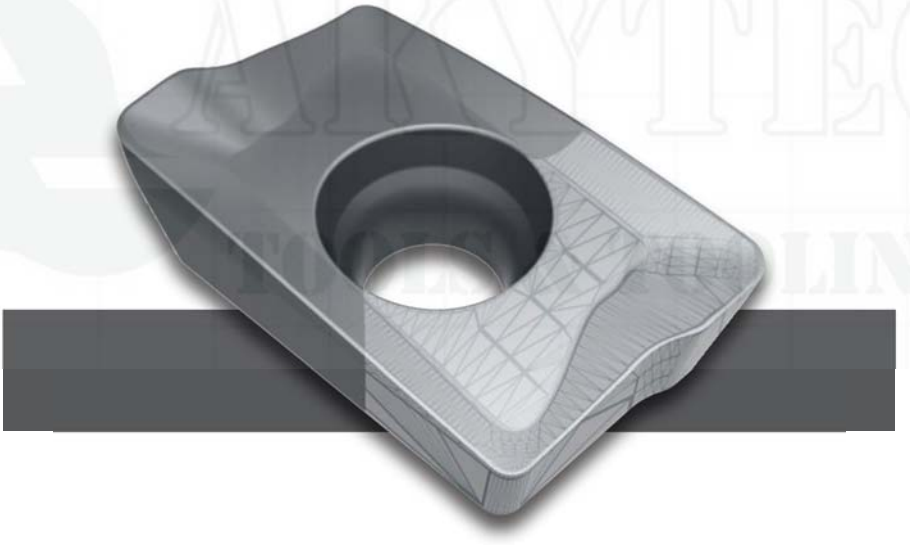
MILLING

LT 30 I LT 3000



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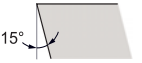
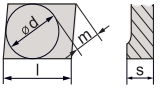
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

A D K T

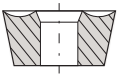
Shape



Clearance Angle



Tolerance
d ± 0.05
m ± 0.013
s ± 0.025



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
ADKT 1505 PDTR LT 30	15.75	5.63	0.96	Right	M0001573

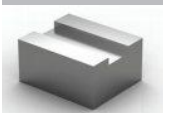
LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
ADKT 1505 PDTR LT 3000	15.75	5.63	0.96	Right	M0002209

Application Guide

Helical Interpolation

Shoulder Mill

Slotting



Surfacing

Ramping Down

Plunging

Pocket Milling

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel
V_C

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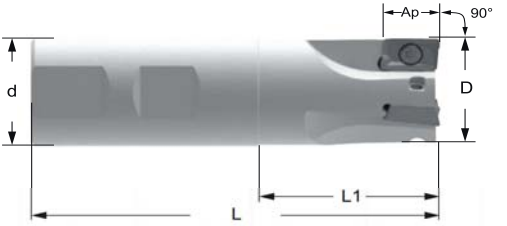
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for ADKT 1505 PDTR								
Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 790 W-W-D025/2*	25	25	44	100	15	2	5	M2001613
LT 790 W-W-D032/3*	32	32	50	110	15	3	3	M2001503
LT 790 W-W-D040/4*	40	32	45	115	15	4	2.5	M2001614

* On request

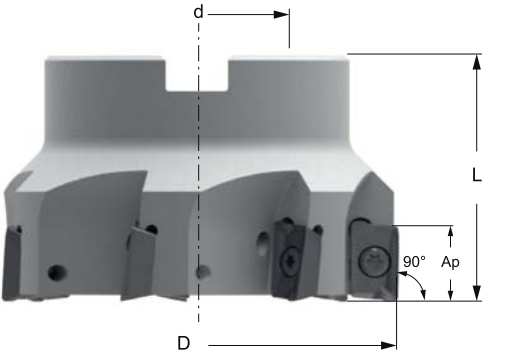
Screw: M2000597
Key: M2000602



Shell Mill for ADKT 1505 PDTR							
Cutter Designation	D	d	L	Ap	z	α	Catalog Nr.
LT 790 M-W-D040/4*	40	16	40	15	4	2.5	M2001615
LT 790 M-W-D050/5*	50	22	40	15	5	2.2	M2001504
LT 790 M-W-D063/6*	63	22	40	15	6	1.8	M2001616
LT 790 M-W-D080/7*	80	27	50	15	7	1.4	M2001617
LT 790 M-W-D100/8*	100	32	50	15	8	1.1	M2001618
LT 790 M-W-D125/9*	125	40	63	15	9	0.8	M2001619

* On request

Screw: M2000597
Key: M2000602

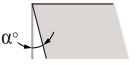


ADKT 1505 – **LT 30 | LT 3000**

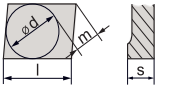
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	14.0	0.18	0.32	190	330	**4.0**	**0.23**	**250**
			2		190 HB	0.5	14.0	0.18	0.32	190	300	**4.0**	**0.23**	**220**
			3		250 HB	0.5	14.0	0.18	0.32	190	250	**4.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	14.0	0.15	0.25	150	240	**4.0**	**0.20**	**200**
			4,6		230 HB	0.5	14.0	0.15	0.25	150	210	**4.0**	**0.20**	**180**
			5,7		280 HB	0.5	14.0	0.15	0.22	130	190	**4.0**	**0.18**	**150**
			8		350 HB	0.5	14.0	0.15	0.22	130	170	**4.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.0	0.12	0.22	90	150	**3.0**	**0.18**	**130**
			10		280 HB	0.5	10.0	0.12	0.22	90	130	**3.0**	**0.18**	**120**
			11		320 HB	0.5	10.0	0.12	0.18	60	110	**3.0**	**0.16**	**100**
			11		350 HB	0.5	10.0	0.12	0.18	60	90	**3.0**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	14.0	0.15	0.25	190	250	**4.0**	**0.20**	**220**
			14		240 HB	0.5	14.0	0.12	0.22	160	210	**4.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.0	0.12	0.18	70	130	**3.0**	**0.16**	**100**
			14		310 HB	0.5	10.0	0.12	0.18	70	120	**3.0**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	14.0	0.15	0.25	150	210	**4.0**	**0.20**	**190**
			13		42 HRc	0.5	10.0	0.15	0.20	90	150	**3.0**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	14.0	0.18	0.32	150	240	**4.0**	**0.23**	**200**
			15		200 HB	0.5	14.0	0.18	0.32	150	220	**4.0**	**0.23**	**180**
			16		250 HB	0.5	14.0	0.18	0.32	150	190	**4.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	14.0	0.15	0.28	100	200	**4.0**	**0.20**	**180**
			17,19		200 HB	0.5	14.0	0.15	0.28	100	180	**4.0**	**0.20**	**150**
			18,20		250 HB	0.5	14.0	0.15	0.28	100	150	**4.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.0	0.12	0.20	40	65	**3.0**	**0.18**	**55**
			37	T40	-	0.5	10.0	0.12	0.18	30	55	**3.0**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.0	0.10	0.18	40	80	**2.0**	**0.14**	**60**
			38		50 HRc	0.5	3.0	0.10	0.16	40	70	**1.5**	**0.13**	**55**
			38		55 HRc	0.5	1.5	0.10	0.14	40	60	**1.0**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.0	0.10	0.18	40	80	**1.5**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.14	30	60	**1.0**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	14.0	0.18	0.32	200	400	**4.0**	**0.25**	**280**

A O M T

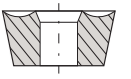
Shape



Clearance Angle
α = Special



Tolerance
d ± 0.05
m ± 0.08
s ± 0.13



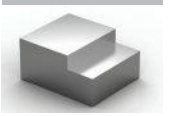
Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
AOMT 123608 PETR LT 30	11.93	3.62	0.7	Right	M0001640

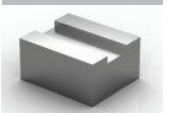
Application Guide

Helical Interpolation

Shoulder Milling



Slotting



Surfacing

Ramping Down

Plunging

Pocket Milling

Machining Recommendations

F ⇒
Productivity

Coolant

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

Stainless Steel
V_c

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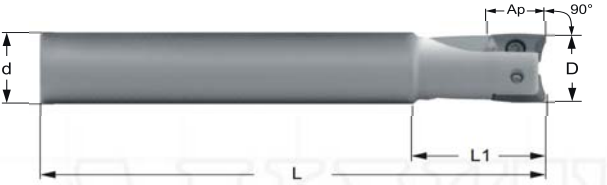
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for AOMT 123608 PETR								
Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 720 W-W-D016/2*	16	16	22	85	10	2	12	M2001781
LT 720 W-W-D020/3*	20	20	25	90	10	3	7	M2001782
LT 720 W-W-D025/3*	25	25	25	95	10	3	5	M2001783
LT 720 W-W-D025/4*	25	25	25	95	10	4	5	M2001819
LT 720 W-W-D032/5*	32	32	25	95	10	5	3	M2001784

* On request

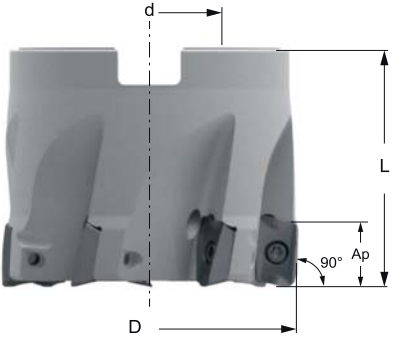
Screw: M2002181
Key: M2000601



Shell Mill for AOMT 123608 PETR							
Cutter Designation	D	d	L	Ap	z	α	Catalog Nr.
LT 720 M-W-D040/6*	40	22	40	10	6	2.5	M2001785
LT 720 M-W-D050/7*	50	22	40	10	7	2.2	M2001821

* On request

Screw: M2002181
Key: M2000601



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тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

AOMT 123608 PETR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	11.0	0.13	0.22	190	330	**2.0**	**0.15**	**250**
			2		190 HB	0.5	11.0	0.13	0.22	190	300	**2.0**	**0.15**	**220**
			3		250 HB	0.5	11.0	0.13	0.22	190	250	**2.0**	**0.15**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	11.0	0.11	0.18	150	240	**2.0**	**0.13**	**200**
			4,6		230 HB	0.5	11.0	0.11	0.18	150	210	**2.0**	**0.13**	**180**
			5,7		280 HB	0.5	11.0	0.11	0.15	130	190	**2.0**	**0.12**	**150**
			8		350 HB	0.5	11.0	0.11	0.15	130	170	**2.0**	**0.12**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	7.9	0.08	0.15	90	150	**1.5**	**0.12**	**130**
			10		280 HB	0.5	7.9	0.08	0.15	90	130	**1.5**	**0.12**	**120**
			11		320 HB	0.5	7.9	0.08	0.13	60	110	**1.5**	**0.10**	**100**
			11		350 HB	0.5	7.9	0.08	0.13	60	90	**1.5**	**0.10**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	11.0	0.11	0.18	190	250	**2.0**	**0.13**	**220**
			14		240 HB	0.5	11.0	0.08	0.15	160	210	**2.0**	**0.13**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	7.9	0.08	0.13	70	130	**1.5**	**0.10**	**100**
			14		310 HB	0.5	7.9	0.08	0.13	70	120	**1.5**	**0.10**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	11.0	0.11	0.18	150	210	**2.0**	**0.13**	**190**
			13		42 HRc	0.5	7.9	0.08	0.14	90	150	**1.5**	**0.10**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	11.0	0.13	0.22	150	240	**2.0**	**0.15**	**200**
			15		200 HB	0.5	11.0	0.13	0.22	150	220	**2.0**	**0.15**	**180**
			16		250 HB	0.5	11.0	0.13	0.22	150	190	**2.0**	**0.15**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	11.0	0.11	0.20	100	200	**2.0**	**0.13**	**180**
			17,19		200 HB	0.5	11.0	0.11	0.20	100	180	**2.0**	**0.13**	**150**
			18,20		250 HB	0.5	11.0	0.11	0.20	100	150	**2.0**	**0.13**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	7.9	0.08	0.13	25	45	**1.5**	**0.10**	**32**
			33	Inconel 700	250 HB	0.5	7.9	0.08	0.13	25	45	**1.5**	**0.10**	**30**
			34	Stellite 21	350 HB	0.5	7.9	0.08	0.13	25	45	**1.5**	**0.10**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	7.9	0.08	0.14	40	65	**1.5**	**0.12**	**55**
			37	T40	-	0.5	7.9	0.08	0.13	30	55	**1.5**	**0.10**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.9	0.07	0.13	40	80	**1.0**	**0.09**	**60**
			38		50 HRc	0.5	2.4	0.07	0.11	40	70	**0.8**	**0.08**	**55**
			38		55 HRc	0.5	1.2	0.07	0.10	40	60	**0.5**	**0.08**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	3.1	0.07	0.13	40	80	**0.8**	**0.09**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.2	0.07	0.10	30	60	**0.5**	**0.08**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	11.0	0.13	0.22	200	400	**2.0**	**0.16**	**280**

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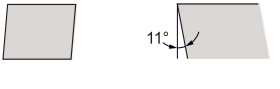


Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

Tolerance
d ± 0.05
m ± 0.013
s ± 0.025

LT 30 Multi-Mat™ General Usage – Standard

Insert Designation	l	s	r	Direction	Catalog Nr.
APKT 060204 PDTR LT 30	06.00	2.16	0.40	Right	M0003885
APKT 100304 PDTR LT 30	10.39	3.53	0.40	Right	M0002920
APKT 1003 PDTR LT 30	10.39	3.53	0.80	Right	M0002918
APKT 100312 PDTR LT 30	10.39	3.53	1.20	Right	M0002921
APKT 100316 PDTR LT 30	10.39	3.53	1.60	Right	M0003094
APKT 100332 PDTR LT 30	10.39	3.53	3.20	Right	M0002922
APKT 100340 PDTR LT 30	10.39	3.53	4.00	Right	M0002923
APKT 1604 PDTR LT 30 (NEW)	15.3	4.76	0.80	Right	M0000022
APKT 1604 PDTR LT 30	15.3	4.76	0.95	Right	M0000021
APKT 160416 PDTR LT 30	15.3	4.76	1.60	Right	M0000172
APKT 160424 PDTR LT 30	15.3	4.76	2.40	Right	M0003833
APKT 160432 PDTR LT 30	15.3	4.76	3.20	Right	M0001569
APKT 1705 PETR LT 30	17.48	5.12	0.80	Right	M0001810

Application Guide

Helical Interpolation

Plunging

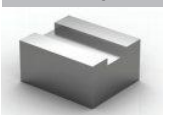
Pocket Milling

Surfacing

Ramping Down

Shoulder Milling

Slotting



Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

A P K T

LT 3000 Multi-Mat™ General Usage – Premium

Insert Designation	l	s	r	Direction	Catalog Nr.
APKT 060204 PDTR LT 3000	6.00	2.16	0.40	Right	M0004026
APKT 100304 PDTR LT 3000	10.39	3.53	0.40	Right	M0003389
APKT 1003 PDTR LT 3000	10.39	3.53	0.80	Right	M0003388
APKT 100312 PDTR LT 3000	10.39	3.53	1.20	Right	M0003391
APKT 100316 PDTR LT 3000	10.39	3.53	1.60	Right	M0003392
APKT 100332 PDTR LT 3000	10.39	3.53	3.20	Right	M0003394
APKT 100340 PDTR LT 3000	10.39	3.53	4.00	Right	M0003395
APKT 1604 PDTR LT 3000 (NEW)	15.3	4.76	0.80	Right	M0002182
APKT 160416 PDTR LT 3000	15.3	4.76	1.60	Right	M0004027
APKT 160424 PDTR LT 3000	15.3	4.76	2.40	Right	M0004029
APKT 160432 PDTR LT 3000	15.3	4.76	3.20	Right	M0004030
APKT 1705 PETR LT 3000	17.48	5.12	0.80	Right	M0002212

Application Guide

Helical Interpolation

Plunging

Pocket-Milling

Surfacing

Ramping Down

Shoulder Milling

Slotting

Machining Recommendations

F ⇒

Productivity

Coolant

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

Stainless Steel

V_C

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for APKT 060204

Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 751 C-W-D010/2	10	10	22	72	5.2	2	10	M2003066
LT 751 CL-W-D010/2	10	10	40	100	5.2	2	10	M2003067
LT 751 CL-W-D012/2	12	12	45	110	5.2	2	7.5	M2003068
LT 751 C-W-D012/3	12	12	26	80	5.2	3	7.5	M2003069
LT 751 CL-W-D016/3	16	16	50	120	5.2	3	4	M2003070
LT 751 C-W-D016/4	16	16	32	90	5.2	4	4	M2003071
LT 751 C-W-D020/5	20	20	40	100	5.2	5	2.5	M2003072
LT 751 C-W-D025/7*	25	20	40	120	5.2	7	1.5	M2003073
LT 751 C-W-D032/8*	32	25	40	130	5.2	8	1	M2003074
LT 751 C-W-D040/10*	40	32	40	140	5.2	10	1	M2003075

* On request

Screw: M2001640
Key: M2003064

End Mill for APKT 100332/40 PDTR

Bezeichnung	D	d	L1	L	Ap	z	α	Katalognr.
LT 745 WL-W-D016/2*	16	16	35	150	9	2	10	M0001849
LT 745 W-W-D016/2*	16	16	25	100	9	2	10	M2001587
LT 745 W-W-D018/2*	18	20	30	100	9	2	8	M0001588
LT 745 WL-W-D020/3*	20	20	35	150	9	3	7	M0001850
LT 745 W-W-D020/3*	20	20	30	100	9	3	7	M0001589
LT 745 W-W-D022/3*	22	20	30	100	9	3	7	M2001590
LT 745 WL-W-D025/4*	25	25	40	200	9	4	5	M0001851
LT 745 W-W-D025/3*	25	25	30	120	9	3	5	M0001591
LT 745 W-W-D028/4*	28	25	30	120	9	4	-	M2001593
LT 745 W-W-D030/4*	30	25	30	120	9	4	-	M2001594
LT 745 WL-W-D032/4*	32	32	40	200	9	4	3	M2001852
LT 745 W-W-D032/5*	32	32	30	120	9	5	3	M2001848

* On request

Screw: M2002181
Key: M2000601

Shell Mill for APKT 100332/40 PDTR

Bezeichnung	D	d	L	Ap	z	Katalognr.
LT 745 M-W-D040/6	40	22	40	9	6	M2001580
LT 745 M-W-D050/7	50	22	40	9	7	M2001581
LT 745 M-W-D063/8	63	22	40	9	8	M2001582
LT 745 M-W-D080/11	80	27	50	9	10	M2001583

* On request

Screw: M2002181
Key: M2000601

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

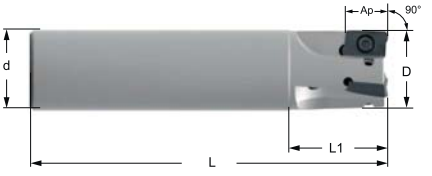
End Mill for APKT 1003 PDTR

Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 741 C-W-D010/1*	10	10	24	80	9	1	5	M2002802
LT 741 CL-W-D010/1*	10	16	32	150	9	1	5	M2002815
LT 741 C-W-D012/1*	12	12	24	80	9	1	5	M2002803
LT 741 CL-W-D012/1*	12	16	32	150	9	1	5	M2002816
LT 741 C-W-D014/1*	14	16	24	80	9	1	5	M2002804
LT 741 C-W-D016/2	16	16	25	100	9	2	12	M2002806
LT 741 CL-W-D016/2	16	16	40	150	9	2	12	M2002817
LT 741 C-W-D018/2	18	20	30	85	9	2	12	M2002807
LT 741 C-W-D020/3	20	20	25	100	9	3	7	M2002808
LT 741 CL-W-D020/3	20	20	40	150	9	3	7	M2002818
LT 741 C-W-D022/3	22	20	25	95	9	3	7	M2002809
LT 741 C-W-D025/3	25	25	32	120	9	3	5	M2002810
LT 741 C-W-D025/4	25	25	32	120	9	4	5	M2002811
LT 741 CL-W-D025/4	25	25	40	200	9	4	5	M2002819
LT 741 C-W-D028/4	28	25	32	120	9	4	2	M2002812
LT 741 C-W-D030/4	30	25	32	95	9	4	2	M2002813
LT 741 W-W-D032/5	32	32	32	95	9	5	3	M2002814
LT 741 WL-W-D032/4	32	32	32	200	9	4	3	M2002820

* On request

Screw: M2002181
Key: M2000601

C



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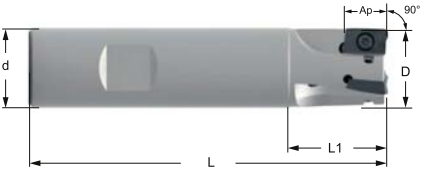
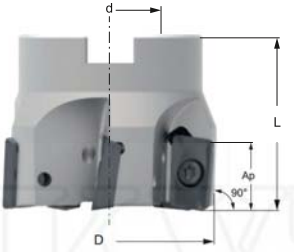


Shell Mill for APKT 1003 PDTR							
Cutter Designation	D	d	L	Ap	z	α	Catalog Nr.
LT 741 M-W-D040/6	40	16	40	9	6	2.5	M2002798
LT 741 M-W-D050/7	50	22	40	9	7	2.2	M2002799
LT 741 M-W-D063/8	63	22	40	9	8	1.8	M2002800
LT 741 M-W-D080/11*	80	27	50	9	10	1.4	M2002801

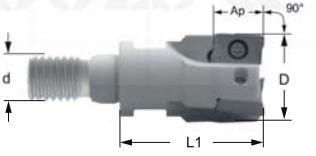
* On request

Screw: M2002181
Key: M2000601



Screw Coupling for APKT 1003 PDTR							
Cutter Designation	D	d	L1	Ap	z	α	Catalog Nr.
LT 741 S-W-D016/2	16	M8	25	9	2	12	M2002962
LT 741 S-W-D020/3	20	M10	30	9	3	7	M2002963
LT 741 S-W-D025/4	25	M12	35	9	4	5	M2002964

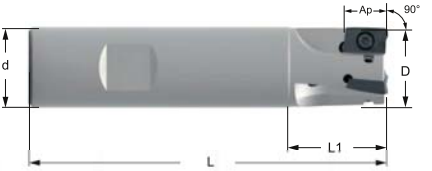
Screw: M2002181
Key: M2000601



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for APKT 1604 PDTR								
Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 731 WL-W-D025/2	25	25	90	220	15	2	5	M2002965
LT 731 W-W-D025/2	25	25	44	100	15	2	5	M2002966
LT 731 WL-W-D032/3	32	32	90	220	15	3	3	M2002967
LT 731 W-W-D032/3	32	32	50	110	15	3	3	M2002968
LT 731 WL-W-D040/4	40	32	90	220	15	4	2.5	M2002969
LT 731 W-W-D040/4	40	32	50	115	15	4	2.5	M2002970

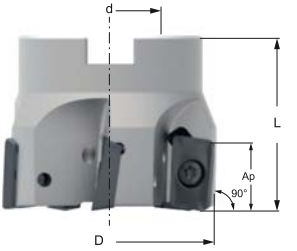
Screw: M2000597
Key: M2000602



Shell Mill for APKT 1604 PDTR							
Cutter Designation	D	d	L	Ap	z	α	Catalog Nr.
LT 731 M-W-D040/4	40	16	40	15	4	2.5	M2002971
LT 731 M-W-D050/5	50	22	40	15	5	2.2	M2002972
LT 731 M-W-D063/6	63	22	40	15	6	1.8	M2002973
LT 731 M-W-D080/7	80	27	50	15	7	1.4	M2002974
LT 731 M-W-D100/8	100	32	50	15	8	1.4	M2002975
LT 731 M-W-D125/9	125	40	63	15	9	0.8	M2002976
LT 731 M-W-D160/10*	160	40	63	15	10	-	M2002977

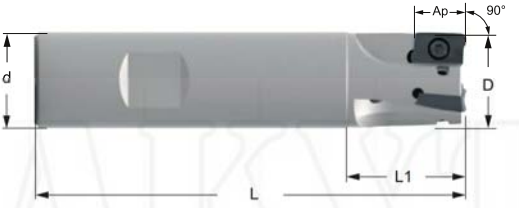
* On request

Screw: M2000597
Key: M2000602



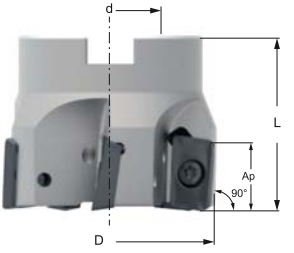
End Mill for APKT 1705 PETR									
Cutter Designation	D	D1	d	L1	L	Ap	z	α	Catalog Nr.
LT 737 W-W-D025/2	25	25	20	32	100	16	2	5	M2001833
LT 737 WL-W-D025/2	25	25	25	40	210	16	2	5	M2001836
LT 737 W-W-D032/3	32	32	32	40	110	16	3	3	M2001834
LT 737 WL-W-D032/3	32	32	32	65	200	16	3	3	M2001837
LT 737 W-W-D040/4	40	40	32	45	115	16	4	2.5	M2001835
LT 737 WL-W-D040/4	40	40	32	45	115	16	4	2.5	M2001982

Screw: M2000597
Key: M2000602



Shell Mill for APKT 1705 PETR								
Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 737 M-W-D040/4	40	40	16	40	16	4	2.5	M2001838
LT 737 M-W-D050/5	50	50	22	40	16	5	2.2	M2001839
LT 737 M-W-D063/6	63	63	22	40	16	6	1.8	M2001841
LT 737 M-W-D080/7	80	80	27	50	16	7	1.4	M2001842
LT 737 M-W-D100/7	100	100	32	50	16	7	1.4	M2001843
LT 737 M-W-D125/9	125	125	40	63	16	9	0.8	M2001844
LT 737 M-W-D160/10	160	160	40	63	16	10	-	M2001845

Screw: M2000597
Key: M2000602



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

APKT 060204 PDTR – LT 30 | LT3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.3	5.5	0.04	0.13	190	330	**1.3**	**0.07**	**250**
			2		190 HB	0.3	5.5	0.04	0.13	190	300	**1.3**	**0.07**	**220**
			3		250 HB	0.3	5.5	0.04	0.13	190	250	**1.3**	**0.07**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.3	5.5	0.03	0.10	150	240	**1.3**	**0.06**	**200**
			4,6		230 HB	0.3	5.5	0.03	0.10	150	210	**1.3**	**0.06**	**180**
			5,7		280 HB	0.3	5.5	0.03	0.09	130	190	**1.3**	**0.05**	**150**
			8		350 HB	0.3	5.5	0.03	0.09	130	170	**1.3**	**0.05**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	3.9	0.03	0.09	90	150	**1.0**	**0.05**	**130**
			10		280 HB	0.3	3.9	0.03	0.09	90	130	**1.0**	**0.05**	**120**
			11		320 HB	0.3	3.9	0.03	0.07	60	110	**1.0**	**0.05**	**100**
			11		350 HB	0.3	3.9	0.03	0.07	60	90	**1.0**	**0.05**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.3	5.5	0.03	0.10	190	250	**1.3**	**0.06**	**220**
			14		240 HB	0.3	5.5	0.03	0.09	160	210	**1.3**	**0.06**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.3	3.9	0.03	0.07	70	130	**1.0**	**0.05**	**100**
			14		310 HB	0.3	3.9	0.03	0.07	70	120	**1.0**	**0.05**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	5.5	0.03	0.10	150	210	**1.3**	**0.06**	**190**
			13		42 HRc	0.3	3.9	0.03	0.08	90	150	**1.0**	**0.05**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	5.5	0.04	0.13	150	240	**1.3**	**0.07**	**200**
			15		200 HB	0.3	5.5	0.04	0.13	150	220	**1.3**	**0.07**	**180**
			16		250 HB	0.3	5.5	0.04	0.13	150	190	**1.3**	**0.07**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.3	5.5	0.03	0.11	100	200	**1.3**	**0.06**	**180**
			17,19		200 HB	0.3	5.5	0.03	0.11	100	180	**1.3**	**0.06**	**150**
			18,20		250 HB	0.3	5.5	0.03	0.11	100	150	**1.3**	**0.06**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.3	3.9	0.03	0.07	25	45	**1.0**	**0.05**	**32**
			33	Inconel 700	250 HB	0.3	3.9	0.03	0.07	25	45	**1.0**	**0.05**	**30**
			34	Stellite 21	350 HB	0.3	3.9	0.03	0.07	25	45	**1.0**	**0.05**	**30**
	Ti Based	10	36	TiAl6V4	-	0.3	3.9	0.03	0.08	40	65	**1.0**	**0.05**	**55**
			37	T40	-	0.3	3.9	0.03	0.07	30	55	**1.0**	**0.05**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	2.0	0.02	0.07	40	80	**0.7**	**0.04**	**60**
			38		50 HRc	0.3	1.2	0.02	0.06	40	70	**0.5**	**0.04**	**55**
			38		55 HRc	0.3	0.6	0.02	0.06	40	60	**0.3**	**0.04**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	1.6	0.02	0.07	40	80	**0.5**	**0.04**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.02	0.06	30	60	**0.3**	**0.04**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.3	5.5	0.04	0.13	200	400	**1.3**	**0.08**	**280**

APKT 1003 PDTR – LT 30 | LT3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.13	0.26	190	330	**2.0**	**0.17**	**250**
			2		190 HB	0.5	9.0	0.13	0.26	190	300	**2.0**	**0.17**	**220**
			3		250 HB	0.5	9.0	0.13	0.26	190	250	**2.0**	**0.17**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.21	150	240	**2.0**	**0.15**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.21	150	210	**2.0**	**0.15**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.18	130	190	**2.0**	**0.13**	**150**
			8		350 HB	0.5	9.0	0.11	0.18	130	170	**2.0**	**0.13**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.18	90	150	**1.5**	**0.13**	**130**
			10		280 HB	0.5	6.4	0.08	0.18	90	130	**1.5**	**0.13**	**120**
			11		320 HB	0.5	6.4	0.08	0.15	60	110	**1.5**	**0.12**	**100**
			11		350 HB	0.5	6.4	0.08	0.15	60	90	**1.5**	**0.12**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.21	190	250	**2.0**	**0.15**	**220**
			14		240 HB	0.5	9.0	0.08	0.18	160	210	**2.0**	**0.15**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.15	70	130	**1.5**	**0.12**	**100**
			14		310 HB	0.5	6.4	0.08	0.15	70	120	**1.5**	**0.12**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.21	150	210	**2.0**	**0.15**	**190**
			13		42 HRc	0.5	6.4	0.11	0.16	90	150	**1.5**	**0.12**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.26	150	240	**2.0**	**0.17**	**200**
			15		200 HB	0.5	9.0	0.13	0.26	150	220	**2.0**	**0.17**	**180**
			16		250 HB	0.5	9.0	0.13	0.26	150	190	**2.0**	**0.17**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.23	100	200	**2.0**	**0.15**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.23	100	180	**2.0**	**0.15**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.23	100	150	**2.0**	**0.15**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.08	0.15	25	45	**1.5**	**0.12**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.08	0.15	25	45	**1.5**	**0.12**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.08	0.15	25	45	**1.5**	**0.12**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.08	0.16	40	65	**1.5**	**0.13**	**55**
			37	T40	-	0.5	6.4	0.08	0.15	30	55	**1.5**	**0.12**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.07	0.15	40	80	**1.0**	**0.10**	**60**
			38		50 HRc	0.5	1.9	0.07	0.13	40	70	**0.8**	**0.09**	**55**
			38		55 HRc	0.5	1.0	0.07	0.11	40	60	**0.5**	**0.09**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.07	0.15	40	80	**0.8**	**0.10**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.07	0.11	30	60	**0.5**	**0.09**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.26	200	400	**2.0**	**0.18**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

