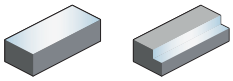
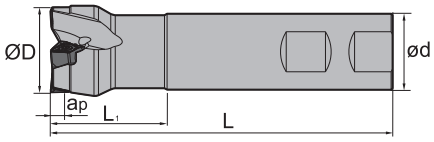
Face milling

FMP12 Kr: 90°







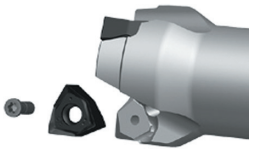
Article	✻	Stock	Dimensions [mm]					Teeth	Coupling	kg	Inserts
			ØD	ød	L_1	L	$a_{p\,max}$				
FMP12-025-XP25-WN06-02C	✻	○	25	25	30	100	5,7	2	XP	0.38	WNHU0604
FMP12-032-XP25-WN06-03C	✻	○	32	25	40	120	5,7	3	XP	0.47	
FMP12-040-XP32-WN06-04C	✻	○	40	32	40	140	5,7	4	XP	0.85	
FMP12-050-XP40-WN06-05C	✻	○	50	40	40	169	5,7	5	XP	1.59	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**WNHU0604**
	ØD	**25-50**
	Screw (insert)	I60M3x9 (1.8 Nm)
	Wrench (insert)	WT09IS

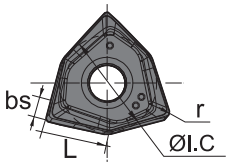


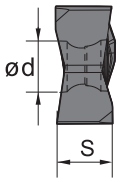
System code B26 | Grade selection B24 | Technical info B527 | Cutting data B230

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

WNHU	L	I.C	S	d
06 04	5.73	9.525	4.704	3.5

Milling inserts





WN** negative insert			HC¹ (CVD)							HC¹ (PVD)								HT	HC²	HW	
P																					
M																					
K																					
N																					
S																					
H																					
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG202	YBG212	YBS203	YBG205	YB9320	YBG302	YBS303	YBG252	YNG151	YNG151C	YD101	YD201
	**WNHU060404PNR-GM**	0.4				○			○	○						○								
	WNHU060408PNR-GM	0.8				●			○	○						○								

● Ex stock ○ On demand

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

System code > B26 Grade selection > B24 Technical info > B527 Cutting data > B230

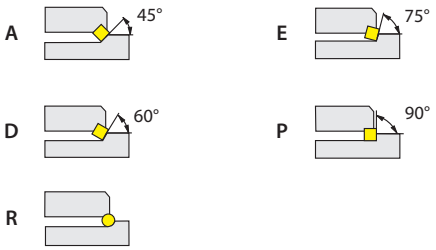
Indexable milling System code – milling bodies

FM	A	12	050	–	A22	O	–	N	06	–	04	(L)	(C)
1	2	3	4		5	6		7	8		9	10	11

Type	
Code	Description
BM	Profile milling
CM	Chamfer milling
EM	Square shoulder milling
FM	Face milling
HM	Helical milling
SM	Slot milling
TM	T-slot milling
XM	Special

