





## HOLDER OPTIONS

Description		Application	Series	Sizes D	Approach Angle	Page
APKT FACE MILL			APKT-F	40-160	90°	474
APKT END MILL			APKT-E	12-40	90°	475

## RECOMMENDED CUTTING CONDITIONS

### 1003 SERIES INSERTS

ISO	WORKPIECE		CUTTING CONDITIONS								
	Material	Hardness HB	Feed (mm/tooth)			Vc (mm/min.)			Depth of Cut (mm)		
			Min.	Max.	Ideal	Min.	Max.	Ideal	Min.	Max.	Ideal
STEEL	Non Alloys	120	0.13	0.26	0.2	190	330	250	0.5	9	2
	Low Alloys	200	0.11	0.21	0.16	150	240	200	0.5	9	2
	High Alloys	220	0.08	0.18	0.13	90	150	120	0.5	6.4	1.5
	Pre Hardened Steel	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1
STAINLESS STEEL	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9	2
CAST IRON	Grey Cast Iron	140	0.13	0.26	0.2	150	240	200	0.5	9	2
HRSA	HRSA	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5

### 1604 SERIES INSERTS

ISO	WORKPIECE		CUTTING CONDITIONS								
	Material	Hardness HB	Feed (mm/tooth)			Vc (mm/min.)			Depth of Cut (mm)		
			Min.	Max.	Ideal	Min.	Max.	Ideal	Min.	Max.	Ideal
STEEL	Non Alloys	120	0.18	0.32	0.25	190	330	250	0.5	15	4
	Low Alloys	200	0.15	0.25	0.2	150	240	195	0.5	15	4
	High Alloys	220	0.12	0.22	0.17	90	150	120	0.5	10.7	4
	Pre Hardened Steel	<45HRc	0.1	0.18	0.14	40	80	60	0.5	5.4	2
STAINLESS STEEL	Austenitic	190	0.15	0.25	0.2	190	250	220	0.5	15	3
CAST IRON	Grey Cast Iron	140	0.18	0.32	0.25	150	240	195	0.5	15	4
HRSA	HRSA	240	0.12	0.18	0.15	25	45	35	0.5	10.7	3

## APKT MILL APPLICATION

The APKT 90 degree milling system is the original indexable square shoulder milling system, used by thousands of engineers in the UK. The inserts and holders are fully interchangeable with all other manufacturers holders.

The insert offers excellent general machining performance on steel, stainless and cast iron machining with a low cost insert and low cost holders. The special YG602 grade is designed for jobbing shops where a reliable multi-purpose insert is required for machining many different materials. It offers extreme toughness and reliability at an economic price.

For higher performance solutions, Alpha Mill or RM3 is an ideal replacement for APKT milling systems.