

Milling

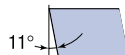


**A**



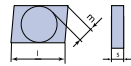
**Shape**  
80° Diamond

**D**



**Clearance Angle**  
15°

**K**



**Tolerance**  
l ± 0.05 m ± 0.013  
s ± 0.025

**T**



**Insert Type**  
Screw Down Clamping  
no chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
ADKT 1505 PDTR	LT 30	15	5,56	90°	15°	Right	M0001573	136

**Surfacing Insert Lead angle 90°**

Application Guide	Slotting	Shoulder Milling	Surfacing

Multi purpose 90° milling insert. Suitable for Roughing to Finishing - Slotting, Shoulder and Face milling operations.

Machining Recommendation Guide - Please see Pg. 8		



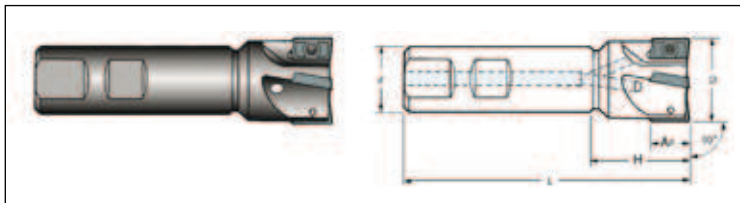
## ADKT 1505 PDTR

Cutters Milling

ADKT

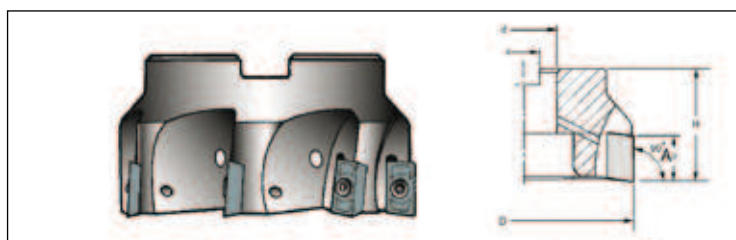
Catalog Nr.	Description	D	d	L	H	Ap	z
M2001613	LT 790 W-W-D25	25	25	100	44	15	2
M2001503	LT 790 W-W-D32	32	32	110	50	15	3
M2001614	LT 790 W-W-D40	40	32	115	45	15	4

Screw set: VT 40 Key set: CT 15



Catalog Nr.	Description	D	d	H	Ap	z
M2001615	LT 790 M-W-D40	40	16	40	15	4
M2001504	LT 790 M-W-D50	50	22	40	15	5
M2001616	LT 790 M-W-D63	63	22	40	15	6
M2001617	LT 790 M-W-D80	80	27	50	15	7
M2001618	LT 790 M-W-D100	100	32	50	15	8
M2001619	LT 790 M-W-D125	125	40	63	15	9

W = With coolant Screw set: VT 50 Key set: CT 15



Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	14.0	0.18	0.32	180	300
			180		14.0		0.32		260
			210		14.0		0.32		220
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	14.0	0.15	0.25	130	200
			230		14.0		0.25		180
			280	0.5	14.0	0.15	0.22	100	160
			320		14.0		0.22		140
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	10.0	0.12	0.22	90	130
			280		10.0		0.22		110
			320	0.5	10.0	0.12	0.18	60	100
			350		10.0		0.18		90
			400	0.5	5.0	0.10	0.18	40	80
			480		3.0		0.16		70
			550		1.5		0.14		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	14.0	0.15	0.25	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	14.0	0.12	0.22	120	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	10.0	0.12	0.18	70	120
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	14.0	0.15	0.25	150	230
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	14.0	0.15	0.25	130	210
			Treated	0.5	14.0	0.15	0.20	90	150
Grey Cast Iron	9	GG 20	140 to 230	0.5	14.0	0.18	0.32	150	240
		GG 25							220
		GG 30							190
Nodular Cast Iron	10	GGG 40	210	0.5	14.0	0.15	0.28	100	200
		GGG 50	260						160
		GGG 70	310	0.5	3.0	0.10	0.14	30	130
		G-X260NiCr42	450						60
Nickel Based Alloys	11	Inconel 625	-----	0.5	10.0	0.12	0.18	25	35
		Inconel 718						28	38
		Hastelloy C						40	65
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	10.0	0.12	0.20	35	60
		T40					0.18	28	40