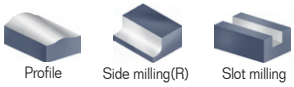
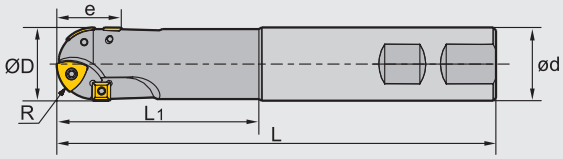
Profile milling tools



BMR01 P M K

Weldon shank



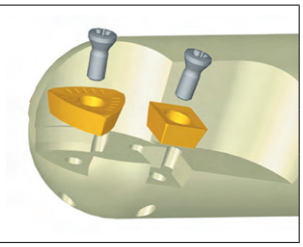
Specification of tools

Type		Stock	Basic dimensions(mm)						Applicable inserts				Weight (kg)
			R	ØD	e	ød	L	L1	Type	Quantity	Type	Quantity	
BMR01	**-020-XP20-S**	▲	10	20	20	20	125	50	ZDET08T2CYR10	2	SPMT060304	2	0.3
	-020-XP20-M	▲	10	20	20	20	150	75	ZDET08T2CYR10	2	SPMT060304	2	0.3
	-020-XP20-L	▲	10	20	20	20	200	100	ZDET08T2CYR10	2	SPMT060304	2	0.4
	-025-XP25-S	▲	12.5	25	23	25	150	70	ZDET1103CYR12.5	2	SPMT060304	2	0.5
	-025-XP25-M	▲	12.5	25	23	25	175	95	ZDET1103CYR12.5	2	SPMT060304	2	0.6
	-025-XP25-L	▲	12.5	25	23	25	200	100	ZDET1103CYR12.5	2	SPMT060304	2	0.7
	-032-XP32-S	▲	16	32	31	32	175	85	ZDET13T3CYR16	2	SDMT090308	2	0.9
	-032-XP32-M	▲	16	32	31	32	200	100	ZDET13T3CYR16	2	SDMT090308	2	1.1
	-032-XP32-L	▲	16	32	31	32	250	150	ZDET13T3CYR16	2	SDMT090308	2	1.4
	-040-XP40-S	▲	20	40	41	40	175	85	ZPNT2204CY(R20)	3	SPMT120408	2	1.4
	-040-XP40-M	▲	20	40	41	40	200	100	ZPNT2204CY(R20)	3	SPMT120408	2	1.7
	-040-XP40-L	▲	20	40	41	40	250	150	ZPNT2204CY(R20)	3	SPMT120408	2	2.1
	-050-XP40-S	▲	25	50	45	40	200	100	ZPNT2204CY(R25)	3	SPMT120408	2	1.8
	-050-XP40-M	▲	25	50	45	40	300	100	ZPNT2204CY(R25)	3	SPMT120408	2	2.8
	-063-XP40-S	▲	31.5	63	52	40	200	100	ZPNT2204CY(R31)	4	SPMT120408	2	3.0
	-063-XP40-M	▲	31.5	63	52	40	300	100	ZPNT2204CY(R31)	4	SPMT120408	2	3.5

▲Stock available △Make-to-order

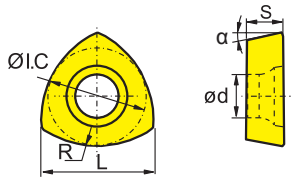
Spare parts

Diameter ØD	Screw	Wrench	
Ø20-Ø25	I43M2.5×5.7	WT07IP	--
Ø32	I43M4×8	--	WT15IS
Ø40-Ø63	I43M5×11	--	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts

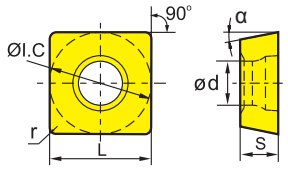


Good working condition · Normal working condition · Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P Steel	😐	😐	😐	😐	☹				😐	😐	😊	☹		😊	😊	😊	☹			
M Stainless steel	😐	😐	😐	😐	☹				😐	😐	😐	☹		😊	😊	😊	☹			
K Cast iron						😐	☹	😊					😐	😊				😊		☹
N Non-ferrous metal																			😐	☹
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐									

Insert shape	Type	Basic dimensions(mm) R	L	ØI.C	S	ød	α	CVD Coating YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	PVD Coating YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	Cermet YNG151	YNG151C	Cemented carbide YC30S	YD051	YD101	YD201
	ZDET08T2CYR10	10	8.4	6.75	2.78	2.8	14°			○									○								
	ZDET1103CYR12.5	12.5	10.6	8.5	3.18	2.8	14°			○									○								
	ZDET13T3CYR16	16	13.2	10.5	3.97	4.4	14°			○									○								
	ZPNT2204CY(R20)	20	16.1	12.7	4.76	5.56	11°			○									○								
	ZPNT2204CY(R25)	25	16.9	12.7	4.76	5.56	11°			○									○								
	ZPNT2204CY(R31)	31.5	17.6	12.7	4.76	5.56	11°			○									○								

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



Good working condition · Normal working condition · Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P Steel	😐	😐	😐	😐	☹				😐	😐	😊	☹		😊	😊	😊	☹			
M Stainless steel	😐	😐	😐	😐	☹				😐	😐	😐	☹		😊	😊	😊	☹			
K Cast iron						😐	☹	😊					😐	😊				😊		☹
N Non-ferrous metal																			😐	☹
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐									

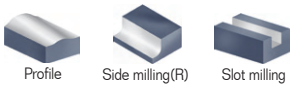
Insert shape	Type	Basic dimensions(mm) r	L	ØI.C	S	ød	α	CVD Coating YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	PVD Coating YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	Cermet YNG151	YNG151C	Cemented carbide YC30S	YD051	YD101	YD201
	SPMT060304	0.4	6.35	6.35	3.18	2.8	11°			○									○								
	SDMT090308	0.8	9.525	9.525	3.18	4.4	15°			○									○								
	SPMT120408	0.8	12.7	12.70	4.76	5.5	11°			●									★								

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

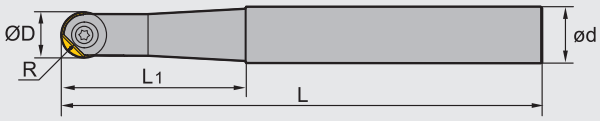
Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters V(m/min)	f(mm/z)
P	Low-carbon steel、Soft steel	≤180	YBM251	180(120-220)	0.25(0.1-0.4)
			YBG302	160(120-220)	0.25(0.1-0.4)
	High-carbon steel、Alloy steel	180-280	YBM251	150(100-200)	0.2(0.1-0.4)
			YBG302	120(100-200)	0.2(0.1-0.4)
	Alloy tool steel	280-350	YBM251	100(80-150)	0.2(0.1-0.3)
			YBG302	100(80-150)	0.2(0.1-0.3)
M	Stainless steel	≤270	YBM251	100(80-150)	0.2(0.1-0.3)
			YBG302	100(80-150)	0.2(0.1-0.3)
K	Cast iron	180-250	YBG302	150(100-180)	0.3(0.2-0.5)

Profile milling tools



BMR02 P M K



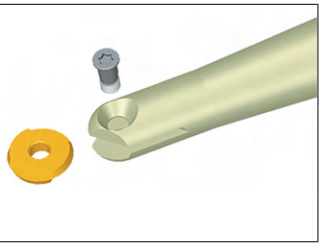
Specification of tools

Type		Stock	Basic dimensions(mm)					Weight (kg)
			R	ØD	ød	L	L_1	
BMR02	**-012-G16-S**	▲	6	12	16	110	40	0.1
	-012-G16-M	▲	6	12	16	130	50	0.2
	-012-G16-L	▲	6	12	16	160	50	0.2
	-016-G20-S	▲	8	16	20	140	45	0.3
	-016-G20-M	▲	8	16	20	170	65	0.3
	-016-G20-L	▲	8	16	20	200	65	0.4
	-020-G25-S	▲	10	20	25	160	60	0.5
	-020-G25-M	▲	10	20	25	200	80	0.6
	-020-G25-L	▲	10	20	25	240	80	0.8

▲Stock available △Make-to-order

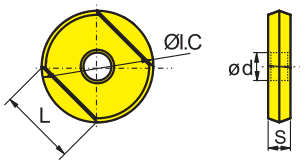
Spare parts

Diameter ØD	Screw	Wrench
Ø12	I70M4×10TT	WT15IS
Ø16	I70M5×12TT	WT20IS
Ø20	I70M5×16TT	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts



Good working condition · Normal working condition · Bad working condition

Workpiece material																							
P	Steel	😐	😐	😐	😐	☹				😐	😐	😊	☹		😊	😊	😊	☹					
M	Stainless steel	😐	😐	😐	😐	☹				😐	😐	😐	☹		😊	😊	😊	☹					
K	Cast iron						😐	☹	😊					😐	😊				😊		☹		
N	Non-ferrous metal																			😐	☹		
S	Heat resistant alloy, Ti alloy								😊	😐	😐	😐											

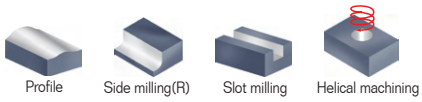
Insert shape	Type	Basic dimensions(mm)				CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	S	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	ROHX1203	12	8.5	3	4														○						
	ROHX1604	16	11.3	4	5														○						
	ROHX2005	20	14.1	5	5														○						

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Recommended cutting parameters

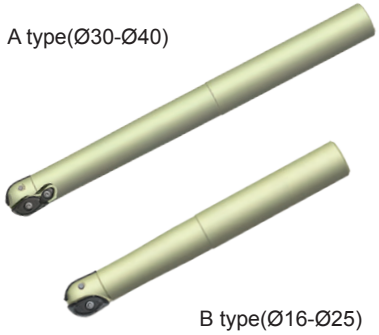
Workpiece material		Hardness HB	Insert grade	Cutting parameters	Diameter Ø12	Diameter Ø16	Diameter Ø20
P	Carbon steel	HB≤180	YBG252	V(m/min)	100~200	100~200	100~200
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
				a_{pmax}(mm)	0.8	1	1.25
				a_{emax}(mm)	0.8	1	1.25
	Alloy steel	HB180~280		V(m/min)	80~180	80~180	80~180
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
				a_{pmax}(mm)	0.8	1	1.25
				a_{emax}(mm)	0.8	1	1.25
	Hardened steel	HRC55~65		V(m/min)	60~100	60~100	60~100
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3
				a_{pmax}(mm)	0.4	0.5	0.6
				a_{emax}(mm)	0.4	0.5	0.6
M	Stainless steel	HB≤270		V(m/min)	70~150	70~150	70~150
				f_z(mm/z)	0.1~0.2	0.1~0.25	0.1~0.25
				a_{pmax}(mm)	0.6	0.8	1
				a_{emax}(mm)	0.6	0.8	1
K	Cast iron	HB180-250		V(m/min)	160~300	160~300	160~300
				f_z(mm/z)	0.2~0.3	0.25~0.35	0.25~0.35
				a_{pmax}(mm)	1	1.5	1.8
				a_{emax}(mm)	1	1.5	1.8

Profile milling tools



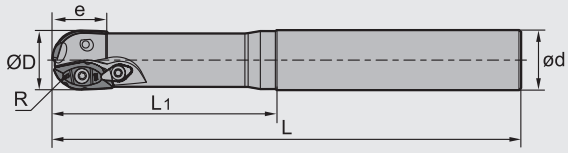
BMR03 P M K

A type(Ø30-Ø40)

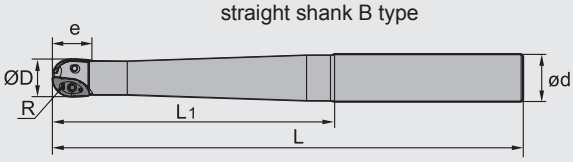


B type(Ø16-Ø25)

straight shank A type



straight shank B type



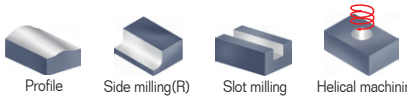
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Weight (kg)	Type	Clamp
			R	ØD	ød	L	L1	e				
BMR03	**-016-G20-S**	▲	8	16	20	150	70	16	2	0.3	B	--
	-016-G20-M	▲	8	16	20	180	80	16	2	0.4	B	
	-020-G25-S	▲	10	20	25	180	80	20	2	0.5	B	
	-020-G25-M	▲	10	20	25	200	100	20	2	0.6	B	
	-020-G25-L	▲	10	20	25	250	150	20	2	0.7	B	
	-020-G25-XL	▲	10	20	25	300	110	20	2	1.0	B	
	-025-G25-S	▲	12.5	25	25	180	80	25	2	0.6	B	
	-025-G25-M	▲	12.5	25	25	200	100	25	2	0.7	B	
	-025-G25-L	▲	12.5	25	25	250	110	25	2	0.8	B	
	-025-G25-XL	▲	12.5	25	25	300	120	25	2	1.0	B	
	-030-G32-S	△	15	30	32	200	120	30	2	1.0	A	WD-208
	-030-G32-M	▲	15	30	32	250	150	30	2	1.3	A	
	-030-G32-L	▲	15	30	32	300	200	30	2	1.6	A	
	-030-G32-XL	△	15	30	32	350	200	30	2	1.9	A	
	-032-G32-S	▲	16	32	32	200	120	32	2	1.1	A	
	-032-G32-M	▲	16	32	32	250	150	32	2	1.4	A	
	-032-G32-L	▲	16	32	32	300	200	32	2	1.6	A	
	-032-G32-XL	△	16	32	32	350	200	32	2	2.0	A	
	-040-G40-S	△	20	40	40	200	120	40	2	1.6	A	CBH5R1
	-040-G40-M	▲	20	40	40	250	150	40	2	2.0	A	
	-040-G40-L	▲	20	40	40	300	200	40	2	2.5	A	
	-040-G40-XL	△	20	40	40	350	200	40	2	3.0	A	

▲Stock available △Make-to-order

Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

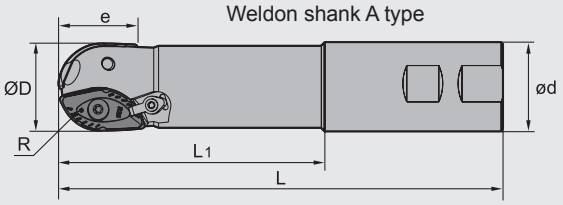
Profile milling tools

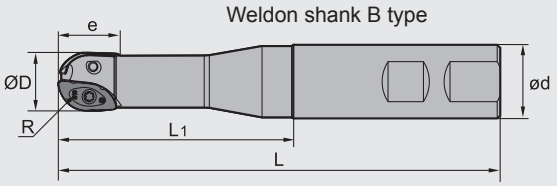


BMR03 P M K

A type(Ø30-Ø50)

B type(Ø16-Ø25)





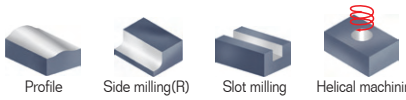
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Weight (kg)	Type	Clamp
			R	ØD	ød	L	L1	e				
BMR03	-016-XP20-M	▲	8	16	20	111	60	16	2	0.2	B	--
	-020-XP25-M	▲	10	20	25	127	70	20	2	0.3	B	
	-020-XP25-L	▲	10	20	25	150	80	20	2	0.4	B	
	-025-XP25-M	▲	12.5	25	25	137	80	25	2	0.4	B	
	-025-XP25-L	▲	12.5	25	25	200	100	25	2	0.6	B	
	-030-XP32-M	▲	15	30	32	161	100	30	2	0.8	A	WD-208
	-030-XP32-L	▲	15	30	32	250	150	30	2	1.3	A	
	-032-XP32-M	▲	16	32	32	161	100	32	2	0.8	A	
	-032-XP32-L	▲	16	32	32	250	120	32	2	1.3	A	
	-040-XP40-M	▲	20	40	40	175	100	40	2	1.3	A	CBH5R1
	-040-XP40-L	▲	20	40	40	250	120	40	2	2.0	A	
	-050-XP50-M	▲	25	50	50	200	100	50	2	2.5	A	
	-050-XP50-L	▲	25	50	50	250	150	50	2	3.1	A	

▲Stock available △Make-to-order

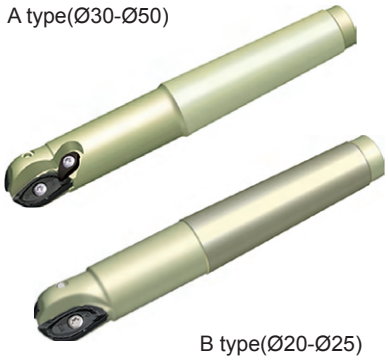
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Profile milling tools



