

# FMA 11 Kr: 45°





## New face mill generation

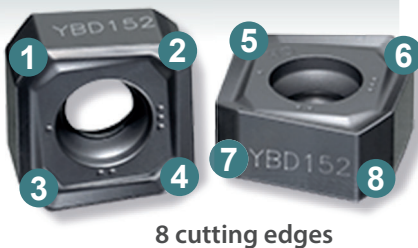
- Double sided, extra thick insert with 8 cutting edges.
- Large rake angle reduces cutting forces.
- More stability for larger cutting depths.
- Wiper geometry for better surface quality.

### Insert grades

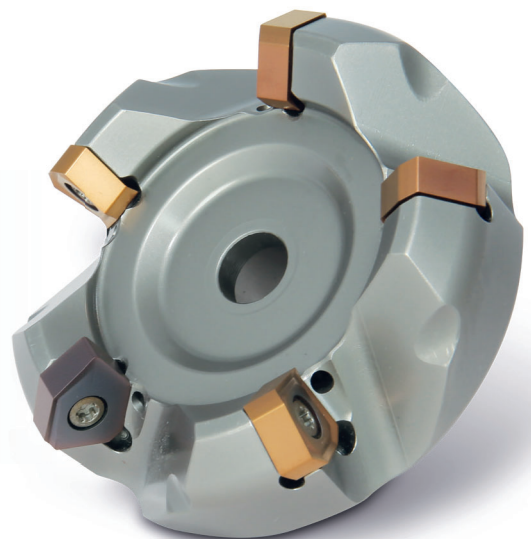
<b>YBC302</b> CVD P15 – P35	<b>YBM253</b> CVD P20 – P40	<b>YBD152</b> CVD K05 – K25
<b>YBD252</b> CVD K15 – K35	<b>YBG205</b> PVD P10 – P30 M20 – M30	<b>YB9320</b> PVD P15 – P25 M20 – M30

### Chip breakers

<b>-GM</b>  • General machining	<b>-GR</b>  • Stable cutting edge
<b>-E</b>  • Sharp cutting edge • First choice for stainless steel	<b>-W</b>  • Wiper geometry for best surface quality

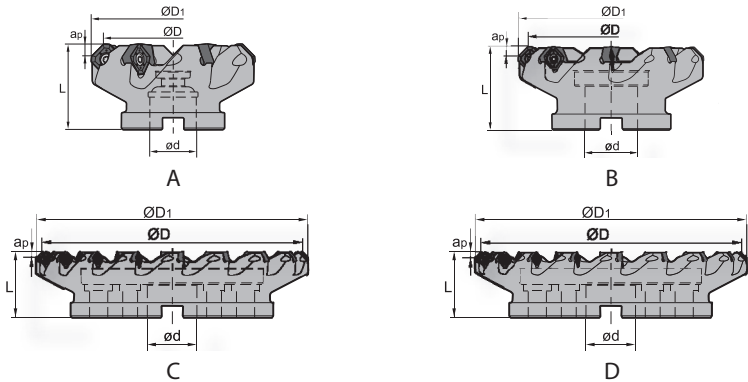
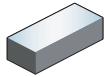


