

Milling Inserts

Nexus High-Performance Milling Inserts

LT 30 Multi-Mat™ Milling

LT 05 Alu-Turning

The Concept



HIGH
PERFORMANCE

LAMINA
TECHNOLOGIES

- High-performance in different materials – same as solid carbide tools
- Eliminate insert guesswork
- Flexible — 1 grade across most materials

- Minimize changeover and set up time
- Much less inventory to buy and manage
- Always have the right insert available

Innovative Technology Let Us Prove it to You!

Simplify



The old way



The Lamina way

- Breakthroughs in honing and coating technologies
- Thickest PVD coating in the industry
- Freedom from the cycle of “new grade” announcements

Attacking Heat & Vibration is in Our DNA.



Milling

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

SNKX High Feed Cutter Inserts



Excellent for
near-to-shape
workpieces



Designed to achieve the same feed
per tooth as bigger inserts



LAMINA
TECHNICAL ENGINEER

HIGH-PERFORMANCE
3x the Thickness of Conventional PVD!

More cutting edges per corner
creates higher productivity

High stability reduces vibration

The Power of 8!

Milling with 8 Cutting Edges

We're excited about our new, 8-cornered negative rake insert with positive geometry. This new-design, high feed insert is optimized for use in steels, cast irons, and hardened materials.

See our special high-feed promotion for this insert on page 4.



Features

- Great for profile and copy milling
- Excels in plunge milling
- Great for roughing operations on pockets and 3D surfaces
- High productivity (more cutting edges per corner)

Benefits

- 8 cutting edges
- Long tool life
- Excellent for dry machining of moulds and dies
- Superior toughness & wear resistances

Part No.	Description	Grade	Programming Radius	Operation	Material
2502115	SNK09T3-HF	LT 30	.165	Roughing	P-K-H

P = steel, K = cast iron, H = hardened material



Insert Grade Descriptions



LT 05

PVD Coated with Chromium Nitride. Great for aluminum $\leq$ 6% silicon and titanium

LT 30 Milling

A sub-micro grain substrate with a very thick high-pulse PVD coating with better adhesion than normal coatings. It can be run in all materials including aluminum

101

Uncoated Ultra Micro-grain Carbide

Used mostly for the general machining of aluminum

Can be used in all non-ferrous materials and high temperature alloys

202

PVD Coated Grade

Ultra-fine grain substrate provides excellent resistance to plastic deformation

NANO-TiAlN Coated

Used for wide range of general milling applications in a variety of materials

351

CVD Coated Grade

Very tough substrate with high wear-resistance

Multi-coating contains TiCN, Al₂O₃, and TiN

Used for rough milling of steel, stainless steel and cast iron

GH05

Uncoated ultra micro-grain carbide

A very sharp, high-polished geometry used in the general and finish machining of aluminum

WSK10

Uncoated ultra micro-grain carbide

A very sharp, high-polished geometry used in the general and finish machining of aluminum



MULTI-MAT™

The Lamina **Multi-Mat™ LT 30 Grade** for Milling
can machine most materials with
ONLY ONE GRADE



Steel



Stainless Steel



Cast Iron



High Temp. Alloys



Hardened Steel



Aluminium & Non ferrous Alloys



True Multi-Mat™ inserts for real productivity



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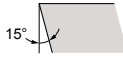
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K

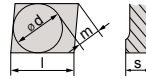
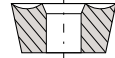
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Shape



Clearance Angle


Tolerance
 $d \pm 0.002$
 $m \pm 0.005$
 $s \pm 0.001$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
1506065	ADKT 1505 PDTR	LT 30	0.512	0.222	0.038	Right	●

● Stocking

○ Non-stocking

Face Milling Insert with 90° Lead Angle

Multi purpose 90° Milling insert. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Slotting

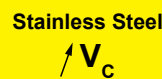
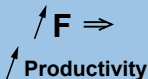


Shoulder Milling



Facing

Machine Recommendations
Guide. Details on page 19.



ADKT 1505 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.551	0.007	0.013	620	1080	0.157	0.009	820
		2	1045, 1060,	190 HB		0.551		0.013		980			720
		3	28Mn6	250 HB		0.551		0.013		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.551	0.006	0.010	490	780	0.157	0.008	650
		4,6	42CrMo4, St50,	230 HB		0.551		0.010		680			590
		5,7	Ck60, 4140, 4340,	280 HB		0.551		0.009		620			490
		8	100Cr6	350 HB		0.551		0.009		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.394	0.005	0.009	290	490	0.118	0.007	420
		10	H13, M42, D3,	280 HB		0.394		0.009		420			390
		11	S6-5-2, 12Ni19	320 HB		0.394		0.007		360			320
		11		350 HB		0.394		0.007		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.551	0.006	0.010	620	820	0.157	0.008	720
		14	X5CrNi18-9	240 HB		0.551		0.005		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.394	0.005	0.007	220	420	0.118	0.006	320
		14	S31500	310 HB		0.394		0.007		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.551	0.006	0.010	490	680	0.157	0.008	620
		13	17-4 PH, 430	42 HRc		0.394		0.008		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.551	0.007	0.013	490	780	0.157	0.009	650
		15	EN-GJL-250,	200 HB		0.551		0.013		720			590
		16	Nu30B	250 HB		0.551		0.013		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.551	0.006	0.011	320	650	0.157	0.008	590
		17,19	50005	200 HB		0.551		0.011		590			490
		18,20		250 HB		0.551		0.011		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.394	0.005	0.007	80	140	0.118	0.006	100
		33	Inconel 700	250 HB		0.394		0.007		140			90
		34	Stellite 21	350 HB		0.394		0.007		140			90
		10	36 TiAl6V4	-	0.020	0.394	0.005	0.008	130	210	0.118	0.007	180
Hardened Mat.	Steel	37	T40	-		0.394		0.007		90			130
		11	38 X100CrMo13,	45 HRc	0.020	0.197	0.004	0.007	130	260	0.079	0.006	190
		38	440C,	50 HRc		0.118		0.006		220			180
		38	G-X260NiCr42	55 HRc		0.059		0.006		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.157	0.004	0.007	130	260	0.059	0.006	160
Ni	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.006	90	190	0.039	0.005	130
	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.551	0.007	0.013	650	1310	0.157	0.010	910



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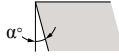
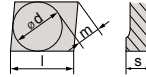
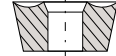
O

M

T



Shape


Clearance Angle
 α = Special

Tolerance
d $\pm$ 0.002
m $\pm$ 0.003
s $\pm$ 0.005

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3153311	AOMT 123608 PETR	LT 30	0.409	0.143	0.031	Right	●

● Stocking

○ Non-stocking

Face Milling Insert with 90° Lead Angle

Multi purpose 90° Milling insert. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Ramping down Milling operations.

Application Guide



Slotting

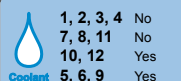
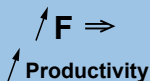


Shoulder Milling



Facing

Machine Recommendations
Guide. Details on page 19.



AOMT 123608 PETR LT 30

Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters	
						min	max	min	max	min	max	D.O.C.	Feed
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.020	0.433	0.005	0.009	620	1080	0.079	0.006
		2	2	1045, 1060,	190 HB		0.433		0.009		980		
		3	3	28Mn6	250 HB		0.433		0.009		820		
	Low alloyed	2	6	180 HB	180 HB	0.020	0.433	0.004	0.007	490	780	0.079	0.005
		4,6	4	42CrMo4, St50,	230 HB		0.433		0.007		680		
		5,7	5	Ck60, 4140, 4340,	280 HB		0.433		0.006		420		
		8	8	100Cr6	350 HB		0.433		0.006		420		
	High alloyed	3	10	220 HB	220 HB	0.020	0.309	0.003	0.006	290	490	0.059	0.005
		10	10	X40CrMoV5,	280 HB		0.309		0.006		420		0.005
		11	11	H13, M42, D3,	320 HB		0.309		0.005		190		0.004
		11	11	S6-5-2, 12Ni19	350 HB		0.309		0.005		190		0.004
Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.020	0.433	0.004	0.007	620	820	0.079	0.005
		14	14	X5CrNi18-9	240 HB		0.433		0.006		520		620
	Duplex	5	14	X2CrNiMo23-4,	290 HB	0.020	0.309	0.003	0.005	220	420	0.059	0.004
		14	14	S31500	310 HB		0.309		0.005		390		290
	Ferritic & Martensitic	6	12	410, X6Cr17,	200 HB	0.020	0.433	0.004	0.007	490	680	0.079	0.005
		13	13	17-4 PH, 430	42 HRC		0.309		0.006		290		0.059
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.020	0.433	0.005	0.009	490	780	0.079	0.006
		15	15	EN-GJL-250,	200 HB		0.433		0.009		720		590
		16	16	No30B	250 HB		0.433		0.009		620		520
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB	0.020	0.433	0.004	0.008	320	650	0.079	0.005
		17,19	17,19	50005	200 HB		0.433		0.008		590		490
		18,20	18,20		250 HB		0.433		0.008		490		420
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.309	0.003	0.005	80	140	0.059	0.004
		33	33	Inconel 700	250 HB		0.309		0.005		140		90
		34	34	Stellite 21	350 HB		0.309		0.005		140		90
	Ti based	10	36	TiAl6V4	-	0.020	0.309	0.003	0.006	130	210	0.059	0.005
		37	37	T40	-		0.309		0.005		90		0.004
													130
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC	0.020	0.155	0.003	0.005	130	260	0.039	0.004
		38	38	440C,	50 HRC		0.093		0.004		220		0.030
		38	38	G-X260NiC42	55 HRC		0.046		0.004		190		0.020
	Chilled Cast Iron	40	40	Ni-Hard 2	400 HB	0.020	0.124	0.003	0.005	130	260	0.030	0.004
	White Cast Iron	41	41	G-X300CrMo15	55 HRC	0.020	0.046	0.003	0.004	90	190	0.020	0.003
													130
Al	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.433	0.005	0.009	650	1310	0.079	0.006



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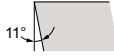
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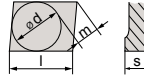
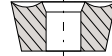
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Shape



Clearance Angle

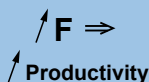

Tolerance
 $d \pm 0.002$
 $m \pm 0.005$
 $s \pm 0.001$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3154422	APKT 100304 PDTR	LT 30	0.409	0.138	0.016	Right	●
3154411	APKT 1003 PDTR	LT 30	0.409	0.138	0.031	Right	●
3154433	APKT 100312 PDTR	LT 30	0.409	0.138	0.047	Right	●
3154444	APKT 100332 PDTR ¹	LT 30	0.409	0.138	0.126	Right	●
3154455	APKT 100340 PDTR ¹	LT 30	0.409	0.138	0.157	Right	●
¹ Replacing APLX 100332 and APLX 100340 respectively; no change in cutter bodies							
1506075	APKT 1604 PDTR-NEW	LT 30	0.606	0.187	0.031	Right	●
1500300	APKT 160424 ER	LT 30	0.606	0.187	0.094	Right	●
1506077	APKT 1705 PETR	LT 30	0.646	0.205	0.031	Right	●

Face Milling Insert with 90° Lead Angle

- Stocking
- Non-stocking

Machine Recommendations
Guide. Details on page 19.

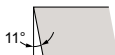
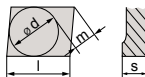
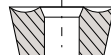


Stainless Steel



All Nexus products are backed
by our 100% satisfaction guarantee.



**A****P****K****T****Shape****Clearance Angle**
Tolerance
 $d \pm 0.002$
 $m \pm 0.005$
 $s \pm 0.001$
**Fixing
Chip breaker**

Application Guide

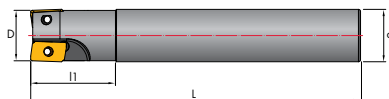
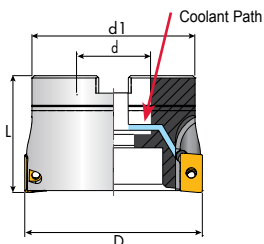
**Slotting****Shoulder Milling****Facing**

Multi purpose 90° Milling insert. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

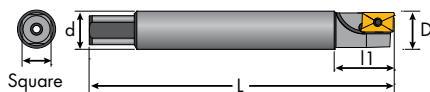
Face Milling Insert with 90° Lead Angle

Face Mill for APKT. See page 30.

End Mill for APKT. See page 44.



PowerLOC End Mill for AP_ _ 1003. See page 45.



APKT 1003 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.353	0.005	0.010	620	1080	0.079	0.007	820
		2	190 HB	0.353		0.010		980		720			
		3	250 HB	0.353		0.010		820		650			
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.353	0.004	0.008	490	780	0.079	0.006	650
			230 HB	0.353		0.008		680		590			
			280 HB	0.353		0.007		420		490			
			350 HB	0.353		0.007		420		550			
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.252	0.003	0.007	290	490	0.059	0.005	420
			280 HB	0.252		0.007		290		390			
			320 HB	0.252		0.006		190		360			
			350 HB	0.252		0.006		190		290			
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.353	0.004	0.008	620	820	0.079	0.006	720
			240 HB	0.353		0.003		0.007		520			680
	Duplex	5	14 X2CrNiN12-3-4, 14 S31500	290 HB	0.020	0.252	0.003	0.006	220	420	0.059	0.005	320
			310 HB	0.252		0.006		390		290			
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.353	0.004	0.008	490	680	0.079	0.006	620
			42 HRC	0.252		0.006		290		490			
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, No30B	150 HB	0.020	0.353	0.005	0.010	490	780	0.079	0.007	650
			200 HB	0.353		0.010		720		590			
			250 HB	0.353		0.010		620		520			
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005	150 HB	0.020	0.353	0.004	0.009	320	650	0.079	0.006	590
			200 HB	0.353		0.009		590		490			
			250 HB	0.353		0.009		490		420			
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.252	0.003	0.006	80	140	0.059	0.005	100
			250 HB	0.252		0.006		140		90			
			350 HB	0.252		0.006		140		90			
	Ti based	10	36 TiAl6V4, 37 T40	-	0.020	0.252	0.003	0.006	130	210	0.059	0.005	180
			-	0.252		0.006		90		130			
	Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.020	0.126	0.003	0.006	130	260	0.039	0.004
			50 HRC	0.076	0.005		220		180				
			55 HRC	0.038	0.005		190		160				
Chilled Cast Iron			40 Ni-Hard 2	400 HB	0.020	0.101	0.003	0.006	130	260	0.030	0.004	160
White Cast Iron			41 G-X300CrMo15	55 HRC	0.020	0.038	0.003	0.005	90	190	0.020	0.003	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.353	0.005	0.010	650	1310	0.079	0.007	910



LAMINA

TECHNICAL SOLUTIONS

APKT 100304 PDTR LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB		0.353		0.008		1080			820
		2		190 HB	0.020	0.353	0.004	0.008	620	980	0.079	0.006	720
		3		250 HB		0.353		0.008		820			650
	Low alloyed	2	6 42CrMo4, St50, 4.6 Ck60, 4140, 4340, 5.7 100Cr6	180 HB		0.353		0.006	490	780		0.005	650
				230 HB	0.020	0.353	0.004	0.006	490	680	0.079	0.005	590
				280 HB		0.353		0.005	420	620		0.004	490
				350 HB		0.353		0.005	420	550		0.004	450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB		0.252		0.005	290	490			420
				280 HB	0.020	0.252	0.003	0.005	290	420	0.059	0.004	390
				320 HB		0.252		0.004	190	360			320
				350 HB		0.252		0.004	190	290			260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.353	0.004	0.006	620	820	0.079	0.005	720
				240 HB		0.353	0.003	0.005	520	680			620
	Duplex	5	14 X2CrNiN23-4, 14 S31500	290 HB	0.020	0.252		0.003	220	420	0.059	0.004	320
				310 HB		0.252		0.004	390				290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.353		0.004	490	680	0.079	0.005	620
				42 HRC		0.252		0.005	290	490	0.059	0.004	420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.353	0.004	0.008	490	720	0.079	0.006	590
				200 HB		0.353		0.008	620				520
				250 HB		0.353							
	Malleable & Nodular	8	17,19 GG40, GG670, 17,19 50005 18,20	150 HB	0.020	0.353		0.007		650			590
				200 HB		0.353	0.004	0.007	320	590	0.079	0.005	490
				250 HB		0.353		0.007		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800 33 Inconel 700 34 Stellite 21	240 HB	0.020	0.252	0.003	0.004		140	0.059	0.004	100
				250 HB		0.252		0.004	80	140			90
				350 HB		0.252		0.004		140			90
	Ti based	10	36 TiAl6V4 37 T40	-	0.020	0.252	0.003	0.005	130	210	0.059	0.004	180
				-		0.252		0.004	90	180			130
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC		0.126		0.004		260	0.039		190
				50 HRC	0.020	0.076	0.002	0.004	130	220	0.030	0.003	180
				55 HRC		0.038		0.003		190	0.020		160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.101	0.002	0.004	130	260	0.030	0.003	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.038	0.002	0.003	90	190	0.020	0.003	130
INF	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.353	0.004	0.008	650	1310	0.079	0.006	910

APKT 100312 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.353	0.005	0.011	620	1080	0.079	0.008	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.353	0.004	0.009	490	780	0.079	0.007	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.252	0.003	0.008	290	420	0.059	0.006	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.353	0.004	0.009	620	820	0.079	0.007	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.252	0.003	0.006	220	420	0.059	0.006	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.353	0.004	0.009	490	680	0.079	0.007	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.353	0.005	0.011	490	720	0.079	0.008	650
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.353	0.004	0.010	320	590	0.079	0.007	490
		17,19	50005	200 HB									
		18,20		250 HB									
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.252	0.003	0.006	80	140	0.059	0.006	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.252	0.003	0.007	130	210	0.059	0.006	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.076	0.003	0.006	130	220	0.039	0.005	190
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.101	0.003	0.006	130	260	0.030	0.005	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.038	0.003	0.005	90	190	0.020	0.004	130
HP	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.353	0.005	0.011	650	1310	0.079	0.009	910

ADKT

AOMT

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APMT

LDMT

ODMT

ODMW

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OFMT

PNEG

RDMT

RDMW

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SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

