MILLING

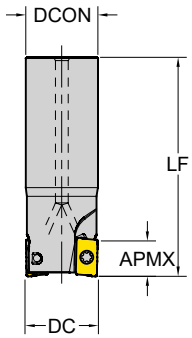
Product Overview

Application Guide

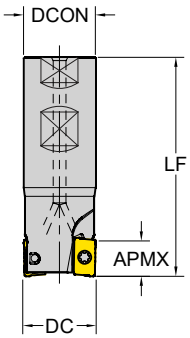
Milling Inserts & Cutter Overview

Milling Inserts & Cutter

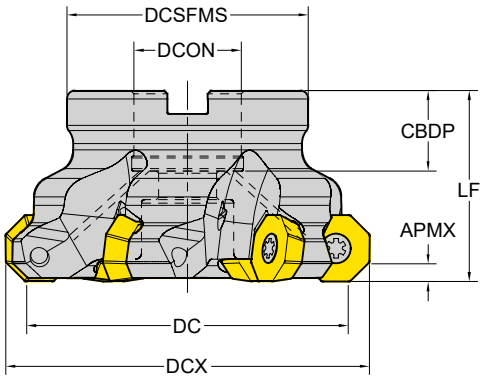
Code Keys - Milling Cutters



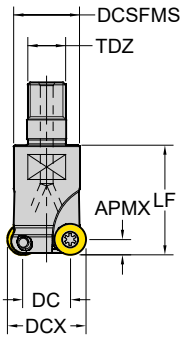
<C> Cylindrical



<W> Weldon



<S> Shell Mill



<M> Modular

Cutting Angle (90°)		Cutter Diameter (Ø1.00")	Connection Type and Size		Inch
			C - Cylindrical S - Shell Mill (Cylindrical Ø1.00")	W - Weldon M - Modular	

E	90	-	APKT10	-	D100	Z2	C100	-	L480	i
	KAPR				DC or DCX*	ZEFP	DCON or TDZ		LF*	

* Shank Type Only

* DCX for Round insert

Cutter Type	Insert Series	Number of Teeth	Functional Length
E - Endmill Type F - Facemill Type M - Modular Type	(APKT 10)	(Z=2)	(4.80 inch)

Insert ISO Code System

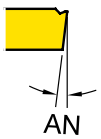
1	2	3	4	5	6	7
A	**P**	**K**	**T**	**16**	**04**	**08**
Shape	Relief Angle (AN)	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness (S)	CornerRadius

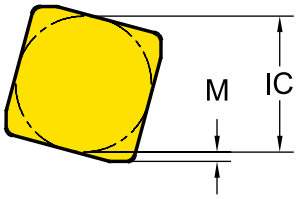
1 - Shape

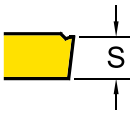
Symbol	Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
A	Parallelogram 80°	
R	Round	

2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
N	No Relief Angle	
B	Relief 5°	
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	







3 - Tolerance Class

Symbol	Inner Circle IC (in)	Nose Height M (in)	Thickness S (in)
C	±.0010	±.0005	±.0010
E	±.001	±.0010	±.001
G	±.001	±.0010	±.005
H	±.0005	± .0005	±.0010
K*	±.002~.006*	±.0005	±.005
M*	±.002~.006*	±.003~.010*	±.005
U*	±.003~.010*	±.005~.015*	±.005

* Tolerance is different by insert IC size. Please see ISO 1832

4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
N	No clamping hole	X	
R		One Face	
W	Screw Hole	X	
T		One Face	
U		Both Faces	
X	Special		

5 - Insert Size

* No Standard for milling insert size

6 - Insert Thickness

* No Standard for milling insert thickness

Milling - Code System

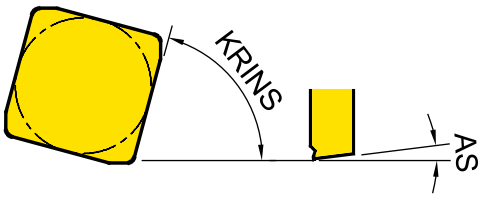
Insert ISO Code System

	page 75		page 74	
(	8	9	10	)
	PDTR	-TR	YG602	
	Corner Geometry	Chipbreaker	Grade	

7 - Corner Radius (RE)

Symbol	Thickness - S (in)	Symbol	Thickness - S (in)
04	.016	16	.063
08	.031	20	.079
12	.047	24	.094

8 - Corner Geometry



8-1	8-2	8-3	8-4
P	D	T	R
Cutting Edge Angle (KRINS)	Wiper Edge Clearance (AS)	Edge Condition	Feed Direction

*Refer to page. 75 for -AL, -ST, -TR… types

8-1 - Cutting Edge Angle (KRINS)

Symbol	Cutting Edge Angle (KRINS)
P	90°
A	45°
D	60°
E	75°
F	85°
Z	Special

8-2 - Wiper Edge Clearance (AS)

Symbol	Wiper Edge Clearance (AS)
N	0°
P	11°
D	15°
E	20°
F	25°
Z	Special

8-3 - Edge Condition

Symbol	Edge Condition
F	Sharp
E	Rounded
T	Chamfered
S	Chamfered and Rounded

8-4 - Feed Direction

Symbol	Feed Direction
R	Right-hand Insert
N	Neutral Insert
L	Left-hand Insert

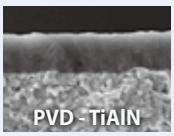
Milling Grades and Chip breakers

Milling Grades

Milling Grades		P Steel					M Stainless steel				K Cast iron				N Non-ferrous				S Superalloys				H Hardened steel			
		P05	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35	H15	H25	H35	
PVD	YG602			602					602				602								602						
	YG622			622									622										622			
	YG712		712																							
	YG713		713																							
	YG613				613				613												613					
	YG501											501														
CVD	YG5020										5020															
Uncoated	YG50														50											

YG602

P20 - P35 | M20 - M40 | K20 - K40 | S15 - S25

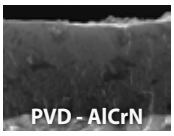


Universal grade for General Milling Application

- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application

YG622

P20 - P40 | K20 - K40 | H10 - H20

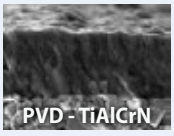


Optimized Grade for High Alloyed or Prehardened Steel

- Excellent hot hardness and oxidation resistance at high speed
- Smooth surface treatment technology provide to prevent thermal shock and chipping resistance

YG712

P10 - P30

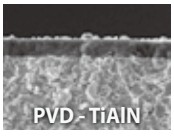


Milling Grade for Medium of Steel Application

- Superior wear resistance and excellent toughness in high speed machining
- Coating layer with high hardness and oxidation resistance

YG713

P15 - P25

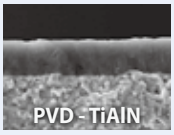


Milling Grade for General Steel Application

- Multi-layer TiAlN structure realizes stronger crater and flank wear resistance
- Fine-grained carbide and balanced substrate

YG613

P30 - P50 | M30 - M40 | S25 - S35

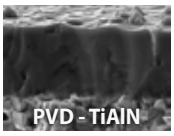
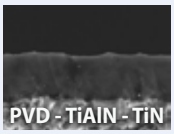
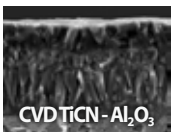
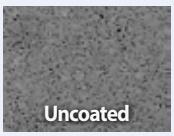


Milling Grade for Stainless Steel Application

- New coating layer with high toughness and lubrication on ultra fine grain substrate with high toughness.
- The toughest substrates provides excellent cutting performance in stainless steel
- Prevents welding and chipping of heat-resistant alloy workpieces through a special coating layer

Milling Grades and Chip breakers

Milling Grades

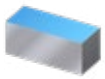
YG501 K05- K25		**Hard Milling grade for Cast Iron** • High wear resistance substrate based on TiAlN PVD Coating • Very good for cast Iron
YG501G K05- K25		**Hard Milling grade for Cast Iron** • High wear resistance sbustrate based on TiAlN / TiN PVD Coating • Excellent performance for cast Iron at high cutting speed
YG5020 K01-K30		**CVD Milling grade for Cast Iron** • CVD coating for Excellent wear resistance • Improved Toughness for chipping resistance
YG50 N05 – N20		**Uncoated Milling Grade for Aluminium** • Submicron carbide substrate for high wear resistance • Preventing built up edge with shining surface

