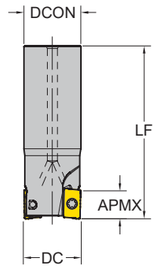
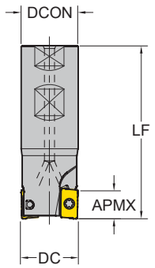
MILLING

Product Overview
Application Guide
Milling Inserts & Cutter Overview
Milling Inserts & Cutter

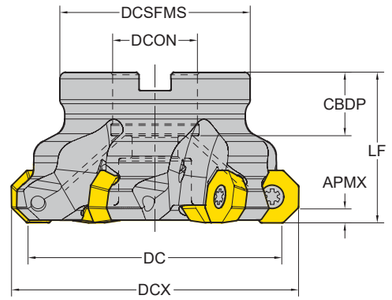
Code Keys - Milling Cutters



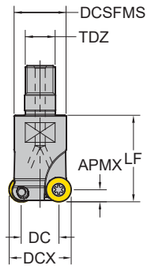
<C> Cylindrical



<W> Weldon



<S> Shell Mill



<M> Modular

E	90	-	APKT10	-	D100	Z2	C100	-	L480	i
	KAPR				DC or DCX*	ZEFP	DCON or TDZ		LF*	

* DCX for Round insert
* Shank Type Only

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

Cutting Angle
(90˚)

Insert Series
(APKT 10)

Cutter Diameter
(Ø1.00")

Number of Teeth
(Z=2)

Connection Type and Size
C - Cylindrical
S - Shell Mill
(Cylindrical Ø1.00")
W - Weldon
M - Modular

Functional Length
(4.80 inch)

Inch

Insert ISO Code System

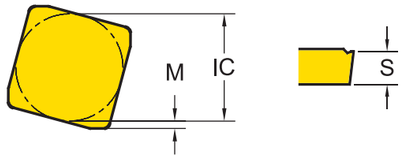
1	2	3	4	5	6	7
A	**P**	**K**	**T**	**16**	**04**	**08**
Shape	Relief Angle (AN)	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness (S)	CornerRadius

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	±.0010	±.0005	±.0010
E	±.001	±.0010	±.001
G	±.001	±.0010	±.005
H	±.0005	± .0005	±.0010
K*	±.002~.006*	±.0005	±.005
M*	±.002~.006*	±.003~.010*	±.005
U*	±.003~.010*	±.005~.015*	±.005

* 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

Insert ISO Code System

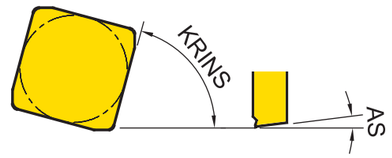
page 71 page 70

(8	9	) 10
PDTR	**-TR**	**YG602**
Corner Geometry	Chipbreaker	Grade

7 - Corner Radius (RE)

Symbol	Thickness - S (in)	Symbol	Thickness - S (in)
04	.016	**16**	.063
08	.031	**20**	.079
12	.047	**24**	.094

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. 71 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

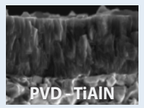
Symbol	Feed Direction	
R	Right-hand Insert	
N	Neutral Insert	
L	Left-hand Insert	

Milling Grades and Chipbreakers

Milling Grades

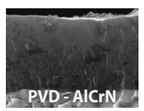
Milling Grades		P Steel					M Stainless steel				K Cast iron				N Non-ferrous				S Superalloys			
		P05	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35
PVD	YG602		602					602				602								602		
	YG622		622									622										
	YG712	712																				
	YG713		713																			
	YG603			603				603													603	
	YG501											501										
CVD	YG5020											5020										
Uncoated	YG50														50							

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



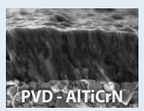
Universal grade for General Milling Application
- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application

YG622
P20 - P40 | K20 - K40



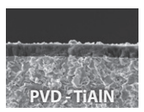
Optimized Grade for High Alloyed or Prehardened Steel
Excellent hot hardness and oxidation resistance at high speed

YG712
P10 - P30



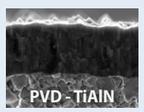
General Milling Grade for Steel

YG713
P15 - P25 | H20-H30



Milling Grade for General Steel Application
- Multi-layer TiAlN structure realizes stronger crater and flank wear resistance
- Fine-grained carbide and balanced substrate

YG603
P35 - P45 | M30 - M40 | S30

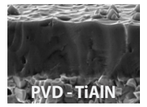


Tough Milling grade for Stainless Steel
- New coating layer with high toughness and lubrication on ultra fine grain substrate with high toughness.
- The toughest substrates provides excellent cutting performance in stainless steel

Milling Grades and Chipbreakers

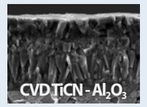
Milling Grades

YG501
K05- K25 | H05 - H25



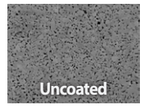
Hard Milling grade for Cast Iron
- Substrate especially designed for high wear resistance
- Excellent wear resistance in cast iron milling application

YG5020
K01-K30



CVD Milling grade for Cast Iron
- CVD coating for Excellent wear resistance
- Improved Toughness for chipping resistance

YG50
N05 – N20



Uncoated Milling Grade for Aluminium
- Submicron carbide substrate for high wear resistance
- Preventing built up edge with shining surface

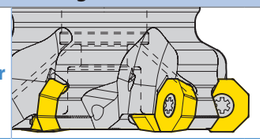
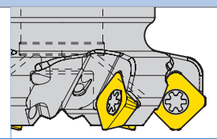
Milling Chipbreakers

–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

Milling Overview

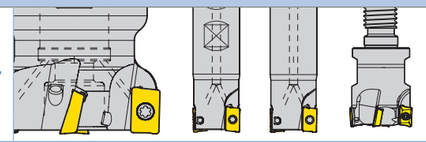
Face Milling

Positive Octagonal

Cutter		ODMT/ODMW 0605		SEKT 1204	SEGT 1204
APMX		.138		.236	.236
DC		Ø2.5~5.0		Ø1.5~6.0	Ø1.5~6.0
page		p. 74		p. 75	p. 75

