

FMA07 *Kr: 45°*

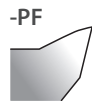
Face mill

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

Insert grades

| | | | |
|--|--|---------------------------------|---------------------------------|
| YBC302 CVD P15–P35 | YBG202 PVD P10–P30 | YBM253 CVD P20–P40 | YBM351 CVD P25–P40 |
| YBG205 PVD P10–P30 M20–M30 | YB9320 PVD P15–P25 M20–M30 | YBD152 CVD K05–K25 | |

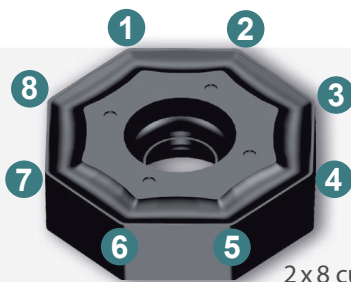
Chip breakers



- Low cutting forces
- Very sharp



- General application
- Good balance between stability and sharpness

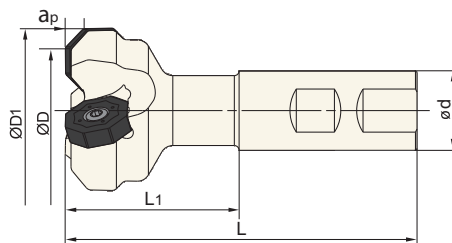
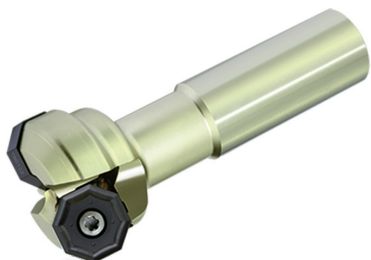
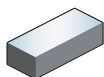


2x8 cutting edges



Face milling

FMA07 Kr: 45°



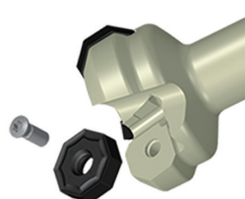
Weldon shank

| Article | * | Stock | Dimensions [mm] | | | | | | Teeth | kg | Inserts |
|-------------------------|---|-------|-----------------|-----------------|----|----------------|-----|--------------------|-------|-----|----------|
| | | | ØD | ØD ₁ | ød | L ₁ | L | a _{p max} | | | |
| FMA07-025-XP20-ON06-02 | | ○ | 25 | 37 | 20 | 45 | 95 | 4 | 2 | 0.2 | ONHU0604 |
| FMA07-025-XP20-ON06-02C | * | ○ | 25 | 37 | 20 | 45 | 95 | 4 | 2 | 0.2 | |
| FMA07-032-XP25-ON06-02C | * | ● | 32 | 44 | 25 | 55 | 111 | 4 | 2 | 0.4 | |
| FMA07-040-XP25-ON06-03 | | ○ | 40 | 52 | 25 | 50 | 106 | 4 | 3 | 0.4 | ONHU08T5 |
| FMA07-032-XP25-ON08-02 | | ● | 32 | 47 | 25 | 55 | 111 | 5 | 2 | 0.4 | |
| FMA07-040-XP25-ON08-03 | | ● | 40 | 55 | 25 | 55 | 111 | 5 | 3 | 0.5 | |
| FMA07-040-XP25-ON08-03C | * | ● | 40 | 55 | 25 | 55 | 111 | 5 | 3 | 0.5 | |
| FMA07-050-XP25-ON08-04 | | ● | 50 | 65 | 25 | 55 | 111 | 5 | 4 | 0.6 | |

● Ex stock ○ On demand

* With internal cooling

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



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

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

Milling inserts

| ON** milling insert | | | HC ¹ (CVD) | | | | | | HC ¹ (PVD) | | | | | | HT | HC ² | HW | | | | | | | |
|---------------------|---------------|-----|-----------------------|--------|--------|--------|--------|--------|-----------------------|--------|--------|--------|--------|--------|--------|-----------------|--------|--------|--------|--------|---------|-------|-------|--|
| | P | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | | | | | |
| | M | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | | | | | |
| | K | | | | | ● | ● | | | ● | | | ● | ● | | ● | | | | | | | | |
| | N | | | | | | | ● | | | | | | | | ● | | | | | | | | |
| | S | | ● | | ● | | | | ● | ● | ● | ● | | | | | | | | | | | | |
| | H | | | | | | | | | | | | | | | | | | | | | | | |
| ISO | | r | YBC302 | YBC301 | YBC401 | YBM253 | YBM251 | YBM351 | YBD152 | YBD252 | YBG101 | YBG102 | YB9320 | YBG205 | YBG202 | YBG212 | YBG302 | YBG152 | YBG252 | YNG151 | YNG151C | YD101 | YD201 | |
| | ONHU060408-PF | 0.8 | ○ | | | ○ | | ● | | | | | | ● | | | | | | | | | | |
| | ONHU08T508-PF | 0.8 | ● | | ● | | | ○ | | | | | ● | ● | | | | | | | | | | |
| | ONHU060408-PM | 0.8 | ● | | ● | | ● | ● | | | | | ● | | | | | | | | | | | |
| | ONHU08T508-PM | 0.8 | ● | | ● | | ● | ● | | | | | | | | | | | | | | | | |

● Ex stock ○ On demand

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

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

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System code > B26

Grade selection > B24

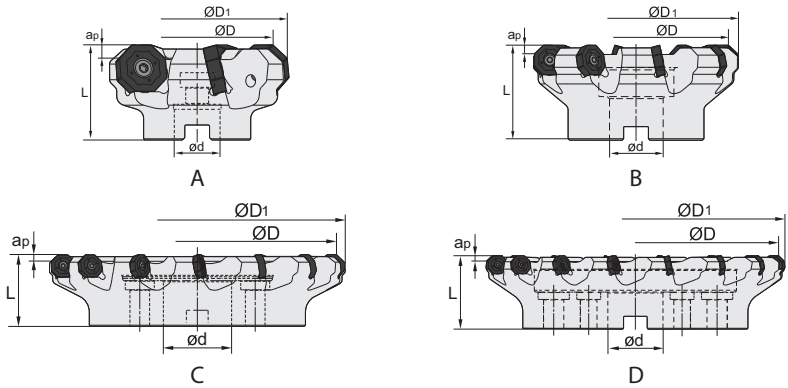
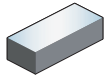
Technical info > B463

Cutting data > B224



Face milling

FMA07 Kr: 45°



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

● Ex stock ○ On demand

* With internal cooling

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

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

Milling inserts

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

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

| ON** milling insert | | ISO | | | | | | | | |
|---------------------|---------------|-----------------------|---|---|-----------------------|---|---|----|-----------------|----|
| | | HC ¹ (CVD) | | | HC ¹ (PVD) | | | HT | HC ² | HW |
| | ONHU060408-PF | 0.8 | ○ | ○ | ● | ● | ● | ● | | |
| | ONHU08T508-PF | 0.8 | ● | ● | ○ | ● | ● | | | |
| | ONHU060408-PM | 0.8 | ● | ● | ● | ● | ● | | | |
| | ONHU08T508-PM | 0.8 | ● | ● | ● | ● | | | | |

● Ex stock ○ On demand

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

Notes

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

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Notes section containing horizontal dotted lines for writing.