APKT 100304 PDTR – **LT 30 | LT3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.11	0.20	190	330	**2.0**	**0.14**	**250**
			2		190 HB	0.5	9.0	0.11	0.20	190	300	**2.0**	**0.14**	**220**
			3		250 HB	0.5	9.0	0.11	0.20	190	250	**2.0**	**0.14**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.09	0.16	150	240	**2.0**	**0.12**	**200**
			4,6		230 HB	0.5	9.0	0.09	0.16	150	210	**2.0**	**0.12**	**180**
			5,7		280 HB	0.5	9.0	0.09	0.14	130	190	**2.0**	**0.11**	**150**
			8		350 HB	0.5	9.0	0.09	0.14	130	170	**2.0**	**0.11**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.07	0.14	90	150	**1.5**	**0.11**	**130**
			10		280 HB	0.5	6.4	0.07	0.14	90	130	**1.5**	**0.11**	**120**
			11		320 HB	0.5	6.4	0.07	0.11	60	110	**1.5**	**0.10**	**100**
			11		350 HB	0.5	6.4	0.07	0.11	60	90	**1.5**	**0.10**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.09	0.16	190	250	**2.0**	**0.12**	**220**
			14		240 HB	0.5	9.0	0.07	0.14	160	210	**2.0**	**0.12**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.07	0.11	70	130	**1.5**	**0.10**	**100**
			14		310 HB	0.5	6.4	0.07	0.11	70	120	**1.5**	**0.10**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.09	0.16	150	210	**2.0**	**0.12**	**190**
			13		42 HRc	0.5	6.4	0.09	0.12	90	150	**1.5**	**0.10**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.11	0.20	150	240	**2.0**	**0.14**	**200**
			15		200 HB	0.5	9.0	0.11	0.20	150	220	**2.0**	**0.14**	**180**
			16		250 HB	0.5	9.0	0.11	0.20	150	190	**2.0**	**0.14**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.09	0.17	100	200	**2.0**	**0.12**	**180**
			17,19		200 HB	0.5	9.0	0.09	0.17	100	180	**2.0**	**0.12**	**150**
			18,20		250 HB	0.5	9.0	0.09	0.17	100	150	**2.0**	**0.12**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.07	0.11	25	45	**1.5**	**0.10**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.07	0.11	25	45	**1.5**	**0.10**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.07	0.11	25	45	**1.5**	**0.10**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.07	0.12	40	65	**1.5**	**0.11**	**55**
			37	T40	-	0.5	6.4	0.07	0.11	30	55	**1.5**	**0.10**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.06	0.11	40	80	**1.0**	**0.09**	**60**
			38		50 HRc	0.5	1.9	0.06	0.10	40	70	**0.8**	**0.08**	**55**
			38		55 HRc	0.5	1.0	0.06	0.09	40	60	**0.5**	**0.07**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.06	0.11	40	80	**0.8**	**0.09**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.06	0.09	30	60	**0.5**	**0.07**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.11	0.20	200	400	**2.0**	**0.16**	**280**

APKT 100312 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.13	0.28	190	330	**2.0**	**0.20**	**250**
			2		190 HB	0.5	9.0	0.13	0.28	190	300	**2.0**	**0.20**	**220**
			3		250 HB	0.5	9.0	0.13	0.28	190	250	**2.0**	**0.20**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.22	150	240	**2.0**	**0.18**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.22	150	210	**2.0**	**0.18**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.19	130	190	**2.0**	**0.16**	**150**
			8		350 HB	0.5	9.0	0.11	0.19	130	170	**2.0**	**0.16**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.19	90	150	**1.5**	**0.16**	**130**
			10		280 HB	0.5	6.4	0.08	0.19	90	130	**1.5**	**0.16**	**120**
			11		320 HB	0.5	6.4	0.08	0.16	60	110	**1.5**	**0.14**	**100**
			11		350 HB	0.5	6.4	0.08	0.16	60	90	**1.5**	**0.14**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.22	190	250	**2.0**	**0.18**	**220**
			14		240 HB	0.5	9.0	0.08	0.19	160	210	**2.0**	**0.18**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.16	70	130	**1.5**	**0.14**	**100**
			14		310 HB	0.5	6.4	0.08	0.16	70	120	**1.5**	**0.14**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.22	150	210	**2.0**	**0.18**	**190**
			13		42 HRc	0.5	6.4	0.11	0.18	90	150	**1.5**	**0.14**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.28	150	240	**2.0**	**0.20**	**200**
			15		200 HB	0.5	9.0	0.13	0.28	150	220	**2.0**	**0.20**	**180**
			16		250 HB	0.5	9.0	0.13	0.28	150	190	**2.0**	**0.20**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	**2.0**	**0.18**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.25	100	180	**2.0**	**0.18**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.25	100	150	**2.0**	**0.18**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.08	0.18	40	65	**1.5**	**0.16**	**55**
			37	T40	-	0.5	6.4	0.08	0.16	30	55	**1.5**	**0.14**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.07	0.16	40	80	**1.0**	**0.12**	**60**
			38		50 HRc	0.5	1.9	0.07	0.14	40	70	**0.8**	**0.11**	**55**
			38		55 HRc	0.5	1.0	0.07	0.12	40	60	**0.5**	**0.11**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.07	0.16	40	80	**0.8**	**0.12**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.07	0.12	30	60	**0.5**	**0.11**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.28	200	400	**2.0**	**0.22**	**280**

APKT 100316 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.13	0.28	190	330	**2.0**	**0.20**	**250**
			2		190 HB	0.5	9.0	0.13	0.28	190	300	**2.0**	**0.20**	**220**
			3		250 HB	0.5	9.0	0.13	0.28	190	250	**2.0**	**0.20**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.22	150	240	**2.0**	**0.18**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.22	150	210	**2.0**	**0.18**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.19	130	190	**2.0**	**0.16**	**150**
			8		350 HB	0.5	9.0	0.11	0.19	130	170	**2.0**	**0.16**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.19	90	150	**1.5**	**0.16**	**130**
			10		280 HB	0.5	6.4	0.08	0.19	90	130	**1.5**	**0.16**	**120**
			11		320 HB	0.5	6.4	0.08	0.16	60	110	**1.5**	**0.14**	**100**
			11		350 HB	0.5	6.4	0.08	0.16	60	90	**1.5**	**0.14**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.22	190	250	**2.0**	**0.18**	**220**
			14		240 HB	0.5	9.0	0.08	0.19	160	210	**2.0**	**0.18**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.16	70	130	**1.5**	**0.14**	**100**
			14		310 HB	0.5	6.4	0.08	0.16	70	120	**1.5**	**0.14**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.22	150	210	**2.0**	**0.18**	**190**
			13		42 HRc	0.5	6.4	0.11	0.18	90	150	**1.5**	**0.14**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.28	150	240	**2.0**	**0.20**	**200**
			15		200 HB	0.5	9.0	0.13	0.28	150	220	**2.0**	**0.20**	**180**
			16		250 HB	0.5	9.0	0.13	0.28	150	190	**2.0**	**0.20**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	**2.0**	**0.18**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.25	100	180	**2.0**	**0.18**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.25	100	150	**2.0**	**0.18**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.08	0.16	25	45	**1.5**	**0.14**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.08	0.18	40	65	**1.5**	**0.16**	**55**
			37	T40	-	0.5	6.4	0.08	0.16	30	55	**1.5**	**0.14**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.07	0.16	40	80	**1.0**	**0.12**	**60**
			38		50 HRc	0.5	1.9	0.07	0.14	40	70	**0.8**	**0.11**	**55**
			38		55 HRc	0.5	1.0	0.07	0.12	40	60	**0.5**	**0.11**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.07	0.16	40	80	**0.8**	**0.12**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.07	0.12	30	60	**0.5**	**0.11**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.28	200	400	**2.0**	**0.22**	**280**

APKT 100332 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.13	0.28	190	330	**1.0**	**0.29**	**250**
			2		190 HB	0.5	9.0	0.13	0.28	190	300	**1.0**	**0.29**	**220**
			3		250 HB	0.5	9.0	0.13	0.28	190	250	**1.0**	**0.29**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.22	150	240	**1.0**	**0.25**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.22	150	210	**1.0**	**0.25**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.19	130	190	**1.0**	**0.22**	**150**
			8		350 HB	0.5	9.0	0.11	0.19	130	170	**1.0**	**0.22**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.19	90	150	**1.0**	**0.22**	**130**
			10		280 HB	0.5	6.4	0.08	0.19	90	130	**1.0**	**0.22**	**120**
			11		320 HB	0.5	6.4	0.08	0.16	60	110	**1.0**	**0.20**	**100**
			11		350 HB	0.5	6.4	0.08	0.16	60	90	**1.0**	**0.20**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.22	190	250	**1.0**	**0.25**	**220**
			14		240 HB	0.5	9.0	0.08	0.19	160	210	**1.0**	**0.25**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.16	70	130	**1.0**	**0.20**	**100**
			14		310 HB	0.5	6.4	0.08	0.16	70	120	**1.0**	**0.20**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.22	150	210	**1.0**	**0.25**	**190**
			13		42 HRc	0.5	6.4	0.11	0.18	90	150	**1.0**	**0.20**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.28	150	240	**1.0**	**0.29**	**200**
			15		200 HB	0.5	9.0	0.13	0.28	150	220	**1.0**	**0.29**	**180**
			16		250 HB	0.5	9.0	0.13	0.28	150	190	**1.0**	**0.29**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	**1.0**	**0.25**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.25	100	180	**1.0**	**0.25**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.25	100	150	**1.0**	**0.25**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.08	0.16	25	45	**1.0**	**0.20**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.08	0.16	25	45	**1.0**	**0.20**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.08	0.16	25	45	**1.0**	**0.20**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.08	0.18	40	65	**1.0**	**0.22**	**55**
			37	T40	-	0.5	6.4	0.08	0.16	30	55	**1.0**	**0.20**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	3.2	0.07	0.16	40	80	**0.7**	**0.17**	**60**
			38		50 HRc	0.4	1.9	0.07	0.14	40	70	**0.7**	**0.16**	**55**
			38		55 HRc	0.4	1.0	0.07	0.12	40	60	**0.7**	**0.15**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	2.6	0.07	0.16	40	80	**0.7**	**0.17**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.07	0.12	30	60	**0.7**	**0.15**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.28	200	400	**1.0**	**0.31**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

APKT 100340 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.13	0.46	190	330	1.0	0.35	250
			2		190 HB	0.5	9.0	0.13	0.46	190	300	1.0	0.35	220
			3		250 HB	0.5	9.0	0.13	0.46	190	250	1.0	0.35	200
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.36	150	240	1.0	0.30	200
			4,6		230 HB	0.5	9.0	0.11	0.36	150	210	1.0	0.30	180
			5,7		280 HB	0.5	9.0	0.11	0.32	130	190	1.0	0.27	150
			8		350 HB	0.5	9.0	0.11	0.32	130	170	1.0	0.27	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.32	90	150	1.0	0.27	130
			10		280 HB	0.5	6.4	0.08	0.32	90	130	1.0	0.27	120
			11		320 HB	0.5	6.4	0.08	0.26	60	110	1.0	0.24	100
			11		350 HB	0.5	6.4	0.08	0.26	60	90	1.0	0.24	80
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.36	190	250	1.0	0.30	220
			14		240 HB	0.5	9.0	0.08	0.32	160	210	1.0	0.30	190
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.26	70	130	1.0	0.24	100
			14		310 HB	0.5	6.4	0.08	0.26	70	120	1.0	0.24	90
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.36	150	210	1.0	0.30	190
			13		42 HRc	0.5	6.4	0.11	0.29	90	150	1.0	0.24	130
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.46	150	240	1.0	0.35	200
			15		200 HB	0.5	9.0	0.13	0.46	150	220	1.0	0.35	180
			16		250 HB	0.5	9.0	0.13	0.46	150	190	1.0	0.35	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.41	100	200	1.0	0.30	180
			17,19		200 HB	0.5	9.0	0.11	0.41	100	180	1.0	0.30	150
			18,20		250 HB	0.5	9.0	0.11	0.41	100	150	1.0	0.30	130
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.08	0.26	25	45	1.0	0.24	32
			33	Inconel 700	250 HB	0.5	6.4	0.08	0.26	25	45	1.0	0.24	30
			34	Stellite 21	350 HB	0.5	6.4	0.08	0.26	25	45	1.0	0.24	30
	Ti Based	10	36	TiAl6V4	-	0.5	6.4	0.08	0.29	40	65	1.0	0.27	55
			37	T40	-	0.5	6.4	0.08	0.26	30	55	1.0	0.24	40
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	3.2	0.07	0.26	40	80	0.7	0.21	60
			38		50 HRc	0.4	1.9	0.07	0.23	40	70	0.7	0.20	55
			38		55 HRc	0.4	1.0	0.07	0.20	40	60	0.7	0.18	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	2.6	0.07	0.26	40	80	0.7	0.21	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.07	0.20	30	60	0.7	0.18	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.46	200	400	1.0	0.38	280

APKT 1604 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.18	0.32	190	330	**4.0**	**0.23**	**250**
			2		190 HB	0.5	15.0	0.18	0.32	190	300	**4.0**	**0.23**	**220**
			3		250 HB	0.5	15.0	0.18	0.32	190	250	**4.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.15	0.25	150	240	**4.0**	**0.20**	**200**
			4,6		230 HB	0.5	15.0	0.15	0.25	150	210	**4.0**	**0.20**	**180**
			5,7		280 HB	0.5	15.0	0.15	0.22	130	190	**4.0**	**0.18**	**150**
			8		350 HB	0.5	15.0	0.15	0.22	130	170	**4.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.22	90	150	**3.0**	**0.18**	**130**
			10		280 HB	0.5	10.7	0.12	0.22	90	130	**3.0**	**0.18**	**120**
			11		320 HB	0.5	10.7	0.12	0.18	60	110	**3.0**	**0.16**	**100**
			11		350 HB	0.5	10.7	0.12	0.18	60	90	**3.0**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.15	0.25	190	250	**4.0**	**0.20**	**220**
			14		240 HB	0.5	15.0	0.12	0.22	160	210	**4.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.18	70	130	**3.0**	**0.16**	**100**
			14		310 HB	0.5	10.7	0.12	0.18	70	120	**3.0**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.15	0.25	150	210	**4.0**	**0.20**	**190**
			13		42 HRc	0.5	10.7	0.15	0.20	90	150	**3.0**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.18	0.32	150	240	**4.0**	**0.23**	**200**
			15		200 HB	0.5	15.0	0.18	0.32	150	220	**4.0**	**0.23**	**180**
			16		250 HB	0.5	15.0	0.18	0.32	150	190	**4.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.15	0.28	100	200	**4.0**	**0.20**	**180**
			17,19		200 HB	0.5	15.0	0.15	0.28	100	180	**4.0**	**0.20**	**150**
			18,20		250 HB	0.5	15.0	0.15	0.28	100	150	**4.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.12	0.18	25	45	**3.0**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.12	0.18	25	45	**3.0**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.12	0.18	25	45	**3.0**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.12	0.20	40	65	**3.0**	**0.18**	**55**
			37	T40	-	0.5	10.7	0.12	0.18	30	55	**3.0**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.10	0.18	40	80	**2.0**	**0.14**	**60**
			38		50 HRc	0.5	3.2	0.10	0.16	40	70	**1.5**	**0.13**	**55**
			38		55 HRc	0.5	1.6	0.10	0.14	40	60	**1.0**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.10	0.18	40	80	**1.5**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.14	30	60	**1.0**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.18	0.32	200	400	**4.0**	**0.25**	**280**

APKT 160416 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.18	0.32	190	330	**5.0**	**0.23**	**250**
			2		190 HB	0.5	15.0	0.18	0.32	190	300	**5.0**	**0.23**	**220**
			3		250 HB	0.5	15.0	0.18	0.32	190	250	**5.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.15	0.25	150	240	**5.0**	**0.20**	**200**
			4,6		230 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**180**
			5,7		280 HB	0.5	15.0	0.15	0.22	130	190	**5.0**	**0.18**	**150**
			8		350 HB	0.5	15.0	0.15	0.22	130	170	**5.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.22	90	150	**3.8**	**0.18**	**130**
			10		280 HB	0.5	10.7	0.12	0.22	90	130	**3.8**	**0.18**	**120**
			11		320 HB	0.5	10.7	0.12	0.18	60	110	**3.8**	**0.16**	**100**
			11		350 HB	0.5	10.7	0.12	0.18	60	90	**3.8**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.15	0.25	190	250	**5.0**	**0.20**	**220**
			14		240 HB	0.5	15.0	0.12	0.22	160	210	**5.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.18	70	130	**3.8**	**0.16**	**100**
			14		310 HB	0.5	10.7	0.12	0.18	70	120	**3.8**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**190**
			13		42 HRc	0.5	10.7	0.15	0.20	90	150	**3.8**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.18	0.32	150	240	**5.0**	**0.23**	**200**
			15		200 HB	0.5	15.0	0.18	0.32	150	220	**5.0**	**0.23**	**180**
			16		250 HB	0.5	15.0	0.18	0.32	150	190	**5.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.15	0.28	100	200	**5.0**	**0.20**	**180**
			17,19		200 HB	0.5	15.0	0.15	0.28	100	180	**5.0**	**0.20**	**150**
			18,20		250 HB	0.5	15.0	0.15	0.28	100	150	**5.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.12	0.20	40	65	**3.8**	**0.18**	**55**
			37	T40	-	0.5	10.7	0.12	0.18	30	55	**3.8**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.10	0.18	40	80	**2.5**	**0.14**	**60**
			38		50 HRc	0.5	3.2	0.10	0.16	40	70	**1.9**	**0.13**	**55**
			38		55 HRc	0.5	1.6	0.10	0.14	40	60	**1.3**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.10	0.18	40	80	**1.9**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.14	30	60	**1.3**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.18	0.32	200	400	**5.0**	**0.25**	**280**

APKT 160424 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.18	0.32	190	330	**5.0**	**0.23**	**250**
			2		190 HB	0.5	15.0	0.18	0.32	190	300	**5.0**	**0.23**	**220**
			3		250 HB	0.5	15.0	0.18	0.32	190	250	**5.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.15	0.25	150	240	**5.0**	**0.20**	**200**
			4,6		230 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**180**
			5,7		280 HB	0.5	15.0	0.15	0.22	130	190	**5.0**	**0.18**	**150**
			8		350 HB	0.5	15.0	0.15	0.22	130	170	**5.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.22	90	150	**3.8**	**0.18**	**130**
			10		280 HB	0.5	10.7	0.12	0.22	90	130	**3.8**	**0.18**	**120**
			11		320 HB	0.5	10.7	0.12	0.18	60	110	**3.8**	**0.16**	**100**
			11		350 HB	0.5	10.7	0.12	0.18	60	90	**3.8**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.15	0.25	190	250	**5.0**	**0.20**	**220**
			14		240 HB	0.5	15.0	0.12	0.22	160	210	**5.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.18	70	130	**3.8**	**0.16**	**100**
			14		310 HB	0.5	10.7	0.12	0.18	70	120	**3.8**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**190**
			13		42 HRc	0.5	10.7	0.15	0.20	90	150	**3.8**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.18	0.32	150	240	**5.0**	**0.23**	**200**
			15		200 HB	0.5	15.0	0.18	0.32	150	220	**5.0**	**0.23**	**180**
			16		250 HB	0.5	15.0	0.18	0.32	150	190	**5.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.15	0.28	100	200	**5.0**	**0.20**	**180**
			17,19		200 HB	0.5	15.0	0.15	0.28	100	180	**5.0**	**0.20**	**150**
			18,20		250 HB	0.5	15.0	0.15	0.28	100	150	**5.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.12	0.20	40	65	**3.8**	**0.18**	**55**
			37	T40	-	0.5	10.7	0.12	0.18	30	55	**3.8**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.10	0.18	40	80	**2.5**	**0.14**	**60**
			38		50 HRc	0.5	3.2	0.10	0.16	40	70	**1.9**	**0.13**	**55**
			38		55 HRc	0.5	1.6	0.10	0.14	40	60	**1.3**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.10	0.18	40	80	**1.9**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.14	30	60	**1.3**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.18	0.32	200	400	**5.0**	**0.25**	**280**

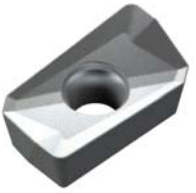
APKT 160432 PDTR – LT 30 | LT 3000

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.18	0.32	190	330	**5.0**	**0.23**	**250**
			2		190 HB	0.5	15.0	0.18	0.32	190	300	**5.0**	**0.23**	**220**
			3		250 HB	0.5	15.0	0.18	0.32	190	250	**5.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.15	0.25	150	240	**5.0**	**0.20**	**200**
			4,6		230 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**180**
			5,7		280 HB	0.5	15.0	0.15	0.22	130	190	**5.0**	**0.18**	**150**
			8		350 HB	0.5	15.0	0.15	0.22	130	170	**5.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.22	90	150	**3.8**	**0.18**	**130**
			10		280 HB	0.5	10.7	0.12	0.22	90	130	**3.8**	**0.18**	**120**
			11		320 HB	0.5	10.7	0.12	0.18	60	110	**3.8**	**0.16**	**100**
			11		350 HB	0.5	10.7	0.12	0.18	60	90	**3.8**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.15	0.25	190	250	**5.0**	**0.20**	**220**
			14		240 HB	0.5	15.0	0.12	0.22	160	210	**5.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.18	70	130	**3.8**	**0.16**	**100**
			14		310 HB	0.5	10.7	0.12	0.18	70	120	**3.8**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.15	0.25	150	210	**5.0**	**0.20**	**190**
			13		42 HRc	0.5	10.7	0.15	0.20	90	150	**3.8**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.18	0.32	150	240	**5.0**	**0.23**	**200**
			15		200 HB	0.5	15.0	0.18	0.32	150	220	**5.0**	**0.23**	**180**
			16		250 HB	0.5	15.0	0.18	0.32	150	190	**5.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.15	0.28	100	200	**5.0**	**0.20**	**180**
			17,19		200 HB	0.5	15.0	0.15	0.28	100	180	**5.0**	**0.20**	**150**
			18,20		250 HB	0.5	15.0	0.15	0.28	100	150	**5.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.12	0.18	25	45	**3.8**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.12	0.20	40	65	**3.8**	**0.18**	**55**
			37	T40	-	0.5	10.7	0.12	0.18	30	55	**3.8**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.10	0.18	40	80	**2.5**	**0.14**	**60**
			38		50 HRc	0.5	3.2	0.10	0.16	40	70	**1.9**	**0.13**	**55**
			38		55 HRc	0.5	1.6	0.10	0.14	40	60	**1.3**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.10	0.18	40	80	**1.9**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.14	30	60	**1.3**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.18	0.32	200	400	**5.0**	**0.25**	**280**

APKT 1705 PDTR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.18	0.40	190	330	**4.0**	**0.28**	**250**
			2		190 HB	0.5	15.0	0.18	0.40	190	300	**4.0**	**0.28**	**220**
			3		250 HB	0.5	15.0	0.18	0.40	190	250	**4.0**	**0.28**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.15	0.31	150	240	**4.0**	**0.24**	**200**
			4,6		230 HB	0.5	15.0	0.15	0.31	150	210	**4.0**	**0.24**	**180**
			5,7		280 HB	0.5	15.0	0.15	0.27	130	190	**4.0**	**0.22**	**150**
			8		350 HB	0.5	15.0	0.15	0.27	130	170	**4.0**	**0.22**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.27	90	150	**3.0**	**0.22**	**130**
			10		280 HB	0.5	10.7	0.12	0.27	90	130	**3.0**	**0.22**	**120**
			11		320 HB	0.5	10.7	0.12	0.22	60	110	**3.0**	**0.19**	**100**
			11		350 HB	0.5	10.7	0.12	0.22	60	90	**3.0**	**0.19**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.15	0.31	190	250	**4.0**	**0.24**	**220**
			14		240 HB	0.5	15.0	0.12	0.27	160	210	**4.0**	**0.24**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.22	70	130	**3.0**	**0.19**	**100**
			14		310 HB	0.5	10.7	0.12	0.22	70	120	**3.0**	**0.19**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.15	0.31	150	210	**4.0**	**0.24**	**190**
			13		42 HRc	0.5	10.7	0.15	0.25	90	150	**3.0**	**0.19**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.18	0.40	150	240	**4.0**	**0.28**	**200**
			15		200 HB	0.5	15.0	0.18	0.40	150	220	**4.0**	**0.28**	**180**
			16		250 HB	0.5	15.0	0.18	0.40	150	190	**4.0**	**0.28**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.15	0.35	100	200	**4.0**	**0.24**	**180**
			17,19		200 HB	0.5	15.0	0.15	0.35	100	180	**4.0**	**0.24**	**150**
			18,20		250 HB	0.5	15.0	0.15	0.35	100	150	**4.0**	**0.24**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.12	0.22	25	45	**3.0**	**0.19**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.12	0.22	25	45	**3.0**	**0.19**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.12	0.22	25	45	**3.0**	**0.19**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.12	0.25	40	65	**3.0**	**0.22**	**55**
			37	T40	-	0.5	10.7	0.12	0.22	30	55	**3.0**	**0.19**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.10	0.22	40	80	**2.0**	**0.17**	**60**
			38		50 HRc	0.5	3.2	0.10	0.20	40	70	**1.5**	**0.16**	**55**
			38		55 HRc	0.5	1.6	0.10	0.17	40	60	**1.0**	**0.14**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.10	0.22	40	80	**1.5**	**0.17**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.17	30	60	**1.0**	**0.14**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.18	0.40	200	400	**4.0**	**0.30**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru



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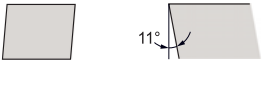


Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

Tolerance
d ± 0.05
m ± 0.08
s ± 0.13

LT 30 Multi-Mat™ General Usage – Standard

Insert Designation	l	s	r	Direction	Catalog Nr.
APMT 1135 PDTR LT 30	11.45	3.52	0.7	Right	M0001133
APMT 1604 PDTR LT 30	17.01	4.82	0.66	Right	M0001134
APMT 160408 PDTR LT 30	17.01	4.82	0.66	Right	M0001733

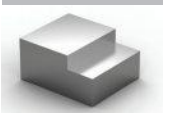
LT 3000 Multi-Mat™ General Usage – Premium

Insert Designation	l	s	r	Direction	Catalog Nr.
APMT 0903 PDTR LT 3000	9.94	3.38	0.4	Right	M0004161
APMT 1135 PDTR LT 3000	11.45	3.52	0.7	Right	M0002216
APMT 1604 PDTR LT 3000	17.01	4.82	0.66	Right	M0002183
APMT 160408 PDTR LT 3000	17.01	4.82	0.66	Right	M0002218

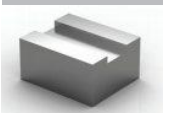
Application Guide

Helical Interpolation

Shoulder Milling



Slotting

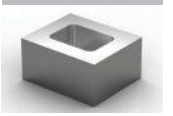


Surfacing

Ramping Down

Plunging

Pocket Milling



Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for APMT 1135 PDTR

Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 755 WL-W-D016/2*	16	16	30	150	9	2	12	M2001658
LT 755 W-W-D016/2*	16	16	30	120	9	2	12	M2001654
LT 755 WL-W-D020/2*	20	20	35	150	9	2	7	M2001659
LT 755 W-W-D020/3*	20	20	35	120	9	3	7	M2001655
LT 755 W-W-D025/4*	25	25	40	200	9	5	4	M2001660
LT 755 WL-W-D025/4*	25	25	40	150	9	4	4	M2001656
LT 755 W-W-D032/5*	32	25	40	150	9	5	3	M2001657
LT 755 WL-W-D032/5*	32	25	40	200	9	5	3	M2001661

* On request

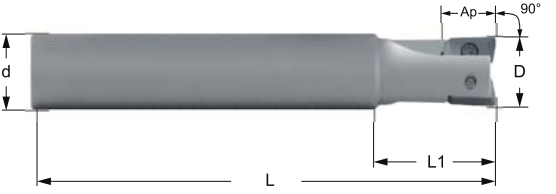
Screw: M2002778
Key: M2002912

End Mill for APMT 1604 PDTR

Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 760 WL-W-D025/2*	25	25	70	200	15	2	5	M2001665
LT 760 W-W-D025/2*	25	25	50	150	15	2	5	M2001662
LT 760 WL-W-D032/3*	32	32	100	250	15	3	3	M2001666
LT 760 W-W-D032/3*	32	32	100	200	15	3	3	M2001663
LT 760 WL-W-D040/4*	40	32	100	250	15	4	2.5	M2001667
LT 760 W-W-D040/4*	40	32	100	200	15	4	2.5	M2001664

