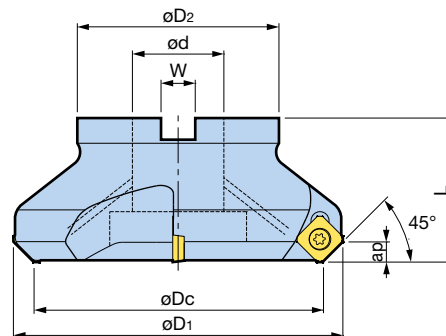
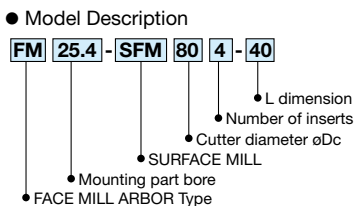


Superior surface finish of the workpiece!



We recommend the **BIG** FACE MILL ARBOR TYPE FMA for holders.

We recommend the **BIG** FACE MILL ARBOR TYPE FMH for holders.



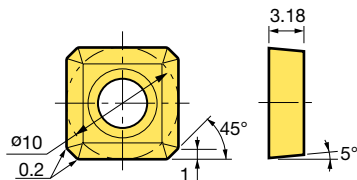
Cutter diameter ϕD_c	Model	Effective cutting edge length ap	ϕD_1	ϕd	ϕD_2	L	W	Number of inserts	Weight (kg)
80	FM25.4-SFM804-40	5	91.6	25.4	56	40	9.5	4	0.9
	FM27-SFM804-40			27	60		12.4		

1. A wrench and screws are included. Inserts must be ordered separately.

Compatible arbors: FMA25.4 and FMH25.4, FMH27

※ When using FMH, clamping screw MBA-M12H is required.

<Insert>



Insert Model	Coating
CM10C1 ACP200	TiAlN and AlCrN multilayer
CM10C1 DS20	DLC

1. Inserts are available in packets of 10 pcs.

<Insert Clamping Screw Set>

Insert clamping screws and tightening wrench are consumables. Order periodically for replacement or spares.

● Insert Clamping Screw Set	● Driver-Type Wrench
Screw x 10 pcs Wrench x 1 pce.	
Set Model	Driver Model
S4S-T15DS	DA-T15

Cutting Conditions

Workpiece material	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	Axial DOC ap Max. (mm)	Insert grade
General Steel	150- 200 - 250	0.10- 0.20 -0.30	3	ACP200
Mild Steel	180- 240 - 300	0.10- 0.25 -0.40	4	
Stainless Steel	160- 205 - 250	0.15- 0.23 -0.30	3	
Cast Iron	100- 175 - 250	0.15- 0.23 -0.30	4	
Light Alloy	500- 750 -1000	0.15- 0.23 -0.30	5	DS20

This table is a guideline for selecting cutting parameters. Adjust them as needed according to the machine and workpiece conditions.