

MILL4FEED

HIGH FEED

High Feed Face Milling 22-160 mm Diameter Feed Master



Highly Durable
Straight Cutting Edge

4 Cutting Edged
Square Insert

Square Insert for High Feed Face Milling with Higher Productivity



Reinforced
Insert Radius



For Stainless Steel,
Cast Iron
& Exotic Materials



Positive Insert
Positioning



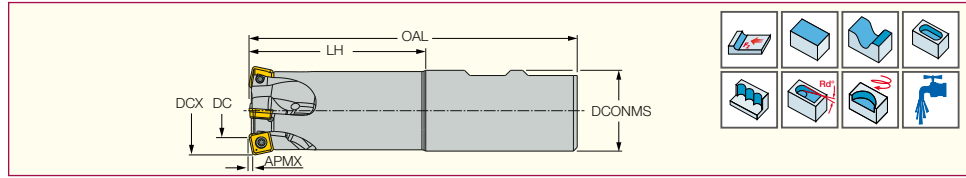
Interrupted Cut

LOGIQMILL
ISCAR CHESS LINES

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FFQ4 D-W-09

Fast Feed Endmills Carrying Single-Sided Inserts with 4 Cutting Edges



Designation	DC	DCX	APMX	AE ⁽¹⁾	CICT ⁽²⁾	LH	OAL	DCONMS	RMPX ⁽³⁾	WT ⁽⁴⁾
FFQ4 D022-2-044-W20-09	7.70	22.00	1.20	6.0	2	44.0	94.00	20.00	8.2	0.19
FFQ4 D025-3-050-W25-09	10.70	25.00	1.20	6.0	3	50.0	106.00	25.00	5.5	0.25
FFQ4 D032-4-064-W25-09	17.70	32.00	1.20	6.0	4	64.0	120.00	25.00	3.2	0.50
FFQ4 D035-5-070-W32-09	20.70	35.00	1.20	6.0	5	70.0	130.00	32.00	2.7	0.70

• Radius for programming 2.5 mm (1) Plunging width (2) Number of inserts (3) Ramping angle maximum (4) Item weight

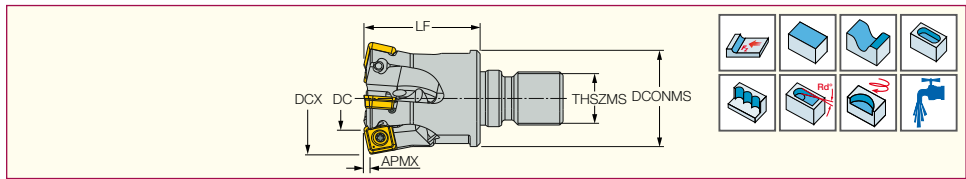
Spare Parts

Designation		
FFQ4 D-W-09	SR M3X0.5-L7.4 IP9	IP-9/151

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FFQ4 D-M-09

Fast Feed Endmills with FLEXFIT Threaded Adaptation Carrying Single-Sided Inserts with 4 Cutting Edges



Designation	DC	DCX	APMX	AE ⁽¹⁾	CICT ⁽²⁾	LF	OAL	DCONMS	THSZMS	RMPX ⁽³⁾	WT ⁽⁴⁾
FFQ4 D022-02-M10-09	7.70	22.00	1.20	6.0	2	25.00	45.00	18.00	M10	8.2	0.04
FFQ4 D025-02-M12-09	10.70	25.00	1.20	6.0	2	30.00	52.00	21.00	M12	5.5	0.05
FFQ4 D025-03-M12-09	10.70	25.00	1.20	6.0	3	30.00	52.00	21.00	M12	5.5	0.07
FFQ4 D032-03-M16-09	17.70	32.00	1.20	6.0	3	35.00	60.00	29.00	M16	3.2	0.14
FFQ4 D032-04-M16-09	17.70	32.00	1.20	6.0	4	35.00	60.00	29.00	M16	3.2	0.14
FFQ4 D035-05-M16-09	20.70	35.00	1.20	6.0	5	35.00	60.00	29.00	M16	2.7	0.16
FFQ4 D040-05-M16-09	25.70	40.00	1.20	6.0	5	35.00	60.00	29.00	M16	2.0	0.18