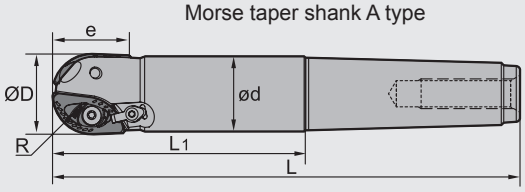
BMR03 P M K

A type(Ø30-Ø50)

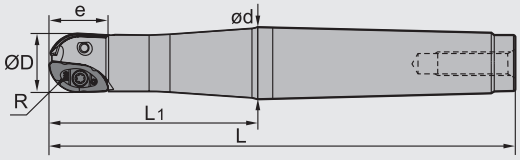


B type(Ø20-Ø25)

Morse taper shank A type



Morse taper shank B type



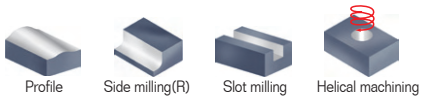
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Weight (kg)	Type	Clamp
			R	ØD	ød	L	L1	e				
BMR03	**-020-MT3-M**	▲	10	20	18.7	156	70	20	2	0.4	B	--
	-020-MT3-L	△	10	20	18.7	186	100	20	2	0.4	B	
	-025-MT3-M	▲	12.5	25	23.5	156	70	25	2	0.4	B	
	-025-MT3-L	△	12.5	25	23.5	186	100	25	2	0.4	B	
	-030-MT4-M	▲	15	30	28.2	189	70	30	2	0.8	A	WD-208
	-030-MT4-L	△	15	30	28.2	229	120	30	2	1.0	A	
	-032-MT4-M	▲	16	32	29.2	179	70	32	2	0.9	A	
	-032-MT4-L	△	16	32	29.2	209	100	32	2	0.9	A	
	-040-MT4-M	▲	20	40	36.9	199	100	40	2	1.0	A	CBH5R1
	-040-MT5-L	▲	20	40	36.9	226	90	40	2	1.8	A	
	-040-MT5-XL	▲	20	40	36.9	256	120	40	2	2.0	A	
	-050-MT5-M	▲	25	50	46.8	236	100	50	2	2.2	A	
	-050-MT5-L	▲	25	50	46.8	286	150	50	2	2.9	A	

▲Stock available △Make-to-order

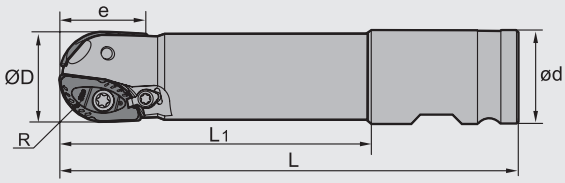
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Profile milling tools



BMR03 P M K

Compound shank



Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth	Weight (kg)	Clamp
			R	ØD	ød	L	L1	e	Z		
BMR03	-040-XPX-M	▲	20	40	50.8	250	170	40	2	1.3	CBH5R1
	-040-XPX-L	▲	20	40	50.8	300	220	40	2	3.1	
	-040-XPX-XL	▲	20	40	50.8	350	270	40	2	3.5	
	-050-XPX-M	▲	25	50	50.8	250	170	50	2	3.1	
	-050-XPX-L	▲	25	50	50.8	300	200	50	2	3.8	
	-050-XPX-XL	▲	25	50	50.8	350	270	50	2	4.4	

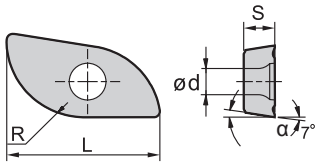
▲Stock available △Make-to-order

Spare parts

Diameter ØD	Clamp	Screw	Wrench	
Φ16	--	I60M2.5×6.5	--	WT07P
Φ20	--	I60M3.5×08TT		WT10IP
Φ25	--	I60M4×10		WT15S
Φ30	WD-208	I60M5×13	WT20IT	--
Φ32	WD-208	I60M5×13		
Φ40	CBH5R1	I43M6×16	WT25IT	
Φ50	CBH5R1	I43M8×21 I43M6×16	WT25IT WT30IT	

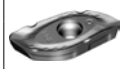
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts

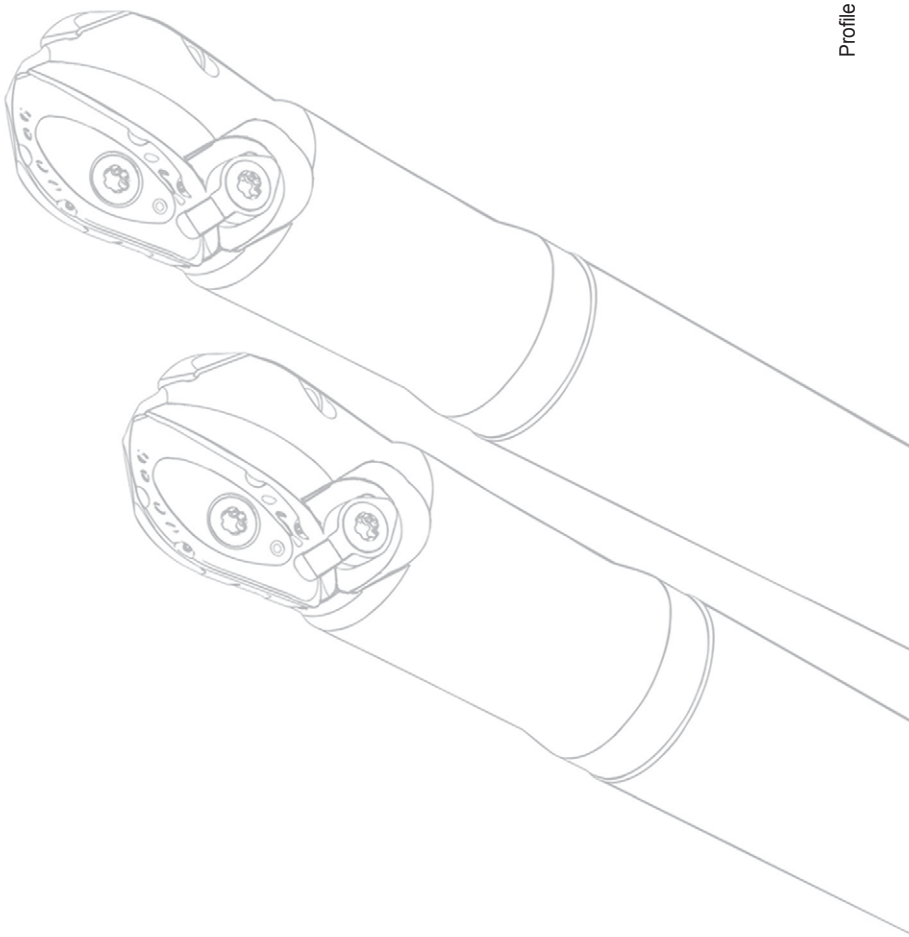


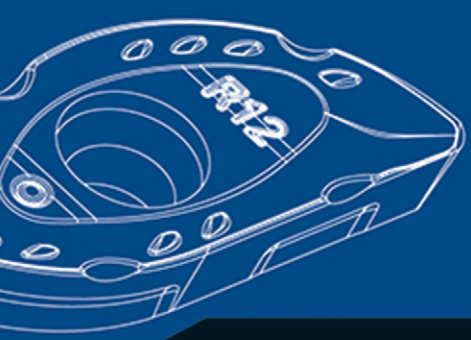
😊 Good working condition 😐 Normal working condition ☹️ Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P Steel	😐	😐	😐	😐	☹️				😐	😐	😊	☹️		😊	😊	😊	☹️			
M Stainless steel	😐	😐	😐	😐	☹️				😐	😐	😐	☹️		😊	😊	😊	☹️			
K Cast iron						😐	☹️	😊					😐	😊				😊		☹️
N Non-ferrous metal																			😐	☹️
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐									

Insert shape	Type	Basic dimensions(mm)						CVD Coating							PVD Coating							Cermet		Cemented carbide			
		R	ød	S	α	L	Applicable tools	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	**XPHT16R0803-GM**	8	3.1	3.18	9°	16	Φ16												★								
	XPHT20R10T3-GM	10	4.0	3.97	9°	20	Φ20												★								
	XPHT25R1204-GM	12.5	4.7	4.76	9°	25	Φ25												★								
	XPHT30R1506-GM	15	5.8	6.35	11°	30	Φ30												★								
	XPHT32R1606-GM	16	5.8	6.35	9°	32	Φ32												★								
	XPHT40R2007-GM	20	6.7	7.94	9°	40	Φ40												★								
	XPHT50R2507-GM	25	9.2	7.94	9°	50	Φ50												★								

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



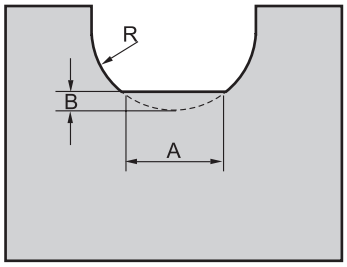


BMR03

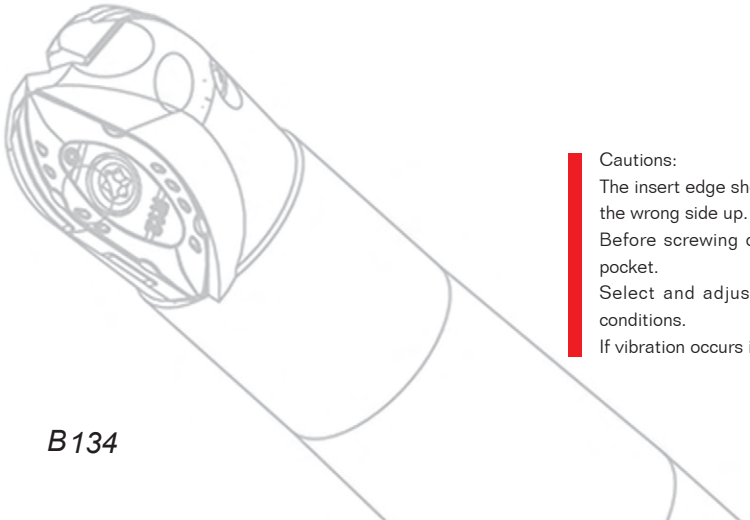
series ball nose end milling tools

- The unique chipbreaker and big rake angle can effectively control the curling and flowing direction of chips and reduce the cutting force, improving workpiece surface quality and tool life.
- After precise grinding of periphery and locating surface, the insert can sufficiently ensure the shape accuracy of cutting edge and the precision of installation and location, improving installation security and workpiece precision after machining.
- The concave structure of the flank can effectively enhance the strength of cutting edge and prevent scraping between the clearance face and workpiece surface. Therefore, it improves the workpiece surface quality and prolongs the life of insert.
- The designs of cutting edge over center and a large negative rake angle make it possible to cut vertically, thus anti-breakage capability is enhanced.
- The rough ball nose milling cutters with large diameter adopt the top and hole clamping style, so insert clamping becomes more firm and stable. The machining is also highly efficient even under poor conditions such as long overhang and large vibration, etc.
- The adapter types include straight shank, Weldon shank, Morse taper shank and combination shank.

Slot shape after machining

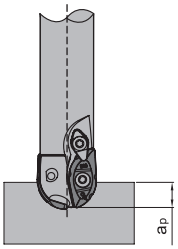
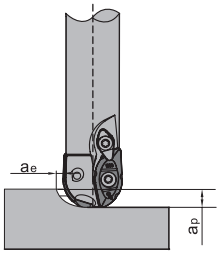
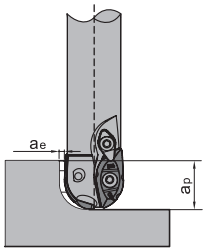


R	A	B
08	1.7	0.09
10	2.2	0.12
12.5	3.0	0.18
15	3.9	0.20
16	3.5	0.22
20	3.6	0.24
25	3.8	0.26



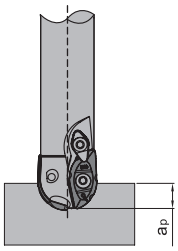
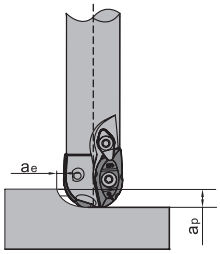
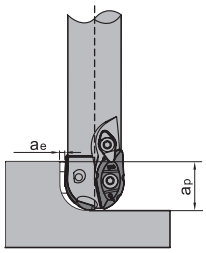
Cautions:
The insert edge should correspond to the locating face of insert pocket in the tool. Don't install the wrong side up.
Before screwing down the insert, confirm the good connection between insert and insert pocket.
Select and adjust the cutting parameters according to machine power and machining conditions.
If vibration occurs in the machining process, cutting speed should be reduced properly.

Recommended cutting parameters Diameter Ø16

Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	4	4	8	16	
	a_e(mm)	--	3	4	1.5	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	4	4	8	16	
	a_e(mm)	--	3	4	1.5	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	4	4	8	16	
	a_e(mm)	--	3	4	1.5	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	4	4	8	--	
	a_e(mm)	--	2	3	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	4	4	8	16	
	a_e(mm)	--	3	4	1.5	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	4	4	8	16	
	a_e(mm)	--	3	4	1.5	

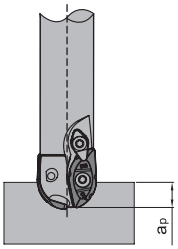
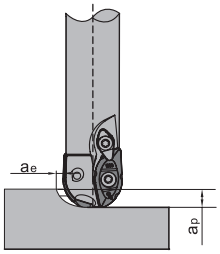
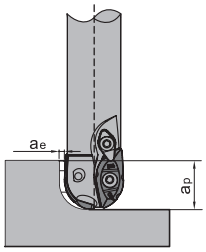
Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Recommended cutting parameters Diameter Ø20

Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	5	5	10	20	
	a_e(mm)	--	4	5	2	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	5	5	10	20	
	a_e(mm)	--	4	5	2	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	5	5	10	20	
	a_e(mm)	--	4	5	2	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	5	5	10	--	
	a_e(mm)	--	4	5	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	5	5	10	20	
	a_e(mm)	--	4	5	2	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	5	5	10	20	
	a_e(mm)	--	4	5	2	

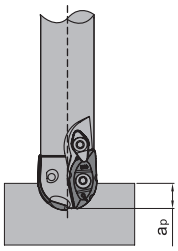
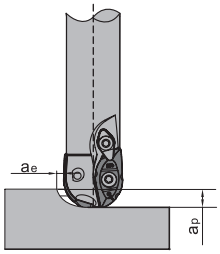
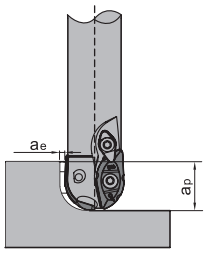
Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Recommended cutting parameters Diameter Ø25

Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	6	6	12.5	25	
	a_e(mm)	--	5	6.5	3	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	6	6	12.5	25	
	a_e(mm)	--	5	6.5	3	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	6	6	12.5	25	
	a_e(mm)	--	5	6.5	3	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	6	6	12.5	--	
	a_e(mm)	--	5	6.5	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	6	6	12.5	25	
	a_e(mm)	--	5	6.5	3	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	6	6	12.5	25	
	a_e(mm)	--	5	6.5	3	

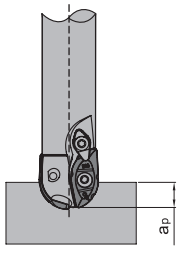
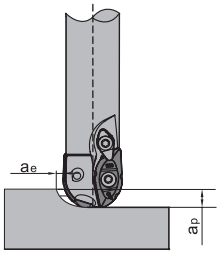
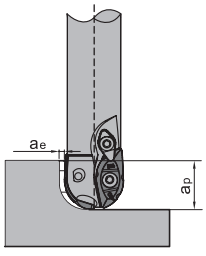
Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Recommended cutting parameters Diameter Ø30, Ø32

Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	10	10	16	28	
	a_e(mm)	--	6	9	6	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	10	10	16	28	
	a_e(mm)	--	6	9	6	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	10	10	16	28	
	a_e(mm)	--	6	9	6	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	10	10	16	--	
	a_e(mm)	--	6	9	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	10	10	16	28	
	a_e(mm)	--	6	9	6	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	10	10	16	28	
	a_e(mm)	--	6	9	6	

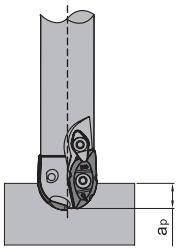
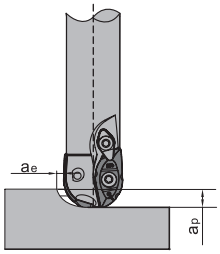
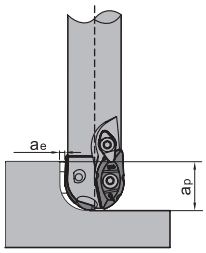
Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Recommended cutting parameters Diameter Ø40

Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	12	10	20	35	
	a_e(mm)	--	8	12	8	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	12	10	20	35	
	a_e(mm)	--	8	12	8	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	12	10	20	35	
	a_e(mm)	--	8	12	8	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	12	10	20	--	
	a_e(mm)	--	8	12	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	12	10	20	35	
	a_e(mm)	--	8	12	8	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	12	10	20	35	
	a_e(mm)	--	8	12	8	

Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Recommended cutting parameters Diameter Ø50

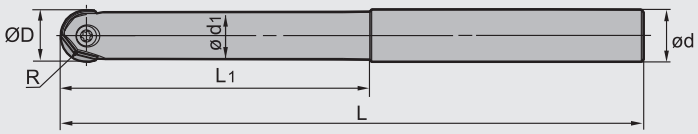
Operations						
Workpiece material	Cutting parameters	Machining of slot	Side milling (slight)		Side milling (deep)	Insert grade
Medium carbon steel Hardness 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	15	10	25	40	
	a_e(mm)	--	10	15	10	
Alloy steel Hardness 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	F_z(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a_p(mm)	15	10	25	40	
	a_e(mm)	--	10	15	10	
Die steel Hardness 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	F_z(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a_p(mm)	15	10	25	40	
	a_e(mm)	--	10	15	10	
Hardened steel Hardness 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a_p(mm)	15	10	25	--	
	a_e(mm)	--	10	15	--	
Gray cast iron Hardness 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	15	10	25	40	
	a_e(mm)	--	10	15	10	
Nodular cast iron Hardness 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	F_z(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a_p(mm)	15	10	25	40	
	a_e(mm)	--	10	15	10	

Note: 1. Parameters in the table shall be adjusted according to the rigidity of the machine or workpiece.
2. Wind cooling to be preferred.

