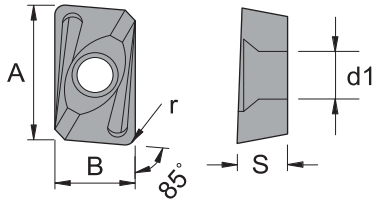
Insert Specifications

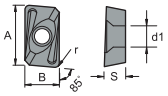
Insert	Dimensions (mm)				
	A	B	S	r	d1
APMT113508	11.0	6.35	3.5	0.8	2.8
APMT113516	11.0	6.35	3.5	1.6	2.8
APMT160408	16.5	9.525	4.76	0.8	4.4
APMT160416	16.5	9.525	4.76	1.6	4.4
APGT160408	16.5	9.525	4.76	0.8	4.4



Insert Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IAPMT113508EMG22HX	APMT113508PDER-MG-CX22HX	●	●	●		○	●
	IAPMT113508EMG23TX	APMT113508PDER-MG-CX23TX	●	●	●		●	●
	IAPMT113508EMG32HX	APMT113508PDER-MG-CX32HX	●	●	●		○	○
	IAPMT113508EMG33TX	APMT113508PDER-MG-CX33TX	●	●	●		●	●
	IAPMT113508EMG43TX	APMT113508PDER-MG-CX43TX	●	●	●		●	
	IAPMT113516EMG32HX	APMT113516PDER-MG-CX32HX	●	●	●		○	○
	IAPMT113516EMG33TX	APMT113516PDER-MG-CX33TX	●	●	●		●	●
	IAPMT113516EMG43TX	APMT113516PDER-MG-CX43TX	●	●	●		●	
	IAPMT113508ERG22HX	APMT113508PDER-RG-CX22HX	●	●	●		○	●
	IAPMT113508ERG23TX	APMT113508PDER-RG-CX23TX	●	●	●		●	●
	IAPMT113508ERG32HX	APMT113508PDER-RG-CX32HX	●	●	●		○	○
	IAPMT113508ERG33TX	APMT113508PDER-RG-CX33TX	●	●	●		●	●
	IAPMT113508ERG43TX	APMT113508PDER-RG-CX43TX	●	●	●		●	
	IAPMT113508EHG32HX	APMT113508PDER-HG-CX32HX	●	●	●		○	○
	IAPMT113508EHG33TX	APMT113508PDER-HG-CX33TX	●	●	●		●	●
	IAPMT113508EHG43TX	APMT113508PDER-HG-CX43TX	●	●	●		●	
	IAPGT160408EAL10	APGT160408PDER-AL-CX10				●		
	IAPGT160408EFG22HX	APGT160408PDER-FG-CX22HX	●	●	●		○	●
	IAPMT160408EMG22HX	APMT160408PDER-MG-CX22HX	●	●	●		○	●
	IAPMT160408EMG32HX	APMT160408PDER-MG-CX32HX	●	●	●		○	○
	IAPMT160408EMG33TX	APMT160408PDER-MG-CX33TX	●	●	●		●	●
	IAPMT160408EMG43TX	APMT160408PDER-MG-CX43TX	●	●	●		●	