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SEET

SEGT

APKT 100332 PDTR LT 30

Material Group	Gr. #	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.353	0.005	0.011	620	1080	0.039	0.011	820
		2	1045, 1060, 28Mn6	190 HB		0.353		0.011		980			720
		3		250 HB		0.353		0.011		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.353	0.004	0.009	490	780	0.039	0.010	650
		4,6	Ck60, 4140, 4340,	230 HB		0.353		0.009		680			590
		5,7	100Cr6	280 HB		0.353		0.008		420			490
		8		350 HB		0.353		0.008		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.252	0.003	0.008	290	490	0.039	0.009	420
		10	H13, M42, D3,	280 HB		0.252		0.008		420			390
		11	S6-5-2, 12Ni19	320 HB		0.252		0.006		190			320
		11		350 HB		0.252		0.006		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.353	0.004	0.009	620	820	0.039	0.010	720
		14	X5CrNi18-9	240 HB		0.353		0.003		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.252	0.003	0.006	220	420	0.039	0.008	320
		14	S31500	310 HB		0.252		0.006		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.353	0.004	0.009	490	680	0.039	0.010	620
		13	17-4 PH, 430	42 HRC		0.252		0.007		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.353	0.005	0.011	490	720	0.039	0.011	590
		15	EN-GJL-250,	200 HB		0.353		0.011		620			520
		16	No30B	250 HB		0.353		0.011		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.353	0.004	0.010	320	650	0.039	0.010	590
		17,19	50005	200 HB		0.353		0.010		590			490
		18,20		250 HB		0.353		0.010		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.252	0.003	0.006	80	140	0.039	0.008	100
		33	Inconel 700	250 HB		0.252		0.006		140			90
		34	Stellite 21	350 HB		0.252		0.006		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.252	0.003	0.007	130	210	0.039	0.009	180
		37	T40	-		0.252		0.006		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.016	0.126	0.003	0.006	130	260	0.028	0.006	190
		38	440C,	50 HRC		0.076		0.006		220			180
		38	G-X260NiCr42	55 HRC		0.038		0.005		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.016	0.101	0.003	0.006	130	260	0.028	0.007	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.016	0.038	0.003	0.005	90	190	0.028	0.006	130
HF	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.353	0.005	0.011	650	1310	0.039	0.012	910

APKT 100340 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters	
					min	max	min	max	min	max	D.O.C.	Feed
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.353	0.005	0.018	620	1080	0.039	0.014
		2		190 HB		0.353		0.018		980		
		3		250 HB		0.353		0.018		820		
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.353	0.004	0.014	490	780	0.039	0.012
		2		230 HB		0.353		0.014		680		
		2		280 HB		0.353		0.013		420		
		2		350 HB		0.353		0.013		420		
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.252	0.003	0.013	290	490	0.039	0.011
		3		280 HB		0.252		0.013		420		
		3		320 HB		0.252		0.010		190		
		3		350 HB		0.252		0.010		190		
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.353	0.003	0.014	620	820	0.039	0.012
		4		240 HB		0.353		0.013		520		
	Duplex	5	14 X2CrNiN23-4, 14 S31500	290 HB	0.020	0.252	0.003	0.010	220	420	0.039	0.009
		5		310 HB		0.252		0.010		390		
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.353	0.004	0.014	490	680	0.039	0.012
		6		42 HRC		0.252		0.011		290		
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.353	0.005	0.018	490	720	0.039	0.014
		7		200 HB		0.353		0.018		620		
		7		250 HB		0.353		0.018		620		
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005, 18,20	150 HB	0.020	0.353	0.004	0.016	320	590	0.039	0.012
		8		200 HB		0.353		0.016		490		
		8		250 HB		0.353		0.016		490		
	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.252	0.003	0.010	80	140	0.039	0.009
		9		250 HB		0.252		0.010		140		
		9		350 HB		0.252		0.010		140		
	Ti based	10	36 TiAl6V4, 37 T40	-	0.020	0.252	0.003	0.011	130	210	0.039	0.011
		10		-		0.252		0.010		90		
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.016	0.126	0.003	0.010	130	260	0.028	0.008
		11		50 HRC		0.076		0.009		220		
		11		55 HRC		0.038		0.008		190		
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.016	0.101	0.003	0.010	130	260	0.028	0.008
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.016	0.038	0.003	0.008	90	190	0.028	0.007
Al	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.353	0.005	0.018	650	1310	0.039	0.015

ADKT

AOMT

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LDMT

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OFMT

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RDMT

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SDKT

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SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

APKT 1604 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.590	0.007	0.013	620	1080	0.157	0.009	820
		2	1045, 1060,	190 HB		0.590		0.013		980			720
		3	28Mn6	250 HB		0.590		0.013		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.590	0.006	0.010	490	780	0.157	0.008	650
		4,6	42CrMo4, St50,	230 HB		0.590		0.010		680			590
		5,7	Ck60, 4140, 4340,	280 HB		0.590		0.009		420			490
		8	100Cr6	350 HB		0.590		0.009		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.422	0.005	0.009	290	490	0.118	0.007	420
		10	H13, M42, D3,	280 HB		0.422		0.009		420			390
		11	S6-5-2, 12Ni19	320 HB		0.422		0.007		190			320
		11		350 HB		0.422		0.007		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.590	0.005	0.010	620	820	0.157	0.008	720
		14	X5CrNi18-9	240 HB		0.590		0.009		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.422	0.005	0.007	220	420	0.118	0.006	320
		14	S31500	310 HB		0.422		0.007		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.590	0.006	0.010	490	680	0.157	0.008	620
		13	17-4 PH, 430	42 HRC		0.422		0.008		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.590	0.007	0.013	490	780	0.157	0.009	650
		15	EN-GJL-250,	200 HB		0.590		0.013		720			590
		16	No30B	250 HB		0.590		0.013		620			520
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.590	0.006	0.011	320	590	0.157	0.008	590
		17,19	50005	200 HB		0.590		0.011		590			490
		18,20		250 HB		0.590		0.011		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.422	0.005	0.007	80	140	0.118	0.006	100
		33	Inconel 700	250 HB		0.422		0.007		140			90
		34	Stellite 21	350 HB		0.422		0.007		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.422	0.005	0.008	130	210	0.118	0.007	180
		37	T40	-		0.422		0.007		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.211	0.004	0.007	130	260	0.079	0.006	190
		38	440C,	50 HRc		0.126		0.006		220			180
		38	G-X260NiCr42	55 HRc		0.063		0.006		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.169	0.004	0.007	130	260	0.059	0.006	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.063	0.004	0.006	90	190	0.039	0.005	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.590	0.007	0.013	650	1310	0.157	0.010	910

APKT 160424 ER LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.590	0.007	0.013	620	980	0.197	0.009	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.590	0.006	0.010	490	780	0.197	0.008	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.422	0.005	0.009	290	420	0.148	0.007	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.590	0.005	0.010	620	820	0.197	0.008	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.422	0.005	0.007	220	420	0.148	0.006	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.590	0.006	0.010	490	680	0.197	0.008	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.590	0.007	0.013	490	720	0.197	0.009	650
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.590	0.006	0.011	320	590	0.197	0.008	490
		17,19	S0005	200 HB									
		18,20		250 HB									
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.422	0.005	0.007	80	140	0.148	0.006	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.422	0.005	0.008	130	210	0.148	0.007	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.126	0.004	0.006	130	220	0.074	0.005	160
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.169	0.004	0.007	130	260	0.074	0.006	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.063	0.004	0.006	90	190	0.049	0.005	130
HP	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.590	0.007	0.013	650	1310	0.197	0.010	910



APKT 1705 PETR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 23Mn6	125 HB	0.020	0.590	0.007	0.016	620	1080	0.157	0.011	820
		2		190 HB		0.590		0.016		980			720
		3		250 HB		0.590		0.016		820			650
	Low alloyed	2	6 42CrMo4, St50, 4.6 Ck60, 4140, 4340, 5.7 100Cr6	180 HB	0.020	0.590	0.006	0.012	490	780	0.157	0.009	650
				230 HB		0.590		0.012		680			590
				280 HB		0.590		0.011		620			490
				350 HB		0.590		0.011		550			450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.422	0.005	0.011	290	490	0.118	0.009	420
				280 HB		0.422		0.011		420			390
				320 HB		0.422		0.009		360			320
				350 HB		0.422		0.009		290			260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.590	0.006	0.012	620	820	0.157	0.009	720
				240 HB		0.590		0.011		520			620
	Duplex	5	14 X2CrNiN23-4, 14 S31500	290 HB	0.020	0.422	0.005	0.009	220	420	0.118	0.008	320
				310 HB		0.422		0.009		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.590	0.006	0.012	490	680	0.157	0.009	620
				42 HRc		0.422		0.010		490			420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.590	0.007	0.016	490	780	0.157	0.011	650
				200 HB		0.590		0.016		720			590
				250 HB		0.590		0.016		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005	150 HB	0.020	0.590	0.006	0.014	320	650	0.157	0.009	590
				200 HB		0.590		0.014		590			490
				250 HB		0.590		0.014		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800 33 Inconel 700 34 Stellite 21	240 HB	0.020	0.422	0.005	0.009	80	140	0.118	0.008	100
				250 HB		0.422		0.009		140			90
				350 HB		0.422		0.009		140			90
	Ti based	10	36 TiAl6V4 37 T40	-	0.020	0.422	0.005	0.010	130	210	0.118	0.009	180
				-		0.422		0.009		180			130
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRc	0.020	0.211	0.004	0.009	130	260	0.079	0.007	190
				50 HRc		0.126		0.008		220			160
				55 HRc		0.063		0.007		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.169	0.004	0.009	130	260	0.059	0.007	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.020	0.063	0.004	0.007	90	190	0.039	0.006	130
NF	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.590	0.007	0.016	650	1310	0.157	0.012	910



A

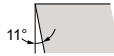
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M

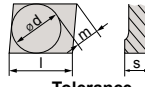
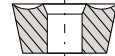
T



Shape



Clearance Angle


Tolerance
d ± 0.002
m ± 0.003
s ± 0.005

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3153317	APMT 0903 PDTR	LT 30	0.375	0.125	0.016	Right	●
3153321	APMT 1135 PDTR	LT 30	0.374	0.139	0.028	Right	●
3151134	APMT 1604 PDTR	LT 30	0.625	0.187	0.026	Right	○
3153325	APMT 160408 PDTR	LT 30	0.625	0.187	0.031	Right	●

● Stocking

○ Non-stocking

Face Milling Insert with 90° Lead Angle

Multi purpose 90° Milling insert. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Slotting

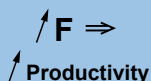


Shoulder Milling



Facing

Machine Recommendations
Guide. Details on page 19.



Productivity


Coolant
1, 2, 3, 4 No
7, 8, 11 No
10, 12 Yes
5, 6, 9 Yes

Stainless Steel



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by our 100% satisfaction guarantee.



APMT 0903 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.314	0.004	0.008	620	1080	0.079	0.006	820
		2	1045, 1060, 28Mn6	190 HB		0.314		0.008		980			720
		3		250 HB		0.314		0.008		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.314	0.004	0.006	490	780	0.079	0.005	650
		4,6	42CrMo4, St50,	230 HB		0.314		0.006		680			590
		5,7	42CrMo4, St50,	280 HB		0.314		0.005		420			490
		8	100Cr6	350 HB		0.314		0.005		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.224	0.003	0.005	290	490	0.059	0.004	420
		10	H13, M42, 03,	280 HB		0.224		0.005		420			390
		11	S6-5-2, 12N19	320 HB		0.224		0.004		190			320
		11		350 HB		0.224		0.004		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.314	0.004	0.006	620	820	0.079	0.005	720
		14	X5CrNi18-9	240 HB		0.314		0.003		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.224	0.003	0.004	220	420	0.059	0.004	320
		14	S31500	310 HB		0.224		0.004		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.314	0.004	0.006	490	680	0.079	0.005	620
		13	17-4 PH, 430	42 HRc		0.224		0.005		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.314	0.004	0.008	490	780	0.079	0.006	650
		15	EN-GJL-250,	200 HB		0.314		0.008		720			590
		16	Ni30B	250 HB		0.314		0.008		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.314	0.004	0.007	320	650	0.079	0.005	590
		17,19	50005	200 HB		0.314		0.007		590			490
		18,20		250 HB		0.314		0.007		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.224	0.003	0.004	80	140	0.059	0.004	100
		33	Inconel 700	250 HB		0.224		0.004		140			90
		34	Stellite 21	350 HB		0.224		0.004		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.224	0.003	0.005	130	210	0.059	0.004	180
		37	T40	-		0.224		0.004		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.112	0.002	0.004	130	260	0.039	0.003	190
		38	440C,	50 HRc		0.067		0.004		220			180
		38	G-X260NiCr42	55 HRc		0.047		0.003		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.090	0.002	0.004	130	260	0.030	0.003	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.047	0.002	0.003	90	190	0.020	0.003	130
NF	Al (>8%Si)	12	25 AlSi12	130 HB	0.020	0.314	0.004	0.008	650	1310	0.079	0.006	910

APMT 1135 PDTR LT 30

Material Group	Gr. #	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB		0.394		0.009		1080			820
		2		190 HB	0.020	0.394	0.005	0.009	620	980	0.079	0.006	720
		3		250 HB		0.394		0.009		820			650
	Low alloyed	2	6 42CrMo4, St50, 46 Ck60, 4140, 4340, 5,7 100Cr6	180 HB		0.394		0.007	490	780			650
				230 HB	0.020	0.394	0.004	0.007	490	680	0.079	0.005	590
				280 HB		0.394		0.006	420	620			490
				350 HB		0.394		0.006	420	550			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, 11 S6-5-2, 12N19	220 HB		0.281		0.006	290	490		0.005	420
				280 HB	0.020	0.281	0.003	0.006	290	420	0.059	0.005	390
				320 HB		0.281		0.005	190	360		0.004	320
				350 HB		0.281		0.005	190	290		0.004	260
Stainless Steel	Austenitic	4	14 304, 316, X5CrNi18-9	180 HB	0.020	0.394	0.004	0.007	620	820	0.079	0.005	720
				240 HB		0.394	0.003	0.006	520	680			620
	Duplex	5	14 X2CrNiN23-4, S31500	290 HB	0.020	0.281	0.003	0.005	220	420	0.059	0.004	320
				310 HB		0.281		0.005	390				290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.394	0.004	0.007	490	680	0.079	0.005	620
				42 HRC		0.281		0.006	290	490	0.059	0.004	420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, No30B	150 HB	0.020	0.394	0.005	0.009	490	720	0.079	0.006	590
				200 HB		0.394		0.009	620				520
				250 HB		0.394		0.009					
	Malleable & Nodular	8	17,19 GG40, GGG70, 17,19 50005, 18,20	150 HB		0.394		0.008		650			590
				200 HB	0.020	0.394	0.004	0.008	320	590	0.079	0.005	490
				250 HB		0.394		0.008		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.281	0.003	0.005	140		0.059	0.004	100
				250 HB		0.281		0.005	80	140			90
				350 HB		0.281		0.005		140			90
		10	36 TiAl6V4, 37 T40	-	0.020	0.281	0.003	0.006	130	210	0.059	0.005	180
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC		0.141		0.005		260	0.039	0.004	190
				50 HRC	0.020	0.084	0.003	0.004	130	220	0.030	0.003	180
				55 HRC		0.042		0.004		190	0.020	0.003	160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.113	0.003	0.005	130	260	0.030	0.004	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.042	0.003	0.004	90	190	0.020	0.003	130
NF	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.394	0.005	0.009	650	1310	0.079	0.006	910



LAMINA

TECHNICAL

APMT 1604 PDTR & APMT 160408 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.590	0.006	0.012	620	1080	0.157	0.008	820
		2	1045, 1060,	190 HB		0.590		0.012		980			720
		3	28Mn6	250 HB		0.590		0.012		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.590	0.005	0.009	490	780	0.157	0.007	650
		4,6	Ck60, 4140, 4340,	230 HB		0.590		0.009		680			590
		5,7	100Cr6	280 HB		0.590		0.009		420			490
		8		350 HB		0.590		0.008		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.422	0.004	0.008	290	490	0.118	0.006	420
		10	H13, M42, D3,	280 HB		0.422		0.008		420			390
		11	S6-5-2, 12Ni19	320 HB		0.422		0.007		190			320
		11		350 HB		0.422		0.007		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.590	0.005	0.009	620	820	0.157	0.007	720
		14	X5CrNi18-9	240 HB		0.590		0.004		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.422	0.004	0.007	220	420	0.118	0.006	320
		14	S31500	310 HB		0.422		0.007		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.590	0.005	0.009	490	680	0.157	0.007	620
		13	17-4 PH, 430	42 HRC		0.422		0.007		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.590	0.006	0.012	490	720	0.157	0.008	650
		15	EN-GJL-250,	200 HB		0.590		0.012		620			590
		16	No30B	250 HB		0.590		0.012		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.590	0.005	0.010	320	590	0.157	0.007	590
		17,19	50005	200 HB		0.590		0.010		590			490
		18,20		250 HB		0.590		0.010		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.422	0.004	0.007	80	140	0.118	0.006	100
		33	Inconel 700	250 HB		0.422		0.007		140			90
		34	Stellite 21	350 HB		0.422		0.007		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.422	0.004	0.007	130	210	0.118	0.006	180
		37	T40	-		0.422		0.007		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.211	0.004	0.007	130	260	0.079	0.005	190
		38	440C,	50 HRC		0.126		0.006		220			180
		38	G-X260NiCr42	55 HRC		0.063		0.005		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.169	0.004	0.007	130	260	0.059	0.005	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.063	0.004	0.005	90	190	0.039	0.004	130
RF	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.590	0.006	0.012	650	1310	0.157	0.009	910



L

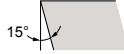
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M

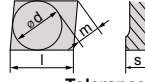
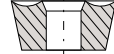
T



Shape



Clearance Angle


Tolerance
 $d \pm 0.002$
 $m \pm 0.003$
 $s \pm 0.005$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3161989	LDMT 1504 PDTR	LT 30	0.575	0.187	0.029	Right	o

Availability is subject to special agreement

- Stocking
- o Non-stocking

Face Milling Insert with 90° Lead Angle

Multi purpose 90° Milling insert. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Slotting

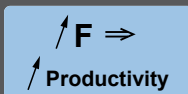


Shoulder Milling



Facing

Machine Recommendations
Guide. Details on page 19.

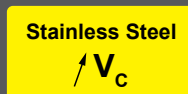


Productivity



1, 2, 3, 4	No
7, 8, 11	No
10, 12	Yes
5, 6, 9	Yes

Coolant



Stainless Steel

V_c

LAMINA
TECHNOLOGIES

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LDMT 1504 PDTR LT 30

Material Group	Gr. #	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.551	0.007	0.013	620	1080	0.157	0.009	820
		2	1045, 1060,	190 HB		0.551		0.013		980			720
		3	28Mn6	250 HB		0.551		0.013		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.551	0.006	0.010	490	780	0.157	0.008	650
		4,6	42CrMo4, St50,	230 HB		0.551		0.010	490	680			590
		5,7	CK60, 4140, 4340,	280 HB		0.551		0.009	420	620			490
		8	100Cr6	350 HB		0.551		0.009	420	550			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.394	0.005	0.009	290	490	0.118	0.007	420
		10	H13, M42, D3,	280 HB		0.394		0.009	290	420			390
		11	S6-5-2, 12Ni19	320 HB		0.394		0.007	190	360			320
		11		350 HB		0.394		0.007	190	290			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.551	0.006	0.010	620	820	0.157	0.008	720
		14	X5CrNi18-9	240 HB		0.551	0.005	0.009	520	680			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.394	0.005	0.007	220	420	0.118	0.006	320
		14	S31500	310 HB		0.394		0.007	390				290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.551	0.006	0.010	490	680	0.157	0.008	620
		13	17-4 PH, 430	42 HRC		0.394		0.008	290	490			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.551	0.007	0.013	490	720	0.157	0.009	590
		15	EN-GJL-250,	200 HB		0.551		0.013	620				520
		16	Ni30B	250 HB		0.551		0.013					
	Malleable & Nodular	8	17,19 GG40, GG70,	150 HB	0.020	0.551	0.006	0.011	320	590	0.157	0.008	490
		17,19	50005	200 HB		0.551		0.011		490			420
		18,20		250 HB		0.551		0.011					
	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.394	0.005	0.007	80	140	0.118	0.006	100
		33	Inconel 700	250 HB		0.394		0.007		140			90
		34	Stellite 21	350 HB		0.394		0.007		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.394	0.005	0.008	130	210	0.118	0.007	180
		37	T40	-		0.394		0.007	90	180			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.197	0.004	0.007	130	260	0.079	0.006	190
		38	440C,	50 HRC		0.118		0.006		220			180
		38	G-X260NiCr42	55 HRC		0.059		0.006		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.157	0.004	0.007	130	260	0.059	0.006	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.006	90	190	0.039	0.005	130
HF	Al (>8%Si)	12	25 AlSi12	130 HB	0.020	0.551	0.007	0.013	650	1310	0.157	0.010	910



O

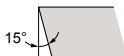
D

M

T



Shape

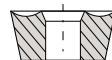


Clearance Angle



Tolerance

s ± 0.005
For l = 05, d ± 0.003 m ± 0.005
For l = 06, d ± 0.004 m ± 0.006


Fixing
Chip breaker

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

Part No.	Description	Grade	l	s	r	Direction	Stock
3954406	ODMT 0504 ZZTR	LT 30	0.207	0.187	0.031	Right	●
3954411	ODMT 060508 TN	LT 30	0.259	0.219	0.031	Right	●

● Stocking

○ Non-stocking

Face Milling Insert with 45° Lead Angle

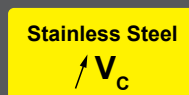
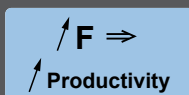
Multi purpose 45° Milling insert with 8 cutting edges.