* On request

Screw: M2000597
Key: M2000602



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

APMT 0903 PDTR – **LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	8.0	0.11	0.20	190	330	**2.0**	**0.14**	**250**
			2		190 HB	0.5	8.0	0.11	0.20	190	300	**2.0**	**0.14**	**220**
			3		250 HB	0.5	8.0	0.11	0.20	190	250	**2.0**	**0.14**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	8.0	0.09	0.16	150	240	**2.0**	**0.12**	**200**
			4,6		230 HB	0.5	8.0	0.09	0.16	150	210	**2.0**	**0.12**	**180**
			5,7		280 HB	0.5	8.0	0.09	0.14	130	190	**2.0**	**0.11**	**150**
			8		350 HB	0.5	8.0	0.09	0.14	130	170	**2.0**	**0.11**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.7	0.07	0.14	90	150	**1.5**	**0.11**	**130**
			10		280 HB	0.5	5.7	0.07	0.14	90	130	**1.5**	**0.11**	**120**
			11		320 HB	0.5	5.7	0.07	0.11	60	110	**1.5**	**0.10**	**100**
			11		350 HB	0.5	5.7	0.07	0.11	60	90	**1.5**	**0.10**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	8.0	0.09	0.16	190	250	**2.0**	**0.12**	**220**
			14		240 HB	0.5	8.0	0.07	0.14	160	210	**2.0**	**0.12**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.7	0.07	0.11	70	130	**1.5**	**0.10**	**100**
			14		310 HB	0.5	5.7	0.07	0.11	70	120	**1.5**	**0.10**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	8.0	0.09	0.16	150	210	**2.0**	**0.12**	**190**
			13		42 HRc	0.5	5.7	0.09	0.12	90	150	**1.5**	**0.10**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	8.0	0.11	0.20	150	240	**2.0**	**0.14**	**200**
			15		200 HB	0.5	8.0	0.11	0.20	150	220	**2.0**	**0.14**	**180**
			16		250 HB	0.5	8.0	0.11	0.20	150	190	**2.0**	**0.14**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	8.0	0.09	0.17	100	200	**2.0**	**0.12**	**180**
			17,19		200 HB	0.5	8.0	0.09	0.17	100	180	**2.0**	**0.12**	**150**
			18,20		250 HB	0.5	8.0	0.09	0.17	100	150	**2.0**	**0.12**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.7	0.07	0.11	25	45	**1.5**	**0.10**	**32**
			33	Inconel 700	250 HB	0.5	5.7	0.07	0.11	25	45	**1.5**	**0.10**	**30**
			34	Stellite 21	350 HB	0.5	5.7	0.07	0.11	25	45	**1.5**	**0.10**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.7	0.07	0.12	40	65	**1.5**	**0.11**	**55**
			37	T40	-	0.5	5.7	0.07	0.11	30	55	**1.5**	**0.10**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.9	0.06	0.11	40	80	**1.0**	**0.09**	**60**
			38		50 HRc	0.5	1.7	0.06	0.10	40	70	**0.8**	**0.08**	**55**
			38		55 HRc	0.5	1.2	0.06	0.09	40	60	**0.5**	**0.07**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.3	0.06	0.11	40	80	**0.8**	**0.09**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.2	0.06	0.09	30	60	**0.5**	**0.07**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	8.0	0.11	0.20	200	400	**2.0**	**0.16**	**280**

APMT 1135 PDTR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	10.0	0.13	0.22	190	330	**2.0**	**0.15**	**250**
			2		190 HB	0.5	10.0	0.13	0.22	190	300	**2.0**	**0.15**	**220**
			3		250 HB	0.5	10.0	0.13	0.22	190	250	**2.0**	**0.15**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	10.0	0.11	0.18	150	240	**2.0**	**0.13**	**200**
			4,6		230 HB	0.5	10.0	0.11	0.18	150	210	**2.0**	**0.13**	**180**
			5,7		280 HB	0.5	10.0	0.11	0.15	130	190	**2.0**	**0.12**	**150**
			8		350 HB	0.5	10.0	0.11	0.15	130	170	**2.0**	**0.12**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	7.2	0.08	0.15	90	150	**1.5**	**0.12**	**130**
			10		280 HB	0.5	7.2	0.08	0.15	90	130	**1.5**	**0.12**	**120**
			11		320 HB	0.5	7.2	0.08	0.13	60	110	**1.5**	**0.10**	**100**
			11		350 HB	0.5	7.2	0.08	0.13	60	90	**1.5**	**0.10**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	10.0	0.11	0.18	190	250	**2.0**	**0.13**	**220**
			14		240 HB	0.5	10.0	0.08	0.15	160	210	**2.0**	**0.13**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	7.2	0.08	0.13	70	130	**1.5**	**0.10**	**100**
			14		310 HB	0.5	7.2	0.08	0.13	70	120	**1.5**	**0.10**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	10.0	0.11	0.18	150	210	**2.0**	**0.13**	**190**
			13		42 HRc	0.5	7.2	0.08	0.14	90	150	**1.5**	**0.10**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	10.0	0.13	0.22	150	240	**2.0**	**0.15**	**200**
			15		200 HB	0.5	10.0	0.13	0.22	150	220	**2.0**	**0.15**	**180**
			16		250 HB	0.5	10.0	0.13	0.22	150	190	**2.0**	**0.15**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	10.0	0.11	0.20	100	200	**2.0**	**0.13**	**180**
			17,19		200 HB	0.5	10.0	0.11	0.20	100	180	**2.0**	**0.13**	**150**
			18,20		250 HB	0.5	10.0	0.11	0.20	100	150	**2.0**	**0.13**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	7.2	0.08	0.13	25	45	**1.5**	**0.10**	**32**
			33	Inconel 700	250 HB	0.5	7.2	0.08	0.13	25	45	**1.5**	**0.10**	**30**
			34	Stellite 21	350 HB	0.5	7.2	0.08	0.13	25	45	**1.5**	**0.10**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	7.2	0.08	0.14	40	65	**1.5**	**0.12**	**55**
			37	T40	-	0.5	7.2	0.08	0.13	30	55	**1.5**	**0.10**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.6	0.07	0.13	40	80	**1.0**	**0.09**	**60**
			38		50 HRc	0.5	2.1	0.07	0.11	40	70	**0.8**	**0.08**	**55**
			38		55 HRc	0.5	1.1	0.07	0.10	40	60	**0.5**	**0.08**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.9	0.07	0.13	40	80	**0.8**	**0.09**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.1	0.07	0.10	30	60	**0.5**	**0.08**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	10.0	0.13	0.22	200	400	**2.0**	**0.16**	**280**

APMT 1604 PDTR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.16	0.30	190	330	**4.0**	**0.21**	**250**
			2		190 HB	0.5	15.0	0.16	0.30	190	300	**4.0**	**0.21**	**220**
			3		250 HB	0.5	15.0	0.16	0.30	190	250	**4.0**	**0.21**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.14	0.23	150	240	**4.0**	**0.18**	**200**
			4,6		230 HB	0.5	15.0	0.14	0.23	150	210	**4.0**	**0.18**	**180**
			5,7		280 HB	0.5	15.0	0.14	0.20	130	190	**4.0**	**0.16**	**150**
			8		350 HB	0.5	15.0	0.14	0.20	130	170	**4.0**	**0.16**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.11	0.20	90	150	**3.0**	**0.16**	**130**
			10		280 HB	0.5	10.7	0.11	0.20	90	130	**3.0**	**0.16**	**120**
			11		320 HB	0.5	10.7	0.11	0.17	60	110	**3.0**	**0.14**	**100**
			11		350 HB	0.5	10.7	0.11	0.17	60	90	**3.0**	**0.14**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.14	0.23	190	250	**4.0**	**0.18**	**220**
			14		240 HB	0.5	15.0	0.11	0.20	160	210	**4.0**	**0.18**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.11	0.17	70	130	**3.0**	**0.14**	**100**
			14		310 HB	0.5	10.7	0.11	0.17	70	120	**3.0**	**0.14**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.14	0.23	150	210	**4.0**	**0.18**	**190**
			13		42 HRc	0.5	10.7	0.14	0.19	90	150	**3.0**	**0.14**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.16	0.30	150	240	**4.0**	**0.21**	**200**
			15		200 HB	0.5	15.0	0.16	0.30	150	220	**4.0**	**0.21**	**180**
			16		250 HB	0.5	15.0	0.16	0.30	150	190	**4.0**	**0.21**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.14	0.26	100	200	**4.0**	**0.18**	**180**
			17,19		200 HB	0.5	15.0	0.14	0.26	100	180	**4.0**	**0.18**	**150**
			18,20		250 HB	0.5	15.0	0.14	0.26	100	150	**4.0**	**0.18**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.11	0.19	40	65	**3.0**	**0.16**	**55**
			37	T40	-	0.5	10.7	0.11	0.17	30	55	**3.0**	**0.14**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.09	0.17	40	80	**2.0**	**0.13**	**60**
			38		50 HRc	0.5	3.2	0.09	0.15	40	70	**1.5**	**0.12**	**55**
			38		55 HRc	0.5	1.6	0.09	0.13	40	60	**1.0**	**0.11**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.09	0.17	40	80	**1.5**	**0.13**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.09	0.13	30	60	**1.0**	**0.11**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.16	0.30	200	400	**4.0**	**0.23**	**280**

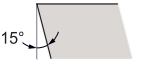
APMT 160408 PDTR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	15.0	0.16	0.30	190	330	**4.0**	**0.21**	**250**
			2		190 HB	0.5	15.0	0.16	0.30	190	300	**4.0**	**0.21**	**220**
			3		250 HB	0.5	15.0	0.16	0.30	190	250	**4.0**	**0.21**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	15.0	0.14	0.23	150	240	**4.0**	**0.18**	**200**
			4,6		230 HB	0.5	15.0	0.14	0.23	150	210	**4.0**	**0.18**	**180**
			5,7		280 HB	0.5	15.0	0.14	0.20	130	190	**4.0**	**0.16**	**150**
			8		350 HB	0.5	15.0	0.14	0.20	130	170	**4.0**	**0.16**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.11	0.20	90	150	**3.0**	**0.16**	**130**
			10		280 HB	0.5	10.7	0.11	0.20	90	130	**3.0**	**0.16**	**120**
			11		320 HB	0.5	10.7	0.11	0.17	60	110	**3.0**	**0.14**	**100**
			11		350 HB	0.5	10.7	0.11	0.17	60	90	**3.0**	**0.14**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	15.0	0.14	0.23	190	250	**4.0**	**0.18**	**220**
			14		240 HB	0.5	15.0	0.11	0.20	160	210	**4.0**	**0.18**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.11	0.17	70	130	**3.0**	**0.14**	**100**
			14		310 HB	0.5	10.7	0.11	0.17	70	120	**3.0**	**0.14**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15.0	0.14	0.23	150	210	**4.0**	**0.18**	**190**
			13		42 HRc	0.5	10.7	0.14	0.19	90	150	**3.0**	**0.14**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	15.0	0.16	0.30	150	240	**4.0**	**0.21**	**200**
			15		200 HB	0.5	15.0	0.16	0.30	150	220	**4.0**	**0.21**	**180**
			16		250 HB	0.5	15.0	0.16	0.30	150	190	**4.0**	**0.21**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	15.0	0.14	0.26	100	200	**4.0**	**0.18**	**180**
			17,19		200 HB	0.5	15.0	0.14	0.26	100	180	**4.0**	**0.18**	**150**
			18,20		250 HB	0.5	15.0	0.14	0.26	100	150	**4.0**	**0.18**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**32**
			33	Inconel 700	250 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**30**
			34	Stellite 21	350 HB	0.5	10.7	0.11	0.17	25	45	**3.0**	**0.14**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.7	0.11	0.19	40	65	**3.0**	**0.16**	**55**
			37	T40	-	0.5	10.7	0.11	0.17	30	55	**3.0**	**0.14**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.4	0.09	0.17	40	80	**2.0**	**0.13**	**60**
			38		50 HRc	0.5	3.2	0.09	0.15	40	70	**1.5**	**0.12**	**55**
			38		55 HRc	0.5	1.6	0.09	0.13	40	60	**1.0**	**0.11**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.3	0.09	0.17	40	80	**1.5**	**0.13**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.09	0.13	30	60	**1.0**	**0.11**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	15.0	0.16	0.30	200	400	**4.0**	**0.23**	**280**

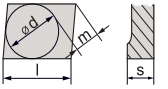
ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

L D M T

Shape

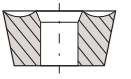


Clearance Angle



Tolerance

d ± 0.05
m ± 0.08
s ± 0.13

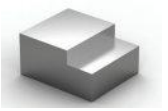


Fixing, Chipbreaker

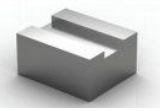
LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
LDMT 1504 PDSR LT30	15.71	4.79	0.74	Right	M0001772

Application Guide

Shoulder Milling



Slotting



Surfacing

Pocket Milling

Ramping Down

Plunging

Helical Inerpolation

Machining Recommendations

F ⇒
Productivity

Coolant

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

Stainless Steel
V_c

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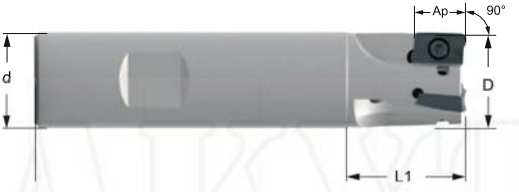
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for LDMT 1504 PDSR								
Cutter Designation	D	d	L1	L	Ap	z	α	Catalog Nr.
LT 770 WL-W-D25/2*	25	25	44	150	15	2	5	M2001825
LT 770 W-W-D025/2*	25	25	44	100	15	2	5	M2001822
LT 770 WL-W-D32/3*	32	25	50	150	15	3	3	M2001826
LT 770 W-W-D032/3*	32	35	50	110	15	3	3	M2001823
LT 770 W-W-D040/4*	40	32	45	115	15	4	2.5	M2001824

* On request

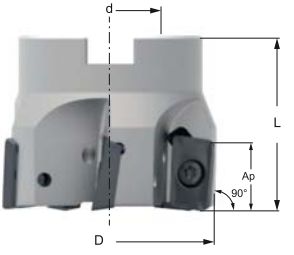
Screw: M2001418
Key: M2000602



Shell Mill for LDMT 1504 PDSR							
Cutter Designation	D	d	L	Ap	z	α	Catalog Nr.
LT 770 M-W-D040/4*	40	16	40	15	4	2.5	M2001827
LT 770 M-W-D050/5*	50	22	40	15	5	2.2	M2001828
LT 770 M-W-D063/6*	63	22	40	15	6	1.8	M2001829
LT 770 M-W-D080/7*	80	27	50	15	7	1.4	M2001846
LT 770 M-W-D100/8*	100	32	50	15	8	1.1	M2001830
LT 770 M-W-D125/9*	125	40	63	15	9	0.8	M2001831
LT 770 M-W-D160/9*	160	40	63	15	9	-	M2001832

* On request

Screw: M2001418
Key: M2000602



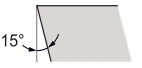
ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

LDMT 1504 PDSR – **LT 30 | LT 3000**

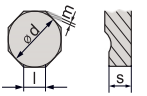
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	14.0	0.18	0.32	190	330	**4.0**	**0.23**	**250**
			2		190 HB	0.5	14.0	0.18	0.32	190	300	**4.0**	**0.23**	**220**
			3		250 HB	0.5	14.0	0.18	0.32	190	250	**4.0**	**0.23**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	14.0	0.15	0.25	150	240	**4.0**	**0.20**	**200**
			4,6		230 HB	0.5	14.0	0.15	0.25	150	210	**4.0**	**0.20**	**180**
			5,7		280 HB	0.5	14.0	0.15	0.22	130	190	**4.0**	**0.18**	**150**
			8		350 HB	0.5	14.0	0.15	0.22	130	170	**4.0**	**0.18**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.0	0.12	0.22	90	150	**3.0**	**0.18**	**130**
			10		280 HB	0.5	10.0	0.12	0.22	90	130	**3.0**	**0.18**	**120**
			11		320 HB	0.5	10.0	0.12	0.18	60	110	**3.0**	**0.16**	**100**
			11		350 HB	0.5	10.0	0.12	0.18	60	90	**3.0**	**0.16**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	14.0	0.15	0.25	190	250	**4.0**	**0.20**	**220**
			14		240 HB	0.5	14.0	0.12	0.22	160	210	**4.0**	**0.20**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	10.0	0.12	0.18	70	130	**3.0**	**0.16**	**100**
			14		310 HB	0.5	10.0	0.12	0.18	70	120	**3.0**	**0.16**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	14.0	0.15	0.25	150	210	**4.0**	**0.20**	**190**
			13		42 HRc	0.5	10.0	0.15	0.20	90	150	**3.0**	**0.16**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	14.0	0.18	0.32	150	240	**4.0**	**0.23**	**200**
			15		200 HB	0.5	14.0	0.18	0.32	150	220	**4.0**	**0.23**	**180**
			16		250 HB	0.5	14.0	0.18	0.32	150	190	**4.0**	**0.23**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	14.0	0.15	0.28	100	200	**4.0**	**0.20**	**180**
			17,19		200 HB	0.5	14.0	0.15	0.28	100	180	**4.0**	**0.20**	**150**
			18,20		250 HB	0.5	14.0	0.15	0.28	100	150	**4.0**	**0.20**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**32**
			33	Inconel 700	250 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**30**
			34	Stellite 21	350 HB	0.5	10.0	0.12	0.18	25	45	**3.0**	**0.16**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	10.0	0.12	0.20	40	65	**3.0**	**0.18**	**55**
			37	T40	-	0.5	10.0	0.12	0.18	30	55	**3.0**	**0.16**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5.0	0.10	0.18	40	80	**2.0**	**0.14**	**60**
			38		50 HRc	0.5	3.0	0.10	0.16	40	70	**1.5**	**0.13**	**55**
			38		55 HRc	0.5	1.5	0.10	0.14	40	60	**1.0**	**0.12**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	4.0	0.10	0.18	40	80	**1.5**	**0.14**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.14	30	60	**1.0**	**0.12**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	14.0	0.18	0.32	200	400	**4.0**	**0.25**	**280**

O D M T

Shape

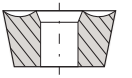


Clearance Angle



Tolerance

s ± 0.13
For l = 05, **d** ± 0.08 **m** ± 0.13
For l = 06, **d** ± 0.10 **m** ± 0.15



Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard					
Insert Designation	l	s	r	Direction	Catalog Nr.
ODMT 0504 ZZTR LT 30	5.08	4.76	0.8	Right	M0000664
ODMT 060508 TN LT 30	6.58	5.56	0.8	Right	M0001104

LT 3000 Multi-Mat™ General Usage – Premium					
Insert Designation	l	s	r	Direction	Catalog Nr.
ODMT 0504 ZZTR LT 3000	5.08	4.76	0.8	Right	M0003399
ODMT 060508 TN LT 3000	6.58	5.56	0.8	Right	M0002219

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒
Productivity

Coolant

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

Stainless Steel
V_c

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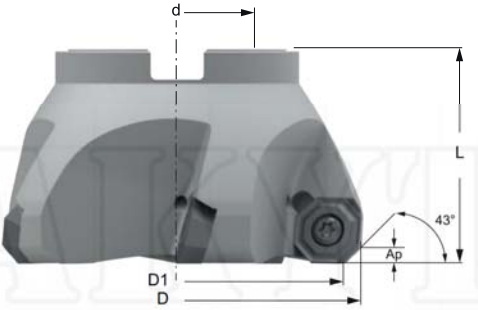
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for ODMT 060508 TN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 820 M-D-D063/5*	63	53	22	50	3.5	5	M2003837
LT 820 M-D-D080/5*	90	80	27	50	3.5	5	M2000711
LT 820 M-D-D100/6*	110	100	32	50	3.5	6	M2000712
LT 820 M-D-D125/7*	135	125	40	63	3.5	7	M2000713
LT 820 M-D-D160/9*	170	160	40	63	3.5	9	M2000714

* On request

Screw: M2002733
Key: M2000603



ODMT 0504 ZZTR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.5	0.22	0.51	190	330	**2.5**	**0.37**	**250**
			2		190 HB	0.5	3.5	0.22	0.51	190	300	**2.5**	**0.37**	**220**
			3		250 HB	0.5	3.5	0.22	0.51	190	250	**2.5**	**0.37**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.5	0.18	0.40	150	240	**2.5**	**0.32**	**200**
			4,6		230 HB	0.5	3.5	0.18	0.40	150	210	**2.5**	**0.32**	**180**
			5,7		280 HB	0.5	3.5	0.18	0.35	130	190	**2.5**	**0.29**	**150**
			8		350 HB	0.5	3.5	0.18	0.35	130	170	**2.5**	**0.29**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.5	0.14	0.35	90	150	**1.9**	**0.29**	**130**
			10		280 HB	0.5	2.5	0.14	0.35	90	130	**1.9**	**0.29**	**120**
			11		320 HB	0.5	2.5	0.14	0.29	60	110	**1.9**	**0.26**	**100**
			11		350 HB	0.5	2.5	0.14	0.29	60	90	**1.9**	**0.26**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.5	0.18	0.35	190	250	**2.5**	**0.29**	**220**
			14		240 HB	0.5	3.5	0.14	0.32	160	210	**2.5**	**0.29**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.5	0.14	0.29	70	130	**1.9**	**0.26**	**100**
			14		310 HB	0.5	2.5	0.14	0.29	70	120	**1.9**	**0.26**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.18	0.35	150	210	**2.5**	**0.29**	**190**
			13		42 HRc	0.5	2.5	0.18	0.32	90	150	**1.9**	**0.26**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.5	0.22	0.51	150	240	**2.5**	**0.37**	**200**
			15		200 HB	0.5	3.5	0.22	0.51	150	220	**2.5**	**0.37**	**180**
			16		250 HB	0.5	3.5	0.22	0.51	150	190	**2.5**	**0.37**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.5	0.18	0.45	100	200	**2.5**	**0.32**	**180**
			17,19		200 HB	0.5	3.5	0.18	0.45	100	180	**2.5**	**0.32**	**150**
			18,20		250 HB	0.5	3.5	0.18	0.45	100	150	**2.5**	**0.32**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**32**
			33	Inconel 700	250 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
			34	Stellite 21	350 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.5	0.14	0.32	40	65	**1.9**	**0.29**	**55**
			37	T40	-	0.5	2.5	0.14	0.29	30	55	**1.9**	**0.26**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.3	0.12	0.29	40	80	**1.3**	**0.22**	**60**
			38		50 HRc	0.4	0.8	0.12	0.26	40	70	**0.9**	**0.21**	**55**
			38		55 HRc	0.4	0.4	0.12	0.22	40	60	**0.6**	**0.19**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.0	0.12	0.29	40	80	**0.9**	**0.22**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	0.4	0.12	0.22	30	60	**0.6**	**0.19**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.5	0.22	0.51	200	400	**2.5**	**0.40**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

ODMT 060508 TN – **LT 30 | LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	4.0	0.22	0.54	190	330	**2.5**	**0.39**	**250**
			2		190 HB	0.5	4.0	0.22	0.54	190	300	**2.5**	**0.39**	**220**
			3		250 HB	0.5	4.0	0.22	0.54	190	250	**2.5**	**0.39**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.0	0.18	0.43	150	240	**2.5**	**0.34**	**200**
			4,6		230 HB	0.5	4.0	0.18	0.43	150	210	**2.5**	**0.34**	**180**
			5,7		280 HB	0.5	4.0	0.18	0.37	130	190	**2.5**	**0.31**	**150**
			8		350 HB	0.5	4.0	0.18	0.37	130	170	**2.5**	**0.31**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.9	0.14	0.37	90	150	**1.9**	**0.31**	**130**
			10		280 HB	0.5	2.9	0.14	0.37	90	130	**1.9**	**0.31**	**120**
			11		320 HB	0.5	2.9	0.14	0.31	60	110	**1.9**	**0.27**	**100**
			11		350 HB	0.5	2.9	0.14	0.31	60	90	**1.9**	**0.27**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	4.0	0.18	0.37	190	250	**2.5**	**0.31**	**220**
			14		240 HB	0.5	4.0	0.14	0.34	160	210	**2.5**	**0.31**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.9	0.14	0.31	70	130	**1.9**	**0.27**	**100**
			14		310 HB	0.5	2.9	0.14	0.31	70	120	**1.9**	**0.27**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	4.0	0.18	0.37	150	210	**2.5**	**0.31**	**190**
			13		42 HRc	0.5	2.9	0.18	0.34	90	150	**1.9**	**0.27**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.0	0.22	0.54	150	240	**2.5**	**0.39**	**200**
			15		200 HB	0.5	4.0	0.22	0.54	150	220	**2.5**	**0.39**	**180**
			16		250 HB	0.5	4.0	0.22	0.54	150	190	**2.5**	**0.39**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.0	0.18	0.48	100	200	**2.5**	**0.34**	**180**
			17,19		200 HB	0.5	4.0	0.18	0.48	100	180	**2.5**	**0.34**	**150**
			18,20		250 HB	0.5	4.0	0.18	0.48	100	150	**2.5**	**0.34**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.9	0.14	0.31	25	45	**1.9**	**0.27**	**32**
			33	Inconel 700	250 HB	0.5	2.9	0.14	0.31	25	45	**1.9**	**0.27**	**30**
			34	Stellite 21	350 HB	0.5	2.9	0.14	0.31	25	45	**1.9**	**0.27**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.9	0.14	0.34	40	65	**1.9**	**0.31**	**55**
			37	T40	-	0.5	2.9	0.14	0.31	30	55	**1.9**	**0.27**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.4	0.12	0.31	40	80	**1.3**	**0.24**	**60**
			38		50 HRc	0.4	1.1	0.12	0.27	40	70	**0.9**	**0.22**	**55**
			38		55 HRc	0.4	0.9	0.12	0.24	40	60	**0.6**	**0.20**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.1	0.12	0.31	40	80	**0.9**	**0.24**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	0.9	0.12	0.24	30	60	**0.6**	**0.20**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	4.0	0.22	0.54	200	400	**2.5**	**0.43**	**280**

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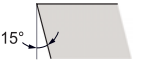
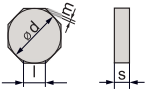
Shape

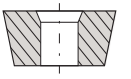


Clearance Angle



Tolerance

d ± 0.10
m ± 0.15
s ± 0.13



Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard					
Insert Designation	l	s	r	Direction	Catalog Nr.
ODMW 060508 TN LT 30	6.58	5.56	0.8	Right	M0000451

LT 3000 Multi-Mat™ General Usage – Premium					
Insert Designation	l	s	r	Direction	Catalog Nr.
ODMW 060508 TN LT 3000	6.58	5.56	0.8	Right	M0003400

Shell Mill for ODMW 060508 TN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 820 M-D-D063/5*	63	53	22	50	3.5	5	M2003837
LT 820 M-D-D080/5*	90	80	27	50	3.5	5	M2000711
LT 820 M-D-D100/6*	110	100	32	50	3.5	6	M2000712
LT 820 M-D-D125/7*	135	125	40	63	3.5	7	M2000713
LT 820 M-D-D160/9*	170	160	40	63	3.5	9	M2000714

* On request

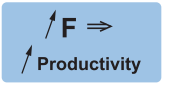
Screw: M2002733
Key: M2000603

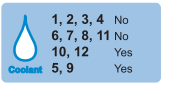
Application Guide

Chamfering

Surfacing

Machining Recommendations





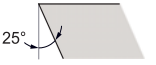
ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

ODMW 060508 TN – LT 30 | LT 3000

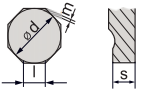
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	4.0	0.22	0.58	190	330	3.0	0.41	250
			2		190 HB	0.5	4.0	0.22	0.58	190	300	3.0	0.41	220
			3		250 HB	0.5	4.0	0.22	0.58	190	250	3.0	0.41	200
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.0	0.18	0.45	150	240	3.0	0.36	200
			4,6		230 HB	0.5	4.0	0.18	0.45	150	210	3.0	0.36	180
			5,7		280 HB	0.5	4.0	0.18	0.40	130	190	3.0	0.32	150
			8		350 HB	0.5	4.0	0.18	0.40	130	170	3.0	0.32	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.9	0.14	0.40	90	150	2.3	0.32	130
			10		280 HB	0.5	2.9	0.14	0.40	90	130	2.3	0.32	120
			11		320 HB	0.5	2.9	0.14	0.32	60	110	2.3	0.29	100
			11		350 HB	0.5	2.9	0.14	0.32	60	90	2.3	0.29	80
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.0	0.22	0.58	150	240	3.0	0.41	200
			15		200 HB	0.5	4.0	0.22	0.58	150	220	3.0	0.41	180
			16		250 HB	0.5	4.0	0.22	0.58	150	190	3.0	0.41	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.0	0.18	0.50	100	200	3.0	0.36	180
			17,19		200 HB	0.5	4.0	0.18	0.50	100	180	3.0	0.36	150
			18,20		250 HB	0.5	4.0	0.18	0.50	100	150	3.0	0.36	130
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.4	0.12	0.32	40	80	1.1	0.25	60
			38		50 HRc	0.4	1.1	0.12	0.29	40	70	0.9	0.23	55
			38		55 HRc	0.4	0.9	0.12	0.25	40	60	0.7	0.22	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.1	0.12	0.32	40	80	0.9	0.25	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	0.9	0.12	0.25	30	60	0.7	0.22	40

O F E R

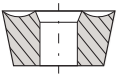
Shape



Clearance Angle



Tolerance
d ± 0.025
m ± 0.025
s ± 0.025



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
OFER 070405 TN LT 30	7.43	4.76	0.8	Right	M0000033

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
OFER 070405 TN LT 3000	7.43	4.76	0.8	Right	M0003401

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒ Productivity

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

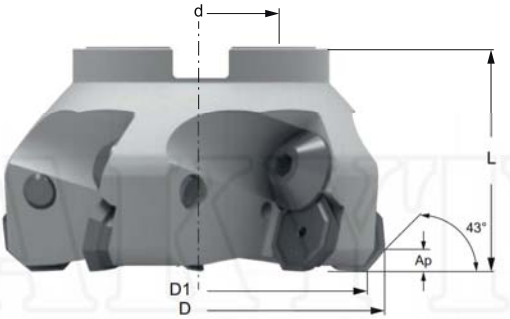
Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for OFER 070405 TN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 880 M-W-D063/4*	73	63	22	40	5	4	M2000508
LT 880 M-W-D080/5*	90	80	27	50	5	5	M2000510
LT 880 M-W-D100/6*	110	100	32	50	5	6	M2000511
LT 880 M-W-D125/8*	135	125	40	63	5	8	M2000512
LT 880 M-W-D160/10*	170	160	40	63	5	10	M2000513