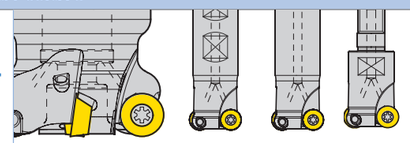
Shoulder Milling

2 Corner Positive

Cutter		APKT 1003	APKT 1604	APMT 1135	APMT 1604	APXT 1604
APMX		.394	.630	.390	.630	.630
DC		Ø.625~2.0	Ø1.0~4.0	Ø.625~1.25	Ø1.25	Ø1.25
page		p.88	p.88	p.89	p.89	p.89

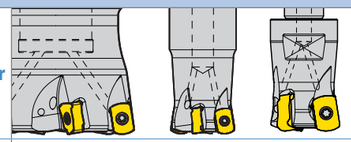
Profiling

Round Positive

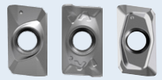
Cutter		RDKT / RDKW 0802	RDKT / RDKW 10T3	RDKT / RDKW 1204
APMX		.157	.196	.236
DCX		Ø.75~1.0	Ø1.0~2.0	Ø1.0~2.5
page		p. 96	p. 96	p. 96

High Feed Milling

Negative 4 Corner

Cutter		ENMX 0604
APMX		.04
DCX		Ø.625~3.0
page		p. 101

Milling Inserts Overview

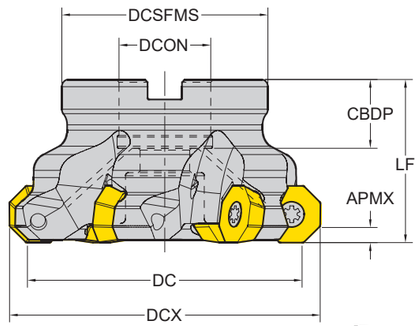
A 2 Corner	 Positive	**ADKT**	ADKT 1505	p. 90
		AOMT	AOMT 1236	
		APKT	APKT 1003, 1604	p. 91
		APMT	APMT 1135, 1504, 1604	p. 92
		APXT	APXT 1604	p. 93
E 4 Corner	 Negative	**ENMX**	ENMX 0604	p. 102
O Octagon	 Positive	**ODMT / ODMW**	ODMT / ODMW 0605	p. 76
		OFER	OFER 0704	p. 77
		OFMT	OFMT 05T3	
	 Negative	**ONMU / ONHU**	ONMU / ONHU 0806	p. 78
R Round	 Positive Round	**RDKT / RDKW**	RDKT 0802, 10T3, 1204 RDKW 0501, 0702, 0802, 10T3, 1204	p. 97
		RDMT / RDMW	RDMT 0802, 0803, 10T3, 1204 RDMW 0802, 10T3, 1204	p. 98
	 Positive 3 Corner	**RPMT / RPMW**	RPMT 08T2, 10T3, 1204 RPMW 1003, 1204	p. 99
		RBEX50	RBEX50	p. 100
S Square	 High Feed	**SDMT / SDMW**	SDMT 1204, SDMW 1204	p. 103
	 Positive	**SEKT**	SEKT 12T3, 1204	p. 81
		SEGT	SEGT12T3, 1204	p. 82
		SEMT	SEMT1204, 13T3	P. 83
		SPMT	SPMT 1204	p. 86
		SDKN / SDCN (45°)	SDKN / SDCN 42, 53	p. 79
		SEKN / SEKR (45°)	SEKN / SEKR 42	p. 80
	 ISO	**SPKN / SPKR / SPCN(75°)**	SPKN 42, 53 SPKR 42 SPCN 42, 53	p. 85
		SPUN	SPUN 42	p. 87
	 Negative	**SNMX**	SNMX1206	p. 84
T Triangle	 ISO	**TPKN / TPKR / TPCN(90°)**	TPKN 32, 43 TPKR 32, 43 TPCN 43	p. 94
		TPUN	TPUN 32	p. 95

Milling - Face Milling - Cutter

Cutters for ODMT, ODMW

Cutting Angle : 43˚
8 Corner Positive

<S> Shell Mill



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

○: p. 76

Unit: inch

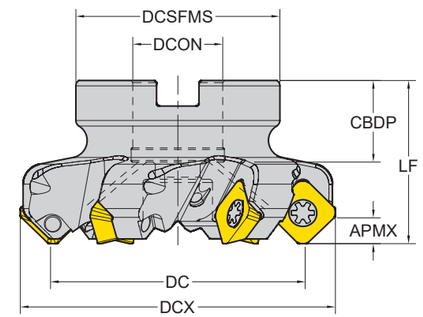
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
ODMT ODMW 0605	.138	F43-ODMT06-D250Z5S075i	0040	2.50	2.89	5	1.575	Shellmill	.75	.75	1.75	-	-	●
		F43-ODMT06-D300Z6S100i	0041	3.00	3.39	6	1.75		1.00	.94	2.25	-	-	●
		F43-ODMT06-D400Z7S125i	0042	4.00	4.30	7	2.00		1.25	1.26	2.88	-	-	●
		F43-ODMT06-D500Z8S150i	0043	5.00	5.39	8	2.25		1.50	1.38	3.54	-	-	●

