

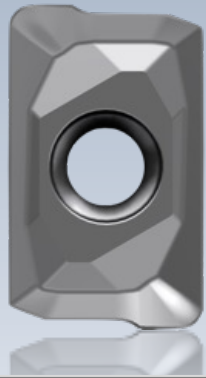
APKT 10 & 16

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Shoulder Milling Line

# FAMILIES

## APKT "Athens"



High End Line  
**Extreme performance & Cutters**  
SOLUTION

## APKT "Utility"

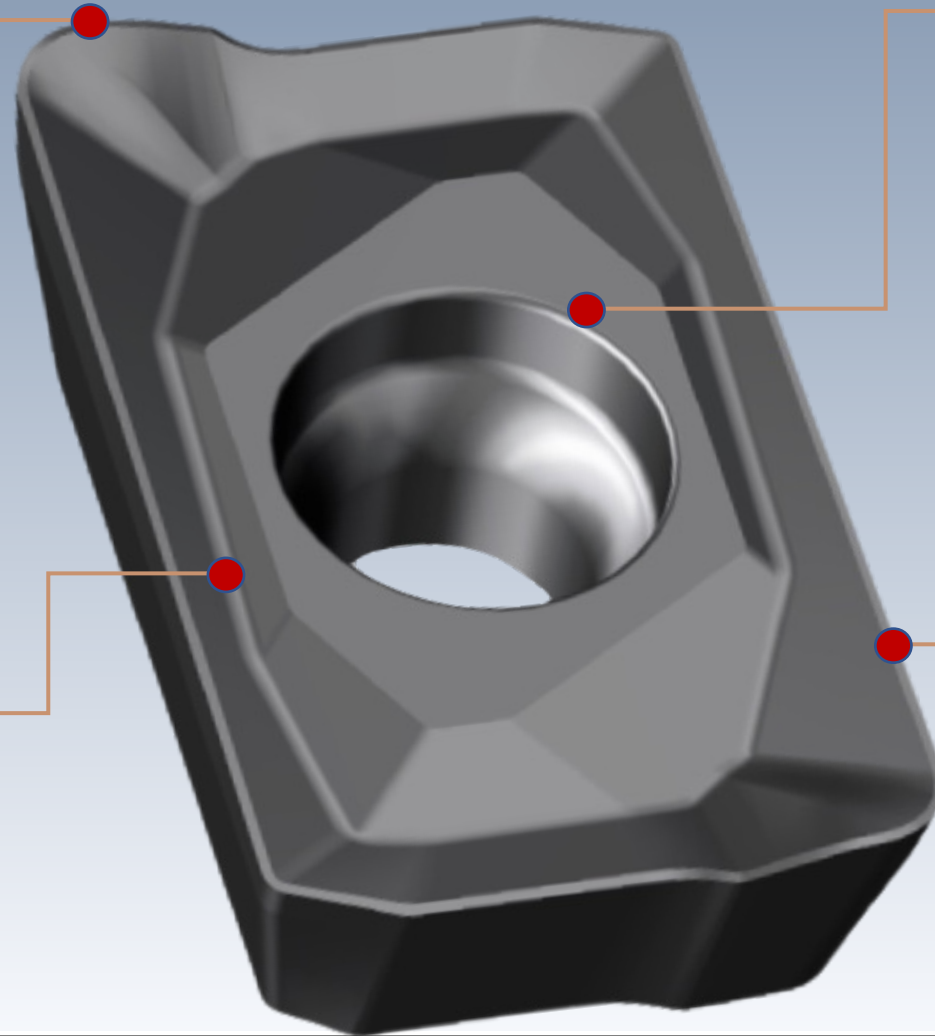


Utility Line  
**Cost-Effective & Iscar compatible**  
SOLUTION

# ATHENS Features

PATENTED  
**WIPPER**  
DESIGN