Suitable for Roughing to Finishing-Face Milling, Plunging and Ramping down operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



ODMT 0504 ZZTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters	
					min	max	min	max	min	max	D.O.C.	Feed
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.138	0.020	0.138	0.020	1080	0.099	0.014
		2	2	1045, 1060,	190 HB	0.138	0.009	0.138	0.020	620		0.014
		3	3	28Mn6	250 HB	0.138	0.020	0.138	0.020	820		0.014
	Low alloyed	2	6	42CrMo4, St50,	180 HB	0.138	0.016	0.138	0.016	490	0.099	0.013
		4,6	7	Ck60, 4140, 4340,	230 HB	0.138	0.007	0.138	0.016	490		0.013
		5,7	8	100Cr6	280 HB	0.138	0.014	0.138	0.014	420		0.011
		8	9		350 HB	0.138	0.014	0.138	0.014	420		0.011
	High alloyed	3	10	X40CrMoV5,	220 HB	0.098	0.014	0.098	0.014	290	0.074	0.011
		10	11	H13, M42, D3,	280 HB	0.098	0.014	0.098	0.014	290		0.011
		11	12	S6-5-2, 12Ni19	320 HB	0.098	0.011	0.098	0.011	190		0.010
		11	13		350 HB	0.098	0.011	0.098	0.011	190		0.010
Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.138	0.007	0.138	0.014	620	0.099	0.011
		14	15	X5CrNi18-9	240 HB	0.138	0.006	0.138	0.013	520		0.011
	Duplex	5	14	X2CrNiN23-4,	290 HB	0.098	0.006	0.098	0.011	420	0.074	0.010
		14	15	S31500	310 HB	0.098	0.011	0.098	0.011	390		0.010
	Ferritic & Martensitic	6	12	410, X6Cr17,	200 HB	0.138	0.007	0.138	0.014	490	0.099	0.011
		13	13	17-4 PH, 430	42 HRC	0.098	0.013	0.098	0.013	290		0.010
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.138	0.020	0.138	0.020	780	0.099	0.014
		15	16	EN-GJL-250,	200 HB	0.138	0.009	0.138	0.020	490		0.014
		16	17	No30B	250 HB	0.138	0.020	0.138	0.020	620		0.014
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB	0.138	0.018	0.138	0.018	650	0.099	0.013
		17,19	18,20	50005	200 HB	0.138	0.007	0.138	0.018	320		0.013
		18,20			250 HB	0.138	0.018	0.138	0.018	490		0.013
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.098	0.011	0.098	0.011	140	0.074	0.010
		33	34	Inconel 700	250 HB	0.098	0.006	0.098	0.011	80		0.010
		34		Stellite 21	350 HB	0.098	0.011	0.098	0.011	140		0.010
	Ti based	10	36	TiAl6V4	-	0.098	0.006	0.098	0.013	130	0.074	0.011
		37		T40	-	0.098	0.011	0.098	0.011	90		0.010
						0.098	0.011	0.098	0.011	180		0.010
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC	0.049	0.011	0.049	0.011	260	0.037	0.008
		38		440C,	50 HRC	0.030	0.005	0.030	0.010	130		0.008
		38		G-X260NiCr42	55 HRC	0.015	0.009	0.015	0.009	190		0.008
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.016	0.039	0.005	0.011	130	0.037	0.009
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.016	0.015	0.005	0.009	90	0.025	0.008
						0.016	0.015	0.005	0.009	190	0.025	0.008
Al	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.138	0.009	0.020	650	0.099	0.016

ODMT 060508 TN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB		0.157	0.021		1080			820
		2	2	1045, 1060,	190 HB	0.020	0.157	0.009	0.021	620	0.099	0.015	720
		3	3	28Mn6	250 HB		0.157		0.021	820			650
	Low alloyed	2	6	42CrMo4, St50,	180 HB		0.157		0.017	490		0.013	850
		4,6	4	Ck60, 4140, 4340,	230 HB	0.020	0.157	0.007	0.017	490	0.099	0.013	590
		5,7	5	100Cr6	280 HB		0.157		0.015	420		0.012	490
		8	8		350 HB		0.157		0.015	420		0.012	450
	High alloyed	3	10	X40CrMoV5,	220 HB		0.112		0.015	290		0.012	420
		10	10	H13, M42, D3,	280 HB	0.020	0.112	0.006	0.015	290	0.074	0.012	390
		11	11	S6-5-2, 12N19	320 HB		0.112		0.012	190		0.011	320
		11	11		350 HB		0.112		0.012	190		0.011	260
Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.020	0.157	0.007	0.015	620	0.099	0.012	720
		14	14	X5CrNi18-9	240 HB		0.157	0.006	0.013	520			620
	Duplex	5	14	X2CrNiN23-4,	290 HB	0.020	0.112	0.006	0.012	220	0.074	0.011	320
		14	14	S31500	310 HB		0.112		0.012	390			290
	Ferritic & Martensitic	6	12	410, X6Cr17,	200 HB	0.020	0.157	0.007	0.015	490	0.099	0.012	620
		13	13	17-4 PH, 430	42 HRC		0.112		0.013	290	0.074	0.011	420
Cast Iron	Grey	7	15	GG20, GG40,	150 HB		0.157		0.021	780			650
		15	15	EN-GJL-250,	200 HB	0.020	0.157	0.009	0.021	490	0.099	0.015	590
		16	16	No30B	250 HB		0.157		0.021	620			520
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB		0.157		0.019	650			590
		17,19	17,19	50005	200 HB	0.020	0.157	0.007	0.019	320	0.099	0.013	490
		18,20	18,20		250 HB		0.157		0.019	490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB		0.112		0.012	140			100
		33	33	Inconel 700	250 HB	0.020	0.112	0.006	0.012	80	0.074	0.011	90
		34	34	Stellite 21	350 HB		0.112		0.012	140			90
	Ti based	10	36	TiAl6V4	-	0.020	0.112	0.006	0.013	130	0.074	0.012	180
		37	37	T40	-		0.112		0.012	90		0.011	130
		37	37		-		0.112		0.012	90			180
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC		0.056		0.012	260	0.050	0.009	190
		38	38	440C,	50 HRC	0.016	0.034	0.005	0.011	130	0.037	0.009	180
		38	38	G-X260NiCr42	55 HRC		0.017		0.009	190	0.025	0.008	160
	Chilled Cast Iron	40	40	Ni-Hard 2	400 HB	0.016	0.045	0.005	0.012	130	0.037	0.009	160
	White Cast Iron	41	41	G-X300CrMo15	55 HRC	0.016	0.017	0.005	0.009	90	0.025	0.008	130
W	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.157	0.009	0.021	650	0.099	0.017	910



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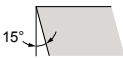
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M

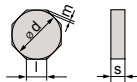
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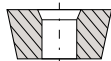
Shape



Clearance Angle



Tolerance
d ± 0.004
m ± 0.006
s ± 0.005



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3954415	ODMW 060508 TN	LT 30	0.259	0.219	0.031	Right	●

Face Milling Insert with 45° Lead Angle

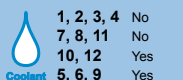
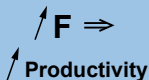
- Stocking
- Non-stocking

Multi purpose 45° Milling insert with 8 cutting edges and flat rake surface. Designed for materials that generate short chips. Suitable for Roughing to Finishing - Face Milling, Plunging and Ramping down operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



ODMW 060508 TN LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 23Mn6	125 HB	0.020	0.157	0.009	0.023	620	1080	0.118	0.016	820
		2		190 HB		0.157		0.023		980			720
		3		250 HB		0.157		0.023		820			650
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.157	0.007	0.018	490	780	0.118	0.014	650
				230 HB		0.157		0.018	490	680			590
				280 HB		0.157		0.016	420	620			490
				350 HB		0.157		0.016	420	550			450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.112	0.006	0.016	290	490	0.089	0.013	420
				280 HB		0.112		0.016	290	420			390
				320 HB		0.112		0.013	190	360			320
				350 HB		0.112		0.013	190	290			260
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.157	0.009	0.023	490	780	0.118	0.016	650
				200 HB		0.157		0.023		720			590
				250 HB		0.157		0.023		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005	150 HB	0.020	0.157	0.007	0.020		650	0.118	0.014	590
			18,20	250 HB		0.157		0.020	320	490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.016	0.056	0.005	0.013		260	0.059	0.010	190
				50 HRC		0.034		0.011	130	220			180
				55 HRC		0.017		0.010		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.016	0.045	0.005	0.013	130	260	0.044	0.010	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.016	0.017	0.005	0.010	90	190	0.030	0.009	130

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

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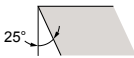
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E

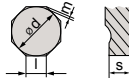
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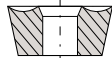
Shape



Clearance Angle



Tolerance
d ± 0.001
m ± 0.001
s ± 0.001



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3954421	OFER 070405 TN	LT 30	0.268	0.187	0.031	Right	●

- Stocking
- Non-stocking

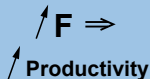
Face Milling Insert with 45° Lead Angle

Multi purpose 45° Milling insert with 8 cutting edges and flat rake surface.
Suitable for Roughing to Finishing-Face Milling,
Plunging and Ramping down operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



OFER 070405 TN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.176	0.009	0.020	620	1080	0.117	0.014	820
		2	1045, 1060,	190 HB		0.176		0.020		980			720
		3	28Mn6	250 HB		0.176		0.020		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.176	0.007	0.016	490	780	0.117	0.013	650
		4,6	Ck60, 4140, 4340,	230 HB		0.176		0.016		680			590
		5,7	100Cr6	280 HB		0.176		0.014		420			490
		8		350 HB		0.176		0.014		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.126	0.006	0.014	290	490	0.087	0.011	420
		10	H13, M42, D3,	280 HB		0.126		0.014		420			390
		11	S6-5-2, 12Ni19	320 HB		0.126		0.011		190			320
		11		350 HB		0.126		0.011		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.176	0.007	0.014	620	820	0.117	0.011	720
		14	X5CrNi18-9	240 HB		0.176		0.013		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.126	0.006	0.011	220	420	0.087	0.010	320
		14	S31500	310 HB		0.126		0.011		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.176	0.007	0.014	490	680	0.117	0.011	620
		13	17-4 PH, 430	42 HRC		0.126		0.013		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.176	0.009	0.020	490	720	0.117	0.014	650
		15	EN-GJL-250,	200 HB		0.176		0.020		620			590
		16	No30B	250 HB		0.176		0.020		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.176	0.007	0.018	320	590	0.117	0.013	590
		17,19	50005	200 HB		0.176		0.018		490			490
		18,20		250 HB		0.176		0.018		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.126	0.006	0.011	80	140	0.087	0.010	100
		33	Inconel 700	250 HB		0.126		0.011		140			90
		34	Stellite 21	350 HB		0.126		0.011		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.126	0.006	0.013	130	210	0.087	0.011	180
		37	T40	-		0.126		0.011		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.016	0.038	0.005	0.011	130	260	0.058	0.009	190
		38	440C,	50 HRC		0.038		0.010		220			180
		38	G-X260NiCr42	55 HRC		0.019		0.009		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.016	0.050	0.005	0.011	130	260	0.044	0.009	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.016	0.019	0.005	0.009	90	190	0.029	0.008	130
NI	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.176	0.009	0.020	650	1310	0.117	0.016	910

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

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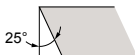
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M

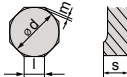
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Shape

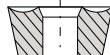


Clearance Angle



Tolerance

s ± 0.005
For l = 05, d ± 0.003 m ± 0.005
For l = 07, d ± 0.004 m ± 0.006



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3954431	OFMT 05T305 TN	LT 30	0.207	0.156	0.031	Right	●
3954441	OFMT 050405 TR	LT 30	0.217	0.187	0.021	Right	●
3954435	OFMT 070405 TN	LT 30	0.268	0.187	0.020	Right	●

Face Milling Insert with 45° Lead Angle

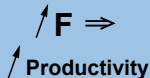
- Stocking
- Non-stocking

Multi purpose 45° Milling insert with 8 cutting edges and flat rake surface.
Suitable for Roughing to Finishing-Face Milling, Plunging and Ramping down operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



OFMT 05T305 TN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.138	0.009	0.020	620	1080	0.099	0.014	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.138	0.007	0.016	490	780	0.099	0.013	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.098	0.006	0.014	290	490	0.074	0.011	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.138	0.007	0.014	620	820	0.099	0.011	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 x2CrNiN23-4,	290 HB	0.020	0.098	0.006	0.011	220	420	0.074	0.010	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.138	0.007	0.014	490	680	0.099	0.011	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.138	0.009	0.020	490	780	0.099	0.014	650
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.138	0.007	0.018	320	590	0.099	0.013	590
		17,19	50005	200 HB									
		18,20		250 HB									
High Temp Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.098	0.006	0.011	80	140	0.074	0.010	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.098	0.006	0.013	130	210	0.074	0.011	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.016	0.030	0.005	0.010	130	220	0.037	0.008	180
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.016	0.039	0.005	0.011	130	260	0.037	0.009	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.016	0.015	0.005	0.009	90	190	0.025	0.008	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.138	0.009	0.020	650	1310	0.099	0.016	910

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

OFMT 050405 TR LT 30

Material Group	Cr. N#	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [Inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.020	0.138	0.009	0.020	620	0.099	0.014	820
		2	2	1045, 1060,	190 HB								
		3	3	28Mn6	250 HB								
	Low alloyed	2	6	42CrMo4, St50,	180 HB	0.020	0.138	0.007	0.016	490	0.099	0.013	650
		4,6	4	Ck60, 4140, 4340,	230 HB								
		5,7	5	100Cr6	280 HB								
		8	8		350 HB								
	High alloyed	3	10	X40CrMoV5,	220 HB	0.020	0.098	0.006	0.014	290	0.074	0.011	420
		10	10	H13, M42, D3,	280 HB								
		11	11	S6-5-2, 12Ni19	320 HB								
					350 HB								
Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.020	0.138	0.007	0.014	620	0.099	0.011	720
		14	14	X5CrNi18-9	240 HB								
	Duplex	5	14	X2CrNiN23-4,	290 HB	0.020	0.098	0.006	0.011	220	0.074	0.010	320
		14	14	S31500	310 HB								
	Ferritic & Martensitic	6	12	410, X6Cr17,	200 HB	0.020	0.138	0.007	0.014	490	0.099	0.011	620
		13	13	17-4 PH, 430	42 HRC								
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.020	0.138	0.009	0.020	490	0.099	0.014	650
		15	15	EN-GJL-250,	200 HB								
		16	16	No30B	250 HB								
	Malleable & Nodular	8	17,19	GG40, GGG70,	150 HB	0.020	0.138	0.007	0.018	320	0.099	0.013	590
		17,19	17,19	50005	200 HB								
		18,20	18,20		250 HB								
	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.098	0.006	0.011	80	0.074	0.010	100
		33	33	Inconel 700	250 HB								
		34	34	Stellite 21	350 HB								
	Ti based	10	36	TiAl6V4	-								
		37	37	T40	-								
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC	0.016	0.030	0.005	0.010	130	0.037	0.008	180
		38	38	440C,	50 HRC								
		38	38	G-X260NiCr42	55 HRC								
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.016	0.039	0.005	0.011	130	0.037	0.009	160
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.016	0.015	0.005	0.009	90	0.025	0.008	130
HP	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.138	0.009	0.020	650	0.099	0.016	910

OFMT 070405 TN LT 30

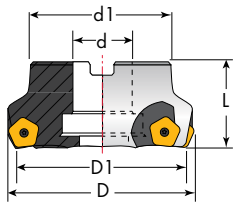
Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters					
					min	max	min	max	min	max	D.O.C.	Feed	V _c			
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB		0.176		0.020		1080	0.117	0.014	820		
		2	2	1045, 1060,	190 HB	0.020	0.176	0.009	0.020	620	980			720		
		3	3	28Mn6	250 HB				0.020		820			650		
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.176	0.007	0.016	490	780	0.117	0.013	850		
		4,6	230 HB		490					680	0.013			590		
		5,7	280 HB		420					620	0.011			490		
		8	350 HB		420					550	0.011			450		
	High alloyed	3	10	X40GrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.126	0.006	0.014	290	490	0.087	0.011	420		
		10	280 HB		290					420	0.011			390		
		11	320 HB		190					360	0.010			320		
					350 HB		0.126		0.011	190	290		0.010	260		
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.020	0.176	0.007	0.014	620	820	0.117	0.011	720		
			14		240 HB					520	680			620		
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.020	0.126	0.006	0.011	220	420	0.087	0.010	320		
			14		310 HB						390			290		
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.176	0.007	0.014	490	680	0.117	0.011	620		
			13		42 HRC					290	490			0.087	0.010	420
Cast Iron	Grey	7	15	GG40, EN-GJL-250, No30B	150 HB	0.020	0.176	0.009	0.020	490	720	0.117	0.014	590		
			16		250 HB						620			520		
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.176	0.007	0.018	320	590	0.117	0.013	490		
			17,19		200 HB						490			590		
			18,20		250 HB									420		
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.126	0.006	0.011	140		0.087	0.010	100		
			33		Inconel 700					250 HB	80			140	90	
			34		Stellite 21					350 HB				140	90	
	Ti based	10	36	TiAl6V4	-	0.020	0.126	0.006	0.013	130	210	0.087	0.011	180		
			37		T40					-				90	180	0.010
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.016	0.063	0.005	0.011	260		0.058	0.009	190		
			38		50 HRC					130	220			0.044	0.008	180
			38		55 HRC						190			0.029	0.008	160
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.016	0.050	0.005	0.011	130	260	0.044	0.009	160		
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.016	0.019	0.005	0.009	90	190	0.029	0.008	130		
WF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.176	0.009	0.020	650	1310	0.117	0.016	910		



Part No.	Description	Grade	l	s	r	Direction	Stock
3959999	PNEG 110512 R CM	152	0.213	0.219	0.047	Right	●

Cast Iron Cutter for PNEG 1105. See page 32.