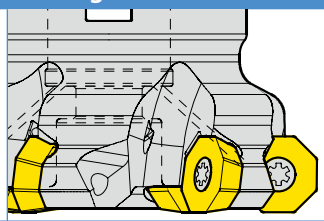
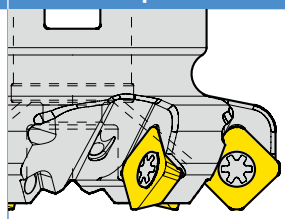
Milling Chip breakers

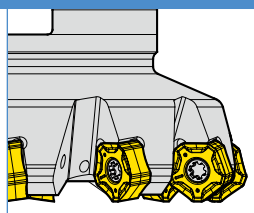
–AL		• For Aluminum • Very Sharp Geometry
–ST		• For Stainless Steel, Super Alloy • Sharp Geometry
General Inserts (No Description)		• First Choice for General Application
–TR		• For Hardened Steels • Reinforced Geometry
...W / ...N		• For Hardened Material and Cast Irons

Milling Cutter Overview

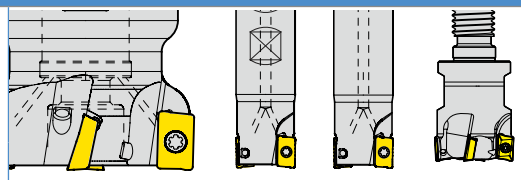
Face Milling



Positive Octagonal			Positive Square		
Cutter		ODMT/ODMW 0605		SEKT 1204	SEGT 1204
APMX	.138			.236	.236
DC	Ø2.5~5.0			Ø1.5~6.0	Ø1.5~6.0
page	p. 79			p. 81	

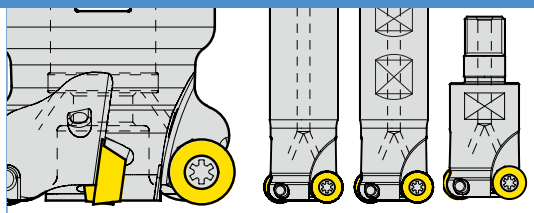
Negative 10 Corner		
Cutter		PNMU 1206
APMX	4	
DC	Ø50~125	
page	p. 80	

Shoulder Milling

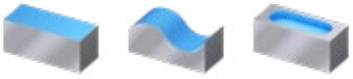
2 Corner Positive						
Cutter		APKT 1003	APKT 1604	APMT 1135	APMT 1604	APGT 1604
APMX		.394	.630	.390	.630	.630
DC		Ø.625~2.0	Ø1.0~4.0	Ø.625~1.25	Ø1.25	Ø1.25
page		p. 95 - 96				

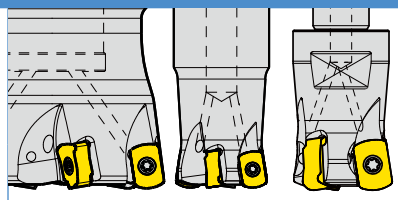
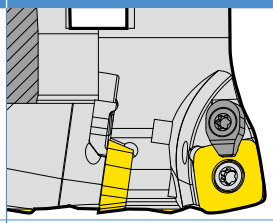
Milling Overview

Profiling

Round Positive				
Cutter			 RDKT / RDKW	
		0802	10T3	1204
APMX		.157	.196	.236
DCX		Ø.75~1.0	Ø1.0~2.0	Ø1.0~2.5
page		p. 103		

High Feed Milling



Negative 4 Corner				Positive 4 Corner	
Cutter		 ENMX 0604	ENMX 0905		 SDMT/SDMW 1204
APMX		0.9	1 / 1.5		1.8
DCX		Ø16~18	Ø20~50 / Ø25~125		Ø32~100
page		p. 107 - 108			p. 109

Milling Inserts Overview

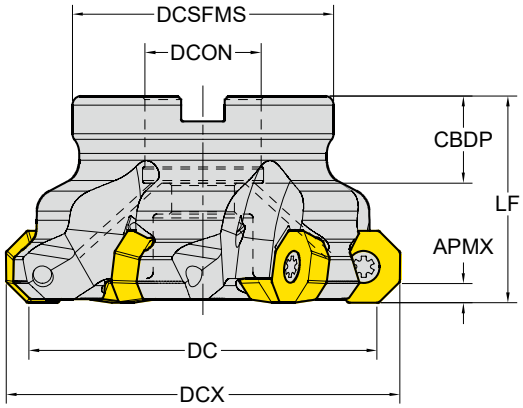
A 2 Corner	 Positive	**ADKT**	ADKT 1505	**p. 97**
		AOMT	AOMT 1236	**p. 97**
		APKT	APKT 1003, 1604	**p. 98**
		APMT	APMT 1135, 1504, 1604	**p. 99**
		APGT	APGT 1003, 1604	**p. 100**
E 4 Corner	 Negative	**ENMX**	ENMX 0604 ENMX 0905	**p. 110**
O Octagon	 Positive	**ODMT / ODMW**	ODMT / ODMW 0605	**p. 82**
		OFER	OFER 0704	**p. 83**
		OFMT	OFMT 05T3	
	 Negative	**ONMU / ONHU**	ONMU / ONHU 0806	**p. 84**
P 10 Corner	 Negative	**PNMU**	PNMU1206	**p. 85**
R Round	 Positive Round	**RDKT / RDKW**	RDKT 0802, 10T3, 1204, 1604 RDKW 0501, 0702, 0802, 10T3, 1204	**p. 104**
		RDMT / RDMW	RDMT 0802, 0803, 10T3, 1204 RDMW 0802, 10T3, 1204	**p. 105**
		RPMT / RPMW	RPMT 08T2, 10T3, 1204 RPMW 1003, 1204	**p. 106**
S Square	 High Feed	**SDMT / SDMW**	SDMT 1204, SDMW 1204	**p. 112**
	 Positive	**SEKT**	SEKT 12T3, 1204	**p. 88**
		SEGT	SEGT12T3, 1204	**p. 89**
		SEMT	SEMT1204, 13T3	**p. 90**
		SPMT	SPMT 1204	**p. 93**
		SDKN, SDCN (45°)	SDKN, SDCN 1203, 1504	**p. 86**
		SEKN / SEKR (45°)	SEKR, SEKN 1203	**p. 87**
	 ISO	**SPKN / SPKR / SPCN(75°)**	SPKN 1203, 1504 SPKR 1203 SPCN 1203, 1504	**p. 92**
		SPUN	SPUN 1203	**p. 94**
	 Negative	**SNMX**	SNMX1206	**p. 91**
T Triangle	 ISO	**TPKN / TPKR / TPCN(90°)**	TPKN 1603, 2204 TPKR 1603, 2204 TPCN 2204	**p. 101**
		TPUN	TPUN 1603	**p. 102**

Milling - Face Milling - Cutter

Cutters for ODMT, ODMW

Entry Angle : 43˚
8 Corner Positive

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

: p. 82

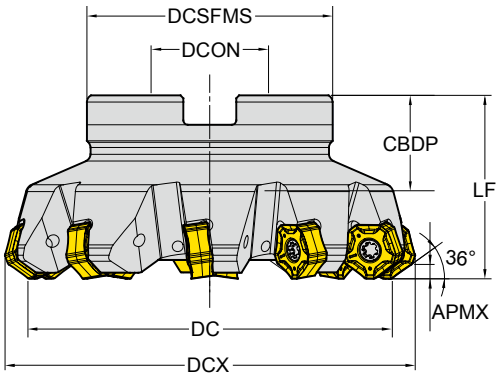
Unit : inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
ODMT ODMW 0605	.138	F43-ODMT06-D250Z5S075i	0040	2.50	2.88	5	1.575	Shellmill	.75	.79	2.00	-	-	●
		F43-ODMT06-D300Z6S100i	0041	3.00	3.55	6	1.750		1.00	.87	2.50	-	-	●
		F43-ODMT06-D400Z7S125i	0042	4.00	4.34	7	2.000		1.25	.98	3.00	-	-	●
		F43-ODMT06-D500Z8S150i	0043	5.00	5.32	8	2.380		1.50	1.14	3.65	-	-	●

