1.2	
FMD02-080-A27-PN11-08C	✲	●		80	90.1	27	50	5	8	A	1.2	
FMD02-100-B32-PN11-07		●		100	110.1	32	50	5	7	B	1.8	
FMD02-100-B32-PN11-07C	✲	○		100	110.1	32	50	5	7	B	1.8	
FMD02-100-B32-PN11-10		●		100	110.1	32	50	5	10	B	1.9	
FMD02-100-B32-PN11-10C	✲	○		100	110.1	32	50	5	10	B	1.9	PNEG1105
FMD02-125-B40-PN11-08		●	●	125	135.1	40	63	5	8	B	2.9	
FMD02-125-B40-PN11-08C	✲	○		125	135.1	40	63	5	8	B	2.9	
FMD02-125-B40-PN11-12		●	○	125	135.1	40	63	5	12	B	3.2	
FMD02-125-B40-PN11-12C	✲	○		125	135.1	40	63	5	12	B	3.2	
FMD02-160-B40-PN11-10		●	○	160	170.1	40	63	5	10	B	5.6	
FMD02-160-B40-PN11-14		●	○	160	170.1	40	63	5	14	B	6.4	
FMD02-200-C60-PN11-12		○	○	200	210.1	60	63	5	12	C	7.9	
FMD02-200-C60-PN11-16		●		200	210.1	60	63	5	16	C	8.5	
FMD02-200-C60-PN11-20		○		200	210.1	60	63	5	20	C	8.5	
FMD02-200-C60-PN11-24		●		200	210.1	60	63	5	24	C	8.6	
FMD02-250-C60-PN11-14		○		250	260.1	60	63	5	14	C	13.4	
FMD02-250-C60-PN11-18		●	○	250	260.1	60	63	5	18	C	18	
FMD02-250-C60-PN11-30		○		250	260.1	60	63	5	30	C	13.5	
FMD02-315-D60-PN11-26		○	○	315	325.1	60	80	5	26	D	24.5	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

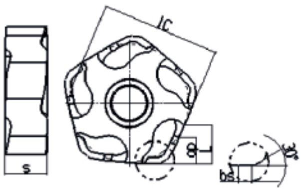
	Insert	PNEG1105
	ØD	50- 315
	Screw (insert)	I60M4*10 (3.4 Nm)
	Wrench (insert)	WT15IS

Milling inserts

◉ Ideal machining conditions
✿ Normal machining conditions
✱ Unfavourable machining conditions

PNEG	L	I.C	S	d
11 05	5.4	15.875	5.56	4.64

PN** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✿	✿	✱	✿	✿	✱		✿			✿	✿	✿	✱	✱		◉	◉	◉		
M		✿	✱	✿	✿	✱					✿	✿	✿	✱	✱		◉	◉	◉		
K							✿	✱		◉						✿	◉				✱
N									✿											✿	✱
S				✱		✱				◉	✿	✿	✿								
H																					

	ISO	bs	a_p max	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**PNEG110512L-CF**	1.6	5							○														
	PNEG110512R-CF	1.6	5							●														
	**PNEG110512L-CM**	1.6	5							○														
	PNEG110512R-CM	1.6	5							●														
	**PNEG110512L-CR**	1.6	5							○	○													
	PNEG110512R-CR	1.6	5							●	●													

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

ZCC·CT

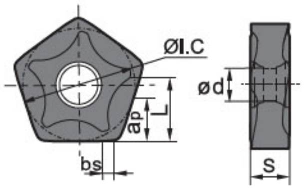
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

◯ Ideal machining conditions
✪ Normal machining conditions
✱ Unfavourable machining conditions

PNEG	L	I.C	S	d
11 05	7.5	15.875	5.56	4.64

PN** milling insert



			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	bs	$a_{p\,max}$	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P			✪	✪	✱	✪	✪	✱		✪			✪	✪	✪	✱	✱		◯	◯	◯		
M				✪	✱	✪	✪	✱					✪	✪	✪	✱	✱		◯	◯	◯		
K									✪	✱		◯						✪	◯				✱
N											✪											✪	✱
S						✱		✱				◯	✪	✪	✪								
H																							
 **PNEG110512L-PF**	1.6	7.5	○																				
PNEG110512R-PF	1.6	7.5	○			○																	
 **PNEG110512L-PM**	1.6	7.5	○			○																	
PNEG110512R-PM	1.6	7.5	●			●																	
 **PNEG110512L-PR**	1.6	7.5	○			●																	
PNEG110512R-PR	1.6	7.5	○			●																	

● Ex stock ○ On demand

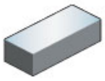
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

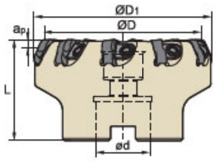
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

ZCC·CT

Face milling

FMD02 Kr: 67°





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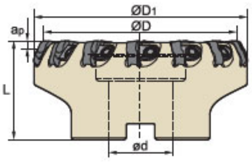

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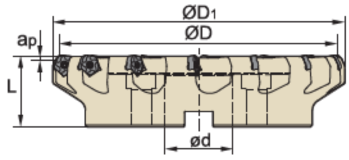


C

Article	✻	Stock		Dimensions [mm]					Teeth	Coupling	kg	Inserts
		R	L	ØD	$ØD_1$	ød	L	$a_{p\,max}$				
FMD02-080-A27-PN11-10		●		80	90.1	27	50	5	10	A	1.3	PNEG1105
FMD02-100-B32-PN11-14		●	○	100	110.1	32	50	5	14	B	1.6	PNEG1105
FMD02-125-B40-PN11-18		●		125	135.1	40	63	5	18	B	3.2	PNEG1105
FMD02-160-B40-PN11-22		●		160	170.1	40	63	5	22	B	5.8	PNEG1105
FMD02-200-C60-PN11-28		○	○	200	210.1	60	63	5	28	C	8.5	PNEG1105

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**PNEG1105**
	ØD	**80-200**
	Screw (wedge)	DM6*20A (7.0 Nm)
	Wedge	W18N
	Wrench (wedge)	WT15IT

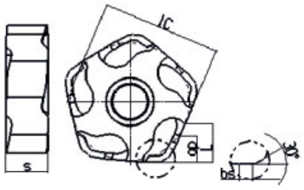
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

PNEG	L	I.C	S	d
11 05	5.4	15.875	5.56	4.64

PN** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	❋	✲	✲	❋		✲			✲	✲	✲	❋	❋		◯	◯	◯		
M		✲	❋	✲	✲	❋					✲	✲	✲	❋	❋		◯	◯	◯		
K							✲	❋		◯						✲	◯				❋
N									✲											✲	❋
S				❋		❋				◯	✲	✲	✲								
H																					

	ISO	bs	a_p max	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**PNEG110512L-CF**	1.6	5							○														
	PNEG110512R-CF	1.6	5							●														
	**PNEG110512L-CM**	1.6	5							○														
	PNEG110512R-CM	1.6	5							●														
	**PNEG110512L-CR**	1.6	5							○	○													
	PNEG110512R-CR	1.6	5							●	●													

● Ex stock ○ On demand

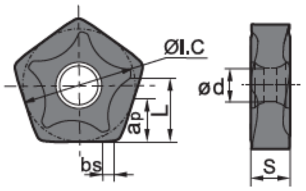
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

PNEG	L	I.C	S	d
11 05	7.5	15.875	5.56	4.64

PN** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	❋	✲	✲	❋		✲			✲	✲	✲	❋	❋		◯	◯	◯		
M		✲	❋	✲	✲	❋					✲	✲	✲	❋	❋		◯	◯	◯		
K							✲	❋		◯						✲	◯				❋
N									✲											✲	❋
S				❋		❋				◯	✲	✲	✲								
H																					

	ISO	bs	$a_{p\,max}$	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**PNEG110512L-PF**	1.6	7.5	○																				
	PNEG110512R-PF	1.6	7.5	○			○																	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

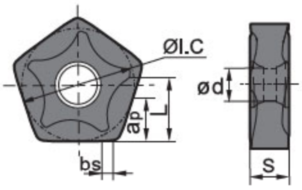
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- ◯ Ideal machining conditions
- ✿ Normal machining conditions
- ✱ Unfavourable machining conditions

PNEG	L	I.C	S	d
11 05	7.5	15.875	5.56	4.64

PN** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT		HC[2]		HW				
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151		YNG151C		YD101	YD201			
P	✿	✿	✱	✿	✿	✱		✿			✿	✿	✿	✱	✱		◯	◯		◯						
M		✿	✱	✿	✿	✱					✿	✿	✿	✱	✱		◯	◯		◯						
K							✿	✱		◯						✿	◯						✱			
N									✿													✿	✱			
S				✱		✱				◯	✿	✿	✿													
H																										

	ISO	bs	$a_{p\,max}$	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151		YNG151C		YD101	YD201			
	**PNEG110512L-PM**	1.6	7.5	○			○																						
	PNEG110512R-PM	1.6	7.5	●			●																						
	**PNEG110512L-PR**	1.6	7.5	○			●																						
	PNEG110512R-PR	1.6	7.5	○			●																						

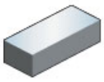
● Ex stock ○ On demand

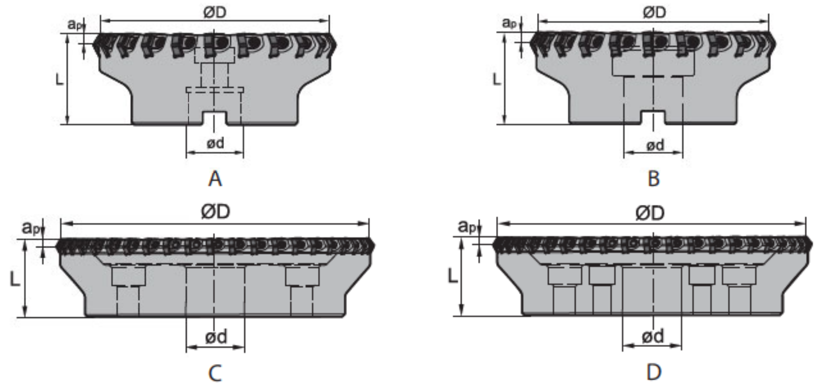
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Face milling

FMD02 Kr: 55°





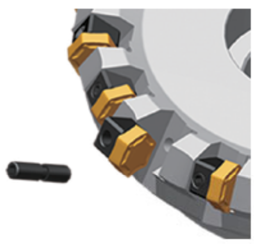
Article	✲	Stock R	Stock L	ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMD02-080-A27-HN09-08		○		80	27	50	6	8	A	1.19	HNEX0905
FMD02-100-B32-HN09-10		○		100	32	50	6	10	B	1.77	
FMD02-125-B40-HN09-14		○		125	40	63	6	14	B	3.55	
FMD02-125-B40-HN09-18		○		125	40	63	6	18	B	3.7	
FMD02-160-B40-HN09-18		●		160	40	63	6	18	B	5.62	
FMD02-160-B40-HN09-22		○		160	40	63	6	22	B	5.6	
FMD02-200-C60-HN09-22		○		200	60	63	6	22	C	6.7	
FMD02-250-C60-HN09-28		○	○	250	60	63	6	28	C	13	
FMD02-315-D60-HN09-44		○		315	60	63	6	44	D	21.7	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	HNEX0905
	ØD	**80- 315**
	Screw (wedge)	DM6*20A (7.0 Nm)
	Wedge	W18N
	Wrench (wedge)	WT15IT



System code B26 Grade selection B24 Technical info B463 Cutting data B224

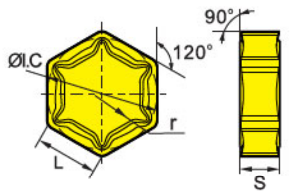
ZCC·CT

Milling inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✻ Unfavourable machining conditions

HNEX	L	I.C	S
09 05	9.16	15.875	5.56

HN** milling insert



ISO	r	HC¹ (CVD) YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	HC¹ (PVD) YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	HT YNG151	HC² YNG151C	HW YD101	YD201
P		⊛	⊛	✻	⊛	⊛	✻		⊛			⊛	⊛	⊛	✻	✻		◯	◯	◯		
M			⊛	✻	⊛	⊛	✻					⊛	⊛	⊛	✻	✻		◯	◯	◯		
K								⊛	✻		◯						⊛	◯				✻
N										⊛											⊛	✻
S					✻		✻				◯	⊛	⊛	⊛								
H																						
 **HNEX090512-DM**	1.2							○	○													
 **HNEX090512-DR**	1.2							●	●													

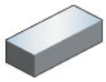
● Ex stock ○ On demand

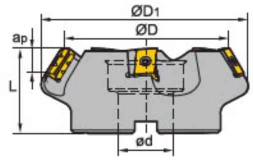
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Face milling

FMD03 Kr: 60°





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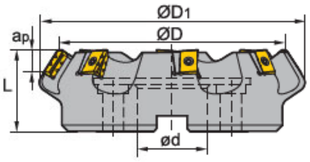
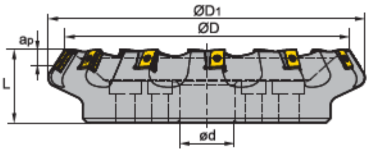


C



D

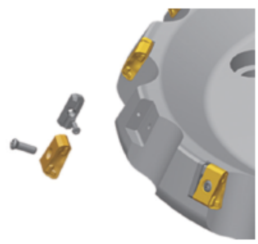
Article	✲	Stock		Dimensions [mm]					Teeth	Coupling	kg	Inserts
		R	L	ØD	$ØD_1$	ød	L	$a_{p\,max}$				
FMD03-100-B32-LN20-05		○		100	129	32	63	12	5	B	3.02	LNKT2007-ZR
FMD03-125-B40-LN20-06		●		125	153	40	63	12	6	B	4.5	LNKT2007-ZR
FMD03-160-C40-LN20-08		●		160	187	40	63	12	8	C	6.9	LNKT2007-ZR
FMD03-160-C40-LN20-09		○		160	187	40	63	12	9	C	6.7	LNKT2007-ZR
FMD03-200-C60-LN20-10		●		200	227	60	70	12	10	C	10.5	LNKT2007-ZR
FMD03-250-C60-LN20-12		●		250	276	60	70	12	12	C	13.4	LNKT2007-ZR
FMD03-315-D60-LN20-15		○		315	339	60	80	12	15	D	26.2	LNKT2007-ZR
FMD03-125-B40-LN25-05		○		125	154	40	63	16	5	B	4.5	LNKT2510-ZR
FMD03-160-C40-LN25-06		●		160	189	40	63	16	6	C	6.9	LNKT2510-ZR
FMD03-200-C60-LN25-08		●		200	229	60	70	16	8	C	10.5	LNKT2510-ZR
FMD03-250-C60-LN25-10		●		250	278	60	70	16	10	C	16.7	LNKT2510-ZR
FMD03-315-D60-LN25-12		○	○	315	346	60	80	16	12	D	27.3	LNKT2510-ZR
FMD03-400-D60-LN25-16		○	○	400	427	60	80	16	16	D	47.1	LNKT2510-ZR

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	LNKT2007-ZR	LNKT2510-ZR
	ØD	100- 315	125 -400
	Screw (insert)	I60M4*15 (3.4 Nm)	I60M5*17 (6.7 Nm)
	Screw (shim)	I60M3*7	I60M3.5*10.4
	Shim	LLN20R-ZR	LLN25R-ZR
	Wrench (insert)	WT15IS	
	Wrench (insert)		WT20IT
	Wrench (shim)	WT09IS	WT15IS



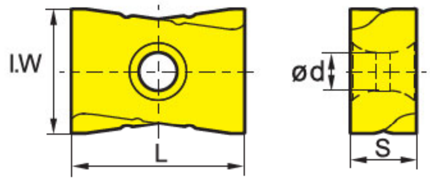
System code B26 Grade selection B24 Technical info B463 Cutting data B224

ZCC·CT

Milling inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✻ Unfavourable machining conditions

LNKT	L	S	d
20 07	20	7.94	4.6
25 10	25	9.525	5.5



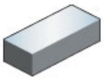
LN** milling insert		HC^1 (CVD)								HC^1 (PVD)									HT		HC^2		HW				
	P	⊕	⊕	✻	⊕	⊕	✻		⊕			⊕	⊕	⊕	✻	✻		◯	◯		◯						
	M		⊕	✻	⊕	⊕	✻					⊕	⊕	⊕	✻	✻		◯	◯		◯						
	K							⊕	✻		◯						⊕	◯						✻			
	N									⊕													⊕	✻			
	S				✻		✻				◯	⊕	⊕	⊕													
	H																										
ISO	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151		YNG151C		YD101	YD201			
 **LNKT2007DN-ZR**	17				●		●		○							●											
LNKT2510-ZR	18						●		●							●											

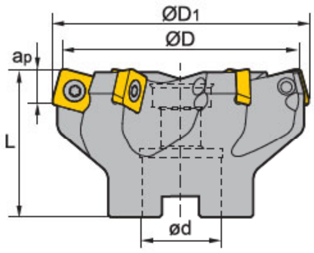
● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Face milling

FME02 Kr: 75° 



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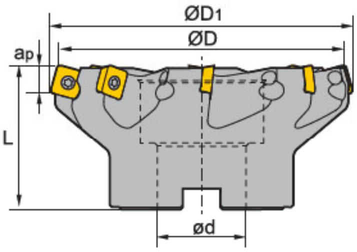


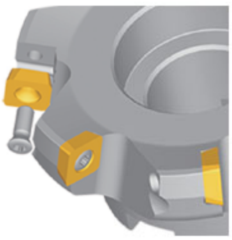
B

Article	✻	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ØD$_1$	ød	L	$a_{p\ max}$				
FME02-050-A22-SP12-04		●	50	54	22	40	6	4	A	0.3	SPKT1204 SPKW1204
FME02-063-A22-SP12-05		●	63	66	22	50	6	5	A	0.6	
FME02-080-A27-SP12-06		●	80	83	27	50	6	6	A	0.9	
FME02-100-B32-SP12-07		●	100	103	32	50	6	7	B	1.4	
FME02-125-B40-SP12-08		●	125	128	40	63	6	8	B	2.5	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SPKT1204 SPKW1204**	
	ØD	**50-125**	
	Screw (insert)	I60M5*13.2 (6.7 Nm)	
	Wrench (insert)	WT20IS	

System code B26 Grade selection B24 Technical info B463 Cutting data B224

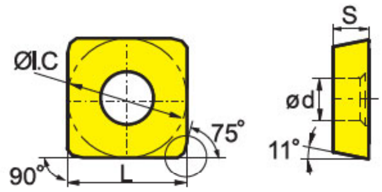
ZCC·CT

Milling inserts

◉ Ideal machining conditions
✿ Normal machining conditions
❁ Unfavourable machining conditions

SPKW	L	I.C	S	d
12 04	12.7	12.7	4.76	5.56

SP milling insert**



	HC¹ (CVD)								HC¹ (PVD)									HT		HC²		HW				
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151		YNG151C		YD101	YD201			
P	✿	✿	❁	✿	✿	❁		✿			✿	✿	✿	❁	❁		◉	◉		◉						
M		✿	❁	✿	✿	❁					✿	✿	✿	❁	❁		◉	◉		◉						
K							✿	❁		◉						✿	◉						❁			
N									✿													✿	❁			
S				❁		❁				◉	✿	✿	✿													
H																										
SPKW1204EDFR													○													
SPKW1204EDSR													●													

● Ex stock ○ On demand

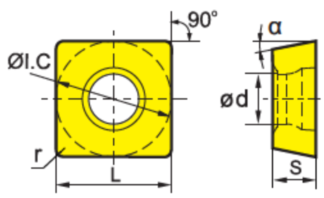
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Milling inserts

◉ Ideal machining conditions
✿ Normal machining conditions
❁ Unfavourable machining conditions

SPKT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.56

SP milling insert**



	HC¹ (CVD)								HC¹ (PVD)									HT		HC²		HW				
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151		YNG151C		YD101	YD201			
P	✿	✿	❁	✿	✿	❁		✿			✿	✿	✿	❁	❁		◉	◉		◉						
M		✿	❁	✿	✿	❁					✿	✿	✿	❁	❁		◉	◉		◉						
K							✿	❁		◉						✿	◉						❁			
N									✿													✿	❁			
S				❁		❁				◉	✿	✿	✿													
H																										
SPKT1204EDR													●													

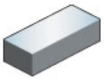
● Ex stock ○ On demand

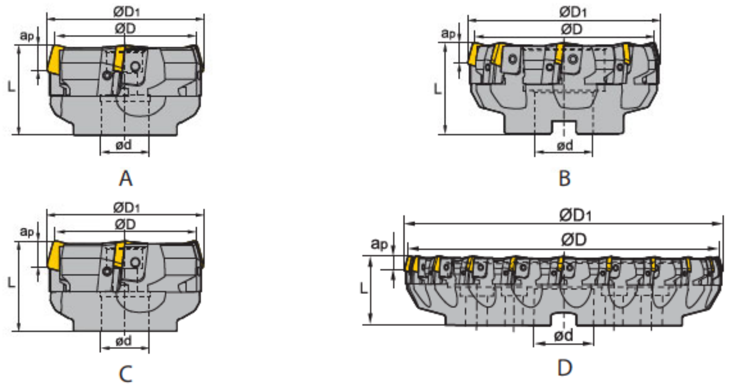
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Face milling

FME03 Kr: 75°





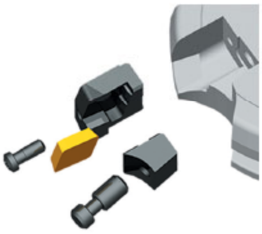
Article	✲	Stock R	Stock L	ØD	$ØD_1$	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FME03-080-A27-SP12-04		○		80	84	27	50	6	4	A	1.1	SPKN1203 SPKR1203 SPEX1203
FME03-100-B32-SP12-06		●		100	104	32	50	6	6	B	1.9	
FME03-125-B40-SP12-08		○	○	125	129	40	63	6	8	B	3.5	
FME03-160-B40-SP12-10		●	○	160	164	40	63	6	10	B	5.7	
FME03-200-C60-SP12-12		○	○	200	203	60	63	6	12	C	8.2	
FME03-250-C60-SP12-16		○	○	250	253	60	63	6	16	C	13.8	
FME03-315-D60-SP12-20		○		315	318	60	70	6	20	D	23.5	
FME03-080-A27-SP15-04		○	○	80	84	27	50	8	4	A	1	SPKN1504 SPKR1504 SPEX1504
FME03-100-B27-SP15-06		○		100	104	27	50	8	6	B	1.8	
FME03-125-B40-SP15-08		●	○	125	129	40	63	8	8	B	3.3	
FME03-160-B40-SP15-10		○	○	160	164	40	63	8	10	B	5.4	
FME03-200-C60-SP15-12		○	○	200	204	60	63	8	12	C	7.9	
FME03-250-C60-SP15-16		○	○	250	253	60	63	8	16	C	13.6	
FME03-315-D60-SP15-20		○	○	315	318	60	70	8	20	D	23.1	

● Ex stock ○ On demand

✲ With internal cooling

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Spare parts				
Insert	SPKN1203 SPKR1203 SPEX1203	SPKN1203 SPKR1203 SPEX1203	SPKN1504 SPKR1504 SPEX1504
ØD	80-100	125 - 315	80- 315
Adjustable screw	LOM5*15.1	LOM5*15.1	LOM5*15.1
Cassette (left)	LSP12L	LSP12L	LSP15L
Cassette (right)	LSP12R	LSP12R	LSP15R
Screw (wedge)	WM8*17	WM8*22	WM8*22
Wedge (left)	W04L	W04L	W04L
Wedge (right)	W04R	W04R	W04R
Wrench (loca-tor)	WT20T	WT20T	WT20T
Wrench (wedge)	WT25T	WT25T	WT25T

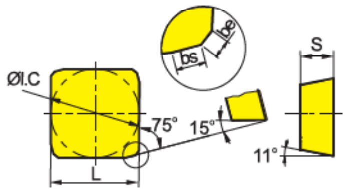


Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPKN	L	I.C	S
12 03	12.7	12.7	3.18
15 04	15.875	15.875	4.76

SP** milling insert



	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

ISO	be	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
SPKN1203EDFL	1	1.4																					●
SPKN1203EDFR	1	1.4		○								○											●
SPKN1203EDSKL	1	1.4		●																			
SPKN1203EDSKR	1	1.4		●	●					○					●		●						
SPKN1203EDTKR	1	1.4						○									○						
SPKN1504EDFL	1	1.4																					○
SPKN1504EDFR	1	1.4																					○
SPKN1504EDS32PR	1	1.4		○												○							
SPKN1504EDSKL	1	1.4															○						
SPKN1504EDSKR	1	1.4		●						●					●		●						
SPKN1504EDTKR	1	1.4													○								

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

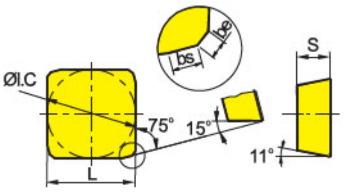
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPKR	L	I.C	S
12 03	12.7	12.7	3.18
15 04	15.875	15.875	4.76

SP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	be	bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SPKR1203EDL-GM**	1	1.4					○																
	SPKR1203EDR-GM	1	1.4					●																
	SPKR1504EDR-GM	1	1.4				○									○								
	**SPKR1203EDR**	1	1.4		○																			

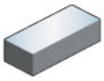
● Ex stock ○ On demand

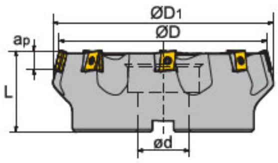
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

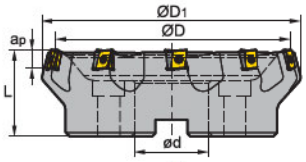
Face milling

FME04 Kr: 75°

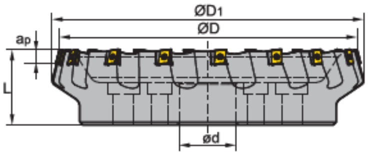




B



C



D

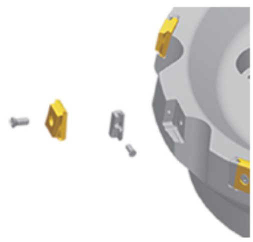
Article	✲	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ØD$_1$	ød	L	$a_{p\,max}$				
FME04-125-B40-LN15-06		●	125	137	40	63	10	6	B	3.8	LNKT1506-ZR
FME04-160-B40-LN15-08		●	160	170	40	63	10	8	C	6.6	
FME04-200-C60-LN15-10		●	200	208	60	70	10	10	C	9.6	
FME04-250-C60-LN15-12		○	250	257	60	70	10	12	C	13.4	
FME04-315-D60-LN15-16		○	315	328	60	80	10	16	D	25.2	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	LNKT1506-ZR
	ØD	**125 - 315**
	Screw (insert)	I60M4*12 (3.4 Nm)
	Screw (shim)	I60M3*7
	Shim	LLN15-ZR
	Wrench (insert)	WT15IS
	Wrench (shim)	WT09IS



System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning | B Milling | C Drilling | D Technical Information | E Index

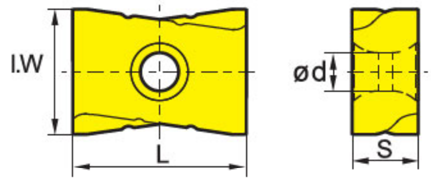
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

◎ Ideal machining conditions
✲ Normal machining conditions
✺ Unfavourable machining conditions

LNKT	L	S	d
15 06	15.875	6.35	4.6

LN** milling insert



	HC¹ (CVD)							
ISO / I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252
P	✲	✲	✺	✲	✲	✺		✲
M		✲	✺	✲	✲	✺		
K							✲	✺
N								
S				✺		✺		
H								
LNKT1506EN-ZR 14		●			○	●	●	●

	HC¹ (PVD)									HT	HC²	HW	
ISO / I.W	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P			✲	✲	✲	✺	✺		◎	◎	◎		
M			✲	✲	✲	✺	✺		◎	◎	◎		
K		◎						✲	◎				✺
N	✲											✲	✺
S		◎	✲	✲	✲								
H													
LNKT1506EN-ZR 14							○						

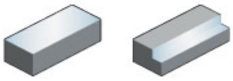
● Ex stock ○ On demand

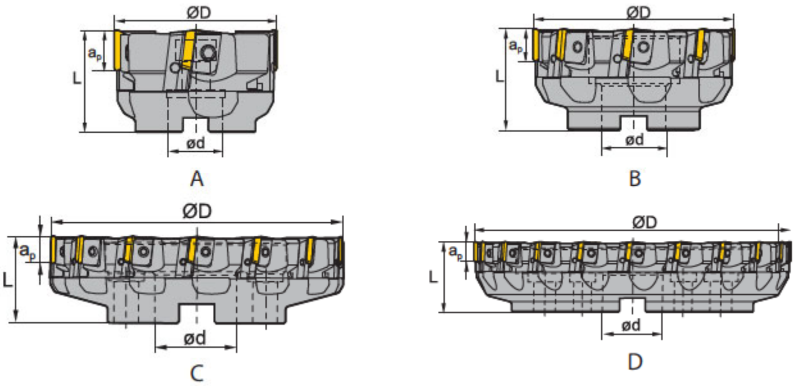
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Face milling