Milling - Face Milling - Cutter

Cutters for SEKT, SEGT

Cutting Angle : 45˚
4 Corner Positive

<S> Shell Mill



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

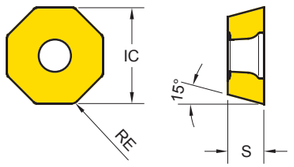
○: p. 81

Unit: inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SEKT SEGT 1204	.236	F45-SEKT12-D150Z4S050i	0060	1.50	2.06	4	1.575	Shellmill	.50	.71	1.25	-	-	●
		F45-SEKT12-D200Z5S075i	0061	2.00	2.57	5	1.575		.75	.74	1.75	-	-	●
		F45-SEKT12-D250Z4S075i	0062	2.50	3.06	4	1.575		.75	.75	2.19	-	-	●
		F45-SEKT12-D250Z6S075i	0063	2.50	3.06	6	1.575		.75	.75	2.19	-	-	●
		F45-SEKT12-D300Z4S100i	0064	3.00	3.56	4	1.75		1.00	.94	2.25	-	-	●
		F45-SEKT12-D300Z7S100i	0065	3.00	3.56	7	1.75		1.00	.94	2.25	-	-	●
		F45-SEKT12-D400Z8S125i	0066	4.00	4.56	8	2.00		1.25	1.22	3.00	-	-	●
		F45-SEKT12-D500Z10S150i	0067	5.00	5.56	10	2.38		1.50	1.38	3.65	-	-	●
		F45-SEKT12-D600Z12S200i	0068	6.00	6.56	12	2.50		2.00	1.50	3.94	-	-	X

Milling - Face Milling - Inserts

ODMT, ODMW - Face Milling Positive (8 Corners)



Series	IC	S
ODM* 0605	.626	.220

EDP 1200..

●: Stock item ○: Order made item

ODMT ODMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
ODMT General 	ODMT 060508	.031	.008 ~ .014		● 0030						
ODMW Hard Materials 	ODMW 060508	.031	.010~.016		● 0031						

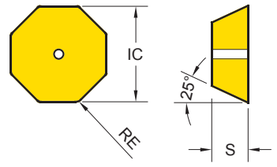
Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

YG MILL INCH

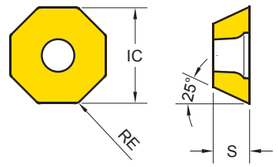
TURNING
PARTING & GROOVING
MILLING
DRILLING
TECHNICAL INFORMATION

Milling - Face Milling - Inserts

OFER, OFMT - Face Milling Positive (8 Corners)



<OFER>



<OFMT>

Series	IC	S
OFER 0704	.711	.188
OFMT 05T3	.501	.160

EDP 1200..

●: Stock item ○: Order made item

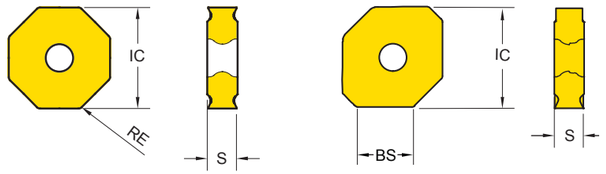
OFER	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
OFER General 	OFER 070405	.020	.009 ~ .020		● 0209						

OFMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
OFMT General 	OFMT 05T308	.031	.006 ~ .010		● 0032						

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

ONMU / ONHU - Face Milling Negative (16 Corners)



<ONMU> <ONHU>

Series	IC	S
ON*U 0806	.795	.228

EDP 1200..
●: Stock item ○: Order made item

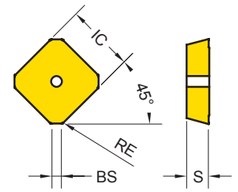
ONMU ONHU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
ONMU General	**ONMU 080608**	.031	.009 ~ .020		● 0233						● 0414
ONHU Wiper Insert	**ONHU 080612**	.047	.003 ~ .010	.417							● 0482

Cutting Speed

ISO	VDI	Sub Group	Vc (ft/min) YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

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



Series	AS	IC	S
SD** 42	15°	.500	.125
SD** 53	15°	.625	.187

EDP 1200..
●: Stock item ○: Order made item

SDKN SDCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SDKN Hard Materials	SDKN 42 AETN	.020	.009 ~ .014	.073	● 0058						
	SDKN 42 AETN -PW	.016	.009 ~ .014	.078	● 0253						
	SDKN 42 AETN -GW	.051	.009 ~ .014	.073	● 0251						
	SDKN 53 AETN	.018	.009 ~ .014	.079	● 0059						
	SDKN 53 AETN -PW	.016	.009 ~ .016	.077	● 0288						
	SDKN 53 AETN -GW	.051	.009 ~ .016	.081	● 0286						
SDCN Ground insert	SDCN 42 AESN -M		.002 ~ .008	.080			● 0135				
	SDCN 53 AESN -M		.002 ~ .008	.086			● 0150				
	SDCN 53 AESN -MR	.039	.002 ~ .008	.086			● 0201				

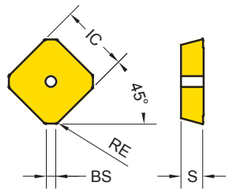
- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed

ISO	VDI	Sub Group	Vc (ft/min) YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

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



Series	AS	IC	S
SEK* 42	20°	.500	.126

EDP 1200..
●: Stock item ○: Order made item

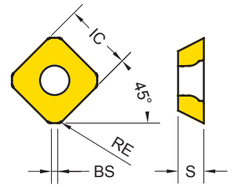
SEKR SEKN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SEKR General	SEKR 42 AFTN	.016	.006 ~ .012	.055	● 0051						
	SEKR 42 AFTN -PW	.016	.006 ~ .012	.079	● 0296						
SEKN Hard Materials	SEKN 42 AFTN	.016	.009 ~ .014	.055	● 0054						
	SEKN 42 AFTN -PW	.016	.009 ~ .014	.079	● 0304						
	SEKN 42 AFTN -GW	.016	.009 ~ .014	.079	● 0297						

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

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

SEKT - Face Milling Positive (4 Corners)



Series	IC	S
SEKT 1204	.500	.193
SEKT 12T3	.528	.157

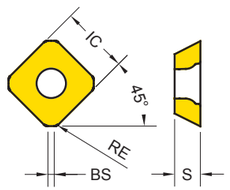
EDP 1200..
●: Stock item ○: Order made item

SEKT 1204	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SEKT 1204 General	SEKT 1204 AFTN	.043	.008 ~ .014	.046	● 0055	● 0416					
-ST Stainless Steel Super Alloy	SEKT 1204 -ST	.043	.003 ~ .012	.079	● 0257						

