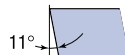




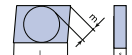
APLX



Shape
80° Diamond



Clearance Angle
15°



Tolerance
l ± 0.05 m ± 0.013
s ± 0.025



Insert Type
Screw Down Clamping
no chip breaker

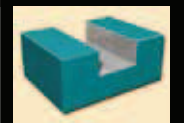
APLX

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
APLX 1003 PDTR	LT 30	10	3,18	90°	15°	Right	M0000454	148
APLX 100308 PDTR	LT 30	10	3,18	0,8	15°	Right	M0001151	148
APLX 100332 PDTR	LT 30	10	3,18	3,2	15°	Right	M0001566	149
APLX 100340 PDTR	LT 30	10	3,18	4,0	15°	Right	M0001567	149

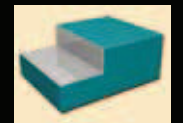
Surfacing Insert Lead angle 90°

Application Guide


Slotting



Shoulder Milling



Surfacing



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



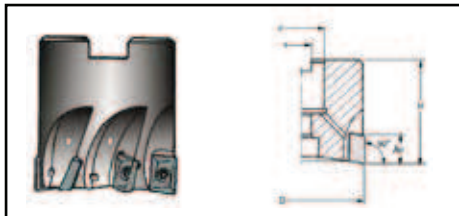
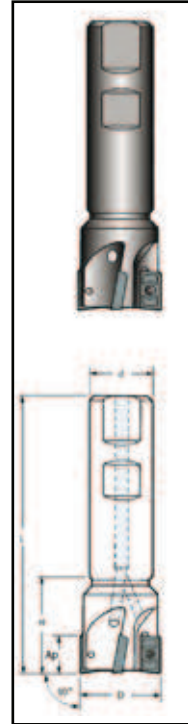


Stainless Steel



Machining Recommendation Guide - Please see Pg. 8

Catalog Nr.	Description	D	d	L	H	Ap	z
M2000518	LT 740 W-W-D10/1	10	16	80	24	9	1
M2000530	LT 740 W-WL-D10	10	16	150	24	9	1
M2000519	LT 740 W-W-D12/1	12	16	80	24	9	1
M2000531	LT 740 W-WL-D12	12	16	150	24	9	1
M2000520	LT 740 W-W-D14/1	14	16	80	24	9	1
M2000521	LT 740 W-W-D16/2	16	16	85	25	9	2
M2000532	LT 740 W-WL-D16	16	16	150	24	9	2
M2000522	LT 740 W-W-D18/2	18	20	85	25	9	2
M2000523	LT 740 W-W-D20	20	20	90	25	9	3
M2000533	LT 740 W-WL-D20	20	20	150	25	9	3
M2000524	LT 740 W-W-D22	22	25	95	25	9	3
M2000525	LT 740 W-W-D25/3	25	25	95	25	9	3
M2000526	LT 740 W-W-D25	25	25	95	25	9	4
M2000534	LT 740 W-WL-D25	25	20	150	25	9	4
M2000527	LT 740 W-W-D28	28	25	95	25	9	4
M2000528	LT 740 W-W-D30	30	25	95	25	9	4
M2000529	LT 740 W-W-D32	32	25	95	26	9	5
M2000535	LT 740 W-WL-D32	32	25	150	26	9	5



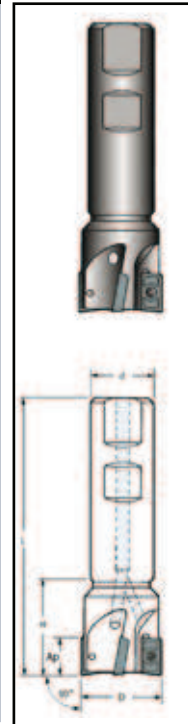
Catalog Nr.	Description	D	d	H	Ap	z
M2000514	LT 740 M-W-D40/6	40	22	40	9	6
M2000515	LT 740 M-W-D50/7	50	22	40	9	7
M2000516	LT 740 M-W-D63/8	63	22	40	9	8
M2000517	LT 740 M-W-D80/11	80	27	50	9	11