FMP01 Kr: 90°





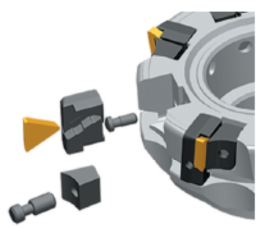
Article	✲	Stock R	Stock L	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMP01-080-A27-TP22-04		●		80	27	50	18	4	A	1.2	
FMP01-100-B32-TP22-06		●		100	32	50	18	6	B	1.7	
FMP01-125-B40-TP22-08		●	○	125	40	63	18	8	B	3.2	
FMP01-160-B40-TP22-10		●	○	160	40	63	18	10	B	5.1	TPKN2204
FMP01-200-C60-TP22-12		●	○	200	60	63	18	12	C	7.4	
FMP01-250-C60-TP22-16		○	○	250	60	63	18	16	C	12.3	
FMP01-315-D60-TP22-20		○	○	315	60	70	18	20	D	21.9	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TPKN2204**	**TPKN2204**
	ØD	**80-100**	**125 - 315**
	Adjustable screw	LOM5*15.1	LOM5*15.1
	Cassette (left)	LTP4L1	LTP4L
	Cassette (right)	LTP4R1	LTP4R
	Screw (wedge)	WM8*12	WM8*22
	Wedge (left)	W04L	W04L
	Wedge (right)	W04R	W04R
	Wrench (locator)	WT20T	WT20T
	Wrench (wedge)	WT25T	WT25T



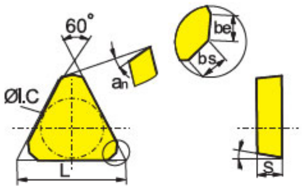
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TPKN	L	I.C	S
22 04	22	12.7	4.76

TP** milling insert



				HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	be	bs	an	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P				Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M					Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K										Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N												Normal											Normal	Unfavourable
S							Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																								
TPKN2204PDFR	1.4	0.7	11°										○											●
TPKN2204PDS32PR	1.4	0.7	11°												○		○							
TPKN2204PDSKL	1.4	0.7	11°		○																			
TPKN2204PDSKR	1.4	0.7	11°		●	●			●		●				●	●		●						
TPKN2204PDTKR	1.4	0.7	11°										●											

● Ex stock ○ On demand

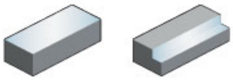
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

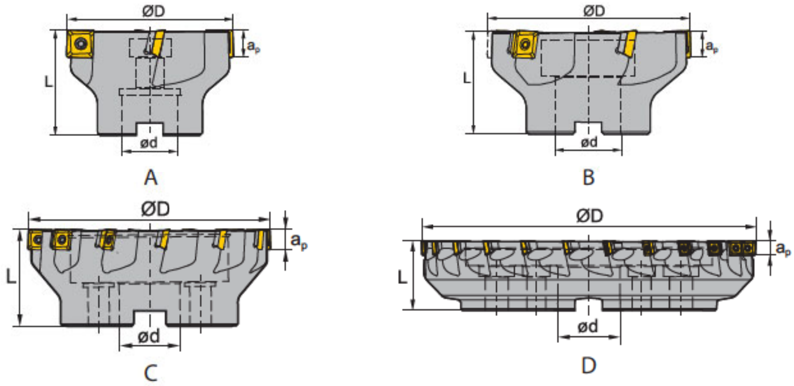
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

ZCC·CT

Face milling

FMP02 Kr: 90°





Article	✲	Stock	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMP02-050-A22-SE09-05		●	50	22	40	6.7	5	A	0.3	SEET09T3
FMP02-050-A22-SE09-05C	✲	●	50	22	40	6.7	5	A	0.3	
FMP02-063-A22-SE09-06		●	63	22	40	6.7	6	A	0.5	
FMP02-063-A22-SE09-06C	✲	●	63	22	40	6.7	6	A	0.5	
FMP02-080-A27-SE09-08		●	80	27	50	6.7	8	A	0.9	
FMP02-100-B32-SE09-08		○	100	32	50	6.7	8	B	1.7	
FMP02-100-B32-SE09-10		○	100	32	50	6.7	10	B	1.7	
FMP02-100-B32-SE09-10C	✲	○	100	32	50	6.7	10	B	1.7	
FMP02-125-B40-SE09-12		●	125	40	63	6.7	12	B	2.6	
FMP02-125-B40-SE09-12C	✲	○	125	40	63	6.7	12	B	2.6	
FMP02-050-A22-SE12-03		○	50	22	40	10.8	3	A	0.3	SEET1203
FMP02-050-A22-SE12-04		●	50	22	40	10.8	4	A	0.3	
FMP02-050-A22-SE12-04C	✲	●	50	22	40	10.8	4	A	0.3	
FMP02-050-A22-SE12-05		●	50	22	40	10.8	5	A	0.2	
FMP02-050-A22-SE12-05C	✲	○	50	22	40	10.8	5	A	0.2	
FMP02-063-A22-SE12-04		○	63	22	40	10.8	4	A	0.4	
FMP02-063-A22-SE12-05		●	63	22	40	10.8	5	A	0.4	
FMP02-063-A22-SE12-05C	✲	●	63	22	40	10.8	5	A	0.4	
FMP02-063-A22-SE12-06		●	63	22	40	10.8	6	A	0.4	
FMP02-063-A22-SE12-06C	✲	○	63	22	40	10.8	6	A	0.4	
FMP02-080-A27-SE12-04		○	80	27	50	10.8	4	A	0.9	
FMP02-080-A27-SE12-06		●	80	27	50	10.8	6	A	0.8	
FMP02-080-A27-SE12-06C	✲	●	80	27	50	10.8	6	A	0.8	
FMP02-080-A27-SE12-08		●	80	27	50	10.8	8	A	0.8	
FMP02-080-A27-SE12-08C	✲	○	80	27	50	10.8	8	A	0.8	
FMP02-100-B32-SE12-05		●	100	32	50	10.8	5	B	1.2	
FMP02-100-B32-SE12-07		●	100	32	50	10.8	7	B	1.2	
FMP02-100-B32-SE12-10		●	100	32	50	10.8	10	B	1.2	
FMP02-100-B32-SE12-10C	✲	○	100	32	50	10.8	10	B	1.2	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

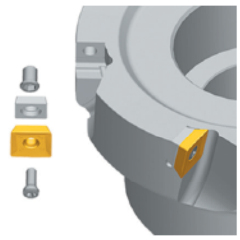
A Turning
B Milling
C Drilling
D Technical Information
E Index

Article	✲	Stock	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts 
FMP02-125-B40-SE12-06		○	125	40	63	10.8	6	B	3.1	SEET1203
FMP02-125-B40-SE12-08		●	125	40	63	10.8	8	B	3	
FMP02-125-B40-SE12-08C	✲	○	125	40	63	10.8	8	B	3	
FMP02-125-B40-SE12-12		●	125	40	63	10.8	12	B	2.9	
FMP02-160-C40-SE12-08		●	160	40	63	10.8	8	C	4.1	
FMP02-160-C40-SE12-12		●	160	40	63	10.8	12	C	3.9	
FMP02-200-C60-SE12-16		●	200	60	63	10.8	16	C	6.1	
FMP02-250-C60-SE12-12		○	250	60	63	10.8	12	C	11.1	
FMP02-250-C60-SE12-18		●	250	60	63	10.8	18	C	10.9	
FMP02-315-D60-SE12-24		○	315	60	63	10.8	24	D	21.6	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts				
	Insert	**SEET09T3**	**SEET1203**	**SEET1203**
	ØD	**50-125**	**50**	**63- 315**
	Screw (insert)	I60M3*7 (1.8 Nm)	I60M3.5*10 (2.7 Nm)	I60M3.5*12 (2.7 Nm)
	Screw (shim)			SM5*7XA
	Shim			S12BSX
	Wrench (insert)	WT09IS	WT15IS	WT15IS
	Wrench (shim)			WH35L

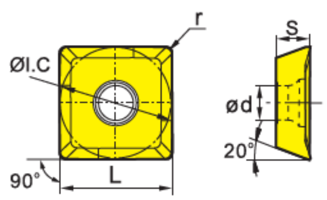


Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✹ Unfavourable machining conditions

SEET	L	I.C	S	d
09 T3	9.525	9.525	4.01	3.3
12 03	13.308	13.308	4.04	4.1

SE** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	✲	✲	✹	✲	✲	✹		✲			✲	✲	✲	✹	✹		◯	◯	◯		
	M		✲	✹	✲	✲	✹					✲	✲	✲	✹	✹		◯	◯	◯		
	K							✲	✹		◯						✲	◯				✹
	N									✲											✲	✹
	S				✹		✹				◯	✲	✲	✲								
	H																					
 **SEET09T3O8PER-APF**	0.8						●				○	○										
SEET120308PER-APF	0.8						●				○	○										

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

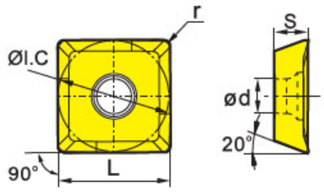
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

ZCC·CT

Milling inserts

- ◯ Ideal machining conditions
- ✪ Normal machining conditions
- ✺ Unfavourable machining conditions

SEET	L	I.C	S	d
09 T3	9.525	9.525	4.01	3.3
12 03	13.308	13.308	4.04	4.1



SE** milling insert		HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	P	✪	✪	✺	✪	✪	✺		✪			✪	✪	✪	✺	✺		◯	◯	◯		
	M		✪	✺	✪	✪	✺					✪	✪	✪	✺	✺		◯	◯	◯		
	K							✪	✺		◯						✪	◯				✺
	N									✪											✪	✺
	S				✺		✺				◯	✪	✪	✪								
	H																					
ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
 **SEET09T308PER-APM**	0.8						●				○	○										
SEET120308PER-APM	0.8						●				○	●										
 **SEET09T308PER-APR**	0.8						●				○	○										
SEET120308PER-APR	0.8						●				○	○										
 **SEET120308-LH**	0.8									○	○										●	
 **SEET09T308PER-PF**	0.8													●								
SEET120308PER-PF	0.8	●	●				○							●								
 **SEET09T308PER-PM**	0.8							○						●								
SEET120308PER-PM	0.8	●				●	●	●	●		●			●		●						
 **SEET09T308PER-PR**	0.8							●								○						
SEET120308PER-PR	0.8	●				●	●	●	●		○			○		○						

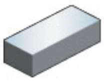
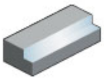
● Ex stock ○ On demand

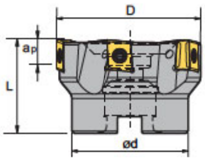
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

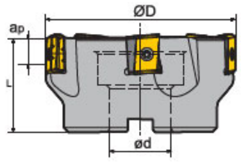
Face milling

FMP03 Kr: 89°

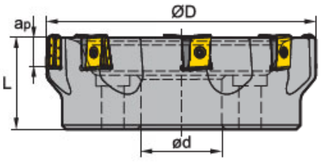





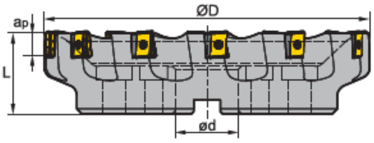
A



B



C



D

Article	✻	Stock		Dimensions [mm]				Teeth	Coupling	kg	Inserts
		R	L	ØD	ød	L	$a_{p\,max}$				
FMP03-050-A22-LN12-04C	✻	●		50	22	40	7	4	A	0.3	
FMP03-050-A22-LN12-05C	✻	○		50	22	40	7	5	A	0.3	
FMP03-063-A22-LN12-05C	✻	●		63	22	40	7	5	A	0.5	
FMP03-063-A27-LN12-05C	✻	○		63	27	50	7	5	A	0.64	
FMP03-063-A22-LN12-06C	✻	○		63	22	40	7	6	A	0.5	LNKT120608-ZR
FMP03-063-A27-LN12-06C	✻	●		63	27	50	7	6	A	0.65	
FMP03-063-A27-LN12-07C	✻	○		63	27	50	7	7	A	0.64	
FMP03-080-A27-LN12-06C	✻	●		80	27	50	7	6	A	1	
FMP03-080-A27-LN12-07C	✻	○		80	27	50	7	7	A	1	
FMP03-100-B32-LN12-06		○		100	32	50	7	6	B	1.47	
FMP03-125-B40-LN15-06		●		125	40	63	12	6	B	3.2	
FMP03-160-C40-LN15-08		●		160	40	63	12	8	C	5.1	
FMP03-160-C40-LN15-09		○		160	40	63	12	9	C		
FMP03-200-C60-LN15-10		●		200	60	70	12	10	C	7.5	LNKT1506EN-ZR
FMP03-250-C60-LN15-12		○		250	60	70	12	12	C	12.2	
FMP03-250-C60-LN15-13		○		250	60	70	12	13	C		
FMP03-315-D60-LN15-16		○		315	60	80	12	16	D	23.7	
FMP03-125-B40-LN20-06		○		125	40	63	16	6	B	3.3	
FMP03-160-C40-LN20-08		●		160	40	63	16	8	C	5.3	
FMP03-160-C40-LN20-09		○		160	40	63	16	9	C		
FMP03-200-C60-LN20-10		●		200	60	70	16	10	C	8.8	LNKT2007DN-ZR
FMP03-200-C60-LN20-11		○		200	60	70	16	11	C		
FMP03-250-C60-LN20-12		●		250	60	70	16	12	C	14	
FMP03-315-D60-LN20-15		○		315	60	80	16	15	D	23.9	
FMP03-125-B40-LN25-05		○		125	40	63	20	5	B	3.3	
FMP03-160-C40-LN25-06		○	○	160	40	63	20	6	C	5.1	
FMP03-200-C60-LN25-08		○		200	60	70	20	8	C	8.9	LNKT2510-ZR
FMP03-250-C60-LN25-10		●	○	250	60	70	20	10	C	12	
FMP03-315-D60-LN25-12		○	○	315	60	80	20	12	D	21.9	

● Ex stock ○ On demand

✻ With internal cooling

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Spare parts

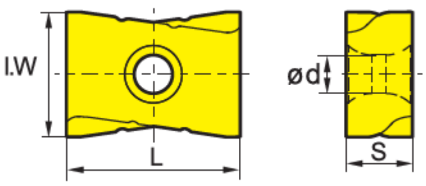
	Insert	LNKT120608-ZR	LNKT1506EN-ZR	LNKT2007DN-ZR	LNKT2510-ZR
	ØD	**50-100**	**125 - 315**	**125 - 315**	**125 - 315**
	Screw (insert)	I60M4*12 (3.4 Nm)	I60M4*12 (3.4 Nm)	I60M4*15 (3.4 Nm)	I60M5*17 (6.7 Nm)
	Screw (shim)		I60M3*7	I60M3*7	I60M3.5*10.4
	Shim		LLN15-ZR	LLN20R-ZR	LLN25R-ZR
	Wrench (insert)	WT15IS	WT15IS	WT15IS	
	Wrench (insert)				WT20IT
	Wrench (shim)		WT09IS	WT09IS	WT15IS

LNKT	L	S	d
12 06	12.7	6.65	4.4
15 06	15.875	6.35	4.6
20 07	20	7.94	4.6
25 10	25	9.525	5.5

◯ Ideal machining conditions
⊕ Normal machining conditions
✱ Unfavourable machining conditions

Milling inserts

LN** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊕	⊕	✱	⊕	⊕	✱		⊕			⊕	⊕	⊕	✱	✱		◯	◯	◯		
M		⊕	✱	⊕	⊕	✱					⊕	⊕	⊕	✱	✱		◯	◯	◯		
K							⊕	✱		◯						⊕	◯				✱
N									⊕											⊕	✱
S				✱		✱				◯	⊕	⊕	⊕								
H																					

ISO	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
LNKT120608-ZR	12	●			●							●										
LNKT1506EN-ZR	14		●			○	●	●	●							○						
LNKT2007DN-ZR	17				●		●		○							●						
LNKT2510-ZR	18						●		●							●						

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Notes

FMP12 *Kr: 90°*

Square shoulder mill

- For steel, stainless steel and cast iron
- Insert with six cutting edges
- Two different insert sizes
- Radii from 0.4–1.6 mm available

Insert grades

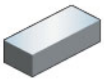
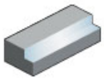
YBM253	YBG205	YBD152	YBD252
CVD	*PVD*	*CVD*	*CVD*
P20–P40	*P10–P30*	*K05–K25*	*K15–K35*
M10–M30	*M20–M30*		

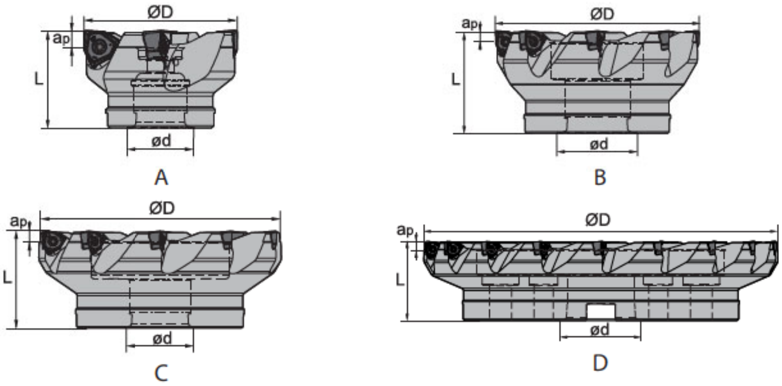
Chip breaker

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

FMP12 Kr: 90°



Article	✲	Stock	Dimensions [mm]			Teeth	Coupling	kg	Inserts 
			ØD	ød	$a_{p\,max}$				
FMP12-050-A22-WN06-05C	✲	○	50	22		5	A	55	WNHU0604
FMP12-063-A22-WN06-06C	✲	●	63	22		6	A	45	
FMP12-080-A27-WN06-07C	✲	●	80	27		7	A	10	
FMP12-100-B32-WN06-09		●	100	32		9	A	1.4	
FMP12-100-B32-WN06-09C	✲	●	100	32		9	A	1.4	
FMP12-125-B40-WN06-11C	✲	○	125	40		11	B	3.4	
FMP12-160-C40-WN06-14		○	160	40		14	C	5.4	
FMP12-063-A22-WN08-04C	✲	●	63	22		4	A	39	WNHU0806
FMP12-063-A22-WN08-05C	✲	●	63	22		5	A	45	
FMP12-080-A27-WN08-05C	✲	●	80	27		5	A	95	
FMP12-100-B32-WN08-06		●	100	32		6	B	1.32	
FMP12-100-B32-WN08-06C	✲	●	100	32		6	B	1.32	
FMP12-125-B40-WN08-08C	✲	○	125	40		8	B	3.3	
FMP12-160-C40-WN08-10		○	160	40		10	C	5.2	
FMP12-200-C60-WN08-12		○	200	60		12	C		
FMP12-250-C60-WN08-14		○	250	60		14	C		
FMP12-315-D60-WN08-18		○	315	60		18	D		

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	WNHU0604	WNHU0806
	ØD	**50-315**	**50-315**
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*10 (3.4 Nm)
	Wrench (insert)	WT09IS	
	Wrench (insert)		WT20IT

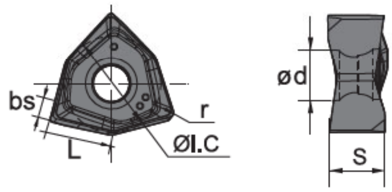
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNHU	L	I.C	S	d
06 04	5.73	9.525	4.704	3.5
08 06	7.76	12.7	6.32	4.4

WN** negative insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P		Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M			Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K								Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N										Normal											Normal	Unfavourable
S					Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																						
WNHU060404PNR-GM	0.4				○			○					○									
WNHU060408PNR-GM	0.8				●			○	○				○									
WNHU080608PNR-GM	0.8				○			●	●				●									
WNHU080616PNR-GM	1.6				○			●	○													

● Ex stock ○ On demand

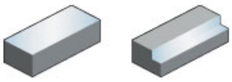
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

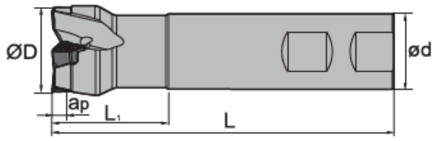
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A
Turning
B
Milling
C
Drilling
D
Technical Information
E
Index

Face milling

FMP12 Kr: 90°





Article	✲	Stock	Dimensions [mm]			Teeth	Coupling	kg	Inserts 
			ØD	ød	$a_{p\,max}$				
FMP12-025-XP25-WN06-02C	✲	○	25	25		2		0.38	WNHU0604
FMP12-032-XP25-WN06-03C	✲	○	32	25		3		0.47	
FMP12-040-XP32-WN06-04C	✲	○	40	32		4		0.85	
FMP12-050-XP40-WN06-05C	✲	○	50	40		5		1.59	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	WNHU0604
	ØD	**25-50**
	Screw (insert)	I60M3x9 (1.8Nm)
	Wrench (insert)	WT09IS

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

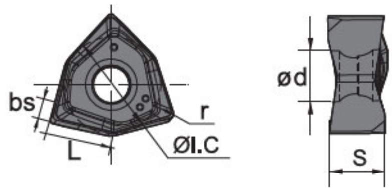
ZCC·CT

Milling inserts

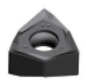
◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

WNHU	L	I.C	S	d
06 04	5.73	9.525	4.704	3.5

WN** negative insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✿	✿	❋	✿	✿	❋		✿			✿	✿	✿	❋	❋		◯	◯	◯		
M		✿	❋	✿	✿	❋					✿	✿	✿	❋	❋		◯	◯	◯		
K							✿	❋		◯						✿	◯				❋
N									✿											✿	❋
S				❋		❋				◯	✿	✿	✿								
H																					



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
WNHU060404PNR-GM	0.4				○			○					○									
WNHU060408PNR-GM	0.8				●			○	○				○									

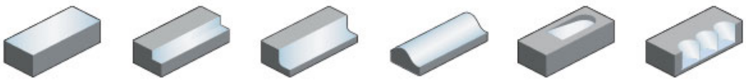
● Ex stock ○ On demand

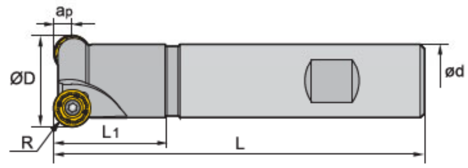
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Face milling

FMR01





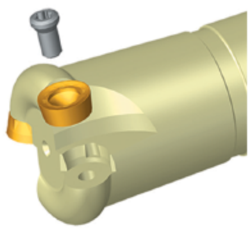
Article	✲	Stock	Dimensions [mm]						Teeth	kg	Inserts
			R	ØD	ød	L_1	L	$a_{p\,max}$			
FMR01-025-XP20-RC10-02		○	5	25	20	30	100	5	2	0.2	RCKT10T3
FMR01-025-XP20-RC10-02C	✲	○	5	25	20	30	100	5	2	0.2	
FMR01-032-XP25-RC10-02		●	5	32	25	35	120	5	2	0.5	
FMR01-032-XP25-RC10-02C	✲	●	5	32	25	35	120	5	2	0.5	
FMR01-040-XP32-RC12-03		●	6	40	32	40	120	6	3	0.7	RCKT1204 RCGX1204
FMR01-040-XP32-RC12-03C	✲	●	6	40	32	40	120	6	3	0.7	
FMR01-050-XP32-RC12-03		●	6	50	32	40	120	6	3	0.8	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	RCKT10T3	RCKT1204 RCGX1204
	ØD	25-32	40-50
	Screw (insert)	I60M4*8.4 (3.4 Nm)	I60M3.5*10 (2.7 Nm)
	Wrench (insert)	WT15S	WT15S

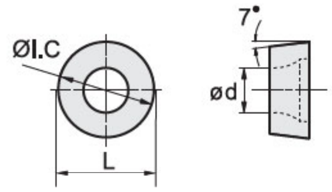


ZCC·CT

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

RCGX	I.C	S	d
12 04	12	4.76	4



RC** positive insert		HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
ISO		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	P	✲	✲	❋	✲	✲	❋		✲			✲	✲	✲	❋	❋		◯	◯	◯		
	M		✲	❋	✲	✲	❋					✲	✲	✲	❋	❋		◯	◯	◯		
	K							✲	❋		◯						✲	◯				❋
	N									✲											✲	❋
	S				❋		❋				◯	✲	✲	✲								
	H																					
	**RCGX1204MO-LH**																				●	

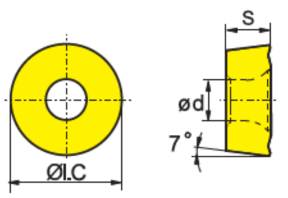
● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

RCKT	I.C	S	d
10 T3	10	3.97	4.4
12 04	12	4.76	4



RC** milling insert		HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
ISO		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	P	✲	✲	❋	✲	✲	❋		✲			✲	✲	✲	❋	❋		◯	◯	◯		
	M		✲	❋	✲	✲	❋					✲	✲	✲	❋	❋		◯	◯	◯		
	K							✲	❋		◯						✲	◯				❋
	N									✲											✲	❋
	S				❋		❋				◯	✲	✲	✲								
	H																					
	**RCKT10T3MO-DM**		●	●										●		○						
	RCKT1204MO-DM		●	●		●	●	○						●		○						
	**RCKT1204MO-DR**		●	●		●	●						○	○								
	**RCKT1204MO-ER**				●																	
	**RCKT1204MO-NM**				●		●					●			○	○						

● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

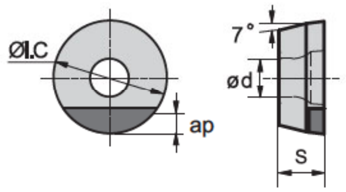
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

● Ideal machining conditions
◌ Normal machining conditions
✲ Unfavourable machining conditions

RCMW	I.C	S	d
12 04	12	4.76	4.1

RN** negative insert



	BL (CBN) YCB121	BL (CBN) YCB131	BH (CBN) YCB211
P			
M			
K			●
N			
S		◌	
H	◌	✲	

	ISO	$a_{p\,max}$	YCB121	YCB131	YCB211
	RCMW1204MO-PCBN	2.7			○

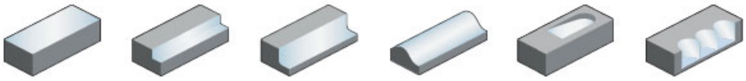
● Ex stock ○ On demand

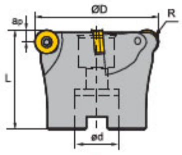
BL (CBN) CBN with a low CBN content
BH (CBN) CBN with a high CBN content

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

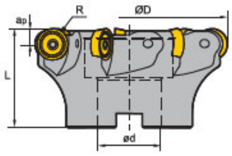
Face milling

FMR02

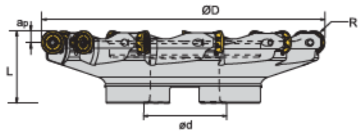




A



B



C

Article	✲	Stock	Dimensions [mm] R	ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
FMR02-050-A22-RC12-05C	✲	●	6	50	22	40	6	5	A	0.7	RCGX1204 RCKT1204 RCMW1204
FMR02-052-A22-RC12-05C	✲	●	6	52	22	40	6	5	A	0.7	
FMR02-063-A22-RC12-04		●	6	63	22	40	6	4	A	0.7	
FMR02-063-A22-RC12-06		●	6	63	22	40	6	6	A	0.7	
FMR02-063-A22-RC12-06C	✲	●	6	63	22	40	6	6	A	0.7	
FMR02-080-A27-RC12-07C	✲	●	6	80	27	50	6	7	B	0.7	
FMR02-100-B32-RC12-08C	✲	●	6	100	32	50	6	8	B	0.89	
FMR02-063-A22-RC16-04		●	8	63	22	40	8	4	A	0.7	RCKT1606
FMR02-063-A22-RC16-04C	✲	○	8	63	22	40	8	4	A	0.7	
FMR02-066-A27-RC16-05C	✲	●	8	66	27	50	8	4	A	0.5	
FMR02-080-B27-RC16-05		●	8	80	27	50	8	5	B	0.7	
FMR02-080-B27-RC16-07		●	8	80	27	50	8	7	B	0.7	
FMR02-100-B32-RC16-06		●	8	100	32	63	8	6	B	1.2	
FMR02-100-A32-RC16-06C	✲	○	8	100	32	63	8	6	B	1.2	
FMR02-125-B40-RC16-07		●	8	125	40	63	8	7	B	2.5	
FMR02-160-B40-RC16-10(FB)		○	8	160	40	63	8	10	B	3.94	
FMR02-200-C60-RC16-12FB		●	8	200	60	63	8	12	C	5.4	
FMR02-080-A27-RC20-04		●	10	80	27	50	10	4	A	0.7	RCKT2006
FMR02-080-A27-RC20-04C	✲	●	10	80	27	50	10	4	A	0.7	
FMR02-100-B32-RC20-05		●	10	100	32	63	10	5	B	1.2	
FMR02-100-B32-RC20-06		●	10	100	32	63	10	6	B	1.2	
FMR02-100-B32-RC20-06C	✲	○	10	100	32	63	10	6	B	1.2	
FMR02-125-B40-RC20-06		●	10	125	40	63	10	6	B	1.2	
FMR02-125-B40-RC20-07		●	10	125	40	63	10	7	B	2.2	
FMR02-125-B40-RC20-07C	✲	○	10	125	40	63	10	7	B	2.2	
FMR02-160-B40-RC20-08		●	10	160	40	63	10	8	B	4.2	
FMR02-160-B40-RC20-08C	✲	○	10	160	40	63	10	8	B	4.2	
FMR02-250-C60-RC20-10		●	10	250	60	63	10	10	C	8.49	
FMR02-250-C60-RC20-11		○	10	250	60	63	10	11	C	8.37	

