



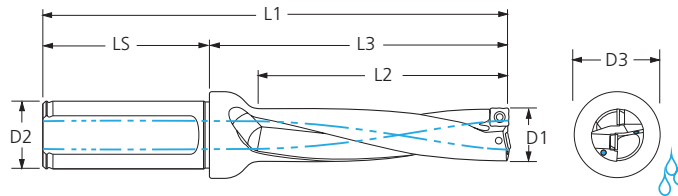
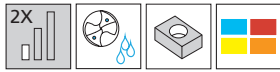
Where **high performance**
is the **standard**®



M.A. FORD MAX
RANGE

Series FMD
2, 3, 4 & 5xD

FMD 2xD Indexable Drill Ø14.0 - Ø48.0



Features

- Twisted "Double Helix" coolant channels
- Enlarged core thickness
- Optimised inner and outer inserts positions
- One insert for inner and outer positions
- Excels in steels and stainless steels

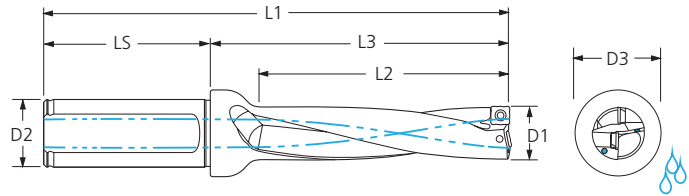
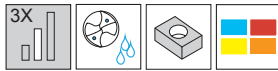
Benefits

- Improved chip evacuation and surface finish
- Improves drilling stability
- Self centres drill on entry
- Reduced stock inventory
- Increased tool-life and stable drilling process

EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2101	FMD-140-2D-FC20-Q04	14	20	25	94	31	44	50	040204
FH2102	FMD-145-2D-FC20-Q04	14.5	20	25	96	33	46	50	040204
FH2106	FMD-150-2D-FC20-Q04	15	20	25	97	35	47	50	040204
FH2107	FMD-155-2D-FC20-Q04	15.5	20	25	99	37	49	50	040204
FH2111	FMD-160-2D-FC25-Q05	16	20	25	101	37	51	50	050204
FH2112	FMD-165-2D-FC25-Q05	16.5	20	25	102	38	52	50	050204
FH2116	FMD-170-2D-FC25-Q05	17	25	32	109	38	53	56	050204
FH2117	FMD-175-2D-FC25-Q05	17.5	25	32	111	39	55	56	050204
FH2121	FMD-180-2D-FC25-Q05	18	25	32	112	41	56	56	050204
FH2122	FMD-185-2D-FC25-Q05	18.5	25	32	113	42	57	56	050204
FH2126	FMD-190-2D-FC25-Q06	19	25	32	114	42	58	56	060204
FH2127	FMD-195-2D-FC25-Q06	19.5	25	32	116	44	60	56	060204
FH2131	FMD-200-2D-FC25-Q06	20	25	32	117	44	61	56	060204
FH2132	FMD-205-2D-FC25-Q06	20.5	25	32	118	45	62	56	060204
FH2136	FMD-210-2D-FC25-Q06	21	25	32	120	47	64	56	060204
FH2137	FMD-215-2D-FC25-Q06	21.5	25	32	121	48	65	56	060204
FH2141	FMD-220-2D-FC25-Q06	22	25	32	122	49	66	56	060204
FH2142	FMD-225-2D-FC25-Q06	22.5	25	32	124	51	68	56	060204
FH2146	FMD-230-2D-FC25-Q07	23	25	32	125	50	69	56	07T306
FH2147	FMD-235-2D-FC25-Q07	23.5	25	32	126	51	70	56	07T306
FH2151	FMD-240-2D-FC25-Q07	24	25	32	127	53	71	56	07T306
FH2152	FMD-245-2D-FC25-Q07	24.5	25	32	129	55	73	56	07T306
FH2156	FMD-250-2D-FC25-Q07	25	25	32	130	54	74	56	07T306
FH2157	FMD-255-2D-FC32-Q07	25.5	32	40	136	55	76	60	07T306
FH2161	FMD-260-2D-FC32-Q07	26	32	40	137	56	77	60	07T306
FH2162	FMD-265-2D-FC32-Q07	26.5	32	40	138	58	78	60	07T306
FH2166	FMD-270-2D-FC32-Q07	27	32	40	139	59	79	60	07T306

EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2167	FMD-275-2D-FC32-Q09	27.5	32	40	141	61	81	60	09T308
FH2171	FMD-280-2D-FC32-Q09	28	32	40	142	60	82	60	09T308
FH2172	FMD-285-2D-FC32-Q09	28.5	32	40	143	62	83	60	09T308
FH2176	FMD-290-2D-FC32-Q09	29	32	40	144	63	84	60	09T308
FH2177	FMD-295-2D-FC32-Q09	29.5	32	40	146	65	86	60	09T308
FH2181	FMD-300-2D-FC32-Q09	30	32	40	147	65	87	60	09T308
FH2182	FMD-305-2D-FC32-Q09	30.5	32	40	149	68	89	60	09T308
FH2186	FMD-310-2D-FC40-Q09	31	40	48	160	67	90	70	09T308
FH2187	FMD-315-2D-FC40-Q09	31.5	40	48	161	68	91	70	09T308
FH2191	FMD-320-2D-FC40-Q09	32	40	48	162	70	92	70	09T308
FH2192	FMD-325-2D-FC40-Q09	32.5	40	48	164	72	94	70	09T308
FH2196	FMD-330-2D-FC40-Q09	33	40	48	165	71	95	70	09T308
FH2198	FMD-335-2D-FC40-Q11	33.5	40	48	167	73	97	70	110408
FH2202	FMD-340-2D-FC40-Q11	34	40	48	168	75	98	70	110408
FH2204	FMD-345-2D-FC40-Q11	34.5	40	48	169	76	99	70	110408
FH2208	FMD-350-2D-FC40-Q11	35	40	48	171	78	101	70	110408
FH2210	FMD-355-2D-FC40-Q11	35.5	40	48	172	79	102	70	110408
FH2214	FMD-360-2D-FC40-Q11	36	40	48	174	78	104	70	110408
FH2216	FMD-365-2D-FC40-Q11	36.5	40	48	175	80	105	70	110408
FH2220	FMD-370-2D-FC40-Q11	37	40	48	175	80	105	70	110408
FH2222	FMD-375-2D-FC40-Q11	37.5	40	48	176	81	106	70	110408
FH2226	FMD-380-2D-FC40-Q11	38	40	48	178	82	108	70	110408
FH2228	FMD-385-2D-FC40-Q11	38.5	40	48	179	84	109	70	110408
FH2232	FMD-390-2D-FC40-Q11	39	40	48	180	85	110	70	110408
FH2234	FMD-395-2D-FC40-Q11	39.5	40	48	182	85	112	70	110408
FH2238	FMD-400-2D-FC40-Q11	40	40	48	183	86	113	70	110408
FH2251	FMD-405-2D-FC40-Q13	40.5	40	48	185	89	115	70	130408
FH2252	FMD-410-2D-FC40-Q13	41	40	48	187	92	117	70	130408
FH2253	FMD-415-2D-FC40-Q13	41.5	40	48	188	94	118	70	130408
FH2254	FMD-420-2D-FC40-Q13	42	40	48	189	92	119	70	130408
FH2255	FMD-425-2D-FC40-Q13	42.5	40	48	191	92	121	70	130408
FH2256	FMD-430-2D-FC40-Q13	43	40	48	192	94	122	70	130408
FH2257	FMD-435-2D-FC40-Q13	43.5	40	48	193	96	123	70	130408
FH2258	FMD-440-2D-FC40-Q13	44	40	48	194	98	124	70	130408
FH2259	FMD-445-2D-FC40-Q13	44.5	40	48	195	99	125	70	130408
FH2260	FMD-450-2D-FC40-Q13	45	40	48	197	103	127	70	130408
FH2261	FMD-455-2D-FC40-Q15	45.5	40	48	198	97	128	70	150512
FH2262	FMD-460-2D-FC40-Q15	46	40	48	200	102	130	70	150512
FH2263	FMD-465-2D-FC40-Q15	46.5	40	48	201	100	131	70	150512
FH2264	FMD-470-2D-FC40-Q15	47	40	48	202	102	132	70	150512
FH2265	FMD-475-2D-FC40-Q15	47.5	40	48	203	106	133	70	150512
FH2266	FMD-480-2D-FC40-Q15	48	40	48	205	110	135	70	150512

