

Square Insert for Fast Feed Face Milling with Higher Productivity

**LIMITED TIME
OFFER!**



Reinforced
Insert Radius



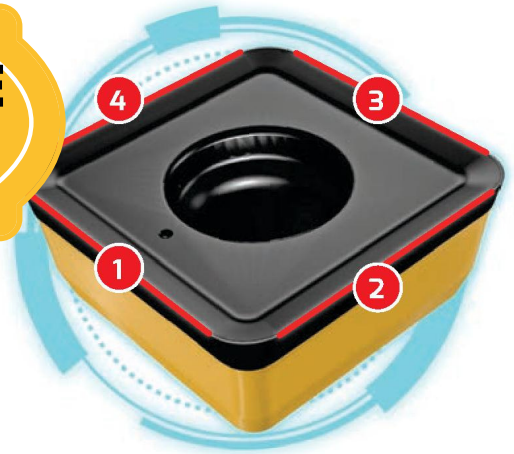
For Stainless Steel,
Cast Iron
& Exotic Materials



Positive Insert
Positioning



Interrupted Cut



Purchase

Min. of qty 10 FFQ4 SOMT 09/12/17
Assorted Inserts
per pocket for all pockets and pay only
\$10 per inch of Endmill or Face Mill.

Promo only valid for up to 5"
Endmill Cutter up to 1.50"
Face Mill Cutter up to 5"



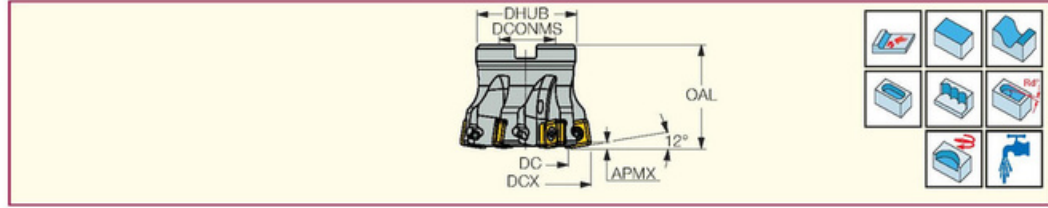
Family of fast feed milling tools that carry FFQ4 SOMT square single-sided indexable inserts with 4 cutting edges. The tools are available in endmills from 7/8" to 1-1/2" and face mills from 1-1/2" to 6" (Promo only valid up to 5") Intended for productive rough milling of various materials in different industries such as die & mold, aerospace and automotive, and in general engineering. Unbeatable Iscar grades for various materials and set-ups.



MILL4FEED

FFQ4 D-09

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



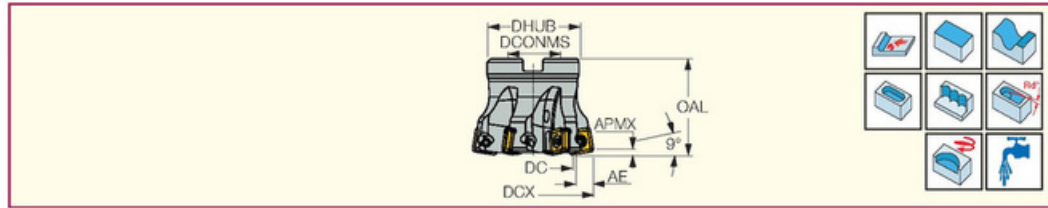
Designation	DCX [®]	DC	APMX	AE [®]	CICT [®]	OAL	DCONMS	DHUB	RMPX [®]		MIID [®]	TQ [®]
FFQ4 D1.50-05-0.50-09	1.500	.933	.047	.280	5	1.400	.500	1.417	2.2	.38	FFQ4 SOMT 090412T	17.70
FFQ4 D2.00-07-0.75-09	2.000	1.439	.047	.280	7	1.600	.750	1.850	1.5	.77	FFQ4 SOMT 090412T	17.70
FFQ4 D2.50-08-1.00-09	2.500	1.937	.047	.280	8	1.850	1.000	2.252	1.1	1.38	FFQ4 SOMT 090412T	17.70

• Radius for programming .098" • To generate a straight surface without cusps, the width of cut must not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%. [®] Cutting diameter maximum [®] Maximum plunging width [®] Number of inserts [®] Maximum ramping angle [®] Master insert identification [®] Recommended tightening torque (lb*in) for insert screw

