



XMR01 Kr: 11/16/22°

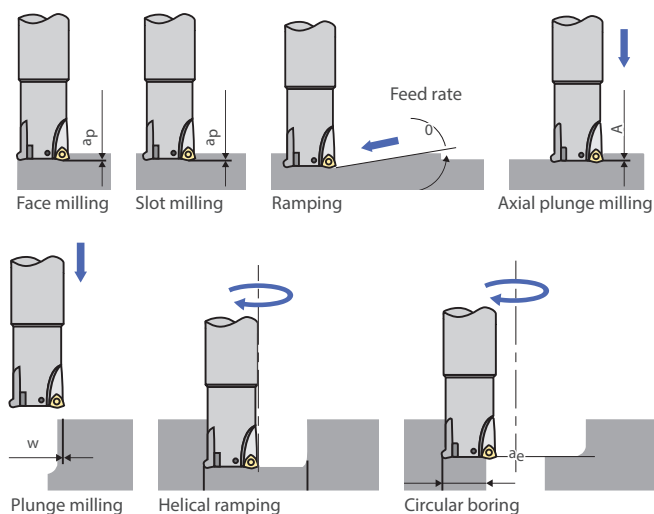
High-feed mill

- Wide range of inserts and grades.
- High-feed mill for high chip removal rates.
- Low cutting forces even with large projecting lengths.

Insert grades

YBC302 CVD P15–P35	YBM253 CVD P20–P40 M10–M30	YBG205 PVD P10–P30 M20–M30	YBG202 PVD P10–P30
YBG302 CVD P15–P35	YBG212 PVD M10–M25	YBM351 CVD P25–P40	YBD252 CVD K15–K35

Machining operations



Chip breakers

-ZSR



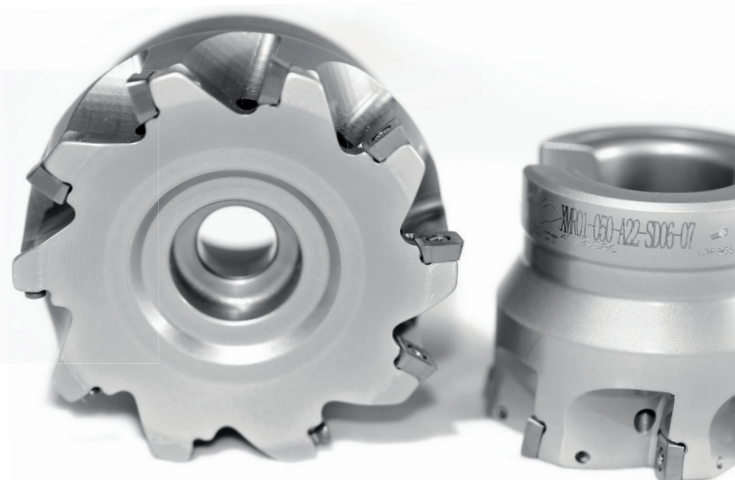
-PM



-DM

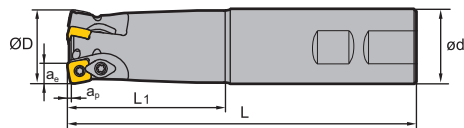
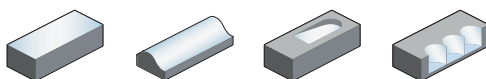


-PM



High feed milling

XMR01 Kr: 15°



S type insert, Weldon shank

Article		Stock	Dimensions [mm]						Teeth		Inserts 
			ØD	ød	a _p	ae	L ₁	L			
XMR01-025-XP25-SD06-03		○	25	25	0.8	5.8	60	140	3	0.46	SDMT06T2
XMR01-025-XP25-SD09-02		○	25	25	1.4	8.8	60	140	2	0.5	
XMR01-032-XP32-SD09-03		○	32	32	1.4	8.8	70	150	3	0.8	
XMR01-035-XP32-SD09-03		○	35	32	1.4	8.8	70	150	3	0.8	
XMR01-040-XP40-SD12-03		○	40	40	1.8	11.7	70	150	3	1.3	
XMR01-040-XP40-SD15-02		○	40	40	2.2	14	70	200	2	1.6	SDMT1505

● Ex stock ○ On demand

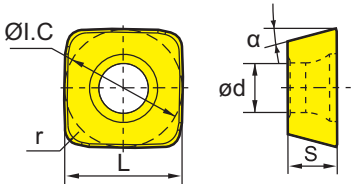
* With internal cooling

Spare parts						
Insert	SDMT06T2	SDMT09T3	SDMT1204	SDMT1505		
ØD	20-63	25-63	32-100	40-160		
Clamp		WD-204	WD-204	WD-208		
Screw (clamp)		I60M4*8.4 (3.4 Nm)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)		
Screw (insert)	I60M2.2*5.5 (0.8 Nm)		I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)		
Screw (insert)		I60M3.5*08TT (2.7 Nm)				
Wrench (clamp)		WT15IP	WT15IP	WT20IP		
Wrench (insert)	WT07IP	WT10IP	WT15IP	WT20IP		