- Stocking
- Non-stocking



Application Guide

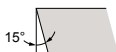
See the back of the box for speeds and feeds.



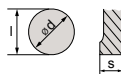
R D M T



Shape

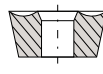


Clearance Angle



Tolerance

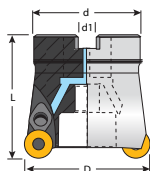
s ± 0.005
For l = 06/08/10, d ± 0.002
For l = 12, d ± 0.003


Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3355528	RDMT 0602 M0	LT 30	0.236	0.094	-	Neutral	●
3351882	RDMT 0702 M0	LT 30	0.276	0.094	-	Neutral	○
3355531	RDMT 0803 M0	LT 30	0.315	0.125	-	Neutral	●
3355533	RDMT 1003 M0	LT 30	0.394	0.125	-	Neutral	●
3355536	RDMT 10T3 M0	LT 30	0.394	0.156	-	Neutral	●
3355543	RDMT 12T3 M0	LT 30	0.472	0.156	-	Neutral	●
3355541	RDMT 1204 M0	LT 30	0.472	0.187	-	Neutral	●
3351881	RDMT 1604 M0	LT 30	0.630	0.187	-	Neutral	○

● Stocking ○ Non-stocking

Face Mill for RDMT.
See page 33.



Application Guide

Surfacing Insert Lead angle 90°



Pocket Milling



Copying

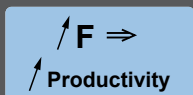


Facing

Multi purpose Round insert. Suitable for Roughing to Semi-Finishing Copying of 3D surfaces and Face Milling operations.

Face Milling Insert with 90° Lead Angle

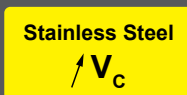
Machine Recommendations
Guide. Details on page 19.



Productivity



1, 2, 3, 4 No
7, 8, 11 No
10, 12 Yes
5, 6, 9 Yes



Stainless Steel

V_c



RDMT 0602 M0 LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.061	0.007	0.019	620	1080	0.031	0.011	820
		2	1045, 1060,	190 HB		0.061		0.019		980			720
		3	28Mn6	250 HB		0.061		0.019		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.061	0.006	0.015	490	780	0.031	0.010	650
		4,6	Ck60, 4140, 4340,	230 HB		0.061		0.015	490	680			590
		5,7	100Cr6	280 HB		0.061		0.013	420	620			490
		8		350 HB		0.061		0.013	420	550			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.043	0.005	0.013	290	490	0.024	0.009	420
		10	H13, M42, D3,	280 HB		0.043		0.013	290	420			390
		11	S6-5-2, 12Ni19	320 HB		0.043		0.011	190	360			320
		11		350 HB		0.043		0.011	190	290			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.061	0.006	0.015	620	820	0.031	0.010	720
		14	X5CrNi18-9	240 HB		0.061	0.005	0.013	520	680			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.048	0.005	0.011	220	420	0.024	0.008	320
		14	S31500	310 HB		0.048		0.011		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.061	0.006	0.015	490	680	0.031	0.010	620
		13	17-4 PH, 430	42 HRC		0.048		0.012	290	490			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.061	0.007	0.019	490	780	0.031	0.011	650
		15	EN-GJL-250,	200 HB		0.061		0.019		720			590
		16	No30B	250 HB		0.061		0.019		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.061	0.006	0.017	320	650	0.031	0.010	590
		17,19	50005	200 HB		0.061		0.017		590			490
		18,20		250 HB		0.061		0.017		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.048	0.005	0.011	80	140	0.024	0.008	100
		33	Inconel 700	250 HB		0.048		0.011		140			90
		34	Stellite 21	350 HB		0.048		0.011		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.048	0.005	0.012	130	210	0.024	0.009	180
		37	T40	-		0.048		0.011	90	180			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.012	0.022	0.004	0.011	130	260	0.016	0.007	190
		38	440C,	50 HRC		0.017		0.009		220			180
		38	G-X260NiCr42	55 HRC		0.015		0.008		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.017	0.004	0.011	130	260	0.012	0.007	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.012	0.015	0.004	0.008	90	190	0.010	0.006	130
Al	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.061	0.007	0.019	650	1310	0.031	0.012	910

RDMT 0702 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [Inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.072	0.007	0.021	620	1080	0.031	0.013	820
		2		190 HB									720
		3		250 HB									650
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.072	0.006	0.017	490	780	0.031	0.011	650
				230 HB									590
				280 HB									490
				350 HB									450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.051	0.005	0.015	290	490	0.024	0.010	420
				280 HB									390
				320 HB									320
				350 HB									260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	220 HB	0.020	0.072	0.006	0.017	620	820	0.031	0.011	720
				240 HB									620
	Duplex	5	14 X2CrNiN23-4, 14 S31500	290 HB	0.020	0.056	0.005	0.012	220	420	0.024	0.009	320
				310 HB									290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.072	0.006	0.017	490	680	0.031	0.011	620
				42 HRc									420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.072	0.007	0.021	490	720	0.031	0.013	650
				200 HB									590
				250 HB									520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005	150 HB	0.020	0.072	0.006	0.019	320	590	0.031	0.011	490
				200 HB									420
				250 HB									100
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.056	0.005	0.012	80	140	0.024	0.009	90
				250 HB									90
				350 HB									90
	Ti based	10	36 TiAl6V4	-	0.020	0.056	0.005	0.013	130	210	0.024	0.010	180
			37 T40	-									130
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRc	0.012	0.020	0.004	0.011	130	220	0.012	0.007	190
				50 HRc									180
				55 HRc									160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.012	0.020	0.004	0.012	130	260	0.012	0.008	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.012	0.018	0.004	0.009	90	190	0.010	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.072	0.007	0.021	650	1310	0.031	0.014	910

RDMT 0803 M0 LT 30

Material Group	Gr. #	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.077	0.007	0.023	620	1080	0.031	0.014	820
		2	1045, 1060,	190 HB		0.077		0.023		980			720
		3	28Mn6	250 HB		0.077		0.023		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.077	0.006	0.018	490	780	0.031	0.012	650
		4,6	42CrMo4, St50,	230 HB		0.077		0.018		680			590
		5,7	Ck60, 4140, 4340,	280 HB		0.077		0.016		620			490
		8	100Cr6	350 HB		0.077		0.016		550			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.055	0.005	0.016	290	490	0.024	0.011	420
		10	H13, M42, D3,	280 HB		0.055		0.016		420			390
		11	S6-5-2, 12Ni19	320 HB		0.055		0.013		360			320
		11		350 HB		0.055		0.013		290			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.077	0.006	0.018	620	820	0.031	0.012	720
		14	X5CrNi18-9	240 HB		0.077		0.016		680			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.061	0.005	0.013	220	420	0.024	0.009	320
		14	S31500	310 HB		0.061		0.013		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.077	0.006	0.018	490	680	0.031	0.012	620
		13	17-4 PH, 430	42 HRC		0.061		0.014		490			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.077	0.007	0.023	490	780	0.031	0.014	650
		15	EN-GJL-250,	200 HB		0.077		0.023		720			590
		16	No30B	250 HB		0.077		0.023		620			520
	Malleable & Nodular	8	17,19 GG40, GG70,	150 HB	0.020	0.077	0.006	0.020	320	590	0.031	0.012	590
		17,19	50005	200 HB		0.077		0.020		590			490
		18,20		250 HB		0.077		0.020		490			420
High Temp Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.061	0.005	0.013	80	140	0.024	0.009	100
		33	Inconel 700	250 HB		0.061		0.013		140			90
		34	Stellite 21	350 HB		0.061		0.013		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.061	0.005	0.014	130	210	0.024	0.011	180
		37	T40	-		0.061		0.013		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.012	0.028	0.004	0.013	130	260	0.016	0.008	190
		38	440C,	50 HRC		0.022		0.011		220			180
		38	G-X260NiCr42	55 HRC		0.019		0.010		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.022	0.004	0.013	130	260	0.012	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.012	0.019	0.004	0.010	90	190	0.010	0.007	130
	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.077	0.007	0.023	650	1310	0.031	0.015	910

RDMT 1003 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.099	0.007	0.025	620	1080	0.039	0.014	820
		2		190 HB		0.099		0.025		980			720
		3		250 HB		0.099		0.025		820			650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.099	0.006	0.020	490	780	0.039	0.012	650
		4,6		230 HB		0.099		0.020		680			590
		5,7		280 HB		0.099		0.017		420			490
		8		350 HB		0.099		0.017		420			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.071	0.005	0.017	290	490	0.030	0.011	420
		10		280 HB		0.071		0.017		420			390
		11		320 HB		0.071		0.014		360			320
		11		350 HB		0.071		0.014		290			260
Stainless Steel	Austenitic	4	14 304, 316, X5CrNi18-9	180 HB	0.020	0.099	0.006	0.020	620	820	0.039	0.012	720
		14		240 HB		0.099		0.017		520			620
	Duplex	5	14 X2CrNiN23-4, S31500	290 HB	0.020	0.078	0.005	0.014	220	420	0.030	0.009	320
		14		310 HB		0.078		0.014		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.099	0.006	0.020	490	680	0.039	0.012	620
		13		42 HRc		0.078		0.016		290			420
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.099	0.007	0.025	490	780	0.039	0.014	650
		15		200 HB		0.099		0.025		720			590
		16		250 HB		0.099		0.025		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, S0005	150 HB	0.020	0.099	0.006	0.022	320	590	0.039	0.012	590
		17,19		200 HB		0.099		0.022		590			490
		18,20		250 HB		0.099		0.022		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.078	0.005	0.014	80	140	0.030	0.009	100
		33		250 HB		0.078		0.014		140			90
		34		350 HB		0.078		0.014		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.078	0.005	0.016	130	210	0.030	0.011	180
		37		T40		0.078		0.014		90			130
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.012	0.035	0.004	0.014	130	260	0.020	0.008	190
		38		50 HRc		0.028		0.013		220			180
		38		55 HRc		0.025		0.011		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.028	0.004	0.014	130	260	0.015	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.012	0.025	0.004	0.011	90	190	0.010	0.007	130
NP	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.099	0.007	0.025	650	1310	0.039	0.015	910



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TECHNICAL SOLUTIONS

RDMT 1204 M0 LT 30

Material Group	Gr. #	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.119	0.010	0.029	620	1080	0.052	0.014	820
		2	1045, 1060,	190 HB		0.119		0.029		980			720
		3	28Mn6	250 HB		0.119		0.029		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.119	0.008	0.023	490	780	0.052	0.012	650
		4,6	42CrMo4, St50,	230 HB		0.119		0.023		680			590
		5,7	Ck60, 4140, 4340,	280 HB		0.119		0.020		420			490
		8	100Cr6	350 HB		0.119		0.020		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.085	0.007	0.020	290	490	0.039	0.011	420
		10	H13, M42, D3,	280 HB		0.085		0.020		420			390
		11	S6-5-2, 12Ni19	320 HB		0.085		0.016		190			320
		11		350 HB		0.085		0.016		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.119	0.008	0.023	620	820	0.052	0.012	720
		14	X5CrNi18-9	240 HB		0.119		0.020		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.093	0.007	0.016	220	420	0.039	0.009	320
		14	S31500	310 HB		0.093		0.016		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.119	0.008	0.023	490	680	0.052	0.012	620
		13	17-4 PH, 430	42 HRc		0.093		0.018		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.119	0.010	0.029	490	780	0.052	0.014	650
		15	EN-GJL-250,	200 HB		0.119		0.029		720			590
		16	No30B	250 HB		0.119		0.029		620			520
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.119	0.008	0.025	320	590	0.052	0.012	490
		17,19	50005	200 HB		0.119		0.025		490			420
		18,20		250 HB		0.119		0.025		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.093	0.007	0.016	80	140	0.039	0.009	100
		33	Inconel 700	250 HB		0.093		0.016		140			90
		34	Stellite 21	350 HB		0.093		0.016		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.093	0.007	0.018	130	210	0.039	0.011	180
		37	T40	-		0.093		0.016		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.012	0.034	0.006	0.014	130	260	0.026	0.008	190
		38	440C,	50 HRc		0.034		0.014		220			180
		38	G-X260NiCr42	55 HRc		0.030		0.013		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.034	0.006	0.016	130	260	0.019	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.012	0.030	0.006	0.013	90	190	0.013	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.119	0.010	0.029	650	1310	0.052	0.015	910

RDMT 10T3 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.099	0.007	0.025	620	1080	0.039	0.014	820
		2	1045, 1060,	190 HB		0.099		0.025		980			720
		3	28Mn6	250 HB		0.099		0.025		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.099	0.006	0.020	490	780	0.039	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB		0.099		0.020		680			590
		5,7	100Cr6	280 HB		0.099		0.017		420			490
		8		350 HB		0.099		0.017		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.071	0.005	0.017	290	490	0.030	0.011	420
		10	H13, M42, D3,	280 HB		0.071		0.017		420			390
		11	S6-5-2, 12Ni19	320 HB		0.071		0.014		190			320
		11		350 HB		0.071		0.014		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.099	0.005	0.020	620	820	0.039	0.012	720
		14	X5CrNi18-9	240 HB		0.099		0.017		680			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.078	0.005	0.014	220	420	0.030	0.009	320
		14	S31500	310 HB		0.078		0.014		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.099	0.006	0.020	490	680	0.039	0.012	620
		13	17-4 PH, 430	42 HRc		0.078		0.016		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.099	0.007	0.025	490	780	0.039	0.014	650
		15	EN-GJL-250, No30B	200 HB		0.099		0.025		720			590
		16		250 HB		0.099		0.025		620			520
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.099	0.006	0.022	320	590	0.039	0.012	490
		17,19	50005	200 HB		0.099		0.022		490			420
		18,20		250 HB		0.099		0.022		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.078	0.005	0.014	80	140	0.030	0.009	100
		33	Inconel 700	250 HB		0.078		0.014		140			90
		34	Stellite 21	350 HB		0.078		0.014		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.078	0.005	0.016	130	210	0.030	0.011	180
		37	T40	-		0.078		0.014		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.012	0.035	0.004	0.014	130	260	0.020	0.008	190
		38	440C,	50 HRc		0.028		0.013		220			180
		38	G-X260NiCr42	55 HRc		0.025		0.011		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.028	0.004	0.014	130	260	0.015	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.012	0.025	0.004	0.011	90	190	0.010	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.099	0.007	0.025	650	1310	0.039	0.015	910



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RDMT 12T3 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.119	0.010	0.029	620	1080	0.052	0.014	820
		2	1045, 1060,	190 HB		0.119		0.029		980			720
		3	28Mn6	250 HB		0.119		0.029		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.119	0.008	0.023	490	780	0.052	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB		0.119		0.023	490	680			590
		5,7	100Cr6	280 HB		0.119		0.020	420	620			490
		8		350 HB		0.119		0.020	420	550			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.085	0.007	0.020	290	490	0.039	0.011	420
		10	H13, M42, D3,	280 HB		0.085		0.020	290	420			390
		11	S6-5-2, 12Ni19	320 HB		0.085		0.016	190	360			320
		11		350 HB		0.085		0.016	190	290			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.119	0.008	0.023	620	820	0.052	0.012	720
		14	X5CrNi18-9	240 HB		0.119	0.007	0.020	520	680			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.093	0.007	0.016	220	420	0.039	0.009	320
		14	S31500	310 HB		0.093		0.016	390	390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.119	0.008	0.023	490	680	0.052	0.012	620
		13	17-4 PH, 430	42 HRc		0.093		0.018	290	490			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.119	0.010	0.029	490	780	0.052	0.014	650
		15	EN-GJL-250,	200 HB		0.119		0.029	490	720			590
		16	No30B	250 HB		0.119		0.029	620	620			520
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.119	0.008	0.025	320	590	0.052	0.012	490
		17,19	50005	200 HB		0.119		0.025	320	590			490
		18,20		250 HB		0.119		0.025	490	490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.093	0.007	0.016	80	140	0.039	0.009	100
		33	Inconel 700	250 HB		0.093		0.016	80	140			90
		34	Stellite 21	350 HB		0.093		0.016	140	140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.093	0.007	0.018	130	210	0.039	0.011	180
		37	T40	-		0.093		0.016	90	180			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.012	0.034	0.006	0.014	130	220	0.013	0.007	160
		38	440C,	50 HRc		0.034		0.014	130	220			180
		38	G-X260NiCr42	55 HRc		0.030		0.013	190	190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.034	0.006	0.016	130	260	0.019	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.012	0.030	0.006	0.013	90	190	0.013	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.119	0.010	0.029	650	1310	0.052	0.015	910

RDMT 1604 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.157	0.010	0.039	620	980	0.079	0.014	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.157	0.038	0.031	490	780	0.079	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.112	0.007	0.027	290	420	0.059	0.011	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.157	0.008	0.031	620	820	0.079	0.012	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.123	0.007	0.022	220	420	0.059	0.009	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.157	0.008	0.031	490	680	0.079	0.012	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.157	0.010	0.039	490	720	0.079	0.014	590
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.157	0.008	0.035	320	590	0.079	0.012	490
		17,19	50005	200 HB									
		18,20		250 HB									
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.123	0.007	0.022	80	140	0.059	0.009	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.123	0.007	0.025	130	210	0.059	0.011	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.016	0.045	0.006	0.020	130	220	0.030	0.008	190
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.016	0.045	0.006	0.022	130	260	0.030	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.016	0.039	0.006	0.017	90	190	0.020	0.007	130
HP	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.157	0.010	0.039	650	1310	0.079	0.015	910



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TECHNICAL SOLUTIONS



R

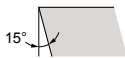
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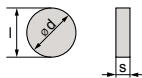
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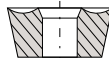
Shape



Clearance Angle



Tolerance
 $d \pm 0.002$
 $s \pm 0.005$



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3355546	RDMW 10T3 M0	LT 30	-	0.156	-	Neutral	●
3355548	RDMW 1204 M0	LT 30	-	0.187	-	Neutral	●

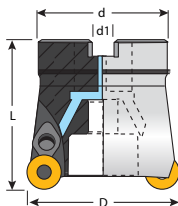
● Stocking

Face Milling Insert with 90° Lead Angle

○ Non-stocking

Multi purpose Round insert with flat rake surface, designed for Hard materials.
Suitable for Roughing to Semi-Finishing Copying of 3D surfaces
and Face Milling operations.

Face Mill for RDMT.
See page 33.



Application Guide



Pocket Milling

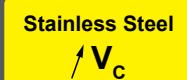
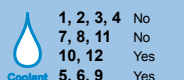
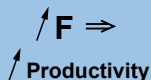


Copying



Facing

Machine Recommendations
Guide. Details on page 19.