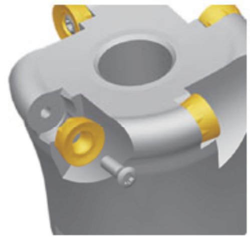
● Ex stock ○ On demand

✲ With internal cooling

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Spare parts

	Insert	RCGX1204 RCKT1204 RCMW1204	RCKT1606	RCKT2006
	ØD	50-100	63-200	80-250
	Screw (insert)	I60M3.5*10 (2.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)
	Wrench (insert)	WT15IS		
	Wrench (insert)		WT20IT	WT25IT

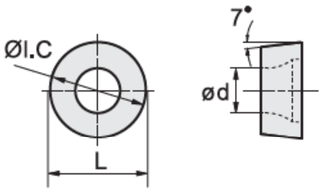


Milling inserts

○ Ideal machining conditions
◍ Normal machining conditions
✱ Unfavourable machining conditions

RCGX	I.C	S	d
12 04	12	4.76	4

RC** positive insert



ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P	◍	◍	✱	◍	◍	✱		◍			◍	◍	◍	✱	✱		○	○	○		
M		◍	✱	◍	◍	✱					◍	◍	◍	✱	✱		○	○	○		
K							◍	✱		○						◍	○				✱
N									◍											◍	✱
S				✱		✱				○	◍	◍	◍								
H																					
 RCGX1204MO-LH																				●	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

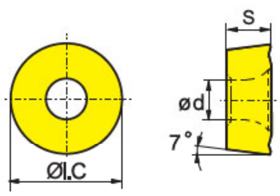
A Turning B Milling C Drilling D Technical Information E Index

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

RCKT	I.C	S	d
12 04	12	4.76	4
16 06	16	6.35	5.56
20 06	20	6.35	6.55

RC** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✿	✿	❋	✿	✿	❋		✿			✿	✿	✿	❋	❋		◯	◯	◯		
M		✿	❋	✿	✿	❋					✿	✿	✿	❋	❋		◯	◯	◯		
K							✿	❋		◯						✿	◯				❋
N									✿											✿	❋
S				❋		❋				◯	✿	✿	✿								
H																					
 **RCKT1204MO-DM**		●	●		●	●	○						●		○						
RCKT1606MO-DM		●	●		○							○			●						
RCKT2006MO-DM		○	○		○																
 **RCKT1204MO-DR**		●	●		●	●						○	○								
RCKT1606MO-DR	●	●	●			●		●			○		○								
RCKT2006MO-DR	●	●	●			○		●					○		○						
 **RCKT1204MO-ER**				●																	
RCKT1606MO-ER				●																	
RCKT2006MO-ER				●																	
 **RCKT1204MO-NM**				●		●					●			○	○						
RCKT1606MO-NM				○		○					●			○	○						

● Ex stock ○ On demand

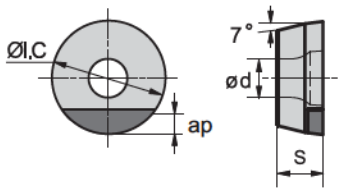
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

RCMW	I.C	S	d
12 04	12	4.76	4.1

RN** negative insert



	$a_{p\ max}$	BL (CBN)		BH (CBN)
ISO		YCB121	YCB131	YCB211
P				
M				
K				◯
N				
S			✿	
H		✿	❋	
 **RCMW1204MO-PCBN**	2.7			○

● Ex stock ○ On demand

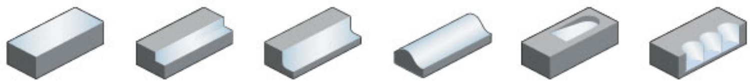
BL (CBN) CBN with a low CBN content
BH (CBN) CBN with a high CBN content

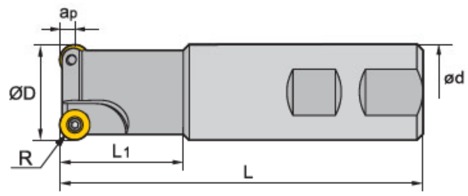
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

FMR03





Article	✲	Stock	Dimensions [mm]						Teeth	kg	Inserts 
			R	ØD	ød	L_1	L	$a_{p\,max}$			
FMR03-016-XP16-RD08-02		○	4	16	16	25	100	4	2	0.1	RDKW0803
FMR03-016-XP16-RD08-02C	✲	○	4	16	16	25	100	4	2	0.1	
FMR03-025-XP25-RD08-02		●	4	25	25	30	100	4	2	0.3	
FMR03-025-XP25-RD08-02C	✲	○	4	25	25	30	100	4	2	0.3	
FMR03-032-XP32-RD10-02		●	5	32	32	40	120	5	2	0.7	RDKW10T3
FMR03-032-XP32-RD10-02C	✲	○	5	32	32	40	120	5	2	0.7	
FMR03-040-XP32-RD12-03		●	6	40	32	40	120	6	3	0.7	RDKW1204
FMR03-040-XP32-RD12-03C	✲	○	6	40	32	40	120	6	3	0.7	
FMR03-050-XP32-RD12-04		●	6	50	32	40	120	6	4	0.8	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	RDKW0803	RDKW10T3	RDKW1204
	ØD	16-25	32	40-50
	Screw (insert)	I60M3*7 (1.8 Nm)	I60M4*10 (3.4 Nm)	I60M4*10 (3.4 Nm)
	Wrench (insert)	WT09IP	WT15IP	WT15IP

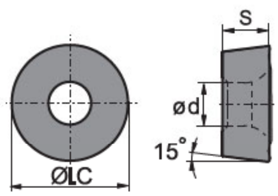
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❀ Unfavourable machining conditions

RDKW	I.C	S	d
08 03	8	3.18	3.4
10 T3	10	3.97	4.4
12 04	12	4.76	4.4

RD** milling insert



ISO		HC¹ (CVD) YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	HC¹ (PVD) YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	HT YNG151	HC² YNG151C	HW YD101	YD201
	P	✿	✿	❀	✿	✿	❀		✿			✿	✿	✿	❀	❀		◯	◯	◯		
	M		✿	❀	✿	✿	❀					✿	✿	✿	❀	❀		◯	◯	◯		
	K							✿	❀		◯						✿	◯				❀
	N									✿											✿	❀
	S				❀		❀				◯	✿	✿	✿								
	H																					
	RDKW0803MO						●							●								
	RDKW10T3MO	●	○				○				●			●		○						
	RDKW1204MO	●				●	●				●	●	●	●		○						

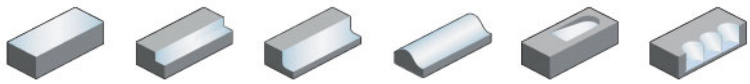
● Ex stock ○ On demand

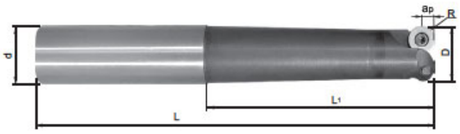
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Face milling

FMR03





Article	✲	Stock	Dimensions [mm] R	ØD	ød	L_1	L	$a_{p\,max}$	Teeth	Inserts 
FMR03-015-G16-XS-RD0702-02		○	3.5	15	16	40	88	3.5	2	
FMR03-015-G16-XS-RD0702-02C	✲	○	3.5	15	16	40	88	3.5	2	
FMR03-015-G16-S-RD0702-02C	✲	○	3.5	15	16	60	108	3.5	2	RDKW0702
FMR03-015-G20-M-RD0702-02C	✲	○	3.5	15	20	80	130	3.5	2	
FMR03-015-G25-XL-RD0702-02C	✲	○	3.5	15	25	120	176	3.5	2	
FMR03-020-G20-XS-RD1003-02C	✲	○	5	20	20	40	90	5	2	
FMR03-020-G20-S-RD1003-02C	✲	○	5	20	20	60	110	5	2	
FMR03-020-G25-M-RD1003-02C	✲	○	5	20	25	80	136	5	2	RDKW1003
FMR03-020-G25-L-RD1003-02C	✲	○	5	20	25	100	156	5	2	
FMR03-020-G25-XL-RD1003-02C	✲	○	5	20	25	120	176	5	2	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	RDKW0702	RDKW1003
	ØD	15	20
	Screw (insert)	I60M2.5*5.0 (1.0 Nm)	I60M3.5*7.7 (2.7 Nm)
	Wrench (insert)	WT07P	WT15P

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

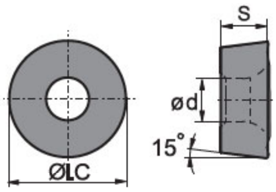
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

RDKW	I.C	S	d
07 02	7	2.38	2.7
10 03	10	3.18	3.9

RD** milling insert



ISO		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102
		HC¹ (CVD)								HC¹ (PVD)	
	P	✿	✿	❋	✿	✿	❋		✿		
	M		✿	❋	✿	✿	❋				
	K							✿	❋		◯
	N									✿	
	S				❋		❋				◯
	H										
	RDKW0702MO-1						●				
	RDKW0702MO-2										●
	RDKW1003MO-1					●	●				
	RDKW1003MO-2										●
	RDKW1003MO-3				●						

ISO		YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (PVD)							HT	HC²	HW	
	P	✿	✿	✿	❋	❋		◯	◯	◯		
	M	✿	✿	✿	❋	❋		◯	◯	◯		
	K						✿	◯				❋
	N										✿	❋
	S	✿	✿	✿								
	H											
	RDKW0702MO-1			●								
	RDKW0702MO-2											
	RDKW1003MO-1	●	●	●								
	RDKW1003MO-2											
	RDKW1003MO-3		●									

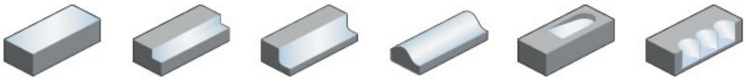
● Ex stock ○ On demand

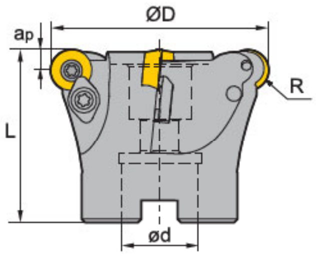
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

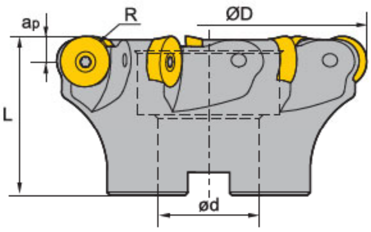
Face milling

FMR04





A



B

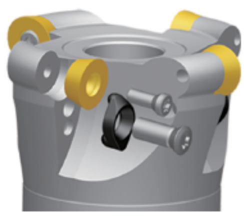
Article	✲	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			R	ØD	ød	L	$a_{p\ max}$				
FMR04-050-A22-RD12-03		●	6	50	22	40	6	3	A	0.3	RDKW1204
FMR04-063-A22-RD12-04		●	6	63	22	50	6	4	A	0.5	
FMR04-080-B27-RD16-05		●	8	80	27	50	8	5	B	1.2	RDKW1605
FMR04-100-B32-RD16-06		●	8	100	32	50	8	6	B	1	
FMR04-125-B40-RD20-06		○	10	125	40	63	10	6	B	1.9	RDKW2006
FMR04-125-B40-RD20-06C	✲	○	10	125	40	63	10	6	B	1.9	
FMR04-160-B40-RD20-07		○	10	160	40	63	10	7	B	3.7	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	RDKW1204	RDKW1605	RDKW2006
	ØD	50-63	80-100	125 -160
	Clamp	WD-204	WD-207	
	Screw (clamp)	I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)	
	Screw (insert)	I60M3.5*10 (2.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)
	Wrench (clamp)	WT15IP		
	Wrench (clamp)		WT20IT	
	Wrench (insert)	WT15IP		
	Wrench (insert)		WT20IT	WT25IT



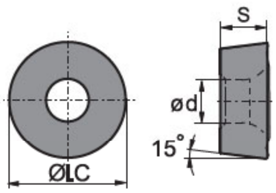
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

RDKW	I.C	S	d
12 04	12	4.76	4.4
16 05	16	5.56	5.5
20 06	20	6.35	6.5

RD** milling insert



Group	ISO	P	M	K	N	S	H	RDKW1204MO	RDKW1605MO	RDKW2006MO	RDKW2006MO-3
HC¹ (CVD)	YBC302	Normal						●			
	YBC301	Normal	Normal							○	
	YBC401	Unfavourable	Unfavourable								
	YBM253	Normal	Normal			Unfavourable					
	YBM251	Normal	Normal					●			
	YBM351	Unfavourable	Unfavourable			Unfavourable		●	○	●	
	YBD152			Normal							
	YBD252	Normal		Unfavourable						○	
HC¹ (PVD)	YBG101				Normal						
	YBG102			Ideal		Ideal		●			
	YB9320	Normal	Normal			Normal		●			
	YBG205	Normal	Normal			Normal		●			●
	YBG202	Normal	Normal			Normal		●	●		
	YBG212	Unfavourable	Unfavourable						○		
	YBG302	Unfavourable	Unfavourable					○	○		
	YBG152			Normal							
	YBG252	Ideal	Ideal	Ideal							
HT	YNG151	Ideal	Ideal								
HC²	YNG151C	Ideal	Ideal								
HW	YD101				Normal						
	YD201			Unfavourable	Unfavourable						

● Ex stock ○ On demand

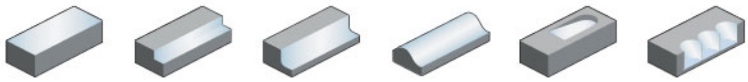
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

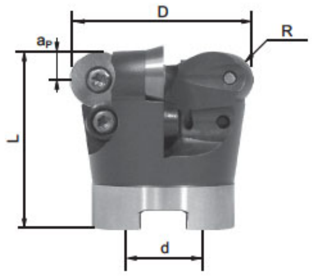
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Face milling

FMR04





Article	✲	Stock	Dimensions [mm] R	ØD	ød	L	$a_{p\,max}$	Teeth	Inserts 
FMR04-042-A16-RD1003-06		●	5	42	16	44	5	6	RDKW1003
FMR04-042-A16-RD1003-06C	✲	○	5	42	16	44	5	6	
FMR04-052-A22-RD1003-07		●	5	52	22	50	5	7	
FMR04-052-A22-RD1003-07C	✲	○	5	52	22	50	5	7	
FMR04-042-A16-RD12T3-05		●	6	42	16	42	6	5	RDKW12T3
FMR04-042-A16-RD12T3-05C	✲	○	6	42	16	42	6	5	
FMR04-052-A22-RD12T3-05		●	6	52	22	50	6	5	
FMR04-052-A22-RD12T3-05C	✲	○	6	52	22	50	6	5	
FMR04-066-A27-RD12T3-06		●	6	66	27	50	6	6	
FMR04-066-A27-RD12T3-06C	✲	○	6	66	27	50	6	6	
FMR04-080-A27-RD12T3-07		●	6	80	27	50	6	7	
FMR04-080-A27-RD12T3-07C	✲	○	6	80	27	50	6	7	
FMR04-052-A22-RD1604-04		●	8	52	22	50	8	4	RDKW1604
FMR04-052-A22-RD1604-04C	✲	○	8	52	22	50	8	4	
FMR04-066-A27-RD1604-05		●	8	66	27	50	8	5	
FMR04-066-A27-RD1604-05C	✲	○	8	66	27	50	8	5	
FMR04-080-A27-RD1604-06		●	8	80	27	52	8	6	
FMR04-080-A27-RD1604-06C	✲	○	8	80	27	52	8	6	
FMR04-100-B32-RD1604-07		●	8	100	32	52	8	7	
FMR04-100-B32-RD1604-07C	✲	○	8	100	32	52	8	7	
FMR04-125-B40-RD1604-08		●	8	125	40	52	8	8	
FMR04-160-B40-RD1604-09		●	8	160	40	52	8	9	
FMR04-160-B40-RD1604-09C	✲	○	8	160	40	52	8	9	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

ZCC·CT

Spare parts

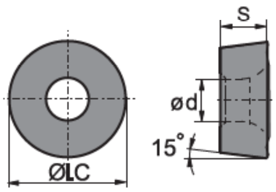
	Insert	RDKW1003	RDKW12T3	RDKW12T3	RDKW1604	RDKW1604
	ØD	**42-52**	**42**	**52-80**	**52**	**66-160**
	Clamp					WX16N
	Clamp			LOM3.5*7.1		
	Screw (clamp)					I60M4.5*10 (5.0 Nm)
	Screw (insert)	I60M3.5*7.7 (2.7 Nm)	I60M3.5*7.7 (2.7 Nm)	I60M3.5*7.7 (2.7 Nm)	I60M4.5*10 (5.0 Nm)	I60M4.5*10 (5.0 Nm)
	Wrench (clamp)			WT15P		
	Wrench (clamp)					WT20T
	Wrench (insert)	WT15P	WT15P	WT15P		
	Wrench (insert)				WT20T	WT20T

Milling inserts

◯ Ideal machining conditions
✪ Normal machining conditions
✱ Unfavourable machining conditions

RDKW	I.C	S	d
10 03	10	3.18	3.9
12 T3	12	3.97	3.9
16 04	16	4.76	5.2

RD** milling insert



ISO	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✪	✪	✱	✪	✪	✱		✪			✪	✪	✪	✱	✱		◯	◯	◯		
M		✪	✱	✪	✪	✱					✪	✪	✪	✱	✱		◯	◯	◯		
K							✪	✱		◯						✪	◯				✱
N									✪											✪	✱
S				✱		✱				◯	✪	✪	✪								
H																					
RDKW1003MO-1					●	●					●	●	●								
RDKW1003MO-2										●											
RDKW1003MO-3				●								●									
RDKW12T3MO-1					●	●					●	●	●								
RDKW12T3MO-2										●		○									
RDKW12T3MO-3				●								●									
RDKW1604MO-1						●					●	●	●		●						
RDKW1604MO-2										○											
RDKW1604MO-3	○	○		●				●		○		●			●						

● Ex stock ○ On demand

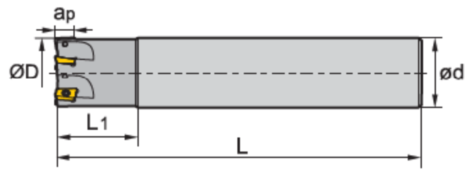
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Square shoulder milling

EMP01 Kr: 90°



Straight shank

Article	✲	Stock	Dimensions [mm] ØD	ød	L_1	L	$a_{p\,max}$	Teeth	kg	Inserts 
EMP01-012-G12-AP07-02C	✲	●	12	12	25	75	6.4	2	0.31	APKT0702
EMP01-014-G16-AP07-03C	✲	●	14	16	25	85	6.4	3	0.61	APKT0702
EMP01-016-G16-AP07-04C	✲	●	16	16	30	90	6.4	4	0.75	APKT0702
EMP01-012-G16-AP11-01		●	12	16	25	85	10.5	1	0.1	APKT11T3
EMP01-016-G16-AP11-02		●	16	16	25	90	10.5	2	0.1	APKT11T3
EMP01-016-G16-AP11-02C	✲	○	16	16	25	90	10.5	2	0.1	APKT11T3
EMP01-020-G20-AP11-02		●	20	20	30	100	10.5	2	0.2	APKT11T3
EMP01-020-G20-AP11-02C	✲	●	20	20	30	100	10.5	2	0.2	APKT11T3
EMP01-020-G20-AP11-03		○	20	20	30	100	10.5	3	0.2	APKT11T3
EMP01-020-G20-AP11-03C	✲	●	20	20	30	100	10.5	3	0.2	APKT11T3
EMP01-025-G25-AP11-03		●	25	25	35	115	10.5	3	0.4	APKT11T3
EMP01-025-G25-AP11-03C	✲	○	25	25	35	115	10.5	3	0.4	APKT11T3
EMP01-025-G25-AP11-04		●	25	25	35	115	10.5	4	0.4	APKT11T3
EMP01-025-G25-AP11-04C	✲	●	25	25	35	115	10.5	4	0.4	APKT11T3
EMP01-032-G32-AP11-04		●	32	32	40	125	10.5	4	0.7	APKT11T3
EMP01-032-G32-AP11-04C	✲	●	32	32	40	125	10.5	4	0.7	APKT11T3
EMP01-025-G25-AP16-02		●	25	25	35	115	15.5	2	0.4	APKT1604
EMP01-025-G25-AP16-02C	✲	●	25	25	35	115	15.5	2	0.4	APKT1604
EMP01-032-G32-AP16-03		●	32	32	40	125	15.5	3	0.7	APKT1604
EMP01-032-G32-AP16-03C	✲	●	32	32	40	125	15.5	3	0.7	APKT1604
EMP01-040-G32-AP16-03		●	40	32	42	130	15.5	3	0.7	APKT1604
EMP01-040-G32-AP16-03C	✲	●	40	32	42	130	15.5	3	0.7	APKT1604
EMP01-040-G32-AP16-04		●	40	32	42	130	15.5	4	0.8	APKT1604
EMP01-040-G32-AP16-04C	✲	○	40	32	42	130	15.5	4	0.8	APKT1604
EMP01-050-G32-AP16-05		●	50	32	45	135	15.5	5	1	APKT1604
EMP01-063-G32-AP16-06		●	63	32	45	135	15.5	6	1.4	APKT1604

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

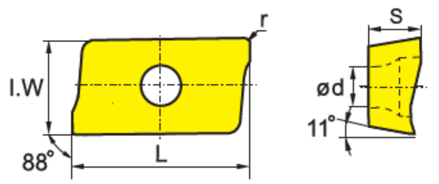
	Insert	APKT0702	APKT11T3	APKT1604
	ØD	12-25	12-32	25-63
	Screw (insert)	I60M1,8x4 (0.3 Nm)		I60M4*8.4 (3.4 Nm)
	Screw (insert)		I60M2.5*6.5T (1.0 Nm)	
	Wrench (insert)	WT05IP	WT08IP	
	Wrench (insert)			WT15S

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

◯ Ideal machining conditions
✪ Normal machining conditions
✲ Unfavourable machining conditions

Milling inserts

AP** milling insert



ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P			✪	✪	✲	✪	✪	✲		✪			✪	✪	✪	✲	✲		◯	◯	◯		
M				✪	✲	✪	✪	✲					✪	✪	✪	✲	✲		◯	◯	◯		
K									✪	✲		◯						✪	◯				✲
N											✪											✪	✲
S						✲		✲				◯	✪	✪	✪								
H																							
 **APKT11T304-ALH**	0.4	6.5									●											●	●
APKT11T308-ALH	0.8	6.5									●											●	●
APKT160408-ALH	0.8	9.33									●											●	●
 **APKT11T304-APF**	0.4	6.5											●										
APKT11T308-APF	0.8	6.5											●										
APKT160408-APF	0.8	9.33											●		○		○						
APKT070204-APM	0.4	6.91								●			●										
APKT11T304-APM	0.4	6.5				●			●				●										
APKT11T308-APM	0.8	6.5				●			●				●										
APKT11T312-APM	1.2	6.5				●			●				●										
APKT11T316-APM	1.6	6.5				●			●				●										
 **APKT11T320-APM**	2	6.5				●			●				●										
APKT160408-APM	0.8	9.33				●			●	●			●										
APKT160416-APM	1.6	9.33				●			●				●										
APKT160420-APM	2	9.33				●			●				●										
APKT160424-APM	2.4	9.33				●			●				●										
APKT160430-APM	3	9.33				●			●				●										
 **APKT11T304-LH**	0.4	6.5																				●	●
APKT11T308-LH	0.8	6.5																				●	●
APKT160408-LH	0.8	9.33																				●	●

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

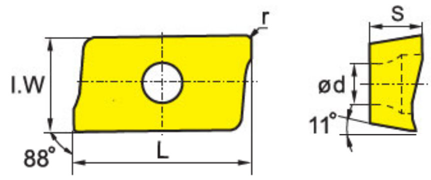
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✹ Unfavourable machining conditions

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

AP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	✹	✲	✲	✹		✲			✲	✲	✲	✹	✹		◯	◯	◯		
M		✲	✹	✲	✲	✹					✲	✲	✲	✹	✹		◯	◯	◯		
K							✲	✹		◯						✲	◯				✹
N									✲											✲	✹
S				✹		✹				◯	✲	✲	✲								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT11T304-PF**	0.4	6.5		○			●					●			●		●						
	APKT11T308-PF	0.8	6.5					○					○			●								
	APKT11T312-PF	1.2	6.5													○								
	APKT11T316-PF	1.6	6.5													○								
	APKT160408-PF	0.8	9.33		●			○	●							●		●						
	APKT160430-PF	3	9.33	○																				
	**APKT11T304-PM**	0.4	6.5	●	●	○		●	●				○			●		●						
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●		●		●	●		●						
	APKT11T312-PM	1.2	6.5					○					○			●		○						
	APKT11T316-PM	1.6	6.5					●					○			●		○						
	APKT160408-PM	0.8	9.33	●	●	●	●	●	●	●	●		●		●	●		●						
	APKT160416-PM	1.6	9.33	○												●								
	**APKT11T304-PR**	0.4	6.5						○							○		○						
	APKT11T316-PR	1.6	6.5															○						

● Ex stock ○ On demand

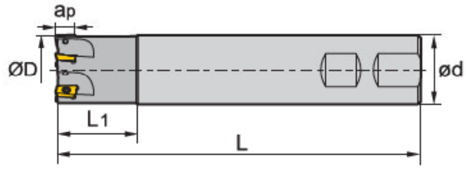
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

ZCC·CT

Square shoulder milling

EMP01 Kr: 90°



Weldon shank

Article	✲	Stock	Dimensions [mm] ØD	ød	L_1	L	$a_{p\,max}$	Teeth	kg	Inserts 
EMP01-020-XP20-AP07-05C	✲	●	20	20	30	100	6.4	5	0.31	APKT0702
EMP01-025-XP25-AP07-07C	✲	●	25	25	35	115	6.4	7	0.61	
EMP01-012-XP16-AP11-01		●	12	16	25	85	10.5	1	0.1	APKT11T3
EMP01-012-XP16-AP11-01C	✲	○	12	16	25	85	10.5	1	0.1	
EMP01-016-XP16-AP11-02		●	16	16	25	90	10.5	2	0.1	
EMP01-016-XP16-AP11-02C	✲	○	16	16	25	90	10.5	2	0.1	
EMP01-020-XP20-AP11-02		●	20	20	30	100	10.5	2	0.2	
EMP01-020-XP20-AP11-02C	✲	○	20	20	30	100	10.5	2	0.2	
EMP01-020-XP20-AP11-03		●	20	20	30	100	10.5	3	0.2	
EMP01-020-XP20-AP11-03C	✲	●	20	20	30	100	10.5	3	0.2	
EMP01-025-XP25-AP11-03		●	25	25	35	115	10.5	3	0.4	
EMP01-025-XP25-AP11-03C	✲	●	25	25	35	115	10.5	3	0.4	
EMP01-025-XP25-AP11-04		●	25	25	35	115	10.5	4	0.4	
EMP01-025-XP25-AP11-04C	✲	○	25	25	35	115	10.5	4	0.4	
EMP01-032-XP32-AP11-04		●	32	32	40	125	10.5	4	0.7	
EMP01-032-XP32-AP11-04C	✲	○	32	32	40	125	10.5	4	0.7	
EMP01-025-XP25-AP16-02		●	25	25	35	115	15.5	2	0.4	APKT1604
EMP01-025-XP25-AP16-02C	✲	○	25	25	35	115	15.5	2	0.4	
EMP01-032-XP32-AP16-03		●	32	32	40	125	15.5	3	0.7	
EMP01-032-XP32-AP16-03C	✲	○	32	32	40	125	15.5	3	0.7	
EMP01-040-XP32-AP16-04		●	40	32	42	130	15.5	4	0.8	
EMP01-040-XP32-AP16-04C	✲	○	40	32	42	130	15.5	4	0.8	
EMP01-050-XP32-AP16-05		●	50	32	45	135	15.5	5	1	
EMP01-063-XP32-AP16-06		○	63	32	45	135	15.5	6	1.4	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