MILL4FEED

FFQ4 D-12

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



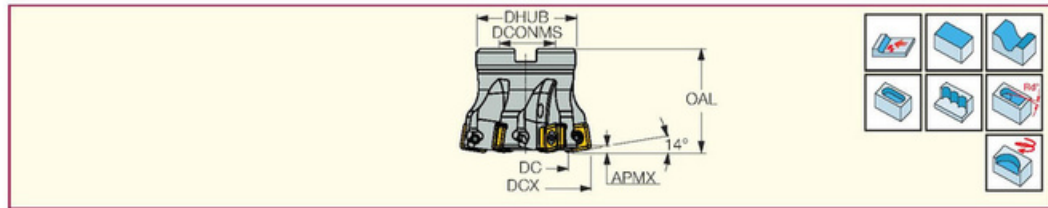
Designation	DCX [®]	DC	APMX	AE [®]	CICT [®]	LF	DHUB	DCONMS	Arbor	RMPX [®]		MIID [®]	TQ [®]
FFQ4 D2.0-5-0.75-12	2.000	1.136	.059	.394	5	2.000	1.850	.750	A	2.6	.88	FFQ4 SOMT 120516HP	42.50
FFQ4 D2.5-6-1.00-12	2.500	1.636	.059	.394	6	2.000	2.252	1.000	A	1.7	1.30	FFQ4 SOMT 120516HP	42.50
FFQ4 D3.0-7-1.00-12	3.000	2.136	.059	.394	7	2.000	2.252	1.000	A	1.3	1.72	FFQ4 SOMT 120516HP	42.50
FFQ4 D4.0-8-1.50-12	4.000	3.136	.059	.394	8	2.000	3.228	1.500	B	.9	2.92	FFQ4 SOMT 120516HP	42.50
FFQ4 D5.0-10-1.50-12	5.000	4.110	.059	.394	10	2.000	3.799	1.500	B	.7	5.51	FFQ4 SOMT 120516HP	42.50

• Radius for programming .122" • To generate a straight surface without cusps, the width of cut must not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%. [®] Cutting diameter maximum [®] Maximum plunging width [®] Number of inserts [®] Maximum ramping angle [®] Master insert identification [®] Recommended tightening torque (lb*in) for insert screw

MILL4FEED

FFQ4 D-17

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



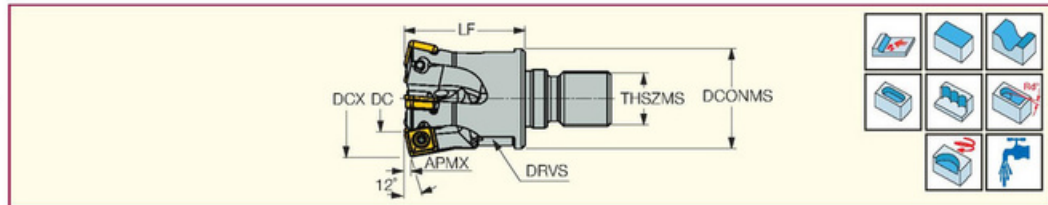
Designation	DCX [®]	DC	APMX	AE [®]	CICT [®]	OAL	DCONMS	DHUB	RMPX [®]	CSP [®]		MIID [®]	TQ [®]
FFQ4 D3.00-06-1.25-17	3.000	1.850	.118	.574	6	2.000	1.250	2.874	1.2	1	1.79	FFQ4 SOMT 170625T	80.00
FFQ4 D4.00-07-1.50-17	4.000	2.850	.118	.574	7	2.000	1.500	3.228	.8	1	2.91	FFQ4 SOMT 170625T	80.00
FFQ4 D5.00-08-1.50-17	5.000	3.850	.118	.574	8	2.250	1.500	3.228	.6	1	4.44	FFQ4 SOMT 170625T	80.00
FFQ4 D6.00-10-2.00-17	6.000	4.850	.118	.574	10	2.500	2.000	5.000	.4	0	9.81	FFQ4 SOMT 170625T	80.00

• Radius for programming .217" • To generate a straight surface without cusps, the width of cut must not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%. [®] Cutting diameter maximum [®] Maximum plunging width [®] Number of inserts [®] Maximum ramping angle [®] 0 - Without coolant supply, 1 - With coolant supply [®] Master insert identification [®] Recommended tightening torque (lb*in) for insert screw

MILL4FEED

FFQ4 D-M-09

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

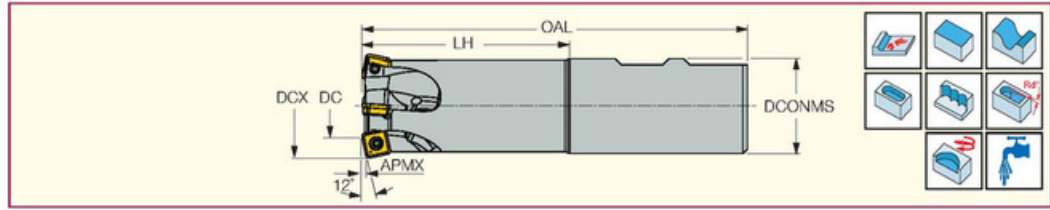


Designation	DCX [®]	DC	APMX	AE [®]	CICT [®]	THSZMS	LF	OAL	DCONMS	RMPX [®]	DRVS [®]		MIID [®]	TQ [®]
FFQ4 D1.50-05-M16-09	1.500	.933	.047	.280	5	M16	1.400	2.400	1.142	2.3	.984	.39	FFQ4 SOMT 090412T	17.70