Profile milling tools

BMR04 P M K

Straight shank with straight neck



Specification of tools

Type		Stock	Basic dimensions(mm)						Weight (kg)
			R	ØD	ød	ød1	L1	L	
BMR04	**-012-G12-M**	▲	6	12	12	11	35	125	0.1
	-012-G12-L	△	6	12	12	11	45	150	0.1
	-016-G16-M	▲	8	16	16	14	40	150	0.2
	-016-G16-L	△	8	16	16	14	55	180	0.3
	-020-G20-M	▲	10	20	20	18	65	180	0.4
	-020-G20-L	△	10	20	20	18	100	250	0.6
	-025-G25-M	▲	12.5	25	25	23	70	200	0.7
	-025-G25-L	△	12.5	25	25	23	100	250	0.9
	-030-G32-M	▲	15	30	32	27	130	250	1.2
	-030-G32-L	△	15	30	32	27	150	300	1.5
	-032-G32-M	▲	16	32	32	29	80	250	1.4
	-032-G32-L	△	16	32	32	29	109	300	1.7

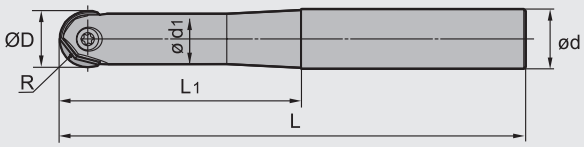
▲Stock available △Make-to-order

Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Profile milling tools

BMR04 P M K

Straight shank with taper neck



Specification of tools

Type		Stock	Basic dimensions(mm)						Weight (kg)
			R	ØD	ød	ød1	L1	L	
BMR04	**-012-G16-M**	▲	6	12	16	11	50	125	0.2
	-012-G16-L	△	6	12	16	11	60	150	0.2
	-016-G20-M	▲	8	16	20	14	60	150	0.3
	-016-G20-L	△	8	16	20	14	80	180	0.3
	-020-G25-M	▲	10	20	25	18	75	180	0.6
	-020-G25-L	△	10	20	25	18	85	200	0.6
	-025-G32-M	▲	12.5	25	32	23	90	200	1.0
	-025-G32-L	△	12.5	25	32	23	110	250	1.3
	-030-G40-M	▲	15	30	40	27	110	250	2.0
	-030-G40-L	△	15	30	40	27	125	300	2.4
	-032-G40-M	▲	16	32	40	29	110	250	2.0
	-032-G40-L	△	16	32	40	29	125	300	2.4

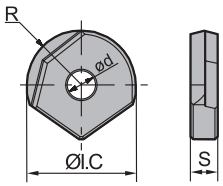
▲Stock available △Make-to-order

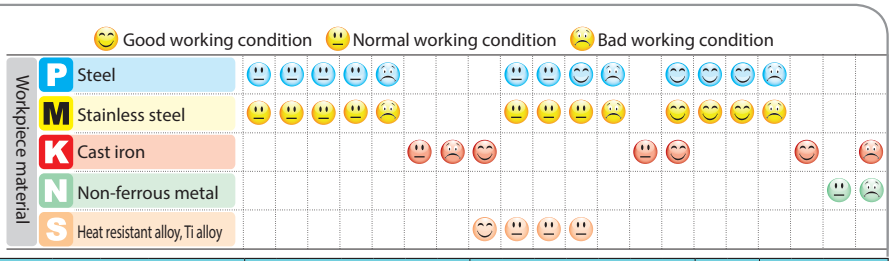
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

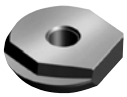
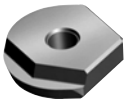
Spare parts

Diameter	Screw	Wrench	
Ø12	I70M4×10TT	WT15IP	--
Ø16	I70M5×12TT	WT20IP	--
Ø20	I70M5×16TT	WT20IP	--
Ø25	I70M6×20TT	WT20IP	--
Ø30	I70M8×25TT	--	WT30IT
Ø32	I70M8×25TT	--	WT30IT

Selection of inserts



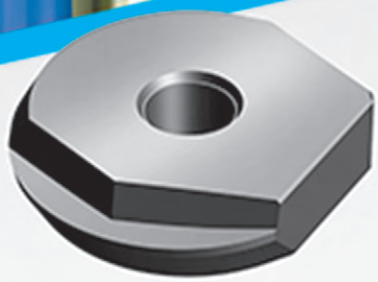


Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		R	ØI.C	S	ød	Applicable insert ØD	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	ZOHX1203-GF	6	12	3	4	Φ12														★						
	ZOHX1604-GF	8	16	4	5	Φ16														★						
	ZOHX2005-GF	10	20	5	5	Φ20														★						
	ZOHX2506-GF	12.5	25	6	6	Φ25														○						
	ZOHX3007-GF	15	30	7	8	Φ30														○						
	ZOHX3207-GF	16	32	7	8	Φ32														○						
	ZOHX1203-GM	6	12	3	4	Φ12														★						
	ZOHX1604-GM	8	16	4	5	Φ16														★						
	ZOHX2005-GM	10	20	5	5	Φ20														★						
	ZOHX2506-GM	12.5	25	6	6	Φ25														★						
	ZOHX3007-GM	15	30	7	8	Φ30														★						
	ZOHX3207-GM	16	32	7	8	Φ32														★						

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

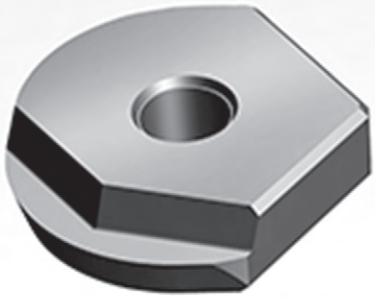
BMR04

Series ball nose finishing end milling tools



-GF

- With positive rake angle and double clearance angle, the design of curved cutting edge combines sharpness and strength. The edge with high precision is applicable under stable machining conditions and in conditions requiring high workpiece profile precision.



-GM

- 0° rake angle, only one clearance angle, high edge strength, suitable for conditions requiring high cutting efficiency.

The inserts are a combination of ultra-fine cemented carbide substrate and nano coating grade YBG252. With excellent cutting performance, they are suitable for semi-finish till finish machining.

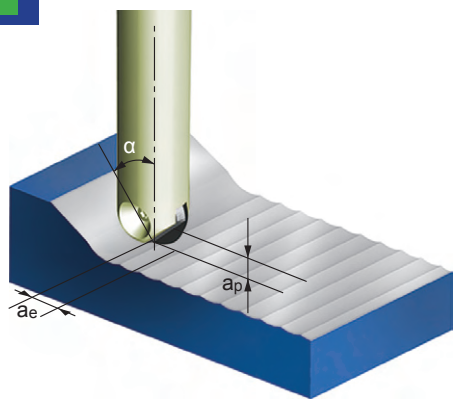
Calculation of cutting speed for BMR02/04 series ball nose end mills

1.When the tool axial line is vertical to the surface being machined,

$$N = \frac{1000Vc}{\pi Dc}(r/min)$$

$$Dc = 2\sqrt{a_p(D-a_p)}$$

N：rotating speed
Vc：actual cutting speed
Dc：effective cutting diameter
D：tool nominal diameter
a_p：axial cutting depth



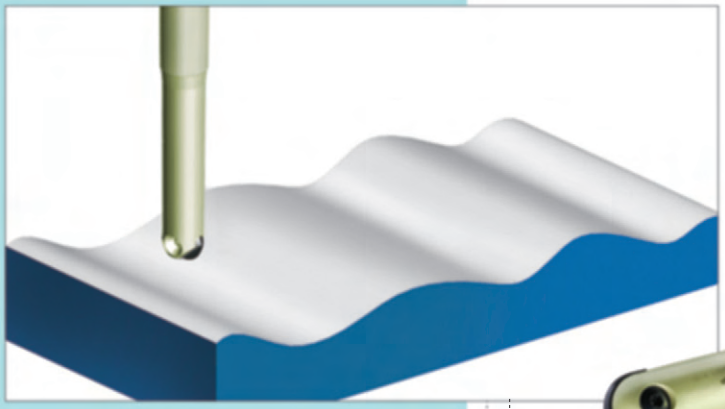
2.When there is an inclined angle between the tool axial line and the surface being machined, the recommended cutting speed should be multiplied by a factor in the table below to obtain the cutting speed used for programming.

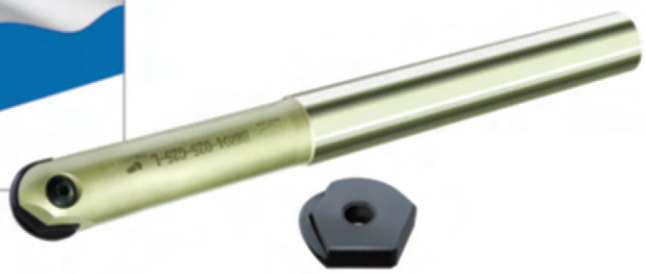
Diameter(mm)		Ø12		Ø16		Ø20		Ø25		Ø30		Ø32	
Cutting depth a_p(mm)		0.2	0.5	0.2	0.5	0.5	1	0.5	1	0.5	1.5	0.5	1.5
Inclined angle α	15°	1.00	1.00	1.00	1.00	1.00	1.02	1.00	1.01	1.00	1.00	1.00	1.00
	30°	1.04	1.01	1.05	1.01	1.02	1.04	1.03	1.04	1.04	1.01	1.04	1.00
	45°	1.16	1.07	1.18	1.10	1.12	1.06	1.14	1.08	1.16	1.06	1.16	1.06
	60°	1.42	1.24	1.47	1.30	1.34	1.21	1.38	1.25	1.42	1.21	1.43	1.22
	75°	2.02	1.60	2.14	1.73	1.83	1.53	1.93	1.62	2.01	1.53	2.04	1.55
	90°	3.92	2.50	4.48	2.87	3.20	2.29	3.57	2.55	3.9	2.29	4.03	2.37

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters	Tool specification					
					Ø12	Ø16	Ø20	Ø25	Ø30	Ø32
P	Carbon steel	HB≤180	YBG252	V(m/min)	100~200	100~200	100~200	100~200	100~200	100~200
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3	0.25~0.35	0.25~0.35	0.25~0.35
				$a_p$max(mm)	0.8	1	1.25	1.5	2	2
				$a_e$max(mm)	0.8	1	1.25	1.5	2	2
	Alloy stee	HB180~280		V(m/min)	80~180	80~180	80~180	80~180	80~180	80~180
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3	0.25~0.35	0.25~0.35	0.25~0.35
				$a_p$max(mm)	0.8	1	1.25	1.5	2	2
				$a_e$max(mm)	0.8	1	1.25	1.5	2	2
	Hardened steel	HRC55~65		V(m/min)	60~100	60~100	60~100	60~100	60~100	60~100
				f_z(mm/z)	0.15~0.25	0.2~0.3	0.2~0.3	0.25~0.35	0.25~0.35	0.25~0.35
				$a_p$max(mm)	0.4	0.5	0.6	0.8	1	1
				$a_e$max(mm)	0.4	0.5	0.6	0.8	1	1
M	Stainless steel	HB≤270		V(m/min)	70~150	70~150	70~150	70~150	70~150	70~150
				f_z(mm/z)	0.1~0.2	0.1~0.25	0.1~0.25	0.2~0.3	0.2~0.3	0.2~0.3
				$a_p$max(mm)	0.6	0.8	1	1.25	1.5	1.5
				$a_e$max(mm)	0.6	0.8	1	1.25	1.5	1.5
K	Cast iron	HB180-250		V(m/min)	160~300	160~300	160~300	160~300	160~300	160~300
				f_z(mm/z)	0.2~0.3	0.25~0.35	0.25~0.35	0.3~0.4	0.3~0.4	0.3~0.4
				$a_p$max(mm)	1	1.5	1.8	2	2.5	2.5
				$a_e$max(mm)	1	1.5	1.8	2	2.5	2.5

Case for BMR04



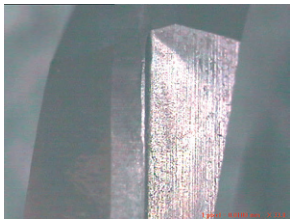
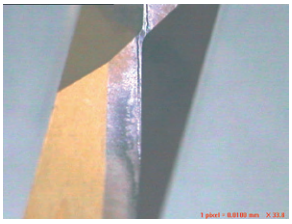
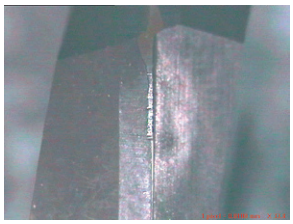
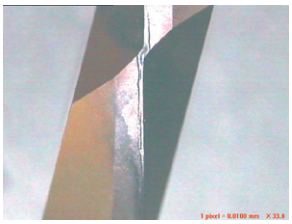


Workpiece material：42CrMo (HRC35)
Cooling system: Dry cutting
Machine: Vertical machining center
Cutting parameters：
Vc=150m/min
a_p=0.1mm
f_z=0.2mm/Z

Tool type：BMR04-020-G25-M

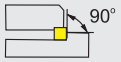
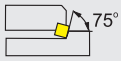
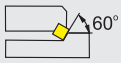
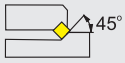
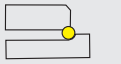
Insert type/grade：ZOHX2005-GM/YBG252

●Abrasion comparison of inserts after milling curved face

	ZCC-CT	Other company product
After 60 minutes of cutting	 Abrasion on the clearance face 0.08	 Abrasion on the clearance face 0.10
After 120 minutes of cutting	 Abrasion on the clearance face 0.12	 Abrasion on the clearance face 0.16

Side and face milling tools code key

Cutter style	
FM	Face milling
EM	Square shoulder milling
HM	Helical end milling
SM	Side and face milling
BM	Profile milling
CM	Chamfer milling
XM	Special milling
TM	T-slot milling
AM	Aluminum alloy high speed milling

Approach angle		
P	90°	
E	75°	
D	60°	
A	45°	
R		

Sequence number of series

Cutting diameter ØD (mm)

Cutting width of milling tools

Coupling structure and demension			
A	A type of coupling	D	D type of coupling
B	B type of coupling	K	Mounting by keyway
C	C type of coupling		