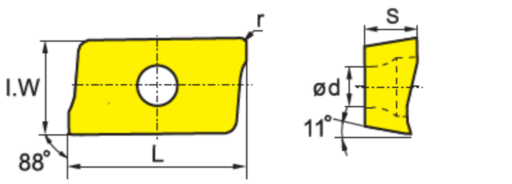
	Insert	APKT0702	APKT11T3	APKT1604
	ØD	12-25	12-32	25-63
	Screw (insert)	I60M1,8x4 (0.3 Nm)		I60M4*8.4 (3.4 Nm)
	Screw (insert)		I60M2.5*6.5T (1.0 Nm)	
	Wrench (insert)	WT05IP	WT08IP	
	Wrench (insert)			WT15S

Milling inserts

- ◯ Ideal machining conditions
- ✲ Normal machining conditions
- ✺ Unfavourable machining conditions

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

AP** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◯	◯	◯		
M		✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◯	◯	◯		
K							✲	✺		◯						✲	◯				✺
N									✲											✲	✺
S				✺		✺				◯	✲	✲	✲								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	APKT11T304-ALH	0.4	6.5									●											●	●
	APKT11T308-ALH	0.8	6.5									●											●	●
	APKT160408-ALH	0.8	9.33									●											●	●
	APKT11T304-APF	0.4	6.5											●										
	APKT11T308-APF	0.8	6.5											●										
	APKT160408-APF	0.8	9.33											●		○		○						
	APKT070204-APM	0.4	6.91								●			●										
	APKT11T304-APM	0.4	6.5				●			●				●										
	APKT11T308-APM	0.8	6.5				●			●				●										
	APKT11T312-APM	1.2	6.5				●			●				●										
	APKT11T316-APM	1.6	6.5				●			●				●										
	APKT11T320-APM	2	6.5				●			●				●										
	APKT160408-APM	0.8	9.33				●			●	●			●										
	APKT160416-APM	1.6	9.33				●			●				●										
	APKT160420-APM	2	9.33				●			●				●										
	APKT160424-APM	2.4	9.33				●			●				●										
	APKT160430-APM	3	9.33				●			●				●										
	APKT11T304-LH	0.4	6.5																				●	●
	APKT11T308-LH	0.8	6.5																				●	●
	APKT160408-LH	0.8	9.33																				●	●

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

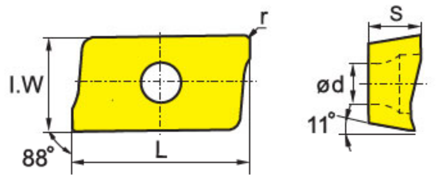
System code > B26 | Grade selection > B24 | Technical info > B463 | Cutting data > B224

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

Milling inserts

- ◯ Ideal machining conditions
- ⊛ Normal machining conditions
- ✺ Unfavourable machining conditions

AP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊛	⊛	✺	⊛	⊛	✺		⊛			⊛	⊛	⊛	✺	✺		◯	◯	◯		
M		⊛	✺	⊛	⊛	✺					⊛	⊛	⊛	✺	✺		◯	◯	◯		
K							⊛	✺		◯						⊛	◯				✺
N									⊛											⊛	✺
S				✺		✺				◯	⊛	⊛	⊛								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT11T304-PF**	0.4	6.5		○			●					●			●		●						
	APKT11T308-PF	0.8	6.5					○					○			●								
	APKT11T312-PF	1.2	6.5													○								
	APKT11T316-PF	1.6	6.5													○								
	APKT160408-PF	0.8	9.33		●			○	●							●		●						
	APKT160430-PF	3	9.33	○																				
	**APKT11T304-PM**	0.4	6.5	●	●	○		●	●				○			●		●						
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●		●		●	●		●						
	APKT11T312-PM	1.2	6.5					○					○			●		○						
	APKT11T316-PM	1.6	6.5					●					○			●		○						
	APKT160408-PM	0.8	9.33	●	●	●	●	●	●	●	●		●		●	●		●						
	APKT160416-PM	1.6	9.33	○												●								
	**APKT11T304-PR**	0.4	6.5						○							○		○						
	APKT11T316-PR	1.6	6.5															○						

● Ex stock ○ On demand

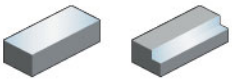
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

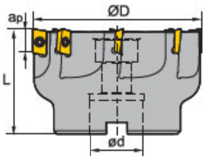
System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

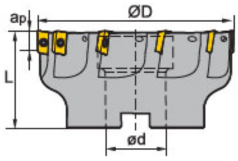
Square shoulder milling

EMP02 Kr: 90°

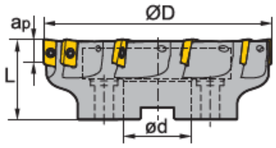




A



B



C

Article	✱	Stock	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts 
EMP02-032-A16-AP07-08C	✱	●	32	16	35	6.4	8	A	34	APKT0702
EMP02-040-A16-AP07-10C	✱	●	40	16	40	6.4	10	A	40	
EMP02-050-A22-AP07-12C	✱	●	50	22	40	6.4	12	A	0.6	
EMP02-040-A16-AP11-04C	✱	●	40	16	40	11	4	A	0.237	APKT11T3
EMP02-040-A16-AP11-05C	✱	●	40	16	40	11	5	A	0.177	
EMP02-040-A16-AP11-06C	✱	●	40	16	40	11	6	A	0.234	
EMP02-050-A22-AP11-06		●	50	22	40	11	6	A	0.3	
EMP02-050-A22-AP11-06C	✱	●	50	22	40	11	6	A	0.3	
EMP02-050-A22-AP11-07C	✱	●	50	22	40	11	7	A	0.39	
EMP02-063-A22-AP11-08		●	63	22	40	11	8	A	0.6	
EMP02-063-A22-AP11-08C	✱	●	63	22	40	11	8	A	0.6	
EMP02-063-A22-AP11-09C	✱	●	63	22	40	11	9	A	0.54	
EMP02-080-A27-AP11-08		●	80	27	50	11	8	A	1.2	
EMP02-080-A27-AP11-08C	✱	●	80	27	50	11	8	A	1.2	
EMP02-080-A27-AP11-10C	✱	●	80	27	50	11	10	A	1.13	
EMP02-100-B32-AP11-10		●	100	32	50	11	10	B	1.7	
EMP02-100-B32-AP11-10C	✱	○	100	32	50	11	10	B	1.7	
EMP02-125-B40-AP11-10		○	125	40	63	11	10	B	3.42	
EMP02-040-A16-AP16-03		○	40	16	40	15.5	3	A	0.17	APKT1604
EMP02-040-A16-AP16-04C	✱	●	40	16	40	15.5	4	A	0.17	
EMP02-050-A22-AP16-05		●	50	22	40	15.5	5	A	0.3	
EMP02-050-A22-AP16-05C	✱	●	50	22	40	15.5	5	A	0.3	
EMP02-063-A22-AP16-06		●	63	22	40	15.5	6	A	0.5	
EMP02-063-A22-AP16-06C	✱	●	63	22	40	15.5	6	A	0.5	
EMP02-080-A27-AP16-06C	✱	○	80	27	50	15.5	6	A	1.08	
EMP02-080-A27-AP16-07		●	80	27	50	15.5	7	A	1.1	
EMP02-080-A27-AP16-07C	✱	●	80	27	50	15.5	7	A	1.1	
EMP02-100-B32-AP16-08		●	100	32	50	15.5	8	B	1.6	

● Ex stock ○ On demand

✱ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Article	*	Stock	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
EMP02-100-B32-AP16-08C	*	●	100	32	50	15.5	8	B	1.6	 APKT1604
EMP02-125-B40-AP16-06C	*	○	125	40	63	15.5	6	B	3.18	
EMP02-125-B40-AP16-10		○	125	40	63	15.5	10	B	3.2	
EMP02-125-B40-AP16-10C	*	○	125	40	63	15.5	10	B	3.2	
EMP02-160-B40-AP16-07C	*	○	160	40	63	15.5	7	B	4.3	
EMP02-160-B40-AP16-10		○	160	40	63	15.5	10	B	6.3	
EMP02-160-B40-AP16-10C	*	○	160	40	63	15.5	10	B	6.3	
EMP02-200-C60-AP16-12		○	200	60	63	15.5	12	C	8.1	
EMP02-250-C60-AP16-12		○	250	60	63	15.5	12	C	11.2	

● Ex stock ○ On demand

* With internal cooling

Spare parts

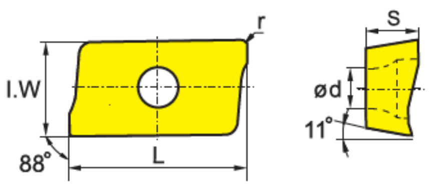
Insert	APKT0702	APKT11T3	APKT1604
ØD	32-50	40-125	40-250
Screw (insert)	I60M1,8x4 (0.3 Nm)		I60M4*10 (3.4 Nm)
Screw (insert)		I60M2.5*6.5T (1.0 Nm)	
Wrench (insert)	WT05IP		
Wrench (insert)		WT08IS	WT15IS

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

AP** milling insert



HC¹ (CVD): YBC302, YBC301, YBC401, YBM253, YBM251, YBM351, YBD152, YBD252
HC¹ (PVD): YBG101, YBG102, YB9320, YBG205, YBG202, YBG212, YBG302, YBG152, YBG252
HT: YNG151
HC²: YNG151C
HW: YD101, YD201

	ISO	r	l.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT11T304-ALH**	0.4	6.5									●											●	●
	APKT11T308-ALH	0.8	6.5									●											●	●
	APKT160408-ALH	0.8	9.33									●											●	●

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

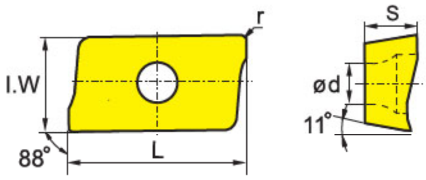
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

APKT	L	S	d
07 02	4.26	2.38	2
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✺ Unfavourable machining conditions

AP** milling insert



	HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◯	◯	◯		
M		✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◯	◯	◯		
K							✲	✺		◯						✲	◯				✺
N									✲											✲	✺
S				✺		✺				◯	✲	✲	✲								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	APKT11T304-APF	0.4	6.5											●										
	APKT11T308-APF	0.8	6.5											●										
	APKT160408-APF	0.8	9.33											●		○		○						
	APKT070204-APM	0.4	6.91								●			●										
	APKT11T304-APM	0.4	6.5				●			●				●										
	APKT11T308-APM	0.8	6.5				●			●				●										
	APKT11T312-APM	1.2	6.5				●			●				●										
	APKT11T316-APM	1.6	6.5				●			●				●										
	APKT11T320-APM	2	6.5				●			●				●										
	APKT160408-APM	0.8	9.33				●			●	●			●										
	APKT160416-APM	1.6	9.33				●			●				●										
	APKT160420-APM	2	9.33				●			●				●										
	APKT160424-APM	2.4	9.33				●			●				●										
	APKT160430-APM	3	9.33				●			●				●										
	APKT11T304-LH	0.4	6.5																				●	●
	APKT11T308-LH	0.8	6.5																				●	●
	APKT160408-LH	0.8	9.33																				●	●
	APKT11T304-PF	0.4	6.5		○			●					●			●		●						
	APKT11T308-PF	0.8	6.5					○					○			●								
	APKT11T312-PF	1.2	6.5													○								
	APKT11T316-PF	1.6	6.5													○								
	APKT160408-PF	0.8	9.33		●			○	●							●		●						
	APKT160430-PF	3	9.33	○																				
	APKT11T304-PM	0.4	6.5	●	●	○		●	●				○			●		●						
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●		●		●	●		●						
	APKT11T312-PM	1.2	6.5					○					○			●		○						
	APKT11T316-PM	1.6	6.5					●					○			●		○						
	APKT160408-PM	0.8	9.33	●	●	●	●	●	●	●	●		●		●	●		●						
	APKT160416-PM	1.6	9.33	○												●								
	APKT11T304-PR	0.4	6.5						○							○		○						
	APKT11T316-PR	1.6	6.5															○						

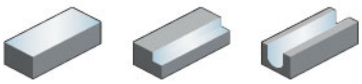
● Ex stock ○ On demand

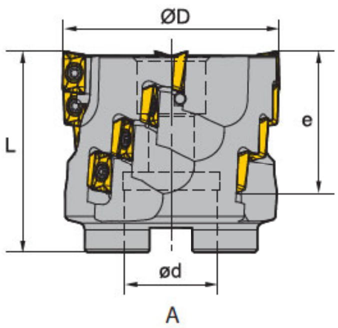
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

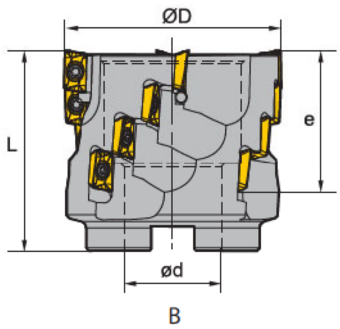
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Square shoulder milling

EMP03 Kr: 90°







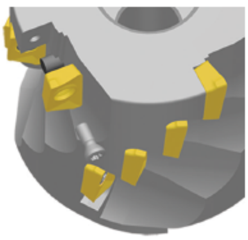
Article	✻	Stock	Dimensions [mm]				Teeth	Coupling	No. of inserts	kg	Inserts 
			ØD	e	ød	L					
EMP03-050-A22-AP11-04		●	50	39	22	58	4	A	16	0.5	
EMP03-050-A22-AP11-04C	✻	○	50	39	22	58	4	A	16	0.5	
EMP03-063-A27-AP11-04		●	63	39	27	58	4	A	16	0.9	
EMP03-063-A27-AP11-04C	✻	○	63	39	27	58	4	A	16	0.9	APKT11T3
EMP03-080-B32-AP11-05		●	80	39	32	63	5	B	20	1.3	
EMP03-080-B32-AP11-05C	✻	○	80	39	32	63	5	B	20	1.3	
EMP03-100-B40-AP11-06		●	100	39	40	63	6	B	24	2	
EMP03-100-B40-AP11-06C	✻	○	100	39	40	63	6	B	24	2	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	APKT11T3
	ØD	**50-100**
	Screw (insert)	I60M2.5*6.5T (1.0 Nm)
	Wrench (insert)	WT08IS



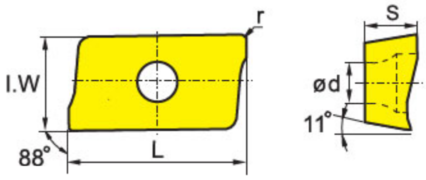
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

APKT	L	S	d
11 T3	12.24	3.6	2.8

AP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✿	✿	❋	✿	✿	❋		✿			✿	✿	✿	❋	❋		◯	◯	◯		
M		✿	❋	✿	✿	❋					✿	✿	✿	❋	❋		◯	◯	◯		
K							✿	❋		◯						✿	◯				❋
N									✿											✿	❋
S				❋		❋				◯	✿	✿	✿								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT11T304-ALH**	0.4	6.5									●											●	●
	APKT11T308-ALH	0.8	6.5									●											●	●
	**APKT11T304-APF**	0.4	6.5											●										
	APKT11T308-APF	0.8	6.5											●										
	**APKT11T304-APM**	0.4	6.5				●			●				●										
	APKT11T308-APM	0.8	6.5				●			●				●										
	APKT11T312-APM	1.2	6.5				●			●				●										
	APKT11T316-APM	1.6	6.5				●			●				●										
	APKT11T320-APM	2	6.5				●			●				●										
	**APKT11T304-LH**	0.4	6.5																				●	●
	APKT11T308-LH	0.8	6.5																				●	●
	**APKT11T304-PF**	0.4	6.5		○			●					●			●		●						
	APKT11T308-PF	0.8	6.5					○					○			●								
	APKT11T312-PF	1.2	6.5													○								
	APKT11T316-PF	1.6	6.5													○								
	**APKT11T304-PM**	0.4	6.5	●	●	○		●	●				○			●		●						
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●		●		●	●		●						
	APKT11T312-PM	1.2	6.5					○					○			●		○						
	APKT11T316-PM	1.6	6.5					●					○			●		○						
	**APKT11T304-PR**	0.4	6.5						○							○		○						
	APKT11T316-PR	1.6	6.5															○						

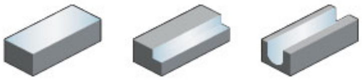
● Ex stock ○ On demand

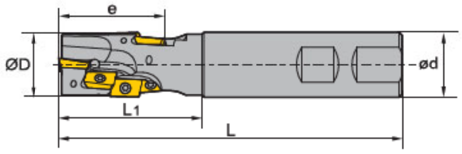
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Square shoulder milling

EMP04 Kr: 90°





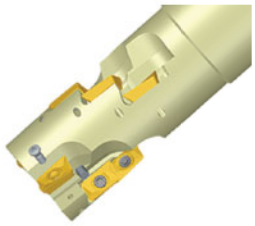
Weldon shank

Article	✻	Stock	Dimensions [mm]					Teeth	No. of inserts	kg	Inserts 
			ØD	e	ød	L_1	L				
EMP04-020-XP20-AP11-01		●	20	29.4	20	45	120	1	3	0.3	APKT11T3
EMP04-025-XP25-AP11-02		●	25	38.9	25	55	130	2	8	0.4	
EMP04-032-XP32-AP11-02		●	32	48.5	32	65	140	2	10	0.7	
EMP04-040-XP40-AP11-02		●	40	58	40	75	150	2	14	1.3	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**APKT11T3**	
	ØD	**20-40**	
	Screw (insert)	I60M2.5*6.5T (1.0 Nm)	
	Wrench (insert)	WT08IS	

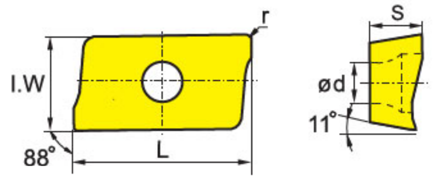
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✸ Unfavourable machining conditions

APKT	L	S	d
11 T3	12.24	3.6	2.8

AP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	✸	✲	✲	✸		✲			✲	✲	✲	✸	✸		◯	◯	◯		
M		✲	✸	✲	✲	✸					✲	✲	✲	✸	✸		◯	◯	◯		
K							✲	✸		◯						✲	◯				✸
N									✲											✲	✸
S				✸		✸				◯	✲	✲	✲								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT11T304-ALH**	0.4	6.5									●											●	●
	APKT11T308-ALH	0.8	6.5									●											●	●
	**APKT11T304-APF**	0.4	6.5											●										
	APKT11T308-APF	0.8	6.5											●										
	**APKT11T304-APM**	0.4	6.5				●			●				●										
	APKT11T308-APM	0.8	6.5				●			●				●										
	APKT11T312-APM	1.2	6.5				●			●				●										
	APKT11T316-APM	1.6	6.5				●			●				●										
	APKT11T320-APM	2	6.5				●			●				●										
	**APKT11T304-LH**	0.4	6.5																				●	●
	APKT11T308-LH	0.8	6.5																				●	●
	**APKT11T304-PF**	0.4	6.5		○			●					●			●		●						
	APKT11T308-PF	0.8	6.5					○					○			●								
	APKT11T312-PF	1.2	6.5													○								
	APKT11T316-PF	1.6	6.5													○								
	**APKT11T304-PM**	0.4	6.5	●	●	○		●	●				○			●		●						
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●		●		●	●		●						
	APKT11T312-PM	1.2	6.5					○					○			●		○						
	APKT11T316-PM	1.6	6.5					●					○			●		○						
	**APKT11T304-PR**	0.4	6.5						○							○		○						
	APKT11T316-PR	1.6	6.5															○						

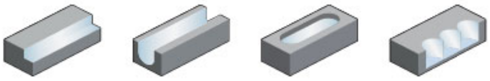
● Ex stock ○ On demand

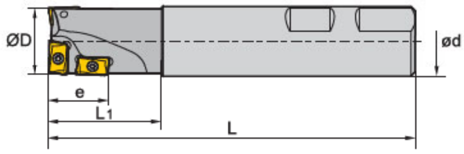
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

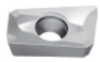
Square shoulder milling

EMP05 Kr: 90°





Weldon shank

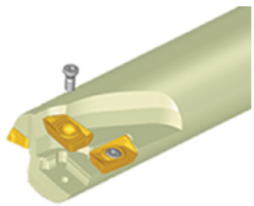
Article	✲	Stock	Dimensions [mm] ØD	e	ød	L_1	L	Teeth	kg	Inserts 
EMP05-025-XP25		○	25	20	25	40	130	3	0.5	APMT1135
EMP05-025-XP25C	✲	●	25	20	25	40	130	3	0.5	APMT1135
EMP05-032-XP32C	✲	○	32	30	32	50	140	3	0.8	APMT1604
EMP05-040-XP32C	✲	○	40	40	32	60	150	4	1	APMT1604

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**APMT1135**	**APMT1604**
	ØD	**25**	**32-40**
	Screw (insert)		I60M4*10 (3.4 Nm)
	Screw (insert)	I60M2.5*6.5T (1.0 Nm)	
	Wrench (insert)	WT08IP	WT15IP



System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

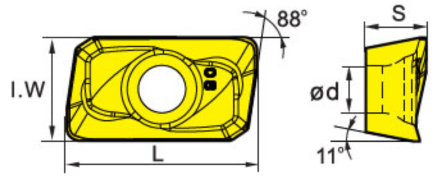
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✺ Unfavourable machining conditions

APMT	L	S	d
11 35	11.25	3.5	2.8
16 04	17.25	4.76	4.4

AN** milling insert



		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	r / I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P		✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◯	◯	◯		
M			✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◯	◯	◯		
K								✲	✺		◯						✲	◯				✺
N										✲											✲	✺
S					✺		✺				◯	✲	✲	✲								
H																						

ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
APMT1135PDR	0.8	6.2					○							●	○		○						
APMT160408PDER	0.8	9.25						○						●	○		○						

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

EMP09 Kr: 90°

Square shoulder mill with tangential inserts

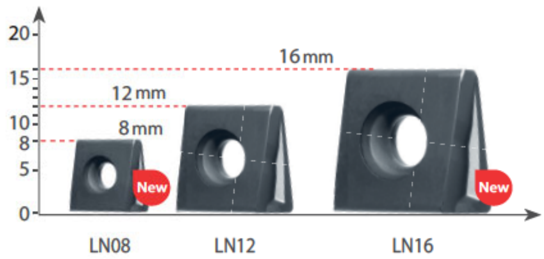
- Sharp cutting edge geometry combined with robust tangential inserts.
- First choice for large cutting depths with high feed rates.
- Very good competitiveness.

Insert grades

YBM253	YB9320	YBD252
CVD	*PVD*	*CVD*
P20 – P40	*P10 – P30*	*K15 – K35*
M10 – M30	*M20 – M30*	

Chip breaker

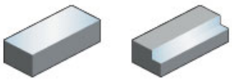
-GM

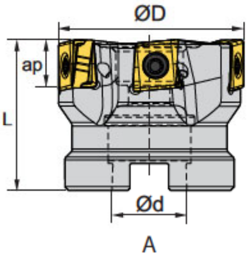


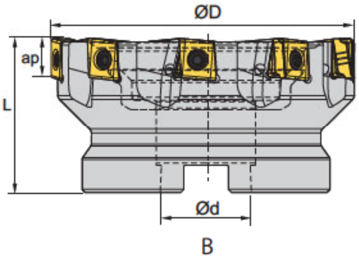
A Turning
B Milling
C Drilling
D Technical Information
E Index

Square shoulder milling

EMP09 Kr: 90°







Article	✻	Stock	Dimensions [mm] ØD	ød	L	$a_{p\,max}$	Teeth	Coupling	kg	Inserts
EMP09-040-A16-LN08-05C	✻	●	40	16	40	8	5	A		LNKT0804PNR-GM
EMP09-050-A22-LN08-06C	✻	●	50	22	40	8	6	A		LNKT0804PNR-GM
EMP09-063-A22-LN08-08C	✻	●	63	22	40	8	8	A		LNKT0804PNR-GM
EMP09-080-A27-LN08-10C	✻	○	80	27	50	8	10	A		LNKT0804PNR-GM
EMP09-040-A16-LN12-04C	✻	●	40	16	40	11.5	4	A	0.19	LNKT1206PNR-GM
EMP09-050-A22-LN12-05C	✻	●	50	22	40	11.5	5	A	0.33	LNKT1206PNR-GM
EMP09-063-A22-LN12-06C	✻	●	63	22	40	11.5	6	A	0.53	LNKT1206PNR-GM
EMP09-080-A27-LN12-07C	✻	●	80	27	50	11.5	7	A	1.18	LNKT1206PNR-GM
EMP09-100-B32-LN12-09C	✻	●	100	32	50	11.5	9	B	1.62	LNKT1206PNR-GM
EMP09-125-B40-LN12-11C	✻	●	125	40	63	11.5	11	B	3.25	LNKT1206PNR-GM
EMP09-080-A27-LN16-06C	✻	●	80	27	50	15	6	A		LNKT1607PNR-GM
EMP09-100-B32-LN16-08C	✻	●	100	32	50	15	8	B		LNKT1607PNR-GM
EMP09-125-B40-LN16-10C	✻	●	125	40	63	15	10	B		LNKT1607PNR-GM
EMP09-160-B40-LN16-12C	✻	●	160	40	63	15	12	B		LNKT1607PNR-GM

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	LNKT0804PNR-GM	LNKT1206PNR-GM	LNKT1607PNR-GM
	ØD	40-80	40-125	80-160
	Screw (clamp)	I60M3*7 (1.8 Nm)	I60M4*12 (3.4 Nm)	I60M5*17 (6.7 Nm)
	Wrench	WT10IS	WT15IS	WT20IS

System code B26 Grade selection B24 Technical info B463 Cutting data B224

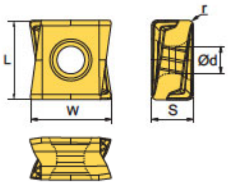
ZCC·CT

Milling inserts

◯ Ideal machining conditions
✻ Normal machining conditions
✹ Unfavourable machining conditions

LNKT	L	S
08 04	8.75	4.45
12 06	12.7	6.75
16 07	16.05	7.35

LN** milling insert



			HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
P			✻	✻	✹	✻	✻	✹		✻			✻	✻	✻	✹	✹		◯	◯	◯		
M				✻	✹	✻	✻	✹					✻	✻	✻	✹	✹		◯	◯	◯		
K									✻	✹		◯						✻	◯				✹
N											✻											✻	✹
S						✹		✹				◯	✻	✻	✻								
H																							
ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
LNKT080404PNR-GM	8.75	0.4				●							●										
LNKT120608PNR-GM	12.7	0.8				●				●			●										
LNKT160708PNR-GM	16.05	0.8				●			○				●										

● Ex stock ○ On demand

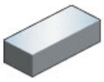
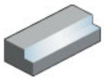
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

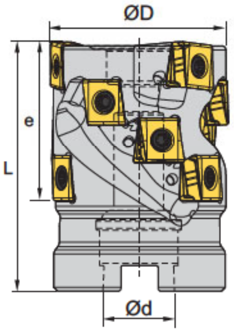
System code B26 Grade selection B24 Technical info B463 Cutting data B224

A
Turning
B
Milling
C
Drilling
D
Technical
Information
E
Index

Square shoulder milling

EMP09 Kr: 90°



Article	✲	Stock	Dimensions [mm] ØD	e	ød	L	Teeth row	Teeth	Coupling	kg	Inserts 
EMP09-040x43-A16-LN12-02C	✲	○	40	43	16	70	2	8	A	0.4	LNKT1206PNR-GM
EMP09-050x43-A22-LN12-03C	✲	●	50	43	22	70	3	12	A	0.64	
EMP09-063x53-A27-LN12-04C	✲	●	63	53	27	80	4	20	A	1.31	
EMP09-080x53-A27-LN12-05C	✲	○	80	53	27	80	5	25	A	2.33	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	LNKT1206PNR-GM
	ØD	**40-80**
	Screw (clamp)	I60M4*12 (3.4 Nm)
	Wrench	WT15IS

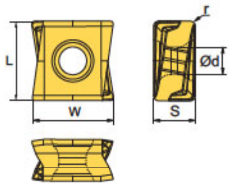
System code B26 Grade selection B24 Technical info B463 Cutting data B224

ZCC·CT

Milling inserts

- ◯ Ideal machining conditions
- ✲ Normal machining conditions
- ✺ Unfavourable machining conditions

LNKT	L	S
12 06	12.7	6.75



			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P			✲	✲	✺	✲	✲	✺		✲			✲	✲	✲	✺	✺		◯	◯	◯		
M				✲	✺	✲	✲	✺					✲	✲	✲	✺	✺		◯	◯	◯		
K									✲	✺		◯						✲	◯				✺
N											✲											✲	✺
S						✺		✺				◯	✲	✲	✲								
H																							
 **LNKT120608PNR-GM**	12.7	0.8				●				●			●										

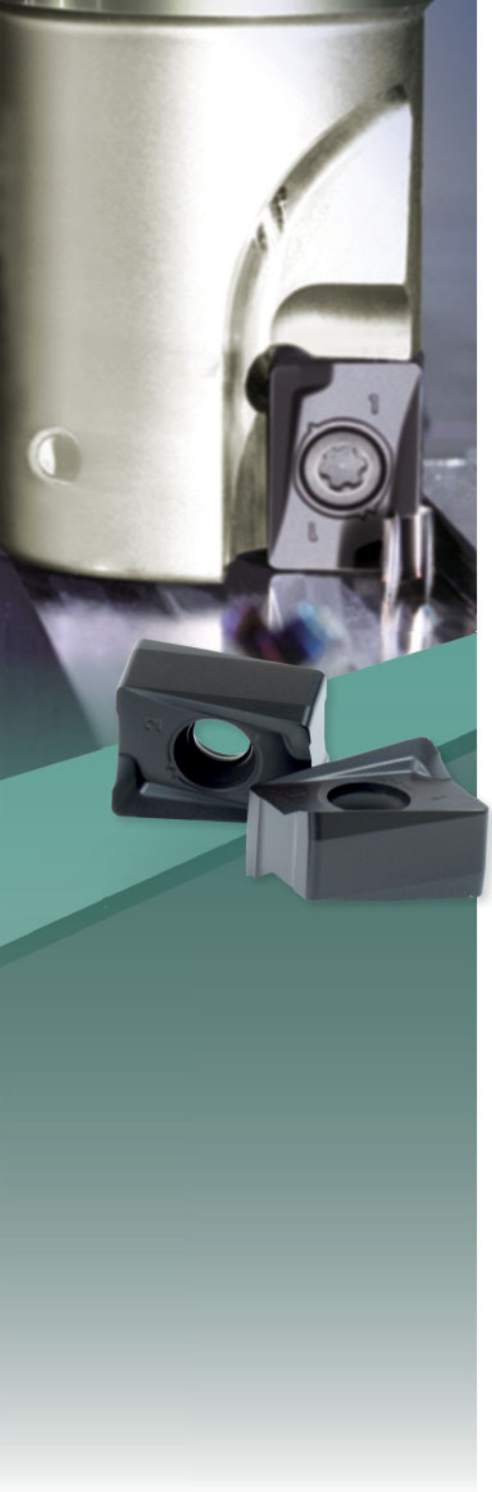
● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Notes



EMP13 Kr: 90°

New square shoulder mill generation

- Specially developed cutting edges for high-quality 90° square shoulder milling.
- Extra thick inserts for better stability.
- Positive, smooth cutting geometry for reduced cutting forces.
- Polished, high-precision geometry for aluminum alloys, steel and cast iron.

