

MILLING - INDEXABLE

Cutter Series

16F1B
6F2B

Insert Series

YDA323L_: Long Finishing Edge
YDA323L114: Short Finishing Edge

Diameter Range

19.00 - 230.00 mm

Depth of Cut Range

0.50 mm Max Depth of Cut

Corner Radii

0.50, 1.00 mm R

Materials

- Steel
- Stainless Steel
- Cast Iron
- Non-Ferrous
- High-Temp Alloys

MICROMILL™



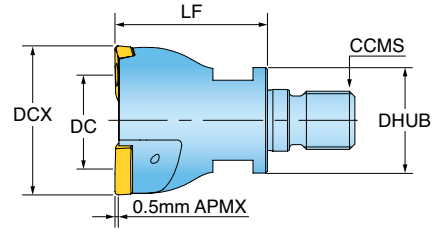
ADJUSTABLE FINISH MILLS

- » Easy and accurate adjustment within 0.005mm
- » Crowned cutting edge produces 15-32 Ra surface finish range
- » Long Wiper produces best Ra finish
- » Short Wiper reduces face pressure
- » Can mill up to a 90° Shoulder
- » Coolant thru

See the
full line »



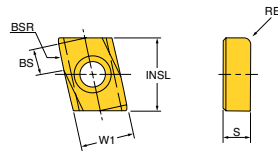
16F1B - Finish End Mill



Part Number	DC Cutting Dia. (mm)	DCX Cutting Dia. Max. (mm)	LF Functional Length (mm)	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia. (mm)
16F1B030043X8R00	19.00 mm	30.00 mm	43.0 mm	1	TopOn M16	28.0 mm
16F1B035043X8R00	24.00 mm	35.00 mm	43.0 mm	2	TopOn M16	29.0 mm
16F1B040043X8R00	29.00 mm	40.00 mm	43.0 mm	2	TopOn M16	29.0 mm

Insert

YDA323L114



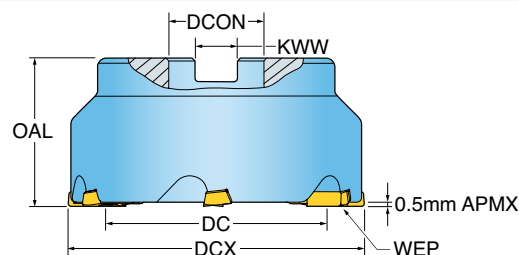
Part Number	Application	RE Corner Radius	BS Wiper Length	BSR Wiper Radius	INSL Insert Length	W1 Insert Width	S Thickness	NOI Number of Indexes	IH Insert Hand	Grades			
										Cermet		Carbide	
										IN0560	IN10K	IN2010	IN2040
YDA323L114	Short Wiper	1.00 mm	5.00 mm	250.00 mm	12.70 mm	9.52 mm	4.76 mm	2	Left	•	•	•	•

6F2B - Finish Face Mill



Facing

Coolant

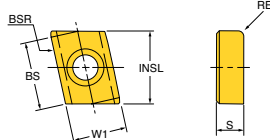


WEP - See insert drawing for wiper options.

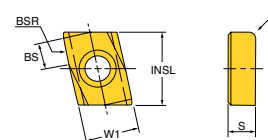
Part Number	DC Cutting Dia. (mm)	DCX Cutting Dia. Max. (mm)	OAL Overall Length (mm)	ZEFF Effective Teeth	DCON Shank Dia. (mm)	KWW Keyway (mm)	DBC Bolt Circle Dia. (mm)	CSP Coolant
6F2B050R00	30.00 mm	50.00 mm	40.00 mm	3	22.00 mm	10.40 mm	-	Yes
6F2B063R00	43.00 mm	63.00 mm	40.00 mm	3	22.00 mm	10.40 mm	-	Yes
6F2B080R00	60.00 mm	80.00 mm	50.00 mm	4	27.00 mm	12.40 mm	-	Yes
6F2B100R00	80.00 mm	100.00 mm	50.00 mm	6	32.00 mm	14.40 mm	-	Yes
6F2B125R00	105.00 mm	125.00 mm	63.00 mm	6	40.00 mm	16.40 mm	-	Yes
6F2B160R00	140.00 mm	160.00 mm	63.00 mm	8	40.00 mm	16.40 mm	66.7 mm	No
6F2B200R00	180.00 mm	200.00 mm	63.00 mm	10	60.00 mm	25.70 mm	101.6 mm	No
6F2B250R00	230.00 mm	250.00 mm	63.00 mm	12	60.00 mm	25.70 mm	101.6 mm	No