SM P 03 - 160 × 16 - K40 - M P 12 - 12 L

Insert shape	
C	Diamond with 80°
D	Diamond with 55°
R	Round
S	Square
T	Regular triangle
V	Diamond with 35°
M	Diamond with 86°

Insert clearance angle	
N	0°
B	5°
C	7°
P	11°
D	15°
E	20°

Diameter of IC	Insert shape					
	C	D	R	S	T	V
5.556	—	—	—	—	09	—
6.350	06	07	—	—	11	—
9.525	09	11	09	09	16	16
12.700	12	15	12	12	22	22
15.875	16	19	15	15	27	—
19.050	19	—	19	19	33	—
25.400	25	—	25	25	44	—

Cutting direction

(R: Right L: Left)

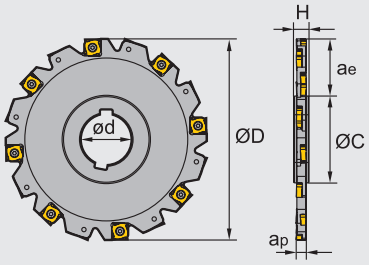
Number of teeth

Side and face milling tools

Machining of slot

SMP01 P M K

K-type coupling



Specification of tools

Type		Stock	Basic dimensions(mm)						Applicable inserts	Number of teeth Z	Type of coupling	Weight (kg)
			ØD	ød	øc	H	a_p	a_{emax}				
SMP01 Mounting by keyway	**-100×4-K27-SN12-10**	△	100	27	45	12	4	25	XSEQ1202	10	K	0.2
	-125×4-K40-SN12-12	△	125	40	56	12	4	32		12	K	0.3
	-160×4-K40-SN12-16	△	160	40	67	12	4	44		16	K	0.5
	-100×5-K27-SN12-10	△	100	27	45	12	5	25	XSEQ1203	10	K	0.2
	-125×5-K40-SN12-12	△	125	40	56	12	5	32		12	K	0.3
	-160×5-K40-SN12-16	△	160	40	67	12	5	44		16	K	0.6
	-100×6-K27-SN12-10	△	100	27	45	12	6	25	XSEQ12T3	10	K	0.3
	-125×6-K40-SN12-12	△	125	40	56	12	6	32		12	K	0.4
	-160×6-K40-SN12-16	△	160	40	67	12	6	44		16	K	0.7
	-200×6-K50-SN12-18	△	200	50	71	12	6	62		18	K	1.1
	-250×6-K50-SN12-24	△	250	50	71	12	6	87		24	K	1.7
	-100×7-K27-SN12-10	△	100	27	45	12	7	25	XSEQ1204	10	K	0.3
	-125×7-K40-SN12-12	△	125	40	56	12	7	32		12	K	0.4
	-160×7-K40-SN12-16	△	160	40	67	12	7	44		16	K	0.8
	-200×7-K50-SN12-18	△	200	50	71	12	7	62		18	K	1.2
	-250×7-K50-SN12-24	△	250	50	71	12	7	87		24	K	1.9
	-100×8-K27-SN12-10	△	100	27	45	12	8	25	XSEQ12T4	10	K	0.3
	-125×8-K40-SN12-12	△	125	40	56	12	8	32		12	K	0.5
	-160×8-K40-SN12-16	△	160	40	67	12	8	44		16	K	0.9
	-200×8-K50-SN12-18	△	200	50	71	12	8	62		18	K	1.4
	-250×8-K50-SN12-24	△	250	50	71	12	8	87		24	K	2.2

▲Stock available △Make-to-order

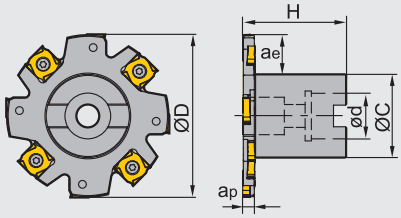
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Side and face milling tools

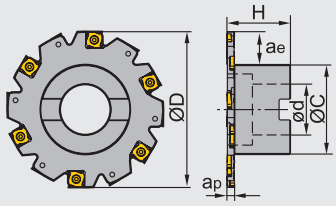
Machining of slot

SMP01 P M K

A-type coupling



B-type coupling



Specification of tools

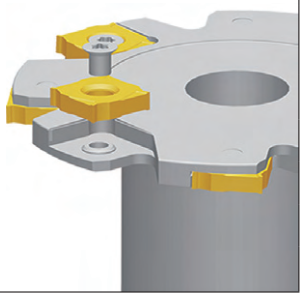
Type		Stock		Basic dimensions(mm)						Applicable inserts	Number of teeth Z	Type of coupling	Weight (kg)
		R	L	ØD	ød	øc	H	a_p	$a_{e max}$				
SMP01 Arbor mounting	**-063×4-A22-SN12-06**	△	△	63	22	32	40	4	14	XSEQ1202	6	A	0.2
	-080×4-A22-SN12-08	△	△	80	22	40	50	4	18		8	A	0.4
	-100×4-A27-SN12-10	△	△	100	27	48	50	4	23		10	A	0.6
	-063×5-A22-SN12-06	△	△	63	22	32	40	5	14	XSEQ1203	6	A	0.2
	-080×5-A22-SN12-08	△	△	80	22	40	50	5	18		8	A	0.4
	-100×5-A27-SN12-10	△	△	100	27	48	50	5	23		10	A	0.7
	-063×6-A22-SN12-06	△	△	63	22	32	40	6	14	XSEQ12T3	6	A	0.2
	-080×6-A22-SN12-08	△	△	80	22	40	50	6	18		8	A	0.5
	-100×6-A27-SN12-10	△	△	100	27	48	50	6	23		10	A	0.7
	-125×6-B32-SN12-12	△	△	125	32	70	50	6	30		12	B	1.0
	-160×6-B40-SN12-16	△	△	160	40	70	50	6	41		16	B	1.3
	-063×7-A22-SN12-06	△	△	63	22	32	40	7	14	XSEQ1204	6	A	0.2
	-080×7-A22-SN12-08	△	△	80	22	40	50	7	18		8	A	0.5
	-100×7-A27-SN12-10	△	△	100	27	48	50	7	23		10	A	0.7
	-125×7-B32-SN12-12	△	△	125	32	70	50	7	30		12	B	1.1
	-160×7-B40-SN12-16	△	△	160	40	70	50	7	41		16	B	1.4
	-063×8-A22-SN12-06	△	△	63	22	32	40	8	14	XSEQ12T4	6	A	0.2
	-080×8-A22-SN12-08	△	△	80	22	40	50	8	18		8	A	0.5
	-100×8-A27-SN12-10	△	△	100	27	48	50	8	23		10	A	0.8
	-125×8-B32-SN12-12	△	△	125	32	70	50	8	30		12	B	1.1
	-160×8-B40-SN12-16	△	△	160	40	70	50	8	41		16	B	1.5

▲Stock available △Make-to-order

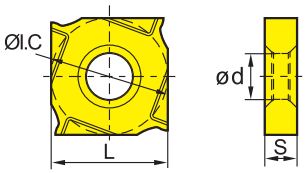
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Spare parts

Diameter ØD	Edge width a_p	Screw	Wrench
Ø63-Ø160	4	I91M4×3.2X	WT09S
Ø63-Ø160	5	I91M4×4.2X	
Ø63-Ø250	6	I91M4×5.1X	
Ø63-Ø250	7	I91M4×6.1X	
Ø63-Ø250	8	I91M4×7.1X	



Selection of inserts



Good working condition · Normal working condition · Bad working condition

Workpiece material																							
P Steel	😐	😐	😐	😐	☹				😐	😐	😊	☹		😊	😊	😊	☹						
M Stainless steel	😐	😐	😐	😐	☹				😐	😐	😐	☹		😊	😊	😊	☹						
K Cast iron						😐	☹	😊					😐	😊					😊		☹		
N Non-ferrous metal																				😐	☹		
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐												

Insert shape	Type	Basic dimensions(mm)				CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	S	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	XSEQ1202	12.7	12.7	2.3	5.0												★								
	XSEQ1203	12.7	12.7	3.0	5.0												★								
	XSEQ12T3	12.7	12.7	3.5	5.0												★								
	XSEQ1204	12.7	12.7	4.0	5.0												★								
	XSEQ12T4	12.7	12.7	4.5	5.0												★								

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Recommended cutting parameters

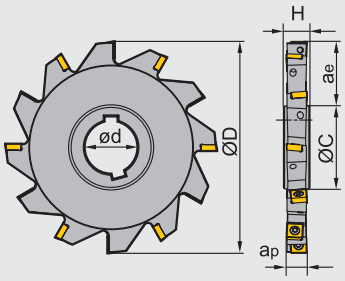
Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				V(m/min)	f(mm/z)
P	Low-carbon steel、Soft steel	≤180	YBG302	150 (100-200)	0.15(0.1-0.3)
P	High-carbon steel、Alloy steel	180-280	YBG302	120 (80-200)	0.15(0.1-0.3)
P	Alloy tool steel	280-350	YBG302	100 (80-200)	0.15(0.1-0.3)
M	Stainless steel	≤270	YBG302	100 (80-200)	0.08(0.05-0.15)
K	Cast iron	180-250	YBG302	150 (100-250)	0.08(0.05-0.15)

Side and face milling tools

Machining of slot

SMP03 P M K

K-type coupling



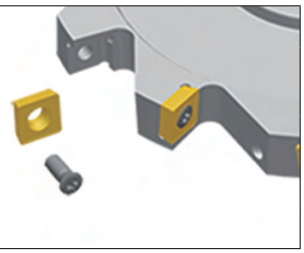
Specification of tools

Type		Stock	Basic dimensions(mm)						Applicable inserts	Number of teeth Z	Type of coupling	Weight (kg)
			ØD	øc	ød	a_{emax}	a_p	H				
SMP03 Mounting by keyway	**-080×8-K27-MP06-10**	△	80	43	27	17	8	12	MPHT060304-DM	10	K	0.2
	-100×8-K32-MP06-14	△	100	47	32	25	8	12		14	K	0.3
	-100×10-K32-MP06-14	△	100	47	32	25	10	14		14	K	0.4
	-125×10-K40-MP06-16	△	125	55	40	34	10	14		16	K	0.6
	-125×12-K40-MP08-12	△	125	55	40	34	12	16	MPHT080305-DM	12	K	0.7
	-160×12-K40-MP08-14	△	160	62	40	47	12	16		14	K	1.3
	-160×16-K40-MP12-12	△	160	62	40	49	16	20	MPHT120408-DM	12	K	1.6
	-160×18-K40-MP12-12	△	160	62	40	49	18	24		12	K	1.9
	-160×20-K40-MP12-12	△	160	62	40	49	20	26		12	K	2.1
	-200×16-K50-MP12-14	△	200	72	50	62	16	20		14	K	2.5
	-200×18-K50-MP12-14	△	200	72	50	62	18	24		14	K	2.9
	-200×20-K50-MP12-14	△	200	72	50	62	20	26		14	K	3.3

▲Stock available △Make-to-order

Spare parts

Diameter Ød	Inserts	Screw	Wrench	
Ø80-Ø125	MP06	I60M2.5x6.5	WT07IP	--
Ø125-Ø160	MP08	I60M3x7	WT09IP	--
Ø160-Ø200	MP12	I60M5x13	--	WT20IS



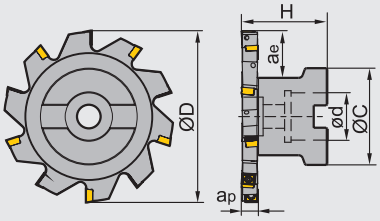
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Side and face milling tools

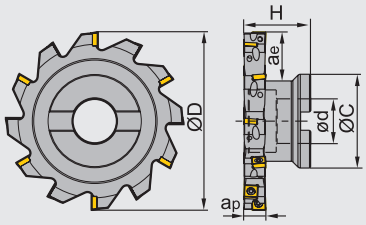
Machining of slot

SMP03 P M K

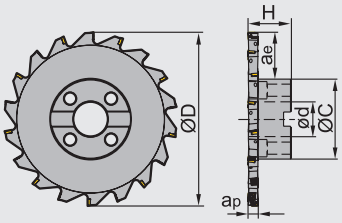
A-type coupling



B-type coupling



C-type coupling

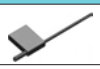


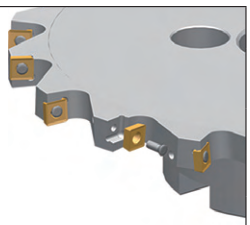
Specification of tools

Type		Stock R	Stock L	Basic dimensions(mm) ØD	øc	ød	aemax	ap	H	Applicable inserts	Number of teeth Z	Type of coupling	Weight (kg)
SMP03 Arbor mounting	**-080×8-A22-MP06-10**	△	△	80	45	22	21	8	40	MPHT060304-DM	10	A	0.4
	-100×8-B27-MP06-14	△	△	100	55	27	24	8	40		14	B	0.6
	-100×10-B27-MP06-14	△	△	100	55	27	24	10	40		14	B	0.7
	-125×10-B32-MP06-16	△	△	125	65	32	33	10	45		16	B	1.1
	-125×12-B32-MP08-12	△	△	125	65	32	33	12	45	MPHT080305-DM	12	B	1.4
	-160×12-B40-MP08-14	△	△	160	80	40	45	12	50		14	B	1.9
	-200×12-C40-MP08-18	△	△	200	92	40	53	12	50		18	C	3.2
	-125×16-B32-MP12-10	△	△	125	65	32	33	16	50	MPHT120408-DM	10	B	2.3
	-160×16-B40-MP12-12	△	△	160	80	40	45	16	60		12	B	2.3
	-160×18-B40-MP12-12	△	△	160	80	40	45	18	60		12	B	2.4
	-200×16-C40-MP12-14	△	△	200	92	40	53	16	50		14	C	3.6
	-200×18-C40-MP12-14	△	△	200	92	40	53	18	50		14	C	3.9
	-200×20-C40-MP12-14	△	△	200	92	40	53	20	50		14	C	4.2

▲Stock available △Make-to-order

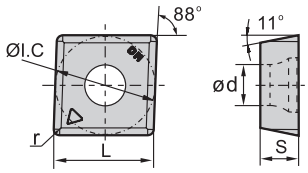
Spare parts

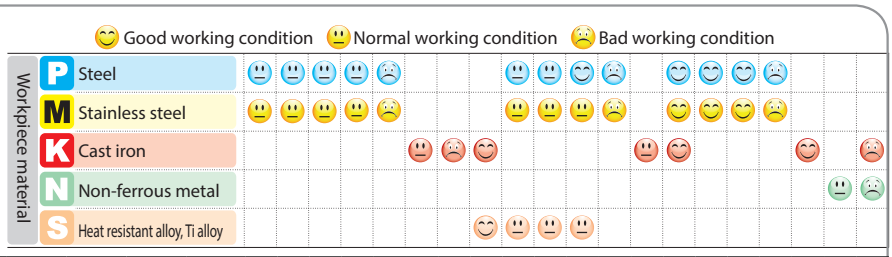
Diameter ØD	Inserts	Screw	Wrench	
				
Ø80-Ø125	MP06	I60M2.5×6.5	WT07IP	--
Ø125-Ø200	MP08	I60M3×7	WT09IP	--
Ø125-Ø200	MP12	I60M5×13	--	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts



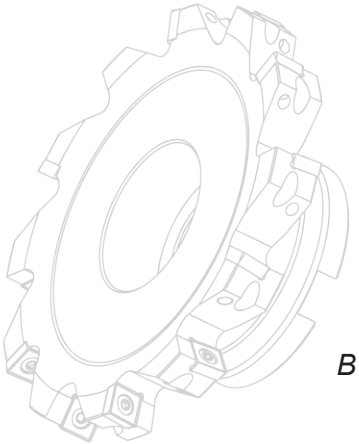


Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	S	ød	r	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	MPHT060304-DM	6.35	6.35	3.18	2.8	0.4												★								
	MPHT080305-DM	8.3	8.3	3.18	3.4	0.5												★								
	MPHT120408-DM	12.7	12.7	4.76	5.56	0.8												★								

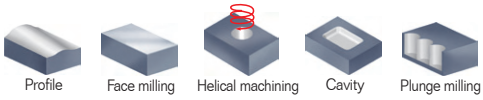
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				V(m/min)	f(mm/z)
P	Low-carbon steel、Soft steel	≤180	YBG302	150 (100-200)	0.15(0.1-0.3)
P	High-carbon steel、Alloy steel	180-280	YBG302	120 (80-200)	0.15(0.1-0.3)
P	Alloy tool steel	280-350	YBG302	100 (80-200)	0.15(0.1-0.3)
M	Stainless steel	≤270	YBG302	100 (80-200)	0.08(0.05-0.15)
K	Cast iron	180-250	YBG302	150 (100-250)	0.08(0.05-0.15)