RDMW 10T3 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.099	0.007	0.028	620	1080	0.039	0.015	820
		2		190 HB		0.099		0.028		990			720
		3		250 HB		0.099		0.028		820			650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.099	0.006	0.022	490	780	0.039	0.013	650
		4,6		230 HB		0.099		0.022		680			590
		5,7		280 HB		0.099		0.019		420			490
		8		350 HB		0.099		0.019		420			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.071	0.005	0.019	290	490	0.030	0.012	420
		10		280 HB		0.071		0.019		420			390
		11		320 HB		0.071		0.016		360			320
		11		350 HB		0.071		0.016		290			260
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No308	150 HB	0.020	0.099	0.007	0.028	490	780	0.039	0.015	650
		15		200 HB		0.099		0.028		720			590
		16		250 HB		0.099		0.028		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 50005	150 HB	0.020	0.099	0.006	0.024	320	650	0.039	0.013	590
		18,20		250 HB		0.099		0.024		490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.012	0.035	0.004	0.016	130	260	0.020	0.009	190
		38		50 HRc		0.028		0.014		220			180
		38		55 HRc		0.025		0.012		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.028	0.004	0.016	130	260	0.015	0.009	160
	White Cast Iron	41	G-X300Cr/Mo15	55 HRc	0.012	0.025	0.004	0.012	90	190	0.010	0.008	130

RDMW 1204 M0 LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.119	0.007	0.029	620	980	0.052	0.015	820
		2		190 HB		0.119		0.029		820			720
		3		250 HB		0.119		0.029					650
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.119	0.006	0.023	490	780	0.052	0.013	650
				230 HB		0.119		0.023	490	680		0.013	590
				280 HB		0.119		0.020	420	620		0.012	490
				350 HB		0.119		0.020	420	550		0.012	450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.085	0.005	0.020	290	490	0.039	0.012	420
				280 HB		0.085		0.020	290	420		0.012	390
				320 HB		0.085		0.016	190	360		0.011	320
				350 HB		0.085		0.016	190	290		0.011	260
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.119	0.007	0.029	490	720	0.052	0.015	650
				200 HB		0.119		0.029		620			590
				250 HB		0.119		0.029					520
	Malleable & Nodular	8	17,19 GGG40, GG670, 17,19 50005	150 HB	0.020	0.119	0.006	0.025	320	590	0.052	0.013	590
			18,20	200 HB		0.119		0.025		490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRc	0.012	0.042	0.004	0.016	130	220	0.026	0.009	190
				50 HRc		0.034		0.014		190	0.019	0.009	180
				55 HRc		0.030		0.013			0.013	0.008	160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.012	0.034	0.004	0.016	130	260	0.019	0.009	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.012	0.030	0.004	0.013	90	190	0.013	0.008	130



R

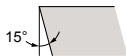
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M

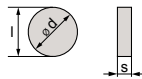
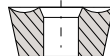
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Shape



Clearance Angle

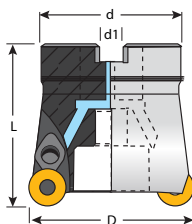

Tolerance
d ± 0.002
s ± 0.005

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3351552	RDMX 10T3 M0	LT 30	0.394	0.156	-	Neutral	○
3355549	RDMX 1204 M0	LT 30	0.472	0.187	-	Neutral	●

Face Milling Insert with 90° Lead Angle

- Stocking
- Non-stocking

Face Mill for RDMT.
See page 33.



Multi purpose Round insert. Suitable for Roughing to Semi-Finishing Copying of 3D surfaces and Face Milling operations.

Application Guide



Pocket Milling

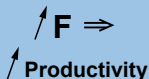


Copying



Facing

Machine Recommendations
Guide. Details on page 19.



Stainless Steel



RDMX 10T3 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.099	0.007	0.025	1080	0.039	0.014	820	720
		2	1045, 1060, 28Mn6	190 HB		0.099		0.025	620				
		3		250 HB		0.099		0.025	820				
	Low alloyed	6	42CrMo4, St50,	180 HB	0.020	0.099	0.006	0.020	490	0.039	0.012	650	590
		4,6	H13, M42, D3,	230 HB		0.099		0.020	490				
		5,7	Ck60, 4140, 4340,	280 HB		0.099		0.017	420				
		8	100Cr6	350 HB		0.099		0.017	420				
	High alloyed	10	X40CrMoV5,	220 HB	0.020	0.071	0.005	0.017	290	0.030	0.011	420	390
		10	H13, M42, D3,	280 HB		0.071		0.017	290				
		11	S6-5-2, 12Ni19	320 HB		0.071		0.014	190				
		11		350 HB		0.071		0.014	190				
		11				0.071		0.014	190				
Stainless Steel	Austenitic	4	304, 316,	180 HB	0.020	0.099	0.006	0.020	620	0.039	0.012	720	620
		14	X5CrNi18-9	240 HB		0.099		0.017	520				
	Duplex	5	X2CrNiN23-4,	290 HB	0.020	0.078	0.005	0.014	220	0.030	0.009	320	290
		14	S31500	310 HB		0.078		0.014	390				
	Ferritic & Martensitic	6	410, X6Cr17,	200 HB	0.020	0.099	0.006	0.020	490	0.039	0.012	620	420
		13	17-4 PH, 430	42 HRC		0.078		0.016	290				
Cast Iron	Grey	7	GG20, GG40,	150 HB	0.020	0.099	0.007	0.025	780	0.039	0.014	650	590
		15	EN-GJL-250,	200 HB		0.099		0.025	490				
		16	No30B	250 HB		0.099		0.025	620				
	Malleable & Nodular	8	GGG40, GGG70,	150 HB	0.020	0.099	0.006	0.022	650	0.039	0.012	490	420
		17,19	50005	200 HB		0.099		0.022	320				
		18,20		250 HB		0.099		0.022	490				
	Fe, Ni & Co based	9	31,32 Incoyl 800	240 HB	0.020	0.078	0.005	0.014	140	0.030	0.009	100	90
		33	Inconel 700	250 HB		0.078		0.014	80				
		34	Stellite 21	350 HB		0.078		0.014	140				
		10	36 TiAl6V4	-		0.078		0.016	130				
		37	T40	-		0.078		0.014	90				
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.012	0.035	0.004	0.014	260	0.020	0.008	190	180
		38	440C,	50 HRC		0.028		0.013	130				
		38	G-X260NiCr42	55 HRC		0.025		0.011	190				
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.012	0.028	0.004	0.014	130	0.015	0.008	160	130
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.012	0.025	0.004	0.011	90	0.010	0.007	130	910
NP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.099	0.007	0.025	650	1310	0.039	0.015	910

RDMX 1204 M0 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters									
					min	max	min	max	min	max	D.O.C.	Feed	V _c							
Steel	Non-alloyed	1	C35, Ck45, 1020,	125 HB	0.020	0.119	0.010	0.029	620	980	0.052	0.014	820							
		2	1045, 1060,	190 HB										0.029						
		3	28Mn6	250 HB																
	Low alloyed	2	6	42CrMo4, St50,	180 HB	0.020	0.119	0.008	0.023	490	780	0.052	0.012	650						
		4,6	230 HB																	
		5,7	Ck60, 4140, 4340,	280 HB	0.020										420	620				
		8	100Cr6	350 HB													0.020	420	550	
	High alloyed	3	10	X40CrMoV5,	220 HB	0.020	0.085	0.007	0.020	290	420	0.039	0.011	420						
		10	H13, M42, D3,	280 HB	0.085										0.016	190	360			
		11	S6-5-2, 12Ni19	320 HB														0.016	190	290
		11	350 HB	0.085																
Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.020	0.119	0.008	0.023	620	820	0.052	0.012	720						
		14	X5CrNi18-9	240 HB	0.020										0.119	0.007	0.020	520	680	
	Duplex	5	14	X2CrNiN23-4,		290 HB	0.020	0.093	0.007	0.016	220	420	0.039	0.009						320
		14	S31500	310 HB	0.093	0.016									390					
	Ferritic & Martensitic	6	12	410, X6Cr17,			200 HB	0.020	0.119	0.008	0.023	490	680	0.052		0.012	620			
		13	17-4 PH, 430	42 HRC	0.093	0.018	290								490					
Cast Iron	Grey	7	15	GG20, GG40,				150 HB	0.020	0.119	0.010	0.029	490	720		0.052	0.014	650		
		15	EN-GJL-250,	200 HB	0.029															
		16	No308	250 HB		0.029														
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB		0.020	0.119	0.008	0.025	320	590	0.052	0.012	490					
		17,19	50005	200 HB	0.025															
		18,20	250 HB	0.119		0.025										490				
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.093	0.007	0.016	80	140	0.039	0.009	100						
		33	Inconel 700	250 HB	0.093															
		34	Stellite 21	350 HB											0.016					
	Ti based	10	36	TiAl6V4	-	0.020	0.093	0.007	0.018	130	210	0.039	0.011	180						
		37	T40	-	0.016										90	180				
	Hardened Mat.	Steel	11	38		X100CrMo13,	45 HRC	0.012	0.034	0.006	0.014	130	220	0.019			0.008	180		
38			440C,	50 HRC	0.030															
38			G-X260NiCr42	55 HRC		0.013														
Chilled Cast Iron			40	Ni-Hard 2	400 HB		0.012	0.034	0.006	0.016	130	260	0.019	0.008	160					
White Cast Iron			41	G-X300CrMo15	55 HRC	0.012	0.030	0.006	0.013	90	190	0.013	0.007	130						
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.119	0.010	0.029	650	1310	0.052	0.015	910						

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT



S

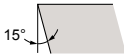
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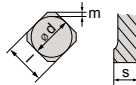
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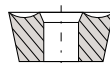
Shape



Clearance Angle



Tolerance
d ± 0.003
m ± 0.0005
s ± 0.0001



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3254411	SDKT 1204 AETN	LT 30	0.500	0.187	-	Neutral	●

- Stocking
- Non-stockings

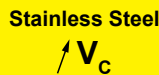
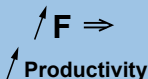
Face Milling Insert with 45° Lead Angle

Multi purpose 45° Milling insert, designed for high depths of cut. Suitable for Roughing to Finishing-Face Milling, Plunging and Ramping down Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



SDKT 1204 AETN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 23Mn5	125 HB	0.020	0.276	0.007	0.021	620	1080	0.118	0.015	820
		2		190 HB									720
		3		250 HB									650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.276	0.006	0.016	490	780	0.118	0.013	650
		4,6		230 HB									590
		5,7		280 HB									490
		8		350 HB									450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.197	0.005	0.014	290	490	0.089	0.012	420
		10		280 HB									390
		11		320 HB									320
		11		350 HB									260
Stainless Steel	Austenitic	4	14 304, 316, X5CrNi18-9	180 HB	0.020	0.276	0.006	0.014	620	820	0.118	0.012	720
		14		240 HB									620
	Duplex	5	14 X2CrNiN23-4, S31500	290 HB	0.020	0.197	0.005	0.012	220	420	0.089	0.011	320
		14		310 HB									290
	Ferritic & Martensitic	6	12 410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.276	0.006	0.014	490	680	0.118	0.012	620
		13		42 HRC									420
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.276	0.007	0.021	490	720	0.118	0.015	590
		15		200 HB									520
		16		250 HB									520
	Malleable & Nodular	8	17,19 GG40, GG670, 50005	150 HB	0.020	0.276	0.006	0.018	320	590	0.118	0.013	590
		17,19		200 HB									490
		18,20		250 HB									420
	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.012	80	140	0.089	0.011	100
		33	Inconel 700	250 HB									90
		34	Stellite 21	350 HB									90
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.013	130	210	0.089	0.012	180
		37	T40	-									130
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.020	0.098	0.004	0.012	130	260	0.059	0.009	190
		38		50 HRC									180
		38		55 HRC									160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.012	130	260	0.044	0.009	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.009	90	190	0.030	0.008	130
NP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.276	0.007	0.021	650	1310	0.118	0.017	910



S D K X

Part No.	Description	Grade	l	s	r	Pr. R.	Direction	Stock
2503095	SDKX 0904 HF	LT 30	0.375	0.187	0.031	0.031	Neutral	●
2503096	SDKX 1205 HF	LT 30	0.500	0.219	0.031	0.031	Neutral	●

- Stocking
- Non-stocking

Face Mills coming early 2014.
End Mills coming late 2014.

Pr. R. = Programming Radius

Application Guide



SDKX 0904 HF LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [Inch/tooth]		V _c [sfm]		Suggested Starting Parameters	
					min	max	min	max	min	max	D.O.C.	Feed V _c
Steel	Non-alloyed	1	1	C35, Ck45, 125 HB		0.059		0.079		1080		820
		2	2	1020, 1045, 190 HB	0.020	0.059	0.012	0.079	620	980	0.059	0.071 720
		3	3	1060, 28Mn6 250 HB		0.059		0.079		820		650
	Low alloyed	2	6	42CrMo4, St50, 180 HB		0.055		0.071	490	780		0.067 650
		4,6	4	Ck60, 4140, 230 HB	0.020	0.055	0.012	0.071	490	680	0.055	0.067 590
		5,7	7	4340, 100Cr6 280 HB		0.055		0.071	420	620		0.067 490
		8	8	350 HB		0.055		0.071	420	550		0.067 450
	High alloyed	3	10	X40CrMoV5, 220 HB		0.051		0.063	290	490		0.059 420
		10	10	H13, M42, D3, 280 HB	0.020	0.051	0.012	0.063	290	420	0.051	0.059 390
		11	11	S6-5-2, 12Ni19 320 HB		0.051		0.063	190	360		0.059 320
		11	11	350 HB		0.051		0.063	190	290		0.059 260
Stainless Steel	Austenitic	4	14	304, 316, 180 HB	0.020	0.047	0.012	0.055	620	820	0.047	0.047 720
		14	14	X5CrNi18-9 240 HB		0.047	0.012	0.055	520	680		620
	Duplex	5	14	X2CrNiN23-4, 290 HB	0.020	0.035	0.012	0.035	220	420	0.035	0.031 320
		14	14	S31500 310 HB		0.035		0.035		390		290
	Ferritic & Martensitic	6	12	410, X6Cr17, 200 HB	0.020	0.047	0.012	0.039	490	680	0.047	0.035 620
		13	13	17-4 PH, 430 42 HRC		0.039		0.031	290	490	0.039	0.028 420
Cast Iron	Grey	7	15	GG20, GG40, 150 HB		0.059		0.079		780		650
		15	15	EN-GJL-250, 200 HB	0.020	0.059	0.012	0.079	490	720	0.059	0.071 590
		16	16	No30B 250 HB		0.059		0.079		620		520
	Malleable & Nodular	8	8	GGG40, GGG70, 150 HB		0.059		0.071		650		590
		9	9	50005 200 HB	0.020	0.059	0.012	0.071	320	590	0.059	0.063 490
		10	10	250 HB		0.059		0.071		490		420
High Temp. Alloys	Fe, Ni & Co based	9	32	Incoloy 800 240 HB		0.051		0.031		140		100
		33	33	Inconel 700 250 HB	0.020	0.051	0.012	0.031	80	140	0.051	0.024 90
		34	34	Stellite 21 350 HB		0.051		0.031		140		90
	Ti based	10	36	TiAl6V4 -	0.020	0.051	0.012	0.028	130	210	0.051	0.024 180
		37	37	-		0.051		0.028	90	180		0.024 130
		37	37	-		0.051		0.028	90	180		0.024 130
Hardened Mat.	Steel	11	38	X100CrMo13, 45 HRC		0.047		0.047		260	0.047	0.039 190
		38	38	440C, 50 HRC	0.012	0.039	0.012	0.039	130	220	0.039	0.035 180
		38	38	G-X260NiCr42 55 HRC		0.035		0.031		190	0.035	0.031 160
		40	40	Ni-Hard 2 400 HB	0.012	0.039	0.012	0.031	130	260	0.039	0.031 160
		41	41	G-X300CrMo15 55 HRC	0.012	0.035	0.012	0.031	90	190	0.035	0.031 130
W	Al (>8%Si)	12	25	AlSi12 130 HB	0.020	0.059	0.012	0.071	650	1310	0.059	0.063 910

SDKX 1205 HF LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1	C35, Ck45, 125 HB		0.098		0.118		1080			
		2	2	1020, 1045, 190 HB	0.020	0.098	0.012	0.118	620	980	0.098	0.102	720
		3	3	1060, 28Mn6 250 HB		0.098		0.118		820			650
	Low alloyed	2	6	42CrMo4, St50, 180 HB		0.087		0.110	490	780		0.094	650
		4,6	4	Ck60, 4140, 230 HB	0.020	0.087	0.012	0.110	490	680	0.087	0.094	590
		5,7	7	4340, 100Cr6 280 HB		0.087		0.110	420	620		0.087	490
		8	8	350 HB		0.087		0.110	420	550		0.087	450
	High alloyed	3	10	X40CrMoV5, 220 HB		0.079		0.098	290	490		0.079	420
		10	10	H13, M42, D3, 280 HB	0.020	0.079	0.012	0.098	290	420	0.079	0.079	390
		11	11	S6-5-2, 12Ni19 320 HB		0.079		0.098	190	360		0.071	320
		11	11	350 HB		0.079		0.098	190	290		0.071	260
Stainless Steel	Austenitic	4	14	304, 316, 180 HB	0.020	0.079	0.012	0.059	620	820	0.079	0.047	720
		14	14	X5CrNi18-9 240 HB		0.079	0.012	0.059	520	680			620
	Duplex	5	14	X2CrNiN23-4, 290 HB	0.020	0.079	0.012	0.039	220	420	0.079	0.031	320
		14	14	S31500 310 HB		0.079		0.039	220	390			290
	Ferritic & Martensitic	6	12	410, X6Cr17, 200 HB	0.020	0.079	0.012	0.047	490	680	0.079	0.031	620
		13	13	17-4 PH, 430 42 HRC		0.079		0.039	290	490	0.079	0.028	420
Cast Iron	Grey	7	15	GG20, GG40, 150 HB		0.098		0.118		780			650
		15	15	EN-GJL-250, 200 HB	0.020	0.098	0.012	0.118	490	720	0.098	0.102	590
		16	16	No30B 250 HB		0.098		0.118		620			520
	Malleable & Nodular	8	17,18	GGG40, GGG70, 150 HB		0.098		0.098		650			590
		18,19	19	50005 200 HB	0.020	0.098	0.012	0.098	320	590	0.098	0.079	490
		19,20	20	250 HB		0.098		0.098		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800 240 HB		0.059		0.035		140			100
		33	33	Inconel 700 250 HB	0.020	0.059	0.012	0.035	80	140	0.059	0.028	90
		34	34	Stellite 21 350 HB		0.059		0.035		140			90
	Ti based	10	36	TiAl6V4 -	0.020	0.059	0.012	0.031	130	210	0.059	0.024	180
		37	37	T40 -		0.059		0.031	90	180		0.024	130
		37	37	-		0.059		0.031	90	180			130
Hardened Mat.	Steel	11	38	X100CrMo13, 45 HRC		0.055		0.055		260	0.055	0.047	190
		38	38	440C, 50 HRC	0.012	0.047	0.012	0.047	130	220	0.047	0.039	180
		38	38	G-X260NiCr42 55 HRC		0.039		0.039		190	0.039	0.035	160
		40	40	Ni-Hard 2 400 HB	0.012	0.047	0.012	0.035	130	260	0.047	0.031	160
		41	41	G-X300CrMo15 55 HRC	0.012	0.039	0.012	0.035	90	190	0.039	0.031	130
Wt	AI (>8%Si)	12	25	AlSi12 130 HB	0.020	0.118	0.012	0.079	650	1310	0.098	0.063	910



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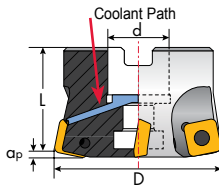
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SEGT

Part No.	Description	Grade	l	s	r	Direction	Pr. R.	Stock
3253310	SDMT 09T312 DM	202	0.375	0.156	0.047	Neutral	0.098	•
3253320	SDMT 120412 DM	202	0.500	0.187	0.047	Neutral	0.157	•

High Feed Face Mill for SDMT 09T312 & 120412. See page 35.