Inserts

YDA323L101/104



YDA323L114



Part Number	Application	RE Corner Radius	BS Wiper Length	BSR Wiper Radius	INSL Insert Length	W1 Insert Width	S Thickness	NOI Number of Indexes	IH Insert Hand	Grades			
										Cermet		Carbide	
										IN0560	IN10K	IN2010	IN2040
YDA323L104	Long Wiper	0.50 mm	12.20 mm	250.00 mm	12.70 mm	9.52 mm	4.76 mm	2	Left	•	•	•	•
YDA323L101	Long Wiper	1.00 mm	11.70 mm	250.00 mm	12.70 mm	9.52 mm	4.76 mm	2	Left	•		•	•
YDA323L114	Short Wiper	1.00 mm	5.00 mm	250.00 mm	12.70 mm	9.52 mm	4.76 mm	2	Left	•	•	•	•

Hardware

Part Number						Optional			
	 Insert Screw	 T-Handle Torx Driver	 Retention Bolt	 Barrel Screw	 Eccentric Pin	 TopOn Wrench	 Torque Driver Handle	 Preset Torque Adapter	 Torque Driver Bit
16F1B030043X8R00	SM40-110-00	DS-T15T	-	SC050-01	PN072-03	622 MM	DS-A00-.25-T	DT-35-.25	DS-T15B
16F1B035043X8R00	SM40-110-00	DS-T15T	-	SC050-01	PN072-03	622 MM	DS-A00-.25-T	DT-35-.25	DS-T15B
16F1B040043X8R00	SM40-110-00	DS-T15T	-	SC050-01	PN072-03	622 MM	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B050R00	SM40-110-00	DS-T15T	DIN912M10X25-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B063R00	SM40-110-00	DS-T15T	DIN912M10X25-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B080R00	SM40-110-00	DS-T15T	DIN912M12X35-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B100R00	SM40-110-00	DS-T15T	DIN912M16X30-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B125R00	SM40-110-00	DS-T15T	DIN912M20X40-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B160R00	SM40-110-00	DS-T15T	DIN912M20X40-12.9	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B200R00	SM40-110-00	DS-T15T	-	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B
6F2B250R00	SM40-110-00	DS-T15T	-	SC050-01	PN072-03	-	DS-A00-.25-T	DT-35-.25	DS-T15B

Operating Guidelines

Materials				Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder «-----» Tougher				Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			Cermet	Carbide			
						IN0560	IN2010	IN10K	IN2040	
P	1-11	Non, Low & High alloy steel	1018, A36, 4140, P20, H13, D2	300 - 650	.010-.030				1	No
				600 - 800		1				
M	12, 13	Stainless steel (ferritic and martensitic)	410, 416, 440	260 - 520	.010-.030				1	Yes
	14	Stainless steel (austenitic)	303, 304, 316, 15-5, 17-4							May not be required at high speeds
K	15, 16	Gray cast iron	CLS. 20, 30, 45	460 - 660	.020-.030		1			No
	17, 18	Nodular cast iron	60-40-18, 100-70-03	330 - 600						
N	21-30	Aluminum	7075, 6061	1300 - 2000	.020-.030			1		Yes
S	31-35	High-temp alloys	Inconel, Hastelloy, Nimonic, Monel	260 - 460	.010-.030				1	Yes

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.