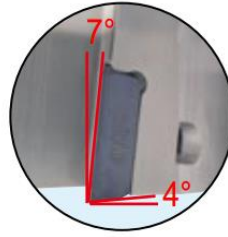


SHELL ROUGH FIXATION MILL

- 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.



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



| 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 |
| M | Alloyed Steels | PL30 | 90 ~ 230 | 0.15 ~ 0.25 | 0.5 ~ 15 |
| | | RM4130 | 60 ~ 300 | 0.10 ~ 0.25 | 3.0 ~ 8.0 |
| K | Stainless Steels | OM4025 | 100 ~ 195 | 0.12 ~ 0.20 | 1.0 ~ 2.0 |
| | | RM4130 | 120 ~ 160 | 0.15 ~ 0.25 | 3.0 ~ 8.0 |
| N | Cast Iron | OM4025 | 180 ~ 230 | 0.15 ~ 0.35 | 0.5 ~ 1.5 |
| | | PL30 | 120 ~ 250 | 0.12 ~ 0.22 | 0.5 ~ 15 |
| N | Aluminum & Al | RM3130 | 200 ~ 300 | 0.06 ~ 0.30 | 1.5 ~ 3.0 |
| | | OM4025 | 200 ~ 300 | 0.06 ~ 0.30 | 1.5 ~ 3.0 |
| | | RM5005 | 400 ~ 850 | 0.05 ~ 0.30 | 1.5 ~ 3.0 |