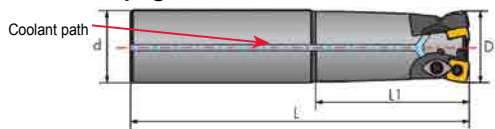


• Stocking

○ Non-stocking

Pr. R. = Programming Radius

High Feed Indexable End Mill for SDMT. See page 46.



Application Guide

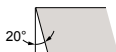
See the back of the box for speeds and feeds.



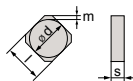
SEKN



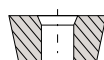
Shape



Clearance Angle

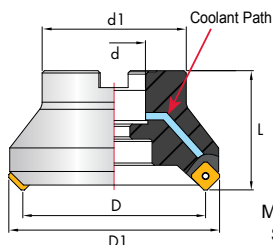


Tolerance
 $m \pm 0.0005$
 $s \pm 0.001$
 For $l = 12$, $d \pm 0.003$
 For $l = 15$, $d \pm 0.004$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3254415	SEKN 42 AFTN (ANSI) SEKN 1203 AFTN (ISO)	LT 30	0.500	0.125	-	Neutral	•
3254417	SEKN 43 AFTN (ANSI) SEKN 1204 AFTN (ISO)	LT 30	0.500	0.187	-	Neutral	•
3254421	SEKN 53 AFTN (ANSI) SEKN 1504 AFTN (ISO)	LT 30	0.625	0.187	-	Neutral	•

- Stocking
- Non-stocking



Face Mill for SEKN. See page 31.

Face Milling Insert with 45° Lead Angle

Multi purpose 45° Milling insert, designed for high depths of cut. Suitable for Roughing to Finishing-Face Milling, Plunging and Ramping down Milling operations.

Application Guide

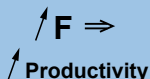


Chamfering



Facing

Machine Recommendations
Guide. Details on page 19.



Stainless Steel



SEKN 1203 AFTN LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	980	0.118	0.013	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	420	0.089	0.010	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.010	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	720	0.118	0.013	590
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.276	0.006	0.016	320	590	0.118	0.012	490
		17,19	S0005	200 HB									
		18,20		250 HB									
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.009	130	220	0.044	0.008	160
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
HP	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910

SEKN 1204 AFTN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	1080	0.118	0.013	820
		2	1045, 1060,	190 HB		0.276		0.018		980			720
		3	28Mn6	250 HB		0.276		0.018		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB		0.276		0.014		680			590
		5,7	100Cr6	280 HB		0.276		0.013		420			490
		8		350 HB		0.276		0.013		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	490	0.089	0.010	420
		10	H13, M42, D3,	280 HB		0.197		0.013		420			390
		11	S6-5-2, 12Ni19	320 HB		0.197		0.010		190			320
		11		350 HB		0.197		0.010		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.000	720
		14	X5CrNi18-9	240 HB		0.276		0.011		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB		0.197		0.010		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRC		0.197		0.010		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	780	0.118	0.013	650
		15	EN-GJL-250,	200 HB		0.276		0.018		720			590
		16	No30B	250 HB		0.276		0.018		620			520
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.276	0.006	0.016	320	590	0.118	0.012	490
		17,19	50005	200 HB		0.276		0.016		590			420
		18,20		250 HB		0.276		0.016		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB		0.197		0.010		140			90
		34	Stellite 21	350 HB		0.197		0.010		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-		0.197		0.010		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.010	130	260	0.059	0.008	190
		38	440C,	50 HRc		0.069		0.009		220			180
		38	G-X260NiCr42	55 HRc		0.059		0.008		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910

SEKN 1504 AFTN LT 30

Material Group	Cir. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.353	0.007	0.020	620	1080	0.157	0.014	820
		2		190 HB		0.353		0.020		980			720
		3		250 HB		0.353		0.020		820			650
	Low alloyed	2	6 42CrMo4, St50, 46 Ck60, 4140, 4340, 57 100Cr6	180 HB	0.020	0.353	0.006	0.015	490	780	0.157	0.013	650
		4		230 HB		0.353		0.015		680			590
		5		280 HB		0.353		0.013		420			490
		8		350 HB		0.353		0.013		420			450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12N119	220 HB	0.020	0.252	0.005	0.013	290	490	0.118	0.011	420
		10		280 HB		0.252		0.013		420			390
		11		320 HB		0.252		0.011		360			320
		11		350 HB		0.252		0.011		290			260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.353	0.006	0.013	620	820	0.157	0.011	720
		14		240 HB		0.353		0.005		520			620
	Duplex	5	14 X2CrNiN23-4, 14 S31500	290 HB	0.020	0.252	0.005	0.011	220	420	0.118	0.010	320
		14		310 HB		0.252		0.011		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.353	0.006	0.013	490	680	0.157	0.011	620
		13		42 HRC		0.252		0.011		290			420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.353	0.007	0.020	490	720	0.157	0.014	650
		15		200 HB		0.353		0.020		720			590
		16		250 HB		0.353		0.020		620			520
	Malleable & Nodular	8	17,19 GG40, GG670, 17,19 50005	150 HB	0.020	0.353	0.006	0.017	320	650	0.157	0.013	590
		17,19		200 HB		0.353		0.017		590			490
		18,20		250 HB		0.353		0.017		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.252	0.005	0.011	80	140	0.118	0.010	100
		33		250 HB		0.252		0.011		140			90
		34		350 HB		0.252		0.011		140			90
High Temp Alloys	Ti based	10	36 TiAl6V4, 37 T40	-	0.020	0.252	0.005	0.012	130	210	0.118	0.011	180
		37		-		0.252		0.011		90			130
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.020	0.126	0.004	0.011	130	260	0.079	0.009	190
		38		50 HRC		0.076		0.010		220			180
		38		55 HRC		0.063		0.009		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.101	0.004	0.011	130	260	0.059	0.009	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.063	0.004	0.009	90	190	0.039	0.008	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.353	0.007	0.020	650	1310	0.157	0.016	910

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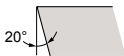
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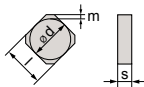
S E K R



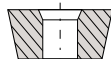
Shape



Clearance Angle



Tolerance
d ± 0.003
m ± 0.0005
s ± 0.0001



Insert Type
Clamping
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3254431	SEKR 42 AFTN (ANSI)	LT 30	0.500	0.125	-	Neutral	●
	SEKR 1203 AFTN (ISO)						
3254433	SEKR 43 AFTN (ANSI)	LT 30	0.500	0.187	-	Neutral	●
	SEKR 1204 AFTN (ISO)						

Face Milling Insert with 45° Lead Angle

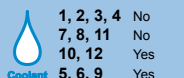
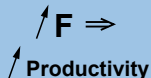
- Stocking
- Non-stocking

Multi purpose 45° Milling insert, designed for high depths of cut and materials that generate long chips. Suitable for Roughing to Finishing-Face, Plunging and Ramping down Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



SEKR 1203 AFTN LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	1080	0.118	0.013	820
		2	1045, 1060,	190 HB									
		3	28Mn6	250 HB									
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB									
		5,7	100Cr6	280 HB									
		8		350 HB									
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	420	0.089	0.010	420
		10	H13, M42, D3,	280 HB									
		11	S6-5-2, 12Ni19	320 HB									
		11		350 HB									
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.010	720
		14	X5CrNi18-9	240 HB									
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB									
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRc									
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	720	0.118	0.013	650
		15	EN-GJL-250,	200 HB									
		16	No30B	250 HB									
	Malleable & Nodular	8	17,19 GG40, GG670,	150 HB	0.020	0.276	0.006	0.016	320	590	0.118	0.012	490
		17,19	50005	200 HB									
		18,20		250 HB									
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB									
		34	Stellite 21	350 HB									
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-									
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.009	130	220	0.044	0.008	160
		38	440C,	50 HRc									
		38	G-X260NiCr42	55 HRc									
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
Hardened Mat.	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
Al	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910



LAMINA

TECHNICAL SOLUTIONS

SEKR 1204 AFTN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	1080	0.118	0.013	820
		2	1045, 1060,	190 HB		0.276		0.018		980			720
		3	28Mn6	250 HB		0.276		0.018		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB		0.276		0.014		680			590
		5,7	100Cr6	280 HB		0.276		0.013		420			490
		8		350 HB		0.276		0.013		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	490	0.089	0.010	420
		10	H13, M42, D3,	280 HB		0.197		0.013		420			390
		11	S6-5-2, 12Ni19	320 HB		0.197		0.010		190			320
		11		350 HB		0.197		0.010		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.010	720
		14	X5CrNi18-9	240 HB		0.276		0.011		520			620
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB		0.197		0.010		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRC		0.197		0.010		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	780	0.118	0.013	650
		15	EN-GJL-250,	200 HB		0.276		0.018		720			590
		16	No30B	250 HB		0.276		0.018		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.276	0.006	0.016	320	590	0.118	0.012	490
		17,19	50005	200 HB		0.276		0.016		490			420
		18,20		250 HB		0.276		0.016		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB		0.197		0.010		140			90
		34	Stellite 21	350 HB		0.197		0.010		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-		0.197		0.010		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.010	130	260	0.059	0.008	190
		38	440C,	50 HRc		0.069		0.009		220			180
		38	G-X260NiCr42	55 HRc		0.059		0.008		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910



S

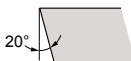
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K

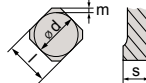
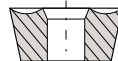
T



Shape



Clearance Angle


Tolerance
 $d \pm 0.003$
 $m \pm 0.0005$
 $s \pm 0.0001$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
2506169	SEKT 12T3 AGSN	LT 30	0.528	0.156	-	Neutral	●
3254435	SEKT 1204 AFTN	LT 30		0.187	-	Neutral	●

Face Milling Insert with 90° Lead Angle

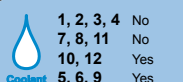
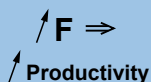
- Stocking
- Non-stocking

Multi purpose 45° Milling insert, designed for high depths of cut. Suitable for Roughing to Finishing-Face, Plunging and Ramping down Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



All Nexus products are backed
by our 100% satisfaction guarantee.



SEKT 12T3 AGSN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	1080	0.118	0.013	820
		2	1045, 1060,	190 HB		0.276		0.018		980			720
		3	28Mn6	250 HB		0.276		0.018		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	H13, M42, D3,	230 HB		0.276		0.014		680			590
		5,7	Ck60, 4140, 4340,	280 HB		0.276		0.013		420			490
		8	100Cr6	350 HB		0.276		0.013		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	490	0.089	0.010	420
		10	H13, M42, D3,	280 HB		0.197		0.013		420			390
		11	S6-5-2, 12Ni19	320 HB		0.197		0.010		190			320
		11		350 HB		0.197		0.010		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.010	720
		14	X5CrNi18-9	240 HB		0.276		0.011		520			620
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB		0.197		0.010		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRC		0.197		0.010		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	780	0.118	0.013	650
		15	EN-GJL-250,	200 HB		0.276		0.018		720			590
		16	No30B	250 HB		0.276		0.018		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.276	0.006	0.016	320	590	0.118	0.012	490
		17,19	50005	200 HB		0.276		0.016		490			420
		18,20		250 HB		0.276		0.016		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB		0.197		0.010		140			90
		34	Stellite 21	350 HB		0.197		0.010		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-		0.197		0.010		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.010	130	260	0.059	0.008	190
		38	440C,	50 HRc		0.069		0.009		220			180
		38	G-X260NiCr42	55 HRc		0.059		0.008		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
HP	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910

SEKT 1204 AFTN LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.018	620	1080	0.118	0.013	820
		2	1045, 1060,	190 HB		0.276		0.018		980			720
		3	28Mn6	250 HB		0.276		0.018		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.014	490	780	0.118	0.012	650
		4,6	Ck60, 4140, 4340,	230 HB		0.276		0.014		680		0.012	590
		5,7	100Cr6	280 HB		0.276		0.013		420		0.010	490
		8		350 HB		0.276		0.013		420		0.010	450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.013	290	490	0.089	0.010	420
		10	H13, M42, D3,	280 HB		0.197		0.013		420		0.010	390
		11	S6-5-2, 12Ni19	320 HB		0.197		0.010		190		0.009	320
		11		350 HB		0.197		0.010		190		0.009	260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.276	0.006	0.013	620	820	0.118	0.010	720
		14	X5CrNi18-9	240 HB		0.276		0.011		520			620
	Duplex	5	14 X2CrNiMo23-4,	290 HB	0.020	0.197	0.005	0.010	220	420	0.089	0.009	320
		14	S31500	310 HB		0.197		0.010		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.276	0.006	0.013	490	680	0.118	0.010	620
		13	17-4 PH, 430	42 HRC		0.197		0.010		290		0.089	420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.018	490	780	0.118	0.013	650
		15	EN-GJL-250,	200 HB		0.276		0.018		720			590
		16	No30B	250 HB		0.276		0.018		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.276	0.006	0.016	320	650	0.118	0.012	590
		17,19	50005	200 HB		0.276		0.016		590			490
		18,20		250 HB		0.276		0.016		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.005	0.010	80	140	0.089	0.009	100
		33	Inconel 700	250 HB		0.197		0.010		140			90
		34	Stellite 21	350 HB		0.197		0.010		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.005	0.011	130	210	0.089	0.010	180
		37	T40	-		0.197		0.010		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.098	0.004	0.010	130	260	0.059	0.008	190
		38	440C,	50 HRC		0.069		0.009		220		0.044	180
		38	G-X260NiCr42	55 HRC		0.059		0.008		190		0.030	160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.008	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.008	90	190	0.030	0.007	130
Al	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.276	0.007	0.018	650	1310	0.118	0.015	910

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT



09T3-HF



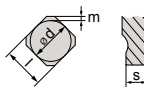
1607-45°

S**N****K****X**

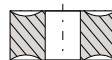
Shape



Clearance Angle



Tolerance
 $d \pm 0.0002$
 $m \pm 0.0005$
 $s \pm 0.0001$



**Fixing
Chip breaker**

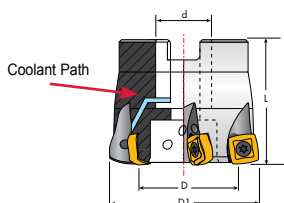
Part No.	Description	Grade	l	s	r	Direction	Pr. R.	Stock
2502115	SNKX 09T3-HF	LT 30		0.146	-	Right	0.165	●
2502205	SNKX 1607-45°	LT 30	0.658	0.269	-	Right	0.165	●

● Stocking

○ Non-stocking

Face Mill for SNKX 09T3. See page 34.

Pr. R. = Programming Radius



**High Feed Indexable End mill
for SNKX 09T3. See page 47.**

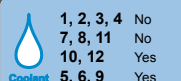
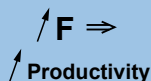


Cutter bodies for SNKX 1607 coming early 2014.

Exclusive and unique design insert with 8 cutting edges for High Feed. Suitable for Roughing to Semi-Finishing Copying of 3D surfaces and Face Milling operations.



Machine Recommendations
Guide. Details on page 19.



SNKX 09T3-HF LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.004	0.039		0.083		1080	0.022	0.043	820
		2		190 HB		0.039	0.011	0.077	620	980			720
		3		250 HB		0.039		0.059		820			650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.004	0.039	0.010	0.077	490	780	0.020	0.039	650
		4,6		230 HB		0.039	0.010	0.067	490	680			590
		5,7		280 HB		0.039	0.009	0.063	420	620			490
		8		350 HB		0.039	0.009	0.059	420	550			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.004	0.039		0.067	290	490	0.020	0.035	420
		10		280 HB		0.039		0.063	290	420			390
		11		320 HB		0.031		0.059	190	360			320
		11		350 HB		0.031		0.055	190	290			260
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No30B	150 HB	0.004	0.039		0.094		780	0.024	0.043	650
		15		200 HB		0.039	0.008	0.094	490	720			590
		16		250 HB		0.039		0.094		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 50005	150 HB	0.004	0.039		0.071		650	0.020	0.039	590
		17,19		200 HB		0.039	0.008	0.071	320	590			490
		18,20		250 HB		0.039		0.071		490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.004	0.024		0.043		260	0.016	0.028	190
		38		50 HRc		0.020	0.006	0.039	130	220			180
		38		55 HRc		0.016		0.035		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.004	0.024	0.006	0.043	130	260	0.016	0.028	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.004	0.016	0.006	0.035	90	190	0.012	0.024	130

ADKT
AOMT
APKT
APMT
LDMT
ODMT
ODMW
OFER
OFMT
PNEG
RDMT
RDMW
RDMX
SDKT
SDKX
SDMT
SEKN
SEKR
SEKT
SNKX
SPKN
SPKR
SPMT
SPG
TPKN
TPKR
TPUN
WPGT
APET
APEX
APGT
SEET
SEGT



SNKX 1607-45° LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Optimal cutting conditions	
					min	max	min	max	min	max	D.O.C.	Feed
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.256	0.006	0.023	620	1080	0.157	0.018
		2	1045, 1060,	190 HB		0.256		0.023		980		0.018
		3	28Mn6	250 HB		0.256		0.023		820		0.018
	Low alloyed	6	42CrMo4, St50,	180 HB	0.020	0.256	0.006	0.020	490	780	0.157	0.016
		4,6	42CrMo4, St50,	230 HB		0.256		0.020		680		0.016
		5,7	Ck60, 4140, 4340,	280 HB		0.256		0.017		420		0.014
		8	100Cr6	350 HB		0.256		0.017		420		0.014
	High alloyed	10	X40CrMoV5,	220 HB	0.020	0.256	0.004	0.017	290	490	0.118	0.014
		10	H13, M42, D3,	280 HB		0.256		0.017		420		0.014
		11	S6-5-2, 12Ni19	320 HB		0.256		0.014		190		0.013
		11		350 HB		0.256		0.014		190		0.013
Stainless Steel	Austenitic	4	304, 316,	180 HB	0.020	0.256	0.006	0.017	620	820	0.157	0.013
		14	X5CrNi18-9	240 HB		0.256		0.016		520		0.013
	Duplex	5	X2CrNiN23-4,	290 HB	0.020	0.197	0.004	0.014	220	420	0.118	0.012
		14	S31500	310 HB		0.197		0.014		390		0.012
	Ferritic & Martensitic	6	410, X6Cr17,	200 HB	0.020	0.256	0.006	0.017	490	680	0.157	0.013
		13	17-4 PH, 430	42 HRC		0.198		0.016		290		0.012
Cast Iron	Grey	7	GG20, GG40,	150 HB	0.020	0.256	0.007	0.023	490	780	0.157	0.018
		15	EN-GJL-250,	200 HB		0.256		0.023		720		0.018
		16	No30B	250 HB		0.256		0.023		620		0.018
	Malleable & Nodular	8	GGG40, GGG70,	150 HB	0.020	0.256	0.006	0.020	320	590	0.157	0.016
		17,19	50005	200 HB		0.256		0.020		490		0.016
		18,20		250 HB		0.256		0.020		490		0.016
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.197	0.004	0.014	80	140	0.118	0.012
		33	Inconel 700	250 HB		0.197		0.014		140		0.012
		34	Stellite 21	350 HB		0.197		0.014		140		0.012
	Ti based	10	36 TiAl6V4	-	0.020	0.197	0.004	0.016	130	210	0.118	0.013
		37	T40	-		0.197		0.014		90		0.012
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.016	0.119	0.004	0.014	130	260	0.079	0.011
		38	440C,	50 HRC		0.119		0.013		220		0.010
		38	G-X260NiCr42	55 HRC		0.059		0.011		190		0.009
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.016	0.119	0.004	0.014	130	260	0.059	0.011
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.016	0.059	0.004	0.011	90	190	0.039	0.009
IN	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.256	0.007	0.024	650	1310	0.157	0.020

Cutter bodies coming early 2014.



