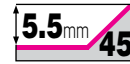


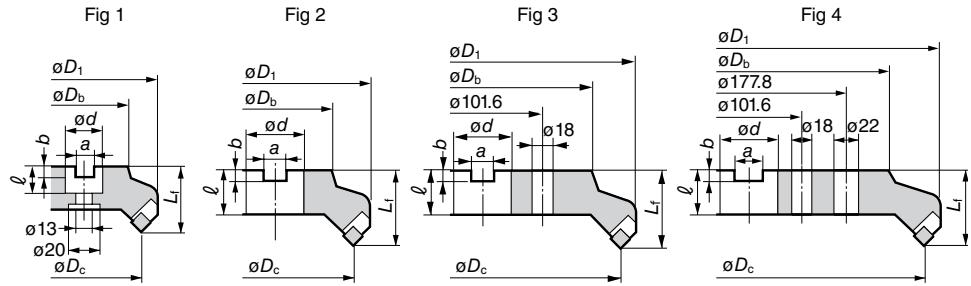
UFO4000 Type

Rake Angle	Radial	-7°
	Axial	+27°



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

General Milling for Steel and Hard-to-cut Material



Body Imperial

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
				øDc	øD1	øDb	Lf	ød	a	b	ℓ			
UFO 4080R	●	UFO 4080L		*80	102	60	50	25.4	9.5	6	25	4	2.1	1
4100R	●	4100L		100	122	70	50	31.75	12.7	8	32	5	2.9	2
4125R	●	4125L		125	146	75	63	38.1	15.9	10	38	6	4.2	2
4160R	●	4160L		160	180	100	63	50.8	19.1	11	38	8	6.6	2
4200R	●	4200L		200	220	130	63	47.625	25.4	14	35	10	9.5	3
UFO 4250R	●	UFO 4250L		250	270	130	63	47.625	25.4	14	35	12	14.8	3
4315R		4315L		315	335	240	80	47.625	25.4	14	35	14	26.6	4

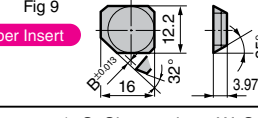
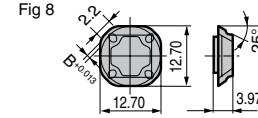
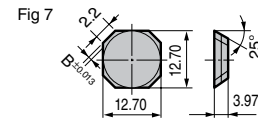
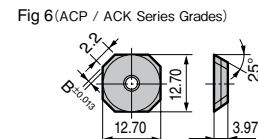
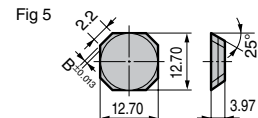


Inserts are not included.
*Please use hexagonal bolt (JISB1176) M12 x 30 to 35mm for securing ø80 cutter to the arbour.

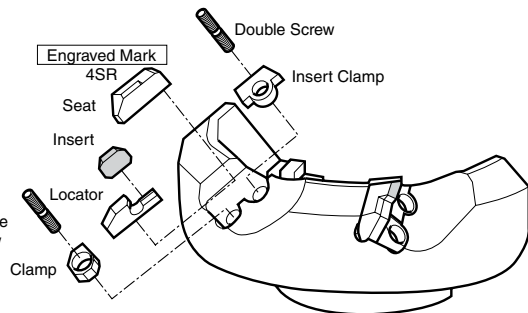
Inserts

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

Application	Grade	Coated Carbide						Carbide				SUMIDIA		
		P	M	K	N	S	H	P	K	N	S	H		
		High Speed/Light	General Purpose	Roughing										
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	G10E	H1	H10E	T250A		Fig
SFEN 12T3AZTN		●	●					●				●		5
12T3AZTN-S								●						5
12T3AZTN-W											●			5
12T3AZFN										●				5
SFKN 12T3AZTN		●	●	●				●				●		6(7)
12T3AZTN-S								●						7
12T3AZTN-W												●		7
12T3AZFN					●	●	●			●				6(7)
SFKR 12T3AZEN		●						●						8
UW 12500R												●		9



* -S: Sharp edge, -W: Strong edge



Spare Parts

Applicable Cutters	Locator Clamp	Insert Clamp	Double Screw	Size	Torque (N·m)	Seat	Locator
UFO 4000R Type	UFKWR	UFTWR	WB7-15T	M7	8.0	UF4SR	UF4KR
UFO 4000L Type	UFKWL	UFTWL	WB7-15T	M7	8.0	UF4SL	UF4KL

Note: Spanner used is TT25.

Recommended Tightening Torque (N·m)

Identification Details

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	100-175-250	0.15-0.23-0.30	ACP200
	Soft Steel	≤180HB	125-210-300	0.15-0.23-0.30	ACP200
	Die Steel	200 to 220HB	80-140-200	0.15-0.20-0.25	ACP200
M	Stainless Steel	—	160-190-220	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	—	300-550-800	0.15-0.23-0.30	H1

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.