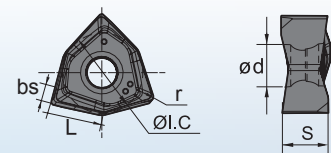
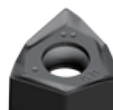


### Selection of inserts



Insert shape	Type	Dimensions(inch)						Coated grade		
		L	ØI.C	S	Ød	bs	r	YBG205	YBD152	YBM253
	WNHU060404PNR-GM	0.224	0.375	0.157	0.137	0.053	0.016	★	★	★
	WNHU060408PNR-GM	0.224	0.375	0.157	0.137	0.053	0.031	★	★	★
	WNHU080608PNR-GM	0.303	0.500	0.212	0.173	0.062	0.031	★	★	★
	WNHU080616PNR-GM	0.303	0.500	0.212	0.173	0.062	0.063	★	★	★

### Recommended cutting parameters

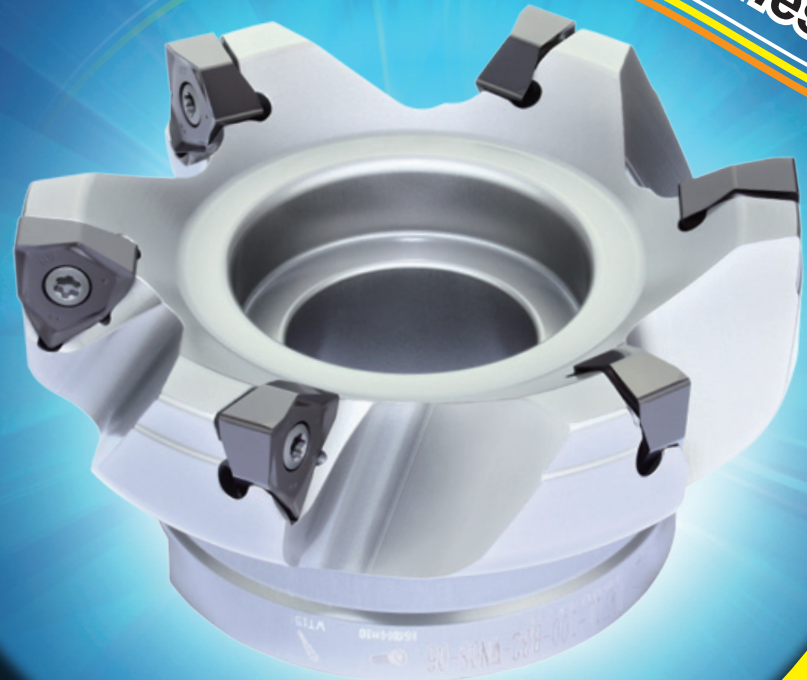
Workpiece material	Hardness HB	Grade	Cutting data		
			V(SFPM)	f(in/z)	a <sub>pmax</sub> (in)
<b>P</b> Low carbon steel Soft steel	≤ 180	YBM253 YBG205	900(700-1100)	0.008 (0.004-0.016)	0.224(WN06) 0.303(WN08)
	180-280	YBM253 YBG205	850 (650-1000)	0.008 (0.004-0.016)	
	280-350	YBM253 YBG205	800 (600-950)	0.008 (0.004-0.016)	
<b>M</b> Stainless steel	≤ 270	YBM253 YBG205	750 (600-950) 500 (360-900)	0.006 (0.004-0.012)	
<b>K</b> Cast iron	180-250	YBD152	900 (500-950)	0.016(0.004-0.020)	