SEKT 12T3	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
SEKT 12T3 General	SEKT 12T3 AGTN	.059	.006 ~ .012	.051	● 0056						
-ST Stainless Steel Super Alloy	SEKT 12T3 -ST	.059	.003 ~ .012	.079	● 0271						

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

SEGT - Face Milling Positive (4 Corners)



Series	IC	S
SEGT 1204	.500	.193
SEGT 12T3	.528	.159

EDP 1200..
●: Stock item ○: Order made item

SEGT 1204

Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020	YG50
				P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15	N15
SEGT 1204 -AL	.043	.004 ~ .014	.079								○ 0467

-AL
Aluminium

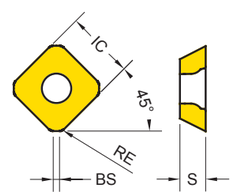
SEGT 12T3

Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020	YG50
SEGT 12T3 -AL	.059	.004 ~ .014	.076								○ 0468

-AL
Aluminium

Cutting Speed			Vc (ft/min)														
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150	-	-
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	980	2620
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-	-	-

SEMT - Face Milling Positive (4 Corners)



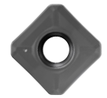
Series	IC	S
SEMT1204	.509	.201
SEMT13T3	.528	.157

EDP 1200..
●: Stock item ○: Order made item

SEMT

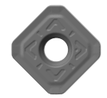
Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
				P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SEMT 1204 AFTN	.047	.010 ~ .016	.049	● 0052						

SEMT 1204
General



Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
SEMT 13T3 AGSN	.059	.006 ~ .012	.052	● 0203						

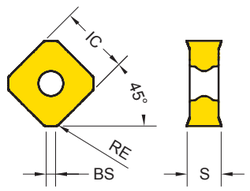
SEMT 13T3
General



Cutting Speed			Vc (ft/min)														
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150	-	-
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts

SNMX - Face Milling Negative (8 Corners)



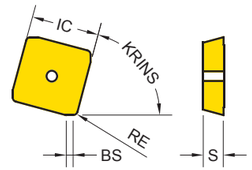
Series	IC	S
SNMX 1206	.500	.246

EDP 1200..
●: Stock item ○: Order made item

SNMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SNMX General 	SNMX 1206 ANN	.031	.006 ~ .013	.067	● 0231						

Milling - Face Milling - Inserts

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



Series	KRINS	AS	IC	S
SP** 42	75°	11°	.500	.126
SP** 53	75°	11°	.625	.189

EDP 1200..
●: Stock item ○: Order made item

SPKR SPKN SPCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SPKR General 	SPKR 42 EDTR	.031	.006 ~ .014	.055	● 0050						
	SPKR 42 EDTR -PW	.031	.006 ~ .014	.061	● 0298						
SPKN Hard Materials 	SPKN 42 EDTR	.031	.006 ~ .013	.055	● 0048						
	SPKN 42 EDTR -PW	.031	.008 ~ .014	.059	● 0279						
	SPKN 42 EDTR -GW	.024	.006 ~ .011	.059	● 0280						
	SPKN 53 EDTR	.031	.006 ~ .013	.051	● 0049						
	SPKN 53 EDTR -PW	.031	.010 ~ .016	.084	● 0299						
	SPKN 53 EDTR -GW	.031	.010 ~ .016	.087	● 0305						
SPCN Ground insert 	SPCN 42 EDSR -M	.031	.004 ~ .008	.072			● 0081				
	SPCN 42 EDSR -MR	.031	.004 ~ .008	.070			● 0198				
	SPCN 53 EDSR -M	.031	.004 ~ .008	.076			● 0098				
	SPCN 53 EDSR -MR	.031	.004 ~ .008	.073			● 0199				

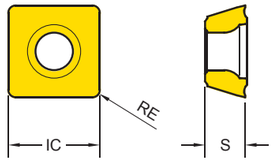
- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Face Milling - Inserts

SPMT - Universal Positive (4 Corners)



Series	AS	IC	S
SPMT 1204	11°	.500	.189

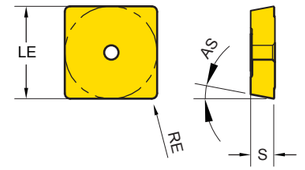
EDP 1200..

●: Stock item ○: Order made item

SPMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SPMT General 	SPMT 120408	.031	.006 ~ .012		● 0223						

Milling - Face Milling - Inserts

SPUN - Universal Positive (4 Corners ISO)



Series	AS	IC	S
SPUN 42	11°	.500	.126

EDP 1200..

●: Stock item ○: Order made item

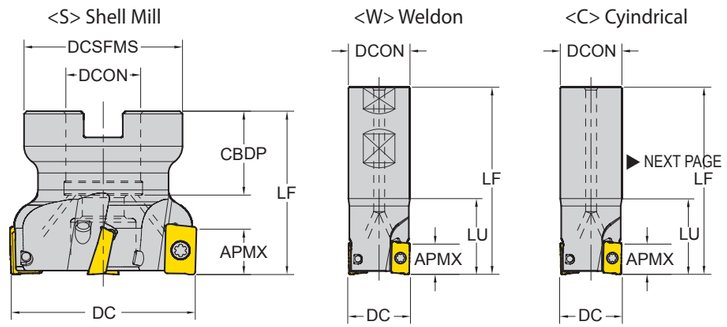
SPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
SPUN General 	SPUN 422	.031			● 0224						

