

MILLING

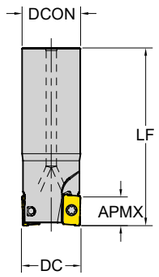
Product Overview

Application Guide

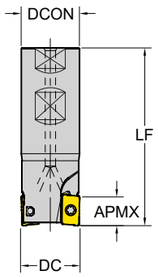
Milling Inserts & Cutter Overview

Milling Inserts & Cutter

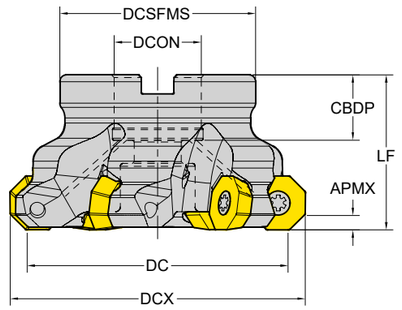
Code Keys - Milling Cutters



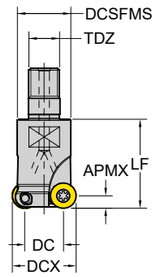
<C> Cylindrical



<W> Weldon



<S> Shell Mill



<M> Modular

Cutting Angle (90°)		Cutter Diameter (Φ16)		Connection Type and Size C - Cylindrical S - Shell Mill (Cylindrical Φ16) W - Weldon M - Modular		* Shank Type Only
E	90	APKT10	D16	Z2	C16	L100
	KAPR		DC or DCX*	ZEFP	DCON or TDZ	LF*

* DCX for Round insert

Cutting Angle
(90°)

Cutter Diameter
(Φ16)

Connection Type and Size
C - Cylindrical
S - Shell Mill
(Cylindrical Φ16)
W - Weldon
M - Modular

* Shank Type Only

Cutter Type
E - Endmill Type
F - Facemill Type
M - Modular Type

Insert Series
(APKT 10)

Number of Teeth
(Z=2)

Functional Length
(100mm)

Insert ISO Code System

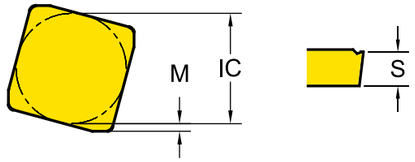
1	2	3	4	5	6	7	page 95	page 95	
							8	9	10
A	**P**	**K**	**T**	**16**	**04**	**08**	**PDTR**	**-TR**	**YG602**
Shape	Relief Angle (AN)	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness (S)	CornerRadius	Corner Geometry	Chipbreaker	Grade

1 - Shape

Symbol	Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
A	Parallelogram 80°	
R	Round	

2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
N	No Relief Angle	
B	Relief 5°	AN
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	



3 - Tolerance Class

Symbol	Inner Circle IC (mm)	Nose Height M (mm)	Thickness S (mm)
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
H	± 0.013	± 0.013	± 0.025
K*	± 0.05~0.15*	± 0.013	± 0.025
M*	± 0.05~0.15*	± 0.08~0.2*	± 0.13
U*	± 0.08~0.25*	± 0.13~0.38*	±0.13

* Tolerance is different by insert IC size. Please see ISO 1832

4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
N	No clamping hole	X	
R		One Face	
W	Screw Hole	X	
T		One Face	
U		Both Faces	
X	Special		

5 - Insert Size

* No Standard for milling insert size

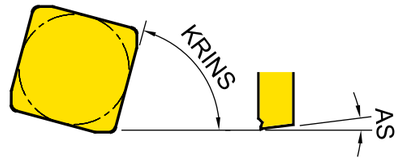
6 - Insert Thickness

* No Standard for milling insert thickness

7 - Corner Radius (RE)

Symbol	Corner Radius - RE (mm)	Symbol	Corner Radius - RE (mm)
04	0.4	**16**	1.6
08	0.8	**20**	2.0
12	1.2	**24**	2.4

8 - Corner Geometry



8-1	8-2	8-3	8-4
P	**D**	**T**	**R**
Cutting Edge Angle (KRINS)	Wiper Edge Clearance (AS)	Edge Condition	Feed Direction

*Refer to page. 95 for -AL, -ST, -TR… types

8-1 - Cutting Edge Angle (KRINS)

Symbol	Cutting Edge Angle (KRINS)
P	90°
A	45°
D	60°
E	75°
F	85°
Z	Special

8-2 - Wiper Edge Clearance (AS)

Symbol	Wiper Edge Clearance (AS)
N	0°
P	11°
D	15°
E	20°
F	25°
Z	Special

8-3 - Edge Condition

Symbol	Edge Condition	
F	Sharp	
E	Rounded	
T	Chamfered	
S	Chamfered and Rounded	

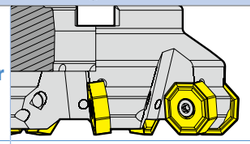
8-4 - Feed Direction

Symbol	Feed Direction	
R	Right-hand Insert	
N	Neutral Insert	
L	Left-hand Insert	

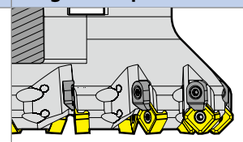
Milling Overview

Face Milling

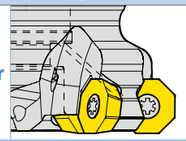
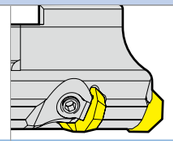
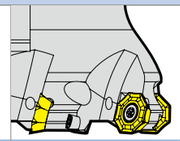
Negative Octagonal

Cutter		ONMU 0806
APMX		5.5
DC		Φ63~315
page		p. 96

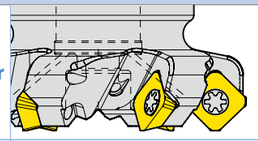
Negative Square

Cutter		SNMX 1206
APMX		6
DC		Φ50~200
page		p. 97

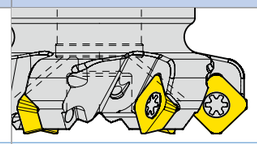
Positive Octagonal

Cutter			
	ODMT/ODMW 0605	OFER 0704	OFMT 05T3
APMX	4	5	3
DC	Φ63~125	Φ63~160	Φ50~125
page	p. 98	p. 99	p. 98

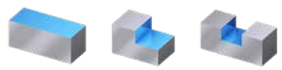
Positive Square

Cutter		SEKT 1204 / SEKT 12T3	SPKN/SPKR/SPCN 1203
APMX		6	6	8
DC		Φ40~160	Φ50~160	Φ50~200
page		p. 100		p. 101

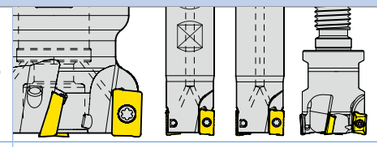
ISO



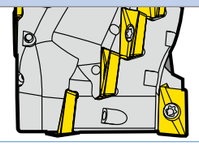
Shoulder Milling



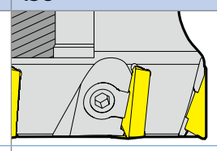
2 Corner Positive

Cutter		ADKT 1505	AOMT 1236	APKT 1003	APKT 1604	APMT 1135	APMT 1604
APMX		15	12	10	16	10	16
DC		Φ25~125	Φ16~50	Φ16~100	Φ25~200	Φ16~80	Φ25~80
page		p. 113	p. 113	p.114-115	p.116-117	p. 73	p. 73

2 Corner Positive Helical (Long Edge)

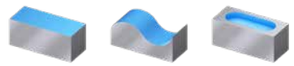
Cutter		APKT 1003
APMX		37~55
DC		Φ25~40
page		p. 119

ISO

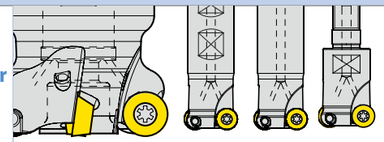
Cutter		TPKN/TPKR/TPCN 1603 / TPKN/TPKR/TPCN 2204
APMX		12	18
DC		Φ50~125	Φ63~315
page		p. 120	

Milling Overview

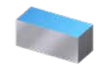
Profiling



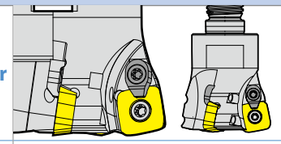
Round Positive

Cutter		RDKT/RDKW 0802	RDKT/RDKW 10T3	RDKT/RDKW 1204	RPMT/RPMW 08T2	RPMT/RPMW 10T3	RPMT/RPMW 1204
APMX		4	5	6	4	5	6
DC		Φ16~25	Φ20~63	Φ25~100	Φ20~25	Φ25~32	Φ32~80
page		p. 126	p. 126	p. 127	p. 128	p. 128	p. 128

High Feed Milling



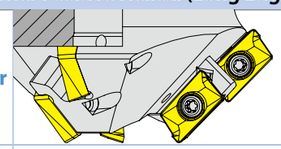
Positive 4 Corner

Cutter		SDMT/SDMW 1204
APMX		6
DC		Φ50~200
page		p. 133

Taper Milling

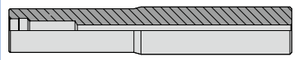


2 Corner Positive Helical (Long Edge)

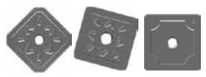
Cutter		APKT 1604
KAPR		15° 45° 60° 75°
page		p. 135