Cutters for PNMU

Entry Angle: 36°
10 Corner Negative

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

: p. 85

Unit: inch

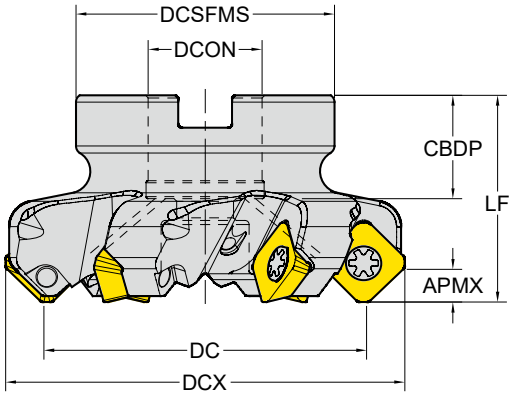
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
PNMU 1206	.157	F36-PNMU12-D200Z4S075I	0468	2	2.50	4	1.575	Shell Mill	0.75	0.75	1.75	-	-	●
		F36-PNMU12-D250Z5S075I	0788	2.5	3.01	5	1.575		0.75	0.75	2	-	-	●
		F36-PNMU12-D300Z8S100I	0469	3	3.68	8	2		1	1.049	2.5	-	-	●
		F36-PNMU12-D400Z10S125I	0470	4	4.46	10	2		1.25	1.269	3	-	-	●
		F36-PNMU12-D600Z14S200I	0863	6	5.45	14	2.48		2.00	1.5	4.7	-	-	●

Milling - Face Milling - Cutter

Cutters for SEKT, SEGT

Entry Angle : 45°
4 Corner Positive

<S> Shell Mill



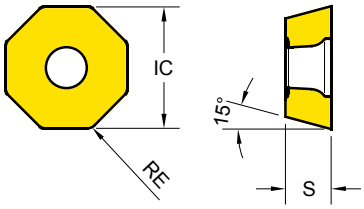
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

: p. 88

Unit:inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SEKT SEGT 1204	.236	F45-SEKT12-D150Z4S050i	0060	1.50	2.06	4	1.575	Shellmill	.50	.71	1.25	-	-	●
		F45-SEKT12-D200Z5S075i	0061	2.00	2.57	5	1.575		.75	.74	1.75	-	-	●
		F45-SEKT12-D250Z4S075i	0062	2.50	3.06	4	1.575		.75	.75	2.19	-	-	●
		F45-SEKT12-D250Z6S075i	0063	2.50	3.06	6	1.575		.75	.75	2.19	-	-	●
		F45-SEKT12-D300Z4S100i	0064	3.00	3.56	4	1.75		1.00	.94	2.25	-	-	●
		F45-SEKT12-D300Z7S100i	0065	3.00	3.56	7	1.75		1.00	.94	2.25	-	-	●
		F45-SEKT12-D400Z8S125i	0066	4.00	4.56	8	2.00		1.25	1.22	3.00	-	-	●
		F45-SEKT12-D500Z10S150i	0067	5.00	5.56	10	2.38		1.50	1.38	3.65	-	-	●
		F45-SEKT12-D600Z12S200i	0068	6.00	6.56	12	2.50		2.00	1.50	3.94	-	-	X

ODMT / ODMW - Face Milling Positive (8 Corners)



Series	IC	S
ODM* 0605	.626	.220

EDP 1200..

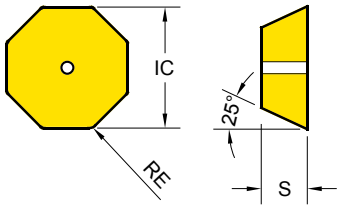
●: Stock item ○: Order made item

ODMT ODMW	Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
ODMT General 	ODMT 060508	.031	.008~.014	-	● 0030	○ 0438		○ 0659	● 0675		
ODMW Hard Materials 	ODMW 060508	.031	.010~.016	-	● 0031						

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

OFER / OFMT - Face Milling Positive (8 Corners)



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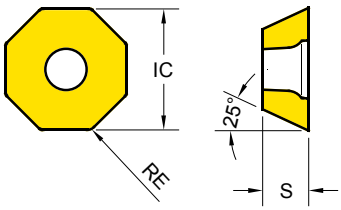


<OFMT>

Series	IC	S
OFER 0704	.711	.188
OFMT 05T3	.501	.160

EDP 1200..

●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20

OFER

Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
OFER 070405	.020	.009~.020	-	● 0209						

OFER
General

OFMT

Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
OFMT 05T308	.031	.006~.010	-	● 0032						

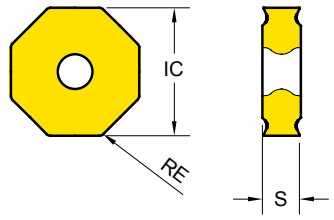
OFMT
General

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

ONMU / ONHU - Face Milling Negative (16 Corners)



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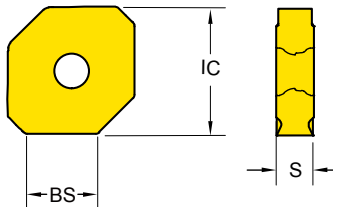

<ONHU>

Series	IC	S
ON*U 0806	.795	.228

EDP 1200..

●: Stock item ○: Order made item

ONMU ONHU	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602 P25 M30 K30 S20	YG622 P30 K30 H15	YG712 P20	YG713 P30	YG613 P40 M35 S30	YG501 K15	YG5020 K20
ONMU General	**ONMU 080608**	.031	.009~.020	-	● 0233	○ 0608		○ 0657	● 0670		● 0414
	ONMU 080612	.031	.009~.020	-					● 0615		● 0542
	ONMU 080620	.031	.009~.020	-							● 0707
ONHU Wiper Insert	**ONHU 080612**	.047	.003~.010	.417						● 0496	● 0482

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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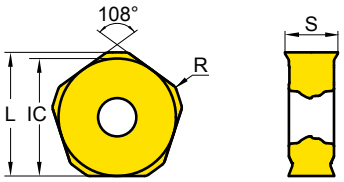
Milling - Face Milling - Inserts

PNMU - Face Milling Negative (10 Corners)



Series	KRINS	IC	S
PNMU 1206	36°	.551	.230

EDP 1200..

●: Stock item ○: Order made item

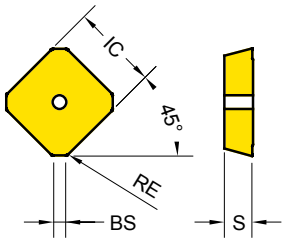
PNMU	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501G	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
PNMU General 	PNMU 1206ZNN	.031	.002~.012	0.08	● 0535		● 0596	○ 0645	● 0671	● 0538	● 0534

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

SDKN / SDCN - Face Milling Positive (4 Corners ISO)



Series	AS	IC	S
SD** 42	15°	.500	.125
SD** 53	15°	.625	.187

EDP 1200..

●: Stock item ○: Order made item

SDKN SDCN		Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
SDKN Hard Materials		SDKN 42 AETN	.020	.009~.014	.073	● 0058						
		SDKN 42 AETN -GW	.051	.009~.014	.073	● 0251						
		SDKN 42 AETN -PW	.016	.009~.014	.078	● 0253						
		SDKN 53 AETN	.018	.009~.014	.079	● 0059						
		SDKN 53 AETN -GW	.051	.009~.016	.081	● 0286						
		SDKN 53 AETN -PW	.016	.009~.016	.077	● 0288						
SDCN Ground insert		SDCN 42 AESN -M	-	.002~.008	.080			● 0135				
		SDCN 53 AESN -M	-	.002~.008	.086			● 0150				
		SDCN 53 AESN -MR	.039	.002~.008	.086			● 0201				

- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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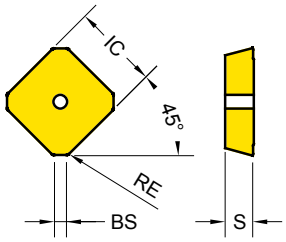
Milling - Face Milling - Inserts

SEKR / SEKN - Face Milling Positive (4 Corners ISO)



Series	AS	IC	S
SEK* 42	20°	.500	.126

EDP 1200..