S

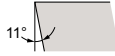
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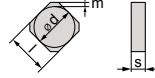
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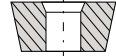
Shape



Clearance Angle



Tolerance

 $m \pm 0.0005$ $s \pm 0.001$
For $l = 12$, $d \pm 0.003$
For $l = 15$, $d \pm 0.004$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3263336	SPKN 42 EDTR (ANSI)	LT 30	0.500	0.125	-	Right	o
	SPKN 1203 EDTR (ISO)						
3263341	SPKN 43 EDTR (ANSI)	LT 30	0.500	0.187	-	Right	o
	SPKN 1204 EDTR (ISO)						
3266029	SPKN 53 EDTR (ANSI)	LT 30	0.625	0.187	-	Right	o
	SPKN 1504 EDTR (ISO)						

● Stocking
○ Non-stocking

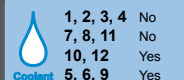
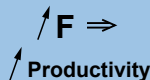
Face Mill Insert with 75° Lead Angle

Square inserts with 75° lead angle, designed for High depths of cut.
Suitable for Roughing to Finishing-Face Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



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ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

SPKN 1203 EDTR LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.276	0.007	0.017	620	1080	0.118	0.012	820
		2		190 HB									720
		3		250 HB									650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.276	0.006	0.013	490	780	0.118	0.010	650
		4,6		230 HB									590
		5,7		280 HB									490
		8		350 HB									450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.197	0.005	0.012	290	420	0.089	0.009	420
		10		280 HB									390
		11		320 HB									320
		11		350 HB									260
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.276	0.007	0.017	490	720	0.118	0.012	650
		15		200 HB									590
		16		250 HB									520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 50005	150 HB	0.020	0.276	0.006	0.015	320	590	0.118	0.010	590
		17,19		200 HB									490
		18,20		250 HB									420
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.069	0.004	0.010	130	220	0.059	0.007	190
		38		50 HRc									180
		38		55 HRc									160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.007	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.007	90	190	0.030	0.006	130

SPKN 1204 EDTR LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.276	0.007	0.017	620	980	0.118	0.012	820
		2	1045, 1060,	190 HB									720
		3	28Mn6	250 HB									650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.276	0.006	0.013	490	780	0.118	0.010	650
		4,6	Ck60, 4140, 4340,	230 HB									590
		5,7	100Cr6	280 HB									490
		8		350 HB									450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.197	0.005	0.012	290	420	0.089	0.009	420
		10	H13, M42, D3,	280 HB									390
		11	S6-5-2, 12Ni19	320 HB									320
		11		350 HB									260
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.276	0.007	0.017	490	720	0.118	0.012	650
		15	EN-GJL-250,	200 HB									590
		16	No30B	250 HB									520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.276	0.006	0.015	320	590	0.118	0.010	590
		17,19	50005	200 HB									490
		18,20		250 HB									420
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.069	0.004	0.010	130	220	0.044	0.007	190
		38	440C,	50 HRc									180
		38	G-X260NiCr42	55 HRc									160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	130	260	0.044	0.007	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.007	90	190	0.030	0.006	130

SPKN 1504 EDTR LT 30

Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters				
						min	max	min	max	min	max	D.O.C.	Feed	V _c		
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.020	0.356	0.007	0.017	620	1080	0.157	0.012	820		
			2	1045, 1060,	190 HB		0.356		0.017		980			720		
			3	28Mn6	250 HB		0.356		0.017		820			650		
	Low alloyed	2	6	42CrMo4, St50,	180 HB	0.020	0.356	0.006	0.013	490	780	0.157	0.010	650		
			4,6	Ck60, 4140, 4340,	230 HB		0.356		0.013		490			680	590	
			5,7	100Cr6	280 HB		0.356		0.012		420			620	0.009	490
			8		350 HB		0.356		0.012		420			550	0.009	450
	High alloyed	3	10	X40CrMoV5,	220 HB	0.020	0.254	0.005	0.012	290	490	0.118	0.009	420		
			10	H13, M42, D3,	280 HB		0.254		0.012		290			420	0.009	390
			11	S6-5-2, 12Ni19	320 HB		0.254		0.010		190			360	0.008	320
			11		350 HB		0.254		0.010		190			290	0.008	260
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.020	0.356	0.007	0.017	490	720	0.157	0.012	650		
			15	EN-GJL-250,	200 HB		0.356		0.017		620			590		
			16	No30B	250 HB		0.356		0.017		620			520		
	Malleable & Nodular	8	17,19	GG40, GG670,	150 HB	0.020	0.356	0.006	0.015	320	650	0.157	0.010	590		
			17,19	50005	200 HB		0.356		0.015		590			490		
			18,20		250 HB		0.356		0.015		490			420		
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC	0.020	0.127	0.004	0.010	130	260	0.079	0.007	190		
			38	440C,	50 HRC		0.089		0.009		220			180		
			38	G-X260Ni/Cr42	55 HRC		0.076		0.007		190			0.039	0.006	160
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.102	0.004	0.010	130	260	0.059	0.007	160		
			41	G-X300CrMo15	55 HRC	0.020	0.076	0.004	0.007	90	190	0.039	0.006	130		



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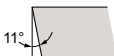
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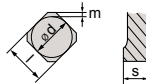
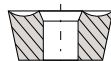
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Shape



Clearance Angle


Tolerance
d ± 0.003
m ± 0.0005
s ± 0.001

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3263336	SPKR 42 EDTR (ANSI) SPKR 1203 EDTR (ISO)	LT 30	0.500	0.125	-	Right	●
3263341	SPKR 43 EDTR (ANSI) SPKR 1204 EDTR (ISO)	LT 30	0.500	0.187	-	Right	●

- Stocking
- Non-stocking

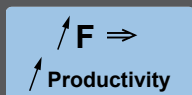
Face Mill Insert with 75° Lead Angle

Square inserts, with 75° lead angle designed for high depths of cut and materials that generate long chips. Suitable for Roughing to Finishing-Face Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



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125

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

SPKR 1203 EDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.276	0.007	0.015	620	1080	0.118	0.010	820
		2		190 HB		0.276		0.015		980			720
		3		250 HB		0.276		0.015		820			650
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.276	0.006	0.012	490	780	0.118	0.009	650
				230 HB		0.276		0.012	490	680			590
				280 HB		0.276		0.010	420	620			490
				350 HB		0.276		0.010	420	550			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12N19	220 HB	0.020	0.197	0.005	0.010	290	490	0.089	0.008	420
				280 HB		0.197		0.010	290	420			390
				320 HB		0.197		0.009	190	360			320
				350 HB		0.197		0.009	190	290			260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.276	0.006	0.010	620	820	0.118	0.008	720
				240 HB		0.276		0.005	520	680			620
	Duplex	5	14 X2CrNi23-4, S31500	290 HB	0.020	0.197	0.005	0.009	220	420	0.089	0.007	320
				310 HB		0.197		0.009	220	390			290
	Ferritic & Martensitic	6	12 410, X6Cr17, 13 17-4 PH, 430	200 HB	0.020	0.276	0.006	0.010	490	680	0.118	0.008	620
				42 HRC		0.197		0.009	290	490			420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.276	0.007	0.015	490	720	0.118	0.010	650
				200 HB		0.276		0.015	490	720			590
				250 HB		0.276		0.015	620				520
	Malleable & Nodular	8	17,19 GG40, GGG70, 18,20 50005	150 HB	0.020	0.276	0.006	0.013	320	590	0.118	0.009	590
				200 HB		0.276		0.013	320	590			490
				250 HB		0.276		0.013	490				420
	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.197	0.005	0.009	80	140	0.089	0.007	100
				250 HB		0.197		0.009	80	140			90
				350 HB		0.197		0.009	140				90
High Temp. Alloys	Ti based	10	36 TiAl6V4, 37 T40	-	0.020	0.197	0.005	0.009	130	210	0.089	0.008	180
				-		0.197		0.009	90	180			130
				-		0.197		0.009	90	180			130
	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.020	0.098	0.004	0.009	130	260	0.059	0.006	190
				50 HRC		0.069		0.008	130	220			180
				55 HRC		0.059		0.007	190				160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.079	0.004	0.009	130	260	0.044	0.006	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.007	90	190	0.030	0.005	130
Al (>8%Si)		12	25 AISI12	130 HB	0.020	0.276	0.007	0.015	650	1310	0.118	0.011	910

SPKR 1204 EDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.276	0.007	0.015	620	1080	0.118	0.010	820
		2		190 HB		0.276		0.015		980			720
		3		250 HB		0.276		0.015		820			650
	Low alloyed	2	6 42CrMo4, St50, 4.6 Ck60, 4140, 4340, 5.7 S6-5-2, 12Ni19	180 HB	0.020	0.276	0.006	0.012	490	780	0.118	0.009	590
		4		230 HB		0.276		0.012		680			650
		5		280 HB		0.276		0.010		420			490
		8		350 HB		0.276		0.010		420			450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.197	0.005	0.010	290	490	0.089	0.008	390
		10		280 HB		0.197		0.010		420			420
		11		320 HB		0.197		0.009		190			320
		11		350 HB		0.197		0.009		190			260
Stainless Steel	Austenitic	4	14 304, 316, 14 X5CrNi18-9	180 HB	0.020	0.276	0.006	0.010	620	820	0.118	0.008	720
		14		240 HB		0.276		0.005		520			620
	Duplex	5	14 X2CrNiMo23-4, 14 S31500	290 HB	0.020	0.197	0.005	0.009	220	420	0.089	0.007	320
		14		310 HB		0.197		0.009		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17, 12 17-4 PH, 430	200 HB	0.020	0.276	0.006	0.010	490	680	0.118	0.008	620
		13		42 HRC		0.197		0.009		290			420
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.276	0.007	0.015	490	780	0.118	0.010	650
				200 HB		0.276		0.015		720			590
				250 HB		0.276		0.015		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 17,19 50005	150 HB	0.020	0.276	0.006	0.013	320	650	0.118	0.009	590
				200 HB		0.276		0.013		590			490
				250 HB		0.276		0.013		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800, 33 Inconel 700, 34 Stellite 21	240 HB	0.020	0.197	0.005	0.009	80	140	0.089	0.007	100
				250 HB		0.197		0.009		140			90
				350 HB		0.197		0.009		140			90
High Temp. Alloys	Ti based	10	36 TiAl6V4, 37 T40	-	0.020	0.197	0.005	0.009	130	210	0.089	0.008	180
				-		0.197		0.009		90			130
	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRC	0.020	0.098	0.004	0.009	130	260	0.058	0.006	190
				50 HRC		0.069		0.008		220			180
				55 HRC		0.059		0.007		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.079	0.004	0.009	130	260	0.044	0.006	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.007	90	190	0.030	0.005	130
	Al (>8%Si)	12	25 AlSi12	130 HB	0.020	0.276	0.007	0.015	650	1310	0.118	0.011	910



S

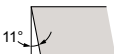
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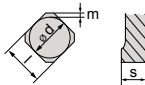
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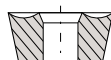
Shape



Clearance Angle



Tolerance
d ± 0.003
m ± 0.005
s ± 0.005



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3263347	SPMT12T308	LT 30	0.523	0.156	0.031	Right	●

Face Mill Insert with 90° Lead Angle

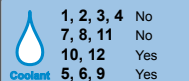
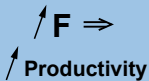
- Stocking
- Non-stocking

Multi purpose 90° Milling insert with 4 cutting edges. Suitable for Roughing to Finishing-Slotting, shoulder and Face Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



SPMT 12T308 LT 30

Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.356	0.005	0.011	620	1080	0.118	0.007	820
		2	2		190 HB		0.356		0.011		980			720
		3	3		250 HB		0.356		0.011		820			650
	Low alloyed	2	4,6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.356	0.004	0.009	490	780	0.118	0.006	650
		2	5		230 HB		0.356		0.009		680			590
		2	5,7		280 HB		0.356		0.008		420			490
		2	8		350 HB		0.356		0.008		420			450
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12N19	220 HB	0.020	0.254	0.003	0.008	290	490	0.089	0.005	420
		3	10		280 HB		0.254		0.008		420			390
		3	11		320 HB		0.254		0.006		190			320
		3	11		350 HB		0.254		0.006		190			280
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.020	0.356	0.004	0.009	620	820	0.118	0.006	720
		4	14		240 HB		0.356		0.003		520			620
	Duplex	5	14	X2CrNiW23-4, S31500	290 HB	0.020	0.254	0.003	0.006	220	420	0.089	0.005	320
		5	14		310 HB		0.254		0.006		390			290
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.356	0.004	0.009	490	680	0.118	0.006	620
		6	13		42 HRC		0.254		0.007		290			420
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.356	0.005	0.011	490	780	0.118	0.007	650
		7	15		200 HB		0.356		0.011		720			590
		7	16		250 HB		0.356		0.011		620			520
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.356	0.004	0.010	320	650	0.118	0.006	590
		8	17,19		200 HB		0.356		0.010		590			490
		8	18,20		250 HB		0.356		0.010		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.254	0.003	0.006	80	140	0.089	0.005	100
		9	33	Inconel 700	250 HB		0.254		0.006		140			90
		9	34	Stellite 21	350 HB		0.254		0.006		140			90
	Ti based	10	36	TiAl6V4	-	0.020	0.254	0.003	0.007	130	210	0.089	0.006	180
		10	37	T40	-		0.254		0.006		90			130
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.020	0.127	0.003	0.006	130	260	0.059	0.004	190
		11	38		50 HRC		0.076		0.006		220			180
		11	38		55 HRC		0.038		0.005		190			160
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.102	0.003	0.006	130	260	0.044	0.004	160
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.020	0.038	0.003	0.005	90	190	0.030	0.004	130
WIP	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.356	0.005	0.011	650	1310	0.118	0.008	910





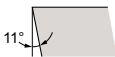
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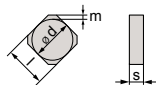
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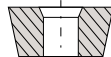
Shape



Clearance Angle



Tolerance
d ± 0.005
m ± 0.008
s ± 0.005



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3263333	SPG 422 (ANSI) SPUN 120308 (ISO)	LT 30	0.500	0.125	0.031	Neutral	●

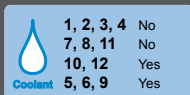
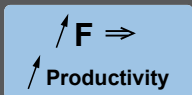
- Stocking
- Non-stocking

Multi purpose Square insert with corner radius and a flat rake surface.
Use for Face Milling. Roughing to Finishing

Application Guide



Machine Recommendations
Guide Details on page 19.



SPG 422 LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 20Mn6	125 HB	0.020	0.276	0.007	0.014	620	1080	0.118	0.010	820
		2		190 HB		0.276		0.014		980			720
		3		250 HB		0.276		0.014		820			650
	Low alloyed	2	6 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.276	0.006	0.011	490	780	0.118	0.009	650
		4,6		230 HB		0.276		0.011		680			590
		5,7		280 HB		0.276		0.010		620			490
		8		350 HB		0.276		0.010		550			450
	High alloyed	3	10 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.197	0.005	0.010	290	490	0.089	0.008	420
		10		280 HB		0.197		0.010		420			390
		11		320 HB		0.197		0.008		360			320
		11		350 HB		0.197		0.008		190			260
Cast Iron	Grey	7	15 GG20, GG40, EN-GJL-250, No308	150 HB	0.020	0.276	0.007	0.014	490	780	0.118	0.010	650
		15		200 HB		0.276		0.014		720			590
		16		250 HB		0.276		0.014		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70, 50005	150 HB	0.020	0.276	0.006	0.013	320	650	0.118	0.009	590
		17,19		200 HB		0.276		0.013		590			490
		18,20		250 HB		0.276		0.013		490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.098	0.004	0.008	130	260	0.059	0.006	190
		38		50 HRc		0.069		0.007		220			180
		38		55 HRc		0.059		0.006		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.008	130	260	0.044	0.006	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.006	90	190	0.030	0.005	130

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

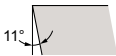




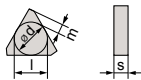
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Shape

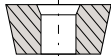


Clearance Angle



Tolerance

m ± 0.013 s ± 0.0005
For l = 16, d ± 0.002
For l = 22, d ± 0.003



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3567741	TPKN 32 PDTR (ANSI)	LT 30	0.650	0.125	-	Right	●
	TPKN 1603 PDTR (ISO)						
3567745	TPKN 43 PDTR (ANSI)	LT 30	0.866	0.187	-	Right	●
	TPKN 2204 PDTR (ISO)						

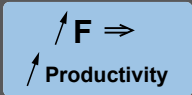
- Stocking
- Non-stocking

Multipurpose 90° Milling insert with 3 cutting edges. Use for Slotting, Shoulder Milling and Face Milling. Roughing to Finishing.

Application Guide



Machine Recommendations
Guide. Details on page 19.



