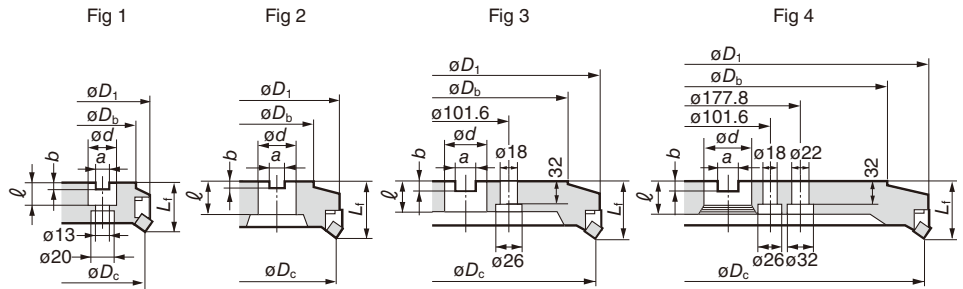


Rake Angle	Radial	-2°
	Axial	+18°



P	M	K	N	N	S	H
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Aluminum	Exotic Alloy	Hardened Steel

General Milling for Aluminium Alloy and Low Carbon Steel



Body

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
				ϕD_c	ϕD_1	ϕD_b	L_1	ϕd	a	b	l			
APG 4080R	●	APG 4080L		*80	90	60	50	25.4	9.5	6	25	5	1.6	1
4100R	●	4100L		100	110	75	60	31.75	12.7	8	32	5	2.7	2
4125R	●	4125L		125	134	75	60	38.1	15.9	10	38	6	4.0	2
4160R	●	4160L		160	169	100	60	50.8	19.1	11	38	8	6.5	2
4200R	●	4200L		200	208	130	60	47.625	25.4	13.5	38	10	9.1	3
APG 4250R	●	APG 4250L		250	258	200	70	47.625	25.4	13.5	40	12	18.3	3
4315R	●	4315L		315	323	240	70	47.625	25.4	13.5	40	16	27.6	3
4400R		4400L		400	408	300	70	63.5	25.4	13.5	45	20		4
4500R		4500L		500	508	400	70	63.5	25.4	13.5	45	24		4

Inserts are not included.

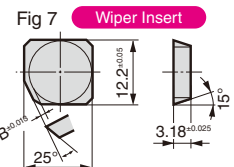
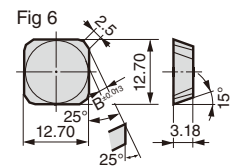
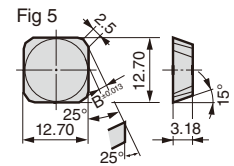


*Please use hexagonal bolt (JIS B1176) M12x30 to 35 mm for securing $\phi 80$ cutter to the arbor.

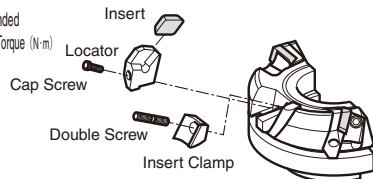
Inserts

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Grade	Coated Carbide		Carbide		Cermet			DLC	SUMIDIA		Fig				
	Application		Application		Application			Application	Application						
	High Speed/Light	General Purpose	High Speed/Light	General Purpose	High Speed/Light	General Purpose	High Speed/Light	High Speed/Light	General Purpose	High Speed/Light					
Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	H1	T1500A	T1200A	T250A	DL1000	DA1000	DA2200	
SDCH 42TR							●								5
42TL															5
42TR-R											●				5
42TL-R															5
SDC 42R							●				●				6
NF-SDC 42R													●	▲	6
SDC 42L							●								6
42TR							●								6
42TL															6
42TR-R											●				6
42TL-R															6
APW 4R									●	▲			●	▲	7



Double Screw (Common)	Size	(N·m)	Recommended Tightening Torque (N·m)
	M8	8.0	
Cap Screw	Size	(N·m)	
	M5	5.0	



Spare Parts

Applicable Cutters	Locator	Insert Clamp	Double Screw	Cap Screw	Spanner
APG4080R	LAP40R	ATW45R	WB8-20	BFX0520R	TH040
APG4100R to APG4500R	LAP40R	ATW45R	WB8-22TL	BFX0520R	TT27
APG4080L	LAP40L	ATW45L	WB8-20	BFX0520R	TH040
APG4100L to APG4500L	LAP40L	ATW45L	WB8-22T	BFX0520R	TT27

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	100-125-150	0.10-0.18-0.25	A30N
	Soft Steel	≤ 180 HB	120-150-180	0.10-0.18-0.25	A30N
	Die Steel	200 to 220HB	60-80-100	0.10-0.18-0.25	A30N
M	Stainless Steel	-	120-150-180	0.10-0.18-0.25	A30N
K	Cast Iron	250HB	60-90-120	0.15-0.23-0.30	H1
N	Non-Ferrous Alloy	-	300-650-1000	0.10-0.20-0.30	H1

Note: The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

▲mark : To be replaced by new item (Please confirm stock availability)