Milling inserts

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

SDMT	L	I.C	S	d
06 T2	6.35	6.35	2.58	2.5
09 T3	9.525	9.525	3.97	4
12 04	12.7	12.7	4.76	4.4
15 05	15.875	15.875	5.56	5.5

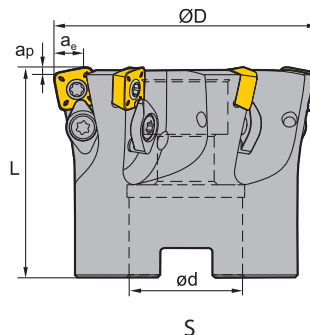
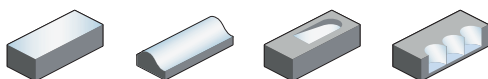
SD** milling insert						HC ¹ (CVD)						HC ¹ (PVD)				HT		HC ²	HW							
				P																						
				M																						
				K																						
				N																						
				S																						
				H																						
ISO				r	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SDMT06T208-DM	0.8	15								○							○								
	SDMT09T312-DM	1.2	15	●							●	○						●		●						
	SDMT120412-DM	1.2	15	●							●	○						●	○							
	SDMT150520-DM	2	15																○							
	SDMT06T208-PM	0.8	15	●			●										●									
	SDMT09T312-PM	1.2	15					●									●	●								
	SDMT120412-PM	1.2	15					●									●	●								
	SDMT150520-PM	2	15						○										○							

● Ex stock ○ On demand

HC ¹	Coated carbide
HT	Uncoated cermet
HC ²	Coated cermet
HW	Uncoated carbide

High feed milling

XMR01 Kr: 15°



Article	*	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ød	ap	ae	L				
XMR01-050-A22-SD06-07		○	50	22	0.8	5.8	40	7	A	0.36	SDMT06T2
XMR01-063-A22-SD06-10		○	63	22	0.8	5.8	40	10	A	0.53	
XMR01-063-A27-SD06-10		○	63	27	0.8	5.8	50	10	A	0.57	
XMR01-040-A16-SD09-04		○	40	16	1.4	8.8	40	4	A	0.182	SDMT09T3
XMR01-050-A22-SD09-04		●	50	22	1.4	8.8	40	4	A	0.3	
XMR01-050-A22-SD09-04C	*	●	50	22	1.4	8.8	40	4	A	0.3	
XMR01-063-A22-SD09-06		●	63	22	1.4	8.8	40	6	A	0.5	SDMT1204
XMR01-063-A22-SD09-06C	*	●	63	22	1.4	8.8	40	6	A	0.5	
XMR01-063-A27-SD09-06		○	63	27	1.4	8.8	50	6	A	0.6	
XMR01-063-A27-SD09-06C	*	○	63	27	1.4	8.8	50	6	A	0.6	SDMT1505
XMR01-063-A22-SD09-07		●	63	22	1.4	8.8	40	7	A	0.44	
XMR01-063-A22-SD12-05		●	63	22	1.8	11.7	40	5	A	0.5	
XMR01-063-A22-SD12-05C	*	●	63	22	1.8	11.7	40	5	A	0.5	SDMT1204
XMR01-063-A27-SD12-05		●	63	27	1.8	11.7	50	5	A	0.6	
XMR01-063-A27-SD12-05C	*	●	63	27	1.8	11.7	50	5	A	0.6	
XMR01-063-A22-SD12-06		●	63	22	1.8	11.7	50	6	A	0.55	SDMT1204
XMR01-066-A27-SD12-05C	*	○	66	27	1.8	11.7	50	5	A	0.56	
XMR01-080-A27-SD12-05		●	80	27	1.8	11.7	63	5	A	0.9	
XMR01-080-A27-SD12-05C	*	●	80	27	1.8	11.7	63	5	A	0.9	SDMT1505
XMR01-080-A27-SD12-06C	*	●	80	27	1.8	11.7	50	6	A	0.9	
XMR01-080-A27-SD12-07		●	80	27	1.8	11.7	50	7	A	0.93	
XMR01-080-A27-SD12-08		●	80	27	1.8	11.7	50	8	A	0.92	SDMT1505
XMR01-100-B32-SD12-06		●	100	32	1.8	11.7	50	6	B	1.8	
XMR01-100-B32-SD12-06C	*	●	100	32	1.8	11.7	50	6	B	1.8	
XMR01-100-B32-SD15-07		○	100	32	2.2	14	50	7	B	1.2	SDMT1505
XMR01-125-B40-SD15-09		○	125	40	2.2	14	63	9	B	2.9	

● Ex stock ○ On demand

* With internal cooling

System code > B26

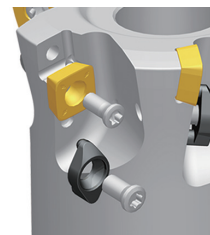
Grade selection > B24

Technical info > B463

Cutting data > B224

Spare parts

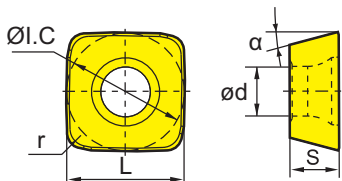
	Insert ØD	SDMT06T2 20-63	SDMT09T3 25-63	SDMT1204 32-100	SDMT1505 40-160
	Clamp		WD-204	WD-204	WD-208
	Screw (clamp)		I60M4*8.4 (3.4 Nm)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)	I60M2.2*5.5 (0.8 Nm)		I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)
	Screw (insert)		I60M3.5*8TT (2.7 Nm)		
	Wrench (clamp)		WT15IP	WT15IP	WT20IP
	Wrench (insert)	WT07IP	WT10IP	WT15IP	WT20IP



