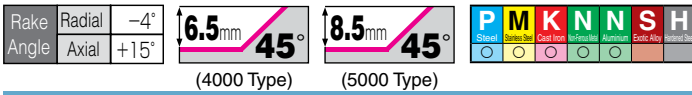
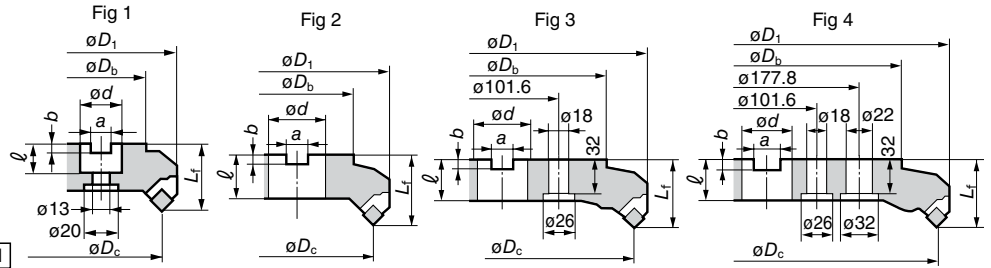


# FPG4000/5000 Type



## General Milling for Steel and Hard-to-cut Material



### Milling Cutter Body Imperial

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
				øD <sub>c</sub>	øD <sub>1</sub>	øD <sub>b</sub>	L <sub>f</sub>	ød	a	b	l			
FPG 4080R	●	FPG 4080L	●	*80	105	60	50	25.4	9.5	6	25	4	1.9	1
4100R	●	4100L	●	100	124	70	60	31.75	12.7	8	32	5	3.0	2
4125R	●	4125L	●	125	148	105	60	38.1	15.9	10	38	6	4.5	2
4160R	●	4160L	●	160	182	135	60	50.8	19.1	11	38	8	6.7	2
4200R	●	4200L	●	200	222	130	60	47.625	25.4	13.5	40	10	9.4	3
4250R	●	4250L	●	250	271	130	70	47.625	25.4	13.5	40	12	16.2	3
4315R	●	4315L	●	315	336	240	70	47.625	25.4	13.5	40	14	24.6	4
FPG 5080R	▲	FPG 5080L	▲	*80	105	60	50	25.4	9.5	6	25	4	1.9	1
5100R	▲	5100L	▲	100	124	70	60	31.75	12.7	8	32	5	3.0	2
5125R	▲	5125L	▲	125	148	80	60	38.1	15.9	10	38	6	4.5	2
5160R	▲	5160L	▲	160	182	100	60	50.8	19.1	11	38	8	6.7	2
5200R	▲	5200L	▲	200	222	130	60	47.625	25.4	13.5	40	10	9.4	3
5250R	▲	5250L	▲	250	271	130	70	47.625	25.4	13.5	40	12	16.2	3
5315R	▲	5315L	▲	315	336	240	70	47.625	25.4	13.5	40	14	24.6	4



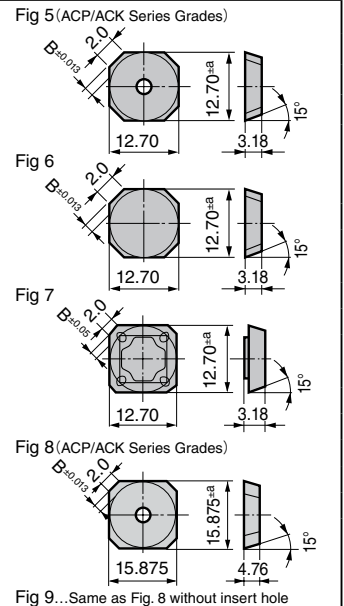
Inserts are not included.

\*Please use hexagonal bolt (JISB1176) M12 x 30 to 35mm for securing ø80 cutter to the arbour.

### Inserts

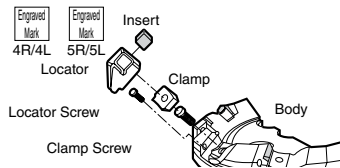
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel

Grade	Coated Carbide						Carbide		Cermet		SUMIDIA		Fig		
	Application														
	High Speed/Light						P	K	P	P	N	N		N	
	General Purpose	P	M	K	N	S							Note: Item marked * B ±0.08		
	Roughing	P	M	K											
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	G10E	T1500A	T1200A	T250A	DA1000	DA2200	
SDEX 42MT								●		▲					6
SDKN 42M					●	●			●						5(6)
NF-SDKN 42M													●	▲	6
SDKN 42MT		●	●	●				●		▲					5(6)
42MT-W															6
*SDNN 1203AETN		●	●					●							6
SDMR 1203AEEN		●	●					●							7
1203AETN													●		7
SDEX 53MT								●							9
SDKN 53M					●	●		●							8(9)
53MT		●	●	●				●							8(9)



### Applicable Inserts

Body	Insert
FPG4000 Type	SD0042 · · SD0012 · ·
FPG5000 Type	SD0053 · ·



### Spare Parts

Applicable Cutters	Locator Screw	Size	Clamp Screw	Clamp	Locator	
						(N·m)
FPG4000R Type	FBH0512	M5	5.0	FBX0817	FPWR	LFP4R
FPG4000L Type					FPWL	LFP4L
FPG5000R Type	FBH0512	M5	5.0	FBX0817	FPWR	LFP5R
FPG5000L Type					FPWL	LFP5L

(N·m) Recommended Tightening Torque (N·m)

Note: T-wrenches used are TH030 (locator screw) and TH040 (clamp screw).

### Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v <sub>c</sub> (m/min) Min. - Optimum - Max.	Feed Rate f <sub>z</sub> (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	100-130-160	0.15-0.28-0.40	ACP200
	Soft Steel	≤180HB	125-210-300	0.15-0.28-0.40	ACP200
	Die Steel	200 to 220HB	80-100-120	0.15-0.23-0.30	ACP200
M	Stainless Steel	—	150-175-200	0.15-0.23-0.30	ACP300
K	Cast Iron	250HB	60-155-250	0.15-0.23-0.30	ACK200
N	Non-Ferrous Alloy	—	300-650-1000	0.15-0.23-0.30	G10E

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.

▲mark : To be replaced by new item (Please confirm stock availability)