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Cutters for APKT

Cutting Angle : 90˚
2 Corner Positive



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

○ : p. 91

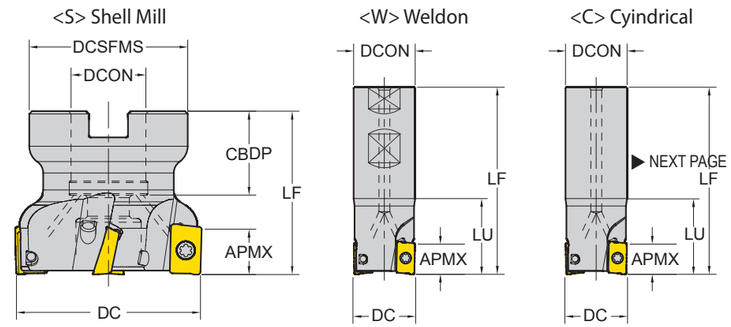
Unit : inch

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APKT 1003	.394	E90-APKT10-D100Z4C075-L600i	0149	1.00	4	1.25	6.00	Cyindrical	.750	-	-	-	-	●
		E90-APKT10-D0625Z2W0625-L350i	0144	.625	2	1.59	3.50	Weldon	.625	-	-	-	-	●
		E90-APKT10-D075Z3W075-L320i	0146	.750	3	1.17	3.20		.75	-	-	-	-	●
		E90-APKT10-D100Z4W100-L400i	0148	1.00	4	1.72	4.00		1	-	-	-	-	●
		F90-APKT10-D150Z4S075i	0150	1.50	4	-	1.575	Shell Mill	.750	.750	1.34	-	-	●
		F90-APKT10-D200Z7S075i	0151	2.00	7	-	1.75		.750	.750	1.75	-	-	●
APKT 1604	.630	E90-APKT16-D100Z2C0875-L378i	0089	1.00	2	1.50	3.78	Cyindrical	.875	-	-	-	-	●
		E90-APKT16-D125Z3C100-L428i	0090	1.25	3	-	4.28		1.00	-	-	-	-	●
		E90-APKT16-D100Z2W100-L400i	0158	1.00	2	1.72	4.00	Weldon	1	-	-	-	-	●
		E90-APKT16-D100Z2W100-L1000i	0208	1.00	2	1.50	1.00		1	-	-	-	-	●
		E90-APKT16-D125Z3W100-L400i	0159	1.25	3	1.72	4.00		1	-	-	-	-	●
		E90-APKT16-D125Z3W125-L1000i	0205	1.25	3	1.50	1.00		1.25	-	-	-	-	●
		E90-APKT16-D125Z4W125-L1000i	0206	1.25	4	1.50	1.00		1.25	-	-	-	-	●
		F90-APKT16-D200Z5S075i	0160	2.00	5	-	1.75	Shell Mill	.750	.750	1.75	-	-	●
		F90-APKT16-D250Z6S075i	0161	2.50	6	-	1.75		.750	.750	1.75	-	-	X
		F90-APKT16-D300Z7S100i	0162	3.00	7	-	2.00		1	.945	2.19	-	-	●
		F90-APKT16-D400Z8S150i	0207	4.00	8	-	2.50		1.50	1.57	3.50	-	-	●

▶ NEXT PAGE

Cutters for APMT, APXT

Cutting Angle : 90˚
2 Corner Positive



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

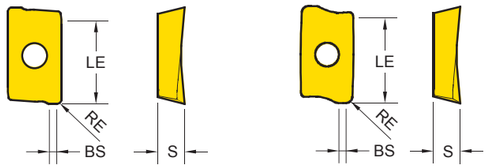
○ : p. 92 / 93

Unit : inch

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APMT 1135	.390	E90-APMT11-D0625Z2C0625-L400i	0098	.625	2	1.60	4.00	Cyindrical	.625	-	-	-	-	●
		E90-APMT11-D075Z2W075-L354i	0099	.750	2	1.17	3.54	Weldon	.750	-	-	-	-	●
		E90-APMT11-D100Z4W100-L428i	0100	1.00	4	1.32	4.28		1.00	-	-	-	-	●
		E90-APMT11-D125Z4W100-L428i	0101	1.25	4	1.32	4.28		1.00	-	-	-	-	●
APMT, APXT 1604	.630	E90-APMT16-D125Z3W125-L390i	0106	1.25	3	1.62	3.90	Weldon	1.25	-	-	-	-	●

Milling - Shoulder Milling - Inserts

ADKT / AOMT - Shoulder Milling Positive (2 Corner)



<ADKT>

<AOMT>

Series	LE	IC	S
ADKT 1505	.539	.382	.228
AOMT 1236	.413	.260	.142

EDP 1200..
●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15	
YG602	YG622	YG712	YG712	YG603	YG501	YG5020	

ADKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG712	YG603	YG501	YG5020
ADKT General 	ADKT 150508 PDTR	.031	.006 ~ .012	.074	● 0220						

AOMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG712	YG603	YG501	YG5020
AOMT General 	AOMT 123604 PDTR	.016	.003 ~ .009	.042	● 0217						
	AOMT 123608 PDTR	.031	.003 ~ .009	.036	● 0218						

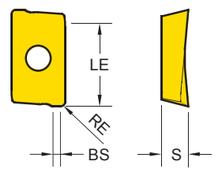
Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

YG MILL INCH

TURNING
PARTING & GROOVING
MILLING
DRILLING
TECHNICAL INFORMATION

Milling - Shoulder Milling - Inserts

APKT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APKT 1003	.390	.264	.142
APKT 1604	.598	.370	.209

EDP 1200..
●: Stock item ○: Order made item

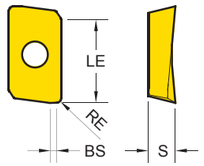
P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15	
YG602	YG622	YG712	YG713	YG603	YG501	YG5020	

APKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
APKT General 	APKT 100305 PDTR	.020	.006 ~ .009	.034	● 0005	● 0429		● 0638			
	APKT 100308 PDTR	.031	.006 ~ .009	.035	● 0004	● 0430		● 0632			
	APKT 160404 PDTR	.016	.006 ~ .010	.044	● 0003						
	APKT 160408 PDTR	.031	.006 ~ .012	.052	● 0001			● 0633			
	APKT 160412 PDTR	.047	.006 ~ .013	.044	● 0002						
	APKT 160416 PDTR	.063	.006 ~ .013	.044	● 0006						
	APKT 160424 PDTR	.094	.006 ~ .015	.059	● 0255						
-ST Stainless Steel Super Alloy 	APKT 100305 -ST	.020	.003 ~ .009	.034	● 0278						
	APKT 160408 -ST	.031	.003 ~ .010	.052	● 0270						
-TR Hardened Steel 	APKT 160404 -TR	.016	.010 ~ .016	.083	● 0492	● 0505					
	APKT 160408 -TR	.031	.010 ~ .016	.052	● 0256	● 0337					
	APKT 160412 -TR	.047	.010 ~ .016	.094	● 0493	● 0523					
	APKT 160416 -TR	.063	.010 ~ .016	.094	● 0472	● 0524					
	APKT 160424 -TR	.094	.010 ~ .016	.059	● 0494	● 0520					