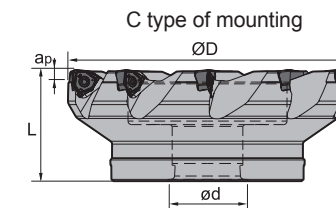
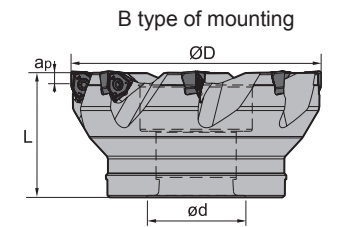
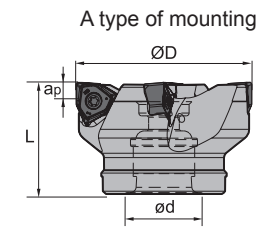
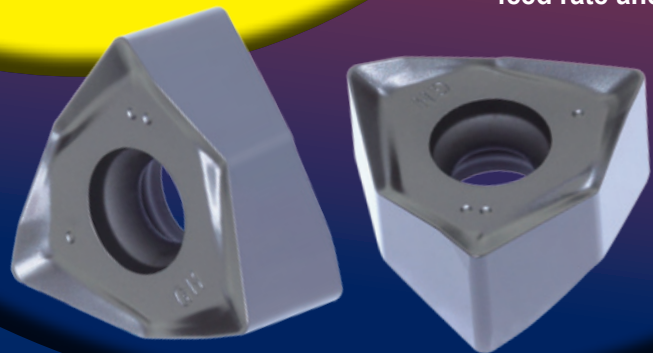
**FMP12**  
Series Face Mills  
High Efficiency and Great Performance

# FMP12 Series Face Mills

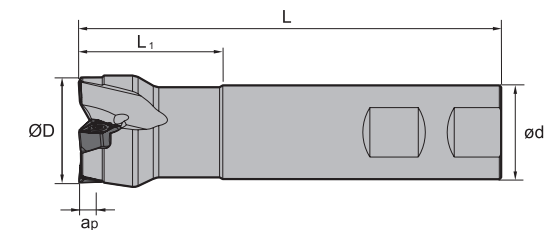
Kr:90°



- Double sided milling inserts with six cutting edges.
- Double negative rake angle with unique insert geometry, resulting dual positive tool angle that help to reduce the cutting force.
- Able to achieve high quality 90° square shoulder milling, face milling, slot milling and other processing.
- Inserts equipped with wiper, ensure higher feed rate and better surface quality.



Type	Basic dimensions(inch)				No. of teeth	Interface form
	ØD	Ød	L	a <sub>p</sub> max		
-2.00"-A0.75"-WN06-05C	2.00	0.75	1.75	0.224	5	A
-2.50"-A0.75"-WN06-06C	2.50	0.75	1.75	0.224	6	A
-2.50"-A1.00"-WN06-06C	2.50	1.00	2.00	0.224	6	A
-3.00"-A1.00"-WN06-07C	3.00	1.00	2.00	0.224	7	A
-4.00"-B1.25"-WN06-09	4.00	1.25	2.00	0.224	9	B
-5.00"-B1.50"-WN06-11	5.00	1.50	2.50	0.224	11	B
FMP12 -6.00"-C1.50"-WN06-14	6.00	1.50	2.50	0.224	14	C
-2.50"-A0.75"-WN08-05C	2.50	0.75	1.75	0.303	5	A
-2.50"-A1.00"-WN08-05C	2.50	1.00	2.00	0.303	5	A
-3.00"-A1.00"-WN08-06C	3.00	1.00	2.00	0.303	6	A
-4.00"-B1.25"-WN08-08	4.00	1.25	2.00	0.303	8	B
-5.00"-B1.50"-WN08-10	5.00	1.50	2.50	0.303	10	B
-6.00"-C1.50"-WN08-12	6.00	1.50	2.50	0.303	12	C



Type	Basic dimensions(inch)					No. of teeth	Interface form
	ØD	Ød	L	L <sub>1</sub>	a <sub>p</sub> max		
FMP12 -1.00"-XP1.00"-WN06-02C	1.00	1.00	4.0	1.25	0.224	2	XP
-1.25"-XP1.00"-WN06-03C	1.25	1.00	4.5	1.50	0.224	3	XP
-1.50"-XP1.25"-WN06-04C	1.50	1.25	4.5	1.50	0.224	4	XP
-2.00"-XP1.50"-WN06-05C	2.00	1.50	4.5	1.50	0.224	5	XP

\*C: coolant through

### Spare parts

Insert	Insert screw	Wrench
WNHU06	I60M3×9	WT09IS
WNHU08	I60M4×10	WT15IS