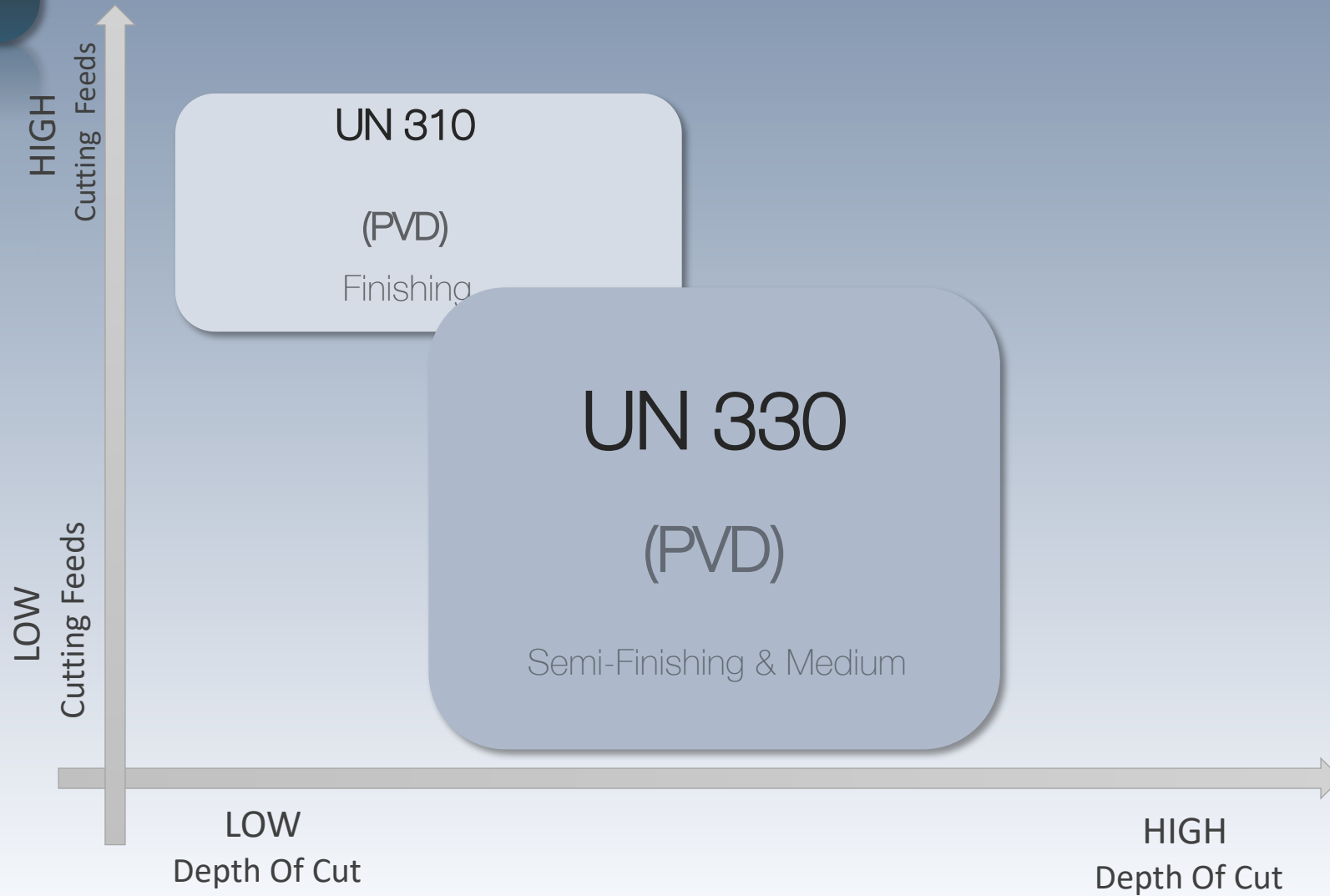
UNIQUE  
**PVD**  
COATING



COMPLITE  
**SCREW**  
PROTECTION

ADVANCED  
**CUTTING EDGE**  
DESIGN

# GRADES



# GRADES

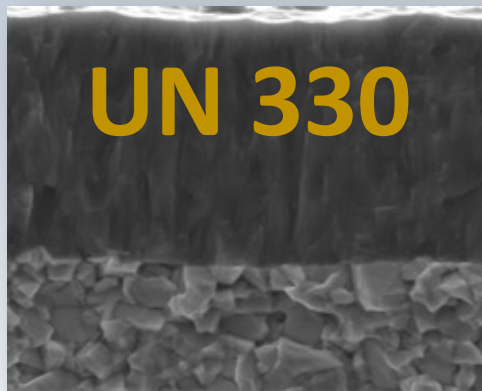
## UN 310



Extremely HARD grade – for Finishing conditions

- Sub-Micron substrate
- Hyper pulsed - PVD coating
- For High wear resistance in high feed & Finishing conditions