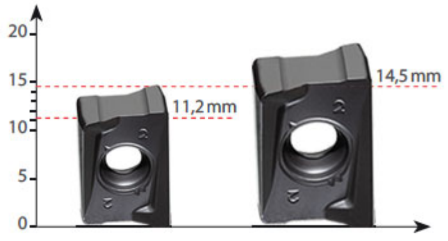
Insert grades

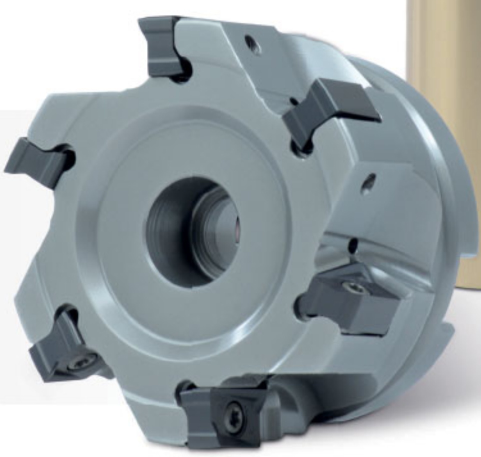
YBC302	YBM253	YB9320	YBG205
CVD	*CVD*	*PVD*	*PVD*
P15 – P35	*P20 – P40*	*P10 – P30*	*P10 – P30*
	M10 – M30	*M20 – M30*	*M20 – M30*

YBD152	YBD252	YD101
CVD	*CVD*	*–*
K05 – K25	*K15 – K35*	*N05 – N25*

Chip breakers

-GM -LH



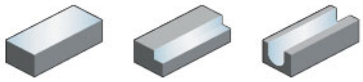


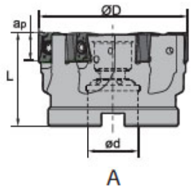
Chip breaker -LH for aluminium

A Turning
B Milling
C Drilling
D Technical Information
E Index

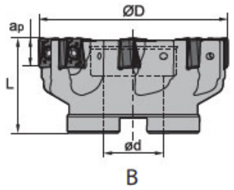
Square shoulder milling

EMP13 Kr: 90°

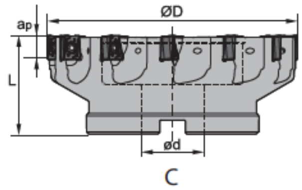




A



B



C

Article	✲	Stock	Dimensions [mm]				Teeth	Coupling	kg	Inserts
			ØD	ød	L	$a_{p\ max}$				
EMP13-040-A16-AN11-04C	✲	○	40	16	40	11.2	4	A	0.45	
EMP13-050-A22-AN11-06		●	50	22	40	11.2	6	A	0.3	
EMP13-063-A22-AN11-06	✲	○	63	22	40	11.2	6	A	0.49	
EMP13-063-A22-AN11-07		●	63	22	40	11.2	7	A	0.49	
EMP13-080-A27-AN11-07	✲	○	80	27	50	11.2	7	A	1.18	
EMP13-080-A27-AN11-09		●	80	27	50	11.2	9	A	1.18	ANGX1105
EMP13-100-B32-AN11-12		●	100	32	50	11.2	12	B	1.46	
EMP13-100-B32-AN11-12C	✲	○	100	32	50	11.2	12	B	1.46	
EMP13-125-B40-AN11-14		●	125	40	63	11.2	14	B	2.92	
EMP13-125-B40-AN11-14C	✲	○	125	40	63	11.2	14	B	2.92	
EMP13-160-C40-AN11-16		●	160	40	63	11.2	16	C	4.3	
EMP13-050-A22-AN15-04		●	50	22	40	14.5	4	A	0.26	
EMP13-063-A22-AN15-05		●	63	22	40	14.5	5	A	0.53	
EMP13-080-A27-AN15-06		●	80	27	50	14.5	6	A	1.23	
EMP13-100-B32-AN15-08		●	100	32	50	14.5	8	B	1.52	
EMP13-100-B32-AN15-08C	✲	○	100	32	50	14.5	8	B	1.52	ANGX1506
EMP13-125-B40-AN15-10		●	125	40	63	14.5	10	B	3.05	
EMP13-125-B40-AN15-10C	✲	○	125	40	63	14.5	10	B	3.05	
EMP13-160-C40-AN15-12		●	160	40	63	14.5	12	C	4.46	
EMP13-200-C60-AN15-16		○	200	60	63	14.5	16	C	6.26	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

ZCC·CT

Spare parts

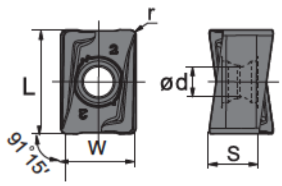
	Insert	ANGX1105	ANGX1506
	ØD	40-160	50-200
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT09IS	WT15IS

Milling inserts

Ideal machining conditions (ideal)
Normal machining conditions (normal)
Unfavourable machining conditions (unfav.)

ANGX	L	S	d
11 05	11.85	5.7	3.5
15 06	15.43	7.3	4.4

AN** milling insert



ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
			HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
P			normal	normal	unfav.	normal	normal	unfav.		normal			normal	normal	normal	unfav.	unfav.		ideal	ideal	ideal		
M				normal	unfav.	normal	normal	unfav.					normal	normal	normal	unfav.	unfav.		ideal	ideal	ideal		
K									normal	unfav.		ideal						normal	ideal				unfav.
N											normal											normal	unfav.
S						unfav.		unfav.				ideal	normal	normal	normal								
H																							
 **ANGX110504PNR-GM**	8.4	0.4				●			●				●	●									
ANGX110508PNR-GM	8.4	0.8	●			●			●	●			●	●									
ANGX150608PNR-GM	11	0.8	○			●			●	●			●	●									
ANGX150616PNR-GM	11	1.6				●			●					●									
ANGX150620PNR-GM	11	2							●	●				●									
 **ANGX110504PNR-LH**	8.4	0.4																				●	
ANGX150608PNR-LH	11	0.8																				●	

● Ex stock ○ On demand

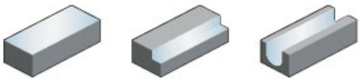
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

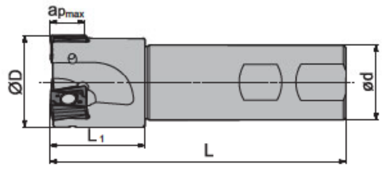
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

ZCC·CT

Square shoulder milling

EMP13 Kr: 90°





Weldon shank

Article	✲	Stock	Dimensions [mm]					Teeth	kg	Inserts 
			ØD	ød	L_1	L	$a_{p\,max}$			
EMP13-025-XP25-AN11-02		●	25	25	32	100	11.2	2	0.31	ANGX1105
EMP13-032-XP32-AN11-03		●	32	32	40	115	11.2	3	0.61	
EMP13-040-XP32-AN11-04		●	40	32	40	125	11.2	4	0.75	
EMP13-032-XP32-AN15-02		●	32	32	40	125	11.2	2	0.66	ANGX1506
EMP13-040-XP32-AN15-03		●	40	32	40	125	11.2	3	0.76	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**ANGX1105**	**ANGX1506**
	ØD	**25-40**	**25-40**
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT09IS	WT15IS

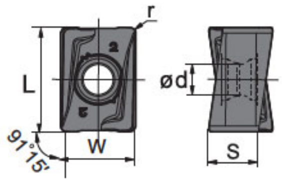
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

ANGX		L	S	d
11	05	11.85	5.7	3.5
15	06	15.43	7.3	4.4

AN** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ANGX110504PNR-GM**	8.4	0.4				●			●				●	●									
	ANGX110508PNR-GM	8.4	0.8	●			●			●	●			●	●									
	ANGX150608PNR-GM	11	0.8	○			●			●	●			●	●									
	ANGX150616PNR-GM	11	1.6				●			●					●									
	ANGX150620PNR-GM	11	2							●	●				●									
	**ANGX110504PNR-LH**	8.4	0.4																				●	
	ANGX150608PNR-LH	11	0.8																				●	

● Ex stock ○ On demand

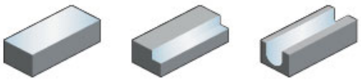
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

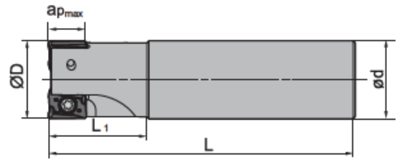
System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning B Milling C Drilling D Technical Information E Index

Square shoulder milling

EMP13 Kr: 90°





Straight shank

Article	✲	Stock	Dimensions [mm]						Teeth	kg	Inserts
			ØD	e	ød	L_1	L	$a_{p\,max}$			
EMP13-025-G25-AN11-02		●	25	11.2	25	32	100	11.2	2	0.31	ANGX1105
EMP13-032-G32-AN11-03		●	32	11.2	32	40	115	11.2	3	0.61	
EMP13-040-G32-AN11-04		●	40	11.2	32	40	125	11.2	4	0.75	
EMP13-032-G32-AN15-02		●	32	14.5	32	40	125	14.5	2	0.66	ANGX1506
EMP13-040-G32-AN15-03		●	40	14.5	32	40	125	14.5	3	0.76	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	ANGX1105	ANGX1506
	ØD	**25-40**	**25-40**
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT09IS	WT15IS

System code B26 Grade selection B24 Technical info B463 Cutting data B224

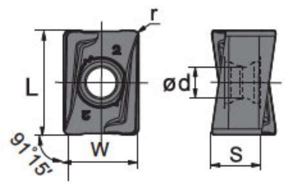
ZCC·CT

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

ANGX	L	S	d
11 05	11.85	5.7	3.5
15 06	15.43	7.3	4.4

AN** milling insert



ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P			Normal	Normal	Unfav.	Normal	Normal	Unfav.		Normal			Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
M				Normal	Unfav.	Normal	Normal	Unfav.					Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
K									Normal	Unfav.		Ideal						Normal	Ideal				Unfav.
N											Normal											Normal	Unfav.
S						Unfav.		Unfav.				Ideal	Normal	Normal	Normal								
H																							
ANGX110504PNR-GM	8.4	0.4				●			●				●	●									
ANGX110508PNR-GM	8.4	0.8	●			●			●	●			●	●									
ANGX150608PNR-GM	11	0.8	○			●			●	●			●	●									
ANGX150616PNR-GM	11	1.6				●			●					●									
ANGX150620PNR-GM	11	2							●	●				●									
ANGX110504PNR-LH	8.4	0.4																				●	
ANGX150608PNR-LH	11	0.8																				●	

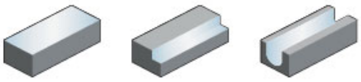
● Ex stock ○ On demand

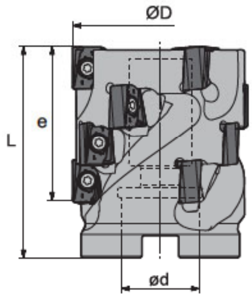
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Square shoulder milling

EMP13 Kr: 90°





Article	✱	Stock	Dimensions [mm] ØD	e	ød	L	Teeth	No. of inserts	kg	Inserts 
EMP13-050x43-A22-AN11-03		●	50	43	22	60	3	12	0.52	ANGX1105
EMP13-063x64-A27-AN11-04		○	63	64	27	80	4	24	1.15	
EMP13-063x53-A27-AN15-03		○	63	53	27	75	3	12	1.14	ANGX1506
EMP13-080x53-A32-AN15-04		●	80	53	32	75	4	16	1.82	

● Ex stock ○ On demand

✱ With internal cooling

Spare parts

	Insert	ANGX1105	ANGX1506
	ØD	**50-63**	**63-80**
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT09IS	WT15IS

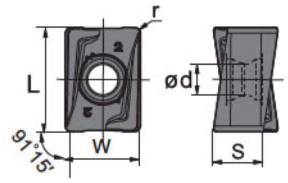
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions

ANGX	L	S	d
11 05	11.85	5.7	3.5
15 06	15.43	7.3	4.4

AN** milling insert



			HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P			⊕	⊕	✲	⊕	⊕	✲		⊕			⊕	⊕	⊕	✲	✲		○	○	○		
M				⊕	✲	⊕	⊕	✲					⊕	⊕	⊕	✲	✲		○	○	○		
K									⊕	✲		○						⊕	○				✲
N											⊕											⊕	✲
S						✲		✲				○	⊕	⊕	⊕								
H																							
 **ANGX110504PNR-GM**	8.4	0.4				●			●				●	●									
ANGX110508PNR-GM	8.4	0.8	●			●			●	●			●	●									
ANGX150608PNR-GM	11	0.8	○			●			●	●			●	●									
ANGX150616PNR-GM	11	1.6				●			●					●									
ANGX150620PNR-GM	11	2							●	●				●									
 **ANGX110504PNR-LH**	8.4	0.4																				●	
ANGX150608PNR-LH	11	0.8																				●	

● Ex stock ○ On demand

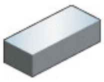
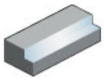
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

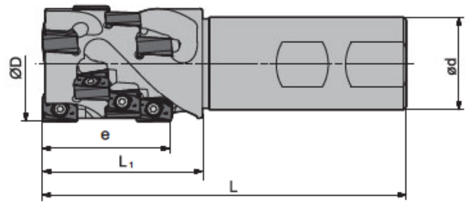
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Square shoulder milling

EMP13 Kr: 90°

Weldon shank

Article	✻	Stock	Dimensions [mm]					Teeth	No. of inserts	kg	Inserts
			ØD	e	ød	L_1	L				
EMP13-032x43-XP32-AN11-02		○	32	43	32	48	115	2	8	0.61	ANGX1105
EMP13-040x43-XP32-AN11-03		○	40	43	32	55	125	3	12	0.79	ANGX1105
EMP13-040x40-XP32-AN15-02		○	40	40	32	55	115	2	6	0.79	ANGX1506
EMP13-050x53-XP40-AN15-02		○	50	53	40	70	145	2	8	1.53	ANGX1506

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

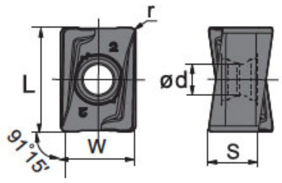
	Insert	ANGX1105	ANGX1506
	ØD	**32-40**	**40-50**
	Screw (insert)	I60M3*9 (1.8 Nm)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT09IS	WT15IS

Milling inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✽ Unfavourable machining conditions

ANGX	L	S	d
11 05	11.85	5.7	3.5
15 06	15.43	7.3	4.4

AN** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊛	⊛	✽	⊛	⊛	✽		⊛			⊛	⊛	⊛	✽	✽		◯	◯	◯		
M		⊛	✽	⊛	⊛	✽					⊛	⊛	⊛	✽	✽		◯	◯	◯		
K							⊛	✽		◯						⊛	◯				✽
N									⊛											⊛	✽
S				✽		✽				◯	⊛	⊛	⊛								
H																					

	ISO	W	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ANGX110504PNR-GM**	8.4	0.4				●			●				●	●									
	ANGX110508PNR-GM	8.4	0.8	●			●			●	●			●	●									
	ANGX150608PNR-GM	11	0.8	○			●			●	●			●	●									
	ANGX150616PNR-GM	11	1.6				●			●					●									
	ANGX150620PNR-GM	11	2							●	●				●									
	**ANGX110504PNR-LH**	8.4	0.4																				●	
	ANGX150608PNR-LH	11	0.8																				●	

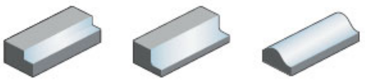
● Ex stock ○ On demand

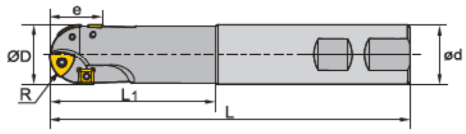
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Profile milling

BMR01 



Weldon shank

Article	✻	Stock	Dimensions [mm]						Teeth		kg	Inserts
			R	ØD	e	ød	L_1	L	ZDET	SPMT		
BMR01-020-XP20-S		○	10	20	20	20	50	125	2	2	0.3	ZDET08T2 & SPMT0603
BMR01-020-XP20-M		○	10	20	20	20	75	150	2	2	0.3	
BMR01-020-XP20-L		○	10	20	20	20	100	200	2	2	0.4	
BMR01-025-XP25-S		○	12.5	25	23	25	70	150	2	2	0.5	ZDET1103 & SPMT0603
BMR01-025-XP25-M		○	12.5	25	23	25	95	175	2	2	0.6	
BMR01-025-XP25-L		○	12.5	25	23	25	100	200	2	2	0.7	
BMR01-032-XP32-S		○	16	32	31	32	85	175	2	2	0.9	ZDET13T2 & SDMT0903
BMR01-032-XP32-M		○	16	32	31	32	100	200	2	2	1.1	
BMR01-032-XP32-L		○	16	32	31	32	150	250	2	2	1.4	
BMR01-040-XP40-S		○	20	40	41	40	85	175	3	2	1.4	ZPNT2204 & SPMT1204
BMR01-040-XP40-M		○	20	40	41	40	100	200	3	2	1.7	
BMR01-040-XP40-L		○	20	40	41	40	150	250	3	2	2.1	
BMR01-050-XP40-S		○	25	50	45	40	100	200	3	2	1.8	
BMR01-050-XP40-M		○	25	50	45	40	100	300	3	2	2.8	
BMR01-063-XP40-S		○	31.5	63	52	40	100	200	4	2	3	
BMR01-063-XP40-M		○	31.5	63	52	40	100	300	4	2	3.5	

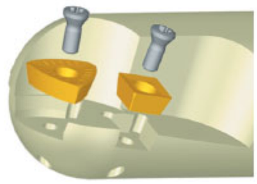
● Ex stock ○ On demand

✻ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

	Insert	ZDET08T2 & SPMT0603	ZDET1103 & SPMT0603	ZDET13T2 & SDMT0903	ZPNT2204 & SPMT1204
	ØD	**20**	**25**	**32**	**40-63**
	Screw (insert)	I43M2.5*5.7 (1.0 Nm)	I43M2.5*5.7 (1.0 Nm)	I43M4*8 (3.4 Nm)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT07IP	WT07IP		
	Wrench (insert)			WT15IS	WT20IS

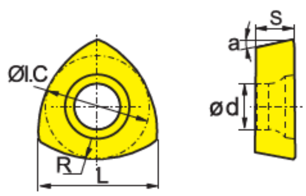


ZDET	L	I.C	S	d
08 T2	8.4	6.75	2.78	2.8
11 03	10.6	8.5	3.18	2.8
13 T3	13.2	10.5	3.97	4.4
22 04	16.1	12.7	4.76	5.56

◯ Ideal machining conditions
❂ Normal machining conditions
✺ Unfavourable machining conditions

Milling inserts

ZD** milling insert



		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	P	❂	❂	✺	❂	❂	✺		❂			❂	❂	❂	✺	✺		◯	◯	◯		
	M		❂	✺	❂	❂	✺					❂	❂	❂	✺	✺		◯	◯	◯		
	K							❂	✺		◯						❂	◯				✺
	N									❂											❂	✺
	S				✺		✺				◯	❂	❂	❂								
	H																					
 **ZDET13T3CYR16-PM**	16					○								○								
 **ZDET08T2CYR10**	10					○																
ZDET1103CYR12.5	12.5					○																
ZDET13T3CYR16	16					○																
 **ZPNT2204CY(R20)**	20					○																
ZPNT2204CY(R25)	25					●																
ZPNT2204CY(R31)	31.5					○																

● Ex stock ○ On demand

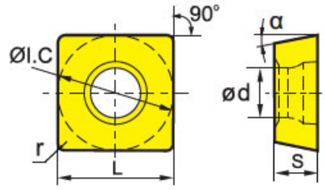
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✹ Unfavourable machining conditions

SPMT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
12 04	12.7	12.7	4.76	5.5



SP** milling insert		HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P		✲	✲	✹	✲	✲	✹		✲			✲	✲	✲	✹	✹		◯	◯	◯		
M			✲	✹	✲	✲	✹					✲	✲	✲	✹	✹		◯	◯	◯		
K								✲	✹		◯						✲	◯				✹
N										✲											✲	✹
S					✹		✹				◯	✲	✲	✲								
H																						
SPMT060304-KT			○																			
SPMT060304	0.4					●										○						
SPMT120408	0.8	○	●	○		●	○									○						

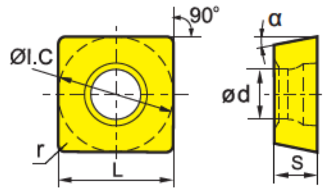

● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
✲ Normal machining conditions
✹ Unfavourable machining conditions

SDMT	L	I.C	S	d
09 03	9.525	9.525	3.18	4.4



SD** milling insert		HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P		✲	✲	✹	✲	✲	✹		✲			✲	✲	✲	✹	✹		◯	◯	◯		
M			✲	✹	✲	✲	✹					✲	✲	✲	✹	✹		◯	◯	◯		
K								✲	✹		◯						✲	◯				✹
N										✲											✲	✹
S					✹		✹				◯	✲	✲	✲								
H																						
SDMT090308	0.8					●	○															

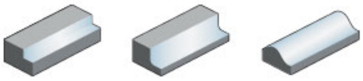
● Ex stock ○ On demand

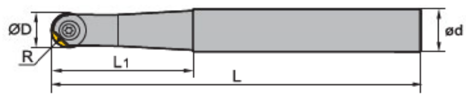
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Profile milling

BMR02





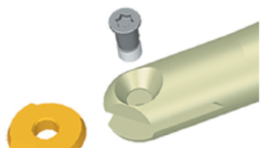
Article	✲	Stock	Dimensions [mm]					kg	Inserts
			R	ØD	ød	L_1	L		
BMR02-012-G16-S		●	6	12	16	40	110	0.1	ROHX1203
BMR02-012-G16-M		●	6	12	16	50	130	0.2	
BMR02-012-G16-L		●	6	12	16	50	160	0.2	
BMR02-016-G20-S		●	8	16	20	45	140	0.3	ROHX1604
BMR02-016-G20-M		●	8	16	20	65	170	0.3	
BMR02-016-G20-L		●	8	16	20	65	200	0.4	
BMR02-020-G25-S		●	10	20	25	60	160	0.5	ROHX2005
BMR02-020-G25-M		●	10	20	25	80	200	0.6	
BMR02-020-G25-L		●	10	20	25	80	240	0.8	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**ROHX1203**	**ROHX1604**	**ROHX2005**
	ØD	**12**	**16**	**20**
	Screw (insert)	I70M4*10TT (3.4 Nm)	I70M5*12TT (6.7 Nm)	I70M5*16TT (6.7 Nm)
	Wrench (insert)	WT15IS	WT20IS	WT20IS



System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

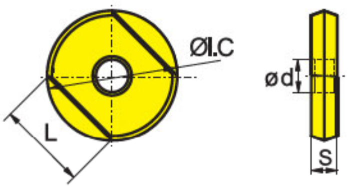
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

ROHX		L	I.C	S	d
12	03	8.5	12	3	4
16	04	11.3	16	4	5
20	05	14.1	20	5	5

RO** positive insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					
ROHX1203										○			●				●				
ROHX1604													●				●				
ROHX2005													●				●				

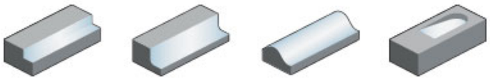
● Ex stock ○ On demand

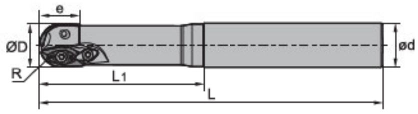
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

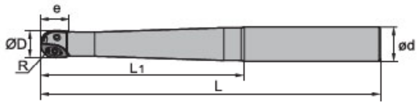
Profile milling

BMR03





A



B

Straight shank

Article	✲	Stock	Dimensions [mm]						Teeth	Coupling	kg	Inserts 
			R	ØD	e	ød	L_1	L				
BMR03-016-G20-S		●	8	16	16	20	70	150	2	B	0.3	XPHT16
BMR03-016-G20-M		●	8	16	16	20	80	180	2	B	0.4	
BMR03-020-G25-S		●	10	20	20	25	80	180	2	B	0.5	XPHT20
BMR03-020-G25-M		●	10	20	20	25	100	200	2	B	0.6	
BMR03-020-G25-L		●	10	20	20	25	150	250	2	B	0.7	
BMR03-020-G25-XL		○	10	20	20	25	110	300	2	B	1	
BMR03-025-G25-S		●	12.5	25	25	25	80	180	2	B	0.6	XPHT25
BMR03-025-G25-M		●	12.5	25	25	25	100	200	2	B	0.7	
BMR03-025-G25-L		○	12.5	25	25	25	110	250	2	B	0.8	
BMR03-025-G25-XL		○	12.5	25	25	25	120	300	2	B	1	
BMR03-030-G32-S		○	15	30	30	32	120	200	2	A	1	XPHT30
BMR03-030-G32-M		●	15	30	30	32	150	250	2	A	1.3	
BMR03-030-G32-L		○	15	30	30	32	200	300	2	A	1.6	
BMR03-032-G32-S		●	16	32	32	32	120	200	2	A	1.1	XPHT32
BMR03-032-G32-M		●	16	32	32	32	150	250	2	A	1.4	
BMR03-032-G32-L		●	16	32	32	32	200	300	2	A	1.6	
BMR03-032-G32-XL		○	16	32	32	32	200	350	2	A	2	
BMR03-040-G40-S		○	20	40	40	40	120	200	2	A	1.6	XPHT40
BMR03-040-G40-M		○	20	40	40	40	150	250	2	A	2	
BMR03-040-G40-L		●	20	40	40	40	200	300	2	A	2.5	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

