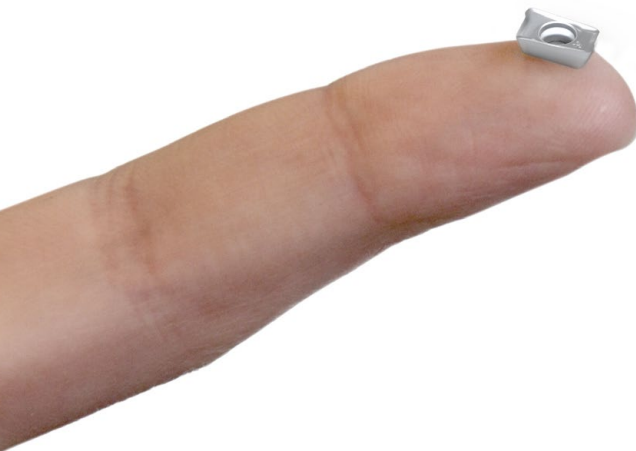


NEW PRODUCT RELEASE

Shoulder milling applications

APKT 060204 PDTR | LT3000

Introducing APKT 060204 available in our next generation premium Multi-Mat™ milling grade, Magia LT 3000.



Magia LT 3000 – Premium Grade

Higher performance, greater productivity, excellent thermal shock resistance & even longer tool life.

- Denser micro structured coating. High quality substrate composition.
- Progressive and predictable wear.
- More flexibility. Extended application range.

Insert Designation	l	s	r	Direction	Catalog Nr.
APKT 060204 PDTR LT 3000	6.00	2.16	0.40	Right	M0004026

Advantages of APKT 06

Compared with larger inserts:

Great Productivity

- Due to the small size of the inserts, it is possible to have more teeth than other indexable cutters of the same diameter, increasing the effective feed rate.

Soft and Stable Cut

- Although the effective feed rate can be higher, the feed per tooth is lower than the feed per tooth with bigger inserts, making the cut smoother with less cutting forces. Excellent advantage for machines with relatively low power.
- Good stability by having minimum of 2 teeth, even in the smallest cutter diameter (10mm).

Compared with solid end mills:

Increased Productivity

- Replaces HSS solid mills in roughing to semi-finishing with much higher metal removal rate.

Cost Savings, More Reliability

- Replaces carbide solid mills in roughing to semi-finishing operations, with substantial cost savings.
- No need to regrind when worn. Simply exchange the insert cutting edge.
- Less carbide is used per insert, which means more economy and less environmental impact.
- Cutter body made of steel improves resistance to shocks/instability while machining.

Pioneers of Multi-Mat™



NEW PRODUCT RELEASE

Shoulder milling applications

LT 751 End Mills for APKT 060204 PDTR



End Mills for APKT 060204 PDTR

Designation	D	d	L1	L	Ap	Z	α	Catalog Nr.
LT 751 C-W-D010/2	10	10	16	72	5.2	2	7.0	M2003066
LT 751 C-W-D012/3	12	12	26	80	5.2	3	5.0	M2003069
LT 751 CL-W-D016/3	16	16	50	120	5.2	3	2.4	M2003070
LT 751 C-W-D016/4	16	16	32	90	5.2	4	2.4	M2003071
LT 751 C-W-D020/5	20	20	40	100	5.2	5	1.6	M2003072
LT 751 C-W-D025/7*	25	20	40	120	5.2	7	1.2	M2003073
LT 751 C-W-D032/8*	32	25	40	130	5.2	8	0.8	M2003074
LT 751 C-W-D040/10*	40	32	40	140	5.2	10	0.6	M2003075

* Available on request

Replacement screw:

Replacement bit (Torx Plus 6IP):

M2001640

M2003064

We highly recommend using our preset torque screw driver (0.4Nm) at all times.

Our new range of LT 751 cutters for APKT 06
come with a free preset torque screw driver (0.4Nm).

Pioneers of Multi-Mat™

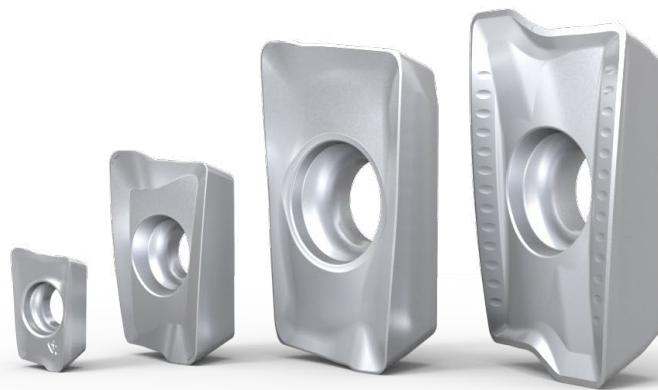


NEW PRODUCT RELEASE

Shoulder milling applications

Full Line of APKT Inserts and Cutters

Visit our website or contact us directly to learn more about our full line of APKT inserts and cutters.

