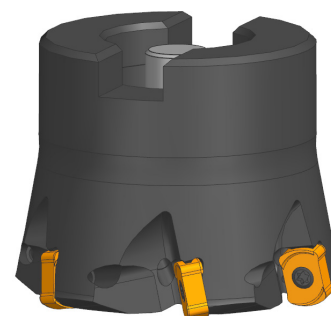
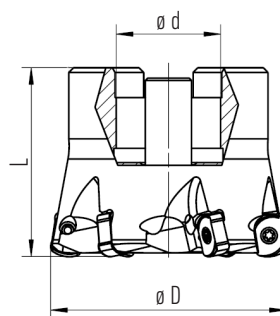


HFC mill F4100



ECO-CUT MAXI

- exceptional milling performance
- negative inserts with 4 edge
- low cutting speed at maximum performance
- double-sided replaceable inserts with 4 edge
- the stable clamping of the board enables its maximum use
- internal cooling

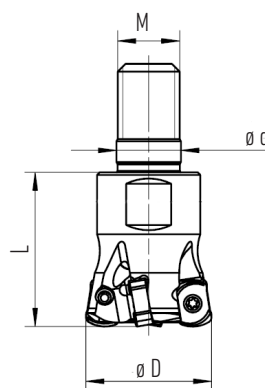


Arbor mounting

Order code	Dimensions (mm)				Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	L	z						
F4100.50.N22.50.Z6.C	50	22	50	6	1,4	JNMT09R2.5	TS3504	TK15	3	●
F4100.52.N22.50.Z6.C	52	22	50	6						●
F4100.52.N27.50.Z6.C	52	27	50	6						○
F4100.63.N27.50.Z7.C	63	27	50	7						●
F4100.66.N27.50.Z7.C	66	27	50	7						●
F4100.80.N27.50.Z8.C	80	27	50	8						●
F4100.100.N32.60.Z10.C	100	32	60	10						○

● = stock item

○ = available under request



Threaded coupling

Order code	Dimensions (mm)					Ap max.	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	M	L	z						
F4100.25.M12.35.Z3.C	25	12,5	M12	35	3	1,4	JNMT09R2.5	TS4009	TK15	3	●
F4100.32.M16.43.Z4.C	32	17,0	M16	43	4						●
F4100.35.M16.43.Z4.C	35	17,0	M16	43	4						●
F4100.40.M16.43.Z5.C	40	17,0	M16	43	5						○
F4100.42.M16.43.Z5+.C	42	17,0	M16	43	5						●

● = stock item

○ = available under request

HFC mill F4100

ECO-CUT MAXI



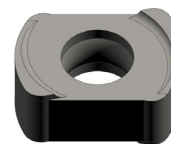
Overview of suitable inserts

Order code	P	M	K	S	H
JNMT09R2.5-M PKU25	●	●	●	●	●
JNMT09R2.5-M PKU35	●	●	●	●	●
JNMT09R2.5-M PKT48	○	○	○	○	

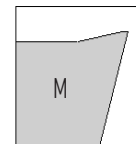
● = stock item ○ = available under request

Insert reference

JNMT09R2.5

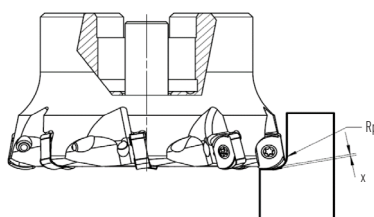


Blade shape



M- low cutting force for medium machining of steel, stainless steel and cast iron

Insert reference	Program	
	Rp	x
JNMT09R2.5	2,5	0,61



Recommended cutting conditions

		Insert reference		
		JNMT09R2.5		
		Cutting speed Vc (m/min.)	Feed fz (mm/t)	Chip depth Ap (mm)
P	Unalloyed steel	180 - 250	0,4 - 2,0	0,3 - 1,4
	Low-alloyed steel	160 - 230		
	High-alloyed steel	120 - 220		
M	SS - Ferritic / Martensitic	140 - 180	0,3 - 1,6	0,3 - 1,2
	SS - Austenitic	120 - 170		
	SS - austenitic - ferritic (Duplex)	100 - 150		
K	Grey cast iron	160 - 250	0,4 - 2,0	0,3 - 1,4
	Malleable cast Iron	120 - 210		
S	Superalloys	40 - 100	0,3 - 1,2	0,3 - 1,2
H	Hard materials (+40 HRC)	50 - 100	0,3 - 1,4	0,3 - 1,2

Ramping

Ø Dc	Ramping		
	Max Ramp α°	Max ap	Min Lr
25	5,1	1	15,8
32	3,5	1	22,8
35	3,1	1	25,8
42	2,4	1	33,8
50	2	1	40,8
52	1,9	1	42,8
63	1,5	1	53,8
66	1,4	1	56,8
80	1,1	1	70,8