* On request

Screw: M2000606
Key: M2000609

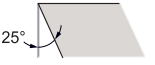


OFER 070405 TN – LT 30 | LT 3000

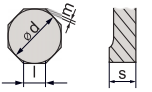
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	4.5	0.22	0.51	190	330	3.0	0.37	250
			2		190 HB	0.5	4.5	0.22	0.51	190	300	3.0	0.37	220
			3		250 HB	0.5	4.5	0.22	0.51	190	250	3.0	0.37	200
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.5	0.18	0.40	150	240	3.0	0.32	200
			4,6		230 HB	0.5	4.5	0.18	0.40	150	210	3.0	0.32	180
			5,7		280 HB	0.5	4.5	0.18	0.35	130	190	3.0	0.29	150
			8		350 HB	0.5	4.5	0.18	0.35	130	170	3.0	0.29	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	3.2	0.14	0.35	90	150	2.2	0.29	130
			10		280 HB	0.5	3.2	0.14	0.35	90	130	2.2	0.29	120
			11		320 HB	0.5	3.2	0.14	0.29	60	110	2.2	0.26	100
			11		350 HB	0.5	3.2	0.14	0.29	60	90	2.2	0.26	80
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	4.5	0.18	0.35	190	250	3.0	0.29	220
			14		240 HB	0.5	4.5	0.14	0.32	160	210	3.0	0.29	190
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	3.2	0.14	0.29	70	130	2.2	0.26	100
			14		310 HB	0.5	3.2	0.14	0.29	70	120	2.2	0.26	90
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	4.5	0.18	0.35	150	210	3.0	0.29	190
			13		42 HRc	0.5	3.2	0.18	0.32	90	150	2.2	0.26	130
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.5	0.22	0.51	150	240	3.0	0.37	200
			15		200 HB	0.5	4.5	0.22	0.51	150	220	3.0	0.37	180
			16		250 HB	0.5	4.5	0.22	0.51	150	190	3.0	0.37	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.5	0.18	0.45	100	200	3.0	0.32	180
			17,19		200 HB	0.5	4.5	0.18	0.45	100	180	3.0	0.32	150
			18,20		250 HB	0.5	4.5	0.18	0.45	100	150	3.0	0.32	130
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	3.2	0.14	0.29	25	45	2.2	0.26	32
			33	Inconel 700	250 HB	0.5	3.2	0.14	0.29	25	45	2.2	0.26	30
			34	Stellite 21	350 HB	0.5	3.2	0.14	0.29	25	45	2.2	0.26	30
	Ti Based	10	36	TiAl6V4	-	0.5	3.2	0.14	0.32	40	65	2.2	0.29	55
			37	T40	-	0.5	3.2	0.14	0.29	30	55	2.2	0.26	40
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.6	0.12	0.29	40	80	1.5	0.22	60
			38		50 HRc	0.4	1.3	0.12	0.26	40	70	1.1	0.21	55
			38		55 HRc	0.4	1.0	0.12	0.22	40	60	0.7	0.19	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.3	0.12	0.29	40	80	1.1	0.22	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.12	0.22	30	60	0.7	0.19	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	4.5	0.22	0.51	200	400	3.0	0.40	280

O F M T

Shape

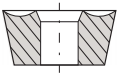


Clearance Angle



Tolerance

s ± 0.13
For l = 05, **d** ± 0.08 **m** ± 0.13
For l = 07, **d** ± 0.10 **m** ± 0.15



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
OFMT 05T305 TN LT 30	5.26	4.00	0.8	Neutral	M0000591
OFMT 050405 TR LT 30	5.51	4.76	0.5	Right	M0000034
OFMT 070405 TN LT 30	7.44	4.76	0.5	Neutral	M0000592

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
OFMT 05T305 TN LT 3000	5.26	4.00	0.8	Neutral	M0002221
OFMT 050405 TR LT 3000	5.51	4.76	0.5	Right	M0002220
OFMT 070405 TN LT 3000	7.44	4.76	0.5	Neutral	M0002222

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒
Productivity

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

Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for OFMT 05T305 TN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 800 M-W-D032/3	39	32	16	40	3	3	M2000501
LT 800 M-W-D040/3	47	40	16	40	3	3	M2000502
LT 800 M-W-D050/4	57	50	22	40	3	4	M2000503
LT 800 M-W-D063/5	70	63	22	40	3	5	M2000504
LT 800 M-W-D080/6	87	80	27	50	3	6	M2000505
LT 800 M-W-D100/7	107	100	32	50	3	7	M2000506
LT 800 M-W-D125/8	132	125	40	63	3	8	M2000507

Screw: M2000597
Key: M2000602

Shell Mill for OFMT 050405 TR							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 805 M-W-D032/3*	39	32	16	40	3	3	M2001602
LT 805 M-W-D040/3*	47	40	16	40	3	3	M2001603
LT 805 M-W-D050/4*	57	50	22	40	3	4	M2001604
LT 805 M-W-D063/5*	70	63	22	40	3	5	M2001605
LT 805 M-W-D080/6*	87	80	27	50	3	6	M2001607
LT 805 M-W-D100/7*	107	100	32	50	3	7	M2001608
LT 805 M-W-D125/8*	132	125	40	63	3	8	M2001609

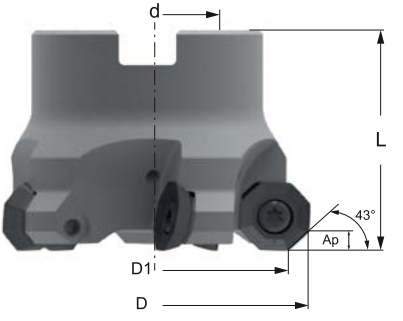
* On request

Screw: M2000597
Key: M2000602

Shell Mill for OFMT 070405 TN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 810 M-D-D080/6*	92	80	27	50	4.5	6	M2000707
LT 810 M-D-D100/7*	112	100	32	50	4.5	7	M2000708
LT 810 M-D-D125/8*	137	125	40	63	4.5	8	M2000709

* On request

Screw: M2002733
Key: M2000603



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

OFMT 050405 TR – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.5	0.22	0.51	190	330	**2.5**	**0.37**	**250**
			2		190 HB	0.5	3.5	0.22	0.51	190	300	**2.5**	**0.37**	**220**
			3		250 HB	0.5	3.5	0.22	0.51	190	250	**2.5**	**0.37**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.5	0.18	0.40	150	240	**2.5**	**0.32**	**200**
			4,6		230 HB	0.5	3.5	0.18	0.40	150	210	**2.5**	**0.32**	**180**
			5,7		280 HB	0.5	3.5	0.18	0.35	130	190	**2.5**	**0.29**	**150**
			8		350 HB	0.5	3.5	0.18	0.35	130	170	**2.5**	**0.29**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.5	0.14	0.35	90	150	**1.9**	**0.29**	**130**
			10		280 HB	0.5	2.5	0.14	0.35	90	130	**1.9**	**0.29**	**120**
			11		320 HB	0.5	2.5	0.14	0.29	60	110	**1.9**	**0.26**	**100**
			11		350 HB	0.5	2.5	0.14	0.29	60	90	**1.9**	**0.26**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.5	0.18	0.35	190	250	**2.5**	**0.29**	**220**
			14		240 HB	0.5	3.5	0.14	0.32	160	210	**2.5**	**0.29**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.5	0.14	0.29	70	130	**1.9**	**0.26**	**100**
			14		310 HB	0.5	2.5	0.14	0.29	70	120	**1.9**	**0.26**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.18	0.35	150	210	**2.5**	**0.29**	**190**
			13		42 HRc	0.5	2.5	0.18	0.32	90	150	**1.9**	**0.26**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.5	0.22	0.51	150	240	**2.5**	**0.37**	**200**
			15		200 HB	0.5	3.5	0.22	0.51	150	220	**2.5**	**0.37**	**180**
			16		250 HB	0.5	3.5	0.22	0.51	150	190	**2.5**	**0.37**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.5	0.18	0.45	100	200	**2.5**	**0.32**	**180**
			17,19		200 HB	0.5	3.5	0.18	0.45	100	180	**2.5**	**0.32**	**150**
			18,20		250 HB	0.5	3.5	0.18	0.45	100	150	**2.5**	**0.32**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**32**
			33	Inconel 700	250 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
			34	Stellite 21	350 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.5	0.14	0.32	40	65	**1.9**	**0.29**	**55**
			37	T40	-	0.5	2.5	0.14	0.29	30	55	**1.9**	**0.26**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.3	0.12	0.29	40	80	**1.1**	**0.22**	**60**
			38		50 HRc	0.4	1.0	0.12	0.26	40	70	**0.9**	**0.21**	**55**
			38		55 HRc	0.4	0.8	0.12	0.22	40	60	**0.6**	**0.19**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.0	0.12	0.29	40	80	**0.9**	**0.22**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	0.8	0.12	0.22	30	60	**0.6**	**0.19**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.5	0.22	0.51	200	400	**2.5**	**0.40**	**280**

OFMT 05T305 TN – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.5	0.22	0.51	190	330	**2.5**	**0.37**	**250**
			2		190 HB	0.5	3.5	0.22	0.51	190	300	**2.5**	**0.37**	**220**
			3		250 HB	0.5	3.5	0.22	0.51	190	250	**2.5**	**0.37**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.5	0.18	0.40	150	240	**2.5**	**0.32**	**200**
			4,6		230 HB	0.5	3.5	0.18	0.40	150	210	**2.5**	**0.32**	**180**
			5,7		280 HB	0.5	3.5	0.18	0.35	130	190	**2.5**	**0.29**	**150**
			8		350 HB	0.5	3.5	0.18	0.35	130	170	**2.5**	**0.29**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.5	0.14	0.35	90	150	**1.9**	**0.29**	**130**
			10		280 HB	0.5	2.5	0.14	0.35	90	130	**1.9**	**0.29**	**120**
			11		320 HB	0.5	2.5	0.14	0.29	60	110	**1.9**	**0.26**	**100**
			11		350 HB	0.5	2.5	0.14	0.29	60	90	**1.9**	**0.26**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.5	0.18	0.35	190	250	**2.5**	**0.29**	**220**
			14		240 HB	0.5	3.5	0.14	0.32	160	210	**2.5**	**0.29**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.5	0.14	0.29	70	130	**1.9**	**0.26**	**100**
			14		310 HB	0.5	2.5	0.14	0.29	70	120	**1.9**	**0.26**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.18	0.35	150	210	**2.5**	**0.29**	**190**
			13		42 HRc	0.5	2.5	0.18	0.32	90	150	**1.9**	**0.26**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.5	0.22	0.51	150	240	**2.5**	**0.37**	**200**
			15		200 HB	0.5	3.5	0.22	0.51	150	220	**2.5**	**0.37**	**180**
			16		250 HB	0.5	3.5	0.22	0.51	150	190	**2.5**	**0.37**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.5	0.18	0.45	100	200	**2.5**	**0.32**	**180**
			17,19		200 HB	0.5	3.5	0.18	0.45	100	180	**2.5**	**0.32**	**150**
			18,20		250 HB	0.5	3.5	0.18	0.45	100	150	**2.5**	**0.32**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**32**
			33	Inconel 700	250 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
			34	Stellite 21	350 HB	0.5	2.5	0.14	0.29	25	45	**1.9**	**0.26**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.5	0.14	0.32	40	65	**1.9**	**0.29**	**55**
			37	T40	-	0.5	2.5	0.14	0.29	30	55	**1.9**	**0.26**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.3	0.12	0.29	40	80	**1.1**	**0.22**	**60**
			38		50 HRc	0.4	1.0	0.12	0.26	40	70	**0.9**	**0.21**	**55**
			38		55 HRc	0.4	0.8	0.12	0.22	40	60	**0.6**	**0.19**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.0	0.12	0.29	40	80	**0.9**	**0.22**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	0.8	0.12	0.22	30	60	**0.6**	**0.19**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.5	0.22	0.51	200	400	**2.5**	**0.40**	**280**

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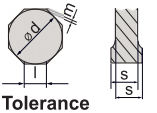
OFMT 070405 TN – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	4.5	0.22	0.51	190	330	**3.0**	**0.37**	**250**
			2		190 HB	0.5	4.5	0.22	0.51	190	300	**3.0**	**0.37**	**220**
			3		250 HB	0.5	4.5	0.22	0.51	190	250	**3.0**	**0.37**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.5	0.18	0.40	150	240	**3.0**	**0.32**	**200**
			4,6		230 HB	0.5	4.5	0.18	0.40	150	210	**3.0**	**0.32**	**180**
			5,7		280 HB	0.5	4.5	0.18	0.35	130	190	**3.0**	**0.29**	**150**
			8		350 HB	0.5	4.5	0.18	0.35	130	170	**3.0**	**0.29**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	3.2	0.14	0.35	90	150	**2.2**	**0.29**	**130**
			10		280 HB	0.5	3.2	0.14	0.35	90	130	**2.2**	**0.29**	**120**
			11		320 HB	0.5	3.2	0.14	0.29	60	110	**2.2**	**0.26**	**100**
			11		350 HB	0.5	3.2	0.14	0.29	60	90	**2.2**	**0.26**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	4.5	0.18	0.35	190	250	**3.0**	**0.29**	**220**
			14		240 HB	0.5	4.5	0.14	0.32	160	210	**3.0**	**0.29**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	3.2	0.14	0.29	70	130	**2.2**	**0.26**	**100**
			14		310 HB	0.5	3.2	0.14	0.29	70	120	**2.2**	**0.26**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	4.5	0.18	0.35	150	210	**3.0**	**0.29**	**190**
			13		42 HRc	0.5	3.2	0.18	0.32	90	150	**2.2**	**0.26**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.5	0.22	0.51	150	240	**3.0**	**0.37**	**200**
			15		200 HB	0.5	4.5	0.22	0.51	150	220	**3.0**	**0.37**	**180**
			16		250 HB	0.5	4.5	0.22	0.51	150	190	**3.0**	**0.37**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.5	0.18	0.45	100	200	**3.0**	**0.32**	**180**
			17,19		200 HB	0.5	4.5	0.18	0.45	100	180	**3.0**	**0.32**	**150**
			18,20		250 HB	0.5	4.5	0.18	0.45	100	150	**3.0**	**0.32**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	3.2	0.14	0.29	25	45	**2.2**	**0.26**	**32**
			33	Inconel 700	250 HB	0.5	3.2	0.14	0.29	25	45	**2.2**	**0.26**	**30**
			34	Stellite 21	350 HB	0.5	3.2	0.14	0.29	25	45	**2.2**	**0.26**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	3.2	0.14	0.32	40	65	**2.2**	**0.29**	**55**
			37	T40	-	0.5	3.2	0.14	0.29	30	55	**2.2**	**0.26**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.6	0.12	0.29	40	80	**1.3**	**0.22**	**60**
			38		50 HRc	0.4	1.3	0.12	0.26	40	70	**0.9**	**0.21**	**55**
			38		55 HRc	0.4	1.0	0.12	0.22	40	60	**0.7**	**0.19**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.3	0.12	0.29	40	80	**0.9**	**0.22**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.12	0.22	30	60	**0.7**	**0.19**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	4.5	0.22	0.51	200	400	**3.0**	**0.40**	**280**

O N K X

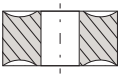
Shape

Clearance Angle



Tolerance

s ± 0.13
For l = 05, **d** ± 0.08 **m** ± 0.13
For l = 07, **d** ± 0.10 **m** ± 0.15



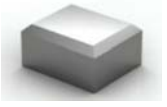
Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
ONKX 0806-45 LT 30	8.36	5.80	0.8	Neutral	M0003673

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
ONKX 0806-45 LT 30	8.36	5.80	0.8	Neutral	M0002211

Application Guide

Chamfering



Surfacing

Machining Recommendations

F ⇒ Productivity

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

Stainless Steel
V_c

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
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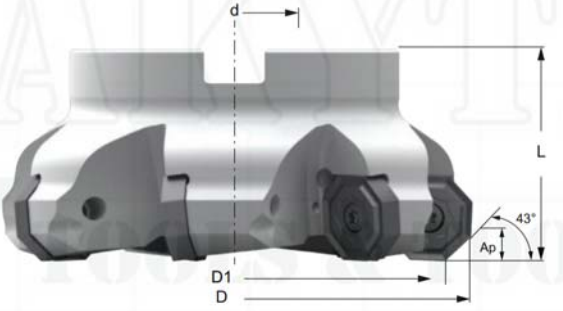
Shell Mill for ONKX 0806-45°

Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 987 M-W-D063/5	75.7	63	22	50	5	5	M2003631
LT 987 M-W-D080/6	92.7	80	27	50	5	6	M2003632
LT 987 M-W-D100/7	112.7	100	32	50	5	7	M2003633
LT 987 M-W-D125/8	137.7	125	40	63	5	8	M2003634
LT 987 M-D-D160/10 [1]	172.7	160	40	63	5	10	M2003635
LT 987 M-D-D200/12* [1]	212.7	200	60	63	5	12	M2003636
LT 987 M-D-D250/14* [1]	262.7	250	60	63	5	14	M2003637

* On request

[1] Accessories available for coolant:
M2003635: M2004024
M2003636-7: M2001847

Screw: M2000599
Key: M2000603



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ONKX 0806-45 – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	4.0	0.16	0.58	190	330	**3.0**	**0.46**	**250**
			2		190 HB	0.5	4.0	0.16	0.58	190	300	**3.0**	**0.46**	**220**
			3		250 HB	0.5	4.0	0.16	0.58	190	250	**3.0**	**0.46**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.0	0.14	0.50	150	240	**3.0**	**0.40**	**200**
			4,6		230 HB	0.5	4.0	0.14	0.50	150	210	**3.0**	**0.40**	**180**
			5,7		280 HB	0.5	4.0	0.14	0.44	130	190	**3.0**	**0.36**	**150**
			8		350 HB	0.5	4.0	0.14	0.44	130	170	**3.0**	**0.36**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4.0	0.11	0.44	90	150	**3.0**	**0.36**	**130**
			10		280 HB	0.5	4.0	0.11	0.44	90	130	**3.0**	**0.36**	**120**
			11		320 HB	0.5	4.0	0.11	0.36	60	110	**3.0**	**0.32**	**100**
			11		350 HB	0.5	4.0	0.11	0.36	60	90	**3.0**	**0.32**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	1.5	0.14	0.44	190	250	**1.2**	**0.34**	**220**
			14		240 HB	0.5	1.5	0.11	0.40	160	210	**1.2**	**0.34**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	1.5	0.11	0.36	70	130	**1.2**	**0.30**	**100**
			14		310 HB	0.5	1.5	0.11	0.36	70	120	**1.2**	**0.30**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	1.5	0.14	0.44	150	210	**1.2**	**0.34**	**190**
			13		42 HRc	0.5	1.5	0.14	0.40	90	150	**1.2**	**0.30**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.0	0.17	0.58	150	240	**4.0**	**0.46**	**200**
			15		200 HB	0.5	4.0	0.17	0.58	150	220	**4.0**	**0.46**	**180**
			16		250 HB	0.5	4.0	0.17	0.58	150	190	**4.0**	**0.46**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.0	0.14	0.52	100	200	**4.0**	**0.40**	**180**
			17,19		200 HB	0.5	4.0	0.14	0.52	100	180	**4.0**	**0.40**	**150**
			18,20		250 HB	0.5	4.0	0.14	0.52	100	150	**4.0**	**0.40**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	1.5	0.11	0.36	25	45	**1.2**	**0.30**	**32**
			33	Inconel 700	250 HB	0.5	1.5	0.11	0.36	25	45	**1.2**	**0.30**	**30**
			34	Stellite 21	350 HB	0.5	1.5	0.11	0.36	25	45	**1.2**	**0.30**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	1.5	0.11	0.40	40	65	**1.2**	**0.34**	**55**
			37	T40	-	0.5	1.5	0.11	0.36	30	55	**1.2**	**0.30**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	3.0	0.10	0.36	40	80	**2.0**	**0.28**	**60**
			38		50 HRc	0.4	3.0	0.10	0.32	40	70	**1.0**	**0.26**	**55**
			38		55 HRc	0.4	1.5	0.10	0.28	40	60	**0.5**	**0.24**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	3.0	0.10	0.36	40	80	**1.5**	**0.28**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.5	0.10	0.28	30	60	**0.5**	**0.24**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	1.5	0.17	0.60	200	400	**1.5**	**0.50**	**280**

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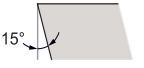
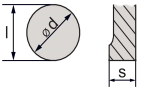
R D M T

Shape

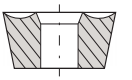


Clearance Angle



Tolerance

s ± 0.13
For l = 06/08/10, **d** ± 0.05
For l = 12, **d** ± 0.08



Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

Insert Designation	l	s	r	Direction	Catalog Nr.
RDMT 0602 M0 LT 30	6	2.38	-	Neutral	M0000035
RDMT 0702 M0 LT 30	7	2.38	-	Neutral	M0001882
RDMT 0803 M0 LT 30	8	3.18	-	Neutral	M0000037
RDMT 1003 M0 LT 30	10	3.18	-	Neutral	M0001875
RDMT 10T3 M0 LT 30	10	3.97	-	Neutral	M0000038
RDMT 12T3 M0 LT 30	12	3.97	-	Neutral	M0001876
RDMT 1204 M0 LT 30	12	4.76	-	Neutral	M0000039
RDMT 1604 M0 LT 30	16	4.76	-	Neutral	M0001881

Application Guide

Copying

Helical Interpolation

Pocket Milling

Slotting

Surfacing

Machining Recommendations

F ⇒
Productivity

Coolant

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

Stainless Steel
V_c

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
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R D M T

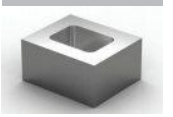
LT 3000 Multi-Mat™ General Usage – Premium					
Insert Designation	l	s	r	Direction	Catalog Nr.
RDMT 0602 M0 LT 3000	6	2.38	-	Neutral	M0003403
RDMT 0702 M0 LT 3000	7	2.38	-	Neutral	M0003404
RDMT 0803 M0 LT 3000	8	3.18	-	Neutral	M0003405
RDMT 1003 M0 LT 3000	10	3.18	-	Neutral	M0002224
RDMT 10T3 M0 LT 3000	10	3.97	-	Neutral	M0002225
RDMT 12T3 M0 LT 3000	12	3.97	-	Neutral	M0002226
RDMT 1204 M0 LT 3000	12	4.76	-	Neutral	M0002227
RDMT 1604 M0 LT 3000	16	4.76	-	Neutral	M0003407

Application Guide

Copying

Helical Interpolation

Pocket-Milling



Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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тел. 8 (499) 550 5039, mail@akytec.ru
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End Mill for RDMT 0602 M0

Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 060 WL-W-D012/2	12	6	16	150	25	3	2	7	M2003321
LT 060 WL-W-D016/2	16	10	16	150	25	3	2	6	M2000676
LT 060 WL-W-D020/3	20	14	20	180	60	3	3	4.5	M2000677
LT 060 WL-W-D025/3	25	19	25	180	80	3	3	4	M2000678

Screw: M2001416
Key: M2002912

End Mill for RDMT 0704 M0

Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 070 WL-W-D016/2	16	9	16	150	25	3.5	2	6	M2003336
LT 070 WL-W D020/3	20	13	20	180	60	3.5	3	4.5	M2003337
LT 070 WL-W D025/4	25	18	25	180	60	3.5	4	4	M2003339

Screw: M2001416
Key: M2002912

End Mill for RDMT 0803 M0

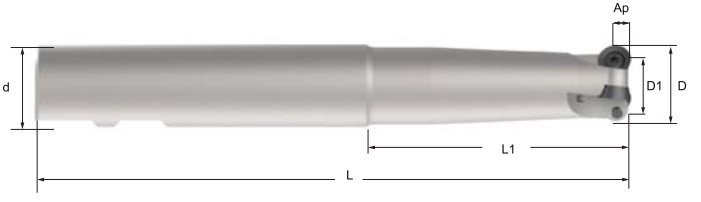
Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 080 WL-W-D016/2	16	8	16	150	25	4	2	12	M2003322
LT 080 WL-W-D020/2	20	12	16	180	42	4	2	6	M2000679
LT 080 WL-W-D025/3	25	17	20	180	60	4	3	4.5	M2000680
LT 080 WL-W-D032/3	32	24	25	180	80	4	3	4	M2000681

Screw: M2002181
Key: M2002912

End Mill for RDMT 10T3 M0

Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 100 WL-W-D020/2	20	10	20	180	80	5	2	12	M2000683
LT 100 WL-W D025/3	25	15	25	180	60	5	3	8	M2000684
LT 100 WL-W D032/3	32	22	32	180	80	5	3	5	M2000685

Screw: M2000597
Key: M2000602



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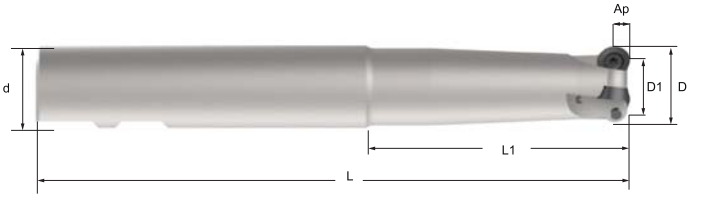
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for RDMT 1204 M0

Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 120 WL-W-D032/3	32	20	32	170	60	6	3	5	M2003323
LT 120 WL-W-D040/4	40	28	32	170	110	6	4	7	M2000687

Screw: M2000597
Key: M2000602



Shell Mill for RDMT 1204 M0

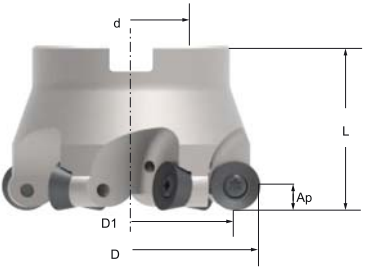
Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 120 M-W-D040/4	40	28	16	40	6	4	7	M2000691
LT 120 M-W-D050/4	50	38	22	40	6	4	5	M2001780
LT 120 M-W-D063/5	63	51	22	40	6	5	3.5	M2000689
LT 120 M-W-D080/6	80	68	27	50	6	6	2.5	M2000690
LT 120 M-W-D100/7	100	88	40	50	6	7	1.5	M2000688

Screw: M2000597
Key: M2000602

Shell Mill for RDMT 1604 M0

Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 160 M-W-D050/4	50	34	22	50	6	4	5	M2003331
LT 160 M-W-D063/5	63	47	22	50	6	5	3.5	M2003332
LT 160 M-W-D080/6	80	64	27	50	6	6	2.5	M2003333
LT 160 M-W-D100/7	100	84	32	50	6	7	2	M2003334
LT 160 M-W-D125/8	125	109	40	63	6	8	1	M2003335

Screw: M2000599
Key: M2000603



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

RDMT 0602 M0 – **LT 30 | LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	1.5	0.18	0.48	190	330	**0.8**	**0.29**	**250**
			2		190 HB	0.5	1.5	0.18	0.48	190	300	**0.8**	**0.29**	**220**
			3		250 HB	0.5	1.5	0.18	0.48	190	250	**0.8**	**0.29**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	1.5	0.15	0.38	150	240	**0.8**	**0.25**	**200**
			4,6		230 HB	0.5	1.5	0.15	0.38	150	210	**0.8**	**0.25**	**180**
			5,7		280 HB	0.5	1.5	0.15	0.33	130	190	**0.8**	**0.23**	**150**
			8		350 HB	0.5	1.5	0.15	0.33	130	170	**0.8**	**0.23**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.1	0.12	0.33	90	150	**0.6**	**0.23**	**130**
			10		280 HB	0.5	1.1	0.12	0.33	90	130	**0.6**	**0.23**	**120**
			11		320 HB	0.5	1.1	0.12	0.27	60	110	**0.6**	**0.20**	**100**
			11		350 HB	0.5	1.1	0.12	0.27	60	90	**0.6**	**0.20**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	1.5	0.15	0.38	190	250	**0.8**	**0.25**	**220**
			14		240 HB	0.5	1.5	0.12	0.33	160	210	**0.8**	**0.25**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	1.2	0.12	0.27	70	130	**0.6**	**0.20**	**100**
			14		310 HB	0.5	1.2	0.12	0.27	70	120	**0.6**	**0.20**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	1.5	0.15	0.38	150	210	**0.8**	**0.25**	**190**
			13		42 HRc	0.5	1.2	0.15	0.30	90	150	**0.6**	**0.20**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	1.5	0.18	0.48	150	240	**0.8**	**0.29**	**200**
			15		200 HB	0.5	1.5	0.18	0.48	150	220	**0.8**	**0.29**	**180**
			16		250 HB	0.5	1.5	0.18	0.48	150	190	**0.8**	**0.29**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	1.5	0.15	0.42	100	200	**0.8**	**0.25**	**180**
			17,19		200 HB	0.5	1.5	0.15	0.42	100	180	**0.8**	**0.25**	**150**
			18,20		250 HB	0.5	1.5	0.15	0.42	100	150	**0.8**	**0.25**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	1.2	0.12	0.27	25	45	**0.6**	**0.20**	**32**
			33	Inconel 700	250 HB	0.5	1.2	0.12	0.27	25	45	**0.6**	**0.20**	**30**
			34	Stellite 21	350 HB	0.5	1.2	0.12	0.27	25	45	**0.6**	**0.20**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	1.2	0.12	0.30	40	65	**0.6**	**0.23**	**55**
			37	T40	-	0.5	1.2	0.12	0.27	30	55	**0.6**	**0.20**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.6	0.10	0.27	40	80	**0.4**	**0.18**	**60**
			38		50 HRc	0.3	0.4	0.10	0.24	40	70	**0.3**	**0.16**	**55**
			38		55 HRc	0.3	0.4	0.10	0.21	40	60	**0.3**	**0.15**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.4	0.10	0.27	40	80	**0.3**	**0.18**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.4	0.10	0.21	30	60	**0.3**	**0.15**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	1.5	0.18	0.48	200	400	**0.8**	**0.31**	**280**

RDMT 0702 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	1.8	0.18	0.54	190	330	**0.8**	**0.32**	**250**
			2		190 HB	0.5	1.8	0.18	0.54	190	300	**0.8**	**0.32**	**220**
			3		250 HB	0.5	1.8	0.18	0.54	190	250	**0.8**	**0.32**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	1.8	0.15	0.43	150	240	**0.8**	**0.28**	**200**
			4,6		230 HB	0.5	1.8	0.15	0.43	150	210	**0.8**	**0.28**	**180**
			5,7		280 HB	0.5	1.8	0.15	0.37	130	190	**0.8**	**0.25**	**150**
			8		350 HB	0.5	1.8	0.15	0.37	130	170	**0.8**	**0.25**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.3	0.12	0.37	90	150	**0.6**	**0.25**	**130**
			10		280 HB	0.5	1.3	0.12	0.37	90	130	**0.6**	**0.25**	**120**
			11		320 HB	0.5	1.3	0.12	0.31	60	110	**0.6**	**0.22**	**100**
			11		350 HB	0.5	1.3	0.12	0.31	60	90	**0.6**	**0.22**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	1.8	0.15	0.43	190	250	**0.8**	**0.28**	**220**
			14		240 HB	0.5	1.8	0.12	0.37	160	210	**0.8**	**0.28**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	1.4	0.12	0.31	70	130	**0.6**	**0.22**	**100**
			14		310 HB	0.5	1.4	0.12	0.31	70	120	**0.6**	**0.22**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	1.8	0.15	0.43	150	210	**0.8**	**0.28**	**190**
			13		42 HRc	0.5	1.4	0.15	0.34	90	150	**0.6**	**0.22**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	1.8	0.18	0.54	150	240	**0.8**	**0.32**	**200**
			15		200 HB	0.5	1.8	0.18	0.54	150	220	**0.8**	**0.32**	**180**
			16		250 HB	0.5	1.8	0.18	0.54	150	190	**0.8**	**0.32**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	1.8	0.15	0.48	100	200	**0.8**	**0.28**	**180**
			17,19		200 HB	0.5	1.8	0.15	0.48	100	180	**0.8**	**0.28**	**150**
			18,20		250 HB	0.5	1.8	0.15	0.48	100	150	**0.8**	**0.28**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	1.4	0.12	0.31	25	45	**0.6**	**0.22**	**32**
			33	Inconel 700	250 HB	0.5	1.4	0.12	0.31	25	45	**0.6**	**0.22**	**30**
			34	Stellite 21	350 HB	0.5	1.4	0.12	0.31	25	45	**0.6**	**0.22**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	1.4	0.12	0.34	40	65	**0.6**	**0.25**	**55**
			37	T40	-	0.5	1.4	0.12	0.31	30	55	**0.6**	**0.22**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.7	0.10	0.31	40	80	**0.4**	**0.20**	**60**
			38		50 HRc	0.3	0.5	0.10	0.27	40	70	**0.3**	**0.18**	**55**
			38		55 HRc	0.3	0.5	0.10	0.24	40	60	**0.3**	**0.17**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.5	0.10	0.31	40	80	**0.3**	**0.20**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.5	0.10	0.24	30	60	**0.3**	**0.17**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	1.8	0.18	0.54	200	400	**0.8**	**0.35**	**280**