1

Entering angle



2

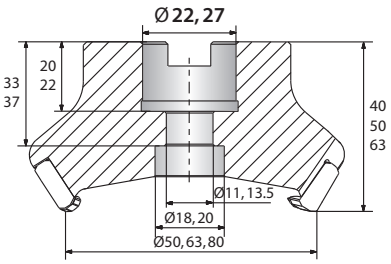
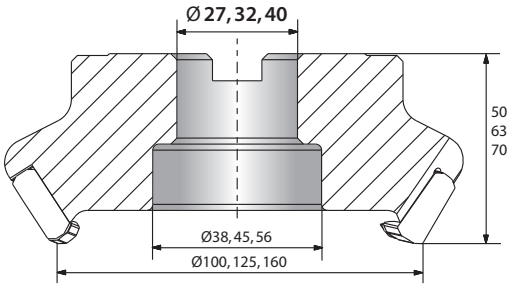
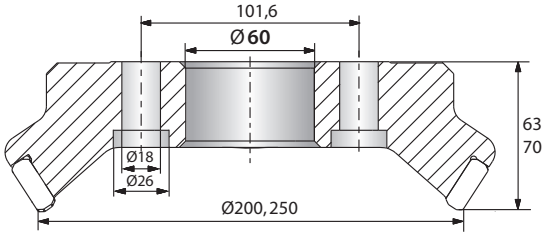
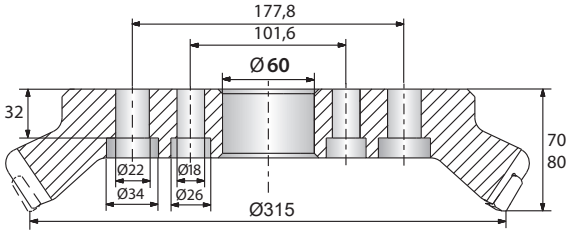
Serial number

3

Nominal diameter [mm]	
Code	Description
025	25
050	50
160	160
315	315
...	

4

Type and size of tool holders

Code	Type	Code	Type
A	Nominal diameter Ø50 – 80 mm 	B	Nominal diameter Ø100 – 160 mm 
C	Nominal diameter Ø200 – 250 mm 	D	Nominal diameter Ø315 mm 
G	Straight shank	XP	Weldon shank
K	Bore with keyway		

5

With respect to mounting please adhere to the information provided by the tool holder manufacturer.

Insert shape			
A		C	
H		L	
M		O	
P		R	
S		T	
W		X	Special
Z	Special		

6

Clearance angle			
B	5°	C	7°
D	15°	E	20°
F	25°	N	0°
P	11°		

7

Cutting edge length l [mm]	
Insert shape	
A	C, M
H, O, P	L
R	S
T	W

8

Number of teeth

9

Cutting direction	
Code	Description
L	Left

10

With inner cooling

11

Tools with B coupling and inner coolant supply require the following spare parts:



Coolant clamp screw



Coolant shower plate



Spare parts (B coupling with inner coolant supply)

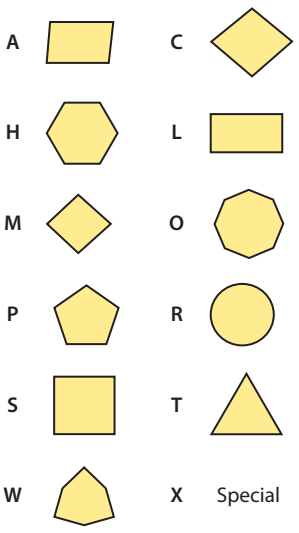
		B27	B32	B40	B40
	Ø	**80**	**100**	**125**	**160**
	**Coolant clamp screw**	LDB27C	LDB32C	LDB40C	LDB40C
	**Coolant shower plate**	B27-002-CP	B32-002-CP	B40-002-CP	B40-003-CP

When purchasing tools with inner coolant supply and B coupling these spare parts are included in delivery.