TPKN 1603 PDTR LT 30

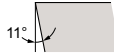
Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.474	0.006	0.011	620	1080	0.118	0.008	820
		2		190 HB		0.474		0.011		980			720
		3		250 HB		0.474		0.011		820			650
	Low alloyed	2	6 42CrMo4, St50, 4,6 Ck60, 4140, 4340, 5,7 100Cr6	180 HB	0.020	0.474	0.005	0.008	490	780	0.118	0.007	650
		4,6		230 HB		0.474		0.008	490	680			590
		5,7		280 HB		0.474		0.007	420	620			490
		8		350 HB		0.474		0.007	420	550			450
	High alloyed	3	10 X40CrMoV5, 10 H13, M42, D3, 11 S6-5-2, 12Ni19	220 HB	0.020	0.339	0.004	0.007	290	490	0.089	0.006	420
		10		280 HB		0.339		0.007	290	420			390
		11		320 HB		0.339		0.006	190	360			320
		11		350 HB		0.339		0.006	190	290			260
Cast Iron	Grey	7	15 GG20, GG40, 15 EN-GJL-250, 16 No30B	150 HB	0.020	0.474	0.006	0.011	490	780	0.118	0.008	650
		15		200 HB		0.474		0.011		720			590
		16		250 HB		0.474		0.011		620			520
	Malleable & Nodular	8	17,19 GGG40, GG670, 17,19 50005	150 HB	0.020	0.474	0.005	0.009	320	650	0.118	0.007	590
		17,19		200 HB		0.474		0.009		590			490
		18,20		250 HB		0.474		0.009		490			420
Hardened Mat.	Steel	11	38 X100CrMo13, 38 440C, 38 G-X260NiCr42	45 HRc	0.020	0.169	0.003	0.006	130	260	0.059	0.005	190
		38		50 HRc		0.119		0.005		220			180
		38		55 HRc		0.102		0.005		190			160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.135	0.003	0.006	130	260	0.044	0.005	160
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.020	0.102	0.003	0.005	90	190	0.030	0.004	130

TPKN 2204 PDTR LT 30

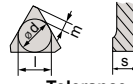
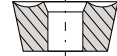
Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters			
						min	max	min	max	min	max	D.O.C.	Feed	V _c	
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.020	0.708	0.006	0.011	620	1080	0.157	0.008	820	
		2	2	1045, 1060,	190 HB	0.000	0.708	0.000	0.011	0	980			720	
		3	3	28Mn6	250 HB	0.000	0.708	0.000	0.011	0	820			650	
	Low alloyed	2	6	180 HB	0.020	0.708	0.005	0.008	490	780	0.157	0.007	0.006	650	
		4,6	4	42CrMo4, St50,	230 HB	0.000	0.708	0.000	0.008	490				680	590
		5,7	5	Ck60, 4140, 4340,	280 HB	0.000	0.708	0.000	0.007	420				620	490
		8	8	100Cr6	350 HB	0.000	0.708	0.000	0.007	420				550	450
	High alloyed	3	10	220 HB	0.020	0.506	0.004	0.007	290	490	0.118	0.006	0.005	420	
		10	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	280 HB	0.000	0.506	0.000	0.007	290				420	390
		11	11	320 HB	0.000	0.506	0.000	0.006	190	360				320	
		11	11	350 HB	0.000	0.506	0.000	0.006	190	290				260	
Cast Iron	Grey	7	15	150 HB	0.020	0.708	0.006	0.011	490	780	0.157	0.008	0.007	650	
		15	15	GG20, GG40, EN-GJL-250, No30B	200 HB	0.000	0.708	0.000	0.011	0				720	590
		16	16	250 HB	0.000	0.708	0.000	0.011	0	620				520	
	Malleable & Nodular	8	17,19	150 HB	0.020	0.708	0.005	0.009	320	650	0.157	0.007	0.006	590	
		17,19	17,19	GGG40, GGG70, 50005	200 HB	0.000	0.708	0.000	0.009	0				590	490
		18,20	18,20	250 HB	0.000	0.708	0.000	0.009	0	490				420	
Hardened Mat.	Steel	11	38	45 HRC	0.020	0.253	0.004	0.006	130	260	0.079	0.005	190		
		38	38	X100CrMo13, 440C, G-X260N/Cr42	50 HRC	0.000	0.177	0.000	0.005	0	220	0.059	0.004	180	
		38	38	55 HRC	0.000	0.152	0.000	0.005	0	190	0.039	0.004	160		
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.202	0.004	0.006	130	260	0.059	0.005	160	
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.020	0.152	0.004	0.005	90	190	0.039	0.004	130	


T
P
K
R


Shape



Clearance Angle


Tolerance
 $m \pm 0.0005$ $s \pm 0.001$
For $l = 16$, $d \pm 0.002$
For $l = 22$, $d \pm 0.003$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
3567751	TPKR 323 PDTR (ANSI)	LT 30	0.650	0.125	-	Right	●
	TPKR 1603 PDTR (ISO)						
3567755	TPKR 43 PDTR (ANSI)	LT 30	0.866	0.187	-	Right	●
	TPKR 2204 PDTR (ISO)						

- Stocking
- Non-stocking

Multi purpose 90° Milling insert with 3 cutting edges, designed for materials that generate long chips. Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Slotting

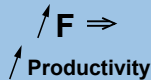


Shoulder Milling



Facing

Machine Recommendations
Guide. Details on page 19.



All Nexus products are backed
by our 100% satisfaction guarantee.



135

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

SDKT

SDKX

SDMT

SEKN

SEKR

SEKT

SNKX

SPKN

SPKR

SPMT

SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT

TPKR 1603 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [Inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.474	0.006	0.009	620	1080	0.118	0.007	820
		2	1045, 1060, 28Mn6	190 HB		0.474		0.009		990			720
		3		250 HB		0.474		0.009		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.474	0.005	0.007	490	780	0.118	0.006	650
		4,6	Ck60, 4140, 4340,	230 HB		0.474		0.007		680			590
		5,7	100Cr6	280 HB		0.474		0.006		420			490
		8		350 HB		0.474		0.006		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.339	0.004	0.006	290	490	0.089	0.005	420
		10	H13, M42, D3,	280 HB		0.339		0.006		420			390
		11	S6-5-2, 12Ni19	320 HB		0.339		0.005		190			320
		11		350 HB		0.339		0.005		190			260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.474	0.005	0.006	620	820	0.118	0.005	720
		14	X5CrNi18-9	240 HB		0.474		0.006		520			620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.339	0.004	0.005	220	420	0.089	0.005	320
		14	S31500	310 HB		0.339		0.005		390			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.474	0.005	0.006	490	680	0.118	0.005	620
		13	17-4 PH, 430	42 HRc		0.339		0.005		290			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.474	0.006	0.009	490	780	0.118	0.007	650
		15	EN-GJL-250,	200 HB		0.474		0.009		720			590
		16	No30B	250 HB		0.474		0.009		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.474	0.005	0.008	320	590	0.118	0.006	590
		17,19	50006	200 HB		0.474		0.008		490			490
		18,20		250 HB		0.474		0.008		490			420
	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.339	0.004	0.005	80	140	0.089	0.005	100
		33	Inconel 700	250 HB		0.339		0.005		140			90
		34	Stellite 21	350 HB		0.339		0.005		140			90
	Ti based	10	36 TiAl6V4	-	0.020	0.339	0.004	0.006	130	210	0.089	0.005	180
		37	T40	-		0.339		0.005		90			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.169	0.004	0.005	130	260	0.059	0.004	190
		38	440C,	50 HRc		0.119		0.004		220			180
		38	G-X260NiCr42	55 HRc		0.102		0.004		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.135	0.004	0.005	130	260	0.044	0.004	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.102	0.004	0.004	90	190	0.030	0.003	130
NF	Al (>8%Si)	12	25 AISi12	130 HB	0.020	0.474	0.006	0.009	650	1310	0.118	0.007	910

TPKR 2204 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters	
					min	max	min	max	min	max	D.O.C.	Feed
Steel	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.708	0.006	0.009	620	980	0.157	0.007
		2	1045, 1060,	190 HB								
		3	28Mn6	250 HB								
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.708	0.005	0.007	490	780	0.157	0.006
		4,6	42CrMo4, St50,	230 HB								
		5,7	42CrMo4, St50,	280 HB								
		8	100Cr6	350 HB								
	High alloyed	3	10 X40CrMoV5,	180 HB	0.020	0.506	0.004	0.006	290	420	0.118	0.005
		10	H13, M42, D3,	280 HB								
		11	S6-5-2, 12Ni19	320 HB								
		11		350 HB								
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.708	0.005	0.006	620	820	0.157	0.005
		14	X5CrNi18-9	240 HB								
	Duplex	5	14 X2CrNi23-4,	290 HB	0.020	0.506	0.004	0.005	220	420	0.118	0.005
		14	S31500	310 HB								
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.708	0.005	0.006	490	680	0.157	0.005
		13	17-4 PH, 430	42 HRC								
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.708	0.006	0.009	490	720	0.157	0.007
		16	EN-GJL-250, No30B	200 HB								
		16		250 HB								
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.708	0.005	0.008	320	590	0.157	0.006
		17,19	50005	200 HB								
		18,20		250 HB								
High Temp Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.506	0.004	0.005	80	140	0.118	0.005
		33	Inconel 700	250 HB								
		34	Stellite 21	350 HB								
	Ti based	10	36 TiAl6V4	-	0.020	0.506	0.004	0.006	130	210	0.118	0.005
		37	T40	-								
						0.506		0.005	90	180		
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.253	0.004	0.005	130	220	0.079	0.004
		38	440C,	50 HRC								
		38	G-X260NiCr42	55 HRC								
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.202	0.004	0.005	130	260	0.059	0.004
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.152	0.004	0.004	90	190	0.039	0.003
WV	Al (>8%Si)	12	25 AISI12	130 HB	0.020	0.708	0.006	0.009	650	1310	0.157	0.007

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

PNEG

RDMT

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SDKT

SDKX

SDMT

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SPG

TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

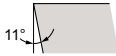
SEGT



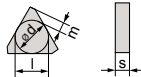
T P U N



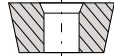
Shape



Clearance Angle



Tolerance
d ± 0.003
m ± 0.005
s ± 0.005



**Fixing
Chip breaker**

Part No.	Description	Grade	l	s	r	Direction	Stock
3567761	TPUN 322 (ANSI)	LT 30	0.650	0.125	0.031	Right	●
	TPUN 160308 (ISO)						

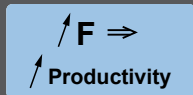
- Stocking
- Non-stocking

Multi purpose 90° Milling insert with 3 cutting edges and corner radius.
Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Machine Recommendations
Guide. Details on page 19.



TPUN 160308 LT 30

Material Group	Cr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Sheet	Non-alloyed	1	1 C35, Ck45, 1020,	125 HB	0.020	0.474	0.006	0.011	620	1080	0.118	0.008	820
		2	1045, 1060,	190 HB		0.474		0.011		980			720
		3	28Mn6	250 HB		0.474		0.011		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.474	0.005	0.008	490	780	0.118	0.007	650
		4,6	Ck60, 4140, 4340,	230 HB		0.474		0.008		680			590
		5,7	100Cr6	280 HB		0.474		0.007		420			490
		8		350 HB		0.474		0.007		420			450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.339	0.004	0.007	290	490	0.089	0.006	420
		10	H13, M42, D3,	280 HB		0.339		0.007		420			390
		11	S6-S-2, 12Ni19	320 HB		0.339		0.006		190			320
		11		350 HB		0.339		0.006		190			260
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.474	0.006	0.011	490	780	0.118	0.008	650
		15	EN-GJL-250,	200 HB		0.474		0.011		720			590
		16	No30B	250 HB		0.474		0.011		620			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.474	0.005	0.009	320	650	0.118	0.007	590
		17,19	50D05	200 HB		0.474		0.009		590			490
		18,20		250 HB		0.474		0.009		490			420
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.020	0.169	0.003	0.006	130	260	0.059	0.005	190
		38	440C,	50 HRc		0.119		0.005		220			180
		38	G-X260NiCr42	55 HRc		0.102		0.005		190			160
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.135	0.003	0.006	130	260	0.044	0.005	160
White Cast Iron		41	G-X300CrMo15	55 HRc	0.020	0.102	0.003	0.005	90	190	0.030	0.004	130

ADKT

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ODMT

ODMW

OFER

OFMT

PNEG

RDMT

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RDMX

SDKT

SDKX

SDMT

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SEKR

SEKT

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TPKN

TPKR

TPUN

WPGT

APET

APEX

APGT

SEET

SEGT





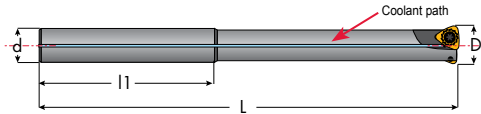
W P G T

Part No.	Description	Grade	I	s	r	Direction	Stock
3451112	WPGT 050315 ZSR HF	351	0.197	0.138	0.059	Neutral	●

HP = High Polish

- Stocking
- Non-stocking

High Feed Indexable End Mill for WPGT. See page 46.

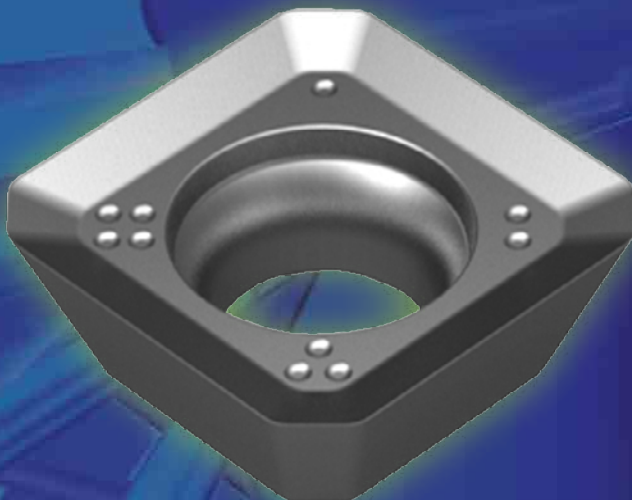


Application Guide

See the back of the box for speeds and feeds.

Alu-Milling Inserts

LT 05 Alu-Milling



Attacking Heat & Vibration is in Our DNA.



ADKT

AOMT

APKT

APMT

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ODMT

ODMW

OFER

OFMT

PNEG

RDMT

RDMW

RDMX

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SDMT

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A P E T



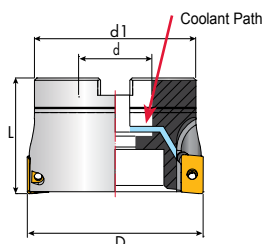
A P E X

Part No.	Description	Grade	I	s	r	Direction	Stock
3151232	APET 160402 LH	101	0.704	0.227	0.008	Neutral	●
3151236	APEX 100304 PDFR F01 HP	5005	0.393	0.125	0.016	Right	●
3151239	APEX 1604 PDFR F01 HP	GH05	0.704	0.227	Sharp	Right	●

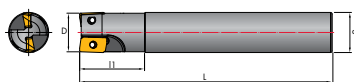
● Stocking

○ Non-stocking

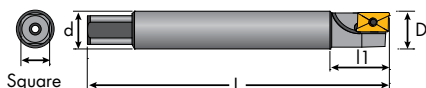
Face Mill for AP __. See page 30.



End Mill for AP __. See page 44.



PowerLOC End Mill for AP __ 1003. See page 45.



Application Guide

See the back of the box for speed and feed information.





A

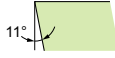
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G

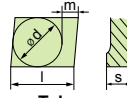
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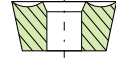
Shape



Clearance Angle



Tolerance

 $d \pm 0.001$
 $m \pm 0.001$
 $s \pm 0.005$

Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
1506501	APGT 1003 PDER ALU	LT 05	0.409	0.136	0.022	Right	●
1506505	APGT 1604 PDER ALU	LT 05	0.606	0.187	0.037	Right	●

● Stocking

○ Non-stocking

Face Milling Insert with 90° Lead Angle

For cutter bodies, see page 30, page 44, and page 50.

Highly positive inserts with a unique coating and 90° lead angle for Aluminium.
Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



Slotting



Shoulder Milling



Facing



APGT 1003 PDER ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
NF	Al (<8%Si)	13	21, 22	Si < 4 %	0.012	0.354	0.005	0.008	1320	3960	0.118	0.006	1650
			23, 24	4% < Si < 8 %		0.354	0.004	0.007	825	1980			1320
	Cooper Alloys	14	26, 27, 28	CuZn30	0.012	0.354	0.004	0.007	330	2640	0.118	0.006	990
			29	Fiber Plastics		0.354		0.008	264	1650			660
	Non-Metallic	15	30	Hard Rubber	0.012	0.354	0.005	0.008	264	990	0.118	0.005	495
			-	Graphite		0.354		0.008	330	660			495
H.T.A.	Ti based Alloys	10	36	Ti 1	0.012	0.197	0.003	0.008	115.5	198	0.079	0.005	148.5
			37	TiAl 6 V4		0.197		0.006	92.4	148.5			115.5

APGT 1604 PDER ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
NF	Al (<8%Si)	13	21, 22	Si < 4 %	0.020	0.591	0.006	0.013	1320	3960	0.157	0.006	1650
			23, 24	4% < Si < 8 %		0.591	0.005	0.011	825	1980			1320
	Cooper Alloys	14	26, 27, 28	CuZn30	0.020	0.591	0.005	0.011	330	2640	0.157	0.006	990
			29	Fiber Plastics		0.591		0.013	264	1650			660
	Non-Metallic	15	30	Hard Rubber	0.020	0.591	0.006	0.013	264	990	0.157	0.005	495
			-	Graphite		0.591		0.013	330	660			495
H.T.A.	Ti based Alloys	10	36	Ti 1	0.020	0.591	0.004	0.013	115.5	198	0.157	0.005	148.5
			37	TiAl 6 V4		0.591		0.009	92.4	148.5			115.5



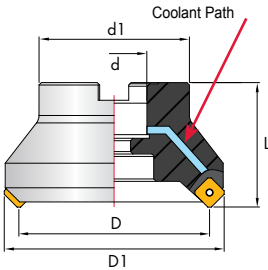


SEET

Part No.	Description	Grade	l	s	r	Direction	Stock
3251239	SEET 13T3 HP	WSK10	0.528	0.158	Chamfer	Neutral	●

Face Mill for SEET. See page 31.

- Stocking
- Non-stocking
- HP = High Polish

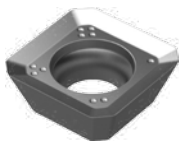


Fits in cutter bodies that take the 12T3 insert.

Application Guide

See the back of the box for speeds and feeds.

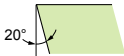




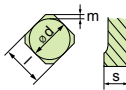
S E G T



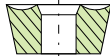
Shape



Clearance Angle



Tolerance
d ± 0.001
m ± 0.001
s ± 0.005



Fixing
Chip breaker

Part No.	Description	Grade	l	s	r	Direction	Stock
2506509	SEGT 1204 AFEN ALU	LT 05	0.500	0.187	-	Neutral	●

Face Milling Insert with 45° Lead Angle

- Stocking
- Non-stocking

Highly positive inserts with a unique coating and 90° lead angle for Aluminium.
Suitable for Roughing to Finishing-Slotting, Shoulder and Face Milling operations.

Application Guide



SEGT 1204 AFEN ALU LT 05

Material Group	Gr. No.	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V _c [sfm]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C.	Feed	V _c
Al (<8%Si)	13	21, 22	Si < 4 %	60 HB	0.012	0.354	0.005	0.014	1320	3960	0.118	0.010	1650
		23, 24	4% < Si < 8 %	100 HB		0.354	0.004	0.014	825	1980			1320
	14	26, 27, 28	CuZn30	100 HB	0.012	0.354	0.004	0.014	330	2640	0.118	0.010	990
		29	Fiber Plastics	-		0.354		0.014	264	1650			660
Non-Metallic	15	30	Hard Rubber	-	0.012	0.354	0.005	0.014	264	990	0.118	0.008	495
		-	Graphite	-		0.354		0.014	330	660			495
		-	-	-		0.354		0.014	330	660			495
Ti based Alloys	10	36	Ti 1	-	0.012	0.197	0.003	0.014	115.5	198	0.079	0.008	148.5
		37	TiAl 6 V4	-		0.197		0.011	92.4	148.5			115.5

ADKT

AOMT

APKT

APMT

LDMT

ODMT

ODMW

OFER

OFMT

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WPGT



APET

APEX

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