Modular Shank

Modular Shank for Modular Head

Cutter		M08 ~ M16
page		p. 137

Milling Inserts Overview

A 2 Corner	 Positive	**ADKT**	ADKT 1505	**p. 121**
		AOMT	AOMT 1236	**p. 121**
		APKT	APKT 1003, 1604	**p. 122**
		APMT	APMT 1135, 1504, 1604	**p. 123**
O Octagon	 Positive	**ODMT / ODMW**	ODMT / ODMW 0605	**p. 102**
		OFER	OFER 0704	**p. 103**
		OFMT	OFMT 05T3	
	 Negative	**ONMU / ONHU**	ONMU / ONHU 0806	**p. 104**
R Round	 Positive Round	**RDKT / RDKW**	RDKT 0802, 10T3, 1204 RDKW 0501, 0702, 0802, 10T3, 1204	**p. 129**
		RDMT / RDMW	RDMT 0802, 0803, 10T3, 1204 RDMW 0802, 10T3, 1204	**p. 130**
	 Positive 3 Corner	**RPMT / RPMW**	RPMT 08T2, 10T3, 1204 RPMW 1003, 1204	**p. 131**
		RBEX50	RBEX50	**P. 132**
S Square	 High Feed	**SDMT / SDMW**	SDMT 1204, SDMW 1204	**p. 134**
	 Positive	**SEKT**	SEKT 12T3, 1204	**p. 107**
		SEMT	SEMT1204, 13T3	**P. 108**
		SPMT	SPMT 1204	**p. 111**
		SDKN (45˚)	SDKN 1203, 1504	**p. 105**
		SEKN / SEKR (45˚)	SEKN 1203 / SEKR 1203	**p. 106**
	 ISO	**SPKN / SPKR / SPCN(75˚)**	SPKN 1203, 1504 SPKR 1203 SPCN 1203, 1504	**p. 110**
		SPUN	SPUN 1203	
	 Negative	**SNMX**	SNMX1206	**p. 109**
T Triangle	 ISO	**TPKN / TPKR / TPCN(90˚)**	TPKN 1603, 2204 TPKR 1603, 2204 TPCN 2204	**p. 124**
		TPUN	TPUN 160308	**p. 125**

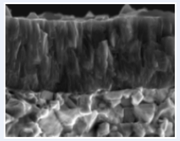
Milling Grades and Chipbreakers

Milling Grades

Milling Grades		P Steel				M Stainless Steel				K Cast Iron				N Non Ferrous				S Super Alloy			
		P05	P15	P25	P35	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35
PVD	YG602			602				602				602								602	
	YG622			622								622									
	YG712		712																		

YG602
P20 - P35 M20 - M40 K20 - K40 S15 - S25

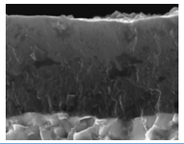
PVD - TiAlN



Universal grade for General Milling Application
- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application

YG622
P20 - P40 K20 - K40

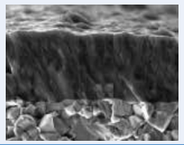
PVD - TiAlN



Optimized Grade for High Alloyed or Prehardened Steel
Excellent hot hardness and oxidation resistance at high speed

YG712
P10 - P30

PVD - AlTiCrN



General Milling Grade for Steel

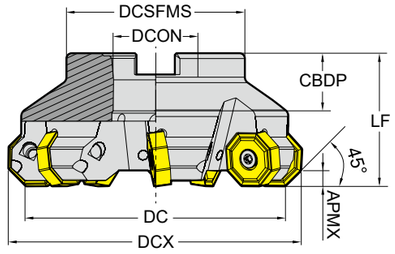
Milling Chipbreakers

–AL		• For Aluminum • Very Sharp Geometry
–ST		• For Stainless Steel, Super Alloy • Sharp Geometry
General Inserts (No Description)		• First Choice for General Application
–TR		• For Hardened Steels • Reinforced Geometry
...W / ...N		• For Hardened Material and Cast Irons

Cutters for ONMU

Cutting Angle : 45°
16 Corner Negative

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○: p. 104 unit:mm

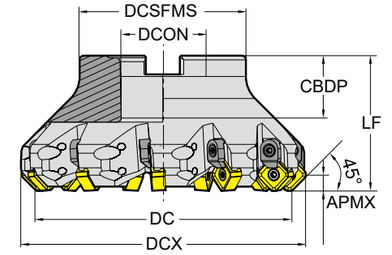
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
ONMU 0806	5.5	F45 - ONMU08 - D63Z5S22	0493	63	75	5	40	Shellmill	22	22	49	-	-	●
		F45 - ONMU08 - D80Z6S27	0494	80	92	6	50		27	25	58	-	-	●
		F45 - ONMU08 - D100Z7S32	0495	100	112	7	50		32	26	67	-	-	●
		F45 - ONMU08 - D125Z8S40 - WOC	0496	125	137	8	63		40	32	87	-	-	X
		F45 - ONMU08 - D160Z10S40 - WOC	0497	160	172	10	63		40	32	107	66.7	-	X
		F45 - ONMU08 - D200Z12S60 - WOC	0498	200	212	12	63		60	40	130	101.6	-	X
		F45 - ONMU08 - D315Z16S60 - WOC	0499	315	327	16	63		60	40	220	101.6	177.8	X

▶ONHU is Available for Wiper Insert

Cutters for SNMX

Cutting Angle : 45°
8 Corner Negative

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

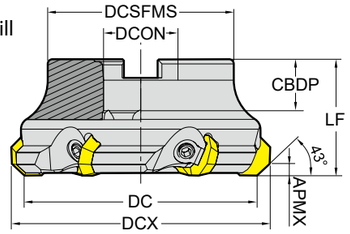
○: p. 109 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SNMX 1206	6.0	F45 - SNMX12 - D50Z4S22	0506	50	63	4	42	Shellmill	22	22	42	-	-	●
		F45 - SNMX12 - D50Z5S22	0507	50	63	5	42		22	22	42	-	-	●
		F45 - SNMX12 - D63Z6S22	0508	63	76	6	42		22	22	48	-	-	●
		F45 - SNMX12 - D63Z7S22	0509	63	76	7	42		22	22	48	-	-	●
		F45 - SNMX12 - D80Z7S27	0510	80	93	7	52		27	25	58	-	-	●
		F45 - SNMX12 - D80Z8S27	0511	80	93	8	52		27	25	58	-	-	●
		F45 - SNMX12 - D100Z10S32	0512	100	113	10	52		32	26	67	-	-	●
		F45 - SNMX12 - D100Z8S32	0513	100	113	8	52		32	26	67	-	-	●
		F45 - SNMX12 - D125Z11S40 - WOC	0514	125	138	11	65		40	32	80	-	-	X
		F45 - SNMX12 - D160Z12S40 - WOC	0515	160	173	12	65		40	32	110	66.7	-	X
		F45 - SNMX12 - D200Z14S60 - WOC	0516	200	213	14	65		60	40	130	101.6	-	X

Cutters for OFER

Cutting Angle : 43˚
8 Corner Positive

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

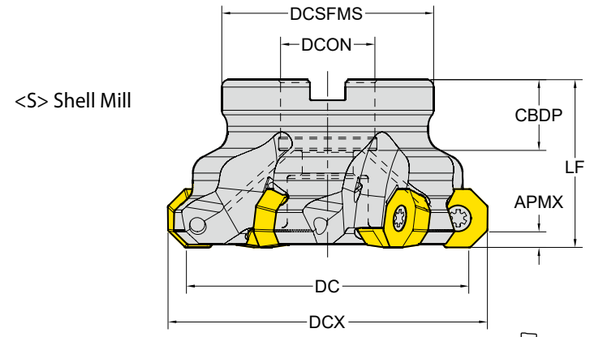
: p. 103 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
OFER 0704	5.0	F43 - OFER07 - D63Z4S22 - WOC	0484	63	75	4	45	Shellmill	22	22	48	-	-	X
		F43 - OFER07 - D80Z5S27 - WOC	0485	80	92	5	50		27	25	58	-	-	X
		F43 - OFER07 - D100Z6S32 - WOC	0486	100	112	6	50		32	26	80	-	-	X
		F43 - OFER07 - D125Z8S40 - WOC	0487	125	137	8	63		40	32	85	-	-	X
		F43 - OFER07 - D160Z9S40 - WOC	0488	160	172	9	63		40	32	110	66.7	-	X

Cutters for ODMT, ODMW, OFMT

Cutting Angle : 43˚
8 Corner Positive

<S> Shell Mill



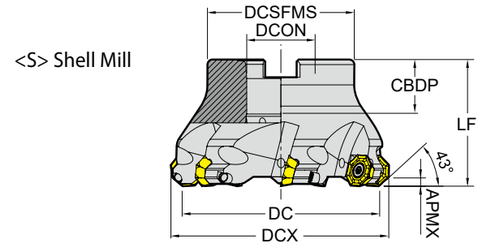
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

: p. 102 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
ODMT ODMW 0605	3.5	F43 - ODMT06 - D63Z5S22	0001	63	73	5	40	Shellmill	22	20	50	-	-	●
		F43 - ODMT06 - D80Z6S27	0002	80	90	6	50		27	23	56	-	-	●
		F43 - ODMT06 - D100Z7S32	0003	100	110	7	50		32	26	78	-	-	●
		F43 - ODMT06 - D125Z8S40	0004	125	135	8	63		40	28	89	-	-	●