RDMT 0803 M0 – **LT 30 | LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.0	0.18	0.58	190	330	**0.8**	**0.35**	**250**
			2		190 HB	0.5	2.0	0.18	0.58	190	300	**0.8**	**0.35**	**220**
			3		250 HB	0.5	2.0	0.18	0.58	190	250	**0.8**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.0	0.15	0.45	150	240	**0.8**	**0.30**	**200**
			4,6		230 HB	0.5	2.0	0.15	0.45	150	210	**0.8**	**0.30**	**180**
			5,7		280 HB	0.5	2.0	0.15	0.40	130	190	**0.8**	**0.27**	**150**
			8		350 HB	0.5	2.0	0.15	0.40	130	170	**0.8**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.4	0.12	0.40	90	150	**0.6**	**0.27**	**130**
			10		280 HB	0.5	1.4	0.12	0.40	90	130	**0.6**	**0.27**	**120**
			11		320 HB	0.5	1.4	0.12	0.32	60	110	**0.6**	**0.24**	**100**
			11		350 HB	0.5	1.4	0.12	0.32	60	90	**0.6**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	2.0	0.15	0.45	190	250	**0.8**	**0.30**	**220**
			14		240 HB	0.5	2.0	0.12	0.40	160	210	**0.8**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	1.5	0.12	0.32	70	130	**0.6**	**0.24**	**100**
			14		310 HB	0.5	1.5	0.12	0.32	70	120	**0.6**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	2.0	0.15	0.45	150	210	**0.8**	**0.30**	**190**
			13		42 HRc	0.5	1.5	0.15	0.36	90	150	**0.6**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.0	0.18	0.58	150	240	**0.8**	**0.35**	**200**
			15		200 HB	0.5	2.0	0.18	0.58	150	220	**0.8**	**0.35**	**180**
			16		250 HB	0.5	2.0	0.18	0.58	150	190	**0.8**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.0	0.15	0.50	100	200	**0.8**	**0.30**	**180**
			17,19		200 HB	0.5	2.0	0.15	0.50	100	180	**0.8**	**0.30**	**150**
			18,20		250 HB	0.5	2.0	0.15	0.50	100	150	**0.8**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	1.5	0.12	0.32	25	45	**0.6**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	1.5	0.12	0.32	25	45	**0.6**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	1.5	0.12	0.32	25	45	**0.6**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	1.5	0.12	0.36	40	65	**0.6**	**0.27**	**55**
			37	T40	-	0.5	1.5	0.12	0.32	30	55	**0.6**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.7	0.10	0.32	40	80	**0.4**	**0.21**	**60**
			38		50 HRc	0.3	0.6	0.10	0.29	40	70	**0.3**	**0.20**	**55**
			38		55 HRc	0.3	0.5	0.10	0.25	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.6	0.10	0.32	40	80	**0.3**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.5	0.10	0.25	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	2.0	0.18	0.58	200	400	**0.8**	**0.38**	**280**

RDMT 10T3 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.5	0.18	0.64	190	330	**1.0**	**0.35**	**250**
			2		190 HB	0.5	2.5	0.18	0.64	190	300	**1.0**	**0.35**	**220**
			3		250 HB	0.5	2.5	0.18	0.64	190	250	**1.0**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.5	0.15	0.50	150	240	**1.0**	**0.30**	**200**
			4,6		230 HB	0.5	2.5	0.15	0.50	150	210	**1.0**	**0.30**	**180**
			5,7		280 HB	0.5	2.5	0.15	0.44	130	190	**1.0**	**0.27**	**150**
			8		350 HB	0.5	2.5	0.15	0.44	130	170	**1.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.8	0.12	0.44	90	150	**0.8**	**0.27**	**130**
			10		280 HB	0.5	1.8	0.12	0.44	90	130	**0.8**	**0.27**	**120**
			11		320 HB	0.5	1.8	0.12	0.36	60	110	**0.8**	**0.24**	**100**
			11		350 HB	0.5	1.8	0.12	0.36	60	90	**0.8**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	2.5	0.15	0.50	190	250	**1.0**	**0.30**	**220**
			14		240 HB	0.5	2.5	0.12	0.44	160	210	**1.0**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.0	0.12	0.36	70	130	**0.8**	**0.24**	**100**
			14		310 HB	0.5	2.0	0.12	0.36	70	120	**0.8**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	2.5	0.15	0.50	150	210	**1.0**	**0.30**	**190**
			13		42 HRc	0.5	2.0	0.15	0.40	90	150	**0.8**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.5	0.18	0.64	150	240	**1.0**	**0.35**	**200**
			15		200 HB	0.5	2.5	0.18	0.64	150	220	**1.0**	**0.35**	**180**
			16		250 HB	0.5	2.5	0.18	0.64	150	190	**1.0**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.5	0.15	0.56	100	200	**1.0**	**0.30**	**180**
			17,19		200 HB	0.5	2.5	0.15	0.56	100	180	**1.0**	**0.30**	**150**
			18,20		250 HB	0.5	2.5	0.15	0.56	100	150	**1.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.0	0.12	0.40	40	65	**0.8**	**0.27**	**55**
			37	T40	-	0.5	2.0	0.12	0.36	30	55	**0.8**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.9	0.10	0.36	40	80	**0.5**	**0.21**	**60**
			38		50 HRc	0.3	0.7	0.10	0.32	40	70	**0.4**	**0.20**	**55**
			38		55 HRc	0.3	0.6	0.10	0.28	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.10	0.36	40	80	**0.4**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.10	0.28	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	2.5	0.18	0.64	200	400	**1.0**	**0.38**	**280**

RDMT 1003 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.5	0.18	0.64	190	330	**1.0**	**0.35**	**250**
			2		190 HB	0.5	2.5	0.18	0.64	190	300	**1.0**	**0.35**	**220**
			3		250 HB	0.5	2.5	0.18	0.64	190	250	**1.0**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.5	0.15	0.50	150	240	**1.0**	**0.30**	**200**
			4,6		230 HB	0.5	2.5	0.15	0.50	150	210	**1.0**	**0.30**	**180**
			5,7		280 HB	0.5	2.5	0.15	0.44	130	190	**1.0**	**0.27**	**150**
			8		350 HB	0.5	2.5	0.15	0.44	130	170	**1.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.8	0.12	0.44	90	150	**0.8**	**0.27**	**130**
			10		280 HB	0.5	1.8	0.12	0.44	90	130	**0.8**	**0.27**	**120**
			11		320 HB	0.5	1.8	0.12	0.36	60	110	**0.8**	**0.24**	**100**
			11		350 HB	0.5	1.8	0.12	0.36	60	90	**0.8**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	2.5	0.15	0.50	190	250	**1.0**	**0.30**	**220**
			14		240 HB	0.5	2.5	0.12	0.44	160	210	**1.0**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.0	0.12	0.36	70	130	**0.8**	**0.24**	**100**
			14		310 HB	0.5	2.0	0.12	0.36	70	120	**0.8**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	2.5	0.15	0.50	150	210	**1.0**	**0.30**	**190**
			13		42 HRc	0.5	2.0	0.15	0.40	90	150	**0.8**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.5	0.18	0.64	150	240	**1.0**	**0.35**	**200**
			15		200 HB	0.5	2.5	0.18	0.64	150	220	**1.0**	**0.35**	**180**
			16		250 HB	0.5	2.5	0.18	0.64	150	190	**1.0**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.5	0.15	0.56	100	200	**1.0**	**0.30**	**180**
			17,19		200 HB	0.5	2.5	0.15	0.56	100	180	**1.0**	**0.30**	**150**
			18,20		250 HB	0.5	2.5	0.15	0.56	100	150	**1.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	2.0	0.12	0.36	25	45	**0.8**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.0	0.12	0.40	40	65	**0.8**	**0.27**	**55**
			37	T40	-	0.5	2.0	0.12	0.36	30	55	**0.8**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.9	0.10	0.36	40	80	**0.5**	**0.21**	**60**
			38		50 HRc	0.3	0.7	0.10	0.32	40	70	**0.4**	**0.20**	**55**
			38		55 HRc	0.3	0.6	0.10	0.28	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.10	0.36	40	80	**0.4**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.10	0.28	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	2.5	0.18	0.64	200	400	**1.0**	**0.38**	**280**

RDMT 12T3 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.0	0.25	0.74	190	330	**1.3**	**0.35**	**250**
			2		190 HB	0.5	3.0	0.25	0.74	190	300	**1.3**	**0.35**	**220**
			3		250 HB	0.5	3.0	0.25	0.74	190	250	**1.3**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.0	0.21	0.58	150	240	**1.3**	**0.30**	**200**
			4,6		230 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**180**
			5,7		280 HB	0.5	3.0	0.21	0.51	130	190	**1.3**	**0.27**	**150**
			8		350 HB	0.5	3.0	0.21	0.51	130	170	**1.3**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.2	0.17	0.51	90	150	**1.0**	**0.27**	**130**
			10		280 HB	0.5	2.2	0.17	0.51	90	130	**1.0**	**0.27**	**120**
			11		320 HB	0.5	2.2	0.17	0.41	60	110	**1.0**	**0.24**	**100**
			11		350 HB	0.5	2.2	0.17	0.41	60	90	**1.0**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.0	0.21	0.58	190	250	**1.3**	**0.30**	**220**
			14		240 HB	0.5	3.0	0.17	0.51	160	210	**1.3**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.4	0.17	0.41	70	130	**1.0**	**0.24**	**100**
			14		310 HB	0.5	2.4	0.17	0.41	70	120	**1.0**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**190**
			13		42 HRc	0.5	2.4	0.21	0.46	90	150	**1.0**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.0	0.25	0.74	150	240	**1.3**	**0.35**	**200**
			15		200 HB	0.5	3.0	0.25	0.74	150	220	**1.3**	**0.35**	**180**
			16		250 HB	0.5	3.0	0.25	0.74	150	190	**1.3**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.0	0.21	0.64	100	200	**1.3**	**0.30**	**180**
			17,19		200 HB	0.5	3.0	0.21	0.64	100	180	**1.3**	**0.30**	**150**
			18,20		250 HB	0.5	3.0	0.21	0.64	100	150	**1.3**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.4	0.17	0.46	40	65	**1.0**	**0.27**	**55**
			37	T40	-	0.5	2.4	0.17	0.41	30	55	**1.0**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	1.1	0.14	0.41	40	80	**0.7**	**0.21**	**60**
			38		50 HRc	0.3	0.9	0.14	0.37	40	70	**0.5**	**0.20**	**55**
			38		55 HRc	0.3	0.8	0.14	0.32	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.9	0.14	0.41	40	80	**0.5**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.8	0.14	0.32	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.0	0.25	0.74	200	400	**1.3**	**0.38**	**280**

RDMT 1204 M0 – **LT 30 | LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.0	0.25	0.74	190	330	**1.3**	**0.35**	**250**
			2		190 HB	0.5	3.0	0.25	0.74	190	300	**1.3**	**0.35**	**220**
			3		250 HB	0.5	3.0	0.25	0.74	190	250	**1.3**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.0	0.21	0.58	150	240	**1.3**	**0.30**	**200**
			4,6		230 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**180**
			5,7		280 HB	0.5	3.0	0.21	0.51	130	190	**1.3**	**0.27**	**150**
			8		350 HB	0.5	3.0	0.21	0.51	130	170	**1.3**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.2	0.17	0.51	90	150	**1.0**	**0.27**	**130**
			10		280 HB	0.5	2.2	0.17	0.51	90	130	**1.0**	**0.27**	**120**
			11		320 HB	0.5	2.2	0.17	0.41	60	110	**1.0**	**0.24**	**100**
			11		350 HB	0.5	2.2	0.17	0.41	60	90	**1.0**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.0	0.21	0.58	190	250	**1.3**	**0.30**	**220**
			14		240 HB	0.5	3.0	0.17	0.51	160	210	**1.3**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.4	0.17	0.41	70	130	**1.0**	**0.24**	**100**
			14		310 HB	0.5	2.4	0.17	0.41	70	120	**1.0**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**190**
			13		42 HRc	0.5	2.4	0.21	0.46	90	150	**1.0**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.0	0.25	0.74	150	240	**1.3**	**0.35**	**200**
			15		200 HB	0.5	3.0	0.25	0.74	150	220	**1.3**	**0.35**	**180**
			16		250 HB	0.5	3.0	0.25	0.74	150	190	**1.3**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.0	0.21	0.64	100	200	**1.3**	**0.30**	**180**
			17,19		200 HB	0.5	3.0	0.21	0.64	100	180	**1.3**	**0.30**	**150**
			18,20		250 HB	0.5	3.0	0.21	0.64	100	150	**1.3**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.4	0.17	0.46	40	65	**1.0**	**0.27**	**55**
			37	T40	-	0.5	2.4	0.17	0.41	30	55	**1.0**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	1.1	0.14	0.41	40	80	**0.7**	**0.21**	**60**
			38		50 HRc	0.3	0.9	0.14	0.37	40	70	**0.5**	**0.20**	**55**
			38		55 HRc	0.3	0.8	0.14	0.32	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.9	0.14	0.41	40	80	**0.5**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.8	0.14	0.32	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.0	0.25	0.74	200	400	**1.3**	**0.38**	**280**

RDMT 1604 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	4.0	0.25	1.00	190	330	**2.0**	**0.35**	**250**
			2		190 HB	0.5	4.0	0.25	1.00	190	300	**2.0**	**0.35**	**220**
			3		250 HB	0.5	4.0	0.25	1.00	190	250	**2.0**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	4.0	0.21	0.78	150	240	**2.0**	**0.30**	**200**
			4,6		230 HB	0.5	4.0	0.21	0.78	150	210	**2.0**	**0.30**	**180**
			5,7		280 HB	0.5	4.0	0.21	0.69	130	190	**2.0**	**0.27**	**150**
			8		350 HB	0.5	4.0	0.21	0.69	130	170	**2.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.9	0.17	0.69	90	150	**1.5**	**0.27**	**130**
			10		280 HB	0.5	2.9	0.17	0.69	90	130	**1.5**	**0.27**	**120**
			11		320 HB	0.5	2.9	0.17	0.56	60	110	**1.5**	**0.24**	**100**
			11		350 HB	0.5	2.9	0.17	0.56	60	90	**1.5**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	4.0	0.21	0.78	190	250	**2.0**	**0.30**	**220**
			14		240 HB	0.5	4.0	0.17	0.69	160	210	**2.0**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	3.1	0.17	0.56	70	130	**1.5**	**0.24**	**100**
			14		310 HB	0.5	3.1	0.17	0.56	70	120	**1.5**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	4.0	0.21	0.78	150	210	**2.0**	**0.30**	**190**
			13		42 HRc	0.5	3.1	0.21	0.63	90	150	**1.5**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	4.0	0.25	1.00	150	240	**2.0**	**0.35**	**200**
			15		200 HB	0.5	4.0	0.25	1.00	150	220	**2.0**	**0.35**	**180**
			16		250 HB	0.5	4.0	0.25	1.00	150	190	**2.0**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	4.0	0.21	0.88	100	200	**2.0**	**0.30**	**180**
			17,19		200 HB	0.5	4.0	0.21	0.88	100	180	**2.0**	**0.30**	**150**
			18,20		250 HB	0.5	4.0	0.21	0.88	100	150	**2.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	3.1	0.17	0.56	25	45	**1.5**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	3.1	0.17	0.56	25	45	**1.5**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	3.1	0.17	0.56	25	45	**1.5**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	3.1	0.17	0.63	40	65	**1.5**	**0.27**	**55**
			37	T40	-	0.5	3.1	0.17	0.56	30	55	**1.5**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	1.4	0.14	0.56	40	80	**1.0**	**0.21**	**60**
			38		50 HRc	0.4	1.1	0.14	0.50	40	70	**0.8**	**0.20**	**55**
			38		55 HRc	0.4	1.0	0.14	0.44	40	60	**0.5**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	1.1	0.14	0.56	40	80	**0.8**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.14	0.44	30	60	**0.5**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	4.0	0.25	1.00	200	400	**2.0**	**0.38**	**280**

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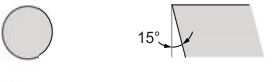
R D M W



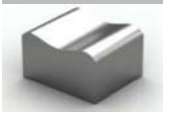
Shape | **Clearance Angle** | **Tolerance** d ± 0.05, s ± 0.13 | **Fixing, Chipbreaker**

LT 30 Multi-Mat™ General Usage – Standard					
Insert Designation	l	s	r	Direction	Catalog Nr.
RDMW 10T3 M0 LT 30	10	3.97	-	Neutral	M0001550
RDMW 1204 M0 LT 30	12	4.76	-	Neutral	M0001551

LT 3000 Multi-Mat™ General Usage – Premium					
Insert Designation	l	s	r	Direction	Catalog Nr.
RDMW 10T3 M0 LT 3000	10	3.97	-	Neutral	M0002228
RDMW 1204 M0 LT 3000	12	4.76	-	Neutral	M0003408

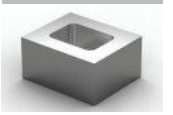
Application Guide

Copying



Helical Interpolation

Pocket Milling



Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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тел. 8 (499) 550 5039, mail@akytec.ru
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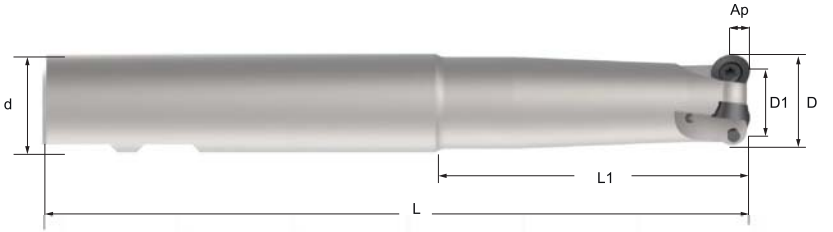
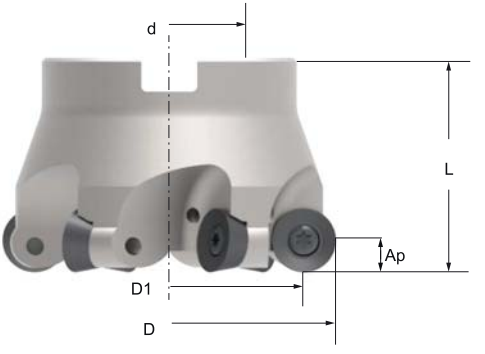
End Mill for RDMW 10T3 M0									
Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 100 WL-W-D020/2	20	10	20	180	80	5	2	12	M2000683
LT 100 WL-W D025/3	25	15	25	180	60	5	3	8	M2000684
LT 100 WL-W D032/3	32	22	32	180	80	5	3	5	M2000685

Screw: M2000597
Key: M2000602



Shell Mill for RDMW 1204 M0								
Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 120 M-W-D040/4	40	28	16	40	6	4	7	M2000691
LT 120 M-W-D050/4	50	38	22	40	6	4	5	M2001780
LT 120 M-W-D063/5	63	51	22	40	6	5	3.5	M2000689
LT 120 M-W-D080/6	80	68	27	50	6	6	2.5	M2000690
LT 120 M-W-D100/7	100	88	40	50	6	7	1.5	M2000688

Screw: M2000597
Key: M2000602



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www.akytec.ru

RDMW 10T3 M0 – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.5	0.18	0.70	190	330	**1.0**	**0.39**	**250**
			2		190 HB	0.5	2.5	0.18	0.70	190	300	**1.0**	**0.39**	**220**
			3		250 HB	0.5	2.5	0.18	0.70	190	250	**1.0**	**0.39**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.5	0.15	0.55	150	240	**1.0**	**0.34**	**200**
			4,6		230 HB	0.5	2.5	0.15	0.55	150	210	**1.0**	**0.34**	**180**
			5,7		280 HB	0.5	2.5	0.15	0.48	130	190	**1.0**	**0.31**	**150**
			8		350 HB	0.5	2.5	0.15	0.48	130	170	**1.0**	**0.31**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.8	0.12	0.48	90	150	**0.8**	**0.31**	**130**
			10		280 HB	0.5	1.8	0.12	0.48	90	130	**0.8**	**0.31**	**120**
			11		320 HB	0.5	1.8	0.12	0.40	60	110	**0.8**	**0.27**	**100**
			11		350 HB	0.5	1.8	0.12	0.40	60	90	**0.8**	**0.27**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.5	0.18	0.70	150	240	**1.0**	**0.39**	**200**
			15		200 HB	0.5	2.5	0.18	0.70	150	220	**1.0**	**0.39**	**180**
			16		250 HB	0.5	2.5	0.18	0.70	150	190	**1.0**	**0.39**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.5	0.15	0.62	100	200	**1.0**	**0.34**	**180**
			17,19		200 HB	0.5	2.5	0.15	0.62	100	180	**1.0**	**0.34**	**150**
			18,20		250 HB	0.5	2.5	0.15	0.62	100	150	**1.0**	**0.34**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.9	0.10	0.40	40	80	**0.5**	**0.24**	**60**
			38		50 HRc	0.3	0.7	0.10	0.35	40	70	**0.4**	**0.22**	**55**
			38		55 HRc	0.3	0.6	0.10	0.31	40	60	**0.3**	**0.20**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.10	0.40	40	80	**0.4**	**0.24**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.10	0.31	30	60	**0.3**	**0.20**	**40**

RDMW 1204 M0 – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.5	0.18	0.70	190	330	1.0	0.39	250
			2		190 HB	0.5	2.5	0.18	0.70	190	300	1.0	0.39	220
			3		250 HB	0.5	2.5	0.18	0.70	190	250	1.0	0.39	200
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.5	0.15	0.55	150	240	1.0	0.34	200
			4,6		230 HB	0.5	2.5	0.15	0.55	150	210	1.0	0.34	180
			5,7		280 HB	0.5	2.5	0.15	0.48	130	190	1.0	0.31	150
			8		350 HB	0.5	2.5	0.15	0.48	130	170	1.0	0.31	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.8	0.12	0.48	90	150	0.8	0.31	130
			10		280 HB	0.5	1.8	0.12	0.48	90	130	0.8	0.31	120
			11		320 HB	0.5	1.8	0.12	0.40	60	110	0.8	0.27	100
			11		350 HB	0.5	1.8	0.12	0.40	60	90	0.8	0.27	80
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.5	0.18	0.70	150	240	1.0	0.39	200
			15		200 HB	0.5	2.5	0.18	0.70	150	220	1.0	0.39	180
			16		250 HB	0.5	2.5	0.18	0.70	150	190	1.0	0.39	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.5	0.15	0.62	100	200	1.0	0.34	180
			17,19		200 HB	0.5	2.5	0.15	0.62	100	180	1.0	0.34	150
			18,20		250 HB	0.5	2.5	0.15	0.62	100	150	1.0	0.34	130
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.9	0.10	0.40	40	80	0.5	0.24	60
			38		50 HRc	0.3	0.7	0.10	0.35	40	70	0.4	0.22	55
			38		55 HRc	0.3	0.6	0.10	0.31	40	60	0.3	0.20	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.10	0.40	40	80	0.4	0.24	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.10	0.31	30	60	0.3	0.20	40

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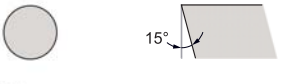

Shape | **Clearance Angle** | **Tolerance** d ± 0.05, s ± 0.13 | **Fixing, Chipbreaker**

LT 30 Multi-Mat™ General Usage – Standard					
Insert Designation	l	s	r	Direction	Catalog Nr.
RDMX 10T3 M0 LT 30	10	3.97	-	Neutral	M0001552
RDMX 1204 M0 LT 30	12	4.76	-	Neutral	M0001553

LT 3000 Multi-Mat™ General Usage – Premium					
Insert Designation	l	s	r	Direction	Catalog Nr.
RDMX 10T3 M0 LT 3000	10	3.97	-	Neutral	M0003409
RDMX 1204 M0 LT 3000	12	4.76	-	Neutral	M0003410

Application Guide

Copying

Helical Interpolation

Pocket Milling

Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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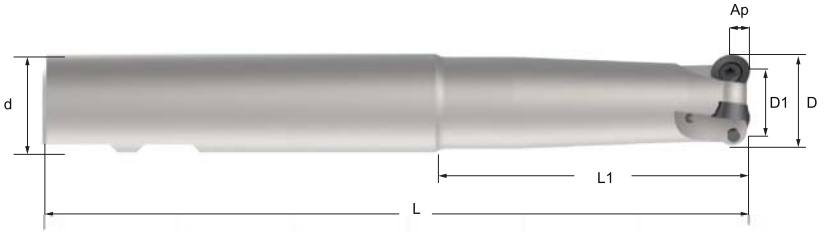
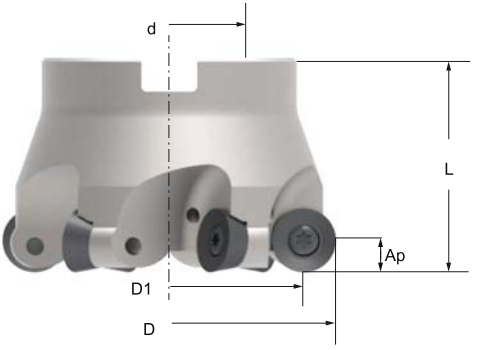
End Mill for RDMX 10T3 M0									
Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 100 WL-W-D020/2	20	10	20	180	80	5	2	12	M2000683
LT 100 WL-W D025/3	25	15	25	180	60	5	3	8	M2000684
LT 100 WL-W D032/3	32	22	32	180	80	5	3	5	M2000685

Screw: M2000597
Key: M2000602



Shell Mill for RDMX 1204 M0								
Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 120 M-W-D040/4	40	28	16	40	6	4	7	M2000691
LT 120 M-W-D050/4	50	38	22	40	6	4	5	M2001780
LT 120 M-W-D063/5	63	51	22	40	6	5	3.5	M2000689
LT 120 M-W-D080/6	80	68	27	50	6	6	2.5	M2000690
LT 120 M-W-D100/7	100	88	40	50	6	7	1.5	M2000688

Screw: M2000597
Key: M2000602



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RDMX 10T3 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	2.5	0.18	0.64	190	330	**1.000**	**0.345**	**250**
			2		190 HB	0.5	2.5	0.18	0.64	190	300	**1.000**	**0.345**	**220**
			3		250 HB	0.5	2.5	0.18	0.64	190	250	**1.000**	**0.345**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	2.5	0.15	0.50	150	240	**1.000**	**0.300**	**200**
			4,6		230 HB	0.5	2.5	0.15	0.50	150	210	**1.000**	**0.300**	**180**
			5,7		280 HB	0.5	2.5	0.15	0.44	130	190	**1.000**	**0.270**	**150**
			8		350 HB	0.5	2.5	0.15	0.44	130	170	**1.000**	**0.270**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	1.8	0.12	0.44	90	150	**0.750**	**0.270**	**130**
			10		280 HB	0.5	1.8	0.12	0.44	90	130	**0.750**	**0.270**	**120**
			11		320 HB	0.5	1.8	0.12	0.36	60	110	**0.750**	**0.240**	**100**
			11		350 HB	0.5	1.8	0.12	0.36	60	90	**0.750**	**0.240**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	2.5	0.15	0.50	190	250	**1.000**	**0.300**	**220**
			14		240 HB	0.5	2.5	0.12	0.44	160	210	**1.000**	**0.300**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.0	0.12	0.36	70	130	**0.750**	**0.240**	**100**
			14		310 HB	0.5	2.0	0.12	0.36	70	120	**0.750**	**0.240**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	2.5	0.15	0.50	150	210	**1.000**	**0.300**	**190**
			13		42 HRc	0.5	2.0	0.15	0.40	90	150	**0.750**	**0.240**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	2.5	0.18	0.64	150	240	**1.000**	**0.345**	**200**
			15		200 HB	0.5	2.5	0.18	0.64	150	220	**1.000**	**0.345**	**180**
			16		250 HB	0.5	2.5	0.18	0.64	150	190	**1.000**	**0.345**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	2.5	0.15	0.56	100	200	**1.000**	**0.300**	**180**
			17,19		200 HB	0.5	2.5	0.15	0.56	100	180	**1.000**	**0.300**	**150**
			18,20		250 HB	0.5	2.5	0.15	0.56	100	150	**1.000**	**0.300**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.0	0.12	0.36	25	45	**0.750**	**0.240**	**32**
			33	Inconel 700	250 HB	0.5	2.0	0.12	0.36	25	45	**0.750**	**0.240**	**30**
			34	Stellite 21	350 HB	0.5	2.0	0.12	0.36	25	45	**0.750**	**0.240**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.0	0.12	0.40	40	65	**0.750**	**0.270**	**55**
			37	T40	-	0.5	2.0	0.12	0.36	30	55	**0.750**	**0.240**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.9	0.10	0.36	40	80	**0.500**	**0.210**	**60**
			38		50 HRc	0.3	0.7	0.10	0.32	40	70	**0.375**	**0.195**	**55**
			38		55 HRc	0.3	0.6	0.10	0.28	40	60	**0.250**	**0.180**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.10	0.36	40	80	**0.375**	**0.210**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.10	0.28	30	60	**0.250**	**0.180**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	2.5	0.18	0.64	200	400	**1.000**	**0.375**	**280**