• Radius for programming 2.5 mm (1) Plunging width (2) Number of inserts (3) Ramping angle maximum (4) Item weight

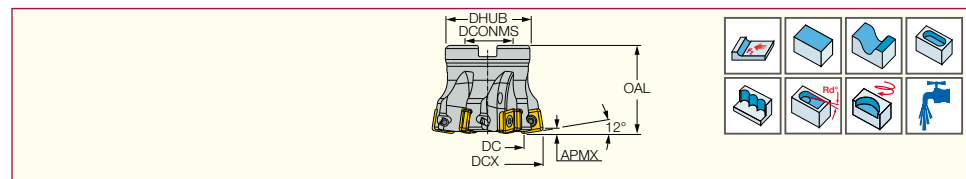
Spare Parts

Designation		
FFQ4 D-M-09	SR M3X0.5-L7.4 IP9	IP-9/151

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FFQ4 D-09




Fast Feed Face Mills Carrying Single-Sided Inserts with 4 Cutting Edges



Designation	DC	DCX	APMX	AE ⁽¹⁾	CICT ⁽²⁾	OAL	DCONMS	DHUB	RMPX ⁽³⁾	WT ⁽⁴⁾
FFQ4 D40-05-16-09	25.70	40.00	1.20	6.0	5	35.00	16.00	38.00	2.0	0.17
FFQ4 D50-07-22-09	35.70	50.00	1.20	6.0	7	40.00	22.00	48.00	1.5	0.32
FFQ4 D52-07-22-09	37.70	52.00	1.20	6.0	7	40.00	22.00	48.00	1.4	0.34
FFQ4 D63-08-22-09	48.70	63.00	1.20	6.0	8	45.00	22.00	48.00	1.1	0.49

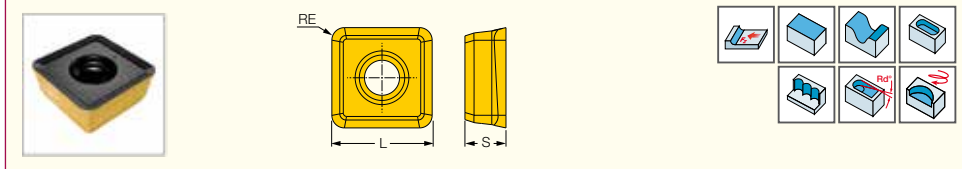
• Radius for programming 2.5 mm (1) Plunging width (2) Number of inserts (3) Ramping angle maximum (4) Item weight

Spare Parts

Designation			
FFQ4 D40-05-16-09	SR M3X0.5-L7.4 IP9	IP-9/151	SR M8X25DIN912
FFQ4 D50-07-22-09	SR M3X0.5-L7.4 IP9	IP-9/151	SR M10X25 DIN912
FFQ4 D52-07-22-09	SR M3X0.5-L7.4 IP9	IP-9/151	SR M10X25 DIN912
FFQ4 D63-08-22-09	SR M3X0.5-L7.4 IP9	IP-9/151	SR M10X30 DIN912

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FFQ4 SOMT 0904
Square Single-Sided Inserts with 4
Cutting Edges for Fast Feed Milling

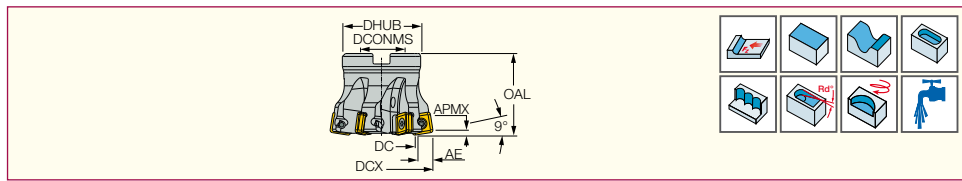


Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data	
	L	S	RE	IC882	IC830	IC5820	IC808	IC810	a _p (mm)	f _z (mm/t)
FFQ4 SOMT 090412T	8.50	3.90	1.20		•		•	•	0.50-1.20	0.40-1.50
FFQ4 SOMT 0904RM-T	8.50	3.80	1.20				•		0.50-1.20	0.40-1.50
FFQ4 SOMT 090412HP	8.50	3.80	1.20	•	•	•	•		0.50-1.20	0.40-1.40