Milling inserts

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

SDMT	L	I.C	S	d
06 T2	6.35	6.35	2.58	2.5
09 T3	9.525	9.525	3.97	4
12 04	12.7	12.7	4.76	4.4
15 05	15.875	15.875	5.56	5.5

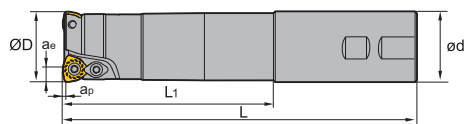
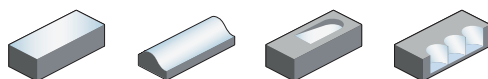
SD** milling insert				HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW						
				P																				
				M																				
				K																				
				N																				
				S																				
				H																				
ISO		r	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SDMT06T208-DM	0.8	15						○							○								
	SDMT09T312-DM	1.2	15	●					●	○						●		●						
	SDMT120412-DM	1.2	15	●					●	○						●	○							
	SDMT150520-DM	2	15														○							
	SDMT06T208-PM	0.8	15	●			●								●									
	SDMT09T312-PM	1.2	15				●								●	●								
	SDMT120412-PM	1.2	15				●								●	●								
	SDMT150520-PM	2	15				○									○								

● Ex stock ○ On demand

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

High feed milling

XMR01 Kr: 11°-22°



W type insert, Weldon shank

Article		Stock	Dimensions [mm]						Teeth			Inserts
			ØD	ød	a _p	ae	L ₁	L				
XMR01-020-XP20-WP05-02-M		○	20	20	1.5	3.8	50	130	2	0.2	WPGT0503	
XMR01-020-XP20-WP05-02-L		○	20	20	1.5	3.8	100	180	2	0.3		
XMR01-020-XP20-WP05-02-XL		○	20	20	1.5	3.8	130	250	2	0.8		
XMR01-025-XP25-WP06-02-M		○	25	25	1.5	4.35	60	140	2	0.4	WPGT0604	
XMR01-025-XP25-WP06-02-L		○	25	25	1.5	4.35	120	200	2	0.6		
XMR01-025-XP25-WP06-02-XL		○	25	25	1.5	4.35	180	300	2	1		
XMR01-032-XP32-WP06-03-M		○	32	32	1.5	4.35	70	150	3	0.8		
XMR01-032-XP32-WP06-03-L		○	32	32	1.5	4.35	120	200	3	1		
XMR01-032-XP32-WP06-03-XL		○	32	32	1.5	4.35	180	300	3	1.6		
XMR01-040-XP32-WP06-03-M		○	40	32	1.5	4.35	50	150	3	0.9	WPGT0604	
XMR01-040-XP32-WP06-03-XL		○	40	32	1.5	4.35	50	300	3	1.8		

● Ex stock ○ On demand

* With internal cooling

variabler Einstellwinkel (Einstellwinkel ist hier plattengrößenabhängig)- lead angle:
WPGT05 insert: 16°; WPGT06 insert: 22°; WPGT08 insert: 11°; WPGT09 insert: 21°

Spare parts				
	Insert	WPGT0503	WPGT0604	
	ØD	20	25-40	
	Clamp			
	Screw (clamp)			
	Screw (insert)		I60M4*8.4 (3.4 Nm)	
	Screw (insert)	I60M3.5*08TT (2.7 Nm)		
	Wrench (clamp)			
	Wrench (insert)	WT10IP	WT15IP	

System code > B26

Grade selection > B24

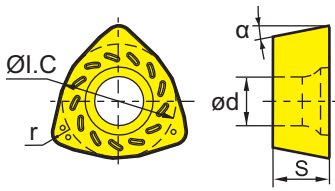
Technical info > B463

Cutting data > B224

Milling inserts

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

WPGT	I.C	S	d
05 03	7.94	3.5	4
06 04	9.525	4.2	4.4
08 06	12.85	6.35	5.5

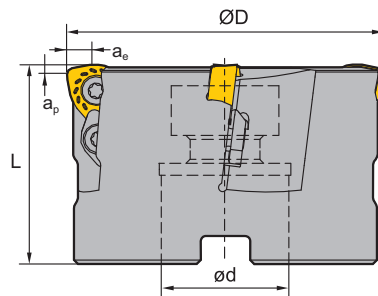
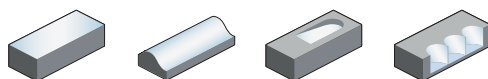
WP** positive insert			HC ¹ (CVD)								HC ¹ (PVD)						HT	HC ²	HW					
			P																					
			M																					
			K																					
			N																					
			S																					
			H																					
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	WPGT050315ZSR-PM	1.5												●										
	WPGT060415ZSR-PM	1.5	●											●										
	WPGT080615ZSR-PM	1.5	●											●										
	WPGT050315ZSR	1.5	●					●									●							
	WPGT060415ZSR	1.5	●					●						●		●								
	WPGT080615ZSR	1.5	●					●						●		●								