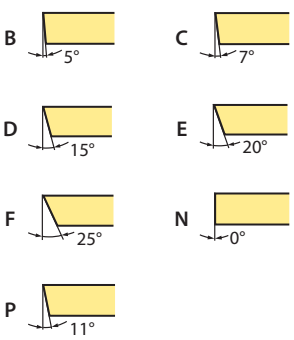
Indexable milling ISO code – inserts

S	P	K	N	12	04	ED	T21K	R	–	DM
1	2	3	4	5	6	7	8	9		10

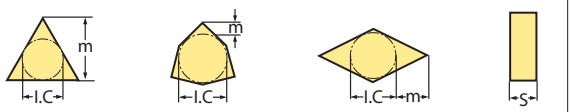
1 Insert shape



2 Clearance angle



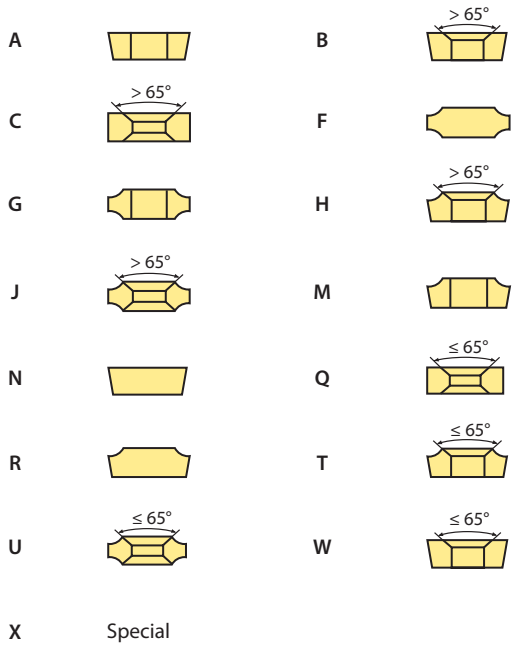
3 Tolerance class



Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,13	±0,005	±0,025
K	±0,05–0,13	±0,013	±0,025
L	±0,05–0,13	±0,025	±0,025
M	±0,05–0,13	±0,08–0,18	±0,130
N	±0,05–0,13	±0,08–0,18	±0,025
U	±0,08–0,25	±0,13–0,38	±0,130

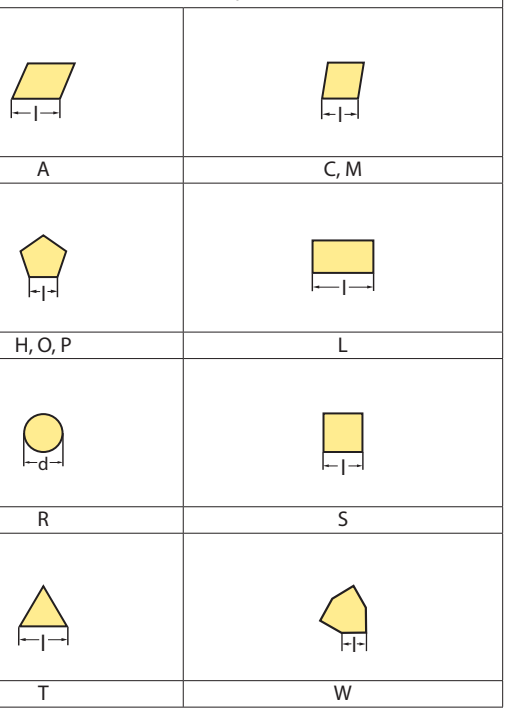
4 Fastening features (metric)

Insert shape



5 Cutting edge length l [mm]

Insert shape



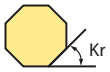
Insert thickness S [mm]



Code	S	Code	S
00	0,79	**05**	5,56
T0	0,99	**T5**	5,95
01	1,59	**06**	6,35
T1	1,98	**T6**	6,75
02	2,38	**07**	7,94
T2	2,58	**09**	9,52
03	3,18	**T9**	9,72
T3	3,97	**11**	11,11
04	4,76	**12**	12,70
T4	4,96		

6

Angle





Code	Kr	Code	αn
A	45°	**A**	3°
D	60°	**B**	5°
E	75°	**C**	7°
F	85°	**D**	15°
P	90°	**E**	20°
Z	Special	**F**	25°
		G	30°
		N	0°
		P	11°
		Z	Special

7

Chamfer

Code	Type	Code	Angle	Code	Width [mm]	Code	Position
F		**0**	5°	**0**	0,10	**K**	
E		**1**	10°	**1**	0,15		
T		**2**	15°	**2**	0,20	**P**	
S		**3**	20°	**3**	0,25		
		4	25°	**4**	0,30	**W**	
		5	30°	**5**	0,35		
				6	0,40		
				7	0,45	**–**	