MILL4FEED

FFQ4 D-W-09

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



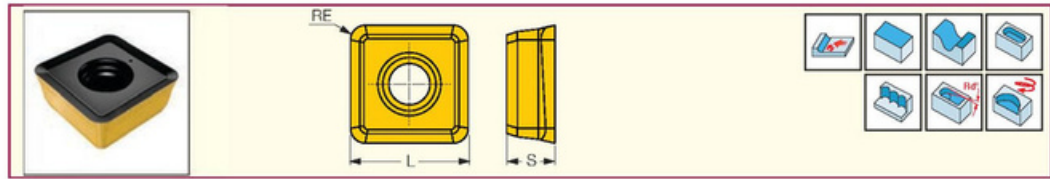
Designation	DCX [®]	DC	APMX	AE [®]	CICT [®]	LH	DCONMS	OAL	RMPX [®]	MIID [®]	TQ [®]
FFQ4 D0.87-2-1.7-W0.75-09	.875	.311	.047	.280	2	1.750	.750	3.800	8.0	.39	FFQ4 SOMT 090412T 17.70
FFQ4 D1.00-3-2.0-W1.00-09	1.000	.437	.047	.280	3	2.000	1.000	4.300	5.4	.74	FFQ4 SOMT 090412T 17.70
FFQ4 D1.25-4-2.5-W1.00-09	1.250	.689	.047	.280	4	2.500	1.000	4.800	3.3	.91	FFQ4 SOMT 090412T 17.70
FFQ4 D1.50-5-3.0-W1.25-09	1.500	.938	.047	.280	5	3.000	1.250	5.300	2.2	1.55	FFQ4 SOMT 090412T 17.70

• Radius for programming .098" • To generate a straight surface without cusps, the width of cut must not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%. [®] Cutting diameter maximum [®] Maximum plunging width [®] Number of inserts [®] Maximum ramping angle [®] Master insert identification [®] Recommended tightening torque (lb*in) for insert screw

MILL4FEED

FFQ4 SOMT 0904

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



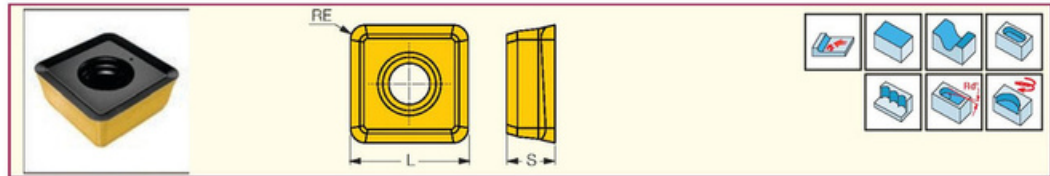
Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data	
	L	S	RE	IC882	IC830	IC5820	IC808	IC810	a (inch)	f (inch/t)
FFQ4 SOMT 090412T	.339	.154	.0472		•		•	•	.020-.047	.0157-.0590
FFQ4 SOMT 0904RM-T	.339	.150	.0472		•		•		.020-.047	.0157-.0590
FFQ4 SOMT 090412HP	.339	.150	.0472	•	•	•	•		.020-.047	.0157-.0551

• For side plunging, the initial cutting feed is .004 inch/t • 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

MILL4FEED

FFQ4 SOMT 1706

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



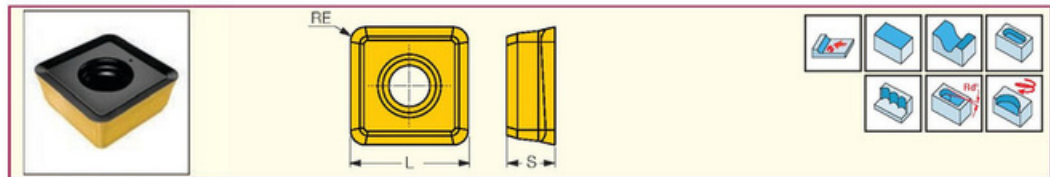
Designation	Dimensions			Tough ↔ Hard					Recommended Machining Data	
	L	S	RE	IC882	IC830	IC5820	IC808	IC810	a (inch)	f (inch/t)
FFQ4 SOMT 1706RM-T ⁽¹⁾	.689	.236	.0984				•		.047-.118	.0157-.0787
FFQ4 SOMT 170625HP ⁽²⁾	.689	.236	.0984	•	•		•		.047-.118	.0157-.0590
FFQ4 SOMT 170625T ⁽³⁾	.689	.236	.0984				•	•	.047-.118	.0157-.0787

• For side plunging, the initial cutting feed is .004 inch/t ⁽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

MILL4FEED

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 (inch)	f (inch/t)
FFQ4 SOMT 1205RM-HP	.500	.205	.063		•				.020-.059	.0157-.0709
FFQ4 SOMT 1205RM-T	.500	.205	.063				•		.020-.059	.0157-.0787
FFQ4 SOMT 120516HP	.500	.205	.063	•	•	•	•		.020-.059	.0157-.0709
FFQ4 SOMT 120516T	.500	.205	.063		•		•		.020-.059	.0157-.0787
FFQ4 SOMT 120516T20	.500	.205	.063					•	.020-.059	.0157-.0787