Cutting Angle : 43˚
8 Corner Positive

<S> Shell Mill



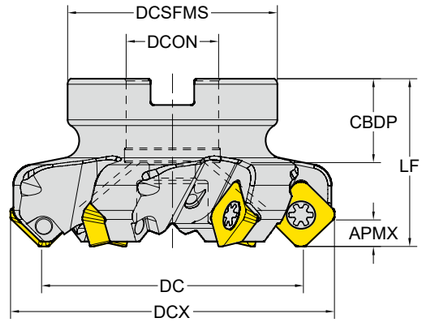
: p. 103 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
OFMT 05T3	3.0	F43 - OFMT05 - D50Z5S22	0489	50	58	5	40	Shellmill	22	22	42	-	-	●
		F43 - OFMT05 - D63Z6S22	0490	63	71	6	40		22	22	48	-	-	●
		F43 - OFMT05 - D80Z7S27	0491	80	88	7	50		27	25	58	-	-	●
		F43 - OFMT05 - D125Z9S40 - WOC	0492	125	133	9	63		40	32	85	-	-	X

Cutters for SEKT

Cutting Angle : 45˚
4 Corner Positive

<S> Shell Mill



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

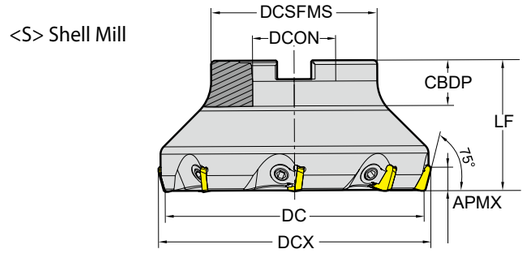
○: p. 107 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SEKT 12T3	6.0	F45 - SE12T3 - D50Z4S22	0500	50	63	4	40	Shellmill	22	22	48	-	-	●
		F45 - SE12T3 - D63Z5S22	0501	63	76	5	40		22	22	48	-	-	●
		F45 - SE12T3 - D80Z6S27	0502	80	93	6	50		27	25	58	-	-	●
		F45 - SE12T3 - D100Z7S32	0503	100	113	7	50		32	26	65	-	-	●
		F45 - SE12T3 - D125Z8S40 - WOC	0504	125	138	8	63		40	32	85	-	-	X
		F45 - SE12T3 - D160Z10S40 - WOC	0505	160	173	10	63		40	32	110	66.7	-	X
SEKT 1204	6.0	F45 - SEKT12 - D40Z4S16	0031	40	54	4	40	Shellmill	16	18	32	-	-	●
		F45 - SEKT12 - D50Z5S22	0032	50	64	5	40		22	20	48	-	-	●
		F45 - SEKT12 - D63Z4S22	0033	63	77	4	40		22	20	50	-	-	●
		F45 - SEKT12 - D63Z6S22	0034	63	77	6	40		22	20	50	-	-	●
		F45 - SEKT12 - D80Z4S27	0035	80	94	4	50		27	22	56	-	-	●
		F45 - SEKT12 - D80Z7S27	0036	80	94	7	50		27	22	56	-	-	●
		F45 - SEKT12 - D100Z8S32	0037	100	114	8	50		32	25	78	-	-	●
		F45 - SEKT12 - D125Z10S40	0038	125	139	10	63		40	29	90	-	-	●
		F45 - SEKT12 - D160Z12S40	0039	160	174	12	63		40	30	114	-	-	X

Cutters for SPKN, SPKR, SPCN

Cutting Angle : 75˚
4 Corner Positive ISO

<S> Shell Mill

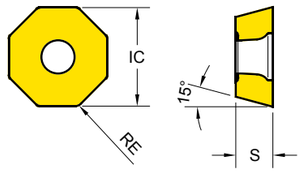


ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○: p. 110 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SPKN SPKR SPCN 1203	8.0	F75 - SPKN12 - D50Z4S22 - WOC	0611	50	56	4	40	Shellmill	22	22	42	-	-	X
		F75 - SPKN12 - D63Z5S22 - WOC	0612	63	69	5	40		22	22	48	-	-	X
		F75 - SPKN12 - D80Z6S27 - WOC	0613	80	86	6	50		27	25	58	-	-	X
		F75 - SPKN12 - D100Z7S32 - WOC	0614	100	106	7	50		32	26	65	-	-	X
		F75 - SPKN12 - D125Z8S40 - WOC	0615	125	131	8	63		40	32	80	-	-	X
		F75 - SPKN12 - D160Z9S40 - WOC	0616	160	166	9	63		40	32	110	66.7	-	X
		F75 - SPKN12 - D200Z12S60 - WOC	0617	200	206	12	63		60	40	130	101.6	-	X

ODMT, ODMW - Face Milling Positive (8 Corners)



Series	IC	S
ODM* 0605	15.9	5.6

EDP 1200..

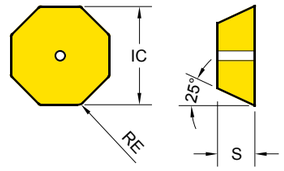
P25	P30	P20
M30		
K30	K30	
S20		

●: Stock item
○: Order made item

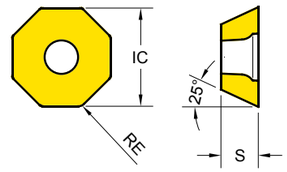
ODMT ODMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
ODMT General	ODMT 060508	0.8	0.21 ~ 0.35		● 0030		
ODMW Hard Materials	ODMW 060508	0.8	0.26 ~ 0.40		● 0031		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

OFER, OFMT - Face Milling Positive (8 Corners)



<OFER>



<OFMT>

Series	IC	S
OFER 0704	18.05	4.78
OFMT 05T3	12.73	4.06

EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

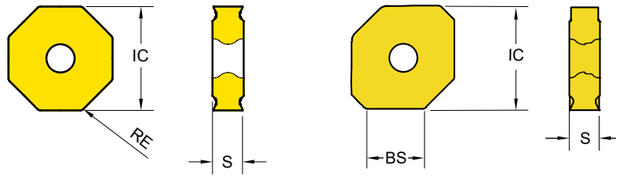
●: Stock item
○: Order made item

OFER	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
OFER General	OFER 070405	0.5	0.22 ~ 0.50		● 0209		

OFMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
OFMT General	OFMT 05T308	0.8	0.15 ~ 0.25		● 0032		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

ONMU / ONHU - Face Milling Negative (16 Corners)



Series	IC	S
ON*U 0806	20.2	5.8

● : Stock item
○ : Order made item

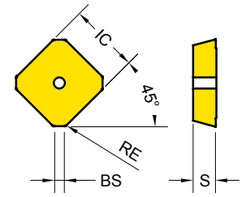
EDP 1200..

P25	P30	P20	
M30			
K30	K30		K15
S20			

ONMU ONHU		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG5020
ONMU General		ONMU 080608	0.8	0.22 ~ 0.50		● 0233			● 0414
ONHU Wiper Insert		ONHU 080612		0.22 ~ 0.50	10.6				● 0482

Cutting Speed			Vc (m/min.)							
ISO	VDI	Sub Group	YG602		YG622		YG712		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-

SDKN / CN - Face Milling Positive (4 Corners ISO)



Series	AS	IC	S
SD** 1203	15°	12.7	3.18
SD** 1504	15°	15.88	4.76

● : Stock item
○ : Order made item

EDP 1200..

P25	P30	P20	
M30			
K30	K30		
S20			

SDKN SDCN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SDKN Hard Materials		SDKN 1203 AETN	0.5	0.22 ~ 0.35	1.85	● 0058		
		SDKN 1504 AETN	0.45	0.22 ~ 0.40	2	● 0059		
		SDKN 1203 AETN - PW	0.4	0.22 ~ 0.35	1.98	● 0253		
		SDKN 1504 AETN - PW	0.4	0.22 ~ 0.40	1.95	● 0288		
		SDKN 1203 AETN - GW	1.3	0.2 ~ 0.4	1.85	● 0251		
		SDKN 1504 AETN - GW	1.3	0.19 ~ 0.38	2.05	● 0286		
SDCN Ground insert		SDCN 1203 AESN - M		0.18 ~ 0.36	2.04			● 0135
		SDCN 1504 AESN - M		0.18 ~ 0.36	2.19			● 0150
		SDCN 1504 AESN - MR	1	0.18 ~ 0.36	2.19			● 0201

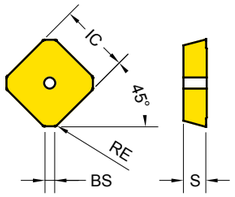
- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602		YG622		YG712	
			Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Milling - Face Milling - Inserts

SEKR / N - Face Milling Positive (4 Corners ISO)

Series	AS	IC	S
SEK* 1203	20°	12.7	3.2



EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

● : Stock item
○ : Order made item

SEKR SEKN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SEKR General		SEKR 1203 AFTN	0.4	0.14 ~ 0.30	1.4	● 0051		
		SEKR 1203 AFTN -PW	0.4	0.14 ~ 0.30	1.4	● 0296		
SEKN Hard Materials		SEKN 1203 AFTN	0.4	0.22 ~ 0.35	1.4	● 0054		
		SEKN 1203 AFTN -PW	0.4	0.22 ~ 0.35	1.4	● 0297		
		SEKN 1203 AFTN -GW	0.4	0.23 ~ 0.35	2	● 0304		

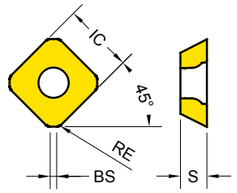
- PW : for Improved Surface Roughness
- GW : Ground Wiper

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602		YG622		YG712	
			Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Milling - Face Milling - Inserts

SEKT - Face Milling Positive (4 Corners)

Series	IC	S
SEKT 1204	12.7	4.9
SEKT 12T3	13.4	4



EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

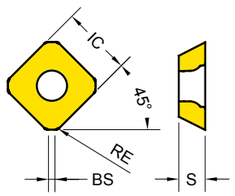
● : Stock item
○ : Order made item

SEKT 1204		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SEKT 1204 General		SEKT 1204 AFTN	1.1	0.20 ~ 0.35	1.18	● 0055		
-ST Stainless Steel Super Alloy		SEKT 1204 - ST	1.1	0.08 ~ 0.30	1.18	● 0257		

SEKT 12T3		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SEKT 12T3 General		SEKT 12T3 AGTN	1.5	0.15 ~ 0.30	1.3	● 0056		
-ST Stainless Steel Super Alloy		SEKT 12T3 - ST	1.5	0.08 ~ 0.30	1.3	● 0271		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602		YG622		YG712	
			Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

SEMT - Face Milling Positive (4 Corners)

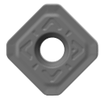


Series	IC	S
SEMT1204	12.92	5.1
SEMT13T3	13.4	4.0

EDP 1200..