8

Cutting direction

Code	Description
R	Right
L	Left
N	Right and left

9

Chip breaker overview
(on page B20)

10

Guide for recommended cutting data – indexable milling

Indexable milling – group 1 (FMA07/11/12, FMD02, EMP09/13)

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v$_c$ [m/min] HC (CVD) YBC302 a_e / D 1/1 | 3/4	YBC302 a_e / D 1/5	YBC401 a_e / D 1/1 | 3/4	YBC401 a_e / D 1/5	YBD152 a_e / D 1/1 | 3/4	YBD152 a_e / D 1/5	YBD252 a_e / D 1/1 | 3/4	YBD252 a_e / D 1/5
P	Unalloyed steel	ca. 0,15 % C	annealed	125	1	260	300	225	260				
		ca. 0,45 % C	annealed	190	2	225	255	195	225				
		ca. 0,45 % C	tempered	250	3	210	240	180	210				
		ca. 0,75 % C	annealed	270	4	185	210	160	185				
		ca. 0,75 % C	tempered	300	5	170	195	150	170				
	Low-alloyed steel		annealed	180	6	225	255	195	225				
			tempered	275	7	185	210	160	185				
			tempered	300	8	170	195	150	170				
			tempered	350	9	145	165	125	145				
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	130	150	115	130				
			hardened and tempered	325	11	95	105	80	95				
M	Stainless steel	ferritic/martensitic	annealed	200	12								
		martensitic	tempered	240	13								
		austenitic	quench hardened	180	14								
		austenitic-ferritic		230	15								
K	Grey cast iron	perlitic/ferritic		180	16					370	430	320	370
		perlitic (martensitic)		260	17					220	255	190	220
	Cast iron with spheroidal graphite	ferritic		160	18					255	295	220	255
		perlitic		250	19					170	200	145	170
	Malleable cast iron	ferritic		130	20					305	355	265	305
		perlitic		230	21					205	240	175	205
N	Aluminium wrought alloys	cannot be hardened		60	22								
		hardenable	hardened	100	23								
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24								
		≤ 12 % Si, hardenable	hardened	90	25								
		> 12 % Si, cannot be hardened		130	26								
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27								
		CuZn, CuSnZn		90	28								
		CuSn, Pb-free copper, electrolytic copper		100	29								
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
Feed rate recommendations on page B248
For examples of material for cutting tool groups view page D22.

Recommend feed rate

Indexable milling – group1 (FMA07/11/12, FMD02, EMP09/13)

5

6

	Material group	Feed rate per cutting edge [mm]																	
		EMP09			EMP13			EMP13			FMA07			FMA07			FMA11		
		LNKT12			ANGX11			ANGX15			ONHU06			ONHU08			SNEG12		
		Application																	
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
P	Unalloyed steel		0,25	0,50		0,23			0,25		0,19	0,23		0,19	0,23			0,20	0,23
P	Low-alloyed steel		0,23	0,47		0,22			0,23		0,17	0,22		0,17	0,22			0,19	0,21
P	High-alloyed steel and high-alloyed tool steel		0,22	0,44		0,20			0,22		0,16	0,20		0,16	0,20			0,18	0,20
M	Stainless steel		0,18	0,35														0,14	0,16
K	Grey cast iron		0,28	0,55		0,26			0,28		0,20	0,26		0,20	0,26			0,22	0,25
K	Cast iron with spheroidal graphite		0,25	0,50		0,23			0,25		0,19	0,23		0,19	0,23			0,20	0,23
K	Malleable cast iron		0,25	0,50		0,23			0,25		0,19	0,23		0,19	0,23			0,20	0,23
N	Aluminium wrought alloys					0,20			0,21										
N	Aluminium-Gusslegierungen					0,20			0,21										
N	Copper and copper alloys(bronze/brass)					0,18			0,19										
S	Heat-resistant alloys																		
S	Titanium alloys																		
H	Hardened steel																		
H	Hard cast iron																		
H	Hardened cast iron																		
X	Non-metallic materials																		

1. Select the appropriate product family/cutting data group.
2. Select the used grade.
3. Determine the immersion.
4. Select the used material and read the cutting speed.
5. Please have a look at the detached feed rate recommendations.
6. Select the used tool, the machining mode and the used material.