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

APMT - Shoulder Milling Positive (2 Corner)



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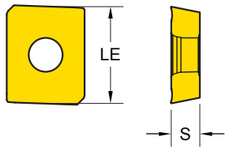


<APMT 1504>

Series	LE	IC	S
APMT 1135	.374	.244	.138
APMT 1604	.575	.362	.187
APMT 1504	.551	.500	.187

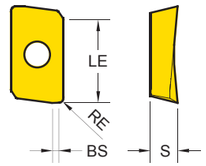
EDP 1200..
●: Stock item ○: Order made item

APMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
APMT General	APMT 113504 PDTR	.016	.006 ~ .009	.050	● 0009	● 0400					
	APMT 113508 PDTR	.031	.006 ~ .010	.042	● 0010						
	APMT 160408 PDTR	.031	.006 ~ .012	.044	● 0008	● 0399	● 0423		● 0465	● 0464	
APMT 1504 General	APMT 1504		.006 ~ .011		● 0276	● 0445					

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

APXT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APXT 1604	.575	.362	.189

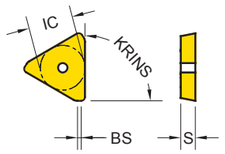
EDP 1200..
●: Stock item ○: Order made item

APXT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020	YG50
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15	N15
-AL Aluminium	APXT 160408 -AL	.031	.004 ~ .051	.069								○ 0528

Cutting Speed			Vc (ft/min)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

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



Series	KRINS	IC	S
TP** 32	90°	.375	.125
TP** 43	90°	.500	.187

EDP 1200..
●: Stock item ○: Order made item

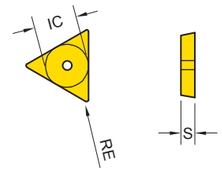
TPKR TPKN TPCN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602 (P25 M30 K30 S20)	YG622 (P30 K30)	YG712 (P20)	YG713 (P30)	YG603 (P40 M35 S30)	YG501 (K15 H15)	YG5020 (K15)
TPKR General		TPKR 32 PDTR		.006 ~ .011	.047	● 0060						
		TPKR 32 PDTR -PW		.004 ~ .008	.047	● 0300						
		TPKR 43 PDTR		.007 ~ .014	.067	● 0061						
		TPKR 43 PDTR -PW		.007 ~ .014	.067	● 0301						
TPKN Hard Materials		TPKN 32 PDTR		.006 ~ .012	.047	● 0062						
		TPKN 32 PDTR -PW		.006 ~ .011	.047	● 0302						
		TPKN 32 PDTR -GW		.006 ~ .012	.063	● 0306						
		TPKN 43 PDTR		.007 ~ .012	.067	● 0063						
		TPKN 43 PDTR -PW		.009 ~ .016	.067	● 0303						
		TPKN 43 PDTR -GW		.009 ~ .016	.098	● 0307						
TPCN Ground insert		TPCN 43 PDSR -M		.002 ~ .008	.069			● 0180				
		TPCN 43 PDSR -MR		.002 ~ .008	.069			● 0202				

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

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts

TPUN - Universal Positive (3 Corners ISO)



Series	IC	S
TPUN 32	.375	.125

EDP 1200..
●: Stock item ○: Order made item

TPUN		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602 (P25 M30 K30 S20)	YG622 (P30 K30)	YG712 (P20)	YG713 (P30)	YG603 (P40 M35 S30)	YG501 (K15 H15)	YG5020 (K15)
TPUN		TPUN 322	.031	.003 ~ .006		● 0064						

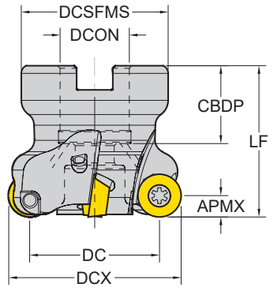
Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Profiling - Cutter

