

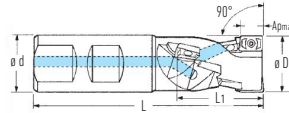
# Helical end mill



## F1150, F1250

- for milling embedded surfaces with greater depth
- suitable for high material removals
- they are mainly used as roughing tools
- it is necessary to pay attention to the stability of the machine, the state of spindle, the removal of chips, tool clamping, machine performance
- internal cooling

### Weldon shank



Order code	Dimensions (mm)						Insert	Screw	Key	Stock
	D	d	L	L1	Ap <sub>max</sub>	Z				
F1150.20.W20.87.28.Z1.C	20	20	87	28	10	1*4	APKT10	VT25	BT08	○
F1150.25.W25.105.37.Z2.C	25	25	105	37	10	2*4				○
F1150.32.W32.115.46.Z2.C	32	32	115	46	10	2*5				○
F1150.40.W32.130.55.Z2.C	40	32	130	55	10	3*6				○
F1250.25.W25.105.29.Z1.C	25	25	105	29	17	1*2	APKT16	VT40	BT15	○
F1250.32.W32.115.44.Z2.C	32	32	115	44	17	2*3				○
F1250.40.W32.130.58.Z2.C	40	32	130	58	17	2*4				○

○ = available under request

### Overview of suitable inserts

Order code	P	M	K	N	S	H
APKT 1003PDR-S PMK19	○	○	○			
APKT 1003PDR-S PK19	○		○			
APKT 1003PDR-S PM19	○	○				
APKT 1003PDR-M PMK20	○	○	○			
APKT 1003PDF-IT AL19				○		
APKT 1604PDR-S PMK19	○	○	○			
APKT 1604PDR-S PK19	○		○			
APKT 1604PDR-S PM19	○	○				
APKT 1604PDR-M PMK20	○	○	○			

○ = available under request

# Helical end mill

## F1150, F1250



### Recommended cutting conditions

		APKT10				Feed fz (mm/t)	Chip depth Ap (mm)	
		Coated insert			AL19			
		PK19	PM19	PMK19	PMK20			
		Cutting speed Vc (m/min.)						
<b>P</b>	Steel	180-280	110-120	100-170	100-170	0,05-0,30	0,5-4,0	
<b>M</b>	Stainless steel		90-160	70-130	70-130	0,05-0,30	0,5-4,0	
<b>K</b>	Cast iron	160-270		120-230	120-230	0,05-0,30	0,5-4,0	
<b>N</b>	Aluminium and non ferrous					300-500	0,06-0,20	

### Recommended cutting conditions

		APKT16				Feed fz (mm/zub)	Chip depth Ap (mm)	
		Coated insert			AL19			
		PK19	PM19	PMK19	PMK20			
		Cutting speed Vc (m/min.)						
<b>P</b>	Steel	180-280	110-120	100-170	100-170	0,05-0,30	0,1-7,0	
<b>M</b>	Stainless steel		90-160	70-130	70-130	0,05-0,30	0,1-7,0	
<b>K</b>	Cast iron	160-270		120-230	120-230	0,05-0,30	0,1-7,0	