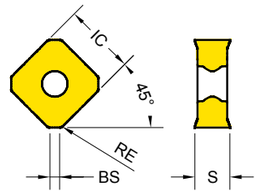
P25	P30	P20
M30		
K30	K30	
S20		

●: Stock item
○: Order made item

SEMT		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SEMT 1204 General		SEMT 1204 AFTN	1.2	0.25 ~ 0.5	1.24	● 0052		
SEMT 13T3 General		SEMT 13T3 AGSN	1.5	0.15 ~ 0.3	1.31	● 0203		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

SNMX - Face Milling Negative (8 Corners)



Series	IC	S
SNMX 1206	12.7	6.25

EDP 1200..

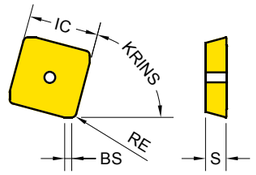
P25	P30	P20
M30		
K30	K30	
S20		

●: Stock item
○: Order made item

SNMX		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SNMX General		SNMX 1206 ANN	0.8	0.16~0.34	1.7	● 0231		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

SPKN / R/ CN - Face Milling Positive (4 Corners ISO)



Series	KRINS	AS	IC	S
SP** 1203	75°	11°	12.7	3.18
SP** 1504	75°	11°	15.88	4.76

● : Stock item
○ : Order made item

EDP 1200..

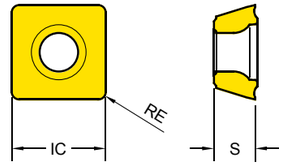
P25	P30	P20
M30		
K30	K30	
S20		

SPKR SPKN SPCN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SPKR General		SPKR 1203 EDTR	0.8	0.15 ~ 0.35	1.4	● 0050		
		SPKR 1203 EDTR -PW	0.8	0.15 ~ 0.35	1.4	● 0298		
SPKN Hard Materials		SPKN 1203 EDTR	0.8	0.16 ~ 0.34	1.4	● 0048		
		SPKN 1504 EDTR		0.15 ~ 0.34	1.3	● 0049		
		SPKN 1203 EDTR - PW	0.8	0.20 ~ 0.35	1.4	● 0279		
		SPKN 1504 EDTR - PW		0.25 ~ 0.40	1.3	● 0299		
		SPKN 1203 EDTR - GW	0.6	0.25 ~ 0.5	1.51	● 0280		
		SPKN 1504 EDTR - GW	0.8	0.25 ~ 0.5	2.2	● 0305		
SPCN Ground insert		SPCN 1203 EDSR - M	0.8	0.2 ~ 0.4	1.82			● 0081
		SPCN 1203 EDSR - MR	0.8	0.2 ~ 0.4	1.77			● 0198
		SPCN 1504 EDSR - M	0.8	0.2 ~ 0.4	1.92			● 0098
		SPCN 1504 EDSR - MR	0.8	0.2 ~ 0.4	1.86			● 0199

- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

SPMT - Universal Positive (4 Corners)



Series	AS	IC	S
SPMT 1204	11°	12.7	4.81

● : Stock item
○ : Order made item

EDP 1200..

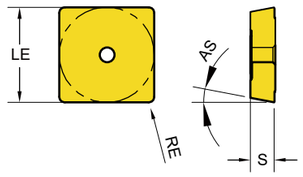
P25	P30	P20
M30		
K30	K30	
S20		

SPMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
SPMT General 	SPMT 120408	0.8	0.15 ~ 0.3		● 0223		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Milling - Face Milling - Inserts

SPUN - Universal Positive (4 Corners ISO)



Series	AS	IC	S
SPUN 1203	11°	12.7	3.2

● : Stock item
○ : Order made item

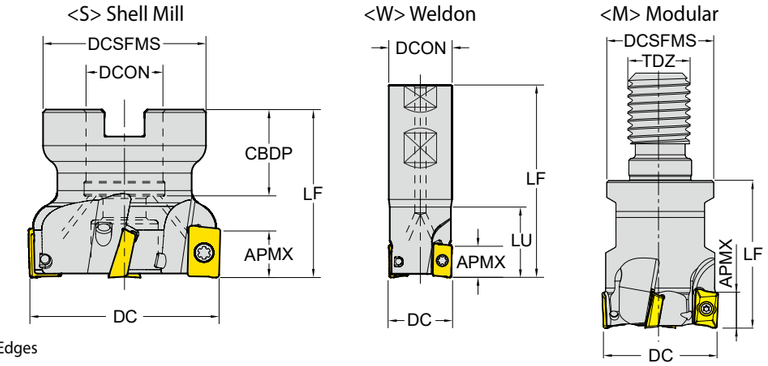
SPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200.. P25 M30 K30 S20 YG602	EDP 1200.. P30 K30 YG622	EDP 1200.. P20 YG712
SPUN General 	SPUN 120308	0.8			● 0224		

TURNING
PARTING & GROOVING
MILLING
DRILLING
TECHNICAL INFORMATION

Milling - Shoulder Milling - Cutter

Cutters for ADKT, AOMT

Cutting Angle : 90°
2 Corner Positive



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○ : p. 121 unit : mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
ADKT 1505	15.0	E90 - ADKT15 - D25Z2W25 - L150 - WOC	0517	25	2	50	150	Weldon	25	-	-	-	-	X
		E90 - ADKT15 - D30Z3W25 - L150 - WOC	0518	30	3	40	150		25	-	-	-	-	X
		E90 - ADKT15 - D32Z3W32 - L150 - WOC	0519	32	3	50	150		32	-	-	-	-	X
		F90 - ADKT15 - D40Z4S16	0520	40	4	-	40	Shellmill	16	20	36	-	-	●
		F90 - ADKT15 - D50Z5S22	0521	50	5	-	40		22	22	42	-	-	●
		F90 - ADKT15 - D63Z6S22	0522	63	6	-	40		22	22	48	-	-	●
		F90 - ADKT15 - D80Z7S27	0523	80	7	-	50		27	25	58	-	-	●
		F90 - ADKT15 - D100Z8S32	0524	100	8	-	50		32	26	65	-	-	●
		F90 - ADKT15 - D125Z9S40 - WOC	0525	125	9	-	63		40	32	80	-	-	X

○ : p. 121 unit : mm

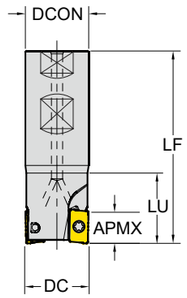
Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	PCD1	PCD2	
AOMT 1236	12.0	E90 - AOMT12 - D16Z2W16 - L150 - WOC	0526	16	2	50	150	Weldon	16	-	-	-	-	X
	12.0	E90 - AOMT12 - D25Z3W25 - L150 - WOC	0527	25	3	50	150		25	-	-	-	-	X
	12.0	E90 - AOMT12 - D32Z4W32 - L150 - WOC	0528	32	4	50	150		32	-	-	-	-	X
	12.0	F90 - AOMT12 - D50Z5S22	0529	50	5	-	40	Shellmill	22	22	42	-	-	●
	12.0	M90 - AOMT12 - D16Z2M08 - WOC	0530	16	2	-	30	Modular	M08	-	14.8	-	-	X
	12.0	M90 - AOMT12 - D20Z3M10 - WOC	0531	20	3	-	35		M10	-	18	-	-	X

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Cutters for APKT

Cutting Angle : 90°
2 Corner Positive

<W> Weldon



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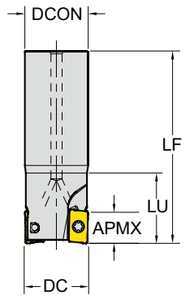

ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○: p. 122 unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APKT 1003	10.0	E90 - APKT10 - D16Z2C16 - L100	0083	16	2	-	100	Cylindrical	16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L120	0532	16	2	30	120		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L150	0154	16	2	50	150		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L200	0533	16	2	100	200		16	-	-	-	-	●
		E90 - APKT10 - D20Z2C20 - L250	0534	20	2	150	250		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L100	0535	20	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L120	0085	20	3	-	120		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L150	0536	20	3	50	150		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L200	0270	20	3	100	200		20	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L100	0537	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L120	0186	25	3	30	120		25	-	-	-	-	●
		E90 - APKT10 - D30Z4C25 - L100	0122	30	4	30	100		25	-	-	-	-	●
		E90 - APKT10 - D30Z4C25 - L120	0086	30	4	30	120		25	-	-	-	-	●
		E90 - APKT10 - D32Z4C25 - L100	0538	32	4	35	100		25	-	-	-	-	●
		E90 - APKT10 - D32Z4C25 - L150 - WOC	0539	32	4	35	150		25	-	-	-	-	X
		E90 - APKT10 - D12Z1W16 - L100	0540	12	1	30	100	Weldon	16	-	-	-	-	●
		E90 - APKT10 - D14Z1W16 - L100	0541	14	1	30	100		16	-	-	-	-	●
		E90 - APKT10 - D16Z2W16 - L100	0542	16	2	30	100		16	-	-	-	-	●
		E90 - APKT10 - D16Z2W16 - L85	0082	16	2	-	85		16	-	-	-	-	●
		E90 - APKT10 - D18Z2W16 - L100	0543	18	2	30	100		16	-	-	-	-	●

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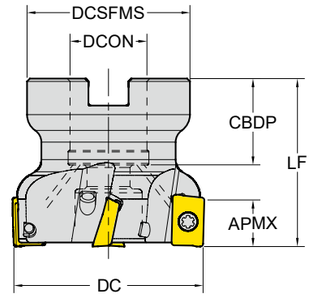
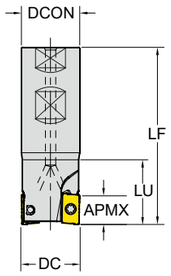
Cutters for APKT

Cutting Angle : 90°
2 Corner Positive

<S> Shell Mill



<W> Weldon



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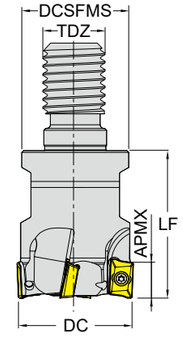


ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

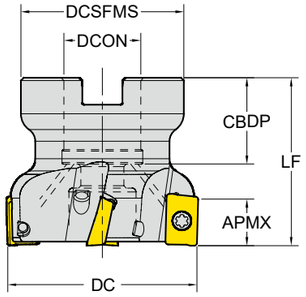
○: p. 122 unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	PCD1	PCD2	
APKT 1003	10.0	E90 - APKT10 - D20Z3W20 - L100	0461	20	3	30	100	Weldon	20	-	-	-	-	●
		E90 - APKT10 - D20Z3W20 - L90	0084	20	3	-	90		20	-	-	-	-	●
		E90 - APKT10 - D22Z3W20 - L100	0544	22	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D25Z3W25 - L100	0545	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z4W25 - L100	0546	25	4	30	100		25	-	-	-	-	●
		E90 - APKT10 - D32Z4W32 - L150 - WOC	0547	32	4	50	150		32	-	-	-	-	X
		F90 - APKT10 - D40Z4S16	0087	40	4	-	40	Shellmill	16	18	34	-	-	●
		F90 - APKT10 - D40Z5S16	0472	40	5	-	40		16	20	36	-	-	●
		F90 - APKT10 - D50Z6S22	0215	50	6	-	40		22	22	42	-	-	●
		F90 - APKT10 - D50Z7S22	0088	50	7	-	40		22	20	42	-	-	●
		F90 - APKT10 - D63Z7S22	0548	63	7	-	40		22	22	48	-	-	●
		F90 - APKT10 - D80Z8S27	0549	80	8	-	50		27	25	58	-	-	●
		F90 - APKT10 - D100Z9S32	0550	100	9	-	50		32	26	65	-	-	●
		M90 - APKT10 - D16Z2M08	0551	16	2	-	30	Modular	M08	-	14.75	-	-	●
		M90 - APKT10 - D20Z3M10	0552	20	3	-	30		M10	-	18	-	-	●
		M90 - APKT10 - D25Z3M12	0553	25	3	-	35		M12	-	21	-	-	●
		M90 - APKT10 - D32Z4M16	0554	32	4	-	35		M16	-	29	-	-	●
		M90 - APKT10 - D40Z5M16	0555	40	5	-	43		M16	-	29	-	-	●
		M90 - APKT10 - D42Z5M16	0556	42	5	-	43		M16	-	29	-	-	●

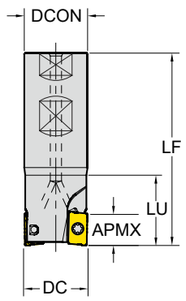
Cutters for APKT

Cutting Angle : 90°
2 Corner Positive

<S> Shell Mill



<W> Weldon



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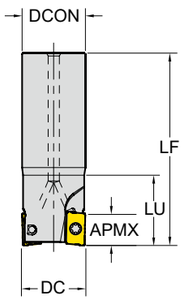


ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○ : p. 122 unit:mm

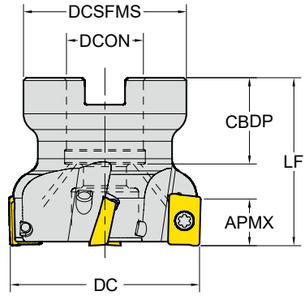
Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APKT 1604	16.0	E90 - APKT16 - D25Z2C20 - L100	0091	25	2	-	100	Cylindrical	20	-	-	-	-	●
		E90 - APKT16 - D25Z2C20 - L100 - WOC	0243	25	2	35	100		20	-	-	-	-	X
		E90 - APKT16 - D25Z2C25 - L250 - WOC	0557	25	2	100	250		25	-	-	-	-	X
		E90 - APKT16 - D32Z2C32 - L250 - WOC	0558	32	2	100	250		32	-	-	-	-	X
		E90 - APKT16 - D32Z3C25 - L110	0094	32	3	-	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3C25 - L200	0559	32	3	40	200		25	-	-	-	-	●
		E90 - APKT16 - D32Z3C32 - L150 - WOC	0250	32	3	50	150		32	-	-	-	-	X
		E90 - APKT16 - D32Z3C32 - L250 - WOC	0560	32	3	100	250		32	-	-	-	-	X
		E90 - APKT16 - D40Z4C32 - L150 - WOC	0561	40	4	40	150		32	-	-	-	-	X
		E90 - APKT16 - D25Z2W25 - L100	0562	25	2	35	100	Weldon	25	-	-	-	-	●
		E90 - APKT16 - D25Z2W25 - L110	0092	25	2	-	110		25	-	-	-	-	●
		E90 - APKT16 - D28Z3W25 - L100	0563	28	3	40	100		25	-	-	-	-	●
		E90 - APKT16 - D30Z3W25 - L110	0564	30	3	40	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3W25 - L110	0093	32	3	-	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3W32 - L110	0565	32	3	40	110		32	-	-	-	-	●
		E90 - APKT16 - D36Z3W32 - L110	0566	36	3	40	110		32	-	-	-	-	●
		F90 - APKT16 - D40Z4S16	0275	40	4	-	40	Shellmill	16	20	36	-	-	●
		F90 - APKT16 - D50Z5S22	0095	50	5	-	40		22	20	45	-	-	●

▶ NEXT PAGE

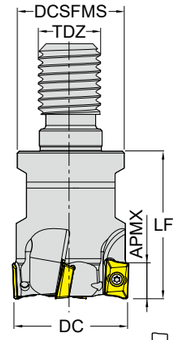
Cutters for APKT

Cutting Angle : 90°
2 Corner Positive

<S> Shell Mill



<M> Modular



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

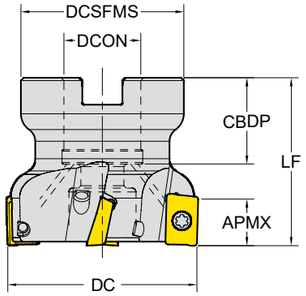
○ : p. 122 unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	PCD1	PCD2	
APKT 1604	16.0	F90 - APKT16 - D52Z5S22	0567	52	5	-	40	Shellmill	22	22	42	-	-	●
		F90 - APKT16 - D63Z6S22	0096	63	6	-	40		22	20	50	-	-	●
		F90 - APKT16 - D80Z7S27	0097	80	7	-	50		27	23	56	-	-	●
		F90 - APKT16 - D100Z8S32	0181	100	8	-	50		32	26	65	-	-	●
		F90 - APKT16 - D125Z9S40 - WOC	0238	125	9	-	63		40	32	80	-	-	X
		F90 - APKT16 - D160Z10S40 - WOC	0568	160	10	-	63		40	32	110	66.7	-	X
		F90 - APKT16 - D200Z12S60 - WOC	0569	200	12	-	63		60	40	130	101.6	-	X
		M90 - APKT16 - D25Z2M12	0570	25	2	-	43	Modular	M12	-	21	-	-	●
		M90 - APKT16 - D32Z3M16	0571	32	3	-	43		M16	-	29	-	-	●
		M90 - APKT16 - D42Z4M16	0572	42	4	-	43		M16	-	29	-	-	●

