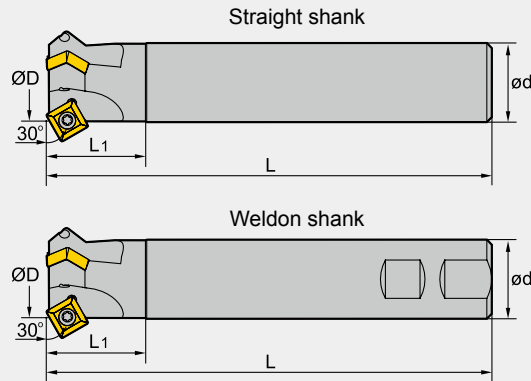


Chamfer milling tools

Kr:30°



CMZ01 P M K



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)	
		ØD	ød	L	L ₁			
Straight shank	CMZ01 -012-G20-SP12-01	△	12	20	100	40	1	0.2
	-025-G25-SP12-02	△	25	25	120	40	2	0.8
	-032-G32-SP12-03	△	32	32	180	40	3	1.1
Weldon shank	-012-XP20-SP12-01	△	12	20	100	40	1	0.2
	-025-XP25-SP12-02	△	25	25	120	40	2	0.6
	-032-XP32-SP12-03	△	32	32	180	40	3	1.0


▲Stock available △Make-to-order

Indexable milling tools

Chamfer milling tools

Spare parts

Diameter ØD	Screw	Wrench
Ø12-Ø32	I43M5×11	WT20IS



Tools code key B22-B23

Grade selection guide B18-B21

Technical data B192-B198

Chamfer milling tools

Kr:45°



Chamfering

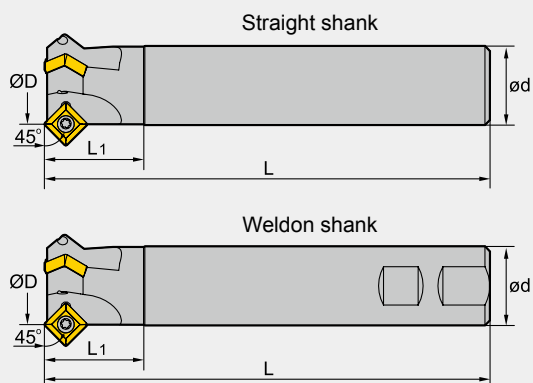


Face milling



Hole stomata chamfer

CMA01 P M K



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)
		ØD	ød	L	L ₁		
Straight shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.8
	▲	32	32	180	40	3	1.1
Weldon shank	▲	12	20	100	40	1	0.2
	▲	25	25	120	40	2	0.6
	▲	32	32	180	40	3	1.0


▲ Stock available △ Make-to-order

Indexable milling tools

Chamfer milling tools

Spare parts

Diameter ØD	Screw	Wrench
	Ø12-Ø32	I43M5×11



Tools code key **B22-B23**

Grade selection guide **B18-B21**

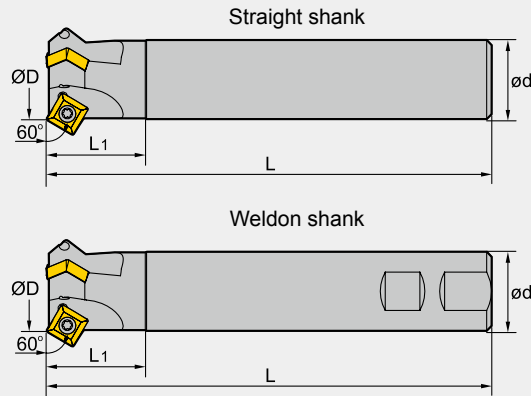
Technical data **B192-B198**

Chamfer milling tools

Kr:60°



CMD01 **P** **M** **K**



➤ **Specification of tools**


Type	Stock	Basic dimensions(mm)				Number of teeth Z	Weight (kg)	
		ØD	ød	L	L ₁			
Straight shank	▲ -012-G20-SP12-01	▲	12	20	100	40	1	0.2
	▲ -025-G25-SP12-02	▲	25	25	120	40	2	0.8
	▲ -036-G32-SP12-03	▲	36	32	180	40	3	1.0
Weldon shank	▲ -012-XP20-SP12-01	▲	12	20	100	40	1	0.2
	▲ -025-XP25-SP12-02	▲	25	25	120	40	2	0.6
	▲ -036-XP32-SP12-03	▲	36	32	180	40	3	1.0


▲ Stock available △ Make-to-order

Indexable milling tools

Chamfer milling tools

➤ **Spare parts**

Diameter ØD	Screw	Wrench
	Ø12-Ø36	 I43M5×11

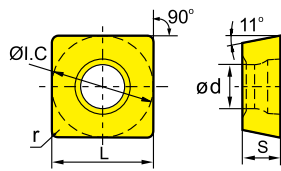


Tools code key **B22-B23**

Grade selection guide **B18-B21**

Technical data **B192-B198**

Selection of inserts



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, Ti alloy
P Steel	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊
M Stainless steel	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊
K Cast iron	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊
N Non-ferrous metal	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊
S Heat resistant alloy, Ti alloy	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊

Insert shape	Type	Basic dimensions(mm)					CVD Coating					PVD Coating				Cermet	Cemented carbide								
		Øl.C	L	r	S	ød	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC305	YD051	YD101	YD201
	SPMT120408	12.7	12.7	0.8	4.76	5.5	●	●	●							★						○			

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

➤ Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters		
			Cutting speed(m/min)	Feed speed(mm/z)	
P	Low-carbon steel, Soft steel	YBM251 YBC301	180(100—250)	0.25 (0.1-0.4)	
		YBM351 YBG302	150(100—200)	0.3 (0.1-0.5)	
		YC30S	120(80—150)	0.4 (0.1-0.5)	
	High-carbon steel, Alloy steel	180-280	YBM251 YBC301	160(100—220)	0.3 (0.1-0.4)
			YBM351 YBG302	130(100—180)	0.3 (0.1-0.5)
			YC30S	100(60—150)	0.4 (0.1-0.5)
	Alloy tool steel	280-350	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)
			YBM351 YBG302	100(80—150)	0.3 (0.1-0.5)
			YC30S	80(60—120)	0.4 (0.1-0.5)
M	Stainless steel	YBM251 YBC301	120(80—180)	0.3 (0.1-0.4)	
		YBM351 YBG302	100(80—150)	0.3 (0.1-0.5)	
		YC30S	80(60—120)	0.4 (0.1-0.5)	
K	Cast iron	180-250	YBG302	130(100—180)	0.4 (0.1-0.5)