● Ex stock ○ On demand

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

High feed milling

XMR01 Kr: 11°-22°



W type insert, Arbor mounting

Article	*	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ød	ap	ae	L				
XMR01-050-A22-WP06-04		●	50	22	1.5	4.35	50	4	A	0.4	WPGT0604
XMR01-050-A22-WP06-04C	*	●	50	22	1.5	4.35	50	4	A	0.4	
XMR01-050-A22-WP08-03		○	50	22	1.5	5.66	50	3	A	0.4	WPGT0806
XMR01-063-A22-WP08-04		●	63	22	1.5	5.66	50	4	A	0.7	
XMR01-063-A27-WP08-04		●	63	27	1.5	5.66	50	4	A	0.7	
XMR01-063-A22-WP08-04C	*	●	63	22	1.5	5.66	50	4	A	0.7	
XMR01-063-A27-WP08-04C	*	○	63	27	1.5	5.66	50	4	A	0.7	
XMR01-080-A27-WP08-05		●	80	27	1.5	5.66	63	5	A	1.5	
XMR01-080-A27-WP08-05C	*	●	80	27	1.5	5.66	63	5	A	1.5	WPGT0907
XMR01-100-B32-WP08-06		●	100	32	1.5	5.66	63	6	B	2.2	
XMR01-125-B40-WP08-07		●	125	40	1.5	5.66	63	7	B	3.5	
XMR01-160-B40-WP08-08		○	160	40	1.5	5.66	63	8	B	6	
XMR01-063-A22-WP09-03C	*	○	63	22	3	6.8	50	3	A	0.7	WPGT0907
XMR01-080-A27-WP09-04C	*	○	80	27	3	6.8	63	4	A	1.4	
XMR01-100-B32-WP09-05		○	100	32	3	6.8	63	5	B	2.1	
XMR01-125-B40-WP09-06		○	125	40	3	6.8	63	6	B	3.7	
XMR01-160-B40-WP09-07		○	160	40	3	6.8	63	7	B	6.3	

● Ex stock ○ On demand

* With internal cooling

variabler Einstellwinkel (Einstellwinkel ist hier plattengrößenabhängig)- lead angle:

WPGT05 insert: 16°; WPGT06 insert: 22°; WPGT08 insert: 11°; WPGT09 insert: 21°

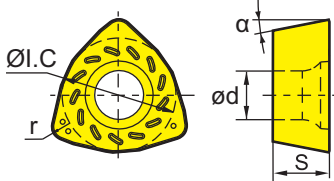
Spare parts

	Insert ØD	WPGT0604 50	WPGT0806 50-160	WPGT0907 3-160	
	Clamp		WD-208	WD-208	
	Screw (clamp)		I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	
	Screw (insert)	I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	
	Wrench (clamp)		WT20IT	WT20IT	
	Wrench (insert)	WT15IS			
	Wrench (insert)		WT20IT	WT20IT	

Milling inserts

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

WPGT	I.C	S	d
06 04	9.525	4.2	4.4
08 06	12.85	6.35	5.5
09 07	15	7	5.5

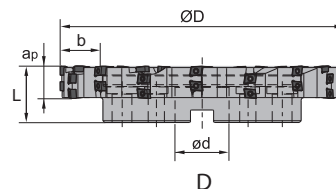
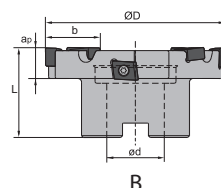
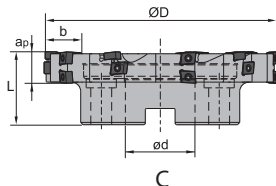
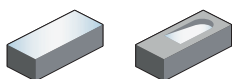
WP** positive insert		HC ¹ (CVD)						HC ¹ (PVD)				HT	HC ²	HW									
	P																						
	M																						
	K																						
	N																						
	S																						
	H																						
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	WPGT060415ZSR-PM	1.5	●											●									
	WPGT080615ZSR-PM	1.5	●											●									
	WPGT090725ZSR-PM	2.5												●									
	WPGT060415ZSR	1.5	●					●						●		●							
	WPGT080615ZSR	1.5	●					●						●		●							
	WPGT090725ZSR	2.5						●						●		○							

● Ex stock ○ On demand

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

Bore milling

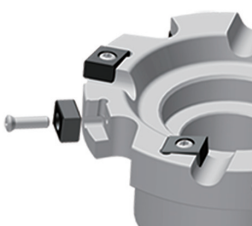
XMP01 Kr: 90°



Article	✱	Stock	Dimensions [mm]					Teeth	Coupling		Inserts 
			ØD	ød	b	ap	L				
XMP01-080*18-B27-CNE1210-08		●	80	27	18	15	50	8	B	0.67	CNE12
XMP01-100*18-B32-CNE1210-08		●	100	32	18	20	50	8	B	0.99	
XMP01-125*27-B40-CNE1210-15		●	125	40	27	22.5	63	15	B	2.46	
XMP01-160*27-C40-CNE1210-18		●	160	40	27	25	63	18	C	3.7	
XMP01-200*27-C60-CNE1210-21		●	200	60	27	31.5	63	21	C	5.46	
XMP01-250*36-C60-CNE1210-32		●	250	40	36	56.5	63	32	C	9.79	
XMP01-315*36-D60-CNE1210-42		●	315	60	36	47.5	63	42	D	17.65	
XMP01-400*36-D60-CNE1210-52		●	400	60	36	36	63	52	D	27.36	