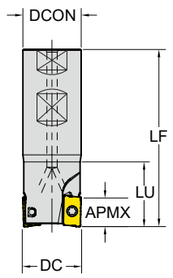
Cutters for APMT

Cutting Angle : 90°
2 Corner Positive

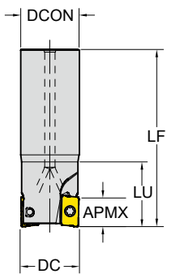
<S> Shell Mill



<W> Weldon



<C> Cyindrical



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

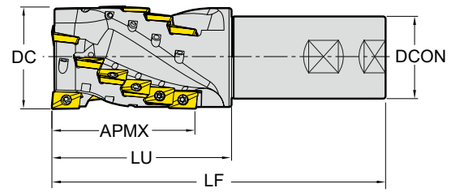
○: p. 123 unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APMT 1135	10.0	E90 - APMT11 - D16Z2C16 - L120	0102	16	2	-	120	Cylindrical	16	-	-	-	-	●
		E90 - APMT11 - D20Z2C20 - L120	0103	20	2	-	120		20	-	-	-	-	●
		E90 - APMT11 - D25Z4C25 - L150	0104	25	4	-	150		25	-	-	-	-	●
		E90 - APMT11 - D32Z4W25 - L110	0105	32	4	-	110	Weldon	25	-	-	-	-	●
APMT 1604	16.0	E90 - APMT16 - D25Z2C25 - L120	0107	25	2	-	120	Cylindrical	25	-	-	-	-	●
		E90 - APMT16 - D32Z3W32 - L110	0108	32	3	-	110	Weldon	32	-	-	-	-	●
		F90 - APMT16 - D50Z5S22	0109	50	5	-	40	Shellmill	22	20	42	-	-	●
		F90 - APMT16 - D63Z6S22	0110	63	6	-	40		22	20	50	-	-	●
		F90 - APMT16 - D80Z7S27	0111	80	7	-	50		27	23	56	-	-	●

Cutters for APKT

Cutting Angle : 90°
2 Corner Positive

<W> Weldon



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts

○: p. 122 unit:mm

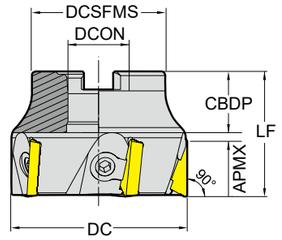
Series	APMX	Designation	EDP 1700..	DC	ZEFP	CICT *	LU	LF	TYPE	DCON	
APKT 1003	37.0	E90 - APKT10 - D25AP37Z208W25 - L105	0573	25	2	8	50	105	Weldon	25	●
	46.0	E90 - APKT10 - D32AP46Z315W32 - L115	0574	32	3	15	55	115		32	●
	55.0	E90 - APKT10 - D40AP55Z318W32 - L130	0575	40	3	18	70	130		32	●

*** : No. of inserts**

Cutters for TPKN, TPKR, TPCN

Cutting Angle : 90°
3 Corner Positive ISO

<S> Shell Mill

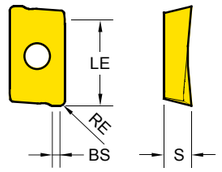


ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

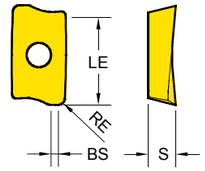
: p. 124 unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
TPKN TPKR TPCN 1603	12.0	F90 - TPKN16 - D50Z4S22 - WOC	0618	50	4	-	40	Shellmill	22	22	42	-	-	X
		F90 - TPKN16 - D63Z6S22 - WOC	0619	63	6	-	45		22	22	48	-	-	X
		F90 - TPKN16 - D80Z7S27 - WOC	0620	80	7	-	50		27	25	58	-	-	X
		F90 - TPKN16 - D125Z8S40 - WOC	0621	125	8	-	63		40	32	80	-	-	X
TPKN TPKR TPCN 2204	18.0	F90 - TPKN22 - D63Z5S22 - WOC	0622	63	5	-	45	Shellmill	22	22	48	-	-	X
		F90 - TPKN22 - D80Z6S27 - WOC	0623	80	6	-	50		27	25	58	-	-	X
		F90 - TPKN22 - D100Z7S32 - WOC	0624	100	7	-	50		32	26	65	-	-	X
		F90 - TPKN22 - D125Z8S40 - WOC	0625	125	8	-	63		40	32	80	-	-	X
		F90 - TPKN22 - D160Z9S40 - WOC	0626	160	9	-	63		40	32	110	66.7	-	X
		F90 - TPKN22 - D200Z12S60 - WOC	0627	200	12	-	63		60	40	130	101.6	-	X
		F90 - TPKN22 - D250Z15S60 - WOC	0628	250	15	-	63		60	40	160	101.6	-	X
		F90 - TPKN22 - D315Z18S60 - WOC	0629	315	18	-	63		60	40	220	101.6	177.8	X

ADKT / AOMT - Shoulder Milling Positive (2 Corner)



<ADKT>



<AOMT>

Series	LE	IC	S
ADKT 1505	13.7	9.7	5.8
AOMT 1236	10.5	6.6	3.6

EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

●: Stock item
○: Order made item

ADKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
ADKT General	ADKT 150508 PDTR	0.8	0.16 ~ 0.30	1.87	● 0220		

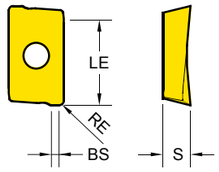


AOMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
AOMT General	AOMT 123604 PDTR	0.4	0.08 ~ 0.22	1.07	● 0217		
	AOMT 123608 PDTR	0.8	0.08 ~ 0.24	0.91	● 0218		



Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

APKT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APKT 1003	9.9	6.7	3.6
APKT 1604	15.2	9.4	5.3

● : Stock item
○ : Order made item

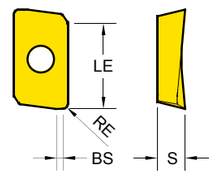
EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

APKT		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
APKT General		APKT 100305 PDTR	0.5	0.15 ~ 0.24	0.86	● 0005		
		APKT 100308 PDTR	0.8	0.15 ~ 0.24	0.9	● 0004		
		APKT 160404 PDTR	0.4	0.15 ~ 0.25	1.11	● 0003		
		APKT 160408 PDTR	0.8	0.15 ~ 0.30	1.32	● 0001		
		APKT 160412 PDTR	1.2	0.15 ~ 0.32	1.13	● 0002		
		APKT 160416 PDTR	1.6	0.15 ~ 0.34	1.13	● 0006		
		APKT 160424 PDTR	2.4	0.15 ~ 0.28		● 0255		
-ST Stainless Steel Super Alloy		APKT 100305 - ST	0.5	0.08 ~ 0.22	0.86	● 0278		
		APKT 160408 - ST	0.8	0.08 ~ 0.25	1.32	● 0270		
-TR Hardened Steel		APKT 160404 - TR	0.4	0.26 ~ 0.40	2.12	● 0492		
		APKT 160408 - TR	0.8	0.26 ~ 0.40	1.32	● 0256	● 0337	
		APKT 160412 - TR	1.2	0.26 ~ 0.40	2.4	● 0493		
		APKT 160416 - TR	1.6	0.26 ~ 0.40	2.4	● 0472		
		APKT 160424 - TR	2.4	0.26 ~ 0.40	1.5	● 0494		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

APMT - Shoulder Milling Positive (2 Corner)



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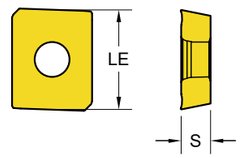


<APMT 1504>

Series	LE	IC	S
APMT 1135	9.5	6.2	3.5
APMT 1604	14.6	9.2	4.76
APMT 1504	14	12.7	4.76

● : Stock item
○ : Order made item

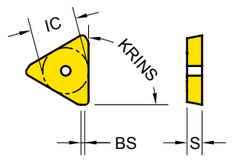
EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

APMT		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
APMT General		APMT 113504 PDTR	0.4	0.15 ~ 0.22	1.26	● 0009		
		APMT 113508 PDTR	0.8	0.15 ~ 0.25	1.07	● 0010		
		APMT 160408 PDTR	0.8	0.16 ~ 0.30	1.11	● 0008		● 0423
APMT 1504 General		APMT 1504		0.14 ~ 0.28		● 0276	● 0445	

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

TPKN / KR / CN - Shoulder Milling Positive (3 Corner ISO)



Series	KRINS	IC	S
TP** 1603	90°	9.53	3.18
TP** 2204	90°	12.7	4.76

EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

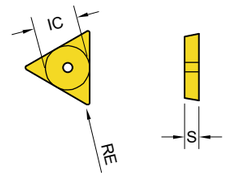
●: Stock item
○: Order made item

TPKR TPKN TPCN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
TPKR General		TPKR 1603 PDTR		0.15 ~ 0.28	1.2	● 0060		
		TPKR 1603 PDTR -PW		0.15 ~ 0.28	1.2	● 0300		
		TPKR 2204 PDTR		0.18 ~ 0.35	1.7	● 0061		
		TPKR 2204 PDTR -PW		0.18 ~ 0.35	1.7	● 0301		
TPKN Hard Materials		TPKN 1603 PDTR		0.15 ~ 0.30	1.2	● 0062		
		TPKN 2204 PDTR		0.17 ~ 0.30	1.7	● 0063		
		TPKN 1603 PDTR -PW		0.20 ~ 0.35	1.2	● 0302		
		TPKN 2204 PDTR -PW		0.24 ~ 0.40	1.7	● 0303		
		TPKN 1603 PDTR-GW		0.15 ~ 0.3	1.62	● 0306		
		TPKN 2204 PDTR-GW		0.24 ~ 0.4	2.49	● 0307		
TPCN Ground insert		TPCN 2204 PDSR -M		0.2 ~ 0.4	1.76			● 0180
		TPCN 2204 PDSR -MR		0.2 ~ 0.4	1.76			● 0202

- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

TPUN- Universal Positive (3 Corners ISO)