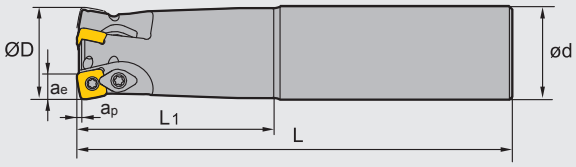


High feed milling cutters



XMR01 P M K

S-type insert, straight shank



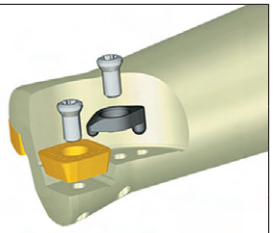
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Weight (kg)
			ØD	a_p	a_e	L_1	L	ød		
XMR01	**-020-G20-SD06-02**	▲	20	0.8	5.8	50	130	20	2	0.26
	-025-G25-SD06-03	▲	25	0.8	5.8	60	140	25	3	0.46
	-025-G25-SD09-02	▲	25	1.4	8.8	60	140	25	2	0.5
	-032-G32-SD09-03	▲	32	1.4	8.8	70	150	32	3	0.8
	-035-G32-SD09-03	▲	35	1.4	8.8	70	150	32	3	0.8
	-032-G32-SD12-02	▲	32	1.8	11.7	70	150	32	2	0.8
	-040-G40-SD12-03	▲	40	1.8	11.7	70	150	40	3	1.3
	-040-G40-SD15-02	▲	40	2.2	14	70	200	40	2	1.6

▲Stock available △Make-to-order

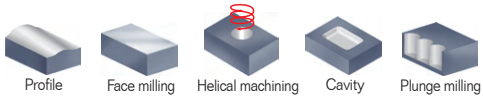
Spare parts

Tool type	Screw	Clamp Screw	Clamp	Wrench	
XMR01□□-SD06□□	I60M2.2×5.5	--	--	WT07IP	--
XMR01□□-SD09□□	I60M3.5×08TT	I60M4×8.4	WD-204	WT10IP	WT15IP
XMR01□□-SD12□□	I60M4×8.4			WT15IP	
XMR01□□-SD15□□	I60M5×13		WD-208	WT20IP	--

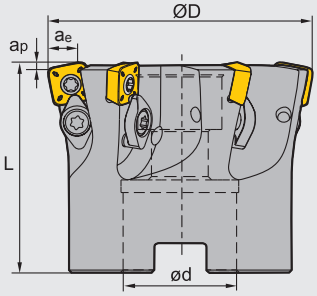


Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

High feed milling cutters



XMR01 P M K



Specification of tools

Type		Stock	Basic dimensions(mm)					Number of teeth Z	Type of coupling	Weight (kg)
			ØD	ap	ae	L	ød			
XMR01	**-050-A22-SD06-07**	▲	50	0.8	5.8	40	22	7	A	0.36
	-063-A22-SD06-10	▲	63	0.8	5.8	40	22	10	A	0.53
	-063-A27-SD06-10	▲	63	0.8	5.8	50	27	10	A	0.57
	-050-A22-SD09-04	▲	50	1.4	8.8	40	22	4	A	0.3
	-063-A22-SD09-06	▲	63	1.4	8.8	40	22	6	A	0.5
	-063-A27-SD09-06	▲	63	1.4	8.8	50	27	6	A	0.6
	-063-A22-SD12-05	▲	63	1.8	11.7	40	22	5	A	0.5
	-063-A27-SD12-05	▲	63	1.8	11.7	50	27	5	A	0.6
	-080-A27-SD12-05	▲	80	1.8	11.7	50	27	5	A	0.9
	-100-B32-SD12-06	▲	100	1.8	11.7	50	32	6	B	1.8
	-080-A27-SD15-05	▲	80	2.2	14	50	27	5	A	0.78
	-080-A32-SD15-05	▲	80	2.2	14	50	32	5	A	0.72
	-100-B32-SD15-07	▲	100	2.2	14	50	32	7	B	1.2
	-125-B40-SD15-09	▲	125	2.2	14	63	40	9	B	2.9
	-160-B40-SD15-12	▲	160	2.2	14	63	40	12	B	4.4

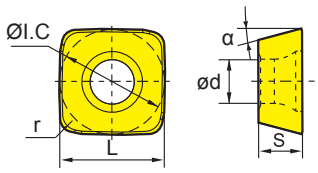
▲Stock available △Make-to-order

Spare parts

Tool type	Screw	Clamp Screw	Clamp	Wrench	
XMR01□□-SD06□□	I60M2.2×5.5	--	--	WT07IP	--
XMR01□□-SD09□□	I60M3.5×08TT	I60M4×8.4	WD-204	WT10IP	WT15IP
XMR01□□-SD12□□	I60M4×8.4			WT15IP	
XMR01□□-SD15□□	I60M5×13		WD-208	WT20IP	--

Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts



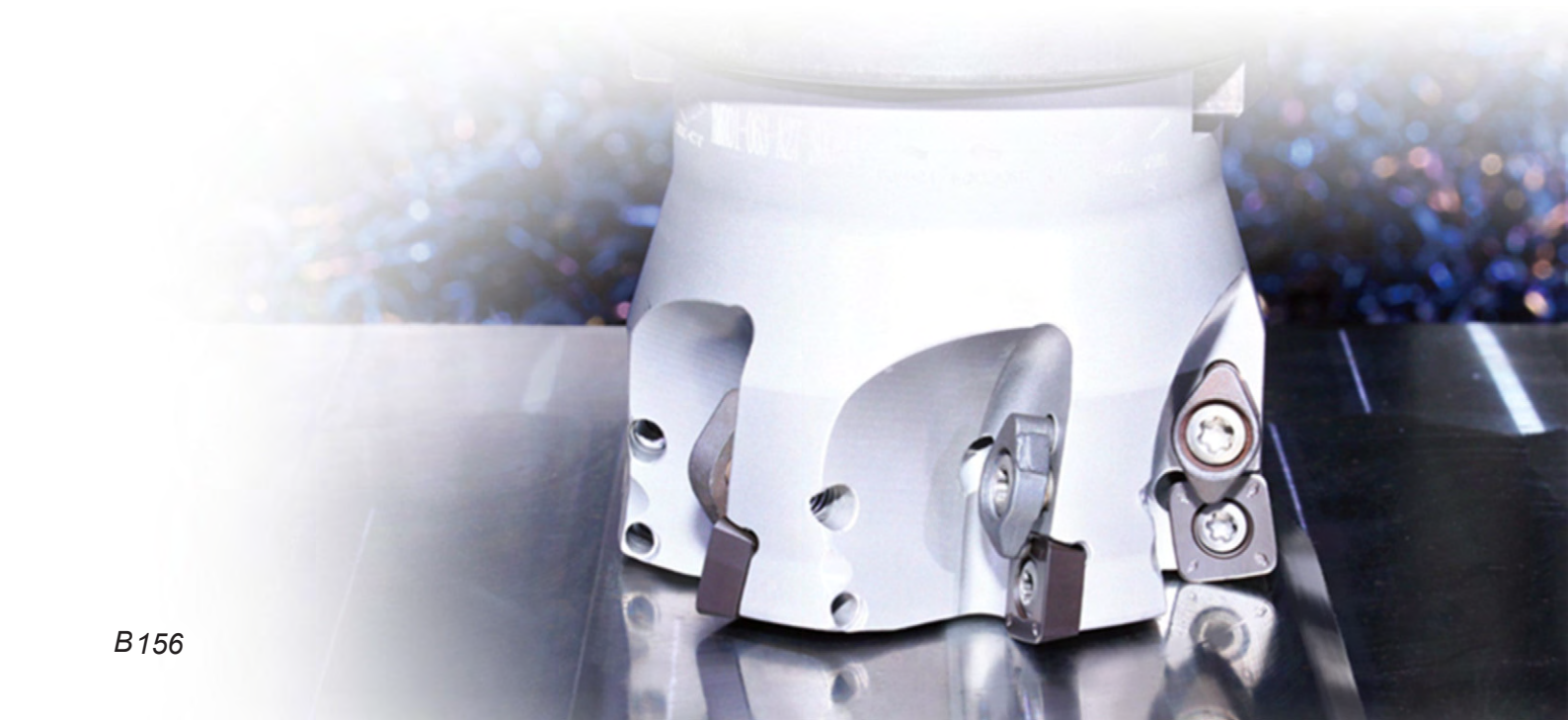
Good working condition Normal working condition Bad working condition

Workpiece material																								
P Steel	😐	😐	😐	😐	☹				😐	😐	😊	☹		😊	😊	😊	☹							
M Stainless steel	😐	😐	😐	😐	☹				😐	😐	😐	☹		😊	😊	😊	☹							
K Cast iron						😐	☹	😊					😐	😊				😊		☹
N Non-ferrous metal																			😐	☹
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐									

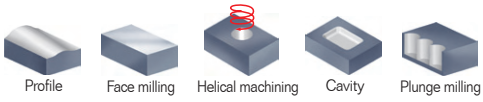
Insert shape	Type	Basic dimensions(mm)						CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	r	S	ød	α	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SDMT06T208-DM	6.35	6.35	0.8	2.58	2.5	15°		★			★							○								
	SDMT09T312-DM	9.525	9.525	1.2	3.97	4.0	15°		★			★							○								
	SDMT120412-DM	12.7	12.7	2.0	4.76	4.4	15°		★			★							○								
	SDMT150520-DM	15.875	15.875	2.0	5.56	5.5	15°		★			★							○								
	SDMT06T208-PM	6.35	6.35	0.8	2.58	2.5	15°		★		○						●										
	SDMT09T312-PM	9.525	9.525	1.2	3.97	4.0	15°		★		●						●										
	SDMT120412-PM	12.7	12.7	2.0	4.76	4.4	15°		★		●						●										
	SDMT150520-PM	15.875	15.875	2.0	5.56	5.5	15°		★		●						●										

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Chipbreaker introduction:
-PM chipbreaker has sharp cutting edge, it is more suitable for machining with power shortage and for relatively adhesive materials, such as stainless steel and Ti alloy, etc.
-DM chipbreaker has blunt cutting edge and is relatively suitable for machining of hard materials such as hardened steel and cast iron, etc.

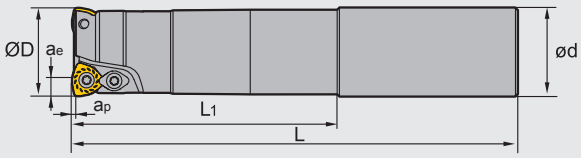


High feed milling cutters



XMR01 P M K

W-type insert, straight shank



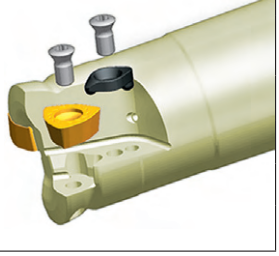
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Weight (kg)
			ØD	ap	ae	L1	L	ød		
XMR01	**-020-G20-WP05-02-M**	△	20	1.5	3.8	50	130	20	2	0.2
	-020-G20-WP05-02-L	△	20	1.5	3.8	100	180	20	2	0.3
	-020-G20-WP05-02-XL	△	20	1.5	3.8	130	250	20	2	0.8
	-025-G25-WP06-02-M	△	25	1.5	4.35	60	140	25	2	0.4
	-025-G25-WP06-02-L	△	25	1.5	4.35	120	200	25	2	0.6
	-025-G25-WP06-02-XL	△	25	1.5	4.35	180	300	25	2	1.0
	-032-G32-WP06-03-M	△	32	1.5	4.35	70	150	32	3	0.8
	-032-G32-WP06-03-L	△	32	1.5	4.35	120	200	32	3	1.0
	-032-G32-WP06-03-XL	△	32	1.5	4.35	180	300	32	3	1.6
	-040-G32-WP06-03-M	△	40	1.5	4.35	50	150	32	3	0.9
	-040-G32-WP06-03-L	△	40	1.5	4.35	50	250	32	3	1.5
	-040-G32-WP06-03-XL	△	40	1.5	4.35	50	300	32	3	1.8
	-040-G32-WP08-02-M	△	40	1.5	5.66	50	150	32	2	0.9
	-040-G32-WP08-02-L	△	40	1.5	5.66	50	250	32	2	1.5
	-040-G32-WP08-02-XL	△	40	1.5	5.66	50	300	32	2	1.9
	-050-G32-WP09-02-M	△	50	3.0	6.8	50	150	32	2	1.9
	-050-G32-WP09-02-L	△	50	3.0	6.8	50	250	32	2	2.5

▲Stock available △Make-to-order

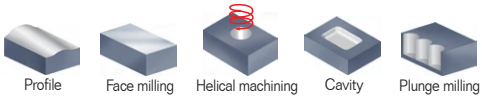
Spare parts

Tool type	Clamp/Insert screw	Clamp	Wrench	
XMR01□□-WP05□□	I60M3.5×08TT	--	WT10P	--
XMR01□□-WP06□□	I60M4×8.4		WT15P	
XMR01□□-WP08□□	I60M5×13	WD-208	--	WT20IT
XMR01□□-WP09□□				



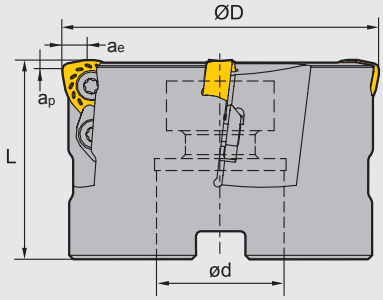
Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

High feed milling cutters



XMR01 P M K

W-type insert, arbor mounting



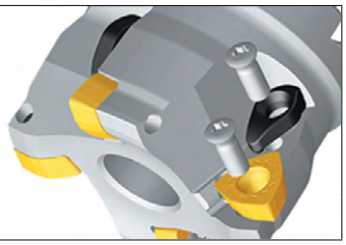
Specification of tools

Type		Stock	Basic dimensions(mm)					Number of teeth Z	Type of coupling	Weight (kg)
			ØD	ap	ae	L	ød			
XMR01	-050-A22-WP06-04	△	50	1.5	4.35	40	22	4	A	0.4
	-050-A22-WP08-03	△	50	1.5	5.66	50	22	3	A	0.4
	-063-A22-WP08-04	△	63	1.5	5.66	50	22	4	A	0.7
	-063-A27-WP08-04	△	63	1.5	5.66	50	27	4	A	0.7
	-080-A27-WP08-05	△	80	1.5	5.66	63	27	5	A	1.5
	-100-B32-WP08-06	△	100	1.5	5.66	63	32	6	B	2.2
	-125-B40-WP08-07	△	125	1.5	5.66	63	40	7	B	3.5
	-160-B40-WP08-08	△	160	1.5	5.66	63	40	8	B	6.0
	-063-A22-WP09-03	△	63	3.0	6.8	50	22	3	A	0.7
	-080-A27-WP09-04	△	80	3.0	6.8	63	27	4	A	1.4
	-100-B32-WP09-05	△	100	3.0	6.8	63	32	5	B	2.1
	-125-B40-WP09-06	△	125	3.0	6.8	63	40	6	B	3.7
	-160-B40-WP09-07	△	160	3.0	6.8	63	40	7	B	6.3

▲Stock available △Make-to-order

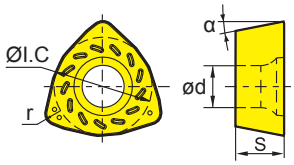
Spare parts

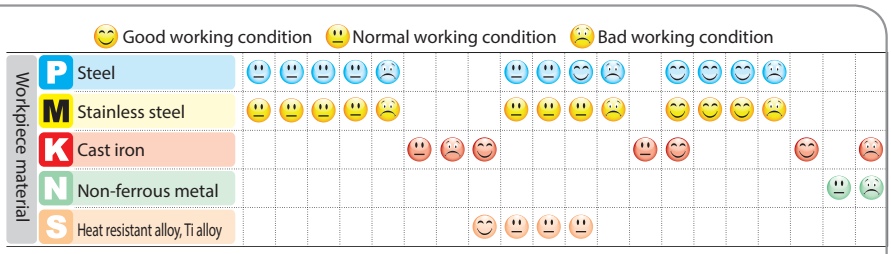
Tool type	Clamp/Insert screw	Clamp	Wrench	
XMR01□□-WP06□□	I60M4×8.4	--	WT15S	--
XMR01□□-WP08□□	I60M5×13	WD-208	--	WT20IT
XMR01□□-WP09□□	I60M5×13	WD-208	--	