● Ex stock ○ On demand

✱ With internal cooling

Spare parts			
	Insert	CNE12	
	ØD	80-400	
	Screw (insert)	I60M4*12 (3.4 Nm)	
	Wrench (insert)	WT15IP	

System code > B26

Grade selection > B24

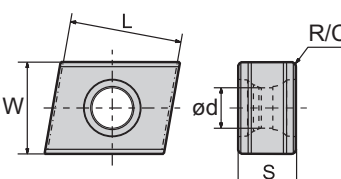
Technical info > B463

Cutting data > B224

Milling inserts

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

CNE	L	S	d
12	12.8	6.35	4.4

CN** milling insert			HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW								
			P	      								    													
			M	    								    													
			K						 				 												
			N															 							
			S			 				   															
			H																						
ISO			R/C	W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	CNE121006A	0.4	10				●																		
	CNE121006B	0.6	10				○				●														

● Ex stock ○ On demand

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

A

Turning

B

Milling

C

Drilling

D

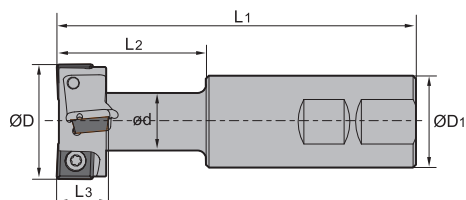
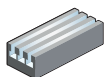
Technical
Information

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T-slot milling

TMP01 Kr: 90°



Weldon shank

Article	✱	Stock	Dimensions [mm]						Teeth	No. of inserts	T-slot specification	Inserts
			ØD	ØD ₁	ød	L ₁	L ₂	L ₃				
TMP01-021-XP25-MP06-01		●	21	25	10	100	32	9	1	2	12	MPHT0603
TMP01-025-XP25-MP06-01		●	25	25	12	100	35	11	1	2	14	
TMP01-032-XP32-MP08-02		●	32	32	15	110	45	14	2	4	18	MPHT0803
TMP01-040-XP32-MP12-02		●	40	32	19	125	55	18	2	4	22	MPHT1204
TMP01-050-XP40-MP12-02		●	50	40	25	140	65	22	2	4	28	
TMP01-060-XP50-MP12-02		●	60	50	32	160	80	28	2	6	36	

● Ex stock ○ On demand

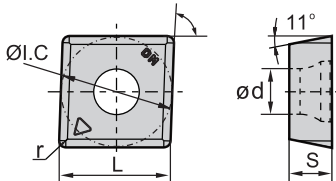
✱ With internal cooling

Spare parts					
Insert	MPHT0603	MPHT0803	MPHT1204		
ØD	21-25	32	40-60		
Screw (insert)	I60M2.5*5.5 (1.0 Nm)	I60M3*7 (1.8 Nm)	I60M5*10 (6.7 Nm)		
Wrench (insert)	WT07IP	WT09IP			
Wrench (insert)			WT20IT		

Milling inserts

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

MPHT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
08 03	8.3	8.3	3.18	3.4
12 04	12.7	12.7	4.76	5.56

MP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	MPHT060304-DM	0.4	●				●										●						
	MPHT080305-DM	0.5	●				●											●					
	MPHT120408-DM	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

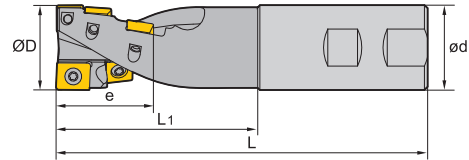
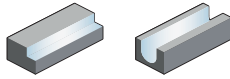
Technical
Information

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Helical milling

HMP01 Kr: 90°

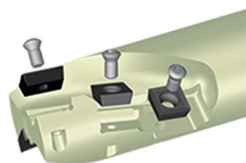


Weldon shank

Article	*	Stock	Dimensions [mm]					Teeth row	Teeth		Shank type	Inserts
			ØD	e	ød	L ₁	L		APKT	SPMT		
HMP01-040x55-XP40-SP12-02	●		40	55	40	95	175	2	1	5	Weldon	APKT1504 & SPMT1204
HMP01-050x55-XP40-SP12-04	●		50	55	40	95	175	4	2	10	Weldon	

● Ex stock ○ On demand

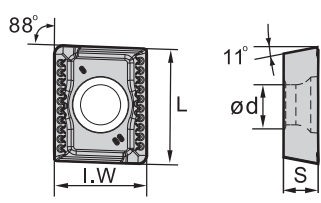
* With internal cooling

Spare parts				
	Insert	APKT1504 & SPMT1204	APKT1504 & SPMT1204	
	ØD	40	50	
	Screw (insert)	I60M5*10 (6.7 Nm)	I60M5*13 (6.7 Nm)	
	Wrench (insert)	WT20T	WT20T	