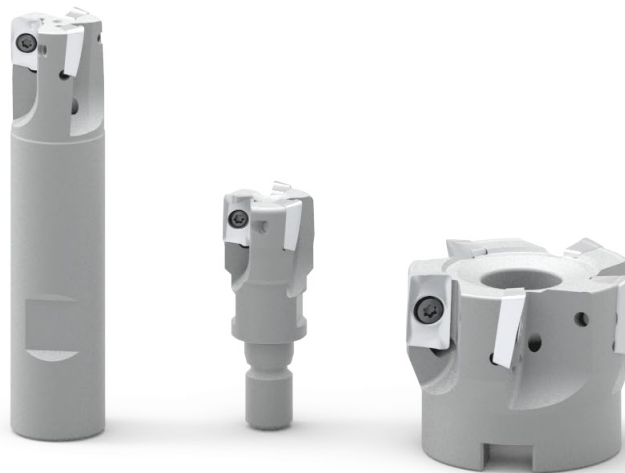


APKT 060204 PDTR

APKT 1003 PDTR

APKT 1604 PDTR

APKT 1705 PETR



END MILLS

SCREW COUPLINGS

SHELL MILLS

Pioneers of Multi-Mat™

NEW PRODUCT RELEASE

Shoulder milling applications

Cutting conditions

APKT 060204 PDTR – LT3000

Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V _c [m/min]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C	Feed	V _c
Steel	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.3	5.5	0.04	0.13	190	330	1.3	0.07	250
		2		190 HB	0.3	5.5	0.04	0.13	190	300	1.3	0.07	220
		3		250 HB	0.3	5.5	0.04	0.13	190	250	1.3	0.07	200
	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.3	5.5	0.03	0.10	150	240	1.3	0.06	200
		4,6		230 HB	0.3	5.5	0.03	0.10	150	210	1.3	0.06	180
		5,7		280 HB	0.3	5.5	0.03	0.09	130	190	1.3	0.05	150
		8		350 HB	0.3	5.5	0.03	0.09	130	170	1.3	0.05	140
	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	3.9	0.03	0.09	90	150	1.0	0.05	130
		10		280 HB	0.3	3.9	0.03	0.09	90	130	1.0	0.05	120
		11		320 HB	0.3	3.9	0.03	0.07	60	110	1.0	0.05	100
		11		350 HB	0.3	3.9	0.03	0.07	60	90	1.0	0.05	80
	Stainless Steel	4	14	304, 316, X5CrNi18-9	180 HB	0.3	5.5	0.03	0.10	190	250	1.3	0.06
14			240 HB		0.3	5.5	0.03	0.09	160	210	1.3	0.06	190
5		14	X2CrNiN23-4, S31500	290 HB	0.3	3.9	0.03	0.07	70	130	1.0	0.05	100
		14		310 HB	0.3	3.9	0.03	0.07	70	120	1.0	0.05	90
6		12	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	5.5	0.03	0.10	150	210	1.3	0.06	190
		13		42 HRc	0.3	3.9	0.03	0.08	90	150	1.0	0.05	130
Cast Iron	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	5.5	0.04	0.13	150	240	1.3	0.07	200
		15		200 HB	0.3	5.5	0.04	0.13	150	220	1.3	0.07	180
		16		250 HB	0.3	5.5	0.04	0.13	150	190	1.3	0.07	160
	8	17,19	GGG40, GGG70, 50005	150 HB	0.3	5.5	0.03	0.11	100	200	1.3	0.06	180
		17,19		200 HB	0.3	5.5	0.03	0.11	100	180	1.3	0.06	150
		18,20		250 HB	0.3	5.5	0.03	0.11	100	150	1.3	0.06	130
High Temp. Alloys	9	31,32	Incoloy 800	240 HB	0.3	3.9	0.03	0.07	25	45	1.0	0.05	32
		33	Inconel 700	250 HB	0.3	3.9	0.03	0.07	25	45	1.0	0.05	30
		34	Stellite 21	350 HB	0.3	3.9	0.03	0.07	25	45	1.0	0.05	30
	10	36	TiAl6V4	-	0.3	3.9	0.03	0.08	40	65	1.0	0.05	55
		37	T40	-	0.3	3.9	0.03	0.07	30	55	1.0	0.05	40
	Hardened Mat.	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	2.0	0.02	0.07	40	80	0.7	0.04
38			50 HRc		0.3	1.2	0.02	0.06	40	70	0.5	0.04	55
38			55 HRc		0.3	0.6	0.02	0.06	40	60	0.3	0.04	50
40			Ni-Hard 2	400 HB	0.3	1.6	0.02	0.07	40	80	0.5	0.04	50
41		G-X300CrMo15	55 HRc	0.3	0.6	0.02	0.06	30	60	0.3	0.04	40	
NF		12	25	AlSi12	130 HB	0.3	5.5	0.04	0.13	200	400	1.3	0.08

Pioneers of Multi-Mat™