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts

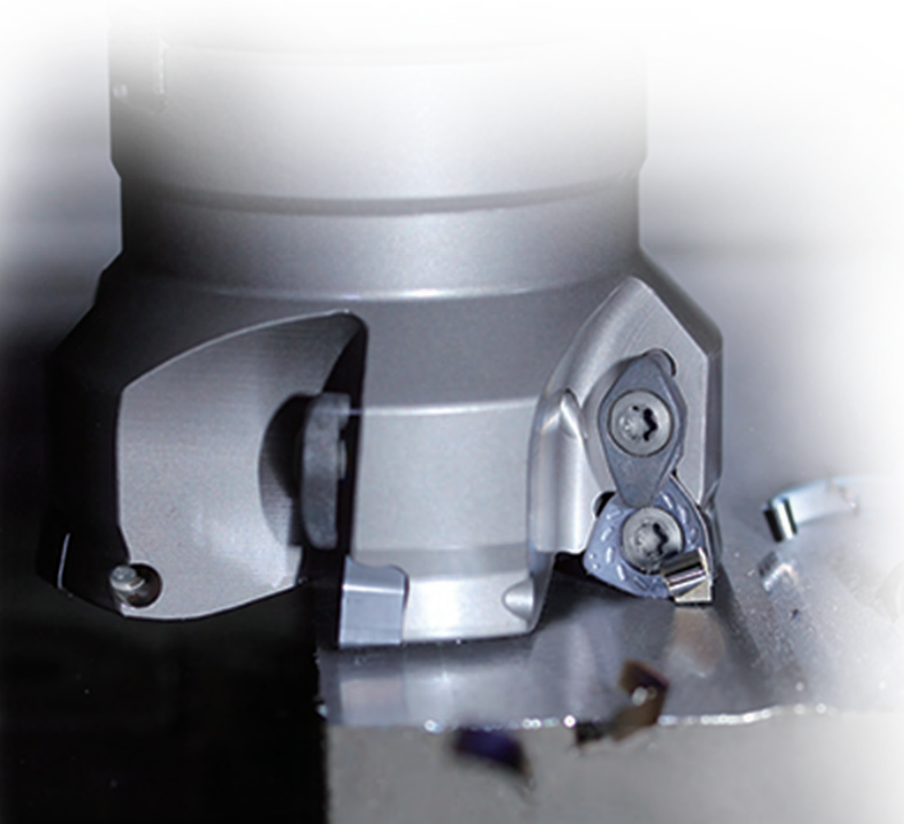




Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	r	S	ød	α	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	WPGT050315ZSR	7.94	1.5	3.5	4.0	11°		★			●															
	WPGT060415ZSR	9.525	1.5	4.2	4.4	11°		★			●															
	WPGT080615ZSR	12.85	1.5	6.35	5.5	11°		★			●															
	WPGT090725ZSR	15	2.5	7	5.5	11°		★			●															
	WPGT050315ZSR-PM	7.94	1.5	3.5	4.0	11°		★			●					●										
	WPGT060415ZSR-PM	9.525	1.5	4.2	4.4	11°		★			●					●										
	WPGT080615ZSR-PM	12.85	1.5	6.35	5.5	11°		★			●					●										
	WPGT090725ZSR-PM	15.00	2.5	7.00	5.5	11°		★			●					●										

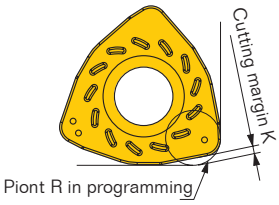
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

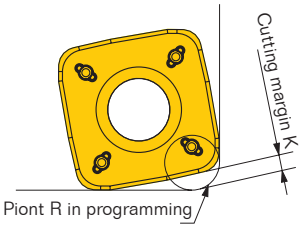
Chipbreaker introduction:
-PM chipbreaker has sharp cutting edge, it is more suitable for machining with power shortage and for relatively adhesive materials, such as stainless steel and Ti alloy, etc.
General chipbreaker has blunt cutting edge and is relatively suitable for machining of hard materials such as hardened steel and cast iron, etc.



Approximate R in machining program

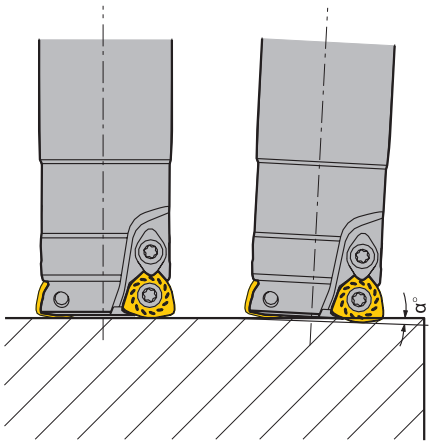
Applicable insert	Approximate R(mm)	Cutting margin K(mm)
WPGT050315ZSR/-PM	2	0.5
WPGT060415ZSR/-PM	2.5	0.7
WPGT080615ZSR/-PM	2.5	0.7
WPGT090725ZSR/-PM	4.5	1.2
SDMT06T208-DM/-PM	1.6	0.5
SDMT09T312-DM/-PM	2.5	0.87
SDMT120412-DM/-PM	4.0	0.93
SDMT150520-DM/-PM	4.0	1.38



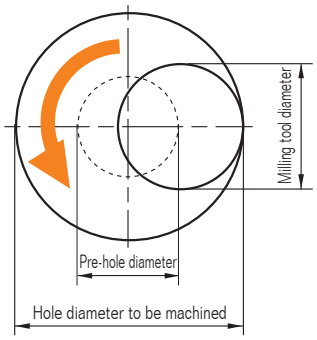


Different machining styles

■ Ramp machining



■ Helical interpolation milling



- Reduce the feed rate in ramp and helical machining operations.
- Set the axial feed rate below 0.2mm/rev in drilling operation.
- Be careful ! Long chippings may fly off in drilling operation.
- The cutting depth of each rotation must not exceed the maximum cutting depth (a_p).
- The S-type insert can be used for plunge milling in addition to the machining operations mentioned above.

Selection guide for XMR01 series

XMR01 series tools (with SD□□ inserts) have perfect edge strength and good economical efficiency, advantageous in face milling.

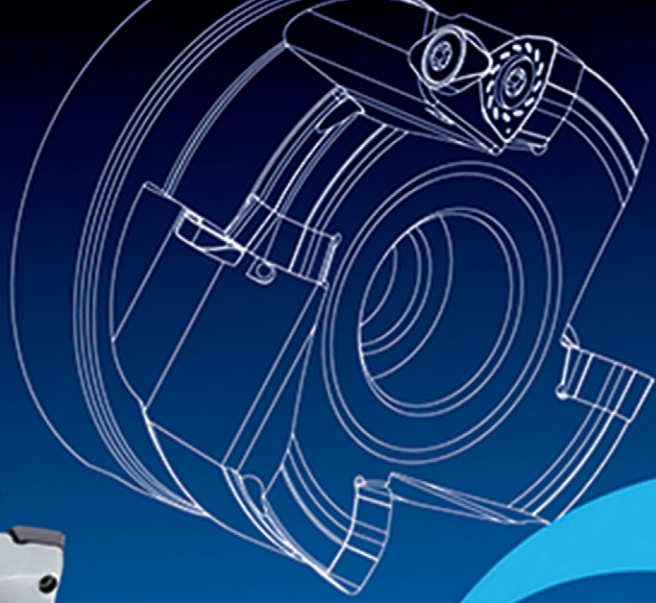
XMR01 series tools (with WP□□ inserts) possess good capability of chip removal, advantageous in cavity milling.

Recommended cutting parameters

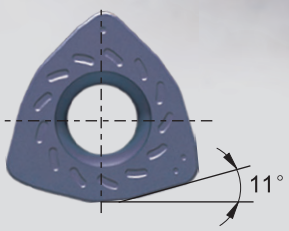
Workpiece material		Hardness HB	Insert grade	Cutting speed (m/min)	Ø25		Ø30/32/35	
					Axial cutting depth	Feed rate per tooth	Axial cutting depth	Feed rate per tooth
P	Soft steel Carbon Steel	≤HB180 HB180-280	YBC302 YBM351 YBM253 YBG205	170(120-220) 150(100-200)	0.6~1.0	0.8~1.2	0.8~1.2	1.0~1.4
P	Alloy steel Alloy tool steel	HB280-350	YBC302 YBM351 YBM253 YBG205	130(80-180)	0.4~0.8	0.8~1.2	0.6~1.0	1.0~1.4
P	pre-hardened steel	≤HRC35	YBC302 YBM351 YBM253 YBG205	120(80-160)	0.4~0.8	0.6~1.0	0.6~1.0	0.8~1.2
M	Stainless steel	≤HB270	YBM351 YBM253	120(80-160)	0.6~1.0	0.6~1.0	0.8~1.2	0.8~1.2
M			YBG205	120(80-190)				
K	Common cast iron	Tensile strength ≤350MPa	YBG302	150(100-200)	0.6~1.0	1.0~1.4	0.8~1.2	1.2~1.6
K	Nodular cast iron	Tensile strength ≤800MPa	YBG302	120(80-160)	0.4~0.8	0.8~1.2	0.6~1.0	1.0~1.4

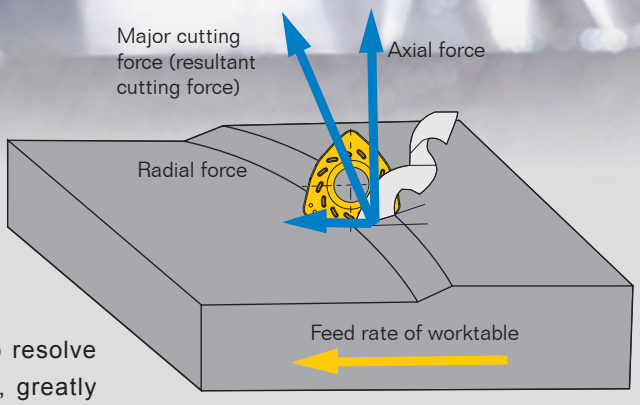
Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting speed (m/min)	Ø40		Ø50/63		Ø80/100	
					Axial cutting depth	Feed rate per tooth	Axial cutting depth	Feed rate per tooth	Axial cutting depth	Feed rate per tooth
P	Soft steel Carbon Steel	≤HB180 HB180-280	YBC302 YBM351 YBM253 YBG205	170(120-220) 150(100-200)	0.8~1.2	1.0~1.4	1.1~1.5	1.1~1.5	1.0~1.5	1.0~1.5
P	Alloy steel Alloy tool steel	HB280-350	YBC302 YBM351 YBM253 YBG205	130(80-180)	0.6~1.0	1.0~1.4	0.9~1.3	1.1~1.5	0.8~1.3	1.0~1.5
P	pre-hardened steel	≤HRC35	YBC302 YBM351 YBM253 YBG205	120(80-160)	0.6~1.0	0.8~1.2	0.9~1.3	0.9~1.3	0.8~1.3	0.8~1.3
M	Stainless steel	≤HB270	YBM351 YBM253	120(80-160)	0.8~1.2	0.8~1.2	1.1~1.5	0.9~1.3	1.0~1.5	0.8~1.3
M			YBG205	120(80-190)						
K	Common cast iron	Tensile strength ≤350MPa	YBG302	150(100-200)	0.8~1.2	1.2~1.6	1.1~1.5	1.3~1.7	1.0~1.5	1.2~1.7
K	Nodular cast iron	Tensile strength ≤800MPa	YBG302	120(80-160)	0.6~1.0	1.0~1.4	0.9~1.3	1.1~1.5	0.8~1.3	1.0~1.5



XMR01 series milling tools

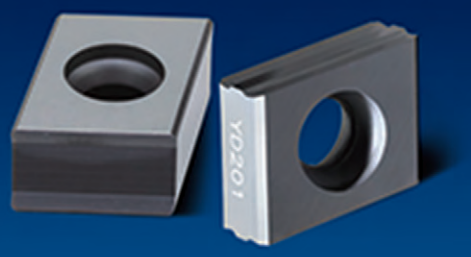




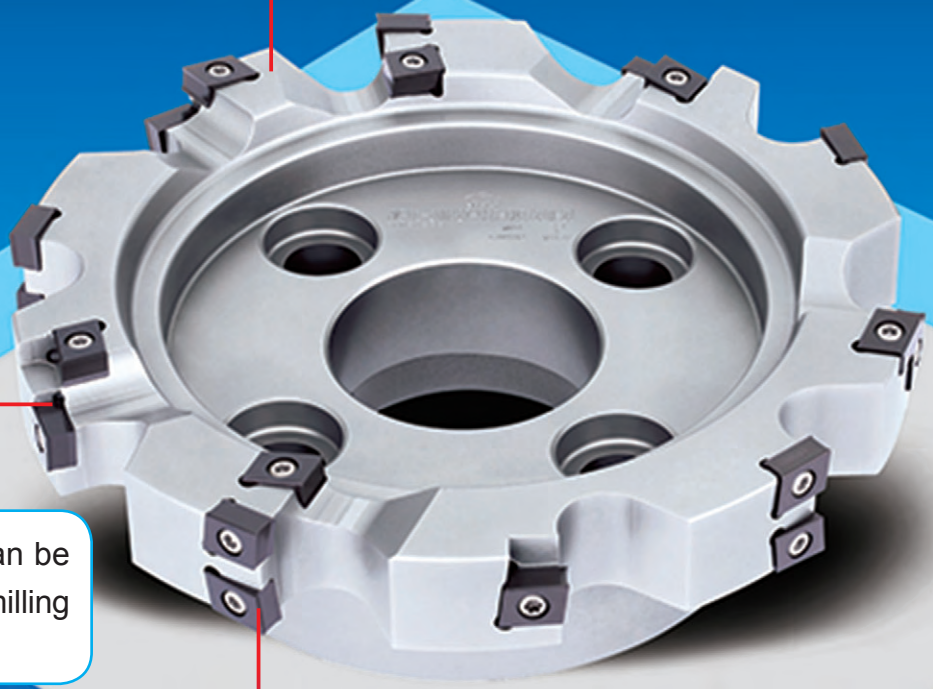
The main feature of high feed tools is to resolve the major cutting force to the axial direction, greatly reducing the radial cutting force, thus improve tool's shock resistance. In addition, this structure can effectively reduce vibration in long-overhang milling operation.

XMP01

Boring millers

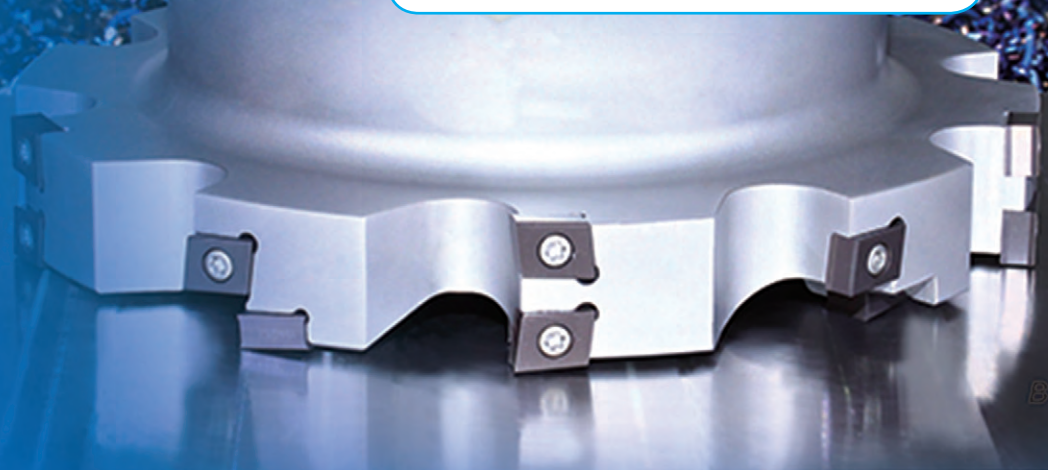


Complexed milling tools, which are mostly used in machining large diameter holes and boring milling cavities.

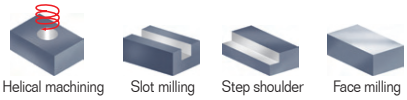


high versatility can be used for surface milling and side milling.

Inserts are vertically loaded. It provides two chipbreaker for you choose, while it fits to machining different cutting performance materials.