RDMX 1204 M0 – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	3.0	0.25	0.74	190	330	**1.3**	**0.35**	**250**
			2		190 HB	0.5	3.0	0.25	0.74	190	300	**1.3**	**0.35**	**220**
			3		250 HB	0.5	3.0	0.25	0.74	190	250	**1.3**	**0.35**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.0	0.21	0.58	150	240	**1.3**	**0.30**	**200**
			4,6		230 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**180**
			5,7		280 HB	0.5	3.0	0.21	0.51	130	190	**1.3**	**0.27**	**150**
			8		350 HB	0.5	3.0	0.21	0.51	130	170	**1.3**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.2	0.17	0.51	90	150	**1.0**	**0.27**	**130**
			10		280 HB	0.5	2.2	0.17	0.51	90	130	**1.0**	**0.27**	**120**
			11		320 HB	0.5	2.2	0.17	0.41	60	110	**1.0**	**0.24**	**100**
			11		350 HB	0.5	2.2	0.17	0.41	60	90	**1.0**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	3.0	0.21	0.58	190	250	**1.3**	**0.30**	**220**
			14		240 HB	0.5	3.0	0.17	0.51	160	210	**1.3**	**0.30**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	2.4	0.17	0.41	70	130	**1.0**	**0.24**	**100**
			14		310 HB	0.5	2.4	0.17	0.41	70	120	**1.0**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.0	0.21	0.58	150	210	**1.3**	**0.30**	**190**
			13		42 HRc	0.5	2.4	0.21	0.46	90	150	**1.0**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.0	0.25	0.74	150	240	**1.3**	**0.35**	**200**
			15		200 HB	0.5	3.0	0.25	0.74	150	220	**1.3**	**0.35**	**180**
			16		250 HB	0.5	3.0	0.25	0.74	150	190	**1.3**	**0.35**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	3.0	0.21	0.64	100	200	**1.3**	**0.30**	**180**
			17,19		200 HB	0.5	3.0	0.21	0.64	100	180	**1.3**	**0.30**	**150**
			18,20		250 HB	0.5	3.0	0.21	0.64	100	150	**1.3**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	2.4	0.17	0.41	25	45	**1.0**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	2.4	0.17	0.46	40	65	**1.0**	**0.27**	**55**
			37	T40	-	0.5	2.4	0.17	0.41	30	55	**1.0**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	1.1	0.14	0.41	40	80	**0.7**	**0.21**	**60**
			38		50 HRc	0.3	0.9	0.14	0.37	40	70	**0.5**	**0.20**	**55**
			38		55 HRc	0.3	0.8	0.14	0.32	40	60	**0.3**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.9	0.14	0.41	40	80	**0.5**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.8	0.14	0.32	30	60	**0.3**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	3.0	0.25	0.74	200	400	**1.3**	**0.38**	**280**

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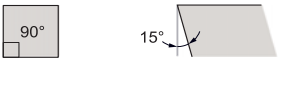

Shape

Clearance Angle

Tolerance
d ± 0.08
m ± 0.013
s ± 0.025

Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
SDKT 1204 AETN LT 30	12.7	4.76	-	Neutral	M0000171

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
SDKT 1204 AETN LT 3000	12.7	4.76	-	Neutral	M0003411

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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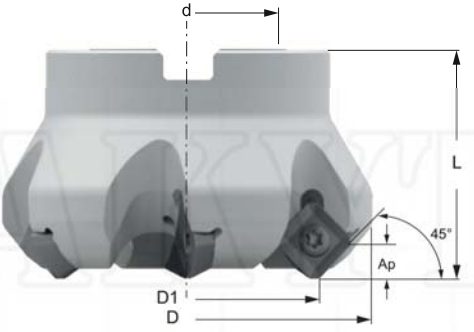
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SDKT 1204 AETN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 670 M-W-D050/4*	63	50	22	48	6	4	M2000553
LT 670 M-W-D063/5*	76	63	22	48	6	5	M2000555
LT 670 M-W-D080/6*	93	80	27	50	6	6	M2000556
LT 670 M-W-D100/6*	113	100	32	50	6	6	M2000557
LT 670 M-W-D125/7*	138	125	40	63	6	7	M2000558
LT 670 M-W-D160/8*	173	160	40	63	6	8	M2000559

* On request

Screw: M2000598
Key: M2000603



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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SDKT 1204 AETN – **LT 30 | LT 3000**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.53	190	330	**3.0**	**0.39**	**250**
			2		190 HB	0.5	7.0	0.18	0.53	190	300	**3.0**	**0.39**	**220**
			3		250 HB	0.5	7.0	0.18	0.53	190	250	**3.0**	**0.39**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.41	150	240	**3.0**	**0.34**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.41	150	210	**3.0**	**0.34**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.36	130	190	**3.0**	**0.31**	**150**
			8		350 HB	0.5	7.0	0.15	0.36	130	170	**3.0**	**0.31**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.36	90	150	**2.3**	**0.31**	**130**
			10		280 HB	0.5	5.0	0.12	0.36	90	130	**2.3**	**0.31**	**120**
			11		320 HB	0.5	5.0	0.12	0.30	60	110	**2.3**	**0.27**	**100**
			11		350 HB	0.5	5.0	0.12	0.30	60	90	**2.3**	**0.27**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.36	190	250	**3.0**	**0.31**	**220**
			14		240 HB	0.5	7.0	0.12	0.33	160	210	**3.0**	**0.31**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.30	70	130	**2.3**	**0.27**	**100**
			14		310 HB	0.5	5.0	0.12	0.30	70	120	**2.3**	**0.27**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.31**	**190**
			13		42 HRc	0.5	5.0	0.15	0.30	90	150	**2.3**	**0.27**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.53	150	240	**3.0**	**0.39**	**200**
			15		200 HB	0.5	7.0	0.18	0.53	150	220	**3.0**	**0.39**	**180**
			16		250 HB	0.5	7.0	0.18	0.53	150	190	**3.0**	**0.39**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.46	100	200	**3.0**	**0.34**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.46	100	180	**3.0**	**0.34**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.46	100	150	**3.0**	**0.34**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.30	25	45	**2.3**	**0.27**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.30	25	45	**2.3**	**0.27**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.30	25	45	**2.3**	**0.27**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.33	40	65	**2.3**	**0.31**	**55**
			37	T40	-	0.5	5.0	0.12	0.30	30	55	**2.3**	**0.27**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.30	40	80	**1.5**	**0.24**	**60**
			38		50 HRc	0.5	1.8	0.10	0.26	40	70	**1.1**	**0.22**	**55**
			38		55 HRc	0.5	1.5	0.10	0.23	40	60	**0.8**	**0.20**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.30	40	80	**1.1**	**0.24**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.23	30	60	**0.8**	**0.20**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.53	200	400	**3.0**	**0.43**	**280**

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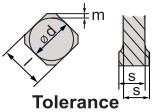
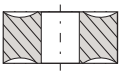
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

S D K X

Shape | **Clearance Angle**



Tolerance
d ± 0.08
m ± 0.013
s ± 0.025



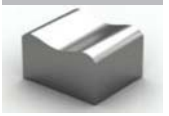
Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	R prog.	Direction	Catalog Nr.
SDKX 0904-HF LT 30	9.52	4.76	2.0	Right	M0003095
SDKX 1205-HF LT 30	12.7	5.56	2.5	Right	M0003096

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	R prog.	Direction	Catalog Nr.
SDKX 0904-HF LT 3000	9.52	4.76	2.0	Right	M0003413
SDKX 1205-HF LT 3000	12.7	5.56	2.5	Right	M0003412

Application Guide

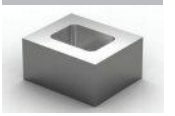
Copying



Helical Interpolation

Plunging

Pocket Milling



Ramping Down

Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel
V_c

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for SDKX 0904 HF

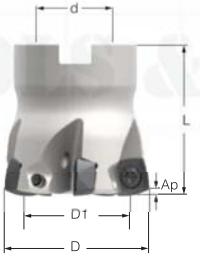
Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 902 WL-W-D025/2	25	9.6	25	120	60	1.5	2	3.5	M2003351
LT 902 W-W-D025/2	25	9.6	25	120	60	1.5	2	3.5	M2003350
LT 902 WL-W-D032/3	32	16.6	32	120	60	1.5	3	2.0	M2003353
LT 902 W-W-D032/3	32	16.6	32	200	60	1.5	3	2.0	M2003352

Screw: M2001420
Key: M2000602

Shell Mill for SDKX 0904 HF

Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 902 M-W-D040/5	40	24.6	16	40	1.5	5	0.8	M2003341
LT 902 M-W-D042/5	42	26.6	16	40	1.5	5	0.8	M2003342
LT 902 M-W-D050/6	50	34.6	22	40	1.5	6	0.7	M2003343
LT 902 M-W-D052/6	52	36.6	22	40	1.5	6	0.7	M2003344
LT 902 M-W-D063/6	63	47.6	22	40	1.5	6	0.6	M2003345
LT 902 M-W-D066/6	66	50.6	22	40	1.5	6	0.6	M2003346

Screw: M2001420
Key: M2000602



Screw Coupling for SDKX 0904 HF

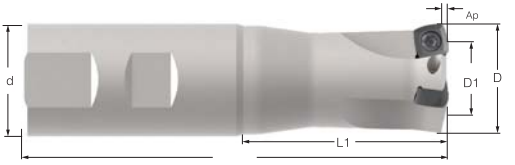
Cutter Designation	D	D1	d	L1	Ap	z	α	Catalog Nr.
LT 902 S-W-D025/2	25	9.6	M12	35	1.5	2	3.5	M2003347
LT 902 S-W-D032/3	32	16.6	M16	35	1.5	3	2.0	M2003348
LT 902 S-W-D035/4	35	19.6	M16	35	1.5	4	1.5	M2003349

Screw: M2001420
Key: M2000602

End Mill for SDKX 1205 HF

Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 903 W-W-D032/2	32	11	32	200	60	2	2	2.0	M2003366
LT 903 WL-W-D032/2	32	11	32	200	60	2	2	2.0	M2003365

Screw: M2000597
Key: M2000602



Shell Mill for SDKX 1205 HF

Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 903 M-W-D050/4	50	29	22	40	2	4	0.8	M2003361
LT 903 M-W-D050/5	50	29	22	40	2	5	0.8	M2003357
LT 903 M-W-D052/5	50	31	22	40	2	5	0.8	M2003358
LT 903 M-W-D063/5	52	42	22	40	2	5	0.6	M2003662
LT 903 M-W-D063/6	63	42	22	40	2	6	0.6	M2003360
LT 903 M-W-D066/6	66	45	22	40	2	6	0.6	M2003361

Screw: M2000597
Key: M2000602

Screw Coupling for SDKX 1205 HF

Cutter Designation	D	D1	d	L1	Ap	z	α	Catalog Nr.
LT 903 S-W-D032/2	32	11	M16	35	2	2	2.0	M2003362
LT 903 S-W-D035/2	35	14	M16	35	2	2	1.5	M2003364
LT 903 S-W-D040/4	40	19	M16	40	2	4	0.8	M2003354
LT 903 S-W-D042/4*	42	21	M16	35	2	4	0.8	M2003356

*On request

Screw: M2000597
Key: M2000602

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SDKX 0904 HF – LT 30 | LT 3000

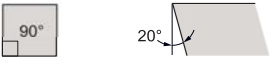
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	0.8	0.30	2.00	190	330	1.4	1.80	250
			2		190 HB	0.5	0.8	0.30	2.00	190	300	1.4	1.80	220
			3		250 HB	0.5	0.8	0.30	2.00	190	250	1.4	1.80	200
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	0.7	0.30	1.80	150	240	1.1	1.70	200
			4,6		230 HB	0.5	0.7	0.30	1.80	150	210	1.1	1.70	180
			5,7		280 HB	0.5	0.7	0.30	1.80	130	190	1.1	1.70	150
			8		350 HB	0.5	0.7	0.30	1.80	130	170	1.1	1.70	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	0.7	0.30	1.60	90	150	0.8	1.50	130
			10		280 HB	0.5	0.7	0.30	1.60	90	130	0.8	1.50	120
			11		320 HB	0.5	0.7	0.30	1.60	60	110	0.8	1.20	100
			11		350 HB	0.5	0.7	0.30	1.60	60	90	0.8	1.20	80
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	1.2	0.30	1.00	190	250	1.2	1.00	220
			14		240 HB	0.5	1.2	0.30	1.00	160	210	1.2	1.00	190
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	0.9	0.30	0.60	70	130	0.9	0.60	100
			14		310 HB	0.5	0.9	0.30	0.60	70	120	0.9	0.60	90
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	1.2	0.30	0.70	150	210	1.2	0.70	190
			13		42 HRc	0.5	1.0	0.30	0.60	90	150	1.0	0.60	130
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	1.5	0.30	2.00	150	240	1.5	1.80	200
			15		200 HB	0.5	1.5	0.30	2.00	150	220	1.5	1.80	180
			16		250 HB	0.5	1.5	0.30	2.00	150	190	1.5	1.80	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	1.5	0.30	1.80	100	200	1.5	1.60	180
			17,19		200 HB	0.5	1.5	0.30	1.80	100	180	1.5	1.60	150
			18,20		250 HB	0.5	1.5	0.30	1.80	100	150	1.5	1.60	130
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	1.3	0.30	0.80	25	45	1.3	0.60	32
			33	Inconel 700	250 HB	0.5	1.3	0.30	0.80	25	45	1.3	0.60	30
			34	Stellite 21	350 HB	0.5	1.3	0.30	0.80	25	45	1.3	0.60	30
	Ti based	10	36	TiAl6V4	-	0.5	1.3	0.30	0.70	40	65	1.3	0.60	55
			37	T40	-	0.5	1.3	0.30	0.70	30	55	1.3	0.60	40
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.6	0.30	1.20	40	80	1.2	1.00	60
			38		50 HRc	0.3	0.5	0.30	1.00	40	70	1.0	0.90	55
			38		55 HRc	0.3	0.5	0.30	0.80	40	60	0.9	0.70	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.5	0.30	0.80	40	80	1.0	0.80	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.5	0.30	0.80	30	60	0.9	0.80	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	1.5	0.30	1.00	200	400	1.5	1.00	280

SDKX 1205-HF – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.3	2.0	0.30	3.00	190	330	1.2	2.00	250
			2		190 HB	0.3	2.0	0.30	3.00	190	300	1.2	2.00	220
			3		250 HB	0.3	2.0	0.30	3.00	190	250	1.2	2.00	200
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.3	1.6	0.30	2.80	150	240	0.9	1.80	200
			4,6		230 HB	0.3	1.6	0.30	2.80	150	210	0.9	1.80	180
			5,7		280 HB	0.3	1.6	0.30	2.80	130	190	0.9	1.60	150
			8		350 HB	0.3	1.6	0.30	2.50	130	170	0.9	1.60	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	1.6	0.30	2.50	90	150	0.7	1.40	130
			10		280 HB	0.3	1.3	0.30	2.20	90	130	0.7	1.40	120
			11		320 HB	0.3	1.1	0.30	2.00	60	110	0.7	1.20	100
			11		350 HB	0.3	1.1	0.30	1.80	60	90	0.7	1.20	80
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.3	1.5	0.30	1.10	190	250	0.9	0.90	220
			14		240 HB	0.3	1.5	0.30	1.10	160	210	0.9	0.90	190
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.3	1.2	0.30	0.70	70	130	0.8	0.60	100
			14		310 HB	0.3	1.2	0.30	0.70	70	120	0.8	0.60	90
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	1.5	0.30	0.80	150	210	0.9	0.70	190
			13		42 HRc	0.3	1.1	0.30	0.70	90	150	0.8	0.60	130
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	2.0	0.30	3.00	150	240	1.5	2.00	200
			15		200 HB	0.3	2.0	0.30	3.00	150	220	1.5	2.00	180
			16		250 HB	0.3	2.0	0.30	3.00	150	190	1.5	2.00	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.3	2.0	0.30	2.50	100	200	1.5	1.90	180
			17,19		200 HB	0.3	2.0	0.30	2.50	100	180	1.5	1.90	150
			18,20		250 HB	0.3	2.0	0.30	2.50	100	150	1.5	1.90	130
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.3	1.8	0.30	0.70	25	45	1.0	0.60	32
			33	Inconel 700	250 HB	0.3	1.8	0.30	0.60	25	45	1.0	0.60	30
			34	Stellite 21	350 HB	0.3	1.8	0.30	0.60	25	45	1.0	0.60	30
	Ti Based	10	36	TiAl6V4	-	0.3	1.8	0.30	0.70	40	65	1.0	0.60	55
			37	T40	-	0.3	2.0	0.30	0.60	30	55	1.0	0.60	40
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	0.8	0.30	1.40	40	80	0.6	1.00	60
			38		50 HRc	0.3	0.7	0.30	1.20	40	70	0.5	0.90	55
			38		55 HRc	0.3	0.6	0.30	1.00	40	60	0.4	0.80	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	0.7	0.30	0.90	40	80	0.4	0.80	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.6	0.30	0.90	30	60	0.4	0.80	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.3	2.0	0.30	1.20	200	400	2.0	1.00	280

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

S E K N



Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

Tolerance
m ± 0.013
s ± 0.025
For l = 12, **d** ± 0.08
For l = 15, **d** ± 0.10

LT 30 Multi-Mat™ General Usage – Standard

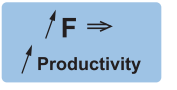
Insert Designation	l	s	r	Direction	Catalog Nr.
SEKN 1203 AFTN LT 30	12.7	3.18	0.39	Neutral	M0000041
SEKN 1204 AFTN LT 30	12.7	4.76	0.39	Neutral	M0000042
SEKN 1504 AFTN LT 30	15.88	4.76	1.1	Neutral	M0000450

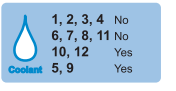
Application Guide

Chamfering

Surfacing

Machining Recommendations



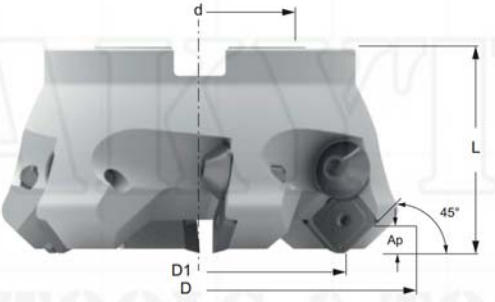


ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SEKN 1203 AFTN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 550 M-D-D050/4*	63	50	22	48	6	4	M2000563
LT 550 M-D-D063/5*	76	63	22	48	6	5	M2000564
LT 550 M-D-D080/6*	93	80	27	50	6	6	M2000565
LT 550 M-D-D100/6*	113	100	32	50	6	6	M2000566
LT 550 M-D-D125/7*	138	125	40	63	6	7	M2000567
LT 550 M-D-D160/7*	173	160	40	63	6	7	M2000568
LT 550 M-D-D200/10*	213	200	60	63	6	10	M2000569
LT 550 M-D-D250/13*	263	250	60	63	6	13	M2000570

* On request

Screw: M2000608
Key: M2000609



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SEKN 1203 AFTN – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

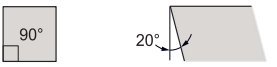
SEKN 1204 AFTN – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

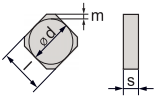
SEKN 1504 AFTN – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.18	0.50	190	330	**4.0**	**0.37**	**250**
			2		190 HB	0.5	9.0	0.18	0.50	190	300	**4.0**	**0.37**	**220**
			3		250 HB	0.5	9.0	0.18	0.50	190	250	**4.0**	**0.37**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.15	0.39	150	240	**4.0**	**0.32**	**200**
			4,6		230 HB	0.5	9.0	0.15	0.39	150	210	**4.0**	**0.32**	**180**
			5,7		280 HB	0.5	9.0	0.15	0.34	130	190	**4.0**	**0.29**	**150**
			8		350 HB	0.5	9.0	0.15	0.34	130	170	**4.0**	**0.29**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.12	0.34	90	150	**3.0**	**0.29**	**130**
			10		280 HB	0.5	6.4	0.12	0.34	90	130	**3.0**	**0.29**	**120**
			11		320 HB	0.5	6.4	0.12	0.28	60	110	**3.0**	**0.26**	**100**
			11		350 HB	0.5	6.4	0.12	0.28	60	90	**3.0**	**0.26**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.15	0.34	190	250	**4.0**	**0.29**	**220**
			14		240 HB	0.5	9.0	0.12	0.31	160	210	**4.0**	**0.29**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.12	0.28	70	130	**3.0**	**0.26**	**100**
			14		310 HB	0.5	6.4	0.12	0.28	70	120	**3.0**	**0.26**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.15	0.34	150	210	**4.0**	**0.29**	**190**
			13		42 HRc	0.5	6.4	0.15	0.28	90	150	**3.0**	**0.26**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.18	0.50	150	240	**4.0**	**0.37**	**200**
			15		200 HB	0.5	9.0	0.18	0.50	150	220	**4.0**	**0.37**	**180**
			16		250 HB	0.5	9.0	0.18	0.50	150	190	**4.0**	**0.37**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.15	0.43	100	200	**4.0**	**0.32**	**180**
			17,19		200 HB	0.5	9.0	0.15	0.43	100	180	**4.0**	**0.32**	**150**
			18,20		250 HB	0.5	9.0	0.15	0.43	100	150	**4.0**	**0.32**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	6.4	0.12	0.28	25	45	**3.0**	**0.26**	**32**
			33	Inconel 700	250 HB	0.5	6.4	0.12	0.28	25	45	**3.0**	**0.26**	**30**
			34	Stellite 21	350 HB	0.5	6.4	0.12	0.28	25	45	**3.0**	**0.26**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	6.4	0.12	0.31	40	65	**3.0**	**0.29**	**55**
			37	T40	-	0.5	6.4	0.12	0.28	30	55	**3.0**	**0.26**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.10	0.28	40	80	**2.0**	**0.22**	**60**
			38		50 HRc	0.5	1.9	0.10	0.25	40	70	**1.5**	**0.21**	**55**
			38		55 HRc	0.5	1.6	0.10	0.22	40	60	**1.0**	**0.19**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.10	0.28	40	80	**1.5**	**0.22**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.6	0.10	0.22	30	60	**1.0**	**0.19**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.18	0.50	200	400	**4.0**	**0.40**	**280**

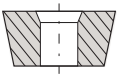
S E K R



Shape | **Clearance Angle**



Tolerance
d ± 0.08
m ± 0.013
s ± 0.025



Insert Type
Clamping,
Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

Insert Designation	l	s	r	Direction	Catalog Nr.
SEKR 1203 AFTN LT 30	12.7	3.18	0.39	Neutral	M0000043
SEKR 1204 AFTN LT 30	12.7	4.76	0.40	Neutral	M0000044

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

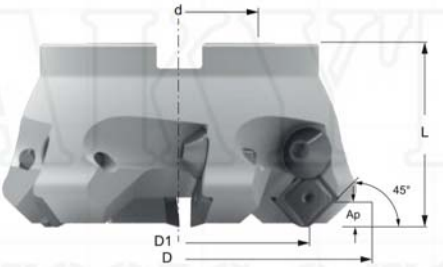
Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SEKR 1203 AFTN							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 550 M-D-D050/4*	63	50	22	48	6	4	M2000563
LT 550 M-D-D063/5*	76	63	22	48	6	5	M2000564
LT 550 M-D-D080/6*	93	80	27	50	6	6	M2000565
LT 550 M-D-D100/6*	113	100	32	50	6	6	M2000566
LT 550 M-D-D125/7*	138	125	40	63	6	7	M2000567
LT 550 M-D-D160/7*	173	160	40	63	6	7	M2000568
LT 550 M-D-D200/10*	213	200	60	63	6	10	M2000569
LT 550 M-D-D250/13*	263	250	60	63	6	13	M2000570

* On request

Screw: M2000608
Key: M2000609



SEKR 1203 AFTN – **LT 30**

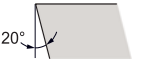
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

SEKR 1204 AFTN – **LT 30**

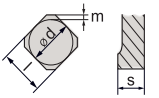
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

S E K T

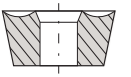
Shape



Clearance Angle



Tolerance
d ± 0.08
m ± 0.013
s ± 0.025



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
SEKT 12T3 AGSN LT 30	13.4	3.97	1.2	Neutral	M0000455
SEKT 1204 AFTN LT 30	12.7	4.76	0.85	Neutral	M0000045

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
SEKT 12T3 AGSN LT 3000	13.4	3.97	1.2	Neutral	M0002231
SEKT 1204 AFTN LT 3000	12.7	4.76	0.85	Neutral	M0002230

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒ Productivity

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

Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SEKT 1204 AFTN

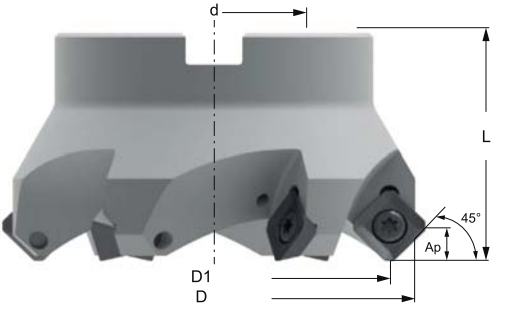
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 600 M-W-D040/3	53	40	16	40	6	3	M2000546
LT 600 M-W-D050/4	63	50	22	48	6	4	M2000547
LT 600 M-W-D063/5	76	63	22	48	6	5	M2000548
LT 600 M-W-D080/6	93	80	27	50	6	6	M2000549
LT 600 M-W-D100/6	113	100	32	50	6	6	M2000500
LT 600 M-W-D125/7	138	125	40	63	6	7	M2000551
LT 600 M-W-D160/8	173	160	40	63	6	8	M2000552

Screw: M2000599
Key: M2000603

Shell Mill for SEKT 12T3 AFTN

Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 610 M-W-D040/3	53	40	16	40	6	3	M2001431
LT 610 M-W-D050/4	63	50	22	48	6	4	M2001382
LT 610 M-W-D063/5	76	63	22	48	6	5	M2001383
LT 610 M-W-D080/6	93	80	27	50	6	6	M2001384
LT 610 M-W-D100/6	113	100	32	50	6	6	M2001432
LT 610 M-W-D125/7	138	125	40	63	6	7	M2001433
LT 610 M-W-D160/8	173	160	40	63	6	8	M2001434

Screw: M2000602
Key: M2001418



SEKT 1204 AFTN – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

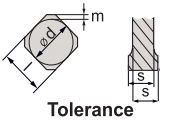
SEKT 12T3 AGSN – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.46	190	330	**3.0**	**0.34**	**250**
			2		190 HB	0.5	7.0	0.18	0.46	190	300	**3.0**	**0.34**	**220**
			3		250 HB	0.5	7.0	0.18	0.46	190	250	**3.0**	**0.34**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.36	150	240	**3.0**	**0.30**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.36	150	210	**3.0**	**0.30**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.32	130	190	**3.0**	**0.27**	**150**
			8		350 HB	0.5	7.0	0.15	0.32	130	170	**3.0**	**0.27**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.32	90	150	**2.3**	**0.27**	**130**
			10		280 HB	0.5	5.0	0.12	0.32	90	130	**2.3**	**0.27**	**120**
			11		320 HB	0.5	5.0	0.12	0.26	60	110	**2.3**	**0.24**	**100**
			11		350 HB	0.5	5.0	0.12	0.26	60	90	**2.3**	**0.24**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.32	190	250	**3.0**	**0.27**	**220**
			14		240 HB	0.5	7.0	0.12	0.29	160	210	**3.0**	**0.27**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.26	70	130	**2.3**	**0.24**	**100**
			14		310 HB	0.5	5.0	0.12	0.26	70	120	**2.3**	**0.24**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.32	150	210	**3.0**	**0.27**	**190**
			13		42 HRc	0.5	5.0	0.15	0.26	90	150	**2.3**	**0.24**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.46	150	240	**3.0**	**0.34**	**200**
			15		200 HB	0.5	7.0	0.18	0.46	150	220	**3.0**	**0.34**	**180**
			16		250 HB	0.5	7.0	0.18	0.46	150	190	**3.0**	**0.34**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.41	100	200	**3.0**	**0.30**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.41	100	180	**3.0**	**0.30**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.41	100	150	**3.0**	**0.30**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.26	25	45	**2.3**	**0.24**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.29	40	65	**2.3**	**0.27**	**55**
			37	T40	-	0.5	5.0	0.12	0.26	30	55	**2.3**	**0.24**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.26	40	80	**1.5**	**0.21**	**60**
			38		50 HRc	0.5	1.8	0.10	0.23	40	70	**1.1**	**0.19**	**55**
			38		55 HRc	0.5	1.5	0.10	0.20	40	60	**0.8**	**0.18**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.26	40	80	**1.1**	**0.21**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.20	30	60	**0.8**	**0.18**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.46	200	400	**3.0**	**0.37**	**280**

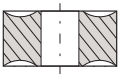
S N K X

Shape

Clearance Angle



Tolerance
d ± 0.05
m ± 0.013
s ± 0.025



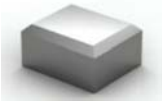
Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
SNKX 1205-45 LT 30	12.70	6.20	0.85	Neutral	M0003221
SNKX 1607-45 LT 30	16.70	7.70	0.80	Neutral	M0002205

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	r	Direction	Catalog Nr.
SNKX 1205-45 LT 3000	12.70	6.20	0.85	Neutral	M0003415
SNKX 1607-45 LT 3000	16.70	7.70	0.80	Neutral	M0002237

Application Guide

Chamfering



Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SNKX 1205-45°

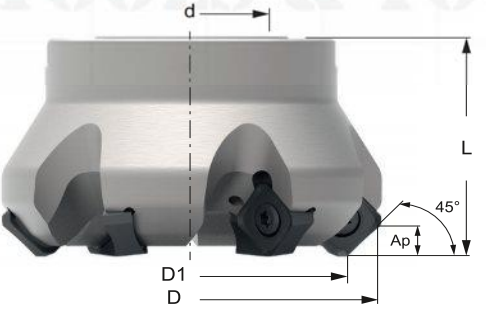
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 946 M-W-D050/4	-	50	22	48	6	4	M2003223
LT 946 M-W-D063/6	-	63	22	48	6	6	M2003224
LT 946 M-W-D080/7	-	80	27	50	6	7	M2003225
LT 946 M-W-D100/8	-	100	32	50	6	8	M2003226
LT 946 M-W-D125/10	-	125	40	63	6	10	M2003227
LT 946 M-W-D160/12	-	160	40	63	6	12	M2003228

Screw: M2002101
Key: M2002911

Shell Mill for SNKX 1604-45°

Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 947 M-W-D050/4	69	50	22	50	7	4	M2002200
LT 947 M-W-D063/5	82	63	22	50	7	5	M2002201
LT 947 M-W-D080/6	99	80	27	50	7	6	M2002202
LT 947 M-W-D100/7	119	100	32	63	7	7	M2002203
LT 947 M-W-D125/8	144	125	40	63	7	8	M2002204

