

Rake	Radial	+2°
Angle	Axial	+8°

0.5mm 90°

P	M	K	N	N	S	H
Steel	Cast Iron	Cast Iron	Aluminum	Exotic Alloy	Inconel	Stainless Steel
×	×	×	×	×	×	×

SUMIBORON BN Finish Mill EASY

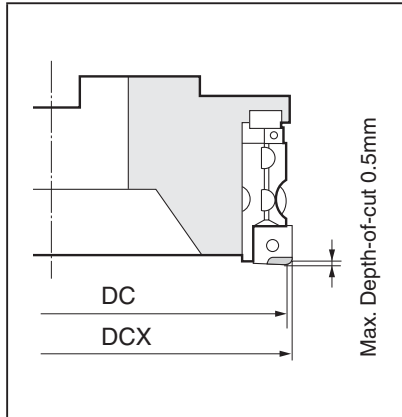
BN Finish Mill EASY FMU FMU-E Type

* Refer to L114 for technical information.

High-speed Finishing for Cast Iron



Max. D.O.C.



Assembly

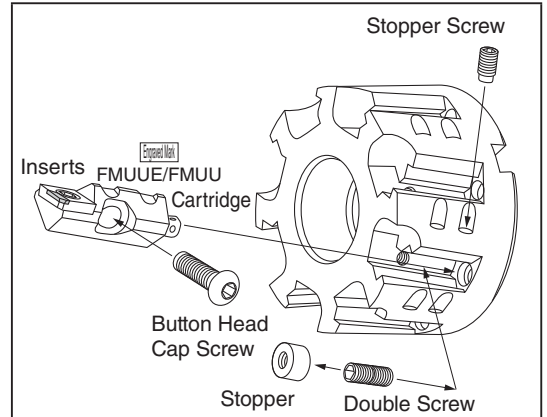


Fig 1

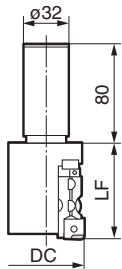


Fig 2

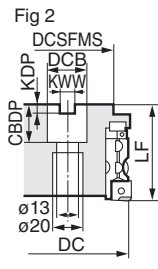


Fig 3

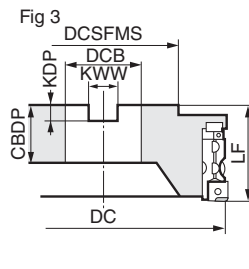


Fig 4

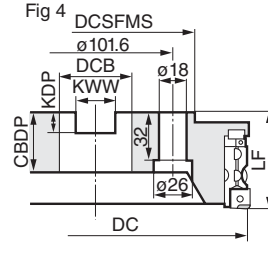
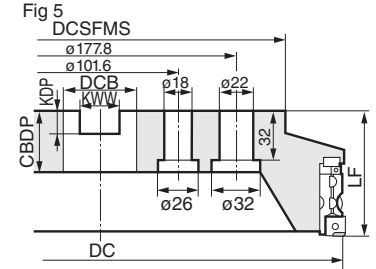


Fig 5



Body

Inch

Dimensions (mm)

Cat. No.	Stock	Diameter		Boss	Total Length	Hole Size	Grooving Width	Grooving Depth	Mounting Depth	No. of Teeth	Weight (kg)	Fig
		DC	DCX									
FMU 4040ER	●	37	40	—	63	—	—	—	—	2	1.0	1
4050ER	●	47	50	—	63	—	—	—	—	3	1.2	1
4063ER	●	60	63	60	63	25.4	9.5	6	25	4	1.0	2
FMU 4080R	●	80	82.8	60	63	25.4	9.5	6	25	6	1.7	2
4100R	●	100	102.8	75	63	31.75	12.7	8	38	8	2.5	3
4125R	●	125	127.8	75	63	38.1	15.9	10	38	10	3.9	3
4160R	●	160	162.8	100	63	50.8	19.1	11	38	12	6.3	3
4200R	●	200	202.8	130	63	47.625	25.4	14	40	16	9.3	4
4250R	●	250	252.8	130	63	47.625	25.4	14	40	20	14.5	4
4315R	●	315	317.8	240	80	47.625	25.4	14	40	24	25.0	5

Inserts

Fig 6

Fig 7

Grade		CBN	
Application	High Speed/Light	K	K
	General Purpose	K	K
	Roughing		
Cat. No		BN7000	BN700
		●	●
		●	●
		6	7
SNEW1203ADTR			
1203ADTR-S			

Parts for Cartridge

Inserts are not included.

Cartridge	Screw	Adjustment Screw	O-ring	Wrench	Wrench
FMUU(E)*	BFTX0509N	FMUJ	P3	TTX20 (For Screw)	TH015

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

* FMU4040ER, FMU4050ER and FMU4063ERS use FMUUE type cartridges.

* FMUU and FMUUE are pre-assembled with screws and adjustment screws (with O-rings attached).

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v_c (m/min)	Feed Rate f_z (mm/t)	Grade
			Min. - Optimum - Max.	Min. - Optimum - Max.	
K	Gray Cast Iron	250HB	800-1400-2000	0.10-0.20-0.30	BN7000(Dry)

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.

Parts

* S denotes low cutting force insert.

Button Head Cap Screw	Stopper Screw	Stopper	Double Screw	Wrench	Wrench	Wrench
BH0620*	BTD0609	FMUE	WB5-10	TH040 (For Cartridges)	LH030 (For Stopper Screws)	LH025 (For Stoppers)

* Button head cap screw for FMU4040ER, 4050ER and 4063ER is BH0615.

* Anti-seizure cream SUMI-P included in the package.

Setting Gauge



Milling Cutters

Face Milling

Shoulder Milling

High Feed

Radius

Multi-Purpose

R/ Profiling

Groove/ T-Slot

Chamfering

Aluminum/ Light Alloys

High-Speed Cast Iron