Milling Inserts Overview

Inserts	Designation	Grade No.								Dimensions (mm)						Drawing	Cutter Page
		CX22HX	CX23TX	CX31NS	CX32HX	CX33TX	CX43TX	CX10		A	B	S	r	d1	t1		
Shoulder Milling - Single-sided Inserts																	
	**APMT113508PDER-MG** *M*	✓	✓		✓	✓	✓			11.0	6.35	3.5	0.8	2.8	-		A046 A124
	**APMT113516PDER-MG** *M*				✓	✓	✓			11.0	6.35	3.5	1.6	2.8	-		
	**APMT113508PDER-RG** *M*	✓	✓		✓	✓	✓			11.0	6.35	3.5	0.8	2.8	-		
	**APMT113508PDER-HG** *M*				✓	✓	✓			11.0	6.35	3.5	0.8	2.8	-		
	**APGT160408PDER-AL** *M*							✓		16.5	9.525	4.76	0.8	4.4	-		
	**APGT160408PDER-FG** *M*	✓								16.5	9.525	4.76	0.8	4.4	-		
	**APMT160408PDER-MG** *M*	✓			✓	✓	✓			16.5	9.525	4.76	0.8	4.4	-		
	**APMT160416PDER-MG** *M*				✓	✓	✓			16.5	9.525	4.76	1.6	4.4	-		
	**APMT160408PDER-RG** *M*	✓	✓		✓	✓	✓			16.5	9.525	4.76	0.8	4.4	-		
	**APMT160408PDER-HG** *M*	✓			✓	✓	✓			16.5	9.525	4.76	0.8	4.4	-		

Insert Order Code

Insert	Order No. 訂購編碼	Designation	Working Material					
			P	M	K	N	S	H
	IAPMT160416EMG32HX	APMT160416PDER-MG-CX32HX	●	●	●		○	○
	IAPMT160416EMG33TX	APMT160416PDER-MG-CX33TX	●	●	●		●	●
	IAPMT160416EMG43TX	APMT160416PDER-MG-CX43TX	●	●	●		●	
	IAPMT160408ERG22HX	APMT160408PDER-RG-CX22HX	●	●	●		○	●
	IAPMT160408ERG23TX	APMT160408PDER-RG-CX23TX	●	●	●		●	●
	IAPMT160408ERG32HX	APMT160408PDER-RG-CX32HX	●	●	●		○	○
	IAPMT160408ERG33TX	APMT160408PDER-RG-CX33TX	●	●	●		●	●
	IAPMT160408ERG43TX	APMT160408PDER-RG-CX43TX	●	●	●		●	
	IAPMT160408EHG22HX	APMT160408PDER-HG-CX22HX	●	●	●		○	●
	IAPMT160408EHG32HX	APMT160408PDER-HG-CX32HX	●	●	●		○	○
	IAPMT160408EHG33TX	APMT160408PDER-HG-CX33TX	●	●	●		●	●
	IAPMT160408EHG43TX	APMT160408PDER-HG-CX43TX	●	●	●		●	

Recommended Cutting Conditions · For Shoulder Milling

Working Material	APMT1135			APMT1604		
	Vc	fz	ap	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.10 ~ 0.22	0.5 ~ 7.0	120 ~ 250	0.12 ~ 0.28	0.5 ~ 11.0
Stainless Steel	100 ~ 180	0.08 ~ 0.18	0.5 ~ 4.0	100 ~ 180	0.10 ~ 0.22	0.5 ~ 7.0
Cast Iron	120 ~ 250	0.10 ~ 0.22	0.5 ~ 6.0	120 ~ 250	0.12 ~ 0.28	0.5 ~ 11.0
Aluminum Alloy	-	-	-	300 ~ 1000	0.10 ~ 0.40	0.5 ~ 11.0
High Temperature Alloy	40 ~ 100	0.07 ~ 0.14	0.5 ~ 4.0	40 ~ 100	0.10 ~ 0.22	0.5 ~ 7.0
Hardened Steel	50 ~ 100	0.07 ~ 0.15	0.5 ~ 4.0	50 ~ 100	0.10 ~ 0.22	0.5 ~ 7.0

· For High Feed Face Milling (use APMT113516 or APMT160416 insert)

Working Material	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.25 ~ 0.55	0.2 ~ 0.5
Stainless Steel	100 ~ 180	0.2 ~ 0.45	0.2 ~ 0.5
Cast Iron	120 ~ 250	0.25 ~ 0.55	0.2 ~ 0.5
High Temperature Alloy	40 ~ 100	0.175 ~ 0.35	0.2 ~ 0.5
Hardened Steel	50 ~ 100	0.175 ~ 0.375	0.2 ~ 0.5