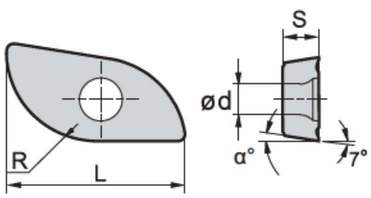
	Insert	XPHT16	XPHT20	XPHT25	XPHT30	XPHT32	XPHT40
	ØD	16	20	25	30	32	40
	Clamp						CBH5R1
	Clamp				WD-208	WD-208	
	Screw (clamp)				I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)
	Screw (insert)	I60M2.5*6.5 (1.0 Nm)		I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)
	Screw (insert)		I60M3.5*08TT (2.7 Nm)				
	Wrench (clamp)				WT20IT	WT20IT	WT25IT
	Wrench (insert)		WT10IP				
	Wrench (insert)				WT20IT	WT20IT	WT25IT
	Wrench (insert)	WT07P					
	Wrench (insert)			WT15S			

XPHT	L	S	d
16	16	3.18	3.1
20	20	3.97	4
25	25	4.76	4.7
30	30	6.35	5.8
32	32	6.35	5.8
40	40	7.94	6.8

Milling inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✻ Unfavourable machining conditions

XP** milling insert



ISO	R	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
			HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
		P	⊕	⊕	✻	⊕	⊕	✻		⊕			⊕	⊕	⊕	✻	✻		○	○	○		
		M		⊕	✻	⊕	⊕	✻					⊕	⊕	⊕	✻	✻		○	○	○		
		K							⊕	✻		○						⊕	○				✻
		N									⊕											⊕	✻
		S				✻		✻				○	⊕	⊕	⊕								
		H																					
XPHT16R0803-GM	8	9															●						
XPHT20R10T3-GM	10	9															●						
XPHT25R1204-GM	12.5	9															●						
XPHT30R1506-GM	15	11															●						
XPHT32R1606-GM	16	9															●						
XPHT40R2007-GM	20	9															●						

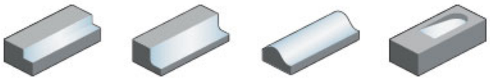
● Ex stock ○ On demand

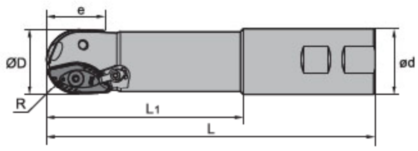
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Profile milling

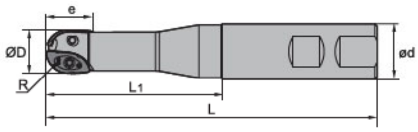
BMR03





A

Weldon shank



B

Article	✲	Stock	Dimensions [mm]						Teeth	Coupling	kg	Inserts
			R	ØD	e	ød	L_1	L				
BMR03-016-XP20-M		●	8	16	16	20	60	111	2	B	0.2	XPHT16
BMR03-020-XP25-M		●	10	20	20	25	70	127	2	B	0.3	XPHT20
BMR03-020-XP25-L		●	10	20	20	25	80	150	2	B	0.4	
BMR03-025-XP25-M		●	12.5	25	25	25	80	137	2	B	0.4	XPHT25
BMR03-025-XP25-L		●	12.5	25	25	25	100	200	2	B	0.6	
BMR03-030-XP32-M		●	15	30	30	32	100	161	2	A	0.8	XPHT30
BMR03-030-XP32-L		●	15	30	30	32	150	250	2	A	1.3	
BMR03-032-XP32-M		●	16	32	32	32	100	161	2	A	0.8	XPHT32
BMR03-032-XP32-L		○	16	32	32	32	120	250	2	A	1.3	
BMR03-040-XP40-M		○	20	40	40	40	100	175	2	A	1.3	XPHT40
BMR03-040-XP40-L		●	20	40	40	40	120	250	2	A	2	
BMR03-050-XP50-M		○	25	50	50	50	100	200	2	A	2.5	XPHT50
BMR03-050-XP50-L		○	25	50	50	50	150	250	2	A	3.1	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Spare parts

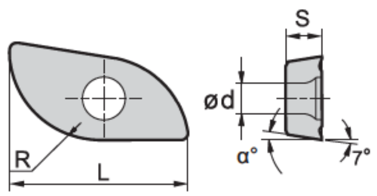
	Insert	XPHT16	XPHT20	XPHT25	XPHT30	XPHT32	XPHT40	XPHT50
	ØD	16	20	25	30	32	40	50
	Clamp						CBH5R1	CBH5R1
	Clamp				WD-208	WD-208		
	Screw (clamp)				I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)	I43M6*16 (9.1 Nm)
	Screw (insert)	I60M2.5*6.5 (1.0 Nm)		I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)	I43M8*21 (16.2 Nm)
	Screw (insert)		I60M3.5*08TT (2.7 Nm)					
	Wrench (clamp)				WT20IT	WT20IT	WT25IT	WT25IT
	Wrench (insert)		WT10IP					
	Wrench (insert)				WT20IT	WT20IT	WT25IT	WT30IT
	Wrench (insert)	WT07P						
	Wrench (insert)			WT15S				

XPHT	L	S	d
16	16	3.18	3.1
20	20	3.97	4
25	25	4.76	4.7
30	30	6.35	5.8
32	32	6.35	5.8
40	40	7.94	6.8
50	50	7.94	9.2

Milling inserts

- ◯ Ideal machining conditions
- ⊕ Normal machining conditions
- ✻ Unfavourable machining conditions

XP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊕	⊕	✻	⊕	⊕	✻		⊕			⊕	⊕	⊕	✻	✻		◯	◯	◯		
M		⊕	✻	⊕	⊕	✻					⊕	⊕	⊕	✻	✻		◯	◯	◯		
K							⊕	✻		◯						⊕	◯				✻
N									⊕											⊕	✻
S				✻		✻				◯	⊕	⊕	⊕								
H																					

ISO	R	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
XPHT16R0803-GM	8	9															●						
XPHT20R10T3-GM	10	9															●						
XPHT25R1204-GM	12.5	9															●						
XPHT30R1506-GM	15	11															●						
XPHT32R1606-GM	16	9															●						
XPHT40R2007-GM	20	9															●						
XPHT50R2507-GM	25	9															●						

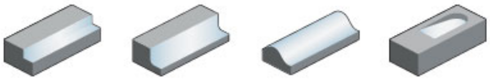
● Ex stock ○ On demand

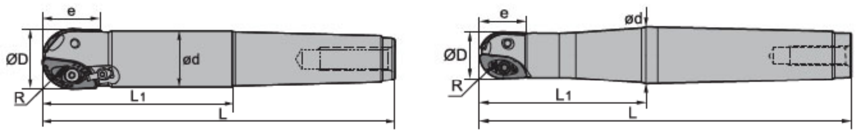
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Profile milling

BMR03





A Morse taper shank B

Article	✲	Stock	Dimensions [mm] R	ØD	e	ød	L_1	L	Teeth	Coupling	kg	Inserts 
BMR03-020-MT3-M		○	10	20	20	18.7	70	156	2	B	0.4	XPHT20
BMR03-020-MT3-L		○	10	20	20	18.7	100	186	2	B	0.4	
BMR03-025-MT3-M		○	12.5	25	25	23.5	70	156	2	B	0.4	XPHT25
BMR03-025-MT3-L		○	12.5	25	25	23.5	100	186	2	B	0.4	
BMR03-030-MT4-M		○	15	30	30	28.2	70	189	2	A	0.8	XPHT30
BMR03-030-MT4-L		○	15	30	30	28.2	120	229	2	A	1	
BMR03-032-MT4-M		○	16	32	32	29.2	70	179	2	A	0.9	XPHT32
BMR03-032-MT4-L		●	16	32	32	29.2	100	209	2	A	0.9	
BMR03-040-MT5-L		○	20	40	40	36.9	90	226	2	A	1.8	XPHT40
BMR03-050-MT5-M		●	25	50	50	46.8	100	236	2	A	2.2	XPHT50
BMR03-050-MT5-L		○	25	50	50	46.8	150	286	2	A	2.9	

● Ex stock ○ On demand

✲ With internal cooling

System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

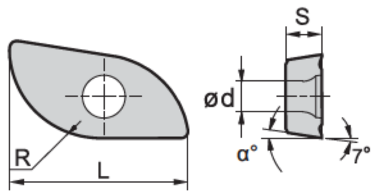
Spare parts						
Insert	XPHT20	XPHT25	XPHT30	XPHT32	XPHT40	XPHT50
ØD	20	25	30	32	40	50
Clamp					CBH5R1	CBH5R1
Clamp			WD-208	WD-208		
Screw (clamp)			I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)	I43M6*16 (9.1 Nm)
Screw (insert)		I60M4*10 (3.4 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I43M6*16 (9.1 Nm)	I43M8*21 (16.2 Nm)
Screw (insert)	I60M3.5*08TT (2.7 Nm)					
Wrench (clamp)			WT20IT	WT20IT	WT25IT	WT25IT
Wrench (insert)	WT10IP					
Wrench (insert)			WT20IT	WT20IT	WT25IT	WT30IT
Wrench (insert)		WT15S				

XPHT	L	S	d
20	20	3.97	4
25	25	4.76	4.7
30	30	6.35	5.8
32	32	6.35	5.8
40	40	7.94	6.8
50	50	7.94	9.2

Milling inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✻ Unfavourable machining conditions

XP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊕	⊕	✻	⊕	⊕	✻		⊕			⊕	⊕	⊕	✻	✻		○	○	○		
M		⊕	✻	⊕	⊕	✻					⊕	⊕	⊕	✻	✻		○	○	○		
K							⊕	✻		○						⊕	○				✻
N									⊕											⊕	✻
S				✻		✻				○	⊕	⊕	⊕								
H																					

ISO	R	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
XPHT20R10T3-GM	10	9															●						
XPHT25R1204-GM	12.5	9															●						
XPHT30R1506-GM	15	11															●						
XPHT32R1606-GM	16	9															●						
XPHT40R2007-GM	20	9															●						
XPHT50R2507-GM	25	9															●						

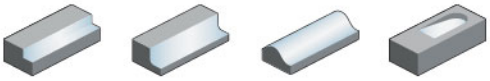
● Ex stock ○ On demand

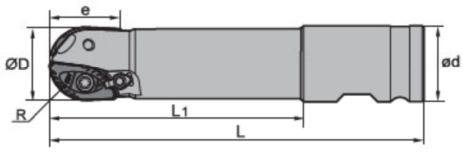
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

Profile milling

BMR03





Compound shank

Article	✲	Stock	Dimensions [mm] R	ØD	e	ød	L_1	L	Teeth	kg	Inserts
BMR03-040-XPX-M		○	20	40	40	50.8	170	250	2	1.3	XPHT40
BMR03-040-XPX-L		○	20	40	40	50.8	220	300	2	3.1	
BMR03-040-XPX-XL		○	20	40	40	50.8	270	350	2	3.5	
BMR03-050-XPX-M		○	25	50	50	50.8	170	250	2	3.1	XPHT50
BMR03-050-XPX-L		○	25	50	50	50.8	200	300	2	3.8	
BMR03-050-XPX-XL		○	25	50	50	50.8	270	350	2	4.4	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**XPHT40**	**XPHT50**
	ØD	**40**	**50**
	Clamp	CBH5R1	CBH5R1
	Screw (clamp)	I43M6*16 (9.1 Nm)	I43M6*16 (9.1 Nm)
	Screw (insert)	I43M6*16 (9.1 Nm)	I43M8*21 (16.2 Nm)
	Wrench (clamp)	WT25IT	WT25IT
	Wrench (insert)	WT25IT	WT30IT

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

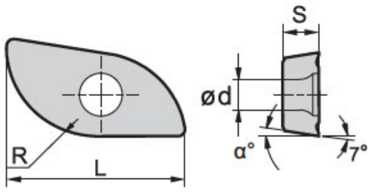
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

○ Ideal machining conditions
◎ Normal machining conditions
✱ Unfavourable machining conditions

XPHT	L	S	d
40	40	7.94	6.8
50	50	7.94	9.2

XP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	◎	◎	✱	◎	◎	✱		◎			◎	◎	◎	✱	✱		○	○	○		
M		◎	✱	◎	◎	✱					◎	◎	◎	✱	✱		○	○	○		
K							◎	✱		○						◎	○				✱
N									◎											◎	✱
S				✱		✱				○	◎	◎	◎								
H																					

ISO	R	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
XPHT40R2007-GM	20	9															●						
XPHT50R2507-GM	25	9															●						

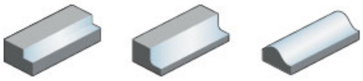
● Ex stock ○ On demand

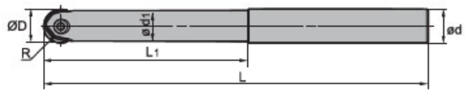
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

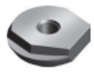
Profile milling

BMR04





Straight shank

Article	✲	Stock	Dimensions [mm]						kg	Inserts
			R	ØD	ød	Ød1	L_1	L		
BMR04-012-G12-M		●	6	12	12	11	35	125	0.1	ZOHX12
BMR04-012-G12-L		●	6	12	12	11	45	150	0.1	
BMR04-016-G16-M		●	8	16	16	14	40	150	0.2	ZOHX16
BMR04-016-G16-L		●	8	16	16	14	55	180	0.3	
BMR04-020-G20-M		●	10	20	20	18	65	180	0.4	ZOHX20
BMR04-020-G20-L		●	10	20	20	18	100	250	0.6	
BMR04-025-G25-M		●	12.5	25	25	23	70	200	0.7	ZOHX25
BMR04-025-G25-L		●	12.5	25	25	23	100	250	0.9	
BMR04-030-G32-M		●	15	30	32	27	80	250	1.2	ZOHX30
BMR04-030-G32-L		●	15	30	32	27	110	300	1.5	
BMR04-032-G32-M		●	16	32	32	29	80	250	1.4	ZOHX32
BMR04-032-G32-L		●	16	32	32	29	110	300	1.7	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**ZOHX12**	**ZOHX16**	**ZOHX20**	**ZOHX25**	**ZOHX30**	**ZOHX32**
	ØD	**12**	**16**	**20**	**25**	**30**	**32**
	Screw (insert)	I70M4*10TT (3.4 Nm)	I70M5*12TT (6.7 Nm)	I70M5*16TT (6.7 Nm)	I70M6*20TT (9.1 Nm)	I70M8*25TT (16.2 Nm)	I70M8*25TT (16.2 Nm)
	Wrench (insert)	WT15IP	WT20IP	WT20IP	WT20IP		
	Wrench (insert)					WT30IT	WT30IT

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

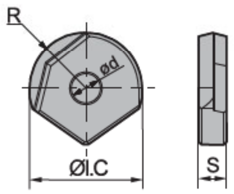
A Turning B Milling C Drilling D Technical Information E Index

ZOHX	I.C	S	d
12	12	1.5	4
16	16	4	5
20	20	5	5
25	25	6	6
30	30	7	8
32	32	7	8

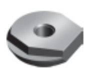
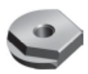
Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

Milling inserts

ZO** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ZOHX1203-GF**	6																	●				
	ZOHX1604-GF	8																	●				
	ZOHX2005-GF	10																	●				
	ZOHX2506-GF	12.5																	○				
	ZOHX3007-GF	15																	●				
	ZOHX3207-GF	16																	●				
	**ZOHX1203-GM**	6																	●				
	ZOHX1604-GM	8																	●				
	ZOHX2005-GM	10																	●				
	ZOHX2506-GM	12.5																	○				
	ZOHX3007-GM	15																	●				
	ZOHX3207-GM	16																	●				

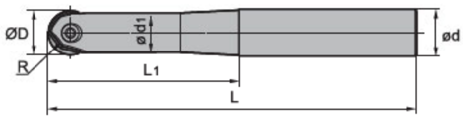
● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

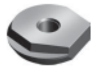
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Profile milling

BMR04



Straight shank

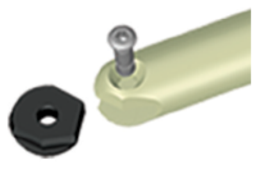
Article	✲	Stock	Dimensions [mm] R	ØD	ød	Ød1	L_1	L	kg	Inserts 
BMR04-012-G16-M		●	6	12	16	11	50	125	0.2	ZOHX12
BMR04-012-G16-L		●	6	12	16	11	70	150	0.2	
BMR04-016-G20-M		●	8	16	20	14	60	150	0.3	ZOHX16
BMR04-016-G20-L		●	8	16	20	14	80	180	0.3	
BMR04-020-G25-M		●	10	20	25	18	75	180	0.6	ZOHX20
BMR04-020-G25-L		●	10	20	25	18	95	200	0.6	
BMR04-025-G32-M		●	12.5	25	32	23	90	200	1	ZOHX25
BMR04-025-G32-L		●	12.5	25	32	23	110	250	1.3	
BMR04-030-G40-M		●	15	30	40	27	110	250	2	ZOHX30
BMR04-030-G40-L		●	15	30	40	27	125	300	2.4	
BMR04-032-G40-M		●	16	32	40	29	110	250	2	ZOHX32
BMR04-032-G40-L		●	16	32	40	29	125	300	2.4	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**ZOHX12**	**ZOHX16**	**ZOHX20**	**ZOHX25**	**ZOHX30**	**ZOHX32**
	ØD	**12**	**16**	**20**	**25**	**30**	**32**
	Screw (insert)	I70M4*10TT (3.4 Nm)	I70M5*12TT (6.7 Nm)	I70M5*16TT (6.7 Nm)	I70M6*20TT (9.1 Nm)	I70M8*25TT (16.2 Nm)	I70M8*25TT (16.2 Nm)
	Wrench (insert)	WT15IP	WT20IP	WT20IP	WT20IP		
	Wrench (insert)					WT30IT	WT30IT



System code B26 Grade selection B24 Technical info B463 Cutting data B224

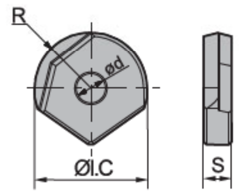
A Turning
B Milling
C Drilling
D Technical Information
E Index

ZOHX	I.C	S	d
12	12	1.5	4
16	16	4	5
20	20	5	5
25	25	6	6
30	30	7	8
32	32	7	8

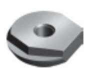
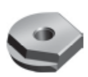
Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

Milling inserts

ZO** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

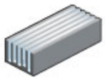
	ISO	R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**ZOHX1203-GF**	6																	●				
	ZOHX1604-GF	8																	●				
	ZOHX2005-GF	10																	●				
	ZOHX2506-GF	12.5																	○				
	ZOHX3007-GF	15																	●				
	ZOHX3207-GF	16																	●				
	**ZOHX1203-GM**	6																	●				
	ZOHX1604-GM	8																	●				
	ZOHX2005-GM	10																	●				
	ZOHX2506-GM	12.5																	○				
	ZOHX3007-GM	15																	●				
	ZOHX3207-GM	16																	●				

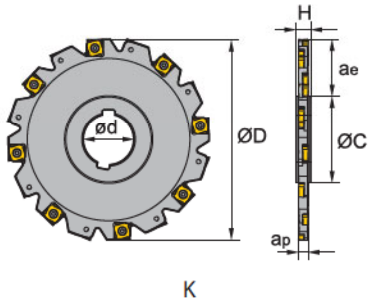
● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Slot milling

SMP01 Kr: 90°  



Article	✲	Stock	Dimensions [mm] ØD	ød	Øc	H	a_p	$a_{e\,max}$	Coupling	kg	Inserts 
SMP01-100x4-K27-SN12-10		○	100	27	45	12	4	25	K	0.2	XSEQ1202
SMP01-125x4-K40-SN12-12		○	125	40	56	12	4	32	K	0.3	
SMP01-160x4-K40-SN12-16		●	160	40	67	12	4	44	K	0.5	
SMP01-100x5-K27-SN12-10		○	100	27	45	12	5	25	K	0.2	XSEQ1203
SMP01-125x5-K40-SN12-12		○	125	40	56	12	5	32	K	0.3	
SMP01-160x5-K40-SN12-16		○	160	40	67	12	5	44	K	0.6	
SMP01-100x7-K27-SN12-10		○	100	27	45	12	7	25	K	0.3	XSEQ1204
SMP01-125x7-K40-SN12-12		○	125	40	56	12	7	32	K	0.4	
SMP01-160x7-K40-SN12-16		○	160	40	67	12	7	44	K	0.8	
SMP01-200x7-K50-SN12-18		○	200	50	71	12	7	62	K	1.2	
SMP01-250x7-K50-SN12-24		○	250	50	71	12	7	87	K	1.9	
SMP01-100x6-K27-SN12-10		○	100	27	45	12	6	25	K	0.3	XSEQ12T3
SMP01-125x6-K40-SN12-12		○	125	40	56	12	6	32	K	0.4	
SMP01-160x6-K40-SN12-16		○	160	40	67	12	6	44	K	0.7	
SMP01-200x6-K50-SN12-18		○	200	50	71	12	6	62	K	1.1	
SMP01-250x6-K50-SN12-24		○	250	50	71	12	6	87	K	1.7	
SMP01-100x8-K27-SN12-10		○	100	27	45	12	8	25	K	0.3	XSEQ12T4
SMP01-125x8-K40-SN12-12		○	125	40	56	12	8	32	K	0.5	
SMP01-160x8-K40-SN12-16		○	160	40	67	12	8	44	K	0.9	
SMP01-200x8-K50-SN12-18		○	200	50	71	12	8	62	K	1.4	
SMP01-250x8-K50-SN12-24		○	250	50	71	12	8	87	K	2.2	

● Ex stock ○ On demand

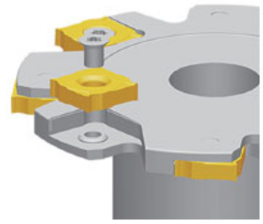
✲ With internal cooling

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Spare parts

	Insert	XSEQ1202	XSEQ1203	XSEQ1204	XSEQ12T3	XSEQ12T4
	ØD	63-160	63-160	63-250	63-250	63-250
	Screw (insert)	I91M4*3.2X (3.4 Nm)	I91M4*3.2X (3.4 Nm)	I91M4*6.1X (3.4 Nm)	I91M4*5.1X (3.4 Nm)	I91M4*7.1X (3.4 Nm)
	Wrench (insert)	WT08IP	WT08IP	WT08IP	WT08IP	WT08IP

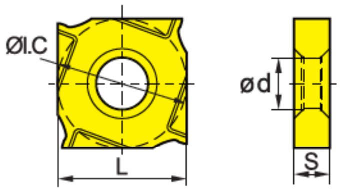


XSEQ		L	I.C	S	d
12	02	12.7	12.7	2.3	5
12	03	12.7	12.7	3	5
12	T3	12.7	12.7	3.5	5
12	04	12.7	12.7	4	5
12	T4	12.7	12.7	4.5	5

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

Milling inserts

XS** milling insert



	HC1 (CVD)								HC1 (PVD)									HT	HC2	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfav.	Normal	Normal	Unfav.		Normal			Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
M		Normal	Unfav.	Normal	Normal	Unfav.					Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
K							Normal	Unfav.		Ideal						Normal	Ideal				Unfav.
N									Normal											Normal	Unfav.
S				Unfav.		Unfav.				Ideal	Normal	Normal	Normal								
H																					
XSEQ1202															○						
XSEQ1203	○			●											●						
XSEQ1204															●						
XSEQ12T3		●													●						○
XSEQ12T4															●						

● Ex stock ○ On demand

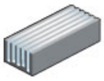
HC1 Coated carbide
HT Uncoated cermet
HC2 Coated cermet
HW Uncoated carbide

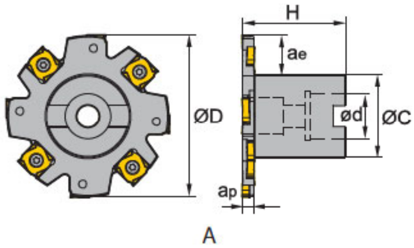
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

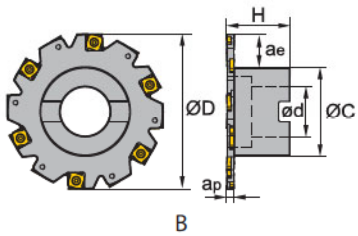
ZCC·CT

Slot milling

SMP01 Kr: 90°







Article	✲	Stock	Dimensions [mm]						Teeth	Coupling	kg	Inserts
			ØD	ød	Øc	H	a_p	$a_{e\,max}$				
SMP01-063x4-A22-SN12-06		○	63	22	32	40	4	14	6	A	0.2	
SMP01-080x4-A22-SN12-08		○	80	22	40	40	4	18	8	A	0.4	XSEQ1202
SMP01-100x4-A27-SN12-10		○	100	27	48	50	4	23	10	A	0.6	
SMP01-063x5-A22-SN12-06		○	63	22	32	40	5	14	6	A	0.2	
SMP01-080x5-A22-SN12-08		○	80	22	40	40	5	18	8	A	0.4	XSEQ1203
SMP01-100x5-A27-SN12-10		○	100	27	48	50	5	23	10	A	0.7	
SMP01-063x7-A22-SN12-06		○	63	22	32	40	7	14	6	A	0.2	
SMP01-080x7-A22-SN12-08		○	80	22	40	40	7	18	8	A	0.5	
SMP01-100x7-A27-SN12-10		○	100	27	48	50	7	23	10	A	0.7	XSEQ1204
SMP01-125x7-B40-SN12-12		○	125	40	72	50	7	23	12	B	1.1	
SMP01-160x7-B40-SN12-16		○	160	40	70	60	7	41	16	B	1.4	
SMP01-063x6-A22-SN12-06		○	63	22	32	40	6	14	6	A	0.2	
SMP01-080x6-A22-SN12-08		○	80	22	40	40	6	18	8	A	0.5	
SMP01-100x6-A27-SN12-10		○	100	27	48	50	6	23	10	A	0.7	XSEQ12T3
SMP01-125x6-B40-SN12-12		○	125	40	72	50	6	23	12	B	1	
SMP01-160x6-B40-SN12-16		○	160	40	70	60	6	41	16	B	1.3	
SMP01-063x8-A22-SN12-06		○	63	22	32	40	8	14	6	A	0.2	
SMP01-080x8-A22-SN12-08		○	80	22	40	40	8	18	8	A	0.5	
SMP01-100x8-A27-SN12-10		○	100	27	48	50	8	23	10	A	0.8	XSEQ12T4
SMP01-125x8-B40-SN12-12		○	125	40	72	50	8	23	12	B	1.1	
SMP01-160x8-B40-SN12-16		○	160	40	70	60	8	41	16	B	1.5	

● Ex stock ○ On demand

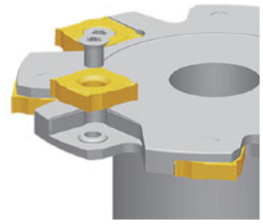
✲ With internal cooling

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Spare parts

	Insert	XSEQ1202	XSEQ1203	XSEQ1204	XSEQ12T3	XSEQ12T4
	ØD	63-160	63-160	63-250	63-250	63-250
	Screw (insert)	I91M4*3.2X (3.4 Nm)	I91M4*3.2X (3.4 Nm)	I91M4*6.1X (3.4 Nm)	I91M4*5.1X (3.4 Nm)	I91M4*7.1X (3.4 Nm)
	Wrench (insert)	WT08IP	WT08IP	WT08IP	WT08IP	WT08IP

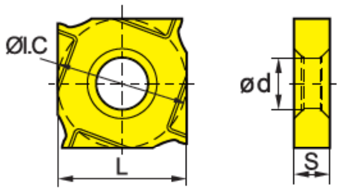


XSEQ		L	I.C	S	d
12	02	12.7	12.7	2.3	5
12	03	12.7	12.7	3	5
12	T3	12.7	12.7	3.5	5
12	04	12.7	12.7	4	5
12	T4	12.7	12.7	4.5	5

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

Milling inserts

XS** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfav.	Normal	Normal	Unfav.		Normal			Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
M		Normal	Unfav.	Normal	Normal	Unfav.					Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
K							Normal	Unfav.		Ideal						Normal	Ideal				Unfav.
N									Normal											Normal	Unfav.
S				Unfav.		Unfav.				Ideal	Normal	Normal	Normal								
H																					
 **XSEQ1202**															○						
XSEQ12T3		●													●						○
XSEQ1203	○			●											●						
XSEQ1204															●						
XSEQ12T4															●						