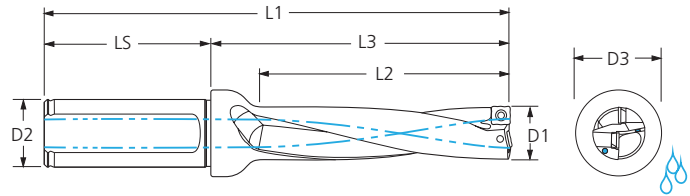
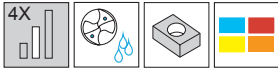
FMD 3xD Indexable Drill Ø14.0 - Ø48.0



EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2028	FMD-140-3D-FC20-Q04	14	20	25	108	45	58	50	040204
FH2103	FMD-145-3D-FC20-Q04	14.5	20	25	110	47	60	50	040204
FH2031	FMD-150-3D-FC20-Q04	15	20	25	112	50	62	50	040204
FH2108	FMD-155-3D-FC20-Q04	15.5	20	25	114	52	64	50	040204
FH2034	FMD-160-3D-FC20-Q05	16	20	25	116	51	66	50	050204
FH2113	FMD-165-3D-FC20-Q05	16.5	20	25	118	53	68	50	050204
FH2036	FMD-170-3D-FC25-Q05	17	25	32	125	54	69	56	050204
FH2118	FMD-175-3D-FC25-Q05	17.5	25	32	128	56	72	56	050204
FH2039	FMD-180-3D-FC25-Q05	18	25	32	129	58	73	56	050204
FH2123	FMD-185-3D-FC25-Q05	18.5	25	32	131	60	75	56	050204
FH2042	FMD-190-3D-FC25-Q06	19	25	32	132	60	76	56	060204
FH2128	FMD-195-3D-FC25-Q06	19.5	25	32	135	62	79	56	060204
FH2045	FMD-200-3D-FC25-Q06	20	25	32	137	64	81	56	060204
FH2133	FMD-205-3D-FC25-Q06	20.5	25	32	138	65	82	56	060204
FH2048	FMD-210-3D-FC25-Q06	21	25	32	140	67	84	56	060204
FH2138	FMD-215-3D-FC25-Q06	21.5	25	32	142	69	86	56	060204
FH2051	FMD-220-3D-FC25-Q06	22	25	32	143	69	87	56	060204
FH2143	FMD-225-3D-FC25-Q06	22.5	25	32	146	72	90	56	060204
FH2054	FMD-230-3D-FC25-Q07	23	25	32	147	72	91	56	07T306
FH2148	FMD-235-3D-FC25-Q07	23.5	25	32	149	75	93	56	07T306
FH2057	FMD-240-3D-FC25-Q07	24	25	32	151	76	95	56	07T306
FH2153	FMD-245-3D-FC25-Q07	24.5	25	32	153	77	97	56	07T306
FH2060	FMD-250-3D-FC25-Q07	25	25	32	155	79	99	56	07T306
FH2158	FMD-255-3D-FC32-Q07	25.5	32	40	160	80	100	60	07T306
FH2063	FMD-260-3D-FC32-Q07	26	32	40	162	81	102	60	07T306
FH2163	FMD-265-3D-FC32-Q07	26.5	32	40	164	84	104	60	07T306
FH2066	FMD-270-3D-FC32-Q07	27	32	40	165	85	105	60	07T306
FH2168	FMD-275-3D-FC32-Q09	27.5	32	40	168	88	108	60	09T308
FH2069	FMD-280-3D-FC32-Q09	28	32	40	169	87	109	60	09T308
FH2173	FMD-285-3D-FC32-Q09	28.5	32	40	171	90	111	60	09T308
FH2072	FMD-290-3D-FC32-Q09	29	32	40	172	91	112	60	09T308

EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2178	FMD-295-3D-FC32-Q09	29.5	32	40	175	93	115	60	09T308
FH2075	FMD-300-3D-FC32-Q09	30	32	40	177	95	117	60	09T308
FH2183	FMD-305-3D-FC32-Q09	30.5	32	40	178	97	118	60	09T308
FH2078	FMD-310-3D-FC40-Q09	31	40	48	191	98	121	70	09T308
FH2188	FMD-315-3D-FC40-Q09	31.5	40	48	192	98	122	70	09T308
FH2081	FMD-320-3D-FC40-Q09	32	40	48	194	101	124	70	09T308
FH2193	FMD-325-3D-FC40-Q09	32.5	40	48	196	103	126	70	09T308
FH2084	FMD-330-3D-FC40-Q09	33	40	48	198	104	128	70	09T308
FH2199	FMD-335-3D-FC40-Q11	33.5	40	48	200	106	130	70	110408
FH2086	FMD-340-3D-FC40-Q11	34	40	48	201	108	131	70	110408
FH2205	FMD-345-3D-FC40-Q11	34.5	40	48	204	109	134	70	110408
FH2088	FMD-350-3D-FC40-Q11	35	40	48	205	112	135	70	110408
FH2211	FMD-355-3D-FC40-Q11	35.5	40	48	207	114	137	70	110408
FH2090	FMD-360-3D-FC40-Q11	36	40	48	209	113	139	70	110408
FH2217	FMD-365-3D-FC40-Q11	36.5	40	48	211	116	141	70	110408
FH2092	FMD-370-3D-FC40-Q11	37	40	48	212	117	142	70	110408
FH2223	FMD-375-3D-FC40-Q11	37.5	40	48	214	118	144	70	110408
FH2094	FMD-380-3D-FC40-Q11	38	40	48	216	122	146	70	110408
FH2229	FMD-385-3D-FC40-Q11	38.5	40	48	218	122	148	70	110408
FH2096	FMD-390-3D-FC40-Q11	39	40	48	219	125	149	70	110408
FH2235	FMD-395-3D-FC40-Q11	39.5	40	48	221	124	151	70	110408
FH2098	FMD-400-3D-FC40-Q11	40	40	48	223	126	153	70	110408
FH2267	FMD-405-3D-FC40-Q13	40.5	40	48	225	126	126	70	130408
FH2268	FMD-410-3D-FC40-Q13	41	40	48	227	129	129	70	130408
FH2269	FMD-415-3D-FC40-Q13	41.5	40	48	226	132	132	70	130408
FH2270	FMD-420-3D-FC40-Q13	42	40	48	230	133	133	70	130408
FH2271	FMD-425-3D-FC40-Q13	42.5	40	48	232	133	133	70	130408
FH2272	FMD-430-3D-FC40-Q13	43	40	48	234	135	135	70	130408
FH2273	FMD-435-3D-FC40-Q13	43.5	40	48	236	136	136	70	130408
FH2274	FMD-440-3D-FC40-Q13	44	40	48	237	137	137	70	130408
FH2275	FMD-445-3D-FC40-Q13	44.5	40	48	240	139	139	70	130408
FH2276	FMD-450-3D-FC40-Q13	45	40	48	242	142	142	70	130408
FH2277	FMD-455-3D-FC40-Q15	45.5	40	48	244	143	143	70	150512
FH2278	FMD-460-3D-FC40-Q15	46	40	48	246	146	146	70	150512
FH2279	FMD-465-3D-FC40-Q15	46.5	40	48	248	150	150	70	150512
FH2280	FMD-470-3D-FC40-Q15	47	40	48	249	152	152	70	150512
FH2281	FMD-475-3D-FC40-Q15	47.5	40	48	251	155	155	70	150512
FH2282	FMD-480-3D-FC40-Q15	48	40	48	253	159	159	70	150512

