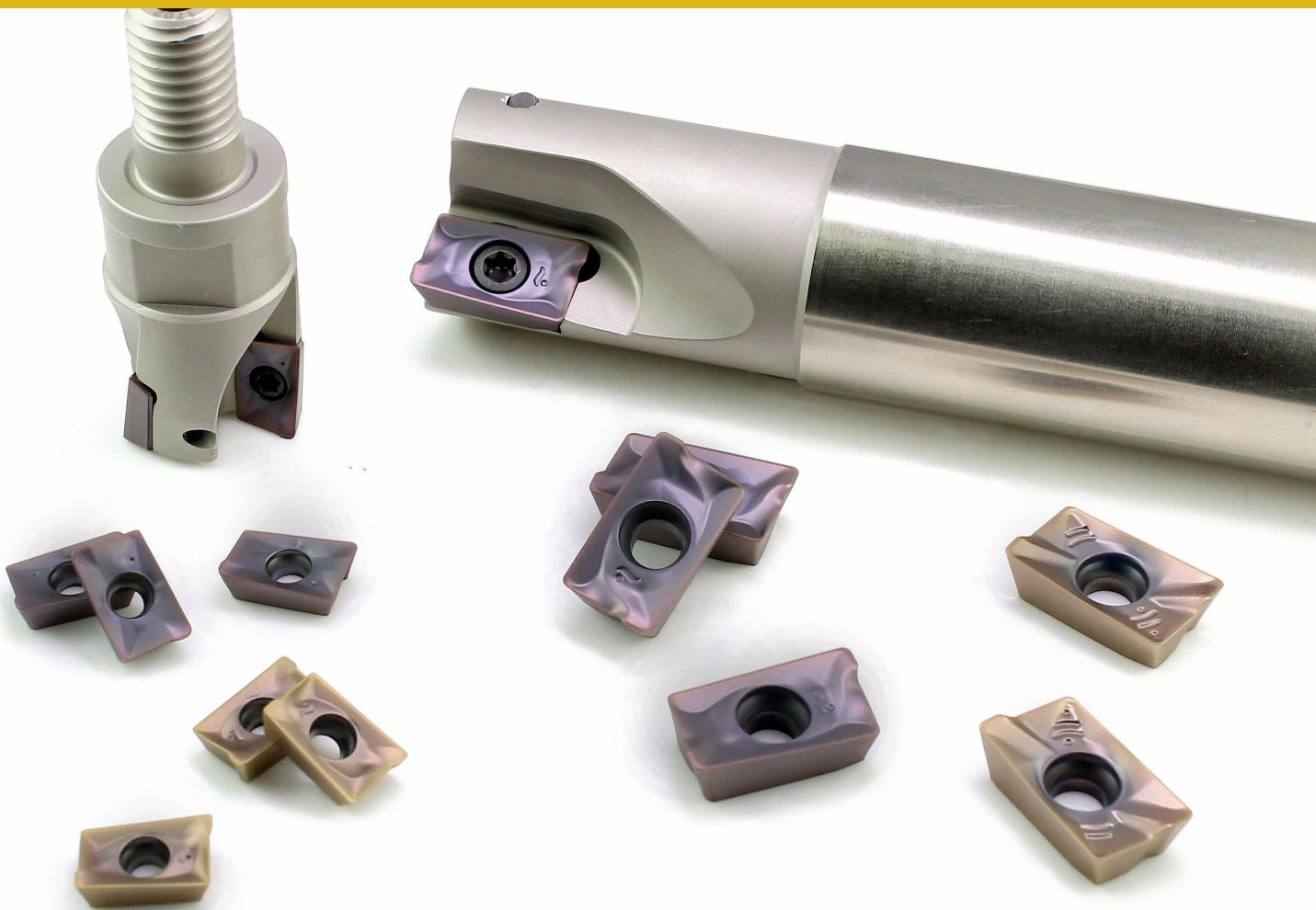


CAPK 90° Shoulder Milling

Single sided, 2 cutting edges



Versatile concept suitable for various applications !

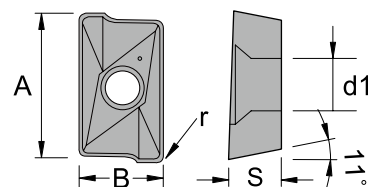
- *Enhancement chip breaker design for longer tool life.*
- *Offering better cost efficiency on medium to large work pieces.*
- *Medium to large sized cutter for shoulder milling and face milling available.*



WI1813-1E

Insert Specification

Insert	Dimensions (mm)				
	A	B	S	r	d1
APKT100304	10.5	6.7	3.5	0.4	2.8
APKT100308	10.5	6.7	3.5	0.8	2.8
APET160402	16.3	9.525	5.25	0.2	4.5
APKT160408	16.3	9.525	5.25	0.8	4.5
APKT170516	18.5	10.7	5.56	1.6	4.5



Insert Geometry

Shape	Chipbreaker	Application
	MG	Low cutting force for medium cutting in steel, stainless and cast iron.
	RG	Strong geometry design for rough cutting in steel, alloy steel and hardened steel.