### Insert sizes



## Face milling

FMA11 Kr: 45°



Article	*	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts	
			ØD	ØD <sub>1</sub>	ød	L	a <sub>p max</sub>					
FMA11-063-A22-SN12-05		●	63	74.47	22	40	5.5	5	A	0.55	SNEG1205	
FMA11-063-A22-SN12-06		●	63	74.47	22	40	5.5	6	A	0.58		
FMA11-080-A27-SN12-06		●	80	91.47	27	50	5.5	6	A	1.14		
FMA11-100-B32-SN12-07		●	100	111.47	32	50	5.5	7	B	1.42		
FMA11-100-B32-SN12-07C	*	○	100	111.47	32	50	5.5	7	B	1.42		
FMA11-100-B32-SN12-10C	*	●	100	111.47	32	50	5.5	10	B	1.42		
FMA11-125-B40-SN12-08		●	125	136.47	40	63	5.5	8	B	2.86		
FMA11-125-B40-SN12-08C	*	○	125	136.47	40	63	5.5	8	B	2.86		
FMA11-125-B40-SN12-12C	*	●	125	136.47	40	63	5.5	12	B	2.86		
FMA11-160-C40-SN12-10		●	160	171.47	40	63	5.5	10	C	4.06		
FMA11-160-C40-SN12-15		●	160	171.47	40	63	5.5	15	C	4.06		
FMA11-200-C60-SN12-14		●	200	212.08	60	63	5.5	14	C	6.89		
FMA11-063-A22-SN15-05		●	63	77.4	22	40	7	5	A	0.56		SNEG1506
FMA11-080-A27-SN15-06		●	80	94.4	27	50	7	6	A	1.06		
FMA11-100-B32-SN15-07		●	100	114.4	32	50	7	7	B	1.47		
FMA11-100-B32-SN15-07C	*	○	100	114.4	32	50	7	7	B	1.47		
FMA11-100-B32-SN15-09C	*	●	100	114.4	32	50	7	9	B	1.47		
FMA11-125-B40-SN15-08		●	125	139.4	40	63	7	8	B	2.7		
FMA11-125-B40-SN15-08C	*	○	125	139.4	40	63	7	8	B	2.7		
FMA11-125-B40-SN15-10C	*	●	125	140.25	40	63	7	10	B	3.1		
FMA11-160-C40-SN15-10		●	160	174.4	40	63	7	10	C	3.92		
FMA11-160-C40-SN15-13		●	160	175.25	40	63	7	13	C	4.14		
FMA11-200-C60-SN15-12		●	200	214.4	60	63	7	12	C	5.46		
FMA11-250-C60-SN15-14		●	250	264.4	60	63	7	14	C	11.26		
FMA11-315-D60-SN15-18		○	315	329.4	60	80	7	18	D	20		
FMA11-125-B40-SN19-07		●	125	142.63	40	63	9	7	B	3	SNEG1907	
FMA11-125-B40-SN19-07C	*	●	125	142.63	40	63	9	7	B	3		
FMA11-160-C40-SN19-09		●	160	167.63	40	63	9	9	C	4.25		
FMA11-200-C60-SN19-11		●	200	217.63	60	63	9	11	C	6.18		

● Ex stock    ○ On demand


\* With internal cooling

System code > B26

Grade selection > B24





Technical info > B463

Cutting data > B224




Article	* Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts 
		ØD	ØD <sub>1</sub>	ød	L	a <sub>p</sub> max				
FMA11-250-C60-SN19-13	●	250	267.63	60	63	9	13	C	11.55	SNEG1907
FMA11-315-D60-SN19-16	○	315	332.63	60	80	9	16	D	20.9	

● Ex stock ○ On demand







\* With internal cooling

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

### Milling inserts

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

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

SN** negative insert				HC <sup>1</sup> (CVD)					HC <sup>1</sup> (PVD)					HT	HC <sup>2</sup>	HW							
		P	M	K	N	S	H	P	M	K	N	S	H										
		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201	
	SNEG1506ANR-E	0.9	1.3										●										
	SNEG1205ANR-GM	0.8	1.05	●	●	●						●											
	SNEG1506ANR-GM	0.9	1.3	●	●	●							●										
	SNEG1205ANR-GR	0.8	1.05	●	●	●																	
	SNEG1506ANR-GR	0.9	1.3	●	●	●																	
	SNEG1907ANR-GR	1	1.67	●	●	●	●																

● Ex stock ○ On demand

HC<sup>1</sup> Coated carbide  
 HT Uncoated cermet  
 HC<sup>2</sup> Coated cermet  
 HW Uncoated carbide

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

**A**

Turning

**B**

Milling

**C**

Drilling

**D**

Technical Information

**E**

Index

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

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

## Milling inserts

SN** negative insert			HC <sup>1</sup> (CVD)						HC <sup>1</sup> (PVD)					HT	HC <sup>2</sup>	HW							
	<b>P</b>		●	●	●	●	●	●	●	●	●	●	●	●	●								
	<b>M</b>		●	●	●	●	●	●	●	●	●	●	●	●	●								
	<b>K</b>									●						●							
	<b>N</b>									●					●	●							
	<b>S</b>			●	●					●	●	●	●										
	<b>H</b>																						
ISO	r1	r2	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SNEG1205ANR-W	0.6	0.8											●									

● Ex stock    ○ On demand

HC<sup>1</sup> Coated carbide  
 HT Uncoated cermet  
 HC<sup>2</sup> Coated cermet  
 HW Uncoated carbide

