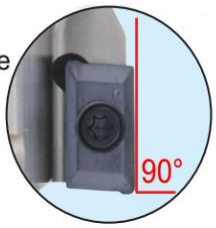
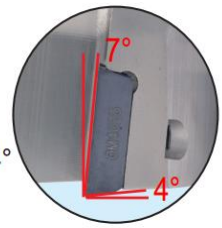
SQUARE SHOULDER MILLING CUTTER

- Providing perfect processing surface when this cutter is being used to process on the machine table.

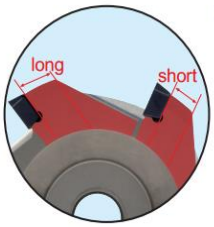


- Good sharpness because of the design of AR+7°, R.R.+4° for insert tip.



- After heat treatment, the connection between insert and insert seat is more closely-contacted, having high hardness, good toughness with good effect of vibration resistance and superior precision.

- Smooth cutting, low noises and reduced wear rate of inserts are provided because of the design of differential pitch.



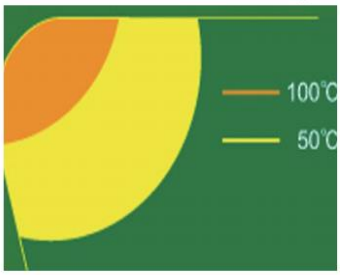
- Suitable for big table feed cutting because of the design of larger metal removal space.

- Excellent design of cutting angle and good metal chips removal, leading to longer use life of inserts.

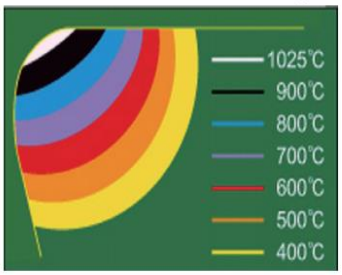
- Different designs of the teeth have different specialities and functions, which help customers with different manufacturing solutions.
- It's made of high alloy element Cr. After special treatment, the body is not easy to get rusty and has good durability.
- Two kinds of designs: with or without coolant holes for customers to choose from.
- The design of coolant holes extends the use life of inserts and is good for metal chips removal and heat dissipation.

Comparison Chart of Color Temperature

Cutter with coolant holes design:



Cutter without coolant holes design:

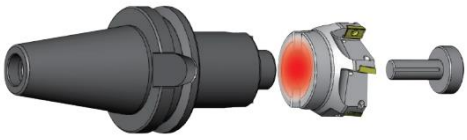


What superiorities are there to use cutter with coolant holes? Please refer to the left charts.

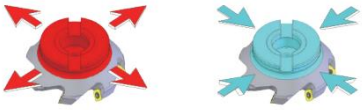
- Extending the use life of inserts by 40%.
- Reducing the cost of cutters.
- Improving the productivity.
- Decreasing the surface roughness.

Good cooling fluid can reduce the heat of insert tips.

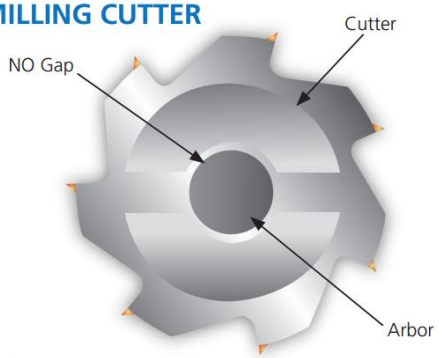
ShrinkMILL:



ShrinkFIT TECHNOLOGY



ShrinkFIT FACE MILLING CUTTER



- More rigid, powerful and accurate connection between cutter and arbor!

INSERTS FOR IFMC, SIFM, SRM TYPE

Machining Materials	GRADE					
	PL30	RM4130	RM3130	OM4025	OM4025N	RM5005
P	△	△		△	△	
M		△		△		
K	△		△	△		
N						△
S						
H						

TYPE	GRADE						DIMENSION			
	PL30	RM4130	RM3130	OM4025	OM4025N	RM5005	d	i	s	r
APKT1604PDTR	V						-	15.3	4.76	0.8
APKT100304PDER - M04		V					6.68	10.5	2.38	0.4
APKT160408PDER - M02		V	V				9.525	16.4	4.76	0.8
APKT160408 - M01				V	V		9.525	16.6	4.76	0.8
APEX1604PDFR - F01						V	9.525	16.4	4.76	-

Cutting Conditions

Machining Materials		Grade	Vc(m/min)	fz(mm/rev)	Ap(mm)
P	Low-Alloy Steels	RM4130	60 ~ 300	0.10 ~ 0.25	3.0 ~ 8.0
		OM4025	220 ~ 300	0.14 ~ 0.24	1.0 ~ 2.0
		OM4025N	220 ~ 300	0.14 ~ 0.24	1.0 ~ 2.0
	Alloyed Steels	PL30	90 ~ 230	0.15 ~ 0.25	0.5 ~ 15
		RM4130	60 ~ 300	0.10 ~ 0.25	3.0 ~ 8.0
		OM4025	100 ~ 195	0.12 ~ 0.20	1.0 ~ 2.0
M	Stainless Steels	RM4130	120 ~ 160	0.15 ~ 0.25	3.0 ~ 8.0
		OM4025	180 ~ 230	0.15 ~ 0.35	0.5 ~ 1.5
K	Cast Iron	PL30	120 ~ 250	0.12 ~ 0.22	0.5 ~ 15
		RM3130	200 ~ 300	0.06 ~ 0.30	1.5 ~ 3.0
		OM4025	200 ~ 300	0.06 ~ 0.30	1.5 ~ 3.0
N	Aluminum & Al	RM5005	400 ~ 850	0.05 ~ 0.30	1.5 ~ 3.0

Product information:

- Spindle Revolution = (1000 ×cutting speed) ÷ (3.14 × the external dia. of cutting tool)
- Table feed(mm/min) = table feed of each tooth × total teeth of cutting tool × spindle revolution