Indexable milling – group 1 (FMA07/11/12, FMD02, FMP12, EMP09/13)

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
						HC (CVD)							
						YBC302		YBC401		YBD152		YBD252	
						a_e / D		a_e / D		a_e / D		a_e / D	
						1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	260	300	225	260				
		approx. 0,45 % C	annealed	190	2	225	255	195	225				
		approx. 0,45 % C	tempered	250	3	210	240	180	210				
		approx. 0,75 % C	annealed	270	4	185	210	160	185				
		approx. 0,75 % C	tempered	300	5	170	195	150	170				
	Low-alloyed steel		annealed	180	6	225	255	195	225				
			tempered	275	7	185	210	160	185				
			tempered	300	8	170	195	150	170				
			tempered	350	9	145	165	125	145				
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	130	150	115	130				
			hardened and tempered	325	11	95	105	80	95				
M	Stainless steel	ferritic/martensitic	annealed	200	12								
		martensitic	tempered	240	13								
		austenitic	quench hardened	180	14								
		austenitic-ferritic		230	15								
K	Grey cast iron	perlitic/ferritic		180	16					370	430	320	370
		perlitic (martensitic)		260	17					220	255	190	220
	Cast iron with spheroidal graphite	ferritic		160	18					255	295	220	255
		perlitic		250	19					170	200	145	170
	Malleable cast iron	ferritic		130	20					305	355	265	305
		perlitic		230	21					205	240	175	205
N	Aluminium wrought alloys	cannot be hardened		60	22								
		hardenable	hardened	100	23								
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24								
		≤ 12 % Si, hardenable	hardened	90	25								
		> 12 % Si, cannot be hardened		130	26								
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27								
		CuZn, CuSnZn		90	28								
		CuSn, Pb-free copper, electrolytic copper		100	29								
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
Feed rate recommendations on page B254.
For examples of material for cutting tool groups view page D11.

	Starting values for cutting speed v_c [m/min]																
	HC (CVD)		HC (PVD)										HW				
	YBM253		YBG102		YB9320		YBG205		YBG252		YBG302		YD101		YD201		
	a_e / D		a_e / D		a_e / D		a_e / D		a_e / D		a_e / D		a_e / D		a_e / D		
	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	1/1 | 3/4	1/5	
	260	300	270	315	245	285	235	275	230	265	225	260					
	225	255	230	270	210	245	200	235	200	230	195	225					
	210	240	220	255	200	230	190	220	185	215	180	210					
	185	210	190	225	175	200	165	195	165	190	160	185					
	170	195	180	205	160	190	155	180	150	175	150	170					
	225	255	230	270	210	245	200	235	200	230	195	225					
	185	210	190	225	175	200	165	195	165	190	160	185					
	170	195	180	205	160	190	155	180	150	175	150	170					
	145	165	150	175	135	160	130	155	130	150	125	145					
	130	150	135	160	125	145	120	140	115	135	115	130					
	95	105	95	115	90	100	85	100	85	95	80	95					
	130	150	135	160	125	145	120	140	115	135	115	130					
	110	130	115	135	105	120	100	120	100	115	95	110					
	140	160	145	170	130	155	125	150	125	145	120	140					
	110	130	115	135	105	120	100	120	100	115	95	110					
			300	345	270	315	260	300	255	295	250	290					
			180	205	160	190	155	180	150	175	150	170					
			205	240	185	215	180	210	175	200	170	195					
			135	160	125	145	120	140	115	135	115	130					
			245	285	225	260	215	250	210	240	205	235					
			165	190	150	175	145	165	140	160	135	160					
													1505	1735	1450	1670	
													1225	1420	1180	1370	
													540	620	515	600	
													435	505	420	485	
													220	255	215	250	
													170	195	160	190	
													210	245	205	235	
													385	445	370	430	