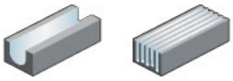
● Ex stock ○ On demand

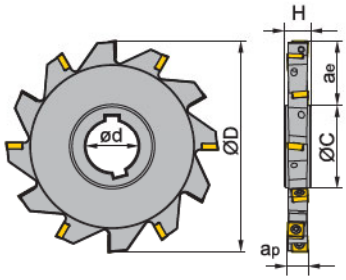
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Slot milling

SMP03 Kr: 90°





K

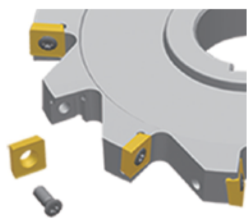
Article	✲	Stock	Dimensions [mm]						Teeth	Coupling	kg	Inserts
			ØD	ød	Øc	H	a_p	$a_{e\,max}$				
SMP03-080x8-K27-MP06-10		○	80	27	44	12	8	17.6	10	K	0.2	MPHT0603
SMP03-100x8-K32-MP06-14		○	100	32	49	12	8	25.1	14	K	0.3	
SMP03-100x10-K32-MP06-14		○	100	32	49	14	10	25.1	14	K	0.4	
SMP03-125x10-K40-MP06-16		○	125	40	57	14	10	33.6	16	K	0.6	
SMP03-125x12-K40-MP08-12		○	125	40	58.3	16	12	32.6	12	K	0.7	MPHT0803
SMP03-160x12-K40-MP08-14		○	160	40	64.3	16	12	31.5	14	K	1.3	
SMP03-160x16-K40-MP12-12		○	160	40	64.6	20	16	47.6	12	K	1.6	MPHT1204
SMP03-160x18-K40-MP12-12		○	160	40	65.3	24	18	47.3	12	K	1.9	
SMP03-160x20-K40-MP12-12		○	160	40	65.3	26	20	47.3	12	K	2.1	
SMP03-200x16-K50-MP12-14		○	200	50	74.6	20	16	62.6	14	K	2.5	
SMP03-200x18-K50-MP12-14		○	200	50	75.3	24	18	62.3	14	K	2.9	
SMP03-200x20-K50-MP12-14		○	200	50	75.3	26	20	62.3	14	K	3.3	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**MPHT0603**	**MPHT0803**	**MPHT1204**
	ØD	**80-125**	**125 -160**	**160-200**
	Screw (insert)	I60M2.5*6.5 (1.0 Nm)	I60M3*7 (1.8 Nm)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT07IP	WT09IP	
	Wrench (insert)			WT20IS



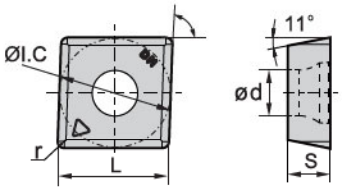
A Turning
B Milling
C Drilling
D Technical Information
E Index

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

MPHT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
08 03	8.3	8.3	3.18	3.4
12 04	12.7	12.7	4.76	5.56

MP** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
	N									Normal											Normal	Unfavourable
	S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
	H																					
 **MPHT060304-DM**	0.4	●				●										●						
MPHT080305-DM	0.5	●				●										●						
MPHT120408-DM	0.8	●				○		●								●						

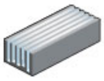
● Ex stock ○ On demand

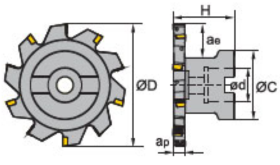
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

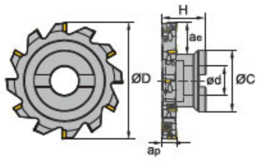
ZCC·CT

Slot milling

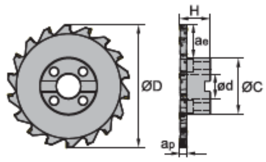
SMP03 Kr: 90°  



A



B



C

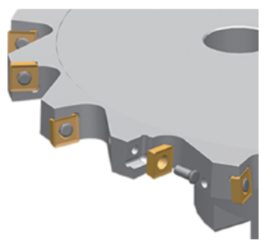
Article	✻	Stock	Dimensions [mm]						Teeth	Coupling	kg	Inserts
			ØD	ød	Øc	H	a_p	$a_{e\,max}$				
SMP03-080x8-A22-MP06-10		○	80	22	45	40	8	21	10	A	0.4	MPHT0603
SMP03-100x8-B27-MP06-14		○	100	27	55	40	8	24.5	14	B	0.6	
SMP03-100x10-B27-MP06-14		●	100	27	55	40	10	24.5	14	B	0.7	
SMP03-125x10-B32-MP06-16		○	125	32	65	45	10	33.3	16	B	1.1	
SMP03-125x12-B32-MP08-12		○	125	32	65	45	12	33	12	B	1.4	MPHT0803
SMP03-160x12-B40-MP08-14		○	160	40	80	50	12	44	14	B	1.9	
SMP03-200x12-C40-MP08-18		○	200	40	92	50	12	52	18	C	3.2	
SMP03-125x16-B32-MP12-10		○	125	32	65	50	16	33	10	B	2.3	MPHT1204
SMP03-160x16-B40-MP12-12		○	160	40	80	60	16	45	12	B	2.3	
SMP03-160x18-B40-MP12-12		○	160	40	80	60	18	45	12	B	2.4	
SMP03-200x16-C40-MP12-14		○	200	40	92	50	16	52	14	C	3.6	
SMP03-200x18-C40-MP12-14		○	200	40	92	50	18	52	14	C	3.9	
SMP03-200x20-C40-MP12-14		○	200	40	92	50	20	52	14	C	4.2	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	MPHT0603	MPHT0803	MPHT1204
	ØD	80-125	125 -200	125 -200
	Screw (insert)	I60M2.5*6.5 (1.0 Nm)	I60M3*7 (1.8 Nm)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT07IP	WT09IP	
	Wrench (insert)			WT20IS



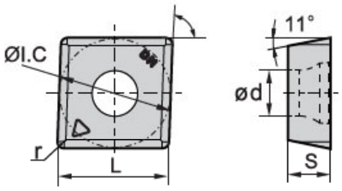
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

MPHT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
08 03	8.3	8.3	3.18	3.4
12 04	12.7	12.7	4.76	5.56

Milling inserts

◯ Ideal machining conditions
✪ Normal machining conditions
✲ Unfavourable machining conditions

MP** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✪	✪	✲	✪	✪	✲		✪			✪	✪	✪	✲	✲		◯	◯	◯		
M		✪	✲	✪	✪	✲					✪	✪	✪	✲	✲		◯	◯	◯		
K							✪	✲		◯						✪	◯				✲
N									✪											✪	✲
S				✲		✲				◯	✪	✪	✪								
H																					

ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
MPHT060304-DM	0.4	●				●										●						
MPHT080305-DM	0.5	●				●										●						
MPHT120408-DM	0.8	●				○		●								●						

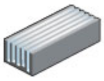
● Ex stock ○ On demand

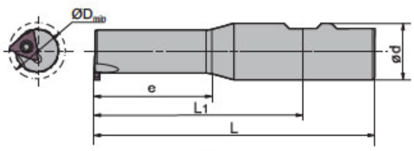
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

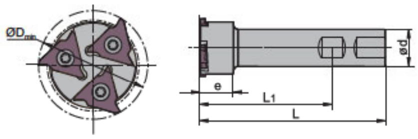
Slot milling

SMP05 Kr: 90°



A



B

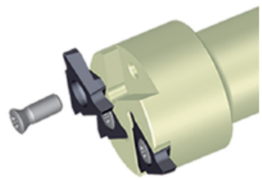
Article	✻	Stock	Dimensions [mm]					Teeth	Coupling	Inserts 
			e	ØDmin	ød	L_1	L			
SMP05-025x3.0-XP25-QC16-01		●	40	25	25	89	125	1	A	QC16L
SMP05-039x3.0-XP25-QC16-03		●	23	39	25	89	125	3	B	
SMP05-044x4.8-XP25-QC22-03		●	23	44	25	89	125	3	B	QC22L

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**QC16L**	**QC16L**	**QC22L**
	ØD	**25**	**39**	**44**
	Screw (insert)	I60M3.5*10 (2.7 Nm)	I60M3.5*10 (2.7 Nm)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT15IP	WT15IP	WT20IP



System code B26 Grade selection B24 Technical info B463 Cutting data B224

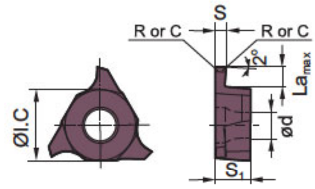
A
Turning
B
Milling
C
Drilling
D
Technical Information
E
Index

Milling inserts

◉ Ideal machining conditions
✲ Normal machining conditions
✽ Unfavourable machining conditions

QC	I.C	d
16	9.525	4.4
22	12.7	5.5

QC** turning/milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	✲	✲	✽	✲	✲	✽		✲			✲	✲	✲	✽	✽		◉	◉	◉		
M		✲	✽	✲	✲	✽					✲	✲	✲	✽	✽		◉	◉	◉		
K							✲	✽		◉						✲	◉				✽
N									✲											✲	✽
S				✽		✽				◉	✲	✲	✲								
H																					

ISO	S±0.025	La_{max}	R/C	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
QC16L075-R01	0.75	2	0.1												○									
QC16L095-R01	0.95	2	0.1												○									
QC16L100-R01	1	2	0.1												○									
QC16L110-R01	1.1	2	0.1												●	○								
QC16L120-R01	1.2	2	0.1												○									
QC16L125-R02	1.25	2	0.2												●									
QC16L130-R02	1.3	2	0.2												○									
QC16L145-R02	1.45	2	0.2												●									
QC16L150-R02	1.5	2	0.2												○									
QC16L160-R02	1.6	2	0.2												●									
QC16L165-R02	1.65	2	0.2												○									
QC16L170-R02	1.7	2	0.2												○									
QC16L175-R02	1.75	2	0.2												○									
QC16L185-R02	1.85	2.5	0.2												○									
QC16L200-R02	2	2.5	0.2												●									
QC16L210-R02	2.1	2.5	0.2												○									
QC16L210-R05	2.1	2.5	0.5												○									
QC16L220-R02	2.2	2.5	0.2												○									
QC16L250-R02	2.5	2.5	0.2												●									
QC16L300-R02	3	3	0.2												●									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

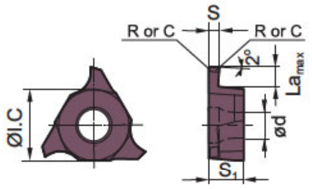
ZCC·CT

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

QC	I.C	d
16	9.525	4.4
22	12.7	5.5

QC** turning/milling insert



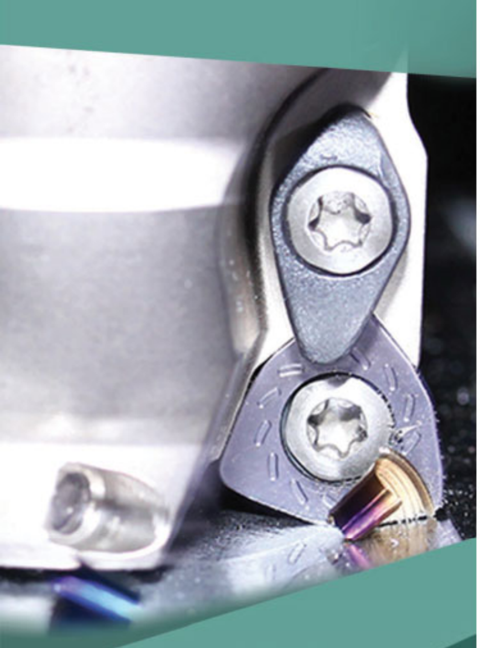
ISO	S±0.025	La_{max}	R/C	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
				HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P				Normal	Normal	Unfav.	Normal	Normal	Unfav.		Normal			Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
M					Normal	Unfav.	Normal	Normal	Unfav.					Normal	Normal	Normal	Unfav.	Unfav.		Ideal	Ideal	Ideal		
K										Normal	Unfav.		Ideal						Normal	Ideal				Unfav.
N												Normal											Normal	Unfav.
S							Unfav.		Unfav.				Ideal	Normal	Normal	Normal								
H																								
QC22L100-R02	1	2	0.2												○									
QC22L125-R02	1.25	2	0.2												○									
QC22L145-R02	1.45	2	0.2												○									
QC22L150-R02	1.5	3.5	0.2												○									
QC22L175-R02	1.75	3.5	0.2												○									
QC22L185-R02	1.85	3.5	0.2												○									
QC22L200-R02	2	3.5	0.2												○									
QC22L230-R02	2.3	3.5	0.2												○									
QC22L250-R03	2.5	4	0.3												○									
QC22L265-R03	2.65	4	0.3												●									
QC22L280-R03	2.8	4	0.3												○									
QC22L300-R03	3	4	0.3												○									
QC22L320-R03	3.2	4	0.3												○									
QC22L330-R03	3.3	4	0.3												○									
QC22L350-R03	3.5	5	0.3												○									
QC22L400-R04	4	5	0.4												●									
QC22L430-R04	4.3	5	0.4												○	○								
QC22L450-R04	4.5	5	0.4												○									○
QC22L480-R04	4.8	5	0.4												○									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Notes



XMR01 Kr: 11/16/22°

High-feed mill

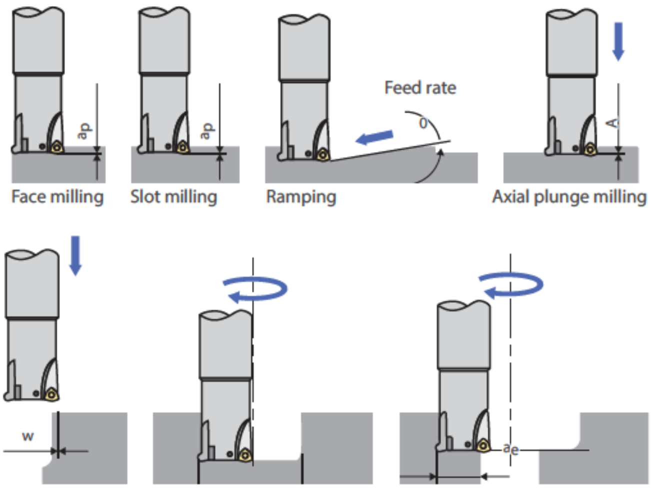
- Wide range of inserts and grades.
- High-feed mill for high chip removal rates.
- Low cutting forces even with large projecting lengths.

Insert grades

YBC302	YBM253	YBG205	YBG202
CVD	*CVD*	*PVD*	*PVD*
P15–P35	*P20–P40*	*P10–P30*	*P10–P30*
	M10–M30	*M20–M30*	

YBG302	YBG212	YBM351	YBD252
CVD	*PVD*	*CVD*	*CVD*
P15–P35	*M10–M25*	*P25–P40*	*K15–K35*

Machining operations

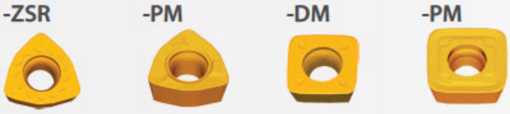


Face milling Slot milling Ramping Axial plunge milling

Plunge milling Helical ramping Circular boring

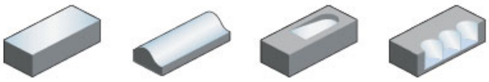
Chip breakers

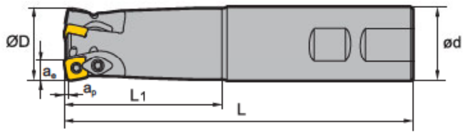
-ZSR -PM -DM -PM



High feed milling

XMR01 Kr: 15°





S type insert, Weldon shank

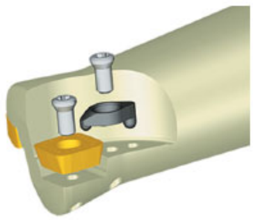
Article	✻	Stock	Dimensions [mm]						Teeth	kg	Inserts
			ØD	ød	a_p	ae	L_1	L			
XMR01-025-XP25-SD06-03		○	25	25	0.8	5.8	60	140	3	0.46	SDMT06T2
XMR01-025-XP25-SD09-02		○	25	25	1.4	8.8	60	140	2	0.5	
XMR01-032-XP32-SD09-03		○	32	32	1.4	8.8	70	150	3	0.8	SDMT09T3
XMR01-035-XP32-SD09-03		○	35	32	1.4	8.8	70	150	3	0.8	
XMR01-040-XP40-SD12-03		○	40	40	1.8	11.7	70	150	3	1.3	SDMT1204
XMR01-040-XP40-SD15-02		○	40	40	2.2	14	70	200	2	1.6	SDMT1505

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SDMT06T2**	**SDMT09T3**	**SDMT1204**	**SDMT1505**
	ØD	**20-63**	**25-63**	**32-100**	**40-160**
	Clamp		WD-204	WD-204	WD-208
	Screw (clamp)		I60M4*8.4 (3.4 Nm)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)	I60M2.2*5.5 (0.8 Nm)		I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)		I60M3.5*08TT (2.7 Nm)		
	Wrench (clamp)		WT15IP	WT15IP	WT20IP
	Wrench (insert)	WT07IP	WT10IP	WT15IP	WT20IP



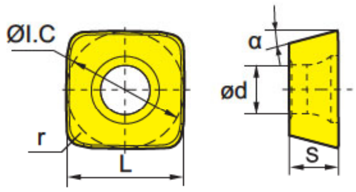
System code B26 Grade selection B24 Technical info B463 Cutting data B224

SDMT	L	I.C	S	d
06 T2	6.35	6.35	2.58	2.5
09 T3	9.525	9.525	3.97	4
12 04	12.7	12.7	4.76	4.4
15 05	15.875	15.875	5.56	5.5

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SD** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SDMT06T208-DM**	0.8	15						○							○								
	SDMT09T312-DM	1.2	15	●					●		○					●		●						
	SDMT120412-DM	1.2	15	●					●		○					●	○							
	SDMT150520-DM	2	15													○								
	**SDMT06T208-PM**	0.8	15	●			●								●									
	SDMT09T312-PM	1.2	15				●								●	●								
	SDMT120412-PM	1.2	15				●								●	●								
	SDMT150520-PM	2	15				○								○									

● Ex stock ○ On demand

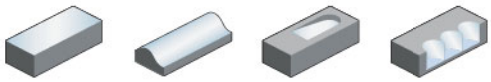
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

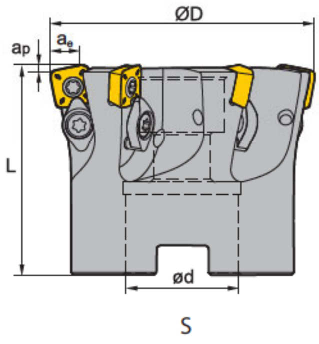
A Turning
B Milling
C Drilling
D Technical Information
E Index

System code B26 Grade selection B24 Technical info B463 Cutting data B224

High feed milling

XMR01 Kr: 15°





Article	✲	Stock	Dimensions [mm] ØD	ød	a_p	ae	L	Teeth	Coupling	kg	Inserts
XMR01-050-A22-SD06-07		○	50	22	0.8	5.8	40	7	A	0.36	SDMT06T2
XMR01-063-A22-SD06-10		○	63	22	0.8	5.8	40	10	A	0.53	
XMR01-063-A27-SD06-10		○	63	27	0.8	5.8	50	10	A	0.57	
XMR01-040-A16-SD09-04		○	40	16	1.4	8.8	40	4	A	0.182	SDMT09T3
XMR01-050-A22-SD09-04		●	50	22	1.4	8.8	40	4	A	0.3	
XMR01-050-A22-SD09-04C	✲	●	50	22	1.4	8.8	40	4	A	0.3	
XMR01-063-A22-SD09-06		●	63	22	1.4	8.8	40	6	A	0.5	
XMR01-063-A22-SD09-06C	✲	●	63	22	1.4	8.8	40	6	A	0.5	
XMR01-063-A27-SD09-06		○	63	27	1.4	8.8	50	6	A	0.6	
XMR01-063-A27-SD09-06C	✲	○	63	27	1.4	8.8	50	6	A	0.6	
XMR01-063-A22-SD09-07		●	63	22	1.4	8.8	40	7	A	0.44	
XMR01-063-A22-SD12-05		●	63	22	1.8	11.7	40	5	A	0.5	SDMT1204
XMR01-063-A22-SD12-05C	✲	●	63	22	1.8	11.7	40	5	A	0.5	
XMR01-063-A27-SD12-05		●	63	27	1.8	11.7	50	5	A	0.6	
XMR01-063-A27-SD12-05C	✲	●	63	27	1.8	11.7	50	5	A	0.6	
XMR01-063-A22-SD12-06		●	63	22	1.8	11.7	50	6	A	0.55	
XMR01-066-A27-SD12-05C	✲	○	66	27	1.8	11.7	50	5	A	0.56	
XMR01-080-A27-SD12-05		●	80	27	1.8	11.7	63	5	A	0.9	
XMR01-080-A27-SD12-05C	✲	●	80	27	1.8	11.7	63	5	A	0.9	
XMR01-080-A27-SD12-06C	✲	●	80	27	1.8	11.7	50	6	A	0.9	
XMR01-080-A27-SD12-07		●	80	27	1.8	11.7	50	7	A	0.93	
XMR01-080-A27-SD12-08		●	80	27	1.8	11.7	50	8	A	0.92	
XMR01-100-B32-SD12-06		●	100	32	1.8	11.7	50	6	B	1.8	
XMR01-100-B32-SD12-06C	✲	●	100	32	1.8	11.7	50	6	B	1.8	
XMR01-100-B32-SD15-07		○	100	32	2.2	14	50	7	B	1.2	SDMT1505
XMR01-125-B40-SD15-09		○	125	40	2.2	14	63	9	B	2.9	

● Ex stock ○ On demand

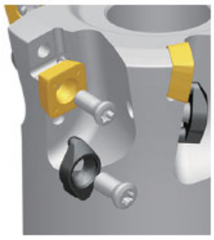
✲ With internal cooling

System code B26 Grade selection B24 Technical info B463 Cutting data B224

ZCC·CT

Spare parts

	Insert	SDMT06T2	SDMT09T3	SDMT1204	SDMT1505
	ØD	20-63	25-63	32-100	40-160
	Clamp		WD-204	WD-204	WD-208
	Screw (clamp)		I60M4*8.4 (3.4 Nm)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)	I60M2.2*5.5 (0.8 Nm)		I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)		I60M3.5*08TT (2.7 Nm)		
	Wrench (clamp)		WT15IP	WT15IP	WT20IP
	Wrench (insert)	WT07IP	WT10IP	WT15IP	WT20IP

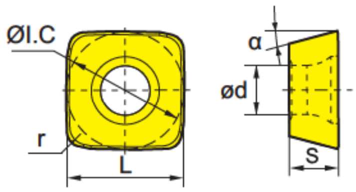


SDMT	L	I.C	S	d
06 T2	6.35	6.35	2.58	2.5
09 T3	9.525	9.525	3.97	4
12 04	12.7	12.7	4.76	4.4
15 05	15.875	15.875	5.56	5.5

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SD** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SDMT06T208-DM**	0.8	15						○							○								
	SDMT09T312-DM	1.2	15	●					●		○					●		●						
	SDMT120412-DM	1.2	15	●					●		○					●	○							
	SDMT150520-DM	2	15													○								
	**SDMT06T208-PM**	0.8	15	●			●								●									
	SDMT09T312-PM	1.2	15				●								●	●								
	SDMT120412-PM	1.2	15				●								●	●								
	SDMT150520-PM	2	15				○								○									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

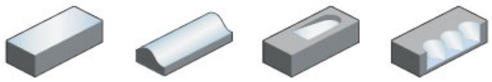
A Turning
B Milling
C Drilling
D Technical Information
E Index

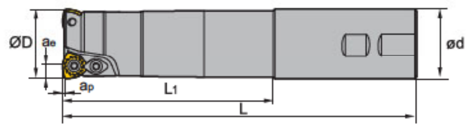
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

High feed milling

XMR01 Kr: 11°-22°





W type insert, Weldon shank

Article	✲	Stock	Dimensions [mm] ØD	ød	a_p	ae	L_1	L	Teeth	kg	Inserts 
XMR01-020-XP20-WP05-02-M		○	20	20	1.5	3.8	50	130	2	0.2	WPGT0503
XMR01-020-XP20-WP05-02-L		○	20	20	1.5	3.8	100	180	2	0.3	
XMR01-020-XP20-WP05-02-XL		○	20	20	1.5	3.8	130	250	2	0.8	
XMR01-025-XP25-WP06-02-M		○	25	25	1.5	4.35	60	140	2	0.4	WPGT0604
XMR01-025-XP25-WP06-02-L		○	25	25	1.5	4.35	120	200	2	0.6	
XMR01-025-XP25-WP06-02-XL		○	25	25	1.5	4.35	180	300	2	1	
XMR01-032-XP32-WP06-03-M		○	32	32	1.5	4.35	70	150	3	0.8	
XMR01-032-XP32-WP06-03-L		○	32	32	1.5	4.35	120	200	3	1	
XMR01-032-XP32-WP06-03-XL		○	32	32	1.5	4.35	180	300	3	1.6	
XMR01-040-XP32-WP06-03-M		○	40	32	1.5	4.35	50	150	3	0.9	
XMR01-040-XP32-WP06-03-XL		○	40	32	1.5	4.35	50	300	3	1.8	

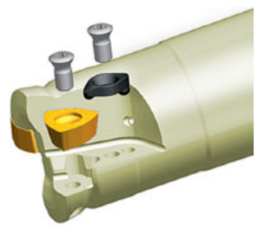
● Ex stock ○ On demand

✲ With internal cooling

variabler Einstellwinkel (Einstellwinkel ist hier plattengrößenabhängig)- lead angle:
WPGT05 insert: 16°; WPGT06 insert: 22°; WPGT08 insert: 11°; WPGT09 insert: 21°

Spare parts

	Insert	**WPGT0503**	**WPGT0604**
	ØD	**20**	**25-40**
	Clamp		
	Screw (clamp)		
	Screw (insert)		I60M4*8.4 (3.4 Nm)
	Screw (insert)	I60M3.5*08TT (2.7 Nm)	
	Wrench (clamp)		
	Wrench (insert)	WT10IP	WT15IP



System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

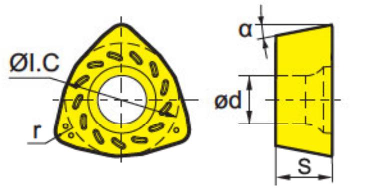
ZCC·CT

Milling inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions

WPGT	I.C	S	d
05 03	7.94	3.5	4
06 04	9.525	4.2	4.4
08 06	12.85	6.35	5.5

WP** positive insert



		HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	P	⊕	⊕	✲	⊕	⊕	✲		⊕			⊕	⊕	⊕	✲	✲		○	○	○		
	M		⊕	✲	⊕	⊕	✲					⊕	⊕	⊕	✲	✲		○	○	○		
	K							⊕	✲		○						⊕	○				✲
	N									⊕											⊕	✲
	S				✲		✲				○	⊕	⊕	⊕								
	H																					
ISO	**r**																					
 **WPGT050315ZSR-PM**	1.5												●									
WPGT060415ZSR-PM	1.5	●											●									
WPGT080615ZSR-PM	1.5	●											●									
 **WPGT050315ZSR**	1.5	●					●								●							
WPGT060415ZSR	1.5	●					●						●		●							
WPGT080615ZSR	1.5	●					●						●		●							

● Ex stock ○ On demand

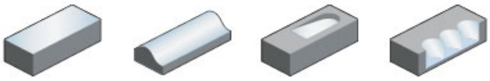
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

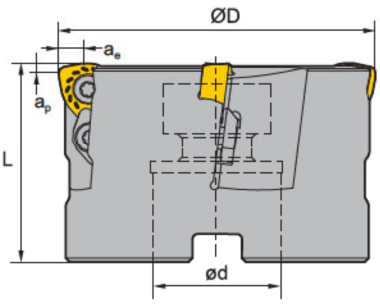
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