●: Stock item ○: Order made item

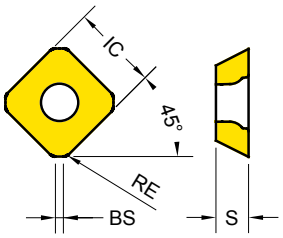
P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
YG602	YG622	YG712	YG713	YG613	YG501	YG5020

SEKR SEKN		Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKR General		SEKR 42 AFTN	.016	.006~.012	.055	● 0051						
		SEKR 42 AFTN -PW	.016	.006~.012	.079	● 0296						
SEKN Hard Materials		SEKN 42 AFTN	.016	.009~.014	.055	● 0054						
		SEKN 42 AFTN -GW	.016	.009~.014	.079	● 0304						
		SEKN 42 AFTN -PW	.016	.009~.014	.079	● 0297						

- PW : for Improved Surface Roughness
- GW : Ground Wiper

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

SEKT - Face Milling Positive (4 Corners)



Series	IC	S
SEKT 1204	.500	.193
SEKT 12T3	.528	.157

EDP 1200..

●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20

SEKT 1204

		Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKT 1204 General		SEKT 1204 AFTN	.043	.008~.014	.046	● 0055	○ 0416					
-ST Stainless Steel Super Alloy		SEKT 1204 -ST	.043	.003~.012	.079	● 0257	○ 0417					

SEKT 12T3

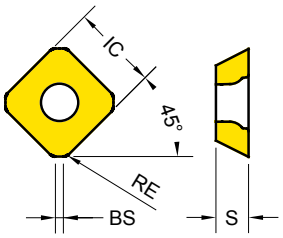
		Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKT 12T3 General		SEKT 12T3 AGTN	.059	.006~.012	.051	● 0056	○ 0688					
-ST Stainless Steel Super Alloy		SEKT 12T3 -ST	.059	.003~.012	.079	● 0271				● 0689		

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

SEGT - Face Milling Positive (4 Corners)



Series	IC	S
SEGT 1204	.500	.193
SEGT 12T3	.528	.159

EDP 1200..

●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K20	N15

SEGT 1204

Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG5020	YG50
SEGT 1204 -AL	.043	.004~.014	.079							● 0467

-AL
Aluminium

SEGT 12T3

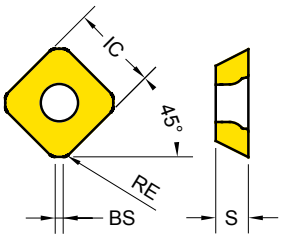
Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG5020	YG50
SEGT 12T3 -AL	.059	.004~.014	.076							● 0468

-AL
Aluminium

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG5020 Min	YG5020 Max	YG50 Min	YG50 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	660	1150	-	-
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	490	980	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	980	2620
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

SEMT - Face Milling Positive (4 Corners)



Series	IC	S
SEMT1204	.509	.201
SEMT13T3	.528	.157

EDP 1200..

●: Stock item ○: Order made item

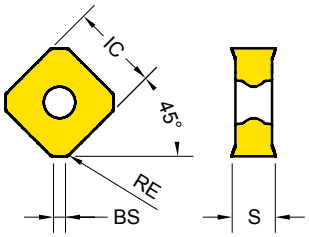
SEMT	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602 P25 M30 K30 S20	YG622 P30 K30 H15	YG712 P20	YG713 P30	YG613 P40 M35 S30	YG501 K15	YG5020 K20
SEMT 1204 General 	SEMT 1204 AFTN	.047	.010~.016	.049	● 0052						
SEMT 13T3 General 	SEMT 13T3 AGSN	.059	.006~.012	.052	● 0203						

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

SNMX - Face Milling Negative (8 Corners)



Series	IC	S
SNMX 1206	.500	.246

EDP 1200..

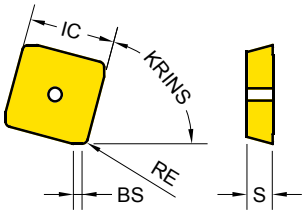
●: Stock item ○: Order made item

SNMX	Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K15	K20
					YG602	YG622	YG712	YG713	YG613	YG501	YG501G	YG5020
SNMX General 	SNMX 1206 ANN	.031	.006~.013	.067	● 0231	○ 0453		○ 0658	● 0674		● 0478	● 0460
	SNMX 1206QNN	0.031	.006~.013	0.08						● 0686		

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501(G)		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	760	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	690	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	330	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	130	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

SPKN / SPKR / SPCN - Face Milling Positive (4 Corners ISO)



Series	KRINS	AS	IC	S
SP** 42	75°	11°	.500	.126
SP** 53	75°	11°	.625	.189

EDP 1200..

●: Stock item ○: Order made item

SPKR SPKN SPCN		Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
SPKR General		SPKR 42 EDTR	.031	.006~.014	.055	● 0050						
		SPKR 42 EDTR -PW	.031	.006~.014	.061	● 0298						
SPKN Hard Materials		SPKN 42 EDTR	.031	.006~.013	.055	● 0048						
		SPKN 42 EDTR -GW	.024	.006~.011	.059	● 0280						
		SPKN 42 EDTR -PW	.031	.008~.014	.059	● 0279						
		SPKN 53 EDTR	.031	.006~.013	.051	● 0049						
		SPKN 53 EDTR -GW	.031	.010~.016	.087	● 0305						
		SPKN 53 EDTR -PW	.031	.010~.016	.084	● 0299						
SPCN Ground insert		SPCN 42 EDSR -M	.031	.004~.008	.072			● 0081				
		SPCN 42 EDSR -MR	.031	.004~.008	.070			● 0198				
		SPCN 53 EDSR -M	.031	.004~.008	.076			● 0098				
		SPCN 53 EDSR -MR	.031	.004~.008	.073			● 0199				

- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

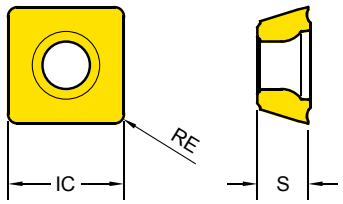
Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

YG-1 USA - 800-765-8665, yg1usa.com
YG-1 HEAD OFFICE - phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr
YG YG-1 CO., LTD.

Milling - Face Milling - Inserts

SPMT - Universal Positive (4 Corners)



Series	AS	IC	S
SPMT 1204	11°	.500	.189

EDP 1200..

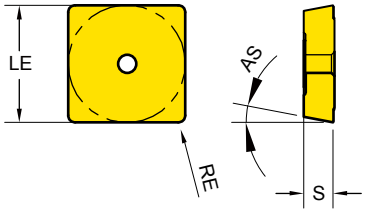
●: Stock item ○: Order made item

SPMT	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
SPMT General 	SPMT 120408	.031	.006~.012	-	● 0223						

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

SPUN - Universal Positive (4 Corners ISO)



Series	AS	IC	S
SPUN 42	11°	.500	.126

EDP 1200..