Insert Grade

Grade Type	Machining Application	Industry area
CX22HS	- Continuous semi-finishing machining - For hardened steel and cast Iron	- Die and mould - Hardened parts
CX32HS	- Medium machining - For carbon steel, alloy steel and stainless steel	- Auto parts - Machinery parts
CX43TS	- Roughing or interrupted machining - For carbon steel, alloy steel, stainless steel and high temperature alloy.	- Auto parts - Machinery parts - Aircraft parts

※ Different grades for various applications are available to select, please contact us for more information.

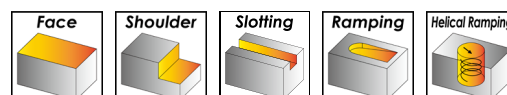
Recommended Cutting Conditions

Working Material	for APKT1003			for APKT1604		
	Vc	fz	ap	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 250	0.10 ~ 0.22	0.3 ~ 7.0	120 ~ 250	0.12 ~ 0.28	0.5 ~ 11.0
Stainless 300 Series	100 ~ 180	0.08 ~ 0.18	0.3 ~ 4.0	70 ~ 150	0.10 ~ 0.22	0.5 ~ 7.0
Cast Iron (HB140-220)	120 ~ 250	0.10 ~ 0.22	0.3 ~ 6.0	120 ~ 220	0.12 ~ 0.28	0.5 ~ 10.0
High temp. & Titanium alloy	40 ~ 100	0.07 ~ 0.14	0.3 ~ 4.0	40 ~ 80	0.10 ~ 0.18	0.5 ~ 7.0
Hardened steel	50 ~ 100	0.07 ~ 0.15	0.3 ~ 4.0	50 ~ 100	0.10 ~ 0.20	0.5 ~ 7.0

Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IAPKT100304EMG22HS	APKT100304PDER-MG-CX22HS	●	○	●		○	●
	IAPKT100304EMG32HS	APKT100304PDER-MG-CX32HS	●	●	●		○	○
	IAPKT100304EMG43TS	APKT100304PDER-MG-CX43TS	●	●	●		●	
	IAPMT100308EMG22HS	APMT100308PDER-MG-CX22HS	●	○	●		○	●
	IAPMT100308EMG32HS	APMT100308PDER-MG-CX32HS	●	●	●		○	○
	IAPKT100304ERG32HS	APKT100304PDER-RG-CX32HS	●	●	●		○	○
	IAPKT160408EMG22HS	APKT160408PDER-MG-CX22HS	●	○	●		○	●
	IAPKT160408EMG32HS	APKT160408PDER-MG-CX32HS	●	●	●		○	○
	IAPKT160408EMG43TS	APKT160408PDER-MG-CX43TS	●	●	●		●	
	IAPKT160408ERG22HS	APKT160408PDER-RG-CX22HS	●	○	●		○	●
	IAPKT160408ERG32HS	APKT160408PDER-RG-CX32HS	●	●	●		○	○
	IAPKT160408ERG43TS	APKT160408PDER-RG-CX43TS	●	●	●		●	
	IAPET160402FAL03	APET160402PDFR-AL-CX03				●		
	IAPKT170516ERG22HS	APKT170516PEER-RG-CX22HS	●	○	●		○	●
	IAPKT170516ERG32HS	APKT170516PEER-RG-CX32HS	●	●	●		○	○

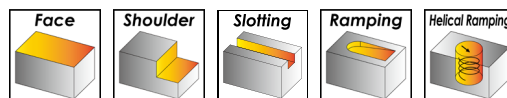
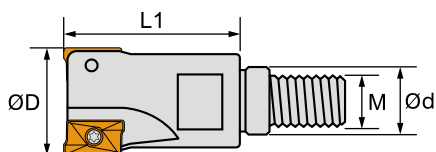
CAPKE - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench
ICAPKE302016120	16	25	120	16	2	APKT1003	ITS2507	ITK08
ICAPKE302020120	20	30	120	20	2			
ICAPKE304025150	25	35	150	25	4			
ICAPKE305032150	32	35	150	32	5			
ICAPKE402025150	25	40	150	25	2	APKT1604	ITS4005	ITK15
ICAPKE402032150	32	45	150	32	2			

Customize available.

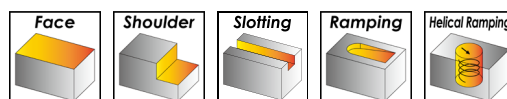
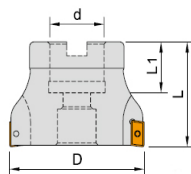
CAPKM - Modular tools



Order No.	D	L1	d	M	T	Inserts	Screw	Wrench
ICAPKM302016080	16	26	8.5	M8	2	APKT1003	ITS2504	ITK08
ICAPKM303020100	20	32	10.5	M10	3			
ICAPKM304025120	25	38	12.5	M12	4			
ICAPKM305032160	32	41	17	M16	5			
ICAPKM402025120	25	38	12.5	M12	2	APKT1604	ITS4004	ITK15
ICAPKM403032160	32	41	17	M16	3			

Customize available.

CAPKF - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench
ICAPKF306050220	50	20	40	22	6	APKT1003	ITS2507	ITK08
ICAPKF306063220	63	21	45	22	6			
ICAPKF307080270	80	23	50	27	7			
ICAPKF404050220	50	23	50	22	4	APKT1604	ITS4005	ITK15
ICAPKF405063220	63	23	50	22	5			
ICAPKF406080270	80	32	55	27	6			
ICAPKF408100320	100	32	55	32	8			

Customize available.

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