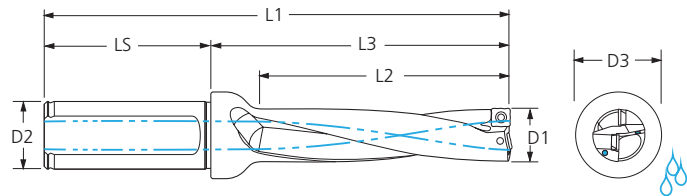
FMD 4xD Indexable Drill Ø14.0 - Ø44.0



EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2029	FMD-140-4D-FC20-Q04	14	20	25	122	59	72	50	040204
FH2104	FMD-145-4D-FC20-Q04	14.5	20	25	125	63	75	50	040204
FH2032	FMD-150-4D-FC20-Q04	15	20	25	127	64	77	50	040204
FH2109	FMD-155-4D-FC20-Q04	15.5	20	25	129	66	79	50	040204
FH2035	FMD-160-4D-FC20-Q05	16	20	25	132	67	82	50	050204
FH2114	FMD-165-4D-FC20-Q05	16.5	20	25	134	70	84	50	050204
FH2037	FMD-170-4D-FC25-Q05	17	25	32	142	71	86	56	050204
FH2119	FMD-175-4D-FC25-Q05	17.5	25	32	145	74	89	56	050204
FH2040	FMD-180-4D-FC25-Q05	18	25	32	147	76	91	56	050204
FH2124	FMD-185-4D-FC25-Q05	18.5	25	32	149	78	93	56	050204
FH2043	FMD-190-4D-FC25-Q06	19	25	32	151	79	95	56	060204
FH2129	FMD-195-4D-FC25-Q06	19.5	25	32	155	83	99	56	060204
FH2046	FMD-200-4D-FC25-Q06	20	25	32	157	84	101	56	060204
FH2134	FMD-205-4D-FC25-Q06	20.5	25	32	159	87	103	56	060204
FH2049	FMD-210-4D-FC25-Q06	21	25	32	161	88	105	56	060204
FH2139	FMD-215-4D-FC25-Q06	21.5	25	32	163	90	107	56	060204
FH2052	FMD-220-4D-FC25-Q06	22	25	32	165	92	109	56	060204
FH2144	FMD-225-4D-FC25-Q06	22.5	25	32	168	95	112	56	060204
FH2055	FMD-230-4D-FC25-Q07	23	25	32	170	99	114	56	07T306
FH2149	FMD-235-4D-FC25-Q07	23.5	25	32	173	102	117	56	07T306
FH2058	FMD-240-4D-FC25-Q07	24	25	32	175	101	119	56	07T306
FH2154	FMD-245-4D-FC25-Q07	24.5	25	32	178	104	122	56	07T306
FH2061	FMD-250-4D-FC25-Q07	25	25	32	180	104	124	56	07T306
FH2159	FMD-255-4D-FC32-Q07	25.5	32	40	186	107	126	60	07T306
FH2064	FMD-260-4D-FC32-Q07	26	32	40	188	108	128	60	07T306
FH2164	FMD-265-4D-FC32-Q07	26.5	32	40	190	110	130	60	07T306
FH2067	FMD-270-4D-FC32-Q07	27	32	40	192	112	132	60	07T306
FH2169	FMD-275-4D-FC32-Q09	27.5	32	40	195	113	135	60	09T308
FH2070	FMD-280-4D-FC32-Q09	28	32	40	197	115	137	60	09T308
FH2174	FMD-285-4D-FC32-Q09	28.5	32	40	199	118	139	60	09T308
FH2073	FMD-290-4D-FC32-Q09	29	32	40	201	120	141	60	09T308

EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2179	FMD-295-4D-FC32-Q09	29.5	32	40	204	123	144	60	09T308
FH2076	FMD-300-4D-FC32-Q09	30	32	40	207	125	147	60	09T308
FH2184	FMD-305-4D-FC32-Q09	30.5	32	40	208	126	148	60	09T308
FH2079	FMD-310-4D-FC40-Q09	31	40	48	222	129	152	70	09T308
FH2189	FMD-315-4D-FC40-Q09	31.5	40	48	224	131	154	70	09T308
FH2082	FMD-320-4D-FC40-Q09	32	40	48	226	134	156	70	09T308
FH2194	FMD-325-4D-FC40-Q09	32.5	40	48	229	137	159	70	09T308
FH2085	FMD-330-4D-FC40-Q09	33	40	48	231	138	161	70	09T308
FH2200	FMD-335-4D-FC40-Q11	33.5	40	48	233	142	163	70	110408
FH2087	FMD-340-4D-FC40-Q11	34	40	48	235	142	165	70	110408
FH2206	FMD-345-4D-FC40-Q11	34.5	40	48	238	142	168	70	110408
FH2089	FMD-350-4D-FC40-Q11	35	40	48	240	146	170	70	110408
FH2212	FMD-355-4D-FC40-Q11	35.5	40	48	243	146	173	70	110408
FH2091	FMD-360-4D-FC40-Q11	36	40	48	245	150	175	70	110408
FH2218	FMD-365-4D-FC40-Q11	36.5	40	48	247	152	177	70	110408
FH2093	FMD-370-4D-FC40-Q11	37	40	48	249	154	179	70	110408
FH2224	FMD-375-4D-FC40-Q11	37.5	40	48	252	158	182	70	110408
FH2095	FMD-380-4D-FC40-Q11	38	40	48	254	157	184	70	110408
FH2230	FMD-385-4D-FC40-Q11	38.5	40	48	256	160	186	70	110408
FH2097	FMD-390-4D-FC40-Q11	39	40	48	258	165	188	70	110408
FH2236	FMD-395-4D-FC40-Q11	39.5	40	48	261	166	191	70	110408
FH2099	FMD-400-4D-FC40-Q11	40	40	48	263	164	193	70	110408
FH2283	FMD-405-4D-FC40-Q13	40.5	40	48	265	167	195	70	130408
FH2284	FMD-410-4D-FC40-Q13	41	40	48	268	169	198	70	130408
FH2285	FMD-415-4D-FC40-Q13	41.5	40	48	270	171	200	70	130408
FH2286	FMD-420-4D-FC40-Q13	42	40	48	272	174	202	70	130408
FH2287	FMD-425-4D-FC40-Q13	42.5	40	48	274	175	204	70	130408
FH2288	FMD-430-4D-FC40-Q13	43	40	48	277	177	207	70	130408
FH2289	FMD-435-4D-FC40-Q13	43.5	40	48	279	179	209	70	130408
FH2290	FMD-440-4D-FC40-Q13	44	40	48	281	181	211	70	130408

FMD 5xD Indexable Drill Ø14.0 - Ø40.0



EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	L5	Insert QPMG
FH2030	FMD-140-5D-FC20-Q04	14	20	25	136	73	86	50	040204
FH2105	FMD-145-5D-FC20-Q04	14.5	20	25	140	77	90	50	040204
FH2033	FMD-150-5D-FC20-Q04	15	20	25	142	79	92	50	040204
FH2110	FMD-155-5D-FC20-Q04	15.5	20	25	145	81	95	50	040204
FH2100	FMD-160-5D-FC20-Q05	16	20	25	148	83	98	50	050204
FH2115	FMD-165-5D-FC20-Q05	16.5	20	25	151	87	101	50	050204
FH2038	FMD-170-5D-FC25-Q05	17	25	32	160	90	104	56	050204
FH2120	FMD-175-5D-FC25-Q05	17.5	25	32	163	93	107	56	050204
FH2041	FMD-180-5D-FC25-Q05	18	25	32	165	94	109	56	050204
FH2125	FMD-185-5D-FC25-Q05	18.5	25	32	168	97	112	56	050204
FH2044	FMD-190-5D-FC25-Q06	19	25	32	170	99	114	56	060204
FH2130	FMD-195-5D-FC25-Q06	19.5	25	32	174	103	118	56	060204
FH2047	FMD-200-5D-FC25-Q06	20	25	32	177	104	121	56	060204
FH2135	FMD-205-5D-FC25-Q06	20.5	25	32	180	107	124	56	060204
FH2050	FMD-210-5D-FC25-Q06	21	25	32	182	109	126	56	060204
FH2140	FMD-215-5D-FC25-Q06	21.5	25	32	185	112	129	56	060204
FH2053	FMD-220-5D-FC25-Q06	22	25	32	187	113	131	56	060204
FH2145	FMD-225-5D-FC25-Q06	22.5	25	32	190	116	134	56	060204
FH2056	FMD-230-5D-FC32-Q07	23	32	40	198	120	138	60	07T306
FH2150	FMD-235-5D-FC32-Q07	23.5	32	40	200	122	140	60	07T306
FH2059	FMD-240-5D-FC32-Q07	24	32	40	203	124	143	60	07T306
FH2155	FMD-245-5D-FC32-Q07	24.5	32	40	206	127	146	60	07T306
FH2062	FMD-250-5D-FC32-Q07	25	32	40	209	129	149	60	07T306
FH2160	FMD-255-5D-FC32-Q07	25.5	32	40	213	133	153	60	07T306
FH2065	FMD-260-5D-FC32-Q07	26	32	40	217	137	157	60	07T306
FH2165	FMD-265-5D-FC32-Q07	26.5	32	40	218	138	158	60	07T306
FH2068	FMD-270-5D-FC32-Q07	27	32	40	219	139	159	60	07T306
FH2170	FMD-275-5D-FC32-Q09	27.5	32	40	222	142	162	60	09T308
FH2071	FMD-280-5D-FC32-Q09	28	32	40	225	143	165	60	09T308
FH2175	FMD-285-5D-FC32-Q09	28.5	32	40	229	147	169	60	09T308
FH2074	FMD-290-5D-FC32-Q09	29	32	40	231	150	171	60	09T308