●: Stock item ○: Order made item

SPUN	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
SPUN General 	SPUN 422	.031	.006~.012	-	● 0224						

Cutting Speed — Vc (ft/min)

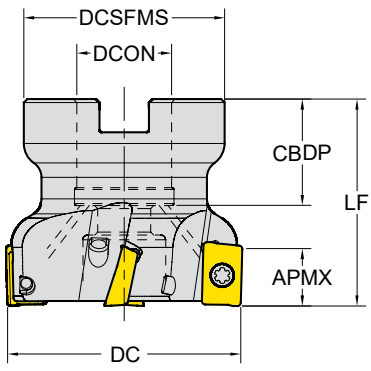
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Cutter

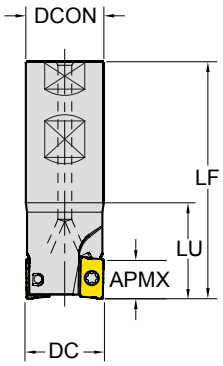
Cutters for APKT

Entry Angle : 90°
2 Corner Positive

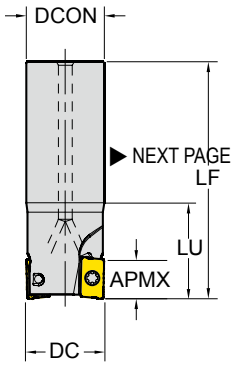
<S> Shell Mill



<W> Weldon



<C> Cyindrical



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

: p. 98

Unit:inch

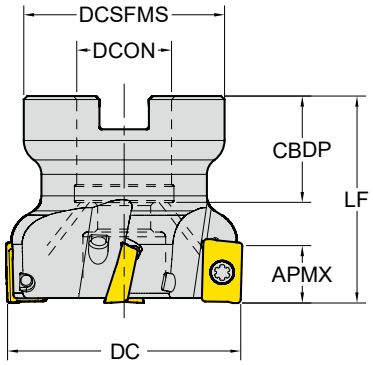
Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APKT 1003	.350	E90-APKT10-D100Z4C075-L350i	0149	1.00	4	-	3.50	Cyindrical	.750	-	-	-	-	●
		E90-APKT10-D0625Z2W0625-L325i	0144	.625	2	-	3.25	Weldon	.625	-	-	-	-	●
		E90-APKT10-D075Z3W075-L320i	0146	.750	3	1.17	3.20		.750	-	-	-	-	●
		E90-APKT10-D100Z4W100-L350i	0148	1.00	4	-	3.50		1.00	-	-	-	-	●
		F90-APKT10-D150Z4S075i	0150	1.50	4	-	1.575	Shell Mill	.750	.750	1.34	-	-	●
		F90-APKT10-D200Z7S075i	0151	2.00	7	-	1.75		.750	.750	1.75	-	-	●
APKT 1604	.630	E90-APKT16-D100Z2C0875-L378i	0089	1.00	2	1.50	3.78	Cyindrical	.875	-	-	-	-	●
		E90-APKT16-D125Z3C100-L428i	0090	1.25	3	-	4.28		1.00	-	-	-	-	●
		E90-APKT16-D100Z2W100-L400i	0158	1.00	2	1.72	4.00	Weldon	1	-	-	-	-	●
		E90-APKT16-D100Z2W100-L1000i	0208	1.00	2	1.50	1.00		1	-	-	-	-	●
		E90-APKT16-D125Z3W100-L400i	0159	1.25	3	1.72	4.00		1	-	-	-	-	●
		E90-APKT16-D125Z3W125-L1000i	0205	1.25	3	1.50	1.00		1.25	-	-	-	-	●
		E90-APKT16-D125Z4W125-L1000i	0206	1.25	4	1.50	1.00		1.25	-	-	-	-	●
		F90-APKT16-D200Z5S075i	0160	2.00	5	-	1.75	Shell Mill	.750	.750	1.75	-	-	●
		F90-APKT16-D250Z6S075i	0161	2.50	6	-	1.75		.750	.750	1.75	-	-	X
		F90-APKT16-D300Z7S100i	0162	3.00	7	-	2.00		1	.945	2.19	-	-	●
		F90-APKT16-D400Z8S150i	0207	4.00	8	-	2.50		1.50	1.57	3.50	-	-	●

▶ NEXT PAGE

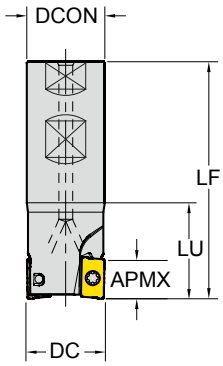
Cutters for APMT, APXT

Entry Angle : 90°
2 Corner Positive

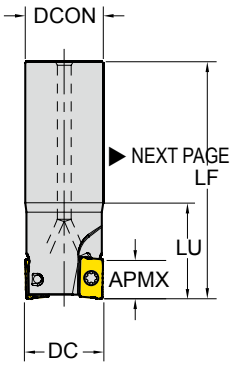
<S> Shell Mill



<W> Weldon



<C> Cyindrical



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

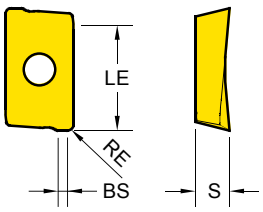
: p. 99 / 100

Unit: inch

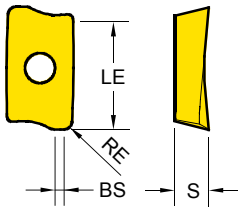
Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APMT 1135	.390	E90-APMT11-D0625Z2C0625-L400i	0098	.625	2	1.60	4.00	Cyindrical	.625	-	-	-	-	●
		E90-APMT11-D075Z2W075-L354i	0099	.750	2	1.17	3.54		.750	-	-	-	-	●
		E90-APMT11-D100Z4W100-L428i	0100	1.00	4	1.32	4.28	Weldon	1.00	-	-	-	-	●
		E90-APMT11-D125Z4W100-L428i	0101	1.25	4	1.32	4.28		1.00	-	-	-	-	●
APMT, APXT 1604	.630	E90-APMT16-D125Z3W125-L390i	0106	1.25	3	1.62	3.90	Weldon	1.25	-	-	-	-	●

Milling - Shoulder Milling - Inserts

ADKT / AOMT - Shoulder Milling Positive (2 Corner)



<ADKT>



<AOMT>

Series	LE	IC	S
ADKT 1505	.539	.382	.228
AOMT 1236	.413	.260	.142

EDP 1200..

●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20

ADKT

Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
ADKT 150508 PDTR	.031	.006~.012	.074	● 0220						

ADKT
General

AOMT

Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
AOMT 123604 PDTR	.016	.003~.009	.042	● 0217						
AOMT 123608 PDTR	.031	.003~.009	.036	● 0218	○ 0709		○ 0708	● 0613		

AOMT
General

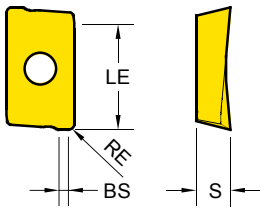
Cutting Speed

Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

APKT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APKT 1003	.390	.264	.142
APKT 1604	.598	.370	.209

EDP 1200..

●: Stock item ○: Order made item

APKT	Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
APKT General	APKT 100305 PDTR	.020	.006~.009	.034	● 0005	○ 0429		○ 0638	● 0672		
	APKT 100308 PDTR	.031	.006~.009	.035	● 0004	○ 0430		○ 0632	● 0610		
	APKT 100316 PDTR	.062	.006~.009	0.05	● 0713	○ 0712			● 0714		
	APKT 160404 PDTR	.016	.006~.010	.044	● 0003			○ 0656			
	APKT 160408 PDTR	.031	.006~.012	.052	● 0001			○ 0633	● 0607		
	APKT 160412 PDTR	.047	.006~.013	.044	● 0002			○ 0649			
	APKT 160416 PDTR	.063	.006~.013	.044	● 0006			○ 0661			
	APKT 160424 PDTR	.094	.006~.015	.059	● 0255			○ 0653			
-ST Stainless Steel Super Alloy	APKT 100305 -ST	.020	.003~.009	.034	● 0278				● 0618		
	APKT 100316 -ST	.062	.006~.009	0.05					● 0719		
	APKT 160408 -ST	.031	.003~.010	.052	● 0270				● 0617		
-TR Hardened Steel	APKT 160404 -TR	.016	.010~.016	.083	● 0492	○ 0505					
	APKT 160408 -TR	.031	.010~.016	.052	● 0256	○ 0337		○ 0637			
	APKT 160412 -TR	.047	.010~.016	.094	● 0493	○ 0523					
	APKT 160416 -TR	.063	.010~.016	.094	● 0472	○ 0524					
	APKT 160424 -TR	.094	.010~.016	.059	● 0494	○ 0520					

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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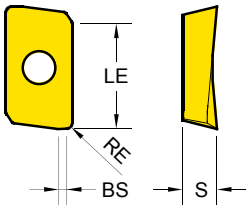
Milling - Shoulder Milling - Inserts

APMT - Shoulder Milling Positive (2 Corner)



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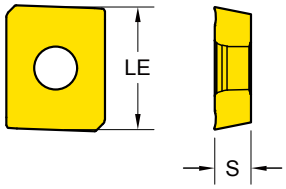


<APMT 1504>

Series	LE	IC	S
APMT 1135	.374	.244	.138
APMT 1604	.575	.362	.187
APMT 1504	.551	.500	.187

EDP 1200..

