

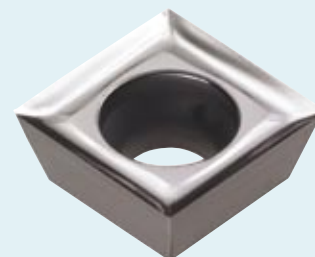
### AA 90°

INDEXABLE MILLING

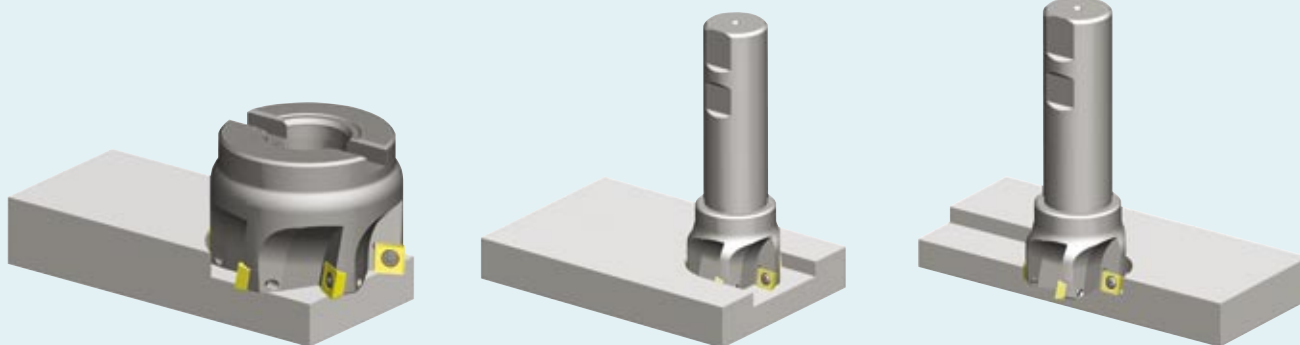
## Features of the Future Mill Insert

### Low cost 4 edged insert for multi-purpose machining

- Ideal for facing slotting & end milling steel, stainless, cast iron & aluminium
- Lowest cost per egde SDXT/SDET style insert
- Suitable for high speed & high feed machining
- Innovative cutting edge for low cutting load and strong cutting edge
- MM chip breaker for general machining of steel, stainless, cast iron & MA chip breaker for high speed machining of aluminium, copper, plastic & brass



## Machining examples



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## Recommended cutting conditions

ISO	GRADE	SDXT-MM		SDXT/SDET-MA	
		vc(m/min)	fz(mm/t)	vc(m/min)	fz(mm/t)
P	NCM325	100~250	0.05~0.30	-	-
	PC3500	100~250	0.05~0.30	-	-
M	PC9530	80~200	0.05~0.20	-	-
	NCM335	80~200	0.05~0.20	-	-
K	PC6510	100~200	0.08~0.25	-	-
ALI	H01	400~1,000	0.10~0.35	400~1,000	0.10~0.4

Machining Formulae	
RPM	$n = \frac{vc \times 1000}{\pi \times D}$
Feed (per min)	$Vf = fz \times n \times z$ (mm/min)

Symbol	Key
vc	Surface speed (m/min)
n	Revolutions per minute
ae	Width of cut
ap	Depth of cut
fz	Feed per tooth (mm/t)
D	Cutting diameter
Z	Number of teeth

### Future Mill 90 FMPCM 3000/4000S SERIES

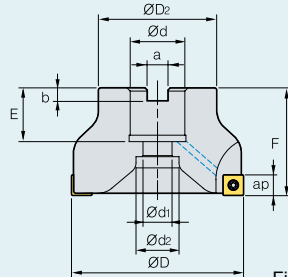
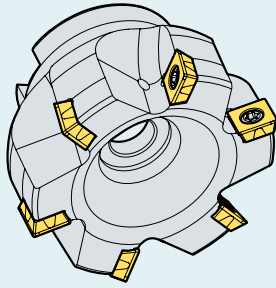


Fig. 1

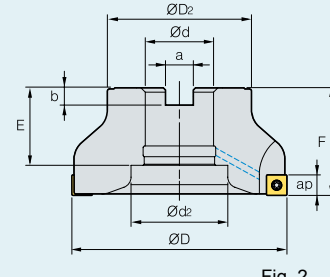
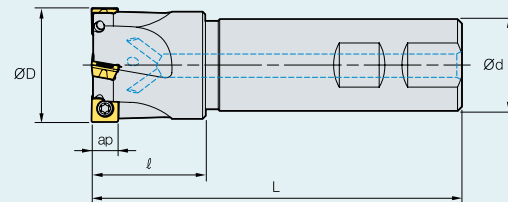
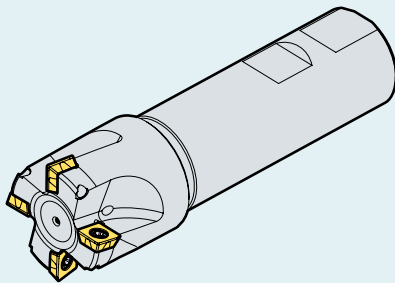


Fig. 2

DESIGNATION	£	STOCK STATUS	ØD		ØD2	Ød	Ød1	Ød2	a	b	E	F	ap	Kg.	Fig.	
FMPCM 3000 SERIES	3050HS	£146.00	•	50	5	40	22	11	18	10.4	6.3	20	40	7	0.3	1
	3063HS	£169.00	•	63	6	40	22	11	18	10.4	6.3	20	40	7	0.5	1
	3080HS	£196.00	•	80	7	55	27	14	20	12.4	7	22	50	7	1	1
	3100HS	£223.00	•	100	8	67	32	18	26	14.4	8	26	50	7	1.5	1
FMPCM 4000 SERIES	4063HS	£152.00	•	63	5	49	22	11	18	10.4	6.3	20	50	11	0.4	1
	4080HS	£182.00	•	80	6	57	27	14	20	12.4	7	23	50	11	0.9	1
	4100HS	£194.00	•	100	7	67	32	18	26	14.4	8	25	50	11	1.5	1
	4125HS	£258.00	□	125	8	87	40	22	32	16.4	9	29	63	11	3.1	1

### Future Mill 90 FMPS 3000/4000S SERIES



DESIGNATION	£	STOCK STATUS	ØD		Ød	l	L	ap	Kg.	
FMPS 3000 SERIES	3025HS	£78.00	•	25	2	40	35	115	7	0.4
	3032HS	£101.00	•	32	3	40	40	125	7	0.5
	3040HS	£128.00	•	40	4	55	40	130	7	0.8
	3050HS	£154.00	□	50	5	67	40	135	7	1
	3063HS	£178.00	□	63	6	49	45	135	7	1.2
FMPS 4000 SERIES	4040HS	£124.00	•	40	3	57	40	130	11	1
	4050HS	£131.00	•	50	4	67	45	135	11	1.5
	4063HS	£159.00	□	63	5	87	45	135	11	2.1

Stock Status • Stock item (next day delivery) □ Non-stock item (7-10 days)

#### Spares & Accessories

HOLDER SERIES	INSERT DESIGNATION	No EDGES	INSERT PAGE	INSERT	SCREW	WRENCH	ARBORS & END MILL HOLDERS
FMPCM 3000S FMPS 3000S	SDET 09M405 SDXT 09M405	4	B10		FTGA03508	TW15S	
FMPCM 4000S FMPS 4000S	SDET130504 SDXT130508	4	B10		FTNC04511	TW20S	Section G

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