• T - type for steel, ferritic and martensitic stainless steel, cast iron and hardened steel • RM-T type for interrupted cut and machining near straight shoulders on steel, ferritic and martensitic stainless steel, cast iron and hardened steel • HP- type for austenitic stainless steel and high temperature alloys

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FFQ4 D-12
Fast Feed Face Mills
Carrying Single-Sided Inserts
with 4 Cutting Edges



Designation	DC	DCX	APMX	AE	CICT	OAL	DHUB	DCONMS	Arbor	RMPX	
FFQ4 D040-3-16-12	18.00	40.00	1.50	10.0	3	45.00	38.00	16.00	A	4.3	0.23
FFQ4 D040-4-16-12	18.00	40.00	1.50	10.0	4	45.00	38.00	16.00	A	4.3	0.22
FFQ4 D050-4-22-12	28.00	50.00	1.50	10.0	4	50.00	48.00	22.00	A	2.7	0.38
FFQ4 D050-5-22-12	28.00	50.00	1.50	10.0	5	50.00	48.00	22.00	A	2.7	0.37
FFQ4 D052-5-22-12	29.00	52.00	1.50	10.0	5	50.00	48.00	22.00	A	2.5	0.39
FFQ4 D063-6-22-12	41.00	63.00	1.50	10.0	6	50.00	48.00	22.00	A	1.8	0.50
FFQ4 D066-6-27-12	43.00	66.00	1.50	10.0	6	50.00	60.00	27.00	A	1.6	0.65
FFQ4 D080-7-27-12	58.00	80.00	1.50	10.0	7	50.00	60.00	27.00	A	1.2	0.84
FFQ4 D100-8-32-12	78.00	100.00	1.50	10.0	8	50.00	78.00	32.00	B	0.9	1.30

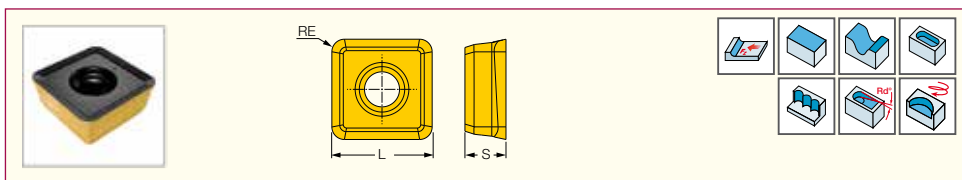
• Radius for programming 3.1 mm (1) Plunging width

Spare Parts

Designation					
FFQ4 D040-3-16-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7		SR PS 118-0416
FFQ4 D040-4-16-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7		SR PS 118-0416
FFQ4 D050-4-22-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M10X35 DIN912	
FFQ4 D050-5-22-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M10X35 DIN912	
FFQ4 D052-5-22-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M10X35 DIN912	
FFQ4 D063-6-22-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M10X35 DIN912	
FFQ4 D066-6-27-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M12X30DIN912	
FFQ4 D080-7-27-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7	SR M12X30DIN912	
FFQ4 D100-8-32-12	SR M4X0.7-L9.6 IP15	SW6-T	BLD IP15/S7		

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FFQ4 SOMT 1205
Square Single-Sided Inserts with 4
Cutting Edges for Fast Feed Milling

