

Milling



**A**

**O**

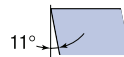
**M**

**T**

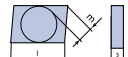
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**Shape**  
80° Diamond



**Clearance Angle**  
15°



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



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

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
AOMT 123608 PETR LT 30	15	5,56	90°	15°	Right	M0001640	139	

**Surfacing Insert Lead angle 90°**

Application Guide

Slotting

Shoulder Milling

Surfacing

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

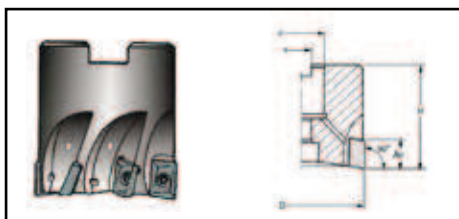
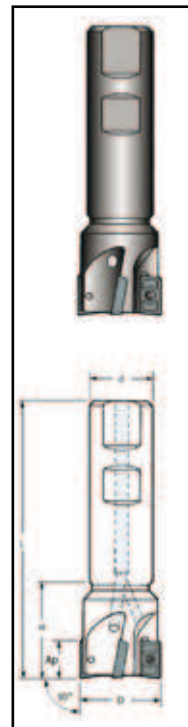
Stainless Steel

Vc

Machining Recommendation Guide - Please see Pg. 8



Catalog Nr.	Description	D	d	L	H	Ap	z
M2001817	LT720 W-W-D16/1	16	16	85	25	10	1
M2001781	LT720 W-W-D16/2	16	16	85	25	10	2
M2001818	LT720 W-W-D20/2	20	20	100	30	10	2
M2001782	LT720 W-W-D20/3	20	20	100	30	10	3
M2001783	LT720 W-W-D25/3	25	25	115	35	10	3
M2001819	LT720 W-W-D25/4	25	25	115	35	10	4
M2001820	LT720 W-W-D32/4	32	32	125	45	10	4
M2001784	LT720 W-W-D32/5	32	32	125	45	10	5



Catalog Nr.	Description	D	d	H	Ap	z
M2001785	LT 720 M-W-D40/6	40	22	40	10	6
M2001821	LT 720 M-W-D50/7	50	22	40	10	7

W = With coolant

Screw set: VT 25 Key set: BT 08



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	11.0	0.10	0.38	180	300
			180		11.0		0.25		260
			210		11.0		0.23		220
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	11.0	0.08	0.22	130	200
			230		11.0		0.22		180
			280	0.5	11.0	0.08	0.18	100	160
			320		11.0		0.18		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	7.0	0.08	0.18	90	130
			280		7.0		0.18		110
			320	0.5	7.0	0.08	0.16	60	100
			350		7.0		0.16		90
			400	0.5	4.0	0.10	0.16	40	80
			480		2.0		0.15		70
			550		1.0		0.14		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	7.0	0.10	0.22	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	7.0	0.10	0.20	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	7.0	0.08	0.18	70	120
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	7.0	0.08	0.20	150	230
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	7.0	0.08	0.20	130	210
			Treated	0.5	7.0	0.08	0.20	90	150
Grey Cast Iron	9	GG 20 GG 25 GG 30	140 to 230	0.5	9.0	0.10	0.25	150	240 220 190
Nodular Cast Iron	10	GGG 40	210	0.5	9.0	0.10	0.22	100	200
		GGG 50	260						160
		GGG 70	310						130
		G-X260NiCr42	450	0.5	3.0	0.10	0.14	30	60
Nickel Based Alloys	11	Inconel 625	-----	0.5	5.0	0.08	0.15	25	35
		Inconel 718						28	38
		Hastelloy C						40	65
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	5.0	0.08	0.18	35	60
		T40					0.15	28	40

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