EDP	Tool Number	Ø D1	Ø D2	Ø D3	L1	L2	L3	LS	Insert QPMG
FH2180	FMD-295-5D-FC32-Q09	29.5	32	40	234	153	174	60	09T308
FH2077	FMD-300-5D-FC32-Q09	30	32	40	237	155	177	60	09T308
FH2185	FMD-305-5D-FC32-Q09	30.5	32	40	240	158	180	60	09T308
FH2080	FMD-310-5D-FC40-Q09	31	40	48	253	160	183	70	09T308
FH2190	FMD-315-5D-FC40-Q09	31.5	40	48	256	163	186	70	09T308
FH2083	FMD-320-5D-FC40-Q09	32	40	48	258	166	188	70	09T308
FH2291	FMD-325-5D-FC40-Q09	32.5	40	48	262	170	192	70	09T308
FH2292	FMD-330-5D-FC40-Q09	33	40	48	264	171	194	70	09T308
FH2293	FMD-335-5D-FC40-Q11	33.5	40	48	269	175	199	70	110408
FH2294	FMD-340-5D-FC40-Q11	34	40	48	269	176	199	70	110408
FH2295	FMD-345-5D-FC40-Q11	34.5	40	48	269	176	199	70	110408
FH2296	FMD-350-5D-FC40-Q11	35	40	48	275	181	205	70	110408
FH2297	FMD-355-5D-FC40-Q11	35.5	40	48	275	182	205	70	110408
FH2298	FMD-360-5D-FC40-Q11	36	40	48	281	186	211	70	110408
FH2299	FMD-365-5D-FC40-Q11	36.5	40	48	284	189	214	70	110408
FH2300	FMD-370-5D-FC40-Q11	37	40	48	286	191	216	70	110408
FH2301	FMD-375-5D-FC40-Q11	37.5	40	48	290	195	220	70	110408
FH2302	FMD-380-5D-FC40-Q11	38	40	48	292	195	222	70	110408
FH2303	FMD-385-5D-FC40-Q11	38.5	40	48	295	198	225	70	110408
FH2304	FMD-390-5D-FC40-Q11	39	40	48	297	204	227	70	110408
FH2305	FMD-395-5D-FC40-Q11	39.5	40	48	303	207	233	70	110408
FH2306	FMD-400-5D-FC40-Q11	40	40	48	303	204	233	70	110408

Inserts & Spare Parts

Inserts

Insert Number	Grades			DP
	FA6230	FM3120	FS6030	
	EDP			
QPMG040204-DP	FW1400	FW4808	FW1401	
QPMG050204-DP	FW1402	FW4809	FW1403	
QPMG060204-DP	FW1404	FW4810	FW1405	
QPMG07T306-DP	FW1406	FW4811	FW1407	
QPMG09T308-DP	FW1408	FW4812	FW1409	
QPMG110408-DP	FW1410	FW4813	FW1411	
QPMG130408-DP	FW1412	FW4814	FW1413	
QPMG150512-DP	FW1414	FW4815	FW1415	