Milling inserts

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

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert				HC ¹ (CVD)								HC ¹ (PVD)					HT		HC ²	HW					
				P	       								       					 							
				M	     								     					 							
				K									     												
				N																	 				
				S	 								   												
				H																					
ISO			r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	APKT150412-KM		1.2	12.7																●					
	APKT150412-PM		1.2	12.7				●												●					

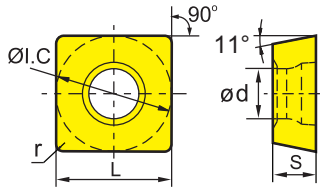
● Ex stock ○ On demand

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

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

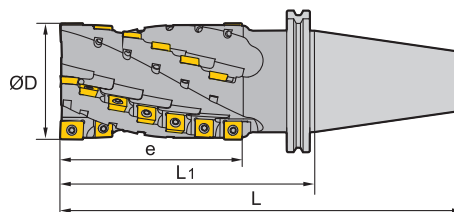
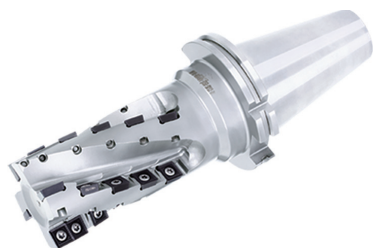
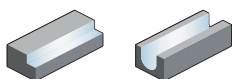
SP** milling insert							HC ¹ (CVD)				HC ¹ (PVD)				HT	HC ²	HW							
			P																					
			M																					
			K																					
			N																					
			S																					
			H																					
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-KM		0.8																●					
	SPMT120408-PM		0.8				●												●					

● Ex stock ○ On demand

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

Helical milling

HMP01 Kr: 90°



Article	*	Stock	Dimensions [mm]				Teeth row	Teeth		Shank type	Inserts
			ØD	e	L ₁	L		APKT	SPMT		
HMP01-050x84-BT50-SP12-04		○	50	84	145	246.8	4	2	16	BT	APKT1504 & SPMT1204
HMP01-050x84-JT50-SP12-04		○	50	84	145	246.75	4	2	16	JT	
HMP01-063x74-BT50-SP12-04		○	63	74	135	236.8	4	2	14	BT	
HMP01-063x74-JT50-SP12-04		○	63	74	135	236.75	4	2	14	JT	
HMP01-063x104-BT50-SP12-04		○	63	104	165	266.8	4	2	20	BT	
HMP01-063x104-JT50-SP12-04	●		63	104	165	266.75	4	2	20	JT	
HMP01-063x134-BT50-SP12-04		○	63	134	195	296.8	4	2	26	BT	
HMP01-063x134-JT50-SP12-04		○	63	134	195	296.75	4	2	26	JT	
HMP01-080x104-BT50-SP12-04		○	80	104	165	266.8	4	2	20	BT	
HMP01-080x104-JT50-SP12-04		○	80	104	165	266.75	4	2	20	JT	
HMP01-080x144-BT50-SP12-04		○	80	144	205	306.8	4	2	28	BT	
HMP01-080x144-JT50-SP12-04		○	80	144	205	306.75	4	2	28	JT	

● Ex stock ○ On demand

* With internal cooling

Spare parts			
	Insert	APKT1504 & SPMT1204	
	ØD	50-80	
	Screw (insert)	I60M5*10 (6.7 Nm)	
	Wrench (insert)	WT20IS	

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

Milling inserts

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

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert														HC ¹ (CVD)					HC ¹ (PVD)					HT		HC ²		HW	
				P																									
				M																									
				K																									
				N																									
				S																									
				H																									
ISO			r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201				
	APKT150412-KM		1.2	12.7																●									
	APKT150412-PM		1.2	12.7				●												●									

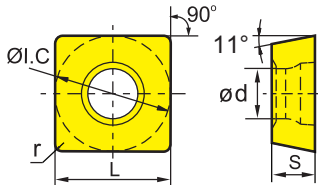
● Ex stock ○ On demand

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

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

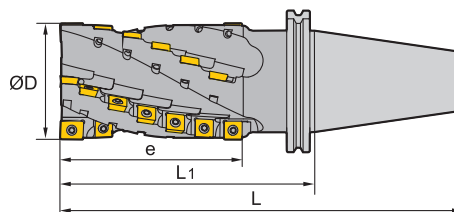
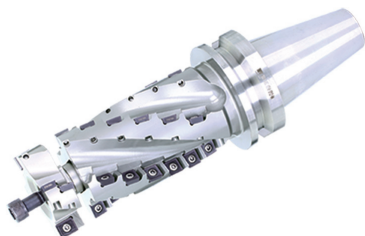
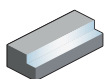
SP** milling insert			Material compatibility																					
				HC ¹ (CVD)						HC ¹ (PVD)				HT	HC ²	HW								
			P																					
			M																					
			K																					
			N																					
			S																					
H																								
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-KM		0.8																●					
	SPMT120408-PM		0.8				●												●					