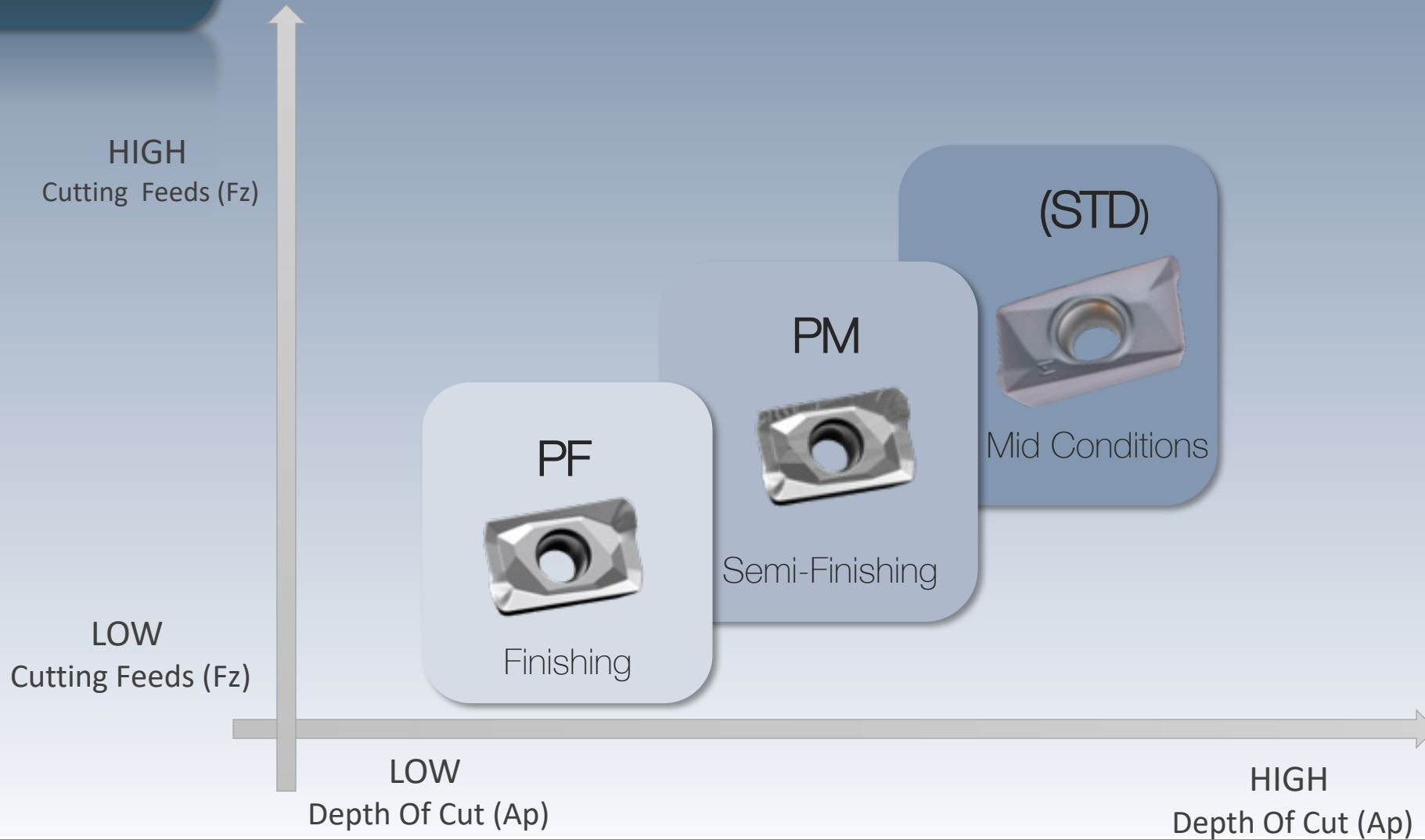
## UN 330



FIRST Choice – General Purpose grade

- Sub-Micron substrate
- Ultra Thick - Hyper pulsed - PVD coating
- Effective balance for excellent - Toughness and wear resistance

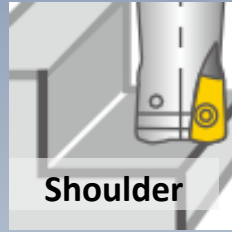
# CHIP BREAKERS



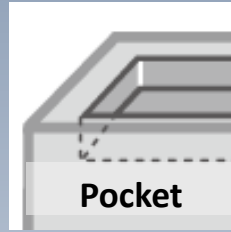
# APPLICATION



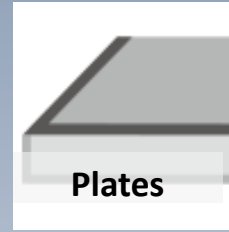
APKT 10308



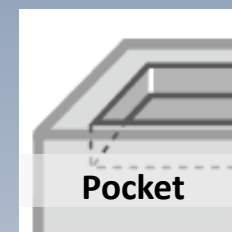
Shoulder



Pocket



Plates



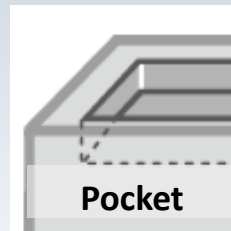
Pocket



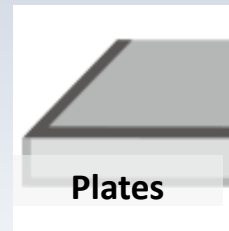
APKT 1604



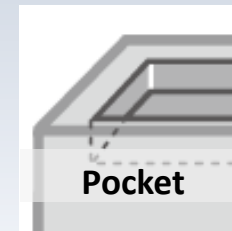
Shoulder



