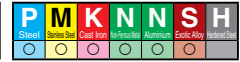
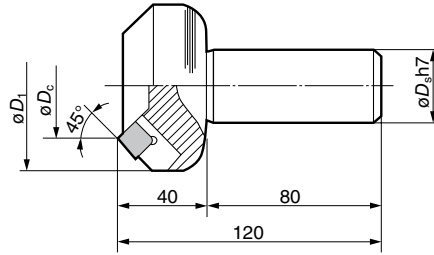
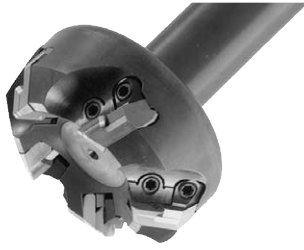


UFO4000E Type

Rake Angle	Radial	-7°
	Axial	+27°



General Milling for Steel and Hard-to-cut Material



Body

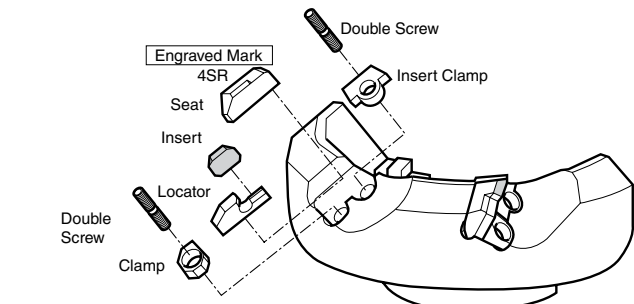
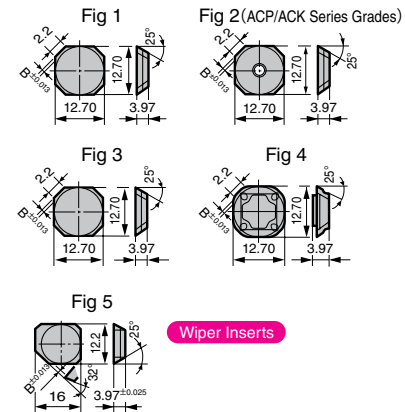
Cat. No.	Stock	Dimensions (mm)			No. of Teeth	Maximum Depth of Cut	Axial Rake	Radial Rake
		ϕD_c	ϕD_1	ϕD_s				
UFO 4050ER	●	50	74	32	4	5.5	+27°	-7°
4050ERS42		50	74	42				
4063ER	●	63	86	32				
4063ERS42		63	86	42				
4080ER	●	80	103	32				
UFO 4080ERS42		80	103	42	6	5.5	+27°	-7°
4100ER		100	122	32				
4100ERS42		100	122	42				

Inserts are not included.

Inserts

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade	Coated Carbide					Carbide				Cermet	Fig	
		High Speed/Light	General Purpose	Roughing									
		P	M	K	M		P	K	K	P			
		P	M	K	M		P	K	K	P			
		P	M	K	M		P	K	K	P			
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	G10E	H1	H10E	T250A	
SFEN 12T3AZTN	●	●						●				●	1
12T3AZTN-S								●					1
12T3AZTN-W										●			1
12T3AZFN											●		1
SFKN 12T3AZTN	●	●	●					●				●	2(3)
12T3AZTN-S								●				●	3
12T3AZTN-W										●		●	3
12T3AZFN					●	●	●		●				2(3)
SFKR 12T3AZEN	●							●					4
UW 12500R											●		5



Spare Parts

Applicable Cutters	Locator Clamp	Insert Clamp	Double Screw	Size		Seat	Locator	Spanner
				Size	(N·m)			
UFO 4000E Type	UFKWR	UFTWR	WB7-15T	M7	8.0	UF4SR	UF4KR	TT25

Note: Spanner used is TT25.

Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

External Diameter $\phi 50$ to $\phi 63$ mm

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	Carbon Steel	180 to 280HB	100-125-200	0.10-0.20-0.30	ACP200
	Alloy Steel	180 to 280HB	80-100-180	0.10-0.20-0.30	ACP200
K	Cast Iron	250HB	80-100-120	0.10-0.20-0.30	ACK200
N	Light Alloy/Non-ferrous Metal	—	80-160-250	0.05-0.15-0.20	H1

Note: The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

External Diameter $\phi 80$ to $\phi 100$ mm

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	Carbon Steel	180 to 280HB	100-125-200	0.10-0.25-0.40	ACP200
	Alloy Steel	180 to 280HB	80-100-180	0.10-0.25-0.40	ACP200
K	Cast Iron	250HB	80-100-120	0.10-0.25-0.40	ACK200
N	Light Alloy/Non-ferrous Metal	—	80-160-250	0.05-0.25-0.30	H1

Note: The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

Milling Cutters

Face Milling

Radius

Multi-Purpose

Shoulder Milling

R/Copying

Groove/T-Slot

Chamfering

Aluminium/Light Alloys

High-Speed Cast Iron