Screw: M2002101
Key: M2002911



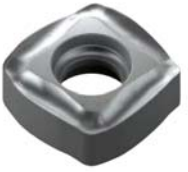
SNKX 1205-45° – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	5.0	0.16	0.34	190	330	**3.0**	**0.30**	**250**
			2		190 HB	0.5	5.0	0.16	0.34	190	300	**3.0**	**0.30**	**220**
			3		250 HB	0.5	5.0	0.16	0.34	190	250	**3.0**	**0.30**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	5.0	0.14	0.28	150	240	**3.0**	**0.26**	**200**
			4,6		230 HB	0.5	5.0	0.14	0.28	150	210	**3.0**	**0.26**	**180**
			5,7		280 HB	0.5	5.0	0.14	0.26	130	190	**3.0**	**0.24**	**150**
			8		350 HB	0.5	5.0	0.14	0.26	130	170	**3.0**	**0.24**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.11	0.28	90	150	**3.0**	**0.26**	**130**
			10		280 HB	0.5	5.0	0.11	0.28	90	130	**3.0**	**0.26**	**120**
			11		320 HB	0.5	5.0	0.11	0.24	60	110	**3.0**	**0.22**	**100**
			11		350 HB	0.5	5.0	0.11	0.24	60	90	**3.0**	**0.22**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	5.0	0.14	0.30	190	250	**3.0**	**0.26**	**220**
			14		240 HB	0.5	5.0	0.11	0.30	160	210	**3.0**	**0.26**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	4.0	0.11	0.25	70	130	**2.5**	**0.22**	**100**
			14		310 HB	0.5	4.0	0.11	0.25	70	120	**2.5**	**0.22**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5.0	0.14	0.30	150	210	**3.0**	**0.26**	**190**
			13		42 HRc	0.5	4.0	0.14	0.25	90	150	**3.0**	**0.22**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	5.0	0.17	0.34	150	240	**3.0**	**0.30**	**200**
			15		200 HB	0.5	5.0	0.17	0.34	150	220	**3.0**	**0.30**	**180**
			16		250 HB	0.5	5.0	0.17	0.34	150	190	**3.0**	**0.30**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	5.0	0.14	0.30	100	200	**3.0**	**0.27**	**180**
			17,19		200 HB	0.5	5.0	0.14	0.30	100	180	**3.0**	**0.27**	**150**
			18,20		250 HB	0.5	5.0	0.14	0.30	100	150	**3.0**	**0.27**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	4.0	0.11	0.20	25	45	**2.5**	**0.18**	**32**
			33	Inconel 700	250 HB	0.5	4.0	0.11	0.20	25	45	**2.5**	**0.18**	**30**
			34	Stellite 21	350 HB	0.5	4.0	0.11	0.20	25	45	**2.5**	**0.18**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	4.0	0.11	0.25	40	65	**2.5**	**0.23**	**55**
			37	T40	-	0.5	4.0	0.11	0.23	30	55	**2.5**	**0.20**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	2.0	0.10	0.22	40	80	**1.3**	**0.18**	**60**
			38		50 HRc	0.4	2.0	0.10	0.20	40	70	**1.3**	**0.16**	**55**
			38		55 HRc	0.4	1.0	0.10	0.18	40	60	**1.0**	**0.15**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	2.0	0.10	0.22	40	80	**1.3**	**0.19**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.0	0.10	0.20	30	60	**1.0**	**0.17**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	5.0	0.17	0.36	200	400	**3.0**	**0.30**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SNKX 1607-45° – LT 30 | LT 3000

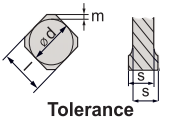
	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	6.5	0.16	0.58	190	330	**4.0**	**0.46**	**250**
			2		190 HB	0.5	6.5	0.16	0.58	190	300	**4.0**	**0.46**	**220**
			3		250 HB	0.5	6.5	0.16	0.58	190	250	**4.0**	**0.46**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	6.5	0.14	0.50	150	240	**4.0**	**0.40**	**200**
			4,6		230 HB	0.5	6.5	0.14	0.50	150	210	**4.0**	**0.40**	**180**
			5,7		280 HB	0.5	6.5	0.14	0.44	130	190	**4.0**	**0.36**	**150**
			8		350 HB	0.5	6.5	0.14	0.44	130	170	**4.0**	**0.36**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.11	0.44	90	150	**3.0**	**0.36**	**130**
			10		280 HB	0.5	6.5	0.11	0.44	90	130	**3.0**	**0.36**	**120**
			11		320 HB	0.5	6.5	0.11	0.36	60	110	**3.0**	**0.32**	**100**
			11		350 HB	0.5	6.5	0.11	0.36	60	90	**3.0**	**0.32**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	6.5	0.14	0.44	190	250	**4.0**	**0.34**	**220**
			14		240 HB	0.5	6.5	0.11	0.40	160	210	**4.0**	**0.34**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.11	0.36	70	130	**3.0**	**0.30**	**100**
			14		310 HB	0.5	5.0	0.11	0.36	70	120	**3.0**	**0.30**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	6.5	0.14	0.44	150	210	**4.0**	**0.34**	**190**
			13		42 HRc	0.5	5.0	0.14	0.40	90	150	**3.0**	**0.30**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	6.5	0.17	0.58	150	240	**4.0**	**0.46**	**200**
			15		200 HB	0.5	6.5	0.17	0.58	150	220	**4.0**	**0.46**	**180**
			16		250 HB	0.5	6.5	0.17	0.58	150	190	**4.0**	**0.46**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	6.5	0.14	0.52	100	200	**4.0**	**0.40**	**180**
			17,19		200 HB	0.5	6.5	0.14	0.52	100	180	**4.0**	**0.40**	**150**
			18,20		250 HB	0.5	6.5	0.14	0.52	100	150	**4.0**	**0.40**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.11	0.36	25	45	**3.0**	**0.30**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.11	0.36	25	45	**3.0**	**0.30**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.11	0.36	25	45	**3.0**	**0.30**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	5.0	0.11	0.40	40	65	**3.0**	**0.34**	**55**
			37	T40	-	0.5	5.0	0.11	0.36	30	55	**3.0**	**0.30**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	3.0	0.10	0.36	40	80	**2.0**	**0.28**	**60**
			38		50 HRc	0.4	3.0	0.10	0.32	40	70	**1.5**	**0.26**	**55**
			38		55 HRc	0.4	1.5	0.10	0.28	40	60	**1.0**	**0.24**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	3.0	0.10	0.36	40	80	**1.5**	**0.28**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.4	1.5	0.10	0.28	30	60	**1.0**	**0.24**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	6.5	0.17	0.60	200	400	**4.0**	**0.50**	**280**



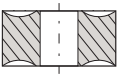
S N K X

Shape

Clearance Angle



Tolerance
d ± 0.05
m ± 0.013
s ± 0.025



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	R prog.	Direction	Catalog Nr.
SNKX 09T3-HF LT 30	9.67	3.71	4.2	Right	M0002115

LT 3000	Multi-Mat™ General Usage – Premium				
Insert Designation	l	s	R prog.	Direction	Catalog Nr.
SNKX 09T3-HF LT 3000	9.67	3.71	4.2	Right	M0002236

Application Guide

Copying

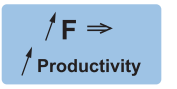
Helical Interpolation

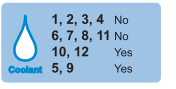
Pocket Milling

Ramping Down

Surfacing

Machining Recommendations





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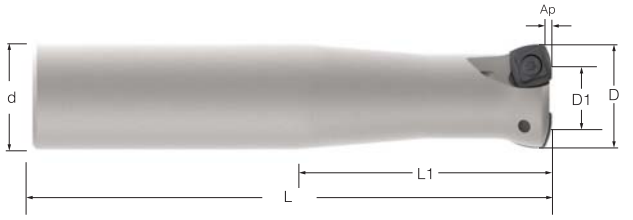
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

End Mill for SNKX 09T3-HF

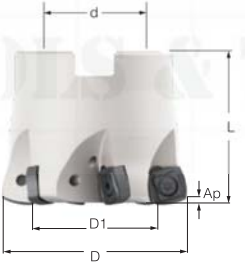
Cutter Designation	D	D1	d	L	L1	Ap	z	α	Catalog Nr.
LT 900 WL-W-D025/2	25	13.5	25	200	60	1	2	3.5	M2002117
LT 900 W-W-D025/3	25	13.5	25	120	60	1	3	3.5	M2002118
LT 900 WL-W-D032/3	32	20.5	32	200	60	1	3	2.0	M2002120
LT 900 W-W-D032/4	32	20.5	32	120	60	1	4	2.0	M2002119



Screw: M2002101
Key: M2002911

Shell Mill for SNKX 09T3-HF

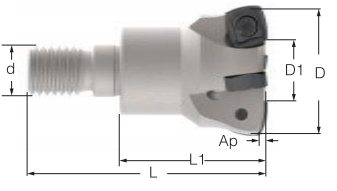
Cutter Designation	D	D1	d	L	Ap	z	α	Catalog Nr.
LT 900 M-W-D040/5	40	28.5	16	40	1	5	3.5	M2002121
LT 900 M-W-D042/5	42	30.5	16	40	1	5	3.2	M2002122
LT 900 M-W-D050/6	50	38.5	22	40	1	6	2.5	M2002123
LT 900 M-W-D052/6	52	40.5	22	40	1	5	2.2	M2002124
LT 900 M-W-D063/6	63	51.5	22	40	1	6	1.8	M2002125
LT 900 M-W-D066/6	66	54.5	22	40	1	6	1.7	M2002127



Screw: M2002101
Key: M2002911

Screw Coupling for SNKX 09T3-HF

Cutter Designation	D	D1	d	L1	Ap	z	α	Catalog Nr.
LT 900 S-W-D025/3	25	13.5	M12	35	1	3	3.5	M2002128
LT 900 S-W-D032/4	32	20.5	M16	35	1	4	2.0	M2002129
LT 900 S-W-D035/4	35	23.5	M16	35	1	4	1.5	M2002130



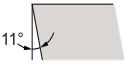
Screw: M2002101
Key: M2002911

SNKX 09T3-HF – LT 30 | LT 3000

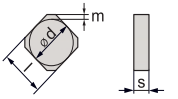
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.1	1.0	0.27	2.10	190	330	**0.6**	**1.10**	**250**
			2		190 HB	0.1	1.0	0.27	1.95	190	300	**0.6**	**1.10**	**220**
			3		250 HB	0.1	1.0	0.27	1.50	190	250	**0.6**	**1.10**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.1	1.0	0.25	1.95	150	240	**0.5**	**1.00**	**200**
			4,6		230 HB	0.1	1.0	0.25	1.70	150	210	**0.5**	**1.00**	**180**
			5,7		280 HB	0.1	1.0	0.23	1.60	130	190	**0.5**	**0.90**	**150**
			8		350 HB	0.1	1.0	0.23	1.50	130	170	**0.5**	**0.90**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.1	1.0	0.20	1.70	90	150	**0.5**	**0.90**	**130**
			10		280 HB	0.1	1.0	0.20	1.60	90	130	**0.5**	**0.90**	**120**
			11		320 HB	0.1	0.8	0.20	1.50	60	110	**0.4**	**0.80**	**100**
			11		350 HB	0.1	0.8	0.20	1.40	60	90	**0.4**	**0.80**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.1	1.0	0.20	2.40	150	240	**0.6**	**1.10**	**200**
			15		200 HB	0.1	1.0	0.20	2.40	150	220	**0.6**	**1.10**	**180**
			16		250 HB	0.1	1.0	0.20	2.40	150	190	**0.6**	**1.10**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.1	1.0	0.20	1.80	100	200	**0.5**	**1.00**	**180**
			17,19		200 HB	0.1	1.0	0.20	1.80	100	180	**0.5**	**1.00**	**150**
			18,20		250 HB	0.1	1.0	0.20	1.80	100	150	**0.5**	**1.00**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.1	0.6	0.16	1.10	40	80	**0.4**	**0.70**	**60**
			38		50 HRc	0.1	0.5	0.16	1.00	40	70	**0.3**	**0.65**	**55**
			38		55 HRc	0.1	0.4	0.16	0.90	40	60	**0.3**	**0.60**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.1	0.6	0.16	1.10	40	80	**0.4**	**0.70**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.1	0.4	0.16	0.90	30	60	**0.3**	**0.60**	**40**

S P K N

Shape

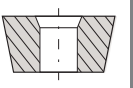


Clearance Angle



Tolerance

m ± 0.013 **s** ± 0.025
For l = 12, **d** ± 0.08
For l = 15, **d** ± 0.10



Fixing, Chipbreaker

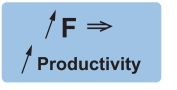
LT 30 Multi-Mat™ General Usage – Standard

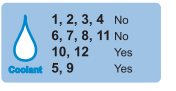
Insert Designation	l	s	r	Direction	Catalog Nr.
SPKN 1203 EDTR LT 30	12.7	3.21	1.2	Right	M0000046
SPKN 1204 EDTR LT 30	12.7	4.76	1.2	Right	M0000047
SPKN 1504 EDTR LT 30	15.88	4.76	1.6	Right	M0001673

Application Guide

Surfacing

Machining Recommendations



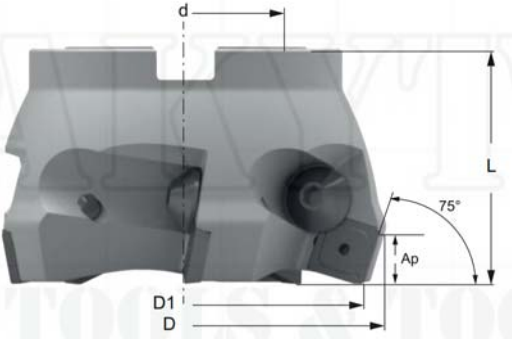


ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SPKN 1203 EDTR							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 750 M-D-D063/4*	69	63	22	40	9	4	M2000571
LT 750 M-D-D080/5*	86	80	27	50	9	5	M2000572
LT 750 M-D-D100/7*	106	100	32	50	9	7	M2000574
LT 750 M-D-D125/8*	131	125	40	63	9	8	M2000575
LT 750 M-D-D160/10*	166	160	40	63	9	10	M2000576
LT 750 M-D-D200/12*	206	200	63	63	9	12	M2000577
LT 750 M-D-D250/14*	256	250	63	63	9	14	M2000578

* On request

Screw: M2000606
Key: M2000609



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SPKN 1203 EDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.43	190	330	**3.0**	**0.30**	**250**
			2		190 HB	0.5	7.0	0.18	0.43	190	300	**3.0**	**0.30**	**220**
			3		250 HB	0.5	7.0	0.18	0.43	190	250	**3.0**	**0.30**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.34	150	240	**3.0**	**0.26**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.34	150	210	**3.0**	**0.26**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.30	130	190	**3.0**	**0.23**	**150**
			8		350 HB	0.5	7.0	0.15	0.30	130	170	**3.0**	**0.23**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.30	90	150	**2.3**	**0.23**	**130**
			10		280 HB	0.5	5.0	0.12	0.30	90	130	**2.3**	**0.23**	**120**
			11		320 HB	0.5	5.0	0.12	0.24	60	110	**2.3**	**0.21**	**100**
			11		350 HB	0.5	5.0	0.12	0.24	60	90	**2.3**	**0.21**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.43	150	240	**3.0**	**0.30**	**200**
			15		200 HB	0.5	7.0	0.18	0.43	150	220	**3.0**	**0.30**	**180**
			16		250 HB	0.5	7.0	0.18	0.43	150	190	**3.0**	**0.30**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.38	100	200	**3.0**	**0.26**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.38	100	180	**3.0**	**0.26**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.38	100	150	**3.0**	**0.26**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.24	40	80	**1.5**	**0.18**	**60**
			38		50 HRc	0.5	1.8	0.10	0.22	40	70	**1.1**	**0.17**	**55**
			38		55 HRc	0.5	1.5	0.10	0.19	40	60	**0.8**	**0.16**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.24	40	80	**1.1**	**0.18**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.19	30	60	**0.8**	**0.16**	**40**

SPKN 1204 EDTR – **LT 30 | LT 3000**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.43	190	330	**3.0**	**0.30**	**250**
			2		190 HB	0.5	7.0	0.18	0.43	190	300	**3.0**	**0.30**	**220**
			3		250 HB	0.5	7.0	0.18	0.43	190	250	**3.0**	**0.30**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.34	150	240	**3.0**	**0.26**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.34	150	210	**3.0**	**0.26**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.30	130	190	**3.0**	**0.23**	**150**
			8		350 HB	0.5	7.0	0.15	0.30	130	170	**3.0**	**0.23**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.30	90	150	**2.3**	**0.23**	**130**
			10		280 HB	0.5	5.0	0.12	0.30	90	130	**2.3**	**0.23**	**120**
			11		320 HB	0.5	5.0	0.12	0.24	60	110	**2.3**	**0.21**	**100**
			11		350 HB	0.5	5.0	0.12	0.24	60	90	**2.3**	**0.21**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.43	150	240	**3.0**	**0.30**	**200**
			15		200 HB	0.5	7.0	0.18	0.43	150	220	**3.0**	**0.30**	**180**
			16		250 HB	0.5	7.0	0.18	0.43	150	190	**3.0**	**0.30**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.38	100	200	**3.0**	**0.26**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.38	100	180	**3.0**	**0.26**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.38	100	150	**3.0**	**0.26**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.24	40	80	**1.5**	**0.18**	**60**
			38		50 HRc	0.5	1.8	0.10	0.22	40	70	**1.1**	**0.17**	**55**
			38		55 HRc	0.5	1.5	0.10	0.19	40	60	**0.8**	**0.16**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.24	40	80	**1.1**	**0.18**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.19	30	60	**0.8**	**0.16**	**40**

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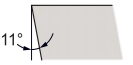
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SPKN 1504 EDTR – **LT 30**

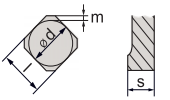
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	9.0	0.18	0.43	190	330	**4.0**	**0.30**	**250**
			2		190 HB	0.5	9.0	0.18	0.43	190	300	**4.0**	**0.30**	**220**
			3		250 HB	0.5	9.0	0.18	0.43	190	250	**4.0**	**0.30**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.15	0.34	150	240	**4.0**	**0.26**	**200**
			4,6		230 HB	0.5	9.0	0.15	0.34	150	210	**4.0**	**0.26**	**180**
			5,7		280 HB	0.5	9.0	0.15	0.30	130	190	**4.0**	**0.23**	**150**
			8		350 HB	0.5	9.0	0.15	0.30	130	170	4.0	0.23	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.12	0.30	90	150	3.0	0.23	130
			10		280 HB	0.5	6.5	0.12	0.30	90	130	3.0	0.23	120
			11		320 HB	0.5	6.5	0.12	0.24	60	110	3.0	0.21	100
			11		350 HB	0.5	6.5	0.12	0.24	60	90	3.0	0.21	80
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.18	0.43	150	240	4.0	0.30	200
			15		200 HB	0.5	9.0	0.18	0.43	150	220	4.0	0.30	180
			16		250 HB	0.5	9.0	0.18	0.43	150	190	4.0	0.30	160
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.15	0.38	100	200	4.0	0.26	180
			17,19		200 HB	0.5	9.0	0.15	0.38	100	180	4.0	0.26	150
			18,20		250 HB	0.5	9.0	0.15	0.38	100	150	4.0	0.26	130
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.10	0.24	40	80	2.0	0.18	60
			38		50 HRc	0.5	2.3	0.10	0.22	40	70	1.5	0.17	55
			38		55 HRc	0.5	1.9	0.10	0.19	40	60	1.0	0.16	50
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.10	0.24	40	80	1.5	0.18	50
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.9	0.10	0.19	30	60	1.0	0.16	40

S P K R

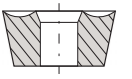
Shape



Clearance Angle



Tolerance
d ± 0.08
m ± 0.013
s ± 0.025



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
SPKR 1203 EDTR LT 30	12.70	3.21	1.2	Right	M0000048
SPKR 1204 EDTR LT 30	12.70	4.76	1.2	Right	M0000049

Application Guide

Surfacing

Machining Recommendations

F ⇒ Productivity

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

Stainless Steel
V_c

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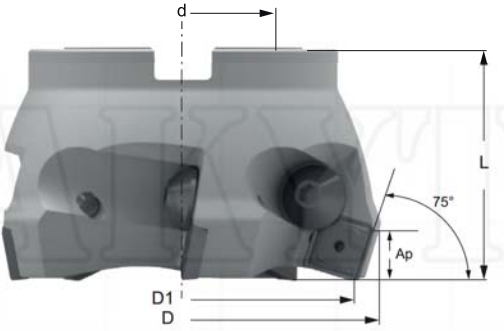
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for SPKR 1203 EDTR							
Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 750 M-D-D063/4*	69	63	22	40	9	4	M2000571
LT 750 M-D-D080/5*	86	80	27	50	9	5	M2000572
LT 750 M-D-D100/7*	106	100	32	50	9	7	M2000574
LT 750 M-D-D125/8*	131	125	40	63	9	8	M2000575
LT 750 M-D-D160/10*	166	160	40	63	9	10	M2000576
LT 750 M-D-D200/12*	206	200	63	63	9	12	M2000577
LT 750 M-D-D250/14*	256	250	63	63	9	14	M2000578

* On request

Screw: M2000606
Key: M2000609



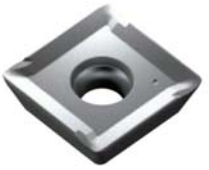
ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SPKR 1203 EDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.38	190	330	**3.0**	**0.26**	**250**
			2		190 HB	0.5	7.0	0.18	0.38	190	300	**3.0**	**0.26**	**220**
			3		250 HB	0.5	7.0	0.18	0.38	190	250	**3.0**	**0.26**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.30	150	240	**3.0**	**0.23**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.30	150	210	**3.0**	**0.23**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.26	130	190	**3.0**	**0.21**	**150**
			8		350 HB	0.5	7.0	0.15	0.26	130	170	**3.0**	**0.21**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.26	90	150	**2.3**	**0.21**	**130**
			10		280 HB	0.5	5.0	0.12	0.26	90	130	**2.3**	**0.21**	**120**
			11		320 HB	0.5	5.0	0.12	0.22	60	110	**2.3**	**0.18**	**100**
			11		350 HB	0.5	5.0	0.12	0.22	60	90	**2.3**	**0.18**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.26	190	250	**3.0**	**0.21**	**220**
			14		240 HB	0.5	7.0	0.12	0.24	160	210	**3.0**	**0.21**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.22	70	130	**2.3**	**0.18**	**100**
			14		310 HB	0.5	5.0	0.12	0.22	70	120	**2.3**	**0.18**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.26	150	210	**3.0**	**0.21**	**190**
			13		42 HRc	0.5	5.0	0.15	0.22	90	150	**2.3**	**0.18**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.38	150	240	**3.0**	**0.26**	**200**
			15		200 HB	0.5	7.0	0.18	0.38	150	220	**3.0**	**0.26**	**180**
			16		250 HB	0.5	7.0	0.18	0.38	150	190	**3.0**	**0.26**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.34	100	200	**3.0**	**0.23**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.34	100	180	**3.0**	**0.23**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.34	100	150	**3.0**	**0.23**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.24	40	65	**2.3**	**0.21**	**55**
			37	T40	-	0.5	5.0	0.12	0.22	30	55	**2.3**	**0.18**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.22	40	80	**1.5**	**0.16**	**60**
			38		50 HRc	0.5	1.8	0.10	0.19	40	70	**1.1**	**0.15**	**55**
			38		55 HRc	0.5	1.5	0.10	0.17	40	60	**0.8**	**0.14**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.22	40	80	**1.1**	**0.16**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.17	30	60	**0.8**	**0.14**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.38	200	400	**3.0**	**0.29**	**280**

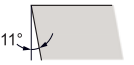
SPKR 1204 EDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.38	190	330	**3.0**	**0.26**	**250**
			2		190 HB	0.5	7.0	0.18	0.38	190	300	**3.0**	**0.26**	**220**
			3		250 HB	0.5	7.0	0.18	0.38	190	250	**3.0**	**0.26**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.30	150	240	**3.0**	**0.23**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.30	150	210	**3.0**	**0.23**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.26	130	190	**3.0**	**0.21**	**150**
			8		350 HB	0.5	7.0	0.15	0.26	130	170	**3.0**	**0.21**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.26	90	150	**2.3**	**0.21**	**130**
			10		280 HB	0.5	5.0	0.12	0.26	90	130	**2.3**	**0.21**	**120**
			11		320 HB	0.5	5.0	0.12	0.22	60	110	**2.3**	**0.18**	**100**
			11		350 HB	0.5	5.0	0.12	0.22	60	90	**2.3**	**0.18**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	7.0	0.15	0.26	190	250	**3.0**	**0.21**	**220**
			14		240 HB	0.5	7.0	0.12	0.24	160	210	**3.0**	**0.21**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.12	0.22	70	130	**2.3**	**0.18**	**100**
			14		310 HB	0.5	5.0	0.12	0.22	70	120	**2.3**	**0.18**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	7.0	0.15	0.26	150	210	**3.0**	**0.21**	**190**
			13		42 HRc	0.5	5.0	0.15	0.22	90	150	**2.3**	**0.18**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.38	150	240	**3.0**	**0.26**	**200**
			15		200 HB	0.5	7.0	0.18	0.38	150	220	**3.0**	**0.26**	**180**
			16		250 HB	0.5	7.0	0.18	0.38	150	190	**3.0**	**0.26**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.34	100	200	**3.0**	**0.23**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.34	100	180	**3.0**	**0.23**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.34	100	150	**3.0**	**0.23**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**32**
			33	Inconel 700	250 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**30**
			34	Stellite 21	350 HB	0.5	5.0	0.12	0.22	25	45	**2.3**	**0.18**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	5.0	0.12	0.24	40	65	**2.3**	**0.21**	**55**
			37	T40	-	0.5	5.0	0.12	0.22	30	55	**2.3**	**0.18**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.22	40	80	**1.5**	**0.16**	**60**
			38		50 HRc	0.5	1.8	0.10	0.19	40	70	**1.1**	**0.15**	**55**
			38		55 HRc	0.5	1.5	0.10	0.17	40	60	**0.8**	**0.14**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.22	40	80	**1.1**	**0.16**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.17	30	60	**0.8**	**0.14**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	7.0	0.18	0.38	200	400	**3.0**	**0.29**	**280**

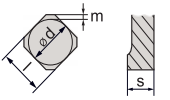


S P M T

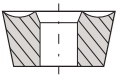
Shape



Clearance Angle



Tolerance
d ± 0.08
m ± 0.13
s ± 0.13



Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

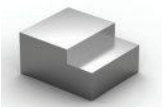
Insert Designation	l	s	r	Direction	Catalog Nr.
SPMT 060304 TN LT 30	6.35	3.2	0.4	Neutral	M0003100
SPMT 09T308 TN LT 30	9.53	3.71	0.8	Neutral	M0003063
SPMT 12T308 LT 30	13.29	3.97	0.8	Neutral	M0001226
SPMT 120408 TN LT 30	12.70	4.80	0.8	Neutral	M0003105

LT 3000 Multi-Mat™ General Usage – Premium

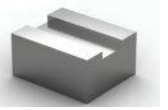
Insert Designation	l	s	r	Direction	Catalog Nr.
SPMT 060304 TN LT 30	6.35	3.2	0.4	Neutral	M0003416
SPMT 09T308 TN LT 30	9.53	3.71	0.8	Neutral	M0003417
SPMT 12T308 LT 30	13.29	3.97	0.8	Neutral	M0003420
SPMT 120408 TN LT 30	12.70	4.80	0.8	Neutral	M0003419

Application Guide

Shoulder Milling



Slotting



Surfacing

Machining Recommendations

F ⇒
Productivity

Coolant

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

Stainless Steel
V_c

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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SPMT 060304 TN – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.3	6.0	0.06	0.12	190	330	**2.4**	**0.10**	**250**
			2		190 HB	0.3	6.0	0.06	0.10	190	300	**2.4**	**0.08**	**220**
			3		250 HB	0.3	6.0	0.06	0.10	190	250	**2.4**	**0.08**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.3	6.0	0.06	0.12	150	240	**2.4**	**0.10**	**200**
			4,6		230 HB	0.3	6.0	0.06	0.10	150	210	**2.4**	**0.08**	**180**
			5,7		280 HB	0.3	6.0	0.05	0.10	130	190	**2.4**	**0.08**	**150**
			8		350 HB	0.3	6.0	0.05	0.10	130	170	**2.4**	**0.08**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	4.3	0.06	0.08	90	150	**1.8**	**0.07**	**130**
			10		280 HB	0.3	4.3	0.05	0.10	90	130	**1.8**	**0.08**	**120**
			11		320 HB	0.3	4.3	0.05	0.08	60	110	**1.8**	**0.06**	**100**
			11		350 HB	0.3	4.3	0.05	0.08	60	90	**1.8**	**0.06**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.3	6.0	0.06	0.08	190	250	**2.4**	**0.07**	**220**
			14		240 HB	0.3	6.0	0.05	0.08	160	210	**2.4**	**0.07**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.3	4.3	0.05	0.08	70	130	**1.8**	**0.07**	**100**
			14		310 HB	0.3	4.3	0.05	0.07	70	120	**1.8**	**0.06**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	6.0	0.05	0.08	150	210	**2.4**	**0.07**	**190**
			13		42 HRc	0.3	4.3	0.05	0.07	90	150	**1.8**	**0.06**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.3	6.0	0.05	0.14	150	240	**2.4**	**0.12**	**200**
			15		200 HB	0.3	6.0	0.05	0.12	150	220	**2.4**	**0.10**	**180**
			16		250 HB	0.3	6.0	0.05	0.12	150	190	**2.4**	**0.10**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.3	6.0	0.05	0.14	100	200	**2.4**	**0.12**	**180**
			17,19		200 HB	0.3	6.0	0.05	0.12	100	180	**2.4**	**0.10**	**150**
			18,20		250 HB	0.3	6.0	0.05	0.12	100	150	**2.4**	**0.10**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.3	4.3	0.04	0.08	25	45	**1.8**	**0.06**	**32**
			33	Inconel 700	250 HB	0.3	4.3	0.04	0.08	25	45	**1.8**	**0.06**	**30**
			34	Stellite 21	350 HB	0.3	4.3	0.04	0.08	25	45	**1.8**	**0.06**	**30**
	Ti based	10	36	TiAl6V4	-	0.3	4.3	0.04	0.08	40	65	**1.8**	**0.06**	**55**
			37	T40	-	0.3	4.3	0.04	0.08	30	55	**1.8**	**0.06**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	2.1	0.04	0.10	40	80	**1.2**	**0.08**	**60**
			38		50 HRc	0.3	1.3	0.04	0.08	40	70	**0.9**	**0.06**	**55**
			38		55 HRc	0.3	0.9	0.04	0.06	40	60	**0.6**	**0.05**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.3	1.7	0.04	0.06	40	80	**0.9**	**0.05**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.3	0.9	0.04	0.06	30	60	**0.6**	**0.05**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.3	6.0	0.08	0.14	200	400	**2.4**	**0.12**	**280**