● Ex stock ○ On demand

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

Helical milling

HMP01 EC Kr: 90°



Article	*	Stock	Dimensions [mm]				Teeth row	Teeth		Shank type	Inserts
			ØD	e	L ₁	L		APKT	SPMT		
HMP01-050x84EC-BT50-SP12-04	○	○	50	84	145	246.8	4	2	16	BT	APKT1504 & SPMT1204
HMP01-050x84EC-JT50-SP12-04	●	○	50	84	145	246.75	4	2	16	JT	
HMP01-063x74EC-BT50-SP12-04	○	○	63	74	135	236.8	4	2	14	BT	
HMP01-063x74EC-JT50-SP12-04	○	○	63	74	135	236.75	4	2	14	JT	
HMP01-063x104EC-BT50-SP12-04	○	○	63	104	165	266.8	4	2	20	BT	
HMP01-063x104EC-JT50-SP12-04	○	○	63	104	165	266.75	4	2	20	JT	
HMP01-063x134EC-BT50-SP12-04	○	○	63	134	195	296.8	4	2	26	BT	
HMP01-063x134EC-JT50-SP12-04	●	○	63	134	195	296.75	4	2	26	JT	
HMP01-080x104EC-BT50-SP12-04	○	○	80	104	165	266.8	4	2	20	BT	
HMP01-080x104EC-JT50-SP12-04	○	○	80	104	165	266.75	4	2	20	JT	
HMP01-080x144EC-BT50-SP12-04	○	○	80	144	205	306.8	4	2	28	BT	
HMP01-080x144EC-JT50-SP12-04	○	○	80	144	205	306.75	4	2	28	JT	

● Ex stock ○ On demand

* With internal cooling

Spare parts					
	Insert	APKT1504 & SPMT1204	APKT1504 & SPMT1204	APKT1504 & SPMT1204	
	ØD	50	63	80	
	Indexable head	050EC	063EC	080EC	
	Screw (head)	M10*50 (16.6 Nm)	M10*50 (16.6 Nm)	M12*55 (25.2 Nm)	
	Screw (insert)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	I60M5*13 (6.7 Nm)	
	Wrench (head)	WH80L	WH80L	WH100L	
	Wrench (insert)	WT20IS	WT20IS	WT20IS	

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

Milling inserts

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

APKT	L	S	d
15 04	16.33	4.76	5.4

AP** milling insert					HC ¹ (CVD)	HC ¹ (PVD)	HT	HC ²	HW
			P	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	
			M	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	
			K		● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			N			● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			S		● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			H						
ISO			r	I.W	YBC302 YBC301 YBC401 YBM253 YBM251 YBM351 YBD152 YBD252	YBG101 YBG102 YB9320 YBG205 YBG202 YBG212 YBG302 YBG152 YBG252 YNG151		YNG151C	YD101 YD201
	APKT150412-KM	1.2	12.7						
	APKT150412-PM	1.2	12.7	●					

● Ex stock ○ On demand

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

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** milling insert					HC ¹ (CVD)	HC ¹ (PVD)	HT	HC ²	HW
			P	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	
			M	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	
			K		● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			N			● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			S		● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ●
			H						
ISO			r	I.W	YBC302 YBC301 YBC401 YBM253 YBM251 YBM351 YBD152 YBD252	YBG101 YBG102 YB9320 YBG205 YBG202 YBG212 YBG302 YBG152 YBG252 YNG151		YNG151C	YD101 YD201
	SPMT120408-KM	0.8							
	SPMT120408-PM	0.8	●						

● Ex stock ○ On demand

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

Chamfer milling

CMZ01 Kr: 30°

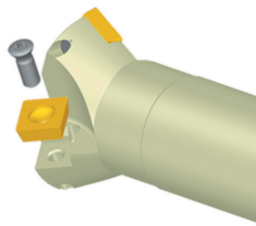


Straight shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMZ01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMZ01-025-G25-SP12-02		●	25	25	40	120	2	0.8	
CMZ01-032-G32-SP12-03		●	32	32	40	180	3	1.1	

● Ex stock ○ On demand

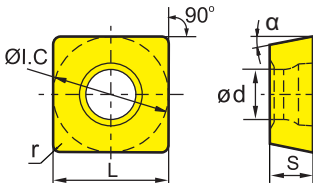
* With internal cooling

Spare parts		
Insert	SPMT1204	
ØD	12-32	
 Screw (insert)	I43M5*11 (6.7 Nm)	
 Wrench (insert)	WT20IS	

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-HT-1	0.8														○							
	SPMT120408	0.8	○	●	○		●	○								○							

● Ex stock ○ On demand

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

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Chamfer milling

CMZ01 Kr: 30°

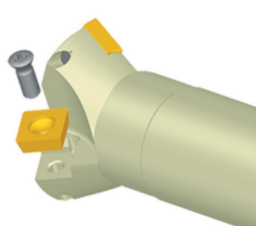


Weldon shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMZ01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMZ01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	
CMZ01-032-XP32-SP12-03		●	32	32	40	180	3	1	

● Ex stock ○ On demand

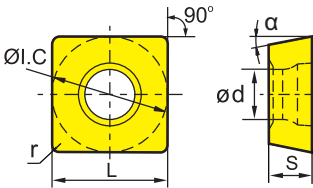
* With internal cooling

Spare parts		
Insert	SPMT1204	
ØD	12-32	
 Screw (insert)	I43M5*11 (6.7 Nm)	
 Wrench (insert)	WT20IS	