W = With coolant

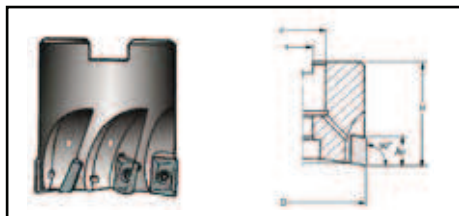
Screw set: VT 25 Key set: BT 08



Catalog Nr.	Description	D	d	L	H	Ap	z
* M2001584	LT 745 W-W-D10/1	10	16	80	24	9	1
* M2001596	LT 745 W-WL-D10	10	16	150	24	9	1
* M2001585	LT 745 W-W-D12/1	12	16	80	24	9	1
* M2001597	LT 745 W-WL-D12	12	16	150	24	9	1
* M2001586	LT 745 W-W-D14/1	14	16	80	24	9	1
* M2001587	LT 745 W-W-D16/2	16	16	85	25	9	2
* M2001598	LT 745 W-WL-D16	16	16	150	24	9	2
* M2001588	LT 745 W-W-D18/2	18	20	85	25	9	2
* M2001589	LT 745 W-W-D20	20	20	90	25	9	3
* M2001599	LT 745 W-WL-D20	20	20	150	25	9	3
* M2001590	LT 745 W-W-D22	22	25	95	25	9	3
* M2001591	LT 745 W-W-D25/3	25	25	95	25	9	3
* M2001592	LT 745 W-W-D25	25	25	95	25	9	4
* M2001600	LT 745 W-WL-D25	25	20	150	25	9	4
* M2001593	LT 745 W-W-D28	28	25	95	25	9	4
* M2001594	LT 745 W-W-D30	30	25	95	25	9	4
* M2001595	LT 745 W-W-D32	32	25	95	26	9	5
* M2001601	LT 745 W-WL-D32	32	25	150	26	9	5



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Catalog Nr.	Description	D	d	H	Ap	z
* M2001580	LT 745 M-W-D40/6	40	22	40	9	6
* M2001581	LT 745 M-W-D50/7	50	22	40	9	7
* M2001582	LT 745 M-W-D63/8	63	22	40	9	8
* M2001583	LT 745 M-W-D80/11	80	27	50	9	11

W = With coolant Screw set: VT 25 Key set: BT 08

* **Non stock item - On special request.**



Milling Machining conditions **APLX 1003 PDTR & APLX 100308 PDTR**

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	9.0	0.10	0.38	180	300
			180		9.0		0.25		260
			210		9.0		0.23		220
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	9.0	0.08	0.22	130	200
			230		9.0		0.22		180
			280	0.5	9.0	0.08	0.18	100	160
			320		9.0		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	9.0	0.10	0.22	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	9.0	0.10	0.20	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	9.0	0.08	0.18	70	120
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	9.0	0.08	0.20	150	230
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	9.0	0.08	0.20	130	210
			Treated	0.5	9.0	0.08	0.20	90	150
Grey Cast Iron	9	GG 20	140 to 230	0.5	9.0	0.10	0.25	150	240
		GG 25							220
		GG 30							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	0.5	3.0	0.10	0.14	30	60
		G-X260NiCr42	450						
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



APLX 100332 PDTR & APLX 100340 PDTR Machining conditions **Milling**

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	9.0	0.10	0.38	180	300
			180		9.0		0.25		260
			210		9.0		0.23		220
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	9.0	0.08	0.22	130	200
			230		9.0		0.22		180
			280	0.5	9.0	0.08	0.18	100	160
			320		9.0		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	9.0	0.10	0.22	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	9.0	0.10	0.20	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	9.0	0.08	0.18	70	120
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	9.0	0.08	0.20	150	230
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	9.0	0.08	0.20	130	210
			Treated	0.5	9.0	0.08	0.20	90	150
Grey Cast Iron	9	GG 20	140 to 230	0.5	9.0	0.10	0.25	150	240
		GG 25							220
		GG 30							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	0.5	3.0	0.10	0.14	30	130
		G-X260NiCr42	450						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

APLX