SPMT 09T308 TN – LT 30 | LT 3000

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	9.0	0.07	0.17	190	330	**2.4**	**0.15**	**250**
			2		190 HB	0.5	9.0	0.06	0.15	190	300	**2.4**	**0.13**	**220**
			3		250 HB	0.5	9.0	0.06	0.15	190	250	**2.4**	**0.13**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.07	0.17	150	240	**2.4**	**0.15**	**200**
			4,6		230 HB	0.5	9.0	0.06	0.15	150	210	**2.4**	**0.13**	**180**
			5,7		280 HB	0.5	9.0	0.05	0.13	130	190	**2.4**	**0.11**	**150**
			8		350 HB	0.5	9.0	0.05	0.13	130	170	**2.4**	**0.11**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.07	0.15	90	150	**1.8**	**0.13**	**130**
			10		280 HB	0.5	6.5	0.05	0.13	90	130	**1.8**	**0.11**	**120**
			11		320 HB	0.5	6.5	0.05	0.10	60	110	**1.8**	**0.08**	**100**
			11		350 HB	0.5	6.5	0.05	0.10	60	90	**1.8**	**0.08**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.07	0.12	190	250	**2.4**	**0.10**	**220**
			14		240 HB	0.5	9.0	0.05	0.10	160	210	**2.4**	**0.08**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.5	0.05	0.10	70	130	**1.8**	**0.08**	**100**
			14		310 HB	0.5	6.5	0.05	0.08	70	120	**1.8**	**0.07**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.05	0.08	150	210	**2.4**	**0.07**	**190**
			13		42 HRc	0.5	6.5	0.05	0.08	90	150	**1.8**	**0.07**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.06	0.22	150	240	**2.4**	**0.18**	**200**
			15		200 HB	0.5	9.0	0.06	0.22	150	220	**2.4**	**0.18**	**180**
			16		250 HB	0.5	9.0	0.06	0.20	150	190	**2.4**	**0.16**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.06	0.22	100	200	**2.4**	**0.18**	**180**
			17,19		200 HB	0.5	9.0	0.05	0.22	100	180	**2.4**	**0.18**	**150**
			18,20		250 HB	0.5	9.0	0.05	0.20	100	150	**2.4**	**0.16**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.5	0.04	0.12	25	45	**1.8**	**0.10**	**32**
			33	Inconel 700	250 HB	0.5	6.5	0.04	0.12	25	45	**1.8**	**0.10**	**30**
			34	Stellite 21	350 HB	0.5	6.5	0.04	0.12	25	45	**1.8**	**0.10**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.5	0.04	0.12	40	65	**1.8**	**0.10**	**55**
			37	T40	-	0.5	6.5	0.04	0.12	30	55	**1.8**	**0.10**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.04	0.12	40	80	**1.2**	**0.10**	**60**
			38		50 HRc	0.5	1.9	0.04	0.10	40	70	**0.9**	**0.08**	**55**
			38		55 HRc	0.5	1.3	0.04	0.08	40	60	**0.6**	**0.06**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.04	0.08	40	80	**0.9**	**0.06**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.3	0.04	0.08	30	60	**0.6**	**0.06**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.08	0.16	200	400	**2.4**	**0.13**	**280**

SPMT 120408 TN – LT 30 | LT 3000

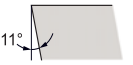
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	9.0	0.13	0.29	190	330	**3.0**	**0.18**	**250**
			2		190 HB	0.5	9.0	0.13	0.29	190	300	**3.0**	**0.18**	**220**
			3		250 HB	0.5	9.0	0.13	0.29	190	250	**3.0**	**0.18**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.23	150	240	**3.0**	**0.16**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.23	150	210	**3.0**	**0.16**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.20	130	190	**3.0**	**0.14**	**150**
			8		350 HB	0.5	9.0	0.11	0.20	130	170	**3.0**	**0.14**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.08	0.20	90	150	**2.3**	**0.14**	**130**
			10		280 HB	0.5	6.5	0.08	0.20	90	130	**2.3**	**0.14**	**120**
			11		320 HB	0.5	6.5	0.08	0.16	60	110	**2.3**	**0.13**	**100**
			11		350 HB	0.5	6.5	0.08	0.16	60	90	**2.3**	**0.13**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.23	190	250	**3.0**	**0.16**	**220**
			14		240 HB	0.5	9.0	0.08	0.20	160	210	**3.0**	**0.16**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.5	0.08	0.16	70	130	**2.3**	**0.13**	**100**
			14		310 HB	0.5	6.5	0.08	0.16	70	120	**2.3**	**0.13**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.23	150	210	**3.0**	**0.16**	**190**
			13		42 HRc	0.5	6.5	0.11	0.18	90	150	**2.3**	**0.13**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.29	150	240	**3.0**	**0.18**	**200**
			15		200 HB	0.5	9.0	0.13	0.29	150	220	**3.0**	**0.18**	**180**
			16		250 HB	0.5	9.0	0.13	0.29	150	190	**3.0**	**0.18**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	**3.0**	**0.16**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.25	100	180	**3.0**	**0.16**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.25	100	150	**3.0**	**0.16**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**32**
			33	Inconel 700	250 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**30**
			34	Stellite 21	350 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	6.5	0.08	0.18	40	65	**2.3**	**0.14**	**55**
			37	T40	-	0.5	6.5	0.08	0.16	30	55	**2.3**	**0.13**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.07	0.16	40	80	**1.5**	**0.11**	**60**
			38		50 HRc	0.5	1.9	0.07	0.14	40	70	**1.1**	**0.10**	**55**
			38		55 HRc	0.5	1.0	0.07	0.13	40	60	**0.8**	**0.10**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.07	0.16	40	80	**1.1**	**0.11**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.07	0.13	30	60	**0.8**	**0.10**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.29	200	400	**3.0**	**0.20**	**280**

SPMT 12T308 – **LT 30 | LT 3000**

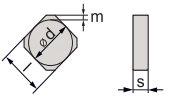
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	9.0	0.13	0.29	190	330	**3.0**	**0.18**	**250**
			2		190 HB	0.5	9.0	0.13	0.29	190	300	**3.0**	**0.18**	**220**
			3		250 HB	0.5	9.0	0.13	0.29	190	250	**3.0**	**0.18**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.23	150	240	**3.0**	**0.16**	**200**
			4,6		230 HB	0.5	9.0	0.11	0.23	150	210	**3.0**	**0.16**	**180**
			5,7		280 HB	0.5	9.0	0.11	0.20	130	190	**3.0**	**0.14**	**150**
			8		350 HB	0.5	9.0	0.11	0.20	130	170	**3.0**	**0.14**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.08	0.20	90	150	**2.3**	**0.14**	**130**
			10		280 HB	0.5	6.5	0.08	0.20	90	130	**2.3**	**0.14**	**120**
			11		320 HB	0.5	6.5	0.08	0.16	60	110	**2.3**	**0.13**	**100**
			11		350 HB	0.5	6.5	0.08	0.16	60	90	**2.3**	**0.13**	**80**
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.23	190	250	**3.0**	**0.16**	**220**
			14		240 HB	0.5	9.0	0.08	0.20	160	210	**3.0**	**0.16**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	6.5	0.08	0.16	70	130	**2.3**	**0.13**	**100**
			14		310 HB	0.5	6.5	0.08	0.16	70	120	**2.3**	**0.13**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.23	150	210	**3.0**	**0.16**	**190**
			13		42 HRc	0.5	6.5	0.11	0.18	90	150	**2.3**	**0.13**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.29	150	240	**3.0**	**0.18**	**200**
			15		200 HB	0.5	9.0	0.13	0.29	150	220	**3.0**	**0.18**	**180**
			16		250 HB	0.5	9.0	0.13	0.29	150	190	**3.0**	**0.18**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	**3.0**	**0.16**	**180**
			17,19		200 HB	0.5	9.0	0.11	0.25	100	180	**3.0**	**0.16**	**150**
			18,20		250 HB	0.5	9.0	0.11	0.25	100	150	**3.0**	**0.16**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**32**
			33	Inconel 700	250 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**30**
			34	Stellite 21	350 HB	0.5	6.5	0.08	0.16	25	45	**2.3**	**0.13**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	6.5	0.08	0.18	40	65	**2.3**	**0.14**	**55**
			37	T40	-	0.5	6.5	0.08	0.16	30	55	**2.3**	**0.13**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	3.2	0.07	0.16	40	80	**1.5**	**0.11**	**60**
			38		50 HRc	0.5	1.9	0.07	0.14	40	70	**1.1**	**0.10**	**55**
			38		55 HRc	0.5	1.0	0.07	0.13	40	60	**0.8**	**0.10**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.6	0.07	0.16	40	80	**1.1**	**0.11**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.0	0.07	0.13	30	60	**0.8**	**0.10**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.29	200	400	**3.0**	**0.20**	**280**

S P U N

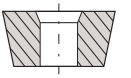
Shape



Clearance Angle



Tolerance
d ± 0.13
m ± 0.20
s ± 0.13



Fixing, Chipbreaker

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
SPUN 120308 LT 30	12.7	3.18	0.8	Neutral	M0000050

Application Guide

Chamfering

Surfacing

Machining Recommendations

F ⇒
Productivity

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

Stainless Steel
V_c

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

SPUN 120308 – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	7.0	0.18	0.37	190	330	**3.0**	**0.26**	**250**
			2		190 HB	0.5	7.0	0.18	0.37	190	300	**3.0**	**0.26**	**220**
			3		250 HB	0.5	7.0	0.18	0.37	190	250	**3.0**	**0.26**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.29	150	240	**3.0**	**0.23**	**200**
			4,6		230 HB	0.5	7.0	0.15	0.29	150	210	**3.0**	**0.23**	**180**
			5,7		280 HB	0.5	7.0	0.15	0.25	130	190	**3.0**	**0.21**	**150**
			8		350 HB	0.5	7.0	0.15	0.25	130	170	**3.0**	**0.21**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.25	90	150	**2.3**	**0.21**	**130**
			10		280 HB	0.5	5.0	0.12	0.25	90	130	**2.3**	**0.21**	**120**
			11		320 HB	0.5	5.0	0.12	0.21	60	110	**2.3**	**0.18**	**100**
			11		350 HB	0.5	5.0	0.12	0.21	60	90	**2.3**	**0.18**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.37	150	240	**3.0**	**0.26**	**200**
			15		200 HB	0.5	7.0	0.18	0.37	150	220	**3.0**	**0.26**	**180**
			16		250 HB	0.5	7.0	0.18	0.37	150	190	**3.0**	**0.26**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.32	100	200	**3.0**	**0.23**	**180**
			17,19		200 HB	0.5	7.0	0.15	0.32	100	180	**3.0**	**0.23**	**150**
			18,20		250 HB	0.5	7.0	0.15	0.32	100	150	**3.0**	**0.23**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.21	40	80	**1.5**	**0.16**	**60**
			38		50 HRc	0.5	1.8	0.10	0.18	40	70	**1.1**	**0.15**	**55**
			38		55 HRc	0.5	1.5	0.10	0.16	40	60	**0.8**	**0.14**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.21	40	80	**1.1**	**0.16**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.16	30	60	**0.8**	**0.14**	**40**

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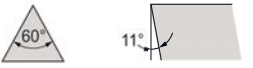
T P K N



Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

Tolerance

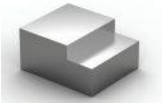
m ± 0.013 **s** ± 0.025
For l = 16, **d** ± 0.05
For l = 22, **d** ± 0.08

LT 30 Multi-Mat™ General Usage – Standard

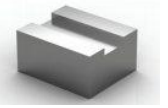
Insert Designation	l	s	r	Direction	Catalog Nr.
TPKN 1603 PDTR LT 30	14.52	3.18	1.2	Right	M0000051
TPKN 2204 PDTR LT 30	19.92	4.76	1.2	Right	M0000052

Application Guide

Shoulder Milling



Slotting



Surfacing

Machining Recommendations

F ⇒ Productivity

Coolant

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

Stainless Steel

V_c

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www.akytec.ru

Shell Mill for TPKN 1603 PDTR						
Cutter Designation	D	d	L	Ap	z	Catalog Nr.
LT 310 M-D063/4*	63	22	50	13	4	M2000699
LT 310 M-D080/5*	80	27	50	13	5	M2000700
LT 310 M-D100/6*	100	32	50	13	6	M2000701
LT 310 M-D125/6*	125	40	63	13	6	M2000702

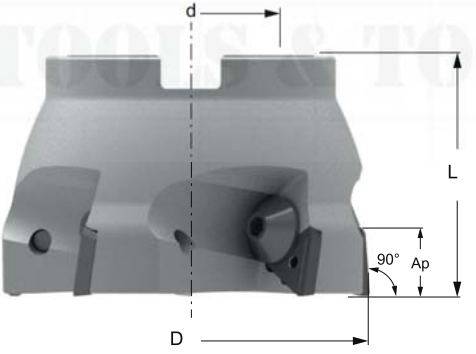
* On request

Screw: On request
Key: M2000609

Shell Mill for TPKN 2204 PDTR						
Cutter Designation	D	d	L	Ap	z	Catalog Nr.
LT 320 M-D080/4*	80	27	50	18	4	M2000703
LT 320 M-D100/5*	100	32	50	18	5	M2000704
LT 320 M-D125/6*	125	40	63	18	6	M2000705
LT 320 M-D160/7*	160	40	63	18	7	M2000706

* On request

Screw: On request
Key: M2000609



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ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

TPKN 1603 PDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	12.0	0.14	0.27	190	330	**3.0**	**0.20**	**250**
			2		190 HB	0.5	12.0	0.14	0.27	190	300	**3.0**	**0.20**	**220**
			3		250 HB	0.5	12.0	0.14	0.27	190	250	**3.0**	**0.20**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	12.0	0.12	0.21	150	240	**3.0**	**0.17**	**200**
			4,6		230 HB	0.5	12.0	0.12	0.21	150	210	**3.0**	**0.17**	**180**
			5,7		280 HB	0.5	12.0	0.12	0.19	130	190	**3.0**	**0.15**	**150**
			8		350 HB	0.5	12.0	0.12	0.19	130	170	**3.0**	**0.15**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	8.6	0.10	0.19	90	150	**2.3**	**0.15**	**130**
			10		280 HB	0.5	8.6	0.10	0.19	90	130	**2.3**	**0.15**	**120**
			11		320 HB	0.5	8.6	0.10	0.15	60	110	**2.3**	**0.14**	**100**
			11		350 HB	0.5	8.6	0.10	0.15	60	90	**2.3**	**0.14**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	12.0	0.14	0.27	150	240	**3.0**	**0.20**	**200**
			15		200 HB	0.5	12.0	0.14	0.27	150	220	**3.0**	**0.20**	**180**
			16		250 HB	0.5	12.0	0.14	0.27	150	190	**3.0**	**0.20**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	12.0	0.12	0.24	100	200	**3.0**	**0.17**	**180**
			17,19		200 HB	0.5	12.0	0.12	0.24	100	180	**3.0**	**0.17**	**150**
			18,20		250 HB	0.5	12.0	0.12	0.24	100	150	**3.0**	**0.17**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	4.3	0.08	0.15	40	80	**1.5**	**0.12**	**60**
			38		50 HRc	0.5	3.0	0.08	0.14	40	70	**1.1**	**0.11**	**55**
			38		55 HRc	0.5	2.6	0.08	0.12	40	60	**0.8**	**0.10**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	3.4	0.08	0.15	40	80	**1.1**	**0.12**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	2.6	0.08	0.12	30	60	**0.8**	**0.10**	**40**

TPKN 2204 PDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	18.0	0.16	0.27	190	330	**4.0**	**0.19**	**250**
			2		190 HB	0.5	18.0	0.16	0.27	190	300	**4.0**	**0.19**	**220**
			3		250 HB	0.5	18.0	0.16	0.27	190	250	**4.0**	**0.19**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	18.0	0.14	0.21	150	240	**4.0**	**0.17**	**200**
			4,6		230 HB	0.5	18.0	0.14	0.21	150	210	**4.0**	**0.17**	**180**
			5,7		280 HB	0.5	18.0	0.14	0.19	130	190	**4.0**	**0.15**	**150**
			8		350 HB	0.5	18.0	0.14	0.19	130	170	**4.0**	**0.15**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	12.9	0.11	0.19	90	150	**3.0**	**0.15**	**130**
			10		280 HB	0.5	12.9	0.11	0.19	90	130	**3.0**	**0.15**	**120**
			11		320 HB	0.5	12.9	0.11	0.15	60	110	**3.0**	**0.13**	**100**
			11		350 HB	0.5	12.9	0.11	0.15	60	90	**3.0**	**0.13**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	18.0	0.16	0.27	150	240	**4.0**	**0.19**	**200**
			15		200 HB	0.5	18.0	0.16	0.27	150	220	**4.0**	**0.19**	**180**
			16		250 HB	0.5	18.0	0.16	0.27	150	190	**4.0**	**0.19**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	18.0	0.14	0.24	100	200	**4.0**	**0.17**	**180**
			17,19		200 HB	0.5	18.0	0.14	0.24	100	180	**4.0**	**0.17**	**150**
			18,20		250 HB	0.5	18.0	0.14	0.24	100	150	**4.0**	**0.17**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	6.4	0.09	0.15	40	80	**2.0**	**0.12**	**60**
			38		50 HRc	0.5	4.5	0.09	0.14	40	70	**1.5**	**0.11**	**55**
			38		55 HRc	0.5	3.9	0.09	0.12	40	60	**1.0**	**0.10**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	5.1	0.09	0.15	40	80	**1.5**	**0.12**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	3.9	0.09	0.12	30	60	**1.0**	**0.10**	**40**

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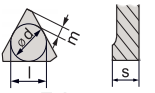
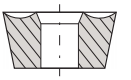
T P K R

Shape | **Clearance Angle**



Tolerance

m ± 0.013 **s** ± 0.025
For l = 16, **d** ± 0.05
For l = 22, **d** ± 0.08



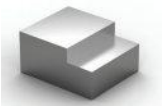
Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

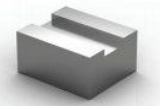
Insert Designation	l	s	r	Direction	Catalog Nr.
TPKR 1603 PDTR LT 30	14.52	3.18	1.2	Right	M0000053
TPKR 2204 PDTR LT 30	19.92	4.76	1.2	Right	M0000983

Application Guide

Shoulder Milling

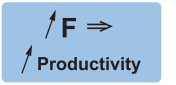


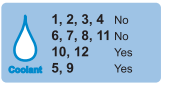
Slotting



Surfacing

Machining Recommendations





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Shell Mill for TPKR 1603 PDTR						
Cutter Designation	D	d	L	Ap	z	Catalog Nr.
LT 310 M-D063/4*	63	22	50	13	4	M2000699
LT 310 M-D080/5*	80	27	50	13	5	M2000700
LT 310 M-D100/6*	100	32	50	13	6	M2000701
LT 310 M-D125/6*	125	40	63	13	6	M2000702

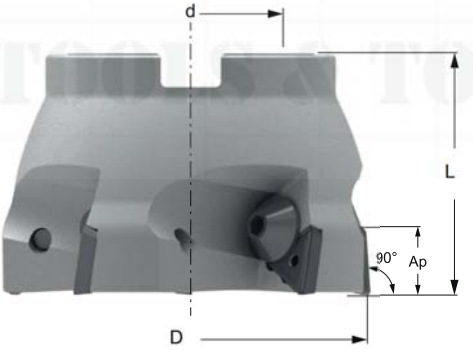
* On request

Screw: On request
Key: M2000609

Shell Mill for TPKR 2204 PDTR						
Cutter Designation	D	d	L	Ap	z	Catalog Nr.
LT 320 M-D080/4*	80	27	50	18	4	M2000703
LT 320 M-D100/5*	100	32	50	18	5	M2000704
LT 320 M-D125/6*	125	40	63	18	6	M2000705
LT 320 M-D160/7*	160	40	63	18	7	M2000706

* On request

Screw: On request
Key: M2000609



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тел. 8 (499) 550 5039, mail@akytec.ru
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TPKR 1603 PDTR – LT 30

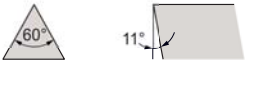
Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	12.0	0.13	0.22	190	330	**3.0**	**0.17**	**250**
			2		190 HB	0.5	12.0	0.13	0.22	190	300	**3.0**	**0.17**	**220**
			3		250 HB	0.5	12.0	0.13	0.22	190	250	**3.0**	**0.17**	**200**
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	12.0	0.11	0.18	150	240	**3.0**	**0.15**	**200**
			4,6		230 HB	0.5	12.0	0.11	0.18	150	210	**3.0**	**0.15**	**180**
			5,7		280 HB	0.5	12.0	0.11	0.15	130	190	**3.0**	**0.13**	**150**
			8		350 HB	0.5	12.0	0.11	0.15	130	170	**3.0**	**0.13**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	8.6	0.08	0.15	90	150	**2.3**	**0.13**	**130**
			10		280 HB	0.5	8.6	0.08	0.15	90	130	**2.3**	**0.13**	**120**
			11		320 HB	0.5	8.6	0.08	0.13	60	110	**2.3**	**0.12**	**100**
			11		350 HB	0.5	8.6	0.08	0.13	60	90	**2.3**	**0.12**	**80**
Stainless Steel	High Alloyed	4	14	304, 316, X5CrNi18-9	180 HB	0.5	12.0	0.11	0.15	190	250	**3.0**	**0.13**	**220**
			14		240 HB	0.5	12.0	0.08	0.14	160	210	**3.0**	**0.13**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	8.6	0.08	0.13	70	130	**2.3**	**0.12**	**100**
			14		310 HB	0.5	8.6	0.08	0.13	70	120	**2.3**	**0.12**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	12.0	0.11	0.15	150	210	**3.0**	**0.13**	**190**
			13		42 HRc	0.5	8.6	0.11	0.13	90	150	**2.3**	**0.12**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	12.0	0.13	0.22	150	240	**3.0**	**0.17**	**200**
			15		200 HB	0.5	12.0	0.13	0.22	150	220	**3.0**	**0.17**	**180**
			16		250 HB	0.5	12.0	0.13	0.22	150	190	**3.0**	**0.17**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	12.0	0.11	0.20	100	200	**3.0**	**0.15**	**180**
			17,19		200 HB	0.5	12.0	0.11	0.20	100	180	**3.0**	**0.15**	**150**
			18,20		250 HB	0.5	12.0	0.11	0.20	100	150	**3.0**	**0.15**	**130**
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.5	8.6	0.08	0.13	25	45	**2.3**	**0.12**	**32**
			33	Inconel 700	250 HB	0.5	8.6	0.08	0.13	25	45	**2.3**	**0.12**	**30**
			34	Stellite 21	350 HB	0.5	8.6	0.08	0.13	25	45	**2.3**	**0.12**	**30**
	Ti based	10	36	TiAl6V4	-	0.5	8.6	0.08	0.14	40	65	**2.3**	**0.13**	**55**
			37	T40	-	0.5	8.6	0.08	0.13	30	55	**2.3**	**0.12**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	4.3	0.07	0.13	40	80	**1.5**	**0.10**	**60**
			38		50 HRc	0.5	3.0	0.07	0.11	40	70	**1.1**	**0.09**	**55**
			38		55 HRc	0.5	2.6	0.07	0.10	40	60	**0.8**	**0.09**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	3.4	0.07	0.13	40	80	**1.1**	**0.10**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	2.6	0.07	0.10	30	60	**0.8**	**0.09**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	12.0	0.13	0.22	200	400	**3.0**	**0.18**	**280**

TPKR 2204 PDTR – LT 30

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	18.0	0.13	0.22	190	330	**4.0**	**0.17**	**250**
			2		190 HB	0.5	18.0	0.13	0.22	190	300	**4.0**	**0.17**	**220**
			3		250 HB	0.5	18.0	0.13	0.22	190	250	**4.0**	**0.17**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	18.0	0.11	0.18	150	240	**4.0**	**0.15**	**200**
			4,6		230 HB	0.5	18.0	0.11	0.18	150	210	**4.0**	**0.15**	**180**
			5,7		280 HB	0.5	18.0	0.11	0.15	130	190	**4.0**	**0.13**	**150**
			8		350 HB	0.5	18.0	0.11	0.15	130	170	4.0	0.13	140
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	12.9	0.08	0.15	90	150	**3.0**	**0.13**	**130**
			10		280 HB	0.5	12.9	0.08	0.15	90	130	**3.0**	**0.13**	**120**
			11		320 HB	0.5	12.9	0.08	0.13	60	110	**3.0**	**0.12**	**100**
			11		350 HB	0.5	12.9	0.08	0.13	60	90	**3.0**	**0.12**	80
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.5	18.0	0.11	0.15	190	250	**4.0**	**0.13**	**220**
			14		240 HB	0.5	18.0	0.08	0.14	160	210	**4.0**	**0.13**	**190**
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	12.9	0.08	0.13	70	130	**3.0**	**0.12**	**100**
			14		310 HB	0.5	12.9	0.08	0.13	70	120	**3.0**	**0.12**	**90**
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	18.0	0.11	0.15	150	210	**4.0**	**0.13**	**190**
			13		42 HRc	0.5	12.9	0.11	0.13	90	150	**3.0**	**0.12**	**130**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	18.0	0.13	0.22	150	240	**4.0**	**0.17**	**200**
			15		200 HB	0.5	18.0	0.13	0.22	150	220	**4.0**	**0.17**	**180**
			16		250 HB	0.5	18.0	0.13	0.22	150	190	**4.0**	**0.17**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	18.0	0.11	0.20	100	200	**4.0**	**0.15**	**180**
			17,19		200 HB	0.5	18.0	0.11	0.20	100	180	**4.0**	**0.15**	**150**
			18,20		250 HB	0.5	18.0	0.11	0.20	100	150	**4.0**	**0.15**	**130**
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.5	12.9	0.08	0.13	25	45	**3.0**	**0.12**	**32**
			33	Inconel 700	250 HB	0.5	12.9	0.08	0.13	25	45	**3.0**	**0.12**	**30**
			34	Stellite 21	350 HB	0.5	12.9	0.08	0.13	25	45	**3.0**	**0.12**	**30**
	Ti Based	10	36	TiAl6V4	-	0.5	12.9	0.08	0.14	40	65	**3.0**	**0.13**	**55**
			37	T40	-	0.5	12.9	0.08	0.13	30	55	**3.0**	**0.12**	**40**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	6.4	0.07	0.13	40	80	**2.0**	**0.10**	**60**
			38		50 HRc	0.5	4.5	0.07	0.11	40	70	**1.5**	**0.09**	**55**
			38		55 HRc	0.5	3.9	0.07	0.10	40	60	**1.0**	**0.09**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	5.1	0.07	0.13	40	80	**1.5**	**0.10**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	3.9	0.07	0.10	30	60	**1.0**	**0.09**	**40**
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	18.0	0.13	0.22	200	400	**4.0**	**0.18**	**280**

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

T P U N



Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

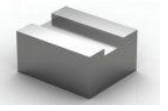
Tolerance
d ± 0.08
m ± 0.13
s ± 0.13

LT 30	Multi-Mat™ General Usage – Standard				
Insert Designation	l	s	r	Direction	Catalog Nr.
TPUN 160308 LT 30	13.49	3.18	0.8	Right	M0000054

Application Guide

Shoulder Milling

Slotting



Surfacing

Machining Recommendations

F ⇒
Productivity

Coolant

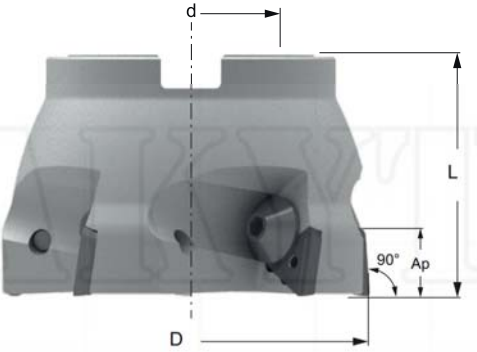
1, 2, 3, 4	No
6, 7, 8, 11	No
10, 12	Yes
5, 9	Yes

ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

Shell Mill for TPUN1603 PDTR						
Cutter Designation	D	d	L	Ap	z	Catalog Nr.
LT 310 M-D063/4*	63	22	50	13	4	M2000699
LT 310 M-D080/5*	80	27	50	13	5	M2000700
LT 310 M-D100/6*	100	32	50	13	6	M2000701
LT 310 M-D125/6*	125	40	63	13	6	M2000702

* On request

Screw: On request
Key: M2000609



ООО "АКИТЭК", РФ., г. Москва.
ул. Подольских курсантов, дом. 22, корпус 5,
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

TPUN 160308 NN PDTR – **LT 30**

Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		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	0.5	12.0	0.14	0.27	190	330	**3.0**	**0.20**	**250**
			2		190 HB	0.5	12.0	0.14	0.27	190	300	**3.0**	**0.20**	**220**
			3		250 HB	0.5	12.0	0.14	0.27	190	250	**3.0**	**0.20**	**200**
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	12.0	0.12	0.21	150	240	**3.0**	**0.17**	**200**
			4,6		230 HB	0.5	12.0	0.12	0.21	150	210	**3.0**	**0.17**	**180**
			5,7		280 HB	0.5	12.0	0.12	0.19	130	190	**3.0**	**0.15**	**150**
			8		350 HB	0.5	12.0	0.12	0.19	130	170	**3.0**	**0.15**	**140**
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	8.6	0.10	0.19	90	150	**2.3**	**0.15**	**130**
			10		280 HB	0.5	8.6	0.10	0.19	90	130	**2.3**	**0.15**	**120**
			11		320 HB	0.5	8.6	0.10	0.15	60	110	**2.3**	**0.14**	**100**
			11		350 HB	0.5	8.6	0.10	0.15	60	90	**2.3**	**0.14**	**80**
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	12.0	0.14	0.27	150	240	**3.0**	**0.20**	**200**
			15		200 HB	0.5	12.0	0.14	0.27	150	220	**3.0**	**0.20**	**180**
			16		250 HB	0.5	12.0	0.14	0.27	150	190	**3.0**	**0.20**	**160**
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	12.0	0.12	0.24	100	200	**3.0**	**0.17**	**180**
			17,19		200 HB	0.5	12.0	0.12	0.24	100	180	**3.0**	**0.17**	**150**
			18,20		250 HB	0.5	12.0	0.12	0.24	100	150	**3.0**	**0.17**	**130**
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	4.3	0.08	0.15	40	80	**1.5**	**0.12**	**60**
			38		50 HRc	0.5	3.0	0.08	0.14	40	70	**1.1**	**0.11**	**55**
			38		55 HRc	0.5	2.6	0.08	0.12	40	60	**0.8**	**0.10**	**50**
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.5	3.4	0.08	0.15	40	80	**1.1**	**0.12**	**50**
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.5	2.6	0.08	0.12	30	60	**0.8**	**0.10**	**40**