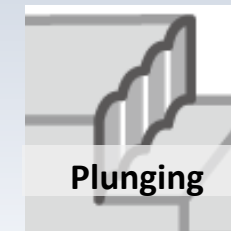
Pocket



Plates



Pocket



Plunging



Ramping

# INSETS

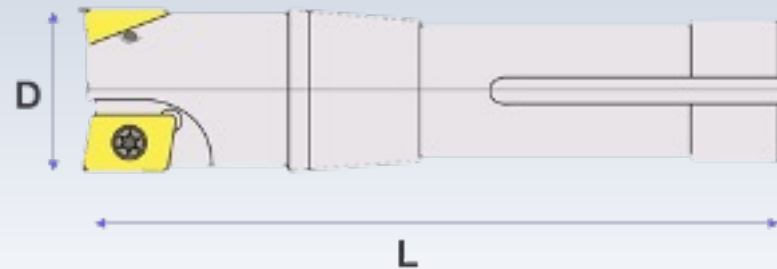
Cat. Num.	Description	Grades	Line	Compatibility	Application
2100000140	APKT 100308 PDTR PF UN330	UN 330	Athens	Iscar	P 10 - P 20 M 05 - M 15
2100000100	APKT 100308 PDTR UF UN330	UN 330	Utility	Iscar	P 10 - P 20 P 15 - P 25
2100000200	APKT 100305 PDTR PF UN330	UN 330	Utility	Iscar	P 10 - P 20 P 15 - P 25
2100000182	APKT 1604 PDTR PM UN330	UN 330	Athens	Iso	P 10 - P 20 P 15 - P 25 M 05 - M 15 M 10 - M 15
2100000102	APKT 160408 PDTR STD UN330	UN 330	Utility	Iscar	P 15 - P 30 P 15 - P 30



