PRAMET

ALL-IN-ONE INDEXABLE CUTTER

Increase Productivity and Optimize Costs with

Force AD

The Pramet Force AD milling cutter is revolutionizing end user productivity with its versatility. This universal shoulder milling cutter features differential pitch to reduce vibration and system noise. Combine solid performance with the cutter's application with multiple materials and in harsh environmental conditions and users have the ideal universal shoulder milling product to fit their needs.

The body of the milling cutter is constructed of a new material specifically suited to machine a pocket for the insert after head treatment. The result in application is closer tolerances for higher accuracy. Designed to be corrosion resistant, the Force AD also provides increased strength at higher temperatures.

Features & Benefits

- High positive 27° geometry to reduce cutting forces
- FA geometry specific to ISO "N" materials to reduce material sticking
- Special surface finish for increased corrosion resistance, reduced wear and lower friction resistance
- Polished inserts for high feed and differential pitch wear and lower friction resistance
- Polished inserts for high feed and differential pitch

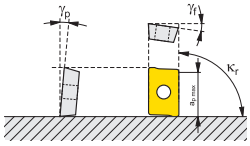
Want to learn more?

Ask for our technical handbook or sign up for eLearning online.

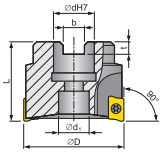
Your one-stop manufacturer - Ask about our Replaceable Head Hydra Drill

Force AD

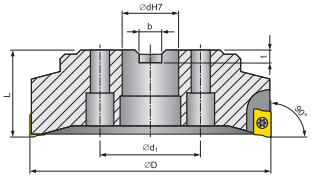
Square Soulder and Slot Milling Cutters



γ_p	+10.5° – 12°	κ_r	90°
γ_f	-3.8° – -8.2°	$a_{p\,max}$	.512 in



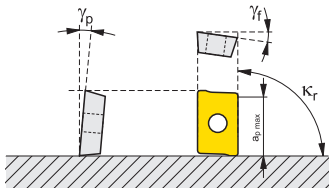
Ø1.500-5.000in



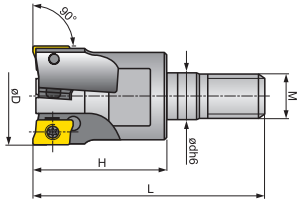
Ø6.000in

Coolant thru

Designation	Availability	Dimensions							lbs
		D	d	d_1	L	b	t	No of teeth	
150A04R-IS90AD16E-C	Standard	1.500	.500	.433	1.575	.258	.165	4	.44
200A03R-IS90AD16E-C	Standard	2.000	.750	.630	1.575	.321	.193	3	.66
200A05R-IS90AD16E-C	Standard	2.000	.750	.630	1.575	.321	.193	5	.66
250A04R-IS90AD16E-C	Standard	2.500	.750	.630	1.575	.321	.193	4	1.10
250A06R-IS90AD16E-C	Standard	2.500	.750	.630	1.575	.321	.193	6	1.10
300A05R-IS90AD16E-C	Standard	3.000	1.000	.827	1.969	.382	.224	5	2.21
300A07R-IS90AD16E-C	Standard	3.000	1.000	.827	1.969	.382	.224	7	2.21
400A06R-IS90AD16E-C	Standard	4.000	1.500	1.260	1.969	.630	.382	6	3.97
400A08R-IS90AD16E-C	Standard	4.000	1.500	1.260	1.969	.630	.382	8	3.75
500A09R-IS90AD16E-C	Standard	5.000	1.500	1.260	2.480	.630	.382	9	7.72
600B10R-IS90AD16E *(not coolant thru)*	Standard	6.000	1.575	3.465	2.480	.756	.445	10	12.57

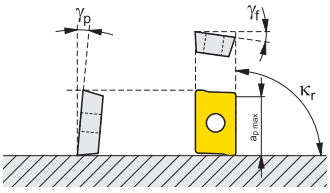


γ_p	+7° – +10.5°	κ_r	90°
γ_f	-8.2° – -12°	$a_{p\,max}$	.512 in

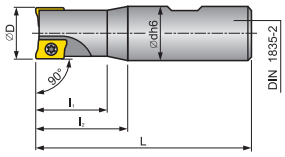


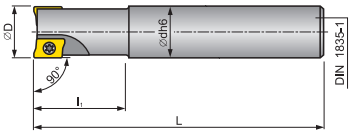
Coolant thru

Designation	Availability	Dimensions						lbs
		D	L	H	M	d	No of teeth	
125A3R169M16-ISAD16E-C	Standard	1.250	2.596	1.690	M16	.669	3	.44
150A4R169M16-ISAD16E-C	Standard	1.500	2.596	1.690	M16	.669	4	.44



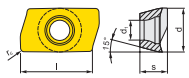
γ_p	+5° – 10.5°	κ_r	90°
γ_f	-8.2° – -13°	$a_{p\,max}$	.512 in



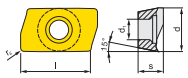


Coolant thru

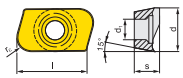
Designation	Availability	Shank style	Dimensions					lbs
			D	L	l_1	d	No of teeth	
100A2R128W100-ISAD16E-C	Standard	Weldon	1.000	3.780	1.280	1.000	2	.66
125A3R150W125-ISAD16E-C	Standard	Weldon	1.250	4.000	1.500	1.250	3	1.10
150A3R160W125-ISAD16E-C	Standard	Weldon	1.500	4.350	1.600	1.250	3	1.32
150A4R160W125-ISAD16E-C	Standard	Weldon	1.500	4.350	1.600	1.250	4	1.32
100A2R130C100-ISAD16E-C	Standard	Cylindrical	1.000	6.496	1.300	1.000	2	1.10
125A3R130C125-ISAD16E-C	Standard	Cylindrical	1.250	7.677	1.300	1.250	3	1.98



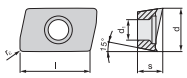
ADMX 16



ADMX 16 (16/32)



ADEX 16



ADEX 16

Indexable Cutting Inserts

Designation	Grades							Dimensions				
								l	d	s	d_1	r_E
ADMX 160608SR-F	M9340	M8340	8215	8230				.630	.392	.246	.177	.031
ADMX 160608SR-M	M5315	M9315	M9325	M9340	M8340	8215	8230	.630	.392	.246	.177	.031
ADMX 160608PR-R	M5315	M9315	M9325	M8340	8215	8230		.630	.392	.246	.177	.031
ADMX 160616SR-M	M9325	M8340	8215	8230				.630	.392	.246	.177	.063
ADMX 160632SR-M	M9325	M8340	8215	8230				.630	.392	.246	.177	.126
ADEX 160608SR-FM	M9325	M9340	M8340	8215	8230			.630	.392	.246	.177	.031
ADEX 160608FR-FA	HF7							.630	.392	.246	.177	.031