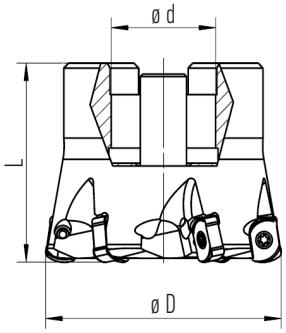
HFC mill F4150

ECO-CUT

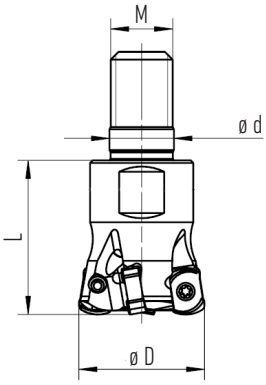
- exceptional milling performance
- negative inserts with 4 edge
- low cutting speed at maximum performance
- double-sided replaceable inserts with 4 edge
- the stable clamping of the board enables its maximum use
- internal cooling



Arbor mounting

Order code	Dimensions (mm)				Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	L	z						
F4150.40.N16.40.1.Z6.C	40	16	40	6	1,4	JNMT06R2.0	TS3004	TK08	1,2	●
F4150.50.N22.40.1.Z7.C	50	22	40	7						●
F4150.52.N22.40.1.Z7.C	52	22	40	7						●
F4150.63.N22.40.1.Z8.C	63	22	40	8						○
F4150.66.N22.40.1.Z8.C	66	22	40	8						○

● = stock item ○ = available under request



Threaded coupling

Order code	Dimensions (mm)					Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	M	L	z						
F4150.16.M8.25.1.Z2.C	16	8,5	M8	25	2	1,4	JNMT06R2.0	TS3004	TK08	1,2	●
F4150.20.M10.30.1.Z3.C	20	10,8	M10	30	3						●
F4150.25.M12.30.1.Z4.C	25	12,5	M12	30	4						●
F4150.32.M16.35.1.Z5.C	32	17,0	M16	35	5						●
F4150.35.M16.35.1.Z5.C	35	17,0	M16	35	5						●
F4150.40.M16.45.1.Z6.C	40	17,0	M16	45	6						●
F4150.42.M16.35.1.Z6.C	42	17,0	M16	35	6						●

● = stock item

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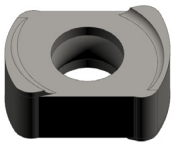
Overview of suitable inserts

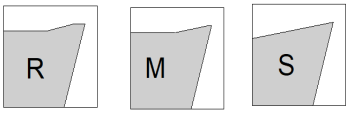
Order code	P	M	K	S	H
JNMT06R2.0-S PKU25	○	○	○	○	○
JNMT06R2.0-S PKU35	●	●	●	●	●
JNMT06R2.0-S PKT48	○	○	○	○	
JNMT06R2.0-M PKU25	●	●	●	●	●
JNMT06R2.0-M PKU35	●	●	●	●	●
JNMT06R2.0-M PKT48	○	○	○	○	
JNMT06R2.0-R PKU25	○	○	○	○	○
JNMT06R2.0-R PKU35	●	●	●	●	●
JNMT06R2.0-S PKT48	○	○	○	○	

● = stock item ○ = available under request

Insert reference
JNMT06R2.0

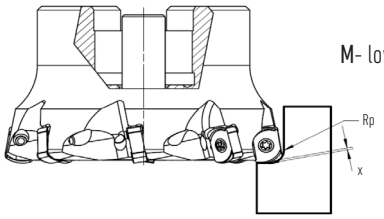


Blade shape



R-solid cutting edge for roughing steel, stainless steel and cast iron
M- low cutting force for medium machining of steel, stainless steel and cast iron
S-sharp geometry for finishing in steel, stainless and cast iron

Insert reference	Program	
	Rp	x
JNMT06R2.0	2,0	0,42



Recommended cutting conditions

		Insert reference JNMT06R2.0		
		Cutting speed Vc (m/min.)	Feed fz (mm/t)	Chip depth Ap (mm)
P	Unalloyed steel	180 - 250	0,4 - 1,6	0,3 - 0,9
	Low-alloyed steel	160 - 230		
	High-alloyed steel	120 - 220		
M	SS - Ferritic / Martensitic	140 - 180	0,3 - 1,2	0,3 - 0,7
	SS - Austenitic	120 - 170		
	SS - austenitic - ferritic (Duplex)	100 - 150		
K	Grey cast iron	160 - 250	0,4 - 1,6	0,3 - 0,9
	Malleable cast Iron	140 - 250 120 - 210		
S	Superalloys	40 - 100	0,3 - 0,8	0,3 - 0,6
H	Hard materials (+40 HRC)	50 - 100	0,3 - 1,0	0,3 - 0,6

Ramping

Ø Dc	Ramping		
	Max Ramp a°	Max ap	Min Lr
16	6	1	9,6
20	4,2	1	13,6
25	3,1	1	18,6
32	2,2	1	25,6
35	2	1	28,6
40	1,7	1	33,6
42	1,6	1	35,6
50	1,3	1	43,6
52	1,3	1	45,6
63	1	1	56,6
66	1	1	59,6