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-HT-1	0.8														○							
	SPMT120408	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

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

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Chamfer milling

CMA01 Kr: 45°

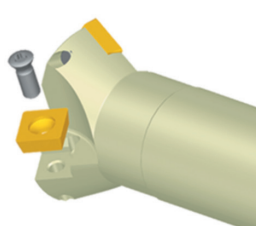


Straight shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMA01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMA01-025-G25-SP12-02		●	25	25	40	120	2	0.8	
CMA01-032-G32-SP12-03		●	32	32	40	180	3	1.1	

● Ex stock ○ On demand

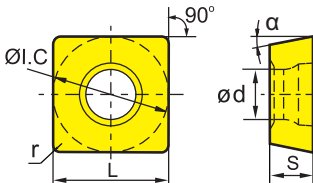
* With internal cooling

Spare parts		
Insert	SPMT1204	
ØD	12-32	
 Screw (insert)	I43M5*11 (6.7 Nm)	
 Wrench (insert)	WT20IS	

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-HT-1	0.8														○							
	SPMT120408	0.8	○	●	○		●	○								○							

● Ex stock ○ On demand

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

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Chamfer milling

CMA01 Kr: 45°

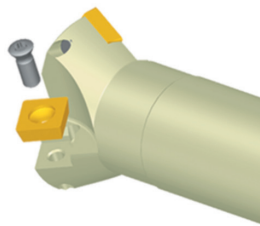


Weldon shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMA01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMA01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	
CMA01-032-XP32-SP12-03		●	32	32	40	100	3	1	

● Ex stock ○ On demand

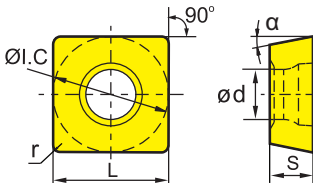
* With internal cooling

Spare parts		
Insert	SPMT1204	
ØD	12-32	
 Screw (insert)	I43M5*11 (6.7 Nm)	
 Wrench (insert)	WT20IS	

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-HT-1	0.8														○							
	SPMT120408	0.8	○	●	○		●	○								○							

● Ex stock ○ On demand

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

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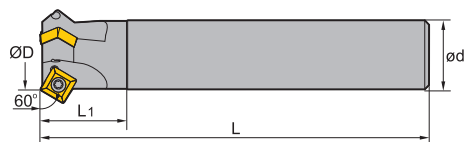
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Chamfer milling

CMD01 Kr: 60°

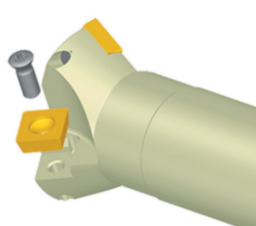


Straight shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMD01-012-G20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMD01-025-G25-SP12-02		●	25	25	40	120	2	0.8	
CMD01-036-G32-SP12-03		●	36	32	40	180	3	1	

● Ex stock ○ On demand

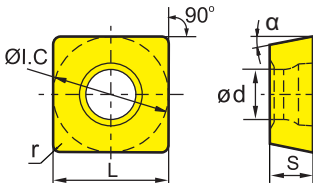
* With internal cooling

Spare parts		
Insert	SPMT1204	
ØD	12-36	
 Screw (insert)	I43M5*11 (6.7 Nm)	
 Wrench (insert)	WT20IS	

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201	
	SPMT120408-HT-1	0.8														○								
	SPMT120408	0.8	○	●	○		●	○									○							

● Ex stock ○ On demand

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

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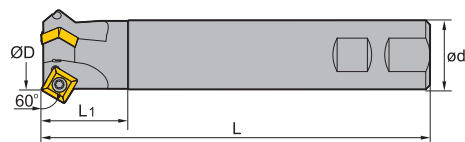
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Chamfer milling

CMD01 Kr: 60°

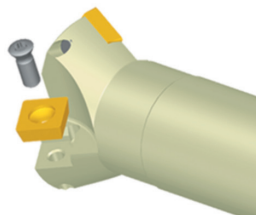


Weldon shank

Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ød	L ₁	L			
CMD01-012-XP20-SP12-01		●	12	20	40	100	1	0.2	SPMT1204
CMD01-025-XP25-SP12-02		●	25	25	40	120	2	0.6	
CMD01-036-XP32-SP12-03		●	36	32	40	180	3	1	

● Ex stock ○ On demand

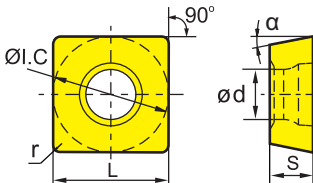
* With internal cooling

Spare parts			
Insert	SPMT1204		
ØD	12-36		
	Screw (insert)		I43M5*11 (6.7 Nm)
	Wrench (insert)		WT20IS

Milling inserts

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

SPMT	L	I.C	S	d
12 04	12.7	12.7	4.76	5.5

SP** 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	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMT120408-HT-1	0.8														○							
	SPMT120408	0.8	○	●	○		●	○									○						

● Ex stock ○ On demand

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

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