Series	IC	S
TPUN 1603	9.53	3.18

EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

●: Stock item
○: Order made item

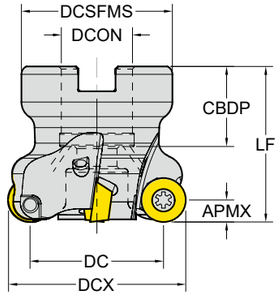
TPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
TPUN 	TPUN 160308	0.8	0.08 ~ 0.15		● 0064		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

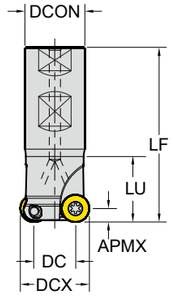
Cutters for RDKT, RDKW

Round Positive

<S> Shell Mill



<W> Weldon



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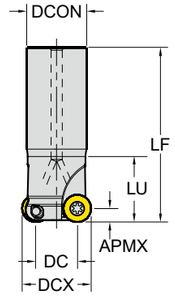
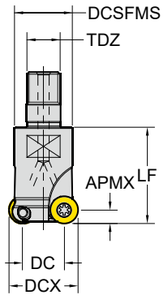


<M> Modular



ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

○: p. 129 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
RDKT RDKW 0802	4.0	E - RDKT08 - D16Z2C16 - L160	0005	8	16	2	-	160	Cylindrical	16	-	-	●
		E - RDKT08 - D20Z2C20 - L180	0007	12	20	2	-	180		20	-	-	●
		E - RDKT08 - D25Z3C20 - L180	0009	17	25	3	-	180		20	-	-	●
		M - RDKT08 - D16Z2M08	0010	8	16	2	-	23	Modular	M08	-	13	●
		M - RDKT08 - D20Z2M10	0011	12	20	2	-	30		M10	-	18	●
		M - RDKT08 - D25Z3M12	0012	17	25	3	-	35		M12	-	21	●
RDKT RDKW 10T3	5.0	E - RDKT10 - D20Z2C20 - L150 - WOC	0576	10	20	2	60	150	Cylindrical	20	-	-	X
		E - RDKT10 - D20Z2C20 - L180	0013	10	20	2	-	180		20	-	-	●
		E - RDKT10 - D25Z2C25 - L150 - WOC	0299	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D25Z2C25 - L180	0015	15	25	2	-	180		25	-	-	●
		E - RDKT10 - D20Z2W20 - L150 - WOC	0577	10	20	2	60	150	Weldon	20	-	-	X
		E - RDKT10 - D25Z2W25 - L150 - WOC	0578	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D32Z3W32 - L150 - WOC	0579	22	32	3	60	150		32	-	-	X
		F - RDKT10 - D40Z5S16	0019	30	40	5	-	40	Shellmill	16	18	34	●
		F - RDKT10 - D50Z5S22	0580	40	50	5	-	50		22	22	42	●
		F - RDKT10 - D50Z6S22	0020	40	50	6	-	50		22	22	42	●
		F - RDKT10 - D63Z6S22	0581	53	63	6	-	50		22	22	48	●
		M - RDKT10 - D20Z2M10	0017	10	20	2	-	30	Modular	M10	-	18	●
		M - RDKT10 - D25Z3M12	0018	15	25	3	-	35		M12	-	21	●

Cutters for RDKT, RDKW

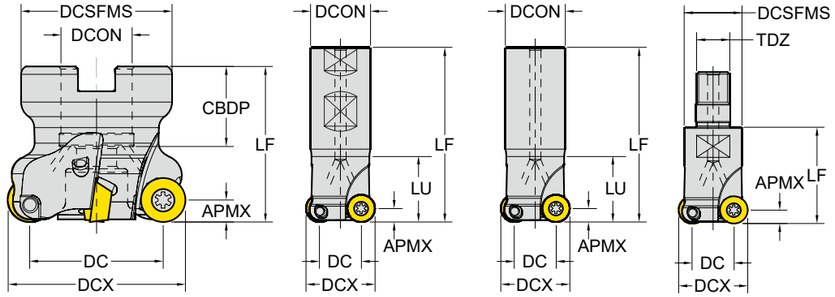
Round Positive

<S> Shell Mill

<W> Weldon

<C> Cyindrical

<M> Modular



ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

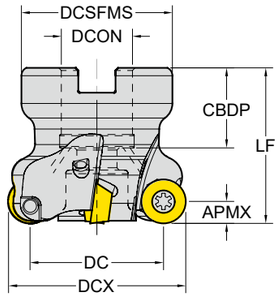
○: p. 129 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
RDKT RDKW 1204	6.0	E - RDKT12 - D25Z2C25 - L180	0021	13	25	2	-	180	Cylindrical	25	-	-	●
		E - RDKT12 - D32Z2C32 - L200	0023	20	32	2	-	200		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160	0024	20	32	3	-	160		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160 - WOC	0582	20	32	3	70	160		32	-	-	X
		E - RDKT12 - D33Z3C32 - L160 - WOC	0583	21	33	3	70	160		32	-	-	X
		E - RDKT12 - D32Z3W32 - L160 - WOC	0584	20	32	3	50	160	Weldon	32	-	-	X
		F - RDKT12 - D40Z4S16	0028	28	40	4	-	40	Shellmill	16	18	34	●
		F - RDKT12 - D50Z5S22	0029	38	50	5	-	50		22	22	42	●
		F - RDKT12 - D52Z5S22	0585	40	52	5	-	50		22	22	42	●
		F - RDKT12 - D63Z6S22	0030	51	63	6	-	50		22	20	48	●
		F - RDKT12 - D80Z7S27	0586	68	80	7	-	50		27	25	58	●
		F - RDKT12 - D100Z7S32	0587	88	100	7	-	50		32	26	65	●
		F - RDKT12 - D100Z8S32	0588	88	100	8	-	50		32	26	65	●
		M - RDKT12 - D25Z2M12	0026	13	25	2	-	35	Modular	M12	-	21	●
		M - RDKT12 - D32Z3M16	0027	20	32	3	-	42		M16	-	29	●
		M - RDKT12 - D42Z4M16	0589	30	42	4	-	43		M16	-	29	●

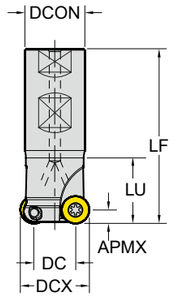
Cutters for RPMT, RPMW

Round Positive

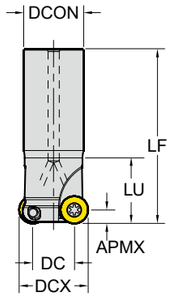
<S> Shell Mill



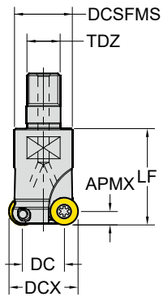
<W> Weldon



<C> Cyindrical



<M> Modular

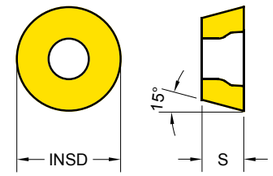


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

○: p. 131 unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
RPMT RPMW 08T2	4.0	E - RPMT08 - D20Z2W20 - L150	0590	12	20	2	60	150	Weldon	20	-	-	●
		E - RPMT08 - D25Z3W25 - L200	0591	17	25	3	100	200		25	-	-	●
		M - RPMT08 - D20Z2M10	0592	12	20	2	-	30	Modular	M10	-	18	●
RPMT RPMW 10T3	5.0	E - RPMT10 - D25Z2W25 - L200	0593	15	25	2	100	200	Weldon	25	-	-	●
		M - RPMT10 - D25Z2M12	0594	15	25	2	-	35	Modular	M12	-	21	●
		M - RPMT10 - D32Z3M16	0595	22	32	3	-	43		M16	-	29	●
RPMT RPMW 1204	6.0	E - RPMT12 - D32Z3W32 - L150	0596	20	32	3	60	150	Weldon	32	-	-	●
		E - RPMT12 - D32Z3W32 - L200	0597	20	32	3	100	200		32	-	-	●
		F - RPMT12 - D50Z4S22	0598	38	50	4	-	50	Shellmill	22	22	42	●
		F - RPMT12 - D52Z5S22	0599	40	52	5	-	50		22	22	42	●
		F - RPMT12 - D63Z5S22	0600	51	63	5	-	50		22	22	48	●
		F - RPMT12 - D80Z6S27	0601	68	80	6	-	50		27	25	58	●
		M - RPMT12 - D32Z3M16	0602	20	32	3	-	43	Modular	M16	-	29	●
		M - RPMT12 - D40Z4M16	0603	28	40	4	-	43		M16	-	29	●

RDKT / W- Profiling Positive (Round)



Series	INSD	S
RDK* 0501	5	1.4
RDK* 0702	7	2.4
RDK* 0802	8	2.4
RDK* 10T3	10	4.0
RDK* 1204	12	4.8

EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

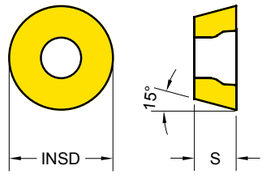
●: Stock item
○: Order made item

RDKT RDKW		Designation	Fz (mm/tooth)	YG602	YG622	YG712
RDKT General		RDKT 0802M0	0.15 ~ 0.25	● 0035		
		RDKT 10T3M0	0.15 ~ 0.28	● 0041		
		RDKT 1204M0	0.20 ~ 0.30	● 0034		
-ST Stainless Steel Super Alloy		RDKT 0802M0 - ST	0.08 ~ 0.25	● 0292		
		RDKT 10T3M0 - ST	0.08 ~ 0.28	● 0293		
		RDKT 1204M0 - ST	0.10 ~ 0.30	● 0294		
-TR Hardened Steel		RDKT 0802M0 - TR	0.18 ~ 0.35	● 0284	● 0339	
		RDKT 10T3M0 - TR	0.22 ~ 0.40	● 0285	● 0338	
		RDKT 1204M0 - TR	0.22 ~ 0.40	● 0272	● 0340	
RDKW Hard Materials		RDKW 0501M0	0.10 ~ 0.20	● 0207		
		RDKW 0702M0	0.12 ~ 0.25	● 0208		
		RDKW 0802M0	0.13 ~ 0.25	● 0043		
		RDKW 10T3M0	0.16 ~ 0.30	● 0040		
		RDKW 1204M0	0.16 ~ 0.35	● 0042		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Milling - Profiling - Inserts

RDMT / W- Profiling Positive (Round)



Series	INSD	S
RDM* 0802	8	2.38
RDM* 0803	8	3.18
RDM* 10T3	10	3.97
RDM* 1204	12	4.76

● : Stock item
○ : Order made item

EDP 1200..