HC Coated carbide
HT Uncoated carbide, main component (TiC) o. (TiN), cermet
HC_1 Coated cermet
HW Uncoated carbide, main component (WC)

Recommended feed rate

Indexable milling – group1 (FMA07/11/12, FMD02, EMP09/13)

Material group		Feed rate per cutting edge [mm]																	
		EMP09			EMP09			EMP13			EMP13			FMA07			FMA07		
		LNKT08/12			LNKT16			ANGX11			ANGX15			ONHU06			ONHU08		
		Application																	
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
P	Unalloyed steel		0,25	0,50		0,28	0,55		0,23			0,25		0,19	0,23		0,19	0,23	
	Low-alloyed steel		0,23	0,47		0,26	0,51		0,22			0,23		0,17	0,22		0,17	0,22	
	High-alloyed steel and high-alloyed tool steel		0,22	0,44		0,24	0,48		0,20			0,22		0,16	0,20		0,16	0,20	
M	Stainless steel		0,18	0,35		0,19	0,39		0,16			0,18							
K	Grey cast iron		0,28	0,55		0,30	0,61		0,26			0,28		0,20	0,26		0,20	0,26	
	Cast iron with spheroidal graphite		0,25	0,50		0,28	0,55		0,23			0,25		0,19	0,23		0,19	0,23	
	Malleable cast iron		0,25	0,50		0,28	0,55		0,23			0,25		0,19	0,23		0,19	0,23	
N	Aluminum wrought alloys								0,20			0,21							
	Aluminum cast alloys								0,20			0,21							
	Copper and copper alloys (bronze/brass)								0,18			0,19							
S	Heat-resistant alloys																		
	Titanium alloys																		
H	Hardened steel																		
	Hard cast iron																		
	Hardened cast iron																		
X	Non-metallic materials																		

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Indexable milling – group1 (FMA07/11/12, FMD02, EMP09/13)

Material group		Feed rate per cutting edge [mm]																	
		FMP12																	
		WNHU08																	
		Application																	
		F	M	R															
P	Unalloyed steel		0,25																
	Low-alloyed steel		0,23																
	High-alloyed steel and high-alloyed tool steel		0,22																
M	Stainless steel		0,18																
K	Grey cast iron		0,28																
	Cast iron with spheroidal graphite		0,25																
	Malleable cast iron		0,25																
N	Aluminium wrought alloys																		
	Aluminum cast alloys																		
	Copper and copper alloys (bronze/brass)																		
S	Heat-resistant alloys																		
	Titanium alloys																		
H	Hardened steel																		
	Hard cast iron																		
	Hardened cast iron																		
X	Non-metallic materials																		

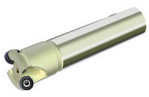
Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

	Feed rate per cutting edge [mm]																							
	FMA11			FMA11			FMA11			FMA12			FMA12			FMD02			FMD02			FMP12		
	SNEG12			SNEG15			SNEG19			ONHU06			ONHU08			PNEG11			HNEX09			WNHU06		
	Application																							
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
		0,20	0,23		0,22	0,25			0,29	0,19	0,23			0,23		0,15	0,20	0,30					0,23	
		0,19	0,21		0,20	0,24			0,27	0,17	0,22			0,22		0,14	0,19	0,28					0,22	
		0,18	0,20		0,19	0,22			0,26	0,16	0,20			0,20		0,13	0,18	0,26					0,20	
		0,14	0,16		0,15	0,18			0,20					0,16									0,16	
		0,22	0,25		0,24	0,28			0,32	0,20	0,26			0,26		0,17	0,22	0,33	0,17	0,22	0,33		0,26	
		0,20	0,23		0,22	0,25			0,29	0,19	0,23			0,23		0,15	0,20	0,30	0,15	0,20	0,30		0,23	
		0,20	0,23		0,22	0,25			0,29	0,19	0,23			0,23		0,15	0,20	0,30	0,15	0,20	0,30		0,23	