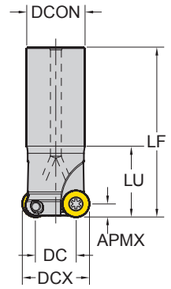
Cutters for RDKT, RDKW

Round Positive

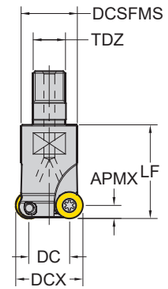
<S> Shell Mill



<C> Cyindrical



<M> Modular



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

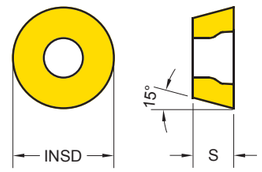
: p. 97

Unit : inch

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
RDKT, RDKW 0802	.157	E-RDKT08-D075Z2C075-L700i	0044	.435	.75	2	1.5	7.00	Cyindrical	.75	-	-	●
		E-RDKT08-D100Z3C075-L700i	0045	.685	1.00	3	1.5	7.00		.75	-	-	●
		M-RDKT08-D075Z2M10i	0046	.435	.75	2	-	1.25	Modular	M10	-	-	●
		M-RDKT08-D100Z3M12i	0047	.685	1.00	3	-	1.50		M12	-	-	●
RDKT, RDKW 10T3	.196	E-RDKT10-D100Z2C100-L700i	0048	.606	1.00	2	1.5	7.00	Cyindrical	1	-	-	●
		M-RDKT10-D100Z3M12i	0049	.606	1.00	3	-	1.50	Modular	M12	-	0.827	●
		F-RDKT10-D150Z5S050i	0050	1.106	1.50	5	-	1.575	Shell Mill	.50	.63	1.25	●
		F-RDKT10-D200Z6S075i	0051	1.606	2.00	6	-	1.75		.75	.75	1.75	●
RDKT, RDKW 1204	.236	E-RDKT12-D100Z2C100-L700i	0052	.527	1.00	2	-	7.00	Cyindrical	1	-	-	●
		E-RDKT12-D125Z2C125-L800i	0053	.777	1.25	2	-	8.00		1.25	-	-	●
		E-RDKT12-D125Z3C125-L600i	0054	.777	1.25	3	-	6.00		1.25	-	-	●
		M-RDKT12-D100Z2M12i	0055	.527	1.00	2	-	1.50	Modular	M12	-	.827	●
		M-RDKT12-D125Z3M16i	0056	.777	1.25	3	-	1.75		M16	-	1.142	●
		F-RDKT12-D150Z4S050i	0057	1.027	1.50	4	-	1.575	Shell Mill	.50	.63	1.25	●
		F-RDKT12-D200Z5S075i	0058	1.527	2.00	5	-	1.75		.75	.75	1.75	
		F-RDKT12-D250Z6S075i	0059	2.027	2.50	6	-	1.75		.75	.75	1.75	

Milling - Profiling - Inserts

RDKT / W- Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDK* 0501	.197	.055	RDK* 10T3	.394	.157
RDK* 0702	.276	.094	RDK* 1204	.472	.189
RDK* 0802	.315	.094			

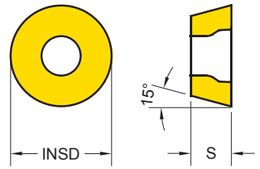
EDP 1200..
●: Stock item ○: Order made item

RDKT RDKW		Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG712	YG603	YG501	YG5020
				P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
RDKT General		RDKT 0802M0	.006 ~ .010	● 0035						
		RDKT 10T3M0	.006 ~ .011	● 0041						
		RDKT 1204M0	.008 ~ .012	● 0034			● 0635			
		RDKT 1604M0	.012 ~ .024	● 0539						
-ST Stainless Steel Super Alloy		RDKT 0802M0 -ST	.003 ~ .010	● 0292						
		RDKT 10T3M0 -ST	.003 ~ .011	● 0293						
		RDKT 1204M0 -ST	.004 ~ .012	● 0294						
-TR Hardened Steel		RDKT 0802M0 -TR	.007 ~ .014	● 0284	● 0339					
		RDKT 10T3M0 -TR	.009 ~ .016	● 0285	● 0338					
		RDKT 1204M0 -TR	.009 ~ .016	● 0272	● 0340					
RDKW Hard Materials		RDKW 0501M0	.004 ~ .008	● 0207	● 0412					
		RDKW 0702M0	.005 ~ .010	● 0208	● 0439					
		RDKW 0802M0	.005 ~ .010	● 0043	● 0440					
		RDKW 10T3M0	.006 ~ .012	● 0040	● 0441					
		RDKW 1204M0	.006 ~ .014	● 0042	● 0442					

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Profiling - Inserts

RDMT / W - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDM* 0802	.315	.094	RDM* 10T3	.394	.156
RDM* 0803	.315	.125	RDM* 1204	.472	.187

EDP 1200..

●: Stock item ○: Order made item

P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15

RDMT RDMW		Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
RDMT General		RDMT 0802M0	.006 ~ .010	● 0245						
		RDMT 0803M0	.006 ~ .010	● 0225						
		RDMT 10T3M0	.007 ~ .011	● 0246						
		RDMT 1204M0	.008 ~ .012	● 0226						
RDMW Hard Materials		RDMW 0802M0	.002 ~ .006	● 0227						
		RDMW 10T3M0	.004 ~ .010	● 0228						
		RDMW 1204M0	.006 ~ .012	● 0229						

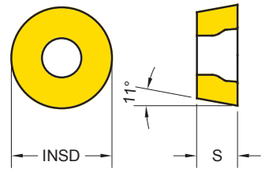
Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

YG MILL INCH

TURNING
PARTING & GROOVING
MILLING
DRILLING
TECHNICAL INFORMATION

Milling - Profiling - Inserts

RPMT / W - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RPM* 08T2	.315	.109	RPM* 1003	.394	.125
RPM* 10T3	.394	.156	RPM* 1204	.472	.187

EDP 1200..

●: Stock item ○: Order made item

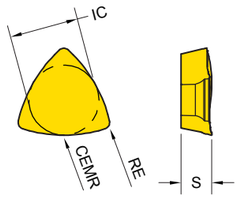
P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15

RPMT RPMW		Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
RPMT General		RPMT 08T2M0	.004 ~ .009	● 0038						
		RPMT 10T3M0	.006 ~ .012	● 0036						
		RPMT 1204M0	.008 ~ .014	● 0037	● 0401	● 0415		● 0463	● 0462	
-ST Stainless Steel Super Alloy		RPMT 1204M0 -ST	.004 ~ .012	● 0230						
RPMW Hard Materials		RPMW 1003M0	.006 ~ .012	● 0204	● 0402					
		RPMW 1204M0	.006 ~ .014	● 0039						

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - Profiling - Inserts

RBEX50 - Profiling / Highfeed (3 Corner)



Series	CEMR	IC	S
RBEX50	.984	.500	.219

EDP 1200..

