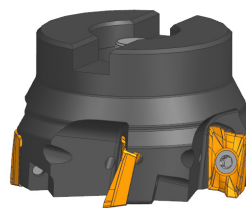
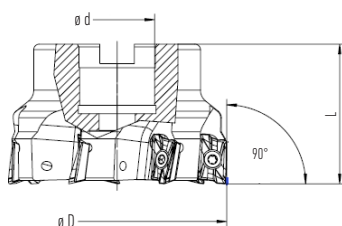


Shoulder mill F1600



- positive milling, 2 edge
- unequal tooth spacing
- high feeds per tooth possible thanks to stable and robust insert
- internal cooling



Arbour mounting

Order Code	D	d	L	Z	Insert screw	Key*	Torque value (Nm)	Stock
F1600.40.N22.40.14.Z4.C	40	22	40	4	BFTX 0409 IP	15 IP	3	●
F1600.50.N22.40.14.Z5.C	50	22	40	5				●
F1600.52.N22.40.14.Z5.C	52	22	40	5				○
F1600.63.N22.40.14.Z5.C	63	22	40	5				●
F1600.66.N22.40.14.Z5.C	66	22	40	5				●
F1600.80.N27.50.14.Z6.C	80	27	50	6				●
F1600.85.N27.50.14.Z6.C	85	27	50	6				○
F1600.100.N32.50.14.Z7.C	100	32	50	7				●
F1600.125.N40.63.14.Z7.C	125	40	63	7				●
F1600.140.N40.63.14.Z8.C	140	40	63	8				●
F1600.160.N40.63.14.Z8.C	160	40	63	8				●
F1600.170.N40.63.14.Z9.C	170	40	63	9				○

● = stock item

○ = available under request

C – internal cooling | * the key is not included in the package

Shoulder mill F1600



Precision insert with strong cutting edge and low cutting force

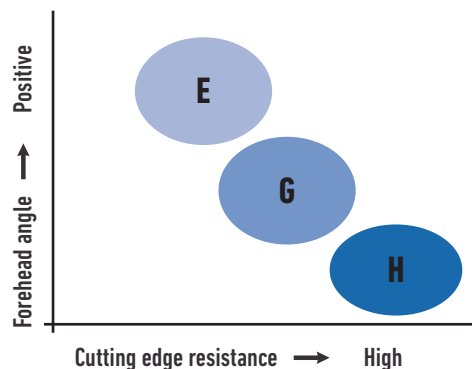
- wave shaped cutting edge reduces cutting force improves edge strenght
- very good surface quality thanks to the narrow tolerance of the cutting edge
- fine machining even with deep slotting (grooving)
- also suitable for less stable machines or machining conditions

Overview of suitable inserts

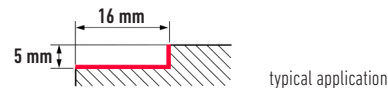
Application	Coated carbid						Carbid			DLC
High speed/light machining	P			K			M S			N
Common use	P			K			M S	M S		N
Roughing	P	P		K			M S			

Order code	P100	P200	P300	K200	K300	M200	M300	NH1	L1000	Radius
APMT 175508 L	○	○	○	○	○					0,8
APMT 175504 G	○	○	○	○	○					0,4
APMT 175508 G	○	●	○	○	○					0,8
APMT 175512 G	○	○	○	○	○					1,2
APMT 175516 G	○	○	○	○	○					1,6
APMT 175508 H	○	●	○	○	○					0,8
APMT 175512 H	○	○	○	○	○					1,2
APMT 175504 E						○	○			0,4

● = stock item ○ = available under request



Order code	P100	P200	P300	K200	K300	M200	M300	NH1	L1000	Radius
APMT 175508 E			○			●	●			0,8
APMT 175512 E						○	○			1,2
APMT 175516 E						○	○			1,6
APMT 175508 EH			○			○	○			0,8
APET 175502 S								○	○	0,2
APET 175504 S								○	○	0,4
APET 175508 S								○	○	0,8



Recommended cutting conditions

HB	Geometry	Coated type																				
		P100			P200			P300			K200			K300			M200			M300		
		Feed fz (mm/t)																				
Cutting Speed Vc (m/min)																						
P	G	Unalloyed steel < 0,15%C, annealed	125	395	365	345	365	345	325	345	325	305										
		Unalloyed steel < 0,45%C, annealed	190	305	275	255	275	255	235	255	235	215										
		Unalloyed steel < 0,45%C, tempered	250	245	215	195	215	195	175	195	175	155										
		Unalloyed steel < 0,75%C, annealed	270	195	185	145	175	155	135	155	135	115										
		Unalloyed steel < 0,75%C, tempered	300	155	125	105	125	105	85	105	85	65										
		Low-alloyed steel, annealed	180	285	255	235	255	235	215	235	215	195										
		Low-alloyed steel, tempered	275	185	155	135	165	145	125	145	125	105										
		Low-alloyed steel, tempered	300	155	125	105	135	115	95	115	95	75										
		Low-alloyed steel, tempered	350	125	95	75	105	85	65	85	65	45										
		High-alloyed steel, annealed	200	255	225	205	225	205	185	205	185	165										
High-alloyed steel, tempered	325	125	95	75	95	75	55	75	55	35												
M	E	Stainless steel, ferritic/martensitic, annealed	200													190	170	140	170	155	125	
		SS austenitic, kalená ponorem	180													205	185	155	185	165	140	
K	G	Grey cast iron										295	265	245	265	245	225					
		Malleable cast iron											195	165	145	165	145	125				
S	E	Heat resistant super alloys, Fe, annealed	300													48	29		44	24		
		Heat resistant super alloys, Fe, hardened	330													48	29		44	24		

For geometry H increase the feed by 20% compared to the values given for geometry G, the cutting speed is the same.