F Finishing
M Medium machining
R Roughing

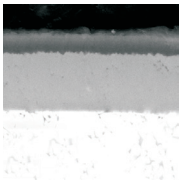
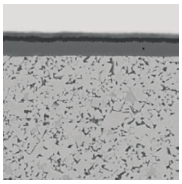
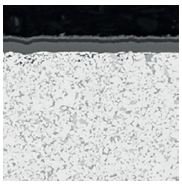
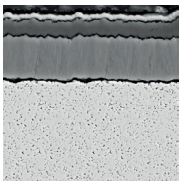
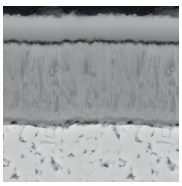
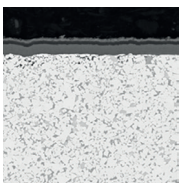
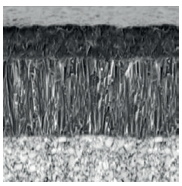
F Finishing
M Medium machining
R Roughing

Face milling

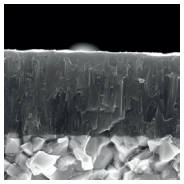
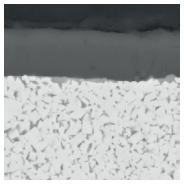
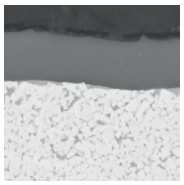
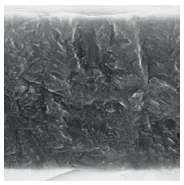
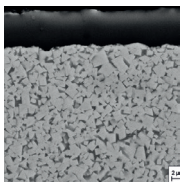
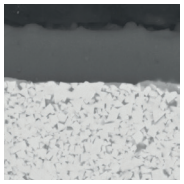
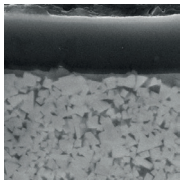
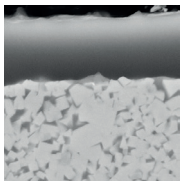
Series	Milling body	Inserts	Kr	Application						Features	Page
				P	M	K	N	S	H		
FMP02		 SEET09T3 SEET1203	90°	✔	✔	✔	✔	✔		• Diameter range Ø50 – 315 mm • For steel, stainless steel, cast iron an non-ferrous metals • Screw clamping	B76
FMP03		 LNKT120608-ZR LNKT1506EN-ZR LNKT2007DN-ZR LNKT2510-ZR	89°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Screw clamping	B79
FMP12		 WNHU0604 WNHU0806	90°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Screw clamping	B81
FMP12		 WNHU0604	90°	✔		✔				• Diameter range Ø50 – 315 mm • For steel, stainless steel and cast iron • Tangential insert with four cutting edges • Screw clamping	B83
FMWX		 XEEC1209		✔		✔				• Diameter range Ø50–125 mm • High feed finishing cutters for steel and cast materials • Inserts with four cutting edges • Reserve insert seats for increased safety • The milling body is only equipped with two opposing inserts	B86
FMR01		 RCKT10T3 RCKT1204 RCGX1204		✔	✔	✔	✔	✔		• Diameter range Ø25 – 63 mm • For steel, stainless steel, cast iron, non-ferrous metals and heatresistant alloys • Screw clamping	B88