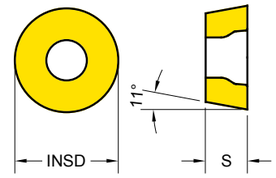
P25	P30	P20
M30		
K30	K30	
S20		

RDMT RDMW		Designation	Fz (mm/tooth)	YG602	YG622	YG712
RDMT General		RDMT 0802M0	0.15 ~ 0.25	● 0245		
		RDMT 0803M0	0.15 ~ 0.25	● 0225		
		RDMT 10T3M0	0.18 ~ 0.28	● 0246		
		RDMT 1204M0	0.2 ~ 0.3	● 0226		
RDMW Hard Materials		RDMW 0802M0	0.05 ~ 0.15	● 0227		
		RDMW 10T3M0	0.1 ~ 0.25	● 0228		
		RDMW 1204M0	0.16 ~ 0.3	● 0229		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Milling - Profiling - Inserts

RPMT / W - Profiling Positive (Round)



Series	INSD	S
RPM* 08T2	8	2.78
RPM* 10T3	10	3.97
RPM* 1204	12	4.76

● : Stock item
○ : Order made item

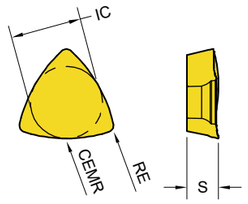
EDP 1200..

P25	P30	P20
M30		
K30	K30	
S20		

RPMT RPMW		Designation	Fz (mm/tooth)	YG602	YG622	YG712
RPMT General		RPMT 08T2M0	0.10 ~ 0.24	● 0038		
		RPMT 10T3M0	0.16 ~ 0.30	● 0036		
		RPMT 1204M0	0.20 ~ 0.35	● 0037		● 0415
-ST Stainless Steel Super Alloy		RPMT 1204M0 - ST	0.10 ~ 0.30	● 0230		
RPMW Hard Materials		RPMW 1003M0	0.16 ~ 0.30	● 0204		
		RPMW 1204M0	0.16 ~ 0.35	● 0039		

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

RBEX50 - Profiling / Highfeed (3 Corner)



Series	CEMR	IC	S
RBEX50	25	12.7	5.55

● : Stock item
○ : Order made item

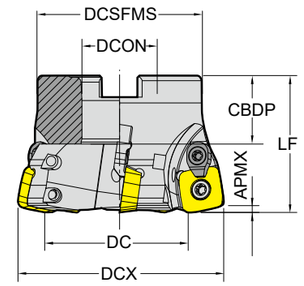
RBEX50	Designation	RE (mm)	EDP 1200.. P25 M30 P30 K30 P20 K20 S20 YG602	YG622	YG712
RBEX50 General 	RBEX 50	1.2	● 0277	● 0443	

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
P	6~9	Low-Alloyed Steel	120	300	120	320	180	250
P	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
M	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
K	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

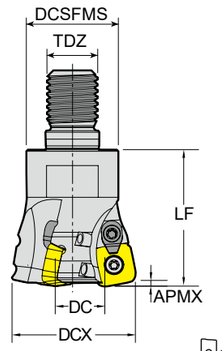
Cutters for SDMT, SDMW

Cutting Angle : 10°
4 Corner Positive

<S> Shell Mill



<M> Modular

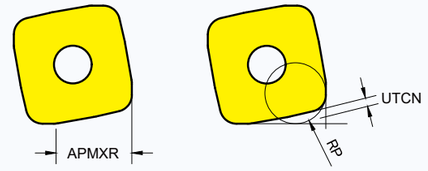


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

○ : p. 134 unit : mm

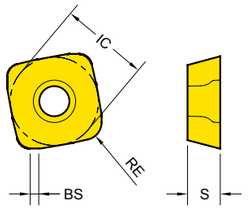
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
SDMT SDMW 1204	1.8	FHF - SDMW12 - D50Z4S22	0604	32.4	50	4	40	Shellmill	22	22	42	●
		FHF - SDMW12 - D63Z5S22	0605	45.4	63	5	40		22	22	48	●
		FHF - SDMW12 - D80Z6S27	0606	62.4	80	6	50		27	25	58	●
		FHF - SDMW12 - D100Z8S32	0607	82.4	100	8	50		32	26	65	●
		MHF - SDMW12 - D32Z2M16	0608	14.4	32	2	43	Modular	M16	-	29	●
		MHF - SDMW12 - D40Z3M16	0609	22.4	40	3	43		M16	-	29	●

Technical Information



APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness
8.6	R3.5	0.94

SDMT / W - High Feed Positive (4 Corners)



Series	IC	S
SDM* 1204	12.7	4.7

● : Stock item
○ : Order made item

EDP 1200..	P25	P30	P20
	M30		
	K30	K30	
	S20		

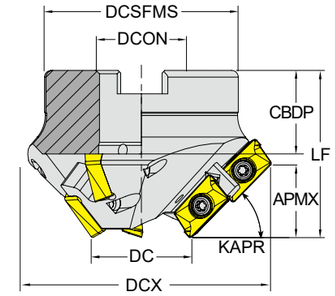
SDMT SDMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712
-ST Stainless Steel Super Alloy 	SDMT 120420 -ST	1.9	0.60 ~ 1.20	1.45	● 0274		
SDMW Hard Materials 	SDMW 120420	1.9	0.60 ~ 1.40	1.4	● 0273	● 0341	

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Cutters for APKT

2 Corner Positive

<S> Shell Mill



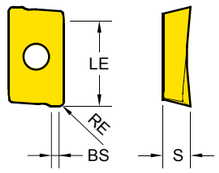
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

○ : p. 136 unit : mm

Series	KAPR	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	CICT	LF	TYPE	DCON	CBDP	DCSFMS	
APKT 1604	15	8.0	F15 - APKT16 - D35AP8Z306S27	0630	35	93	3	6	50	Shellmill	27	25	58	●
	45	21.5	F45 - APKT16 - D35AP21Z306S27	0631	35	77	3	6	50		27	25	58	●
	60	26.5	F60 - APKT16 - D35AP26Z306S22	0632	35	65	3	6	50		22	22	48	●
	75	29.5	F75 - APKT16 - D35AP29Z306S22	0633	35	50	3	6	50		22	22	42	●

APKT - Taper Milling Positive (2 Corner)

Series	LE	IC	S
APKT 1604	15.2	9.4	5.3

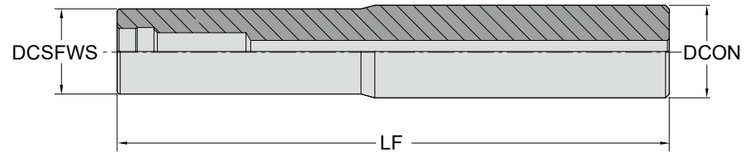


● : Stock item
○ : Order made item

APKT		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200.. P25 M30 K30 S20 YG602	EDP 1200.. P30 K30 YG622	EDP 1200.. P20 YG712
APKT General		APKT 160408 PDTR	0.8	0.15 ~ 0.30	1.32	● 0001		
-ST Stainless Steel Super Alloy		APKT 160408 - ST	0.8	0.08 ~ 0.25	1.32	● 0270		
-TR Hardened Steel		APKT 160408 - TR	0.8	0.26 ~ 0.40	1.32	● 0256	● 0337	

Cutting Speed			Vc (m/min.)					
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300
	6~9	Low-Alloyed Steel	120	300	120	320	180	250
	10~11	High-Alloyed Steel	70	150	70	170	100	140
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-

Modular Shanks



unit : mm

Series	Designation	EDP 1700..	DCSFWS	LF	TYPE	DCON	
M08	EM - M08 - D16ZC16 - L100	0634	16	100	Cylindrical	16	●
	EM - M08 - D16ZC16 - L130	0635	16	130		16	●
M10	EM - M10 - D20ZC20 - L130	0636	20	130	Cylindrical	20	●
M12	EM - M12 - D25ZC25 - L150	0637	25	150	Cylindrical	25	●
	EM - M12 - D25ZC25 - L200	0638	25	200		25	●
	EM - M12 - D25ZC25 - L250	0639	25	250		25	●
M16	EM - M16 - D32ZC32 - L150	0640	32	150	Cylindrical	32	●
	EM - M16 - D32ZC32 - L200	0641	32	200		32	●
	EM - M16 - D32ZC32 - L250	0642	32	250		32	●
	EM - M16 - D32ZC32 - L300	0643	32	300		32	●