ALU-MILLING

LT 05

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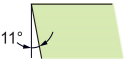
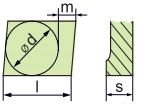
A P G T

Shape

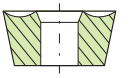


Clearance Angle



Tolerance

d ± 0.025
m ± 0.025
s ± 0.13



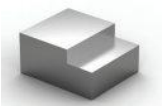
Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

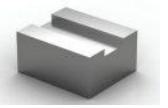
Insert Designation	l	s	r	Direction	Catalog Nr.
APGT 100304 PDER-ALU LT05	10.80	3.52	0.4	Right	M0003089
APGT 160408 PDER-ALU LT05	16.40	4.89	0.8	Right	M0001010

Application Guide

Shoulder Mill



Slotting



Surfacing

Machining Recommendations

F ⇒
Productivity

Coolant

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

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APGT 100304 PDER-ALU – **LT 05**

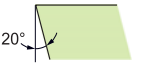
	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	9.0	0.12	0.20	400	1200	**3.0**	**0.14**	**500**
				4% < Si < 8 %	100 HB	0.3	9.0	0.10	0.18	250	600	**3.0**	**0.14**	**400**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	9.0	0.10	0.18	100	800	**3.0**	**0.14**	**300**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	9.0	0.12	0.20	80	500	**3.0**	**0.12**	**200**
			30	Hard Rubber	-	0.3	9.0	0.12	0.20	80	300	**3.0**	**0.12**	**150**
			-	Graphite	-	0.3	9.0	0.12	0.20	100	200	**3.0**	**0.12**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	5.0	0.08	0.20	35	60	**2.0**	**0.12**	**45**
			37	TiAl 6 V4	-	0.3	5.0	0.08	0.15	28	45	**2.0**	**0.12**	**35**

APGT 160408 PDER-ALU – **LT 05**

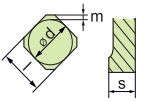
	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.5	15.0	0.15	0.32	400	1200	**4.0**	**0.16**	**500**
				4% < Si < 8 %	100 HB	0.5	15.0	0.13	0.29	250	600	**4.0**	**0.16**	**400**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.5	15.0	0.13	0.29	100	800	**4.0**	**0.16**	**300**
	Non-Metallic	15	29	Fiber Plastics	-	0.5	15.0	0.15	0.32	80	500	**4.0**	**0.14**	**200**
			30	Hard Rubber	-	0.5	15.0	0.15	0.32	80	300	**4.0**	**0.14**	**150**
			-	Graphite	-	0.5	15.0	0.15	0.32	100	200	**4.0**	**0.14**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.5	15.0	0.10	0.32	35	60	**4.0**	**0.14**	**45**
			37	TiAl 6 V4	-	0.5	15.0	0.10	0.24	28	45	**4.0**	**0.14**	**35**

S E G T

Shape



Clearance Angle



Tolerance
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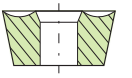
m ± 0.025
s ± 0.13



Fixing, Chipbreaker

LT 30 Multi-Mat™ General Usage – Standard

Insert Designation	l	s	r	Direction	Catalog Nr.
SEGT 1204 AFEN-ALU LT05	12.70	4.79	0.84	Neutral	M0001008

Application Guide

Surfacing

Chamfering

Machining Recommendations

F ⇒ Productivity

Coolant

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

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SEGT 1204 AFEN-ALU – **LT 05**

	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
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	9.0	0.12	0.35	400	1200	**3.0**	**0.25**	**500**
				4% < Si < 8 %	100 HB	0.3	9.0	0.10	0.35	250	600	**3.0**	**0.25**	**400**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	9.0	0.10	0.35	100	800	**3.0**	**0.25**	**300**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	9.0	0.12	0.35	80	500	**3.0**	**0.20**	**200**
			30	Hard Rubber	-	0.3	9.0	0.12	0.35	80	300	**3.0**	**0.20**	**150**
			-	Graphite	-	0.3	9.0	0.12	0.35	100	200	**3.0**	**0.20**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	5.0	0.08	0.35	35	60	**2.0**	**0.20**	**45**
			37	TiAl 6 V4	-	0.3	5.0	0.08	0.28	28	45	**2.0**	**0.20**	**35**