✔ Very suitable ✔ Suitable

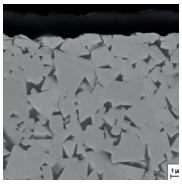
Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YBC302	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel at higher cutting speed. Optimal performance of wear resistance and toughness for a wide application field.
YBC301	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel at lower cutting speed.
YBC401	P30 - P50 M30 - M40		CVD coated P30–P50/M30–M40 carbide grade for roughing operation of steel at lower cutting speed and unstable condition.
YBM251	P20 - P30 M15 - M35		CVD coated P20–P30/M15–M35 carbide grade for medium to roughing operation in stainless steel and steel with wide application field. Good wear resistance and capability against plastic deformation at normal cutting speed.
YBM253	M15 - M35		CVD coated M15–M35 carbide grade for medium to roughing operation in stainless steel with wide application field. High wear resistance and capability against plasctic deformation at higher cutting speed.
YBM351	P25 - P40 M20 - M40		CVD coated P25–P40/M25–M40 carbide grade for roughing operation in stainless steel and steel. Good wear resistance and edge stability at normal cutting speed.
YBD152	K10 - K25		CVD coated K10–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Good wear resistance and toughness at higher cutting speed.
YBD252	K20 - K35		CVD coated K20–K35 carbide substrate. Optimized for medium to roughing operation of cast iron and Steel. Good wear resistance and toughness at higher cutting speed.

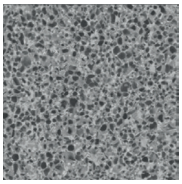
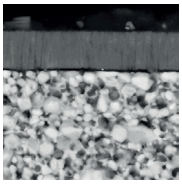
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG101	N05–N20		PVD coated N05–N20 carbide substrate for finishing to semi-finishing in aluminium materials. Coating only on the top face, in combination with the aluminium chip breakers, prevents built-up edges and gives a smooth cut.
YBG102	S05 - S15		PVD coated S05–S15 carbide substrate for finishing to medium application of super alloy material, stainless steel and aluminum. Good wear resistance in a wide application field.
YBG202	P10 - P30 M10-M25		PVD coated P10–P30/M10–M25 carbide substrate for finishing to medium application of stainless steel and steel (milling). Good wear resistance in a wide application field.
YBG212	P25 - P35 M25-M40		PVD coated M25–M40/P25–P35 carbide substrate for steel and stainless steel. Especially for inner insert at drilling operation.
YBS203	S15 – S25		Turning and milling grades for processing heat-resistant materials. A special carbon substrate and the latest PVD coating technology enable a very good wear behaviour, high fracture toughness and high thermal stability.
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated P10–P30/M20–M40/S15–S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.
YB9320	P10 - P30 M10-M25		PVD multilayer coated P10–P30/M10–M25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (grooving/milling). Optimised coating stability for higher wear resistance and thermal stability in a wide range of applications.
YBG302	P15 - P30 M25 - M40		PVD coated P15–P30/M25–M40 carbide substrate for medium roughing application of stainless steel and steel (milling). Good wear resistance and toughness.

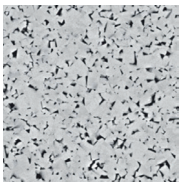
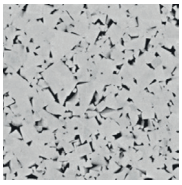
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBS303	S25 - S35		Milling grade for machining titanium alloys. A tough carbide substrate and the latest PVD coating technology with increased impact resistance and high thermal stability.

Cermet

Grade	ISO	Micro structure	Grade description
YNG151	P05 - P15		Uncoated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good resistance against plastic deformation for good surface finishing.
YNG151C	P05 - P15		PVD coated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good wear resistance and capability against plastic deformation for good surface roughness.

Uncoated cemented carbide

Grade	ISO	Micro structure	Grade description
YD101	N05 - N25 K05 - K20		Uncoated K05–K20/N05–N20 carbide substrate for fine to medium application in aluminum and other material.
YD201	K10 - K30 N10 - N30		Uncoated K10–K30/N10–N30 carbide substrate for medium application in aluminum and other material.

Application fields of grades – indexable milling