# CUTTERS

APKT 10

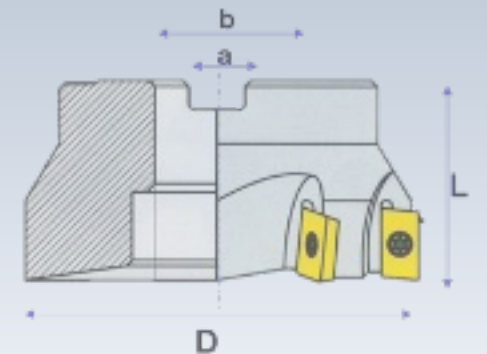
			D	L	Z
End Mill	2800000100	AP10 –EM- 16 – Z2 - 85	16	85	2
End Mill	2800000102	AP10 – EM- 20 – Z3 - 85	20	85	3
End Mill	2800000104	AP10 – EM- 25 – Z4 - 95	25	95	4
Face Mill	2800000108	AP10 – FM- 40 – Z6 - 40	40	40	6



# CUTTERS

APKT 16

			D	L	Z
End Mill	2800000110	AP16-EM-25-Z2-95	25	95	2
End Mill	2800000112	AP16-EM-32-Z3-95	32	95	3
Face Mill	2800000114	AP16-FM-50-Z5-40	50	40	5
Face Mill	2800000116	AP16-FM-63-Z6-40	63	40	6
Face Mill	2800000118	AP16-FM-80-Z7-50	80	50	7

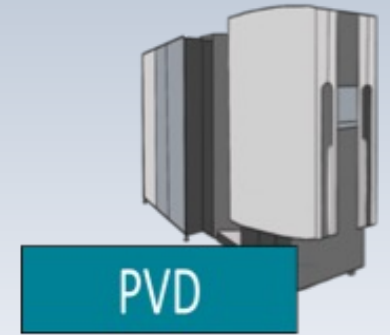
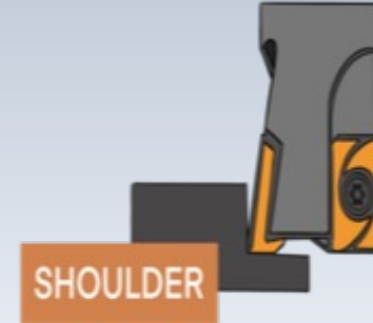


# APKT 10

## Cutting conditions

- High Performance
- For General Purpose
- Optimized for Steel, Stainless Steel and Cast Iron
- Standard dimensions- will fit Most Cutters
- Use without coolant

	(P) STEEL	(M) STAINLESS STEEL	(K) CAST IRON	
Vc	120 - 190	Vc 130 - 190	Vc 120 - 220	CUTTING CONDITIONS
fz	0.1 - 0.22	fz 0.12 - 0.2	fz 0.1 - 0.22	
Ap	0,5 - 9	Ap 0,5 - 9	Ap 0,5 - 9	



# APKT 16

## Cutting conditions

- High Performance
- For General Purpose
- Optimized for Steel, Stainless Steel and Cast Iron
- Athens inserts - will fit ISO cutters
- Use without coolant

	(P) STEEL	(M) STAINLESS STEEL	(K) CAST IRON	CUTTING CONDITIONS
Vc	130 - 190	Vc 150 - 200	Vc 150 - 220	
Fz	0.17 - 0.28	Fz 0.19 - 0.29	Fz 0.15 - 0.26	
Ap	0,5 - 15	Ap 0,5 - 15	Ap 0,5 - 15	