Spare Parts

			Insert Screw		Torx Plus Flag Key	
						
Insert		Nm	EDP	Part No.	EDP	Part Number
QPMG040204-DP	5IP	0.4	FS1138	MS20050GIP	FS1149	FH180-IP5
QPMG050204-DP	6IP	0.6	FS1139	MS22055GIP	FS1150	FH180-IP6
QPMG060204-DP	6IP	0.6	FS1139	MS22055GIP	FS1150	FH180-IP6
QPMG07T306-DP	7IP	0.9	FS1140	MS25070GIP	FS1151	FH180-IP7
QPMG09T308-DP	9IP	1.4	FS1141	MS30080GIP	FS1153	FH180-IP9
QPMG110408-DP	15IP	3.0	FS1142	MS40100GIP	FS1147	FH180-IP15
QPMG130408-DP	15IP	3.0	FS1142	MS40100GIP	FS1147	FH180-IP15
QPMG150512-DP	20IP	3.8	FS1027	MS50110GIP	FS1148	FH180-IP20

Inserts & Spare Parts

Grades & Applications

Grade	Type	Coating	Application
FA6230	PVD	TiAlN	Universal grade that works in a wide range of materials including steels, stainless steels and cast irons.
FM3120	PVD	TiAlSiN	First choice for stainless steels, and also works well in carbon and alloy steels. High cobalt content offers increased toughness with excellent wear resistance. Suitable for medium and low cutting speeds.
FS6030	PVD	TiAlN	Stainless steels, titaniums and high temperature alloys. Suitable for unstable conditions.

Recommended cutting data

Workpiece Material Group		Material Type	Cutting Speed Vc (m/min)	Feed (mm/rev) Based On Drill Diameter Range			
				Ø14.0 - Ø22.5	Ø23.0 - Ø27.0	Ø27.5 - Ø33.0	Ø33.5 - Ø48.0
Steels	P	Low Carbon Steels	160 - 240 - 300	0.04 - 0.10	0.04 - 0.12	0.06 - 0.16	0.08 - 0.18
		Medium Carbon Steels	140 - 180 - 220	0.04 - 0.10	0.04 - 0.12	0.06 - 0.16	0.08 - 0.18
		Alloy Steels	100 - 160 - 200	0.04 - 0.10	0.04 - 0.12	0.06 - 0.16	0.08 - 0.18
		Die/Tool Steels	80 - 160 - 200	0.04 - 0.10	0.04 - 0.12	0.06 - 0.16	0.08 - 0.18
Stainless Steels	M	Free Machining Stainless	100 - 140 - 200	0.04 - 0.10	0.06 - 0.12	0.06 - 0.14	0.06 - 0.16
		Austenitic Stainless	100 - 130 - 180	0.04 - 0.10	0.06 - 0.12	0.06 - 0.14	0.06 - 0.16
		Difficult Stainless	60 - 130 - 180	0.03 - 0.08	0.04 - 0.12	0.06 - 0.14	0.06 - 0.16
		PH Stainless	60 - 140 - 180	0.03 - 0.08	0.04 - 0.12	0.06 - 0.14	0.06 - 0.16
		Duplex Stainless	60 - 140 - 180	0.03 - 0.08	0.04 - 0.12	0.06 - 0.14	0.06 - 0.16
Cast Irons	K	Grey Cast Iron	140 - 180 - 230	0.04 - 0.10	0.06 - 0.14	0.06 - 0.16	0.08 - 0.20
		Moderate Nodular Cast Iron	120 - 160 - 200	0.04 - 0.10	0.06 - 0.14	0.06 - 0.16	0.08 - 0.20
		Difficult Nodular Cast Iron	120 - 160 - 200	0.04 - 0.10	0.06 - 0.12	0.08 - 0.16	0.08 - 0.18
Special Alloys	S	High Temperature Alloys	30 - 50 - 70	0.03 - 0.06	0.04 - 0.08	0.04 - 0.10	0.06 - 0.12
		Titanium Alloys	30 - 50 - 80	0.03 - 0.08	0.04 - 0.10	0.04 - 0.10	0.06 - 0.12



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M.A. Ford Europe Ltd.

650 City Gate
London Road, Derby
DE24 8WY
United Kingdom

Tel: +44(0) 1332 267960
Fax: +44(0) 1332 267969
e-mail: sales@mafordeurope.com
www.mafordeurope.com

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7737 Northwest Blvd.
Davenport,
IA 52806
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e-mail: sales@maford.com
www.maford.com

M.A. Ford® Asia-Pacific Limited

Room 1709, Level 17
Millennium City 2
378 Kwun Tong Road
Kowloon, Hong Kong

Tel: +852-2167-7150
Fax: +852-2167-8150
Email: sales@mafordap.com