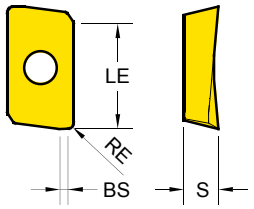
●: Stock item ○: Order made item

APMT	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
APMT General 	APMT 113504 PDTR	.016	.006~.009	.050	● 0009	○ 0400		○ 0655			
	APMT 113508 PDTR	.031	.006~.010	.042	● 0010	○ 0641		○ 0654	● 0668		
	APMT 160408 PDTR	.031	.006~.012	.044	● 0008	○ 0399	● 0423	○ 0642	● 0663	● 0464	
APMT 1504 General 	APMT 1504	.031	.006~.011	-	● 0276	○ 0445					

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

APGT Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
AP*T 1135	.374	.244	.141
AP*T 1604	.575	.362	.189

EDP 1200..

●: Stock item ○: Order made item

APGT	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG5020	YG50
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K20	N15
-AL Aluminium 	APGT100305-AL	.019	.002~.012	.056							● 0730
	APGT 160408 -AL	.031	.004~.051	.070							● 0428

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	660	1150	-	-
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	490	980	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	980	2620
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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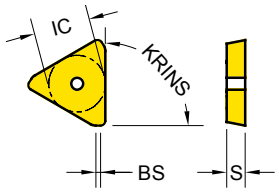
Milling - Shoulder Milling - Inserts

TPKN / TPKR / TPCN - Shoulder Milling Positive (3 Corner ISO)



Series	KRINS	IC	S
TP** 32	90°	.375	.125
TP** 43	90°	.500	.187

EDP 1200..

●: Stock item ○: Order made item

TPKR TPKN TPCN		Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
TPKR General		TPKR 32 PDTR	.047	.006~.011	.047	● 0060				● 0690		
		TPKR 32 PDTR -PW	.024	.004~.008	.047	● 0300						
		TPKR 43 PDTR	.012	.007~.014	.067	● 0061				● 0715		
		TPKR 43 PDTR -PW	.024	.007~.014	.067	● 0301						
TPKN Hard Materials		TPKN 32 PDTR	-	.006~.012	.047	● 0062						
		TPKN 32 PDTR -GW	-	.006~.012	.064	● 0306						
		TPKN 32 PDTR -PW	-	.006~.011	.047	● 0302						
		TPKN 43 PDTR	-	.007~.012	.067	● 0063						
		TPKN 43 PDTR -GW	-	.009~.016	.098	● 0307						
		TPKN 43 PDTR -PW	-	.009~.016	.067	● 0303						
TPCN Ground insert		TPCN 43 PDSR -M	-	.002~.008	.069			● 0180				
		TPCN 43 PDSR -MR	-	.002~.008	.069			● 0202				

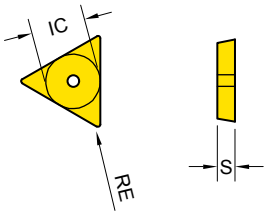
- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

TPUN - Universal Positive (3 Corners ISO)



Series	IC	S
TPUN 32	.375	.125

EDP 1200..

●: Stock item ○: Order made item

TPUN	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
TPUN 	TPUN 322	.031	.003~.006	-	● 0064						

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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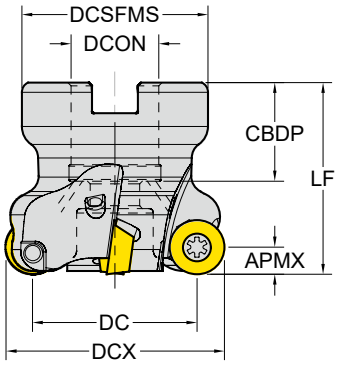
Milling - Profiling - Cutter

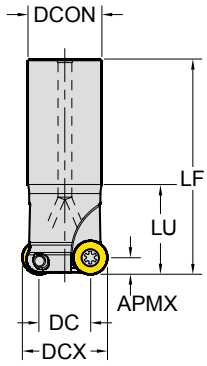
Cutters for RDKT, RDKW

Round Positive

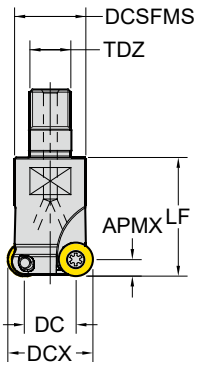
<S> Shell Mill



<C> Cyindrical



<M> Modular

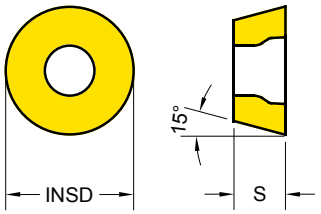


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

: p. 104 Unit : inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
RDKT, RDKW 0802	.157	E-RDKT08-D075Z2C075-L700i	0044	.435	.75	2	1.5	7.00	Cyindrical	.75	-	-	●
		E-RDKT08-D100Z3C075-L700i	0045	.685	1.00	3	1.5	7.00		.75	-	-	●
		M-RDKT08-D075Z2M10i	0046	.435	.75	2	-	1.25	Modular	M10	-	-	●
		M-RDKT08-D100Z3M12i	0047	.685	1.00	3	-	1.50		M12	-	-	●
RDKT, RDKW 10T3	.196	E-RDKT10-D100Z2C100-L700i	0048	.606	1.00	2	1.5	7.00	Cyindrical	1	-	-	●
		M-RDKT10-D100Z3M12i	0049	.606	1.00	3	-	1.50	Modular	M12	-	0.827	●
		F-RDKT10-D150Z5S050i	0050	1.106	1.50	5	-	1.575	Shell Mill	.50	.63	1.25	●
		F-RDKT10-D200Z6S075i	0051	1.606	2.00	6	-	1.75		.75	.75	1.75	●
RDKT, RDKW 1204	.236	E-RDKT12-D100Z2C100-L700i	0052	.527	1.00	2	-	7.00	Cyindrical	1	-	-	●
		E-RDKT12-D125Z2C125-L800i	0053	.777	1.25	2	-	8.00		1.25	-	-	●
		E-RDKT12-D125Z3C125-L600i	0054	.777	1.25	3	-	6.00		1.25	-	-	●
		M-RDKT12-D100Z2M12i	0055	.527	1.00	2	-	1.50	Modular	M12	-	.827	●
		M-RDKT12-D125Z3M16i	0056	.777	1.25	3	-	1.75		M16	-	1.142	●
		F-RDKT12-D150Z4S050i	0057	1.027	1.50	4	-	1.575	Shell Mill	.50	.63	1.25	●
		F-RDKT12-D200Z5S075i	0058	1.527	2.00	5	-	1.75		.75	.75	1.75	
		F-RDKT12-D250Z6S075i	0059	2.027	2.50	6	-	1.75		.75	.75	1.75	

RDKT / RDKW - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDK* 0501	.197	.055	RDK* 10T3	.394	.157
RDK* 0702	.276	.094	RDK* 1204	.472	.189
RDK* 0802	.315	.094			

EDP 1200..