●: Stock item ○: Order made item

RBEX50	Designation	RE (in)	Fz (in/tooth)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
				P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
RBEX50 General 	RBEX 50	.047	.008 ~ .016	○ 0277	○ 0443					

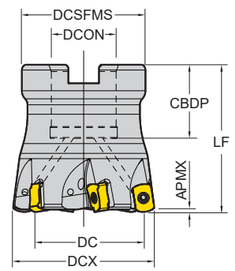
Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

Milling - High Feed Milling - Cutter

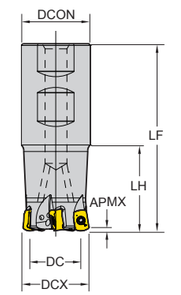
Cutters for ENMX

Cutting Angle : 10°
4 Corner Negative

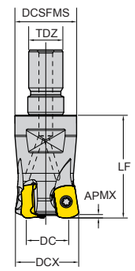
<S> Shell Mill



<W> Weldon



<M> Modular

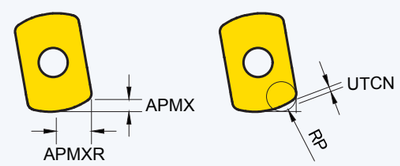


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

○: p. 102 Unit : inch

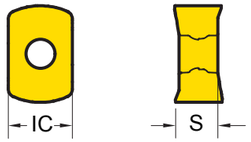
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	
ENMX 0604	.04	EHF-ENMX06-D0625Z2W0625-L500I	0759	.296	.625	2	5	Weldon	.625	1.25	-	-	●
		EHF-ENMX06-D075Z3W075-L500I	0669	.435	.75	3	5.0		.750	2.00	-	-	●
		EHF-ENMX06-D100Z4W100-L550I	0670	.671	1.00	4	5.5		1.00	2.50	-	-	●
		EHF-ENMX06-D125Z5W125-L600I	0671	.905	1.25	5	6.0		1.25	3.00	-	-	●
		FHF-ENMX06-D150Z6S050I	0672	1.15	1.50	6	1.575	Shell Mill	.500		.75	1.34	●
		FHF-ENMX06-D200Z6S075I	0673	1.62	2.00	6	1.969		.750		.75	1.57	●
		FHF-ENMX06-D300Z10S100I	0760	2.54	3.00	10	2.48		1.00		1.024	2.835	●
		MHF-ENMX06-D0625Z2M08	0761	.296	.625	2	1	Modular	M08	-	-	.512	●
		MHF-ENMX06-D0705Z2M08	0762	.377	.705	2	1		M08	-	-	.512	●
		MHF-ENMX06-D075Z3M10	0763	.435	.75	3	1.25		M10	-	-	.709	●
		MHF-ENMX06-D083Z3M10	0764	.504	.83	3	1.25		M10	-	-	.709	●
		MHF-ENMX06-D100Z4M12	0765	.671	1.00	4	1.5		M12	-	-	.827	●
		MHF-ENMX06-D1125Z4M12	0766	.789	1.125	4	1.5		M12	-	-	.827	●
		MHF-ENMX06-D125Z5M16	0767	.905	1.25	5	1.75		M16	-	-	1.142	●
		MHF-ENMX06-D1375Z5M16	0768	1.025	1.375	5	1.75		M16	-	-	1.142	●
		MHF-ENMX06-D150Z6M16	0769	1.15	1.50	6	1.75		M16	-	-	1.142	●

Technical Information



DCX Cutting Diameter Maximum	APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
.625	.137	R.079	.012	.000
.625 ~	.145	R.098	.007	.007
		R.118	.003	.014

ENMX - High Feed Negative (4 Corners)



Series	IC	S
ENMX0604	.248	.166

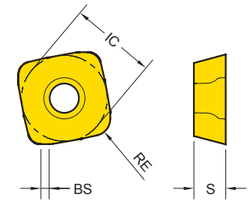
EDP 1200..
●: Stock item ○: Order made item

ENMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
ENMX General	ENMX 0604		.012 ~ .079		● 0474						
- TR Hardened Steel	ENMX 0604 -TR		.012 ~ .098		● 0459						

DCX External Cutter Diameter	APMX Maximum Depth of Cut	APMXR Maximum Radial Depth of Cut	RMPX Maximum Ramping Angle(°)	RP Programmed Corner Radius	UTCN Uncut Thickness	Diameter Minimum Cutting Diameter	Diameter Maximum Cutting Diameter	Pitch Helical Interpolation Pitch	Ae Enlarge Width
.625	.035	.137	3.4°	R.079	.011	.817	1.171	.035	.487
.75	.039	.145	2.0°	R.079	.012	1.067	1.421	.039	.604
1	.039	.145	1.2°	R.079	.012	1.567	1.921	.039	.854
1.25	.039	.145	0.9°	R.079	.012	2.067	2.421	.039	1.104
1.5	.039	.145	0.7°	R.079	.012	2.567	2.921	.039	1.354
2	.039	.145	0.5°	R.079	.012	3.567	3.921	.039	1.854

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-

SDMT / W - High Feed Positive (4 Corners)



Series	IC	S
SDM* 1204	.500	.185

EDP 1200..
●: Stock item ○: Order made item

SDMT SDMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
					P25 M30 K30 S20	P30 K30	P20	P30	P40 M35 S30	K15 H15	K15
-ST Stainless Steel Super Alloy	SDMT 120420 -ST	.075	.024 ~ .047	.057	● 0274						
SDMW Hard Materials	SDMW 120420	.075	.024 ~ .055	.055	● 0273	● 0341		● 0634			

Cutting Speed			Vc (ft/min)											
ISO	VDI	Sub Group	YG602 Min	YG602 Max	YG622 Min	YG622 Max	YG712 Min	YG712 Max	YG713 Min	YG713 Max	YG603 Min	YG603 Max	YG501 Min	YG501 Max	YG5020 Min	YG5020 Max
P	1~5	Non-Alloyed Steel	460	1250	460	1310	560	980	490	920	295	755	-	-	-	-
P	6~9	Low-Alloyed Steel	390	980	390	1050	590	820	430	770	230	689	-	-	-	-
P	10~11	High-Alloyed Steel	230	490	230	560	330	460	300	430	197	328	-	-	-	-
M	12~13	Ferritic & Martensitic	390	660	-	-	-	-	-	-	262	591	-	-	-	-
M	14	Austenitic Stainless Steel	430	820	-	-	-	-	-	-	328	656	-	-	-	-
K	15~16	Grey Cast Iron	390	820	390	890	-	-	-	-	-	-	590	1150	660	1150
K	17~18	Nodular Cast Iron	430	720	430	790	-	-	-	-	-	-	390	890	490	980
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	80	150	-	-	-	-	-	-	66	131	-	-	-	-
H	38~41	Hard Materials	130	260	130	330	-	-	160	330	-	-	-	-	-	-