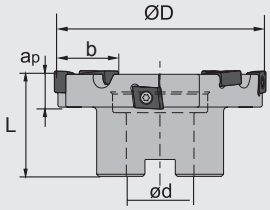


Boring millers

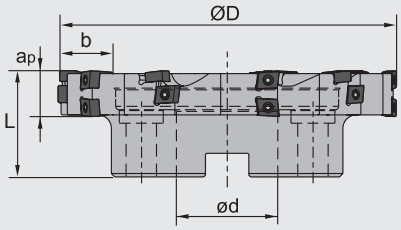


XMP01 P M K

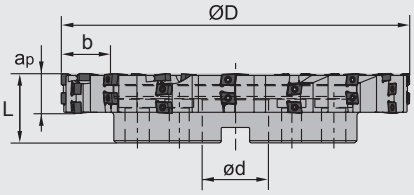
B-type coupling



C-type coupling



D-type coupling



Specification of tools

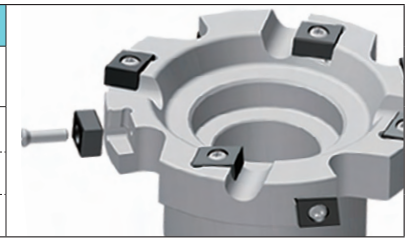
Type		Stock	Basic dimensions(mm)					Number of teeth Z	Zeff (Peripheral teeth/ end teeth)	Type of coupling	Weight (kg)
			ØD	ød	L	ap	b				
XMP01	**-080X18-B27-CNE1210-08**	△	80	27	50	19	18	8	2/2	B	0.67
	-100X18-B32-CNE1210-08	△	100	32	50	19	18	8	2/2	A	0.99
	-125X27-B40-CNE1210-15	△	125	40	63	27	27	15	3/2	B	2.46
	-160X27-C40-CNE1210-18	△	160	40	63	27	27	18	4/2	C	3.7
	-200X27-C60-CNE1210-21	△	200	60	63	27	27	21	5/2	C	5.46
	-250X36-C60-CNE1210-32	△	250	40	63	36	36	32	6/2	C	9.79
	-315X36-D60-CNE1210-42	△	315	60	63	45	36	42	8/2	D	17.65
	-400X36-D60-CNE1210-52	△	400	60	63	53	36	52	10/2	D	27.36

Notes: The values of ap, b and D could be customized by requirements in a certain range; Zeff stands for valid teeth.

▲Stock available △Make-to-order

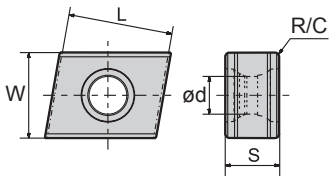
Spare parts

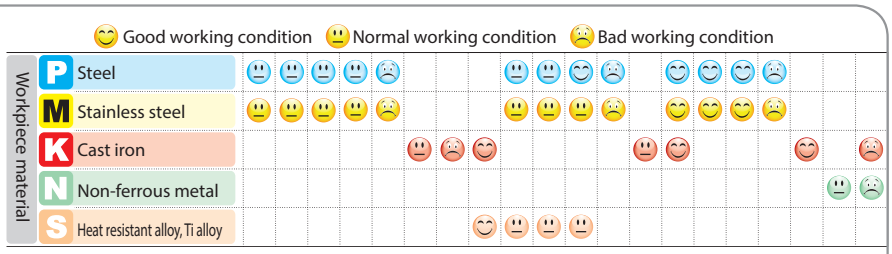
Diameter ØD	Inserts	Screw	Wrench
Ø80-Ø400	CNE121006*	I60M4X12	WT15IP



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

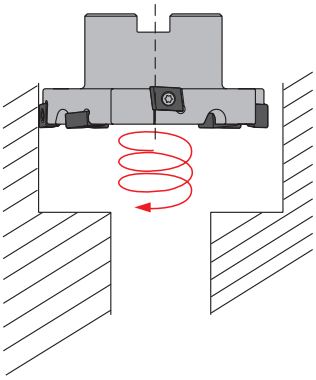
Selection of inserts





Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		L	W	S	R/C	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	CNE121006A	12.8	10.0	6.35	0.4	4.4				●		○														
	CNE121006B	12.0	10.0	6.35	0.6	4.4				●		○														

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



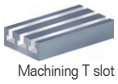
Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters			
				V(m/min)	f(mm/Zeff)	$a_p$max(mm)	
						CNE121006A	CNE121006B
P	Soft steel Carbon Steel	≤180	YBM253	270 (220-350)	0.2 (0.15-0.3)	15-90	15-90
P	Alloy steel Alloy tool steel	180-280	YBM253	260 (200-320)	0.2 (0.15-0.3)	15-90	15-90
P	pre-hardened steel	280-350	YBM253	240 (180-300)	0.2 (0.15-0.3)	15-90	15-90
M	Stainless steel	≤270	YBM253	230(180-300)	0.2(0.1-0.3)	15-90	15-90
K	Common cast Iron	180-250	YBD152	270 (150-300)	0.2(0.15-0.3)	15-90	15-90

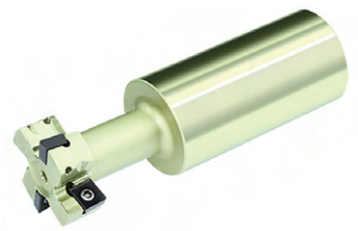
Note: Zeff means effective tooth number.

T-slot milling tools

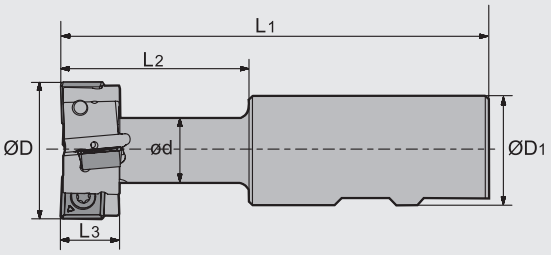
Kr:90°


Machining T slot

TMP01 K



Weldon shank



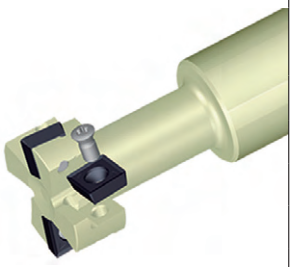
Specification of tools

Type		Stock	Basic dimensions(mm)						Number of teeth Z	Number of insert	T-slot specification
			ØD	ØD1	ød	L1	L2	L3			
TMP01	-021-XP25-MP06-01	▲	21	25	10	100	32	9	1	2	12
	-025-XP25-MP06-01	▲	25	25	12	100	35	11	1	2	14
	-032-XP32-MP08-02	▲	32	32	15	110	45	14	2	4	18
	-040-XP32-MP12-02	▲	40	32	19	125	55	18	2	4	22
	-050-XP40-MP12-02	▲	50	40	25	140	65	22	2	4	28
	-060-XP50-MP12-02	▲	60	50	32	160	80	28	2	6	36

▲Stock available △Make-to-order

Spare parts

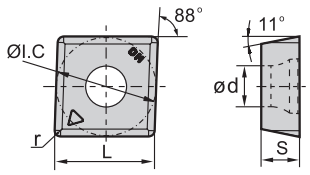
Tool type	Screw	Wrench	
TMP01-021-XP25-MP06-01	I60M2.5×5.5	WT07IP	--
TMP01-025-XP25-MP06-01	I60M2.5×5.5		
TMP01-032-XP32-MP08-02	I60M3×7	WT10IP	--
TMP01-040-XP32-MP12-02	I60M5×10	--	WT20IT
TMP01-050-XP40-MP12-02	I60M5×10		
TMP01-060-XP50-MP12-02	I60M5×10		

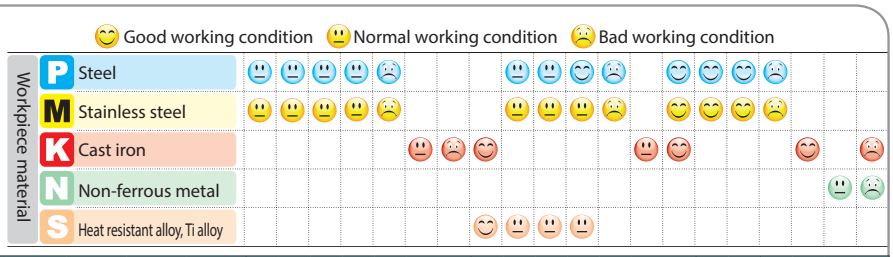


Caution: When installing inserts, make sure the insert nose marked with "DM" or "Δ" is pointing to the slot.

Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

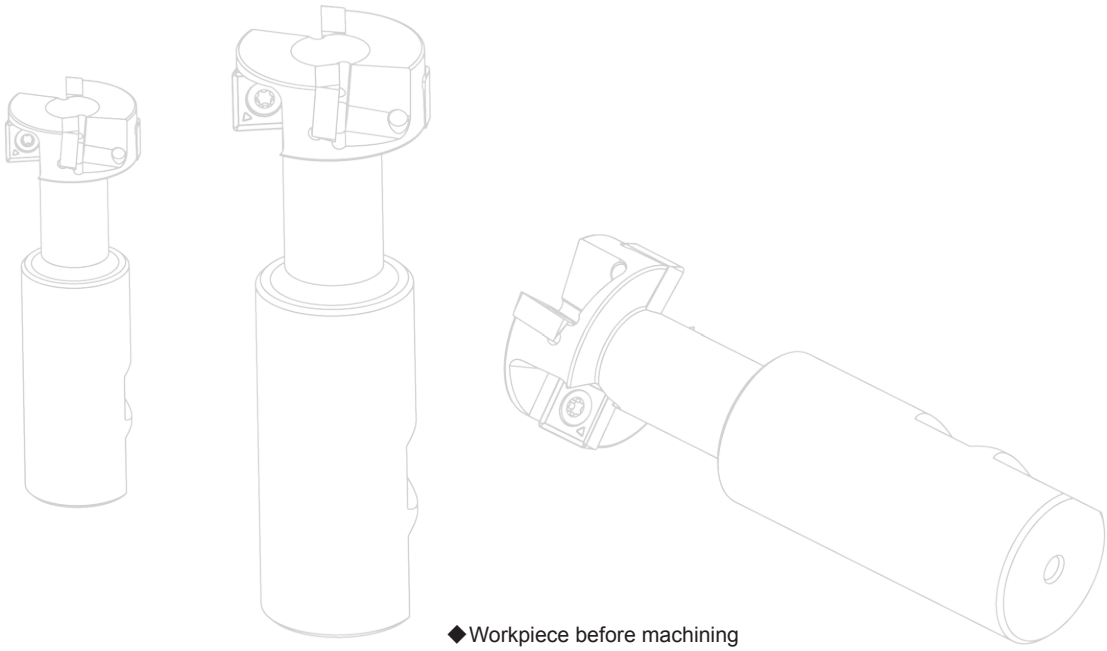
Selection of inserts



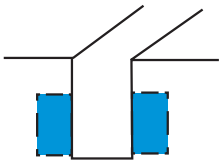


Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	s	ød	r	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	MPHT060304-DM	6.35	6.35	3.18	2.8	0.4												★								
	MPHT080305-DM	8.3	8.3	3.18	3.4	0.5												★								
	MPHT120408-DM	12.7	12.7	4.76	5.56	0.8												★								

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



◆Workpiece before machining



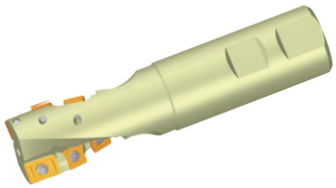
Recommended cutting parameters

Workpiece material	Insert grade	Cutting parameters		
		V(m/min)	f(mm/z)	Cooling
Grey cast iron	YBG302	80~160	0.05~0.2	Wet / Dry

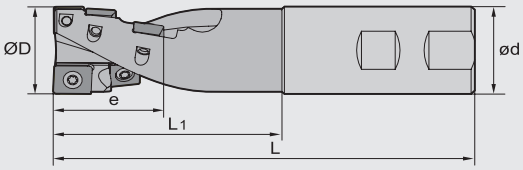
Helical end mill

Kr:90°

HMP01 P K



Weldon shank

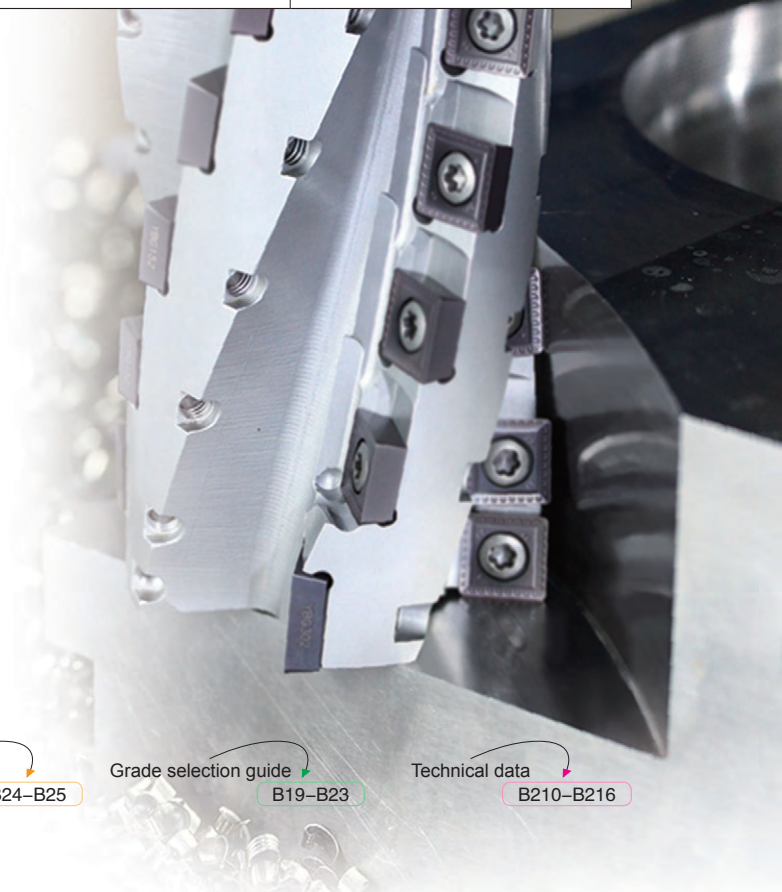


Specification of tools

Type		Stock		Basic dimensions(mm)					Number of flute	Number of inserts		Shank type
		R	L	ØD	ød	e	L_1	L	Z	APKT 150412-PM/KM	SPMT 120408-PM/KM	
HMP01	**-040×55-XP40-SP12-02**	△	△	40	40	55	95	175	2	1	5	Weldon shank
	-050×55-XP40-SP12-04	△	△	50	40	55	95	175	4	2	10	Weldon shank

▲Stock available △Make-to-order

Diameter ØD	Screw	Wrench
Ø40	I60M5×10	WT20T
Ø50	I60M5×13	WT20T



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Helical end mill

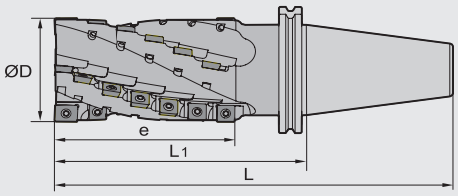
Kr:90°

Side milling

Slot milling

HMP01 P K

JT shank/ BT shank (JT shank shown)



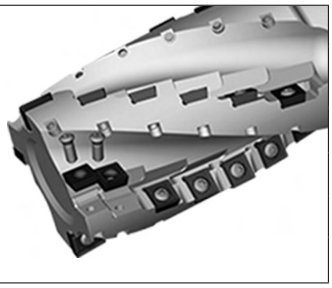
Specification of tools

Type		Stock		Basic dimensions(mm)				Number of flute	Number of inserts		Shank type
		R	L	ØD	e	L1	L	Z	APKT 150412-PM/KM	SPMT 120408-PM/KM	
HMP01	**-050×84-JT50-SP12-04**	△	△	50	84	145	246.75	4	2	16	JT
	-063×74-JT50-SP12-04	△	△	63	74	135	236.75	4	2	14	JT
	-063×104-JT50-SP12-04	△	△	63	104	165	266.75	4	2	20	JT
	-063×134-JT50-SP12-04	△	△	63	134	195	296.75	4	2	26	JT
	-080×104-JT50-SP12-04	△	△	80	104	165	266.75	4	2	20	JT
	-080×144-JT50-SP12-04	△	△	80	144	205	306.75	4	2	28	JT
	-050×84-BT50-SP12-04	△	△	50	84	145	246.8	4	2	16	BT
	-063×74-BT50-SP12-04	△	△	63	74	135	236.8	4	2	14	BT
	-063×104-BT50-SP12-04	△	△	63	104	165	266.8	4	2	20	BT
	-063×134-BT50-SP12-04	△	△	63	134	195	296.8	4	2	26	BT
	-080×104-BT50-SP12-04	△	△	80	104	165	266.8	4	2	20	BT
	-080×144-BT50-SP12-04	△	△	80	144	205	306.8	4	2	28	BT