●: Stock item ○: Order made item

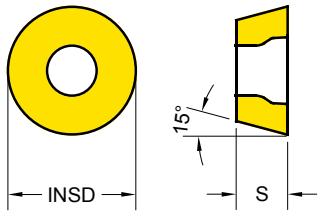
RDKT RDKW		Designation		Fz (in/tooth)		YG602	YG622	YG712	YG713	YG613	YG501	YG5020
						P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
RDKT General		RDKT 0802M0	-	.006~.010	-	● 0035						
		RDKT 10T3M0	-	.006~.011	-	● 0041			○ 0651			
		RDKT 1204M0	-	.008~.012	-	● 0034			○ 0635	● 0678		
		RDKT 1604M0	-	.012~.024	-	● 0539						
-ST Stainless Steel Super Alloy		RDKT 0802M0 -ST	-	.003~.010	-	● 0292						
		RDKT 10T3M0 -ST	-	.003~.011	-	● 0293				● 0620		
		RDKT 1204M0 -ST	-	.004~.012	-	● 0294				● 0621		
-TR Hardened Steel		RDKT 0802M0 -TR	-	.007~.014	-	● 0284	○ 0339					
		RDKT 10T3M0 -TR	-	.009~.016	-	● 0285	○ 0338					
		RDKT 1204M0 -TR	-	.009~.016	-	● 0272	○ 0340		○ 0650			
RDKW Hard Materials		RDKW 0501M0	-	.004~.008	-	● 0207	○ 0412					
		RDKW 0702M0	-	.005~.010	-	● 0208	○ 0439		○ 0652			
		RDKW 0802M0	-	.005~.010	-	● 0043	○ 0440					
		RDKW 10T3M0	-	.006~.012	-	● 0040	○ 0441					
		RDKW 1204M0	-	.006~.014	-	● 0042	○ 0442		○ 0647			

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Profiling - Inserts

RDMT / RDMW - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDM* 0802	.315	.094	RDM* 10T3	.394	.156
RDM* 0803	.315	.125	RDM* 1204	.472	.187

EDP 1200..

●: Stock item ○: Order made item

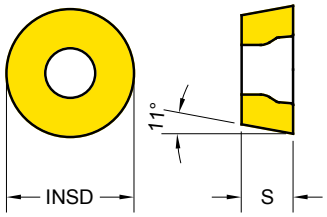
RDMT RDMW		Designation		Fz (in/tooth)		YG602	YG622	YG712	YG713	YG613	YG501	YG5020
						P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
RDMT General		RDMT 0802M0	-	.006~.010	-	● 0245						
		RDMT 0803M0	-	.006~.010	-	● 0225						
		RDMT 10T3M0	-	.007~.011	-	● 0246						
		RDMT 1204M0	-	.008~.012	-	● 0226						
RDMW Hard Materials		RDMW 0802M0	-	.002~.006	-	● 0227						
		RDMW 10T3M0	-	.004~.010	-	● 0228						
		RDMW 1204M0	-	.006~.012	-	● 0229						

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

Milling - Profiling - Inserts

RPMT / RPMW - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RPM* 08T2	.315	.109	RPM* 1003	.394	.125
RPM* 10T3	.394	.156	RPM* 1204	.472	.187

EDP 1200..

●: Stock item ○: Order made item

RPMT RPMW		Designation		Fz (in/tooth)		P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
RPMT General		RPMT 08T2M0	-	.004~.009	-	● 0038			○ 0660	● 0676		
		RPMT 10T3M0	-	.006~.012	-	● 0036			○ 0644	● 0665		
		RPMT 1204M0	-	.008~.014	-	● 0037	○ 0401	● 0415	○ 0643	● 0664	● 0462	
-ST Stainless Steel Super Alloy		RPMT 1204M0 -ST	-	.004~.012	-	● 0230				● 0667		
-TR Hardened Steel		RPMT 1204M0 -TR	-		-				○ 0532			
RPMW Hard Materials		RPMW 1003M0	-	.006~.012	-	● 0204	○ 0402		○ 0646			
		RPMW 1204M0	-	.006~.014	-	● 0039			○ 0648			

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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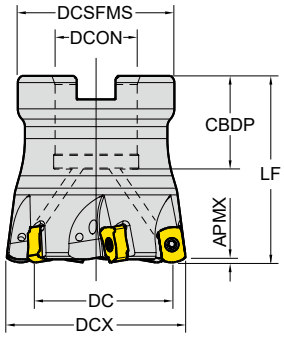
Milling - High Feed Milling - Cutter

Cutters for ENMX

Entry Angle : 10°
4 Corner Negative

<S> Shell Mill



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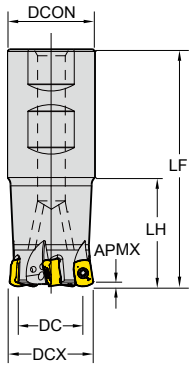

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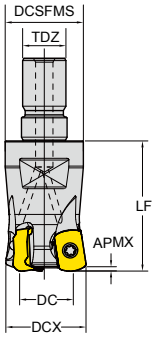


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

: p. 110 Unit : inch

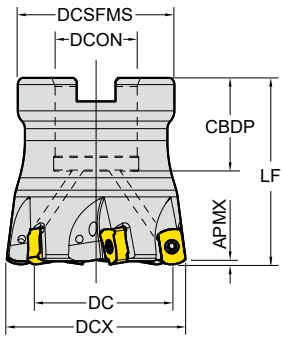
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	
ENMX 0604	.04	EHF-ENMX06-D0625Z2W0625-L500I	0759	.334	.625	2	5.000	Weldon	.625	1.250	-	.-	●
		EHF-ENMX06-D075Z3W075-L500I	0669	.460	.750	3	5.000		.750	2.000	-	-	●
		EHF-ENMX06-D100Z4W100-L550I	0670	.710	1.000	4	5.500		1.000	2.500	-	-	●
		EHF-ENMX06-D125Z5W125-L600I	0671	.960	1.250	5	6.000		1.250	3.000	-	-	●
		FHF-ENMX06-D150Z6S050I	0672	1.210	1.500	6	1.575	Shell Mill	.500	-	.750	1.340	●
		FHF-ENMX06-D200Z6S075I	0673	1.710	2.000	6	1.969		.750	-	.750	1.570	●
		FHF-ENMX06-D300Z10S100I	0760	2.710	3.000	10	2.480		1.000	-	1.024	2.835	●
		MHF-ENMX06-D0625Z2M08I	0761	.310	.625	2	1.000	Modular	M08	-	-	0.512	●
		MHF-ENMX06-D0705Z2M08I	0762	.410	.705	2	1.000		M08	-	-	0.512	●
		MHF-ENMX06-D075Z3M10I	0763	.460	.750	3	1.250		M10	-	-	0.709	●
		MHF-ENMX06-D083Z3M10I	0764	.540	.830	3	1.250		M10	-	-	0.709	●
		MHF-ENMX06-D100Z4M12I	0765	.710	1.000	4	1.500		M12	-	-	0.827	●
		MHF-ENMX06-D1125Z4M12I	0766	.830	1.125	4	1.500		M12	-	-	0.827	●
		MHF-ENMX06-D125Z5M16I	0767	.960	1.250	5	1.750		M16	-	-	1.142	●
		MHF-ENMX06-D1375Z5M16I	0768	1.080	1.375	5	1.750		M16	-	-	1.142	●
		MHF-ENMX06-D150Z6M16I	0769	1.210	1.500	6	1.750		M16	-	-	1.142	●

Series	Series	EDP 1800..	Designation
ENMX 0604	Wrench	0218	TPWBTP08
	Screw	0206	TP082507-GS
	Handle	0189	DH-H4
	Bit	0190	DB-TP08

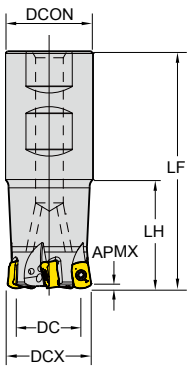
Cutters for ENMX

Entry Angle : 10˚
4 Corner Negative

<S> Shell Mill



<W> Weldon



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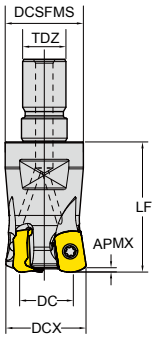


