

Teeth good, everything good!

FMA11 - Special Promotion

2014

FMA11 for free with a minimum purchase
of 50 (Ø63-125 mm) inserts

*Only valid for the milling diameters 63, 80, 100 and 125 mm. Prices for inserts according your standard conditions.

Valid until 30 September 2014 and while stocks last.



your Partner
your Value

ZCC-CT
ZCC Cutting Tools Europe GmbH



FMA 11 Kr:45°

New generation of face milling with double sided insert
Neue Planfräsergeneration mit doppelseitiger WSP



Double sided inserts
Doppelseitige WSP

8 cutting edge

8 Schneidkanten für wirtschaftliche Auslastung der WSP.

Inserts with big rake angle, reducing power consumption.

Großer Spanwinkel für weichen Schnitt.

Milling cutter with thicker inserts for high stability and big cutting depth.

Doppelseitige, extra dicke Wendeschneidplatte für große Spantiefen bei hoher Bruchsicherheit.

Grade / Sorte:

YBC302

YBM253

YBD152

a_p max:



Inserts with wiper cutting edge for good surface quality.

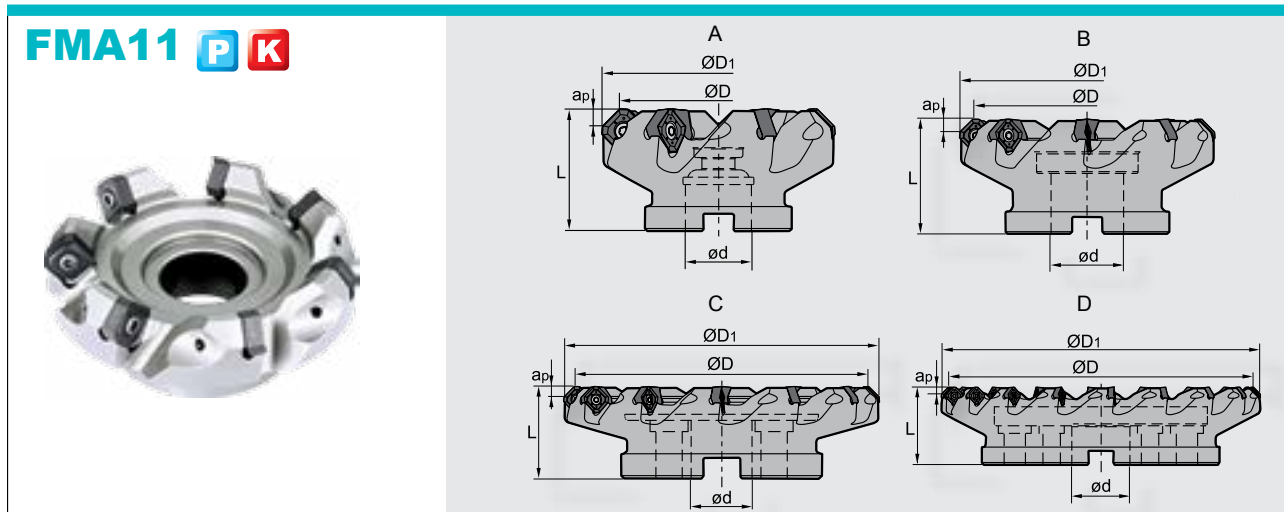
Wiper Geometrie für beste Oberflächengüte.

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Distributor
Vertretung

Face Milling Tools · Planfräser

Kr:45°



Specification of tools · Werkzeug Beschreibung

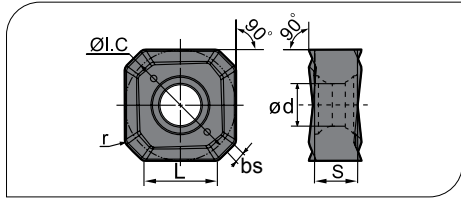
Type Typ	*	Stock Lager		Dimension (mm) Abmessung					No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)	
		R	L	ØD	ØD ₁	Ød	L	a _{pmax}				
FMA11	-063-A22-SN12-05	*	●		63	74.47	22	40	5.5	5	A	0.55
	-080-A27-SN12-06	*	●		80	91.47	27	50	5.5	6	A	1.14
	-100-B32-SN12-07		●		100	111.47	32	50	5.5	7	B	1.42
	-125-B40-SN12-08		●		125	136.47	40	63	5.5	8	B	2.86
FMA11	-063-A22-SN15-05	*	●		63	77.4	22	40	7.0	5	A	0.56
	-080-A27-SN15-06	*	●		80	94.4	27	50	7.0	6	A	1.06
	-100-B32-SN15-07		●		100	114.4	32	50	7.0	7	B	1.47
	-125-B40-SN15-08		●		125	139.4	40	63	7.0	8	B	2.70
FMA11	-125-B40-SN19-07		●		125	142.63	40	63	9.0	7	B	3.00

* Internal coolant · Innenkühlung

Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Wrench Schlüssel		
SN12 Ø63 - Ø125	SNEG1205ANR-GR	I60M3.5x10		WT15IS	
SN15 Ø63 - Ø125	SNEG1506ANR-GR	I60M5x13		WT20IT	
SN19 Ø125	SNEG1907ANR-GR	I43M6x16		WT25IT	

Applicable inserts Wendeschneidplatten



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

Workpiece Material Werkstoffe	P	M	K	N	S
Steel Stahl	●	●	●	●	●
Stainless Steel Rostfreier Stahl	●	●	●	●	●
Cast iron Gusseisen	●	●	●	●	●
Non-ferrous material Nichtmetalle	●	●	●	●	●
Heat-resistant steel Wärmebeständiger Stahl	●	●	●	●	●

Insert shape Plattenform	Type Typ	Dimension (mm) Abmessung						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.				Cermet Cermet	Carbide uncoat. unbe. Hartmetall								
		L	I.C	S	bs	Ø d	r	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	SNEG1205ANR-GM	7.6	12.0	4.76	1.05	4.6	0.8	●				●															
	SNEG1506ANR-GM	9.4	15.0	5.54	1.30	5.5	0.9	●				●															
	SNEG1205ANR-GR	7.6	12.0	4.76	1.05	4.6	0.8	●				●															
	SNEG1506ANR-GR	9.4	15.0	5.54	1.30	5.5	0.9	●				●															
	SNEG1907ANR-GR	12.1	19.0	7.0	1.67	7.2	1.0	●				●															

Recommended cutting data · Empfohlene Schnittdaten

	Workpiece material Werkstückstoff	Hardness HB Härte	Grade Sorte	Cutting data Schnittdaten		
				V (m/min)	f (mm/z)	a _{pmax}
P	Low-carbon steel Soft steel Niedriglegierter Kohlenstoffstahl Baustahl	≤180	YBM253	270 (220-350)	0.2 (0.1-0.4)	5.5-9.0
			YBC302	270 (220-350)	0.2 (0.1-0.4)	5.5-9.0
	High-carbon steel Alloy steel Hochleg. Kohlenstoffstahl	180-280	YBM253	260 (200-320)	0.2 (0.1-0.4)	5.5-9.0
			YBC302	260 (200-320)	0.2 (0.1-0.4)	5.5-9.0
	Alloy tool steel Leg. Werkzeugstahl	280-350	YBM253	240 (180-300)	0.2 (0.1-0.4)	5.5-9.0
			YBC302	240 (180-300)	0.2 (0.1-0.4)	5.5-9.0
K	Cast iron Gusseisen	180-250	YBD152	270 (150-300)	0.4 (0.1-0.5)	5.5-9.0