▲Stock available △Make-to-order

Spare parts

Diameter ØD	Screw	Wrench
Ø50	I60M5×13	WT20IS
Ø63	I60M5×13	WT20IS
Ø80	I60M5×13	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

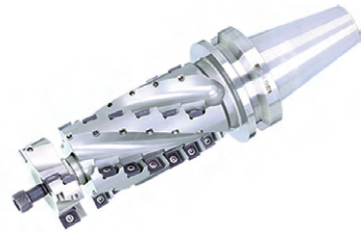
Helical end mills with interchangeable heads

Kr:90°

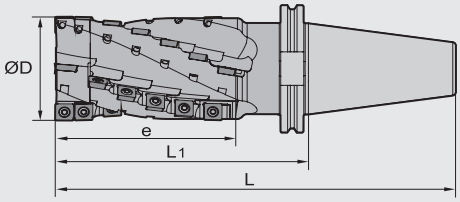
Side milling

Slot milling

HMP01 EC P K



JT shank/ BT shank (JT shank shown)



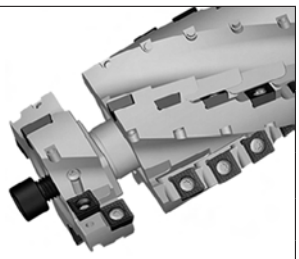
Specification of tools

Type		Stock		Basic dimensions(mm)				Number of flute	Number of inserts		Shank type
		R	L	ØD	e	L1	L	Z	APKT 150412-PM/KM	SPMT 120408-PM/KM	
HMP01	-050×84EC-JT50-SP12-04	△	△	50	84	145	246.75	4	2	16	JT
	-063×74EC-JT50-SP12-04	△	△	63	74	135	236.75	4	2	14	JT
	-063×104EC-JT50-SP12-04	△	△	63	104	165	266.75	4	2	20	JT
	-063×134EC-JT50-SP12-04	△	△	63	134	195	296.75	4	2	26	JT
	-080×104EC-JT50-SP12-04	△	△	80	104	165	266.75	4	2	20	JT
	-080×144EC-JT50-SP12-04	△	△	80	144	205	306.75	4	2	28	JT
	-050×84EC-BT50-SP12-04	△	△	50	84	145	246.8	4	2	16	BT
	-063×74EC-BT50-SP12-04	△	△	63	74	135	236.8	4	2	14	BT
	-063×104EC-BT50-SP12-04	△	△	63	104	165	266.8	4	2	20	BT
	-063×134EC-BT50-SP12-04	△	△	63	134	195	296.8	4	2	26	BT
	-080×104EC-BT50-SP12-04	△	△	80	104	165	266.8	4	2	20	BT
	-080×144EC-BT50-SP12-04	△	△	80	144	205	306.8	4	2	28	BT

▲Stock available △Make-to-order

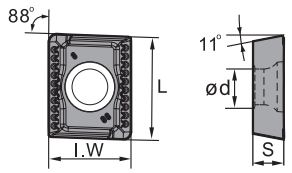
Spare parts

Diameter ØD	Insert screw	Screw of interchangeable head	Wrench of insert screw	Wrench of interchangeable head	Interchangeable head
Ø50	I60M5×13	M10×50	WT20IS	WH80L	050EC
Ø63	I60M5×13	M10×50	WT20IS	WH80L	063EC
Ø80	I60M5×13	M12×55	WT20IS	WH100L	080EC



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts



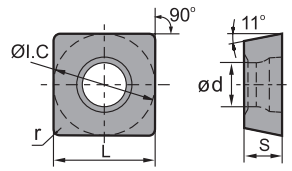
Good working condition | Normal working condition | Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P Steel	Normal	Normal	Normal	Normal	Bad				Normal	Normal	Good	Bad		Good	Good	Good	Bad			
M Stainless steel	Normal	Normal	Normal	Normal	Bad				Normal	Normal	Normal	Bad		Good	Good	Good	Bad			
K Cast iron						Normal	Bad	Good					Normal	Good				Good		Bad
N Non-ferrous metal																			Normal	Bad
S Heat resistant alloy, Ti alloy								Good	Normal	Normal	Normal									

Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		L	I.W	S	ød	r	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	APKT150412-PM	16.33	12.7	4.76	5.4	1.2				★								●	○							
	APKT150412-KM	16.33	12.7	4.76	5.4	1.2												●	○							

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Selection of inserts



Good working condition | Normal working condition | Bad working condition

Workpiece material	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
P Steel	Normal	Normal	Normal	Normal	Bad				Normal	Normal	Good	Bad		Good	Good	Good	Bad			
M Stainless steel	Normal	Normal	Normal	Normal	Bad				Normal	Normal	Normal	Bad		Good	Good	Good	Bad			
K Cast iron						Normal	Bad	Good					Normal	Good				Good		Bad
N Non-ferrous metal																			Normal	Bad
S Heat resistant alloy, Ti alloy								Good	Normal	Normal	Normal									

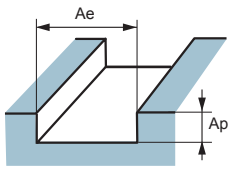
Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		L	ØI.C	S	ød	r	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SPMT120408-PM	12.7	12.7	4.76	5.5	0.8				★								●	○							
	SPMT120408-KM	12.7	12.7	4.76	5.5	0.8												●	○							

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Chipbreaker selection for HMP01 milling inserts

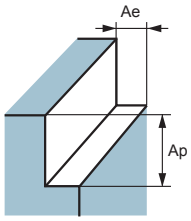
Classification \ Function	For semi-finishing	For roughing
P	-PM	-PM
K	-KM	-KM

A Slot milling



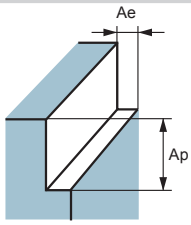
Ae=D
Ap=0.5D(cast iron)
Maximum 12mm(steel)

B Square shoulder milling



Ae=0.5D
Ap=1.5D(cast iron)
1.0D(steel)

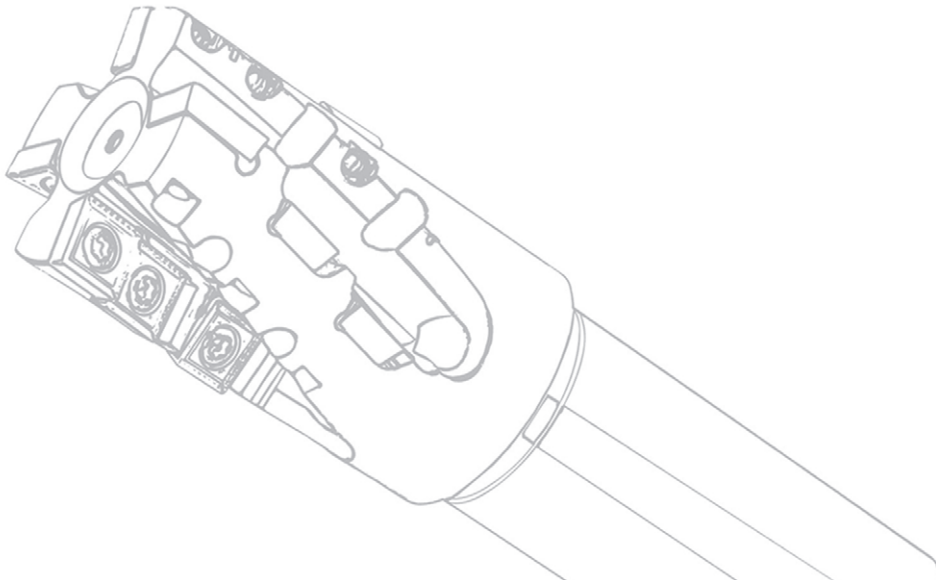
C Narrow shoulder milling



Ae=0.1D
Ap≤Maximum cutting length

Recommended cutting parameters

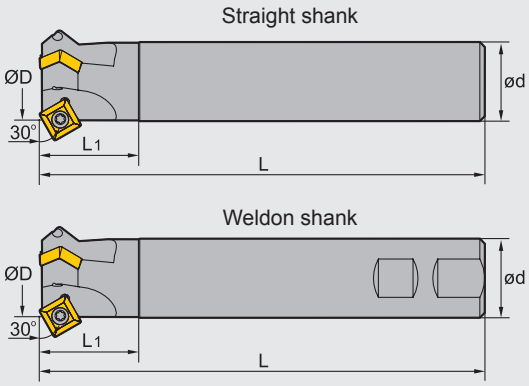
Workpiece material		Hardness HB	Insert grade	Cutting parameters		Operation (figure)
				Cutting speed(m/min)	Feed speed(mm/z)	
P	Low-carbon steel、Soft steel	⩽180	YBM253 YBG302	80(60-90)	0.25(0.1-0.35)	A
				90(70-120)	0.3(0.15-0.4)	B
				90(70-120)	0.3(0.15-0.4)	C
	High-carbon steel、Alloy steel	180-280	YBM253 YBG302	70(60-100)	0.2(0.1-0.35)	A
				80(60-120)	0.25(0.15-0.35)	B
				90(70-120)	0.25(0.15-0.35)	C
	Alloy tool steel	280-350	YBM253 YBG302	50(40-80)	0.15(0.08-0.25)	A
				60(50-100)	0.2(0.1-0.35)	B
				70(50-100)	0.2(0.1-0.35)	C
K	Cast iron	180-250	YBG152 YBG302	70(50-100)	0.2(0.1-0.35)	A
				80(60-120)	0.25(0.15-0.35)	B
				90(80-120)	0.25(0.15-0.35)	C



Chamfer milling tools

Kr:30°

CMZ01 P M K



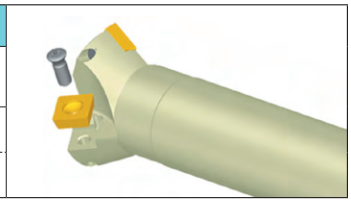
Specification of tools

Type		Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
			ØD	ød	L	L1		
CMZ01 Straight shank	**-012-G20-SP12-01**	△	12	20	100	40	1	0.2
	-025-G25-SP12-02	△	25	25	120	40	2	0.8
	-032-G32-SP12-03	△	32	32	180	40	3	1.1
Weldon shank	**-012-XP20-SP12-01**	△	12	20	100	40	1	0.2
	-025-XP25-SP12-02	△	25	25	120	40	2	0.6
	-032-XP32-SP12-03	△	32	32	180	40	3	1.0

▲Stock available △Make-to-order

Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø32	I43M5×11	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Chamfer milling tools

Kr:45°

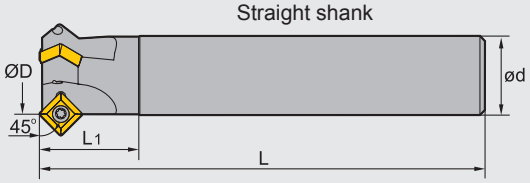
Chamfering

Face milling

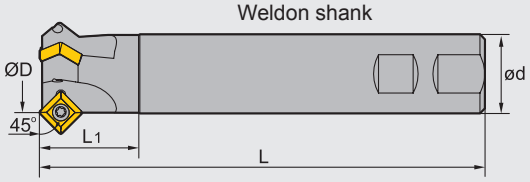
Hole stomata chamfer

CMA01 P M K

Straight shank



Weldon shank



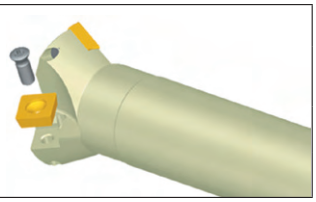
Specification of tools

Type		Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
			ØD	ød	L	L1		
CMA01 Straight shank	**-012-G20-SP12-01**	▲	12	20	100	40	1	0.2
	-025-G25-SP12-02	▲	25	25	120	40	2	0.8
	-032-G32-SP12-03	▲	32	32	180	40	3	1.1
Weldon shank	**-012-XP20-SP12-01**	▲	12	20	100	40	1	0.2
	-025-XP25-SP12-02	▲	25	25	120	40	2	0.6
	-032-XP32-SP12-03	▲	32	32	180	40	3	1.0

▲Stock available △Make-to-order

Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø32	I43M5×11	WT20IS

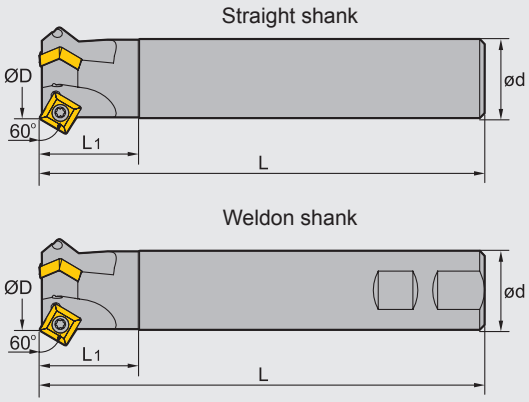


Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Chamfer milling tools

Kr:60°

CMD01 P M K



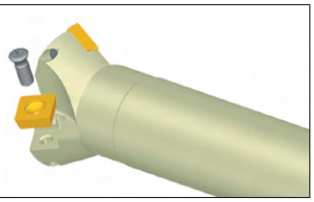
Specification of tools

Type		Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
			ØD	ød	L	L_1		
CMD01 Straight shank	**-012-G20-SP12-01**	▲	12	20	100	40	1	0.2
	-025-G25-SP12-02	▲	25	25	120	40	2	0.8
	-036-G32-SP12-03	▲	36	32	180	40	3	1.0
Weldon shank	**-012-XP20-SP12-01**	▲	12	20	100	40	1	0.2
	-025-XP25-SP12-02	▲	25	25	120	40	2	0.6
	-036-XP32-SP12-03	▲	36	32	180	40	3	1.0

▲Stock available △Make-to-order

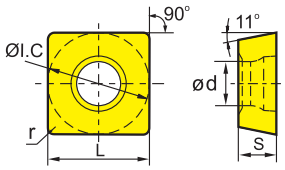
Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø36	I43M5×11	WT20IS



Tools code key B24–B25
Grade selection guide B19–B23
Technical data B210–B216

Selection of inserts



😊 Good working condition 😐 Normal working condition ☹️ Bad working condition

Workpiece material																						
P Steel	😐	😐	😐	😐	☹️				😐	😐	😊	☹️		😊	😊	😊	☹️					
M Stainless steel	😐	😐	😐	😐	☹️				😐	😐	😐	☹️		😊	😊	😊	☹️					
K Cast iron						😐	☹️	😊					😐	😊				😊		☹️		
N Non-ferrous metal																					😐	☹️
S Heat resistant alloy, Ti alloy								😊	😐	😐	😐											

Insert shape	Type	Basic dimensions(mm)					CVD Coating							PVD Coating							Cermet		Cemented carbide			
		ØI.C	L	r	S	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	SPMT120408	12.7	12.7	0.8	4.76	5.5	●		●		●							★					○			

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				Cutting speed(m/min)	Feed speed(mm/z)
P	Low-carbon steel、Soft steel	≤180	YBM251 YBC301	180(100—250)	0.25 (0.1-0.4)
			YBM351 YBG302	150(100—200)	0.3 (0.1-0.5)
			YC30S	120(80—150)	0.4 (0.1-0.5)
	High-carbon steel、Alloy steel	180-280	YBM251 YBC301	160(100—220)	0.3 (0.1-0.4)
			YBM351 YBG302	130(100—180)	0.3 (0.1-0.5)
			YC30S	100(60—150)	0.4 (0.1-0.5)
	Alloy tool steel	280-350	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)
			YBM351 YBG302	100(80—150)	0.3 (0.1-0.5)
			YC30S	80(60—120)	0.4 (0.1-0.5)
M	Stainless steel	≤270	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)
			YBM351 YBG302	100(80—150)	0.3 (0.1-0.5)
			YC30S	80(60—120)	0.4 (0.1-0.5)
K	Cast iron	180-250	YBG302	130(100—180)	0.4 (0.1-0.5)