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

: p. 110 Unit : inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	
ENMX 0905	.059	EHF-ENMX09-D100Z2W100-L550I	0777	.614	1.00	2	5.500	Cylindrical	1.00	2.50	-	-	●
		EHF-ENMX09-D125Z3W125-L600I	0778	.864	1.25	3	6		1.25	3.0	-	-	●
		EHF-ENMX09-D150Z4W125-L600I	0779	1.114	1.50	4	6		1.25	1.5	-	-	●
		FHF-ENMX09-D200Z5S075I	0780	1.614	2.00	5	1.969	Shell Mill	.75	-	0.750	1.75	●
		FHF-ENMX09-D250Z6S075I	0781	2.114	2.50	6	1.969		.75	-	0.750	2.204	●
		FHF-ENMX09-D300Z8S100I	0782	2.614	3.00	8	2.480		1.00	-	1.049	2.204	●
		FHF-ENMX09-D400Z10S125I	0783	3.614	4.00	10	2.480		1.25	-	1.260	3	●
		FHF-ENMX09-D600Z14S200I	0784	5.614	6.00	14	2.480		2.00	-	1.496	4.7	●
		MHF-ENMX09-D100Z2M12I	0852	.614	1.000	2	1.500	Modular	M12	-	-	0.827	●
		MHF-ENMX09-D1125Z2M12I	0853	.740	1.125	2	1.500		M12	-	-	0.827	●
		MHF-ENMX09-D125Z3M16I	0854	.864	1.250	3	1.750		M16	-	-	1.142	●
		MHF-ENMX09-D1375Z3M16I	0855	.990	1.375	3	1.750		M16	-	-	1.142	●
		MHF-ENMX09-D150Z4M16I	0856	1.114	1.500	4	1.750		M16	-	-	1.142	●

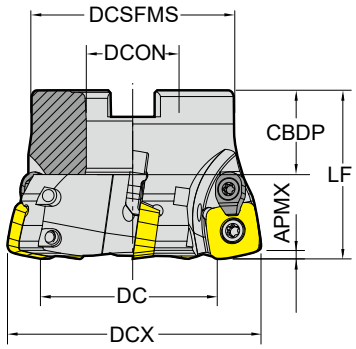
Series	Series	EDP 1800..	Designation
ENMX 0905	Wrench	0216	TPWBTP09
	Screw	0214	TP093510-GS
	Handle	0189	DH-H4
	Bit	0209	DB-TP09

Milling - High Feed Milling - Cutter

Cutters for SDMT, SDMW

Entry Angle : 10°
4 Corner Positive

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

: p. 112

Unit : mm

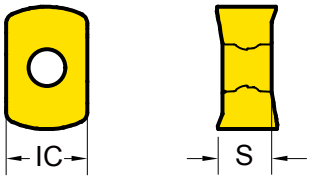
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
SDMT SDMW 1204	.059	FHF-SD1204-D200Z5S075i	0388	2.000	2.00	5	2.00	Shellmill	.75	0.789	1.75	●
		FHF-SD1204-D250Z5S100i	0389	2.500	2.50	5	2.00		1.00	0.945	2.13	●
		FHF-SD1204-D300Z5S100i	0436	3.000	3.00	5	2.00		1.00	0.945	2.13	●
		FHF-SD1204-D300Z7S100i	0437	3.000	3.00	7	2.00		1.00	0.945	2.13	●
		FHF-SD1204-D400Z7S150i	0438	4.000	4.00	7	2.55		1.50	1.181	3.81	●
		FHF-SD1204-D400Z9S150i	0439	4.000	4.00	9	2.55		1.50	1.181	3.81	●

YG MILL INCH

Milling - High Feed Milling - Inserts

ENMX - High Feed Negative (4 Corners)

Click for the ENMX Catalog



Series	IC	S
ENMX0604	.248	.166
ENMX0905	.354	.213

EDP 1200..

●: Stock item ○: Order made item

ENMX		Designation	RE (in)	Fz (in/tooth)	BS (in)	P25 M30 K30 S20 YG602	P30 K30 H15 YG622	P20 YG712	P30 YG713	P40 M35 S30 YG613	K15 YG501	K20 YG5020
ENMX General		ENMX 0604	-	.012~.079	-	● 0474	○ 0553			● 0606		
		ENMX 0905	-	.012~.098	-	● 0702	○ 0704			● 0703		
- ST Stainless Steel		ENMX 0604 -ST	-	.012~.031	-	● 0623				● 0625		
		ENMX 0905 -ST	-	.008~.047	-	● 0705				● 0706		
- TR Hardened Steel		ENMX 0604 -TR	-	.012~.098	-	● 0459	○ 0552	● 0504	○ 0636			
		ENMX 0905 -TR	-	.012~.118	-	● 0600	○ 0629		○ 0717			

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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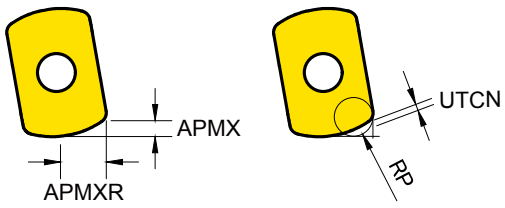
ENMX - High Feed Negative (4 Corners) Technical Information

ENMX 0604



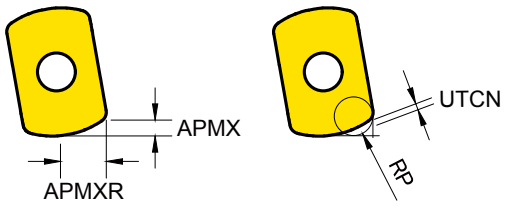
Unit : inch

RP Programmed Corner R	UTCN Uncut Thickness	Overcut
.079	.012	.000
.098	.007	.007
.118	.003	.014

Facing | Plunging | Ramping | Profiling | Helical Interpolation | Enlarge Hole

DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Prograined Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
.625	.035	.137	3.4°	R.079	.011	.817	1.171	.035	.487
.750	.039	.145	2.0°	R.079	.012	1.067	1.421	.039	.612
1.00	.039	.145	1.2°	R.079	.012	1.567	1.921	.039	.862
1.25	.039	.145	0.9°	R.079	.012	2.067	2.421	.039	1.112
1.50	.039	.145	0.7°	R.079	.012	2.567	2.921	.039	1.362
2.00	.039	.145	0.5°	R.079	.012	3.567	3.921	.039	1.862
3.00	.039	.145	0.3°	R.079	.012	5.567	5.922	.039	2.862

ENMX 0905



Unit : inch

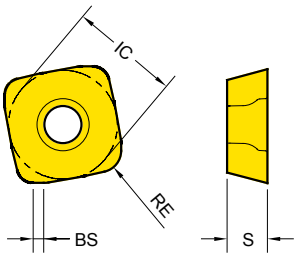
RP Programmed Corner R	UTCN Uncut Thickness	Overcut
.098	.022	.000
.118	.015	.004
.137	.009	0.01
.157	.004	.016
.177	.000	.019

Facing | Plunging | Ramping | Profiling | Helical Interpolation | Enlarge Hole

DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Prograined Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
1.0	.059	.185	3.8°	R.098	.022	1.685	1.921	.059	.803
1.25	.059	.185	2.4°	R.098	.022	2.185	2.421	.059	1.053
1.5	.059	.185	1.7°	R.098	.022	2.685	2.921	.059	1.303
2.0	.059	.185	1.1°	R.098	.022	3.685	3.921	.059	1.803
2.5	.059	.185	0.8°	R.098	.022	4.685	4.921	.059	2.303
3.0	.059	.185	0.7°	R.098	.022	5.685	5.921	.059	2.803
4.0	.059	.185	0.4°	R.098	.022	7.685	7.921	.059	3.803
6.0	.059	.185	0.3°	R.098	.022	11.685	11.921	.059	5.803

Milling - High Feed Milling - Inserts

SDMT / SDMW - High Feed Positive (4 Corners)



Series	IC	S
SDM* 1204	.500	.185

EDP 1200..

●: Stock item ○: Order made item

SDMT SDMW	Designation	RE (in)	Fz (in/tooth)	BS (in)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
					P25 M30 K30 S20	P30 K30 H15	P20	P30	P40 M35 S30	K15	K20
-ST Stainless Steel Super Alloy 	SDMT 120420 -ST	.075	.024~.047	.057	● 0274				● 0666		
SDMW Hard Materials 	SDMW 120420	.075	.024~.055	.055	● 0273	○ 0341		○ 0634	● 0691		

Cutting Speed — Vc (ft/min)

ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG613 Min	YG613 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	590	1250	460	1310	560	980	660	980	330	690	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	560	890	230	590	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	280	480	130	290	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	230	590	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	230	660	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	-	-	-	-	-	-	-	-

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