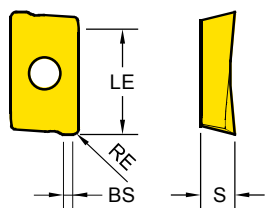


Milling - Shoulder Milling - Inserts  
**APKT** - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APKT 1003	9.9	6.7	3.6
APKT 1604	15.2	9.4	5.3

**EDP 1200..**

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30	K30			M35	S30	H15
S20						

APKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..							
					YG602	YG622	YG712	YG713	YG603	YG501	YG5020	
APKT General	APKT 100305 PDTR	0.5	0.15 ~ 0.24	0.86	●0005	●0429		●0638				
	APKT 100308 PDTR	0.8	0.15 ~ 0.24	0.90	●0004	●0430		●0632				
	APKT 160404 PDTR	0.4	0.15 ~ 0.25	1.11	●0003							
	APKT 160408 PDTR	0.8	0.15 ~ 0.30	1.32	●0001			●0633				
	APKT 160412 PDTR	1.2	0.15 ~ 0.32	1.13	●0002							
	APKT 160416 PDTR	1.6	0.15 ~ 0.34	1.13	●0006							
	APKT 160424 PDTR	2.4	0.15 ~ 0.38		●0255							
-ST Stainless Steel Super Alloy	APKT 100305 - ST	0.5	0.08 ~ 0.22	0.86	●0278							
	APKT 160408 - ST	0.8	0.08 ~ 0.25	1.32	●0270							
-TR Hardened Steel	APKT 160404 - TR	0.4	0.26 ~ 0.40	2.12	●0492	●0505						
	APKT 160408 - TR	0.8	0.26 ~ 0.40	1.32	●0256	●0337						
	APKT 160412 - TR	1.2	0.26 ~ 0.40	2.40	●0493	●0523						
	APKT 160416 - TR	1.6	0.26 ~ 0.40	2.40	●0472	●0524						
	APKT 160424 - TR	2.4	0.26 ~ 0.40	1.50	●0494	●0520						

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	150	280	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	130	235	70	210	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	90	130	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	20	40	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	50	100	-	-	50	90	-	-

Milling - Shoulder Milling - Inserts  
**APXT** - Shoulder Milling Positive (2 Corner)

TURNING

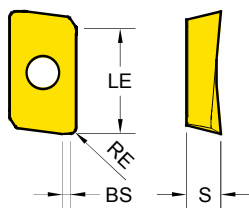
PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION


Series	LE	IC	S
APXT 1604	14.6	9.2	4.8



EDP 1200..

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15	N15
M30				M35			
K30	K30			S30	H15		
S20							

APXT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020	YG50
	APXT 160408 -AL	0.8	0.1 ~ 1.3	1.75								○ 0528
<b>-AL</b> Aluminium												

Cutting Speed			Vc (m/min.)															
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	150	280	90	230	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	130	235	70	210	-	-	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	90	130	60	100	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	80	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	100	200	-	-	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	180	350	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	120	270	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	300	800
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	20	40	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	50	100	-	-	50	90	-	-	-	-