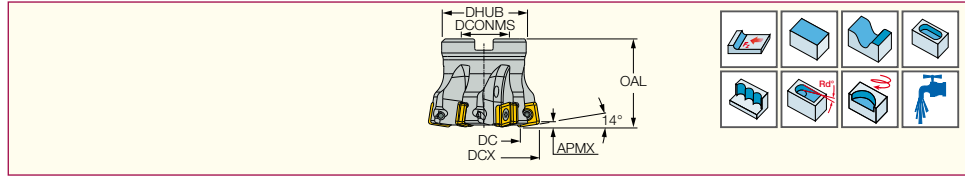


Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data	
	L	S	RE	IC882	IC830	IC5820	IC808	IC810	a _p (mm)	f _z (mm/t)
FFQ4 SOMT 1205RM-HP	12.70	5.20	1.60		•				0.50-1.50	0.40-1.80
FFQ4 SOMT 1205RM-T	12.70	5.20	1.60				•		0.50-1.50	0.40-2.00
FFQ4 SOMT 120516HP	12.70	5.20	1.60	•	•	•	•		0.50-1.50	0.40-1.80
FFQ4 SOMT 120516T	12.70	5.20	1.60		•		•		0.50-1.50	0.40-2.00
FFQ4 SOMT 120516T20	12.70	5.20	1.60					•	0.50-1.50	0.40-2.00

• RM-HP- for interrupted cut and machining next to shoulders of austenitic stainless steel and high temperature alloys • RM-T- for interrupted cut and machining next to shoulders of steel, ferritic and martensitic stainless steel, cast iron and hardened steel • HP- for austenitic stainless steel and high temperature alloys
• T- for steel, ferritic and martensitic stainless steel, cast iron and hardened steel • T20- for grey and nodular cast iron

FFQ4 D-17

Fast Feed Face Mills Carrying Single-Sided Inserts with 4 Cutting Edges



Designation	DCX	DC	APMX	AE	CICT ⁽¹⁾	OAL	DCONMS	DHUB	RMPX ⁽²⁾	WT ⁽³⁾
FFQ4 D080-06-27-17	80.00	50.80	3.00	13.0	6	50.00	27.00	60.00	1.2	0.78
FFQ4 D100-07-32-17	100.00	70.80	3.00	13.0	7	50.00	32.00	78.00	0.8	1.18
FFQ4 D125-08-40-17	125.00	95.80	3.00	13.0	8	63.00	40.00	92.00	0.6	2.48
FFQ4 D160-10-40-17	160.00	130.80	3.00	13.0	10	63.00	40.00	95.00	0.2	2.90





• Radius for programming 5.5 mm

⁽¹⁾ Number of inserts

⁽²⁾ Ramping angle maximum

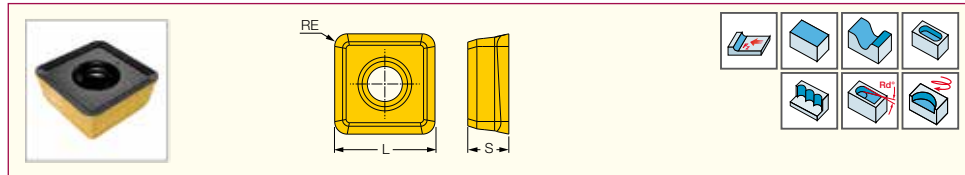
⁽³⁾ Item weight

Spare Parts

Designation				
FFQ4 D080-06-27-17	SR M5-14 IP20	SW6-T	BLD IP20/S7	SR M12X30DIN912
FFQ4 D100-07-32-17	SR M5-14 IP20	SW6-T	BLD IP20/S7	
FFQ4 D125-08-40-17	SR M5-14 IP20	SW6-T	BLD IP20/S7	
FFQ4 D160-10-40-17	SR M5-14 IP20	SW6-T	BLD IP20/S7	

FFQ4 SOMT 1706

Square Single-Sided Inserts with 4 Cutting Edges for Fast Feed Milling



Designation	Dimensions			Tough ↔ Hard				Recommended Machining Data	
	L	S	RE	IC882	IC830	IC808	IC810	a _p (mm)	f _z (mm/t)
FFQ4 SOMT 1706RM-T ⁽¹⁾	17.50	6.00	2.50			•		1.20-3.00	0.40-2.00
FFQ4 SOMT 170625HP ⁽²⁾	17.50	6.00	2.50	•	•	•		1.20-3.00	0.40-1.50
FFQ4 SOMT 170625T ⁽³⁾	17.50	6.00	2.50		•	•	•	1.20-3.00	0.40-2.00

⁽¹⁾ For interrupted cut and machining next to shoulders on steel, stainless steel, cast iron and hardened steel

⁽²⁾ For austenitic stainless steel and high temperature alloys

⁽³⁾ For steel, ferritic and martensitic stainless steel, cast iron and hardened steel