High feed milling

XMR01 Kr: 11°-22°





W type insert, Arbor mounting

Article	✲	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts 
			ØD	ød	a_p	ae	L				
XMR01-050-A22-WP06-04		●	50	22	1.5	4.35	50	4	A	0.4	WPGT0604
XMR01-050-A22-WP06-04C	✲	●	50	22	1.5	4.35	50	4	A	0.4	
XMR01-050-A22-WP08-03		○	50	22	1.5	5.66	50	3	A	0.4	WPGT0806
XMR01-063-A22-WP08-04		●	63	22	1.5	5.66	50	4	A	0.7	
XMR01-063-A27-WP08-04		●	63	27	1.5	5.66	50	4	A	0.7	
XMR01-063-A22-WP08-04C	✲	●	63	22	1.5	5.66	50	4	A	0.7	
XMR01-063-A27-WP08-04C	✲	○	63	27	1.5	5.66	50	4	A	0.7	
XMR01-080-A27-WP08-05		●	80	27	1.5	5.66	63	5	A	1.5	
XMR01-080-A27-WP08-05C	✲	●	80	27	1.5	5.66	63	5	A	1.5	
XMR01-100-B32-WP08-06		●	100	32	1.5	5.66	63	6	B	2.2	
XMR01-125-B40-WP08-07		●	125	40	1.5	5.66	63	7	B	3.5	
XMR01-160-B40-WP08-08		○	160	40	1.5	5.66	63	8	B	6	
XMR01-063-A22-WP09-03C	✲	○	63	22	3	6.8	50	3	A	0.7	WPGT0907
XMR01-080-A27-WP09-04C	✲	○	80	27	3	6.8	63	4	A	1.4	
XMR01-100-B32-WP09-05		○	100	32	3	6.8	63	5	B	2.1	
XMR01-125-B40-WP09-06		○	125	40	3	6.8	63	6	B	3.7	
XMR01-160-B40-WP09-07		○	160	40	3	6.8	63	7	B	6.3	

● Ex stock ○ On demand

✲ With internal cooling

variabler Einstellwinkel (Einstellwinkel ist hier plattengrößenabhängig)- lead angle:
WPGT05 insert: 16°; WPGT06 insert: 22°; WPGT08 insert: 11°; WPGT09 insert: 21°

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Spare parts

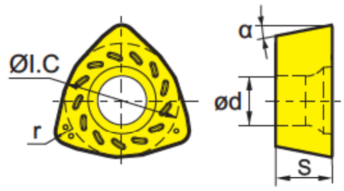
	Insert	WPGT0604	WPGT0806	WPGT0907
	ØD	50	50-160	3-160
	Clamp		WD-208	WD-208
	Screw (clamp)		I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)
	Wrench (clamp)		WT20IT	WT20IT
	Wrench (insert)	WT15IS		
	Wrench (insert)		WT20IT	WT20IT

Milling inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✻ Unfavourable machining conditions

WPGT	I.C	S	d
06 04	9.525	4.2	4.4
08 06	12.85	6.35	5.5
09 07	15	7	5.5

WP** positive insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO / r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊛	⊛	✻	⊛	⊛	✻		⊛			⊛	⊛	⊛	✻	✻		◯	◯	◯		
M		⊛	✻	⊛	⊛	✻					⊛	⊛	⊛	✻	✻		◯	◯	◯		
K							⊛	✻		◯						⊛	◯				✻
N									⊛											⊛	✻
S				✻		✻				◯	⊛	⊛	⊛								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**WPGT060415ZSR-PM**	1.5	●											●									
	WPGT080615ZSR-PM	1.5	●											●									
	WPGT090725ZSR-PM	2.5												●									
	**WPGT060415ZSR**	1.5	●					●						●		●							
	WPGT080615ZSR	1.5	●					●						●		●							
	WPGT090725ZSR	2.5						●						●		○							

● Ex stock ○ On demand

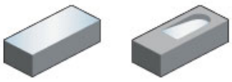
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

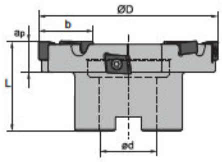
System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

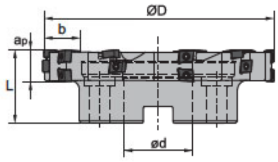
Bore milling

XMP01 Kr: 90°

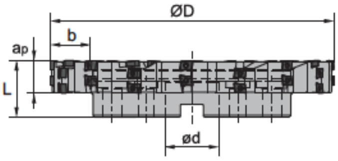




B



C



D

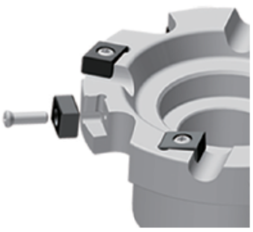
Article	✲	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ød	b	a_p	L				
XMP01-080*18-B27-CNE1210-08		●	80	27	18	15	50	8	B	0.67	CNE12
XMP01-100*18-B32-CNE1210-08		●	100	32	18	20	50	8	B	0.99	
XMP01-125*27-B40-CNE1210-15		●	125	40	27	22.5	63	15	B	2.46	
XMP01-160*27-C40-CNE1210-18		●	160	40	27	25	63	18	C	3.7	
XMP01-200*27-C60-CNE1210-21		●	200	60	27	31.5	63	21	C	5.46	
XMP01-250*36-C60-CNE1210-32		●	250	40	36	56.5	63	32	C	9.79	
XMP01-315*36-D60-CNE1210-42		●	315	60	36	47.5	63	42	D	17.65	
XMP01-400*36-D60-CNE1210-52		●	400	60	36	36	63	52	D	27.36	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CNE12**
	ØD	**80-400**
	Screw (insert)	I60M4*12 (3.4 Nm)
	Wrench (insert)	WT15IP



System code B26 Grade selection B24 Technical info B463 Cutting data B224

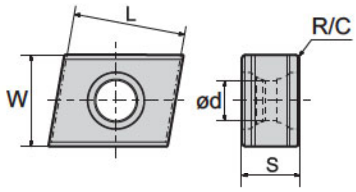
ZCC·CT

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CNE	L	S	d
12	12.8	6.35	4.4

CN** milling insert



Material	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	R/C	W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**CNE121006A**	0.4	10				●																	
	**CNE121006B**	0.6	10				○			●														

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

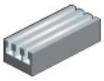
A Turning
B Milling
C Drilling
D Technical Information
E Index

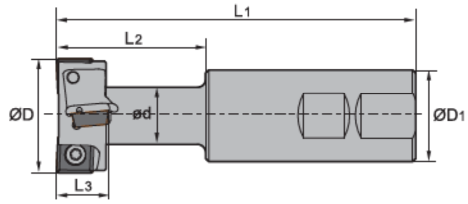
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

T-slot milling

TMP01 Kr: 90°





Weldon shank

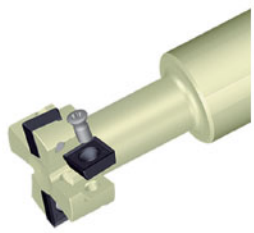
Article	✲	Stock	Dimensions [mm]						Teeth	No. of inserts	T-slot specification	Inserts 
			ØD	ØD1	ød	L1	L2	L3				
TMP01-021-XP25-MP06-01		●	21	25	10	100	32	9	1	2	12	MPHT0603
TMP01-025-XP25-MP06-01		●	25	25	12	100	35	11	1	2	14	
TMP01-032-XP32-MP08-02		●	32	32	15	110	45	14	2	4	18	MPHT0803
TMP01-040-XP32-MP12-02		●	40	32	19	125	55	18	2	4	22	MPHT1204
TMP01-050-XP40-MP12-02		●	50	40	25	140	65	22	2	4	28	
TMP01-060-XP50-MP12-02		●	60	50	32	160	80	28	2	6	36	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**MPHT0603**	**MPHT0803**	**MPHT1204**
	ØD	**21-25**	**32**	**40-60**
	Screw (insert)	I60M2.5*5.5 (1.0 Nm)	I60M3*7 (1.8 Nm)	I60M5*10 (6.7 Nm)
	Wrench (insert)	WT07IP	WT09IP	
	Wrench (insert)			WT20IT



System code B26 Grade selection B24 Technical info B463 Cutting data B224

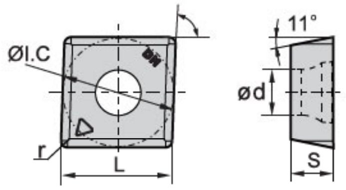
ZCC·CT

MPHT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
08 03	8.3	8.3	3.18	3.4
12 04	12.7	12.7	4.76	5.56

◯ Ideal machining conditions
⊛ Normal machining conditions
✽ Unfavourable machining conditions

Milling inserts

MP** milling insert



Group	ISO	P	M	K	N	S	H	MPHT060304-DM (r 0.4)	MPHT080305-DM (r 0.5)	MPHT120408-DM (r 0.8)
HC¹ (CVD)	YBC302	⊛						●	●	●
HC¹ (CVD)	YBC301	⊛	⊛							
HC¹ (CVD)	YBC401	✽	✽							
HC¹ (CVD)	YBM253	⊛	⊛			✽				
HC¹ (CVD)	YBM251	⊛	⊛					●	●	○
HC¹ (CVD)	YBM351	✽	✽			✽				
HC¹ (CVD)	YBD152			⊛						●
HC¹ (CVD)	YBD252	⊛		✽						
HC¹ (PVD)	YBG101				⊛					
HC¹ (PVD)	YBG102			◯		◯				
HC¹ (PVD)	YB9320	⊛	⊛			⊛				
HC¹ (PVD)	YBG205	⊛	⊛			⊛				
HC¹ (PVD)	YBG202	⊛	⊛			⊛				
HC¹ (PVD)	YBG212	✽	✽							
HC¹ (PVD)	YBG302	✽	✽					●	●	●
HC¹ (PVD)	YBG152			⊛						
HC¹ (PVD)	YBG252	◯	◯	◯						
HT	YNG151	◯	◯							
HC²	YNG151C	◯	◯							
HW	YD101				⊛					
HW	YD201			✽	✽					

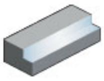
● Ex stock ○ On demand

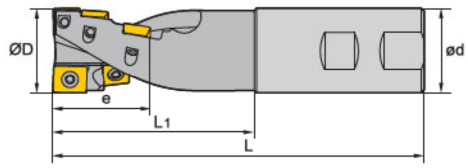
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

Helical milling

HMP01 Kr: 90°



Weldon shank

Article	✲	Stock	Dimensions [mm] ØD	e	ød	L_1	L	Teeth row	Teeth APKT	SPMT	Shank type	Inserts 
HMP01-040x55-XP40-SP12-02		●	40	55	40	95	175	2	1	5	Weldon	APKT1504 & SPMT1204
HMP01-050x55-XP40-SP12-04		●	50	55	40	95	175	4	2	10	Weldon	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**APKT1504 & SPMT1204**	**APKT1504 & SPMT1204**
	ØD	**40**	**50**
	Screw (insert)	I60M5*10 (6.7 Nm)	I60M5*13 (6.7 Nm)
	Wrench (insert)	WT20T	WT20T

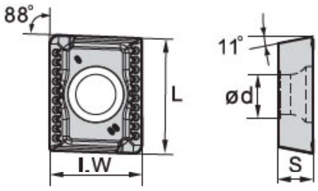
System code B26 Grade selection B24 Technical info B463 Cutting data B224

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert



	HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT150412-KM**	1.2	12.7																●					
	**APKT150412-PM**	1.2	12.7				●											●						

● Ex stock ○ On demand

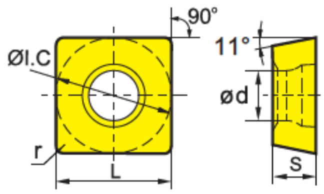
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



	HC^1 (CVD)								HC^1 (PVD)									HT	HC^2	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SPMT120408-KM**	0.8																●					
	**SPMT120408-PM**	0.8				●											●						

● Ex stock ○ On demand

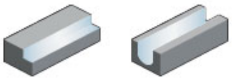
HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

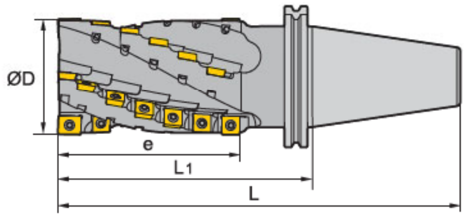
System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Helical milling

HMP01 Kr: 90°





Article	✲	Stock	Dimensions [mm]				Teeth row	Teeth		Shank type	Inserts
			ØD	e	L_1	L		APKT	SPMT		
HMP01-050x84-BT50-SP12-04		○	50	84	145	246.8	4	2	16	BT	APKT1504 & SPMT1204
HMP01-050x84-JT50-SP12-04		○	50	84	145	246.75	4	2	16	JT	
HMP01-063x74-BT50-SP12-04		○	63	74	135	236.8	4	2	14	BT	
HMP01-063x74-JT50-SP12-04		○	63	74	135	236.75	4	2	14	JT	
HMP01-063x104-BT50-SP12-04		○	63	104	165	266.8	4	2	20	BT	
HMP01-063x104-JT50-SP12-04		●	63	104	165	266.75	4	2	20	JT	
HMP01-063x134-BT50-SP12-04		○	63	134	195	296.8	4	2	26	BT	
HMP01-063x134-JT50-SP12-04		○	63	134	195	296.75	4	2	26	JT	
HMP01-080x104-BT50-SP12-04		○	80	104	165	266.8	4	2	20	BT	
HMP01-080x104-JT50-SP12-04		○	80	104	165	266.75	4	2	20	JT	
HMP01-080x144-BT50-SP12-04		○	80	144	205	306.8	4	2	28	BT	
HMP01-080x144-JT50-SP12-04		○	80	144	205	306.75	4	2	28	JT	

● Ex stock ○ On demand

✲ With internal cooling

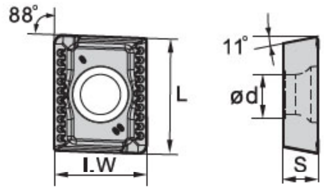
Spare parts			
	Insert	APKT1504 & SPMT1204	
	ØD	50-80	
	Screw (insert)	I60M5*10 (6.7 Nm)	
	Wrench (insert)	WT20IS	

Milling inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert



	HC^{1} (CVD)								HC^{1} (PVD)									HT	HC^{2}	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊕	⊕	✲	⊕	⊕	✲		⊕			⊕	⊕	⊕	✲	✲		◯	◯	◯		
M		⊕	✲	⊕	⊕	✲					⊕	⊕	⊕	✲	✲		◯	◯	◯		
K							⊕	✲		◯						⊕	◯				✲
N									⊕											⊕	✲
S				✲		✲				◯	⊕	⊕	⊕								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT150412-KM**	1.2	12.7																●					
	**APKT150412-PM**	1.2	12.7				●											●						

● Ex stock ○ On demand

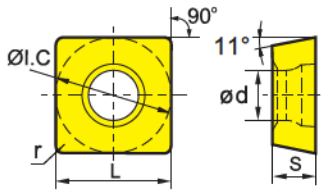
HC^{1} Coated carbide
HT Uncoated cermet
HC^{2} Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



	HC^{1} (CVD)								HC^{1} (PVD)									HT	HC^{2}	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	⊕	⊕	✲	⊕	⊕	✲		⊕			⊕	⊕	⊕	✲	✲		◯	◯	◯		
M		⊕	✲	⊕	⊕	✲					⊕	⊕	⊕	✲	✲		◯	◯	◯		
K							⊕	✲		◯						⊕	◯				✲
N									⊕											⊕	✲
S				✲		✲				◯	⊕	⊕	⊕								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SPMT120408-KM**	0.8																●					
	**SPMT120408-PM**	0.8				●											●						

● Ex stock ○ On demand

HC^{1} Coated carbide
HT Uncoated cermet
HC^{2} Coated cermet
HW Uncoated carbide

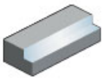
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

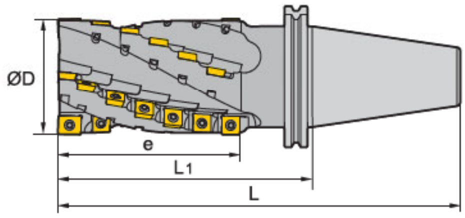
A Turning | B Milling | C Drilling | D Technical Information | E Index

A Turning
B Milling
C Drilling
D Technical Information
E Index

Helical milling

HMP01 EC Kr: 90°





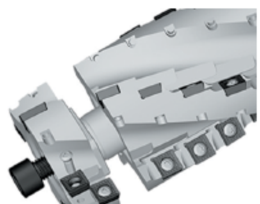
Article	✻	Stock	Dimensions [mm]				Teeth row	Teeth		Shank type	Inserts 
			ØD	e	L_1	L		APKT	SPMT		
HMP01-050x84EC-BT50-SP12-04		○	50	84	145	246.8	4	2	16	BT	APKT1504 & SPMT1204
HMP01-050x84EC-JT50-SP12-04		●	50	84	145	246.75	4	2	16	JT	
HMP01-063x74EC-BT50-SP12-04		○	63	74	135	236.8	4	2	14	BT	
HMP01-063x74EC-JT50-SP12-04		○	63	74	135	236.75	4	2	14	JT	
HMP01-063x104EC-BT50-SP12-04		○	63	104	165	266.8	4	2	20	BT	
HMP01-063x104EC-JT50-SP12-04		○	63	104	165	266.75	4	2	20	JT	
HMP01-063x134EC-BT50-SP12-04		○	63	134	195	296.8	4	2	26	BT	
HMP01-063x134EC-JT50-SP12-04		●	63	134	195	296.75	4	2	26	JT	
HMP01-080x104EC-BT50-SP12-04		○	80	104	165	266.8	4	2	20	BT	
HMP01-080x104EC-JT50-SP12-04		○	80	104	165	266.75	4	2	20	JT	
HMP01-080x144EC-BT50-SP12-04		○	80	144	205	306.8	4	2	28	BT	
HMP01-080x144EC-JT50-SP12-04		○	80	144	205	306.75	4	2	28	JT	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**APKT1504 & SPMT1204**	**APKT1504 & SPMT1204**	**APKT1504 & SPMT1204**
	ØD	**50**	**63**	**80**
	Indexable head	050EC	063EC	080EC
	Screw (head)	M10*50 (16.6 Nm)	M10*50 (16.6 Nm)	M12*55 (25.2 Nm)
	Screw (insert)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)
	Wrench (head)	WH80L	WH80L	WH100L
	Wrench (insert)	WT20IS	WT20IS	WT20IS



System code B26 Grade selection B24 Technical info B463 Cutting data B224

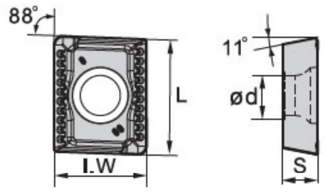
ZCC·CT

Milling inserts

◯ Ideal machining conditions
◐ Normal machining conditions
✻ Unfavourable machining conditions

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	◐	◐	✻	◐	◐	✻		◐			◐	◐	◐	✻	✻		◯	◯	◯		
M		◐	✻	◐	◐	✻					◐	◐	◐	✻	✻		◯	◯	◯		
K							◐	✻		◯						◐	◯				✻
N									◐											◐	✻
S				✻		✻				◯	◐	◐	◐								
H																					

	ISO	r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**APKT150412-KM**	1.2	12.7																●					
	**APKT150412-PM**	1.2	12.7				●											●						

● Ex stock ○ On demand

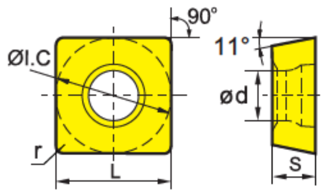
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Milling inserts

◯ Ideal machining conditions
◐ Normal machining conditions
✻ Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



	HC[1] (CVD)								HC[1] (PVD)									HT	HC[2]	HW	
	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	◐	◐	✻	◐	◐	✻		◐			◐	◐	◐	✻	✻		◯	◯	◯		
M		◐	✻	◐	◐	✻					◐	◐	◐	✻	✻		◯	◯	◯		
K							◐	✻		◯						◐	◯				✻
N									◐											◐	✻
S				✻		✻				◯	◐	◐	◐								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SPMT120408-KM**	0.8																●					
	**SPMT120408-PM**	0.8				●											●						

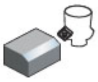
● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Chamfer milling

CMZ01 Kr: 30°



Straight shank

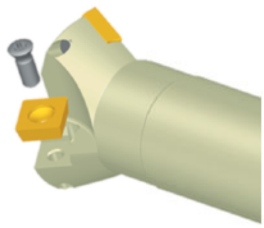
Article	✲	Stock	Dimensions [mm] ØD	ød	L1	L	Teeth	kg	Inserts
CMZ01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMZ01-025-G25-SP12-02		●	25	25	40	120	2	0.8	SPMT1204
CMZ01-032-G32-SP12-03		●	32	32	40	180	3	1.1	SPMT1204

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SPMT1204**
	ØD	**12-32**
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS



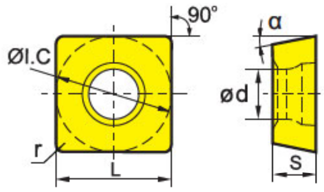
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
	P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
	K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
	N									Normal											Normal	Unfavourable
	S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
	H																					
 **SPMT120408-HT-1**	0.8														○							
 **SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

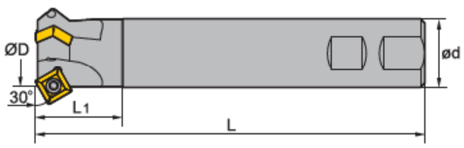
A Turning
B Milling
C Drilling
D Technical Information
E Index

System code > B26 Grade selection > B24 Technical info > B463 Cutting data > B224

A Turning B Milling C Drilling D Technical Information E Index

Chamfer milling

CMZ01 Kr: 30°



Weldon shank

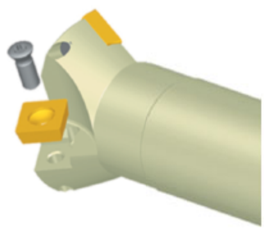
Article	✲	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L_1	L			
CMZ01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMZ01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	SPMT1204
CMZ01-032-XP32-SP12-03		●	32	32	40	180	3	1	SPMT1204

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	SPMT1204
	ØD	12-32
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS



System code B26 Grade selection B24 Technical info B463 Cutting data B224

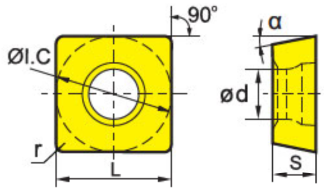
ZCC·CT

Milling inserts

◯ Ideal machining conditions
❀ Normal machining conditions
✱ Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P		❀	❀	✱	❀	❀	✱		❀			❀	❀	❀	✱	✱		◯	◯	◯		
M			❀	✱	❀	❀	✱					❀	❀	❀	✱	✱		◯	◯	◯		
K								❀	✱		◯						❀	◯				✱
N										❀											❀	✱
S					✱		✱				◯	❀	❀	❀								
H																						
 **SPMT120408-HT-1**	0.8														○							
 **SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

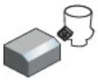
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

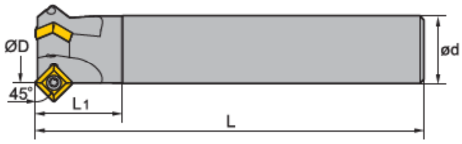
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Chamfer milling

CMA01 Kr: 45°





Straight shank

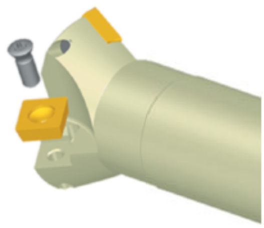
Article	✲	Stock	Dimensions [mm] ØD	ød	L_1	L	Teeth	kg	Inserts
CMA01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMA01-025-G25-SP12-02		●	25	25	40	120	2	0.8	SPMT1204
CMA01-032-G32-SP12-03		●	32	32	40	180	3	1.1	SPMT1204

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SPMT1204**
	ØD	**12-32**
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS

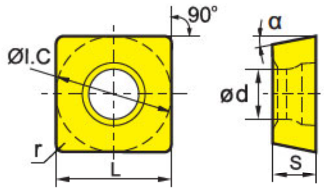


Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
P		Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M			Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K								Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N										Normal											Normal	Unfavourable
S					Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																						
 **SPMT120408-HT-1**	0.8														○							
 **SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

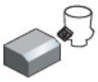
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

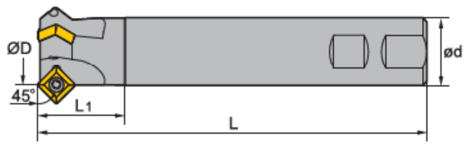
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Chamfer milling

CMA01 Kr: 45°





Weldon shank

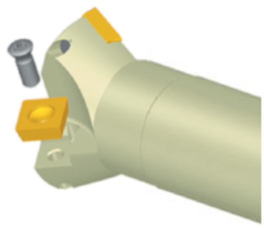
Article	✲	Stock	Dimensions [mm]				Teeth	kg	Inserts 
			ØD	ød	L_1	L			
CMA01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMA01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	
CMA01-032-XP32-SP12-03		●	32	32	40	100	3	1	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	SPMT1204
	ØD	**12-32**
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS



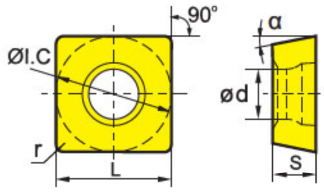
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SP** milling insert



	HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P	Normal	Normal	Unfavourable	Normal	Normal	Unfavourable		Normal			Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
M		Normal	Unfavourable	Normal	Normal	Unfavourable					Normal	Normal	Normal	Unfavourable	Unfavourable		Ideal	Ideal	Ideal		
K							Normal	Unfavourable		Ideal						Normal	Ideal				Unfavourable
N									Normal											Normal	Unfavourable
S				Unfavourable		Unfavourable				Ideal	Normal	Normal	Normal								
H																					

	ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	**SPMT120408-HT-1**	0.8														○							
	**SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

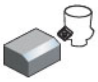
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

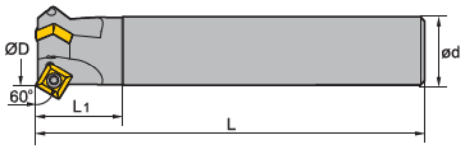
System code B26 | Grade selection B24 | Technical info B463 | Cutting data B224

A Turning B Milling C Drilling D Technical Information E Index

Chamfer milling

CMD01 Kr: 60°





Straight shank

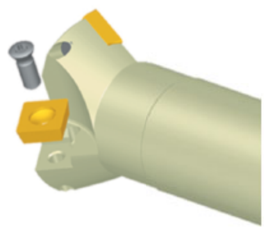
Article	✲	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L_1	L			
CMD01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMD01-025-G25-SP12-02		●	25	25	40	120	2	0.8	SPMT1204
CMD01-036-G32-SP12-03		●	36	32	40	180	3	1	SPMT1204

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	SPMT1204
	ØD	**12-36**
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS



System code B26 Grade selection B24 Technical info B463 Cutting data B224

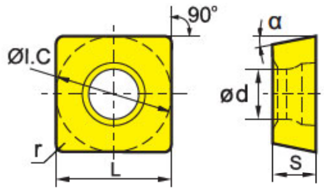
ZCC·CT

Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



P M K N S H

	ISO	r	HC[1] (CVD) YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	HC[1] (PVD) YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	HT YNG151	HC[2] YNG151C	HW YD101	YD201
	**SPMT120408-HT-1**	0.8														○							
	**SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

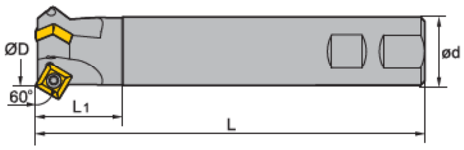
HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

System code B26 Grade selection B24 Technical info B463 Cutting data B224

A Turning
B Milling
C Drilling
D Technical Information
E Index

Chamfer milling

CMD01 Kr: 60°



Weldon shank

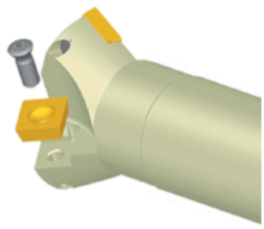
Article	✲	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L_1	L			
CMD01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMD01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	SPMT1204
CMD01-036-XP32-SP12-03		●	36	32	40	180	3	1	SPMT1204

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	SPMT1204
	ØD	**12-36**
	Screw (insert)	I43M5*11 (6.7 Nm)
	Wrench (insert)	WT20IS

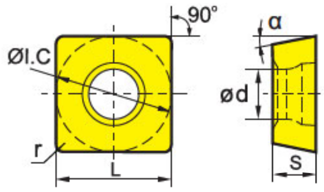


Milling inserts

- ◯ Ideal machining conditions
- ✲ Normal machining conditions
- ✹ Unfavourable machining conditions

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert



		HC¹ (CVD)								HC¹ (PVD)									HT	HC²	HW	
ISO	r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
P		✲	✲	✹	✲	✲	✹		✲			✲	✲	✲	✹	✹		◯	◯	◯		
M			✲	✹	✲	✲	✹					✲	✲	✲	✹	✹		◯	◯	◯		
K								✲	✹		◯						✲	◯				✹
N										✲											✲	✹
S					✹		✹				◯	✲	✲	✲								
H																						
 **SPMT120408-HT-1**	0.8														○							
 **SPMT120408**	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

HC¹	Coated carbide
HT	Uncoated cermet
HC²	Coated cermet
HW	Uncoated carbide

System code B26 · Grade selection B24 · Technical info B463 · Cutting data B224

Notes