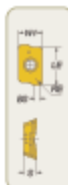




FAMILY

			W1	LE	RE	S	BS
2100000200	APKT 100305 PDTR PF UN330	UN330	6.70	10.95	0.50	3.50	0.90
2100000140	APKT 100308 PDTR PF UN330	UN330	6.72	11.05	0.50	3.62	1.00
2100000100	APKT 100308 PDTR UF UN330	UN330	6.72	11.05	0.80	3.52	1.00
2100000102	APKT 1604 PDTR PM UN330	UN330	9.40	16.00	0.80	4.76	1.50
2100000102	APKT 160408 PDTR STD UN330	UN330	9.40	16.00	0.80	4.76	1.80



PRODUCT - LINE UP



CHIP BREAKERS

PF / UF

- Sharp Chip-breaker
- for Finishing and sticky material
- **Recommended Feed (Fz) : 0.15 (mm/tooth)**

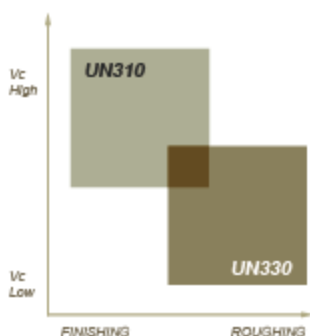
(STD)

- Mid & Roughing conditions Chip-Breaker
- for General-tough or unstable machining conditions
- **Recommended Feed (Fz) : 0.28 (mm/tooth)**

PM

- Semi Finishing chip Breaker for General Machining
- First Choice for stable conditions
- **Recommended Feed (Fz) : 0.20 (mm/tooth)**

GRADE



UN330

- Sub Micron Substrate & Hyper Pulsed PVD coating.
- General Purpose MILLING Applications.
- Where a good balance of wear resistance and toughness is required.
- First Choice for Milling in all condition.

CUTTING CONDITIONS

(P) STEEL

Vc	110 - 190
Fz	0.10 - 0.22
Ap	0.5 - 0.0

(M) STAINLESS STEEL

Vc	110 - 190
Fz	0.12 - 0.20
Ap	0.5 - 0.0

(K) CAST IRON

Vc	110 - 220
Fz	0.10 - 0.22
Ap	0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	160	Fz	0.16	Ap	2.0
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Iscar-76 Line

APKT 100308 PDTR PF UN330

(P) STEEL

Vc	110 - 190
Fz	0.11 - 0.18
Ap	0.5 - 0.0

(M) STAINLESS STEEL

Vc	110 - 190
Fz	0.13 - 0.21
Ap	0.5 - 0.0

(K) CAST IRON

Vc	110 - 220
Fz	0.13 - 0.20
Ap	0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	160	Fz	0.16	Ap	2.0
----	-----	----	------	----	-----

Iscar-HM Line

APKT 100308 PDTR UF UN330

(P) STEEL

Vc	110 - 190
Fz	0.10 - 0.22
Ap	0.5 - 0.0

(M) STAINLESS STEEL

Vc	110 - 190
Fz	0.12 - 0.20
Ap	0.5 - 0.0

(K) CAST IRON

Vc	110 - 220
Fz	0.10 - 0.22
Ap	0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	160	Fz	0.16	Ap	2.0
----	-----	----	------	----	-----

Iscar-76 Line

APKT 1604 PDTR PM UN330

(P) STEEL

Vc	110 - 190
Fz	0.17 - 0.28
Ap	0.5 - 15.0

(M) STAINLESS STEEL

Vc	110 - 190
Fz	0.19 - 0.29
Ap	0.5 - 15.0

(K) CAST IRON

Vc	110 - 220
Fz	0.15 - 0.20
Ap	0.5 - 15.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	160	Fz	0.23	Ap	2.0
----	-----	----	------	----	-----

Iso

APKT 160408 PDTR STD UN330

(P) STEEL

Vc	110 - 190
Fz	0.22 - 0.35
Ap	0.5 - 15.0

(M) STAINLESS STEEL

Vc	110 - 190
Fz	0.24 - 0.35
Ap	0.5 - 15.0

(K) CAST IRON

Vc	150 - 220
Fz	0.20 - 0.32
Ap	0.5 - 15.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

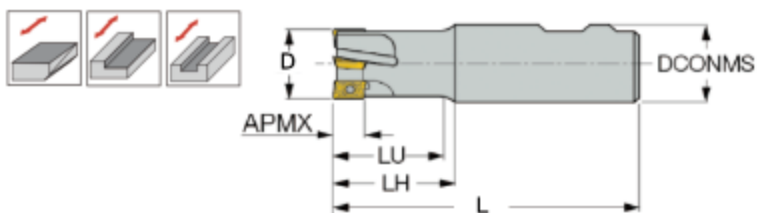
Vc	160	Fz	0.29	Ap	2.0
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Iscar-76 Line

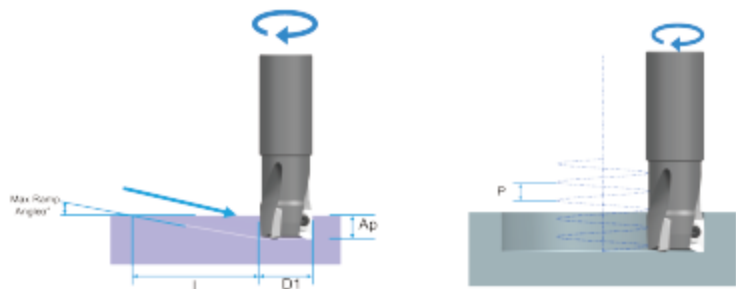
APKT
APMT
RDHX
RDMT
RPMT
SDMT
SEKN
SEKT
SNMX
SPKN
TPKN
WNMX



			D	L	Z
2800000100	End Mill	AP10-EM-16-Z2-85	16	85	2
2800000102	End Mill	AP10-EM-20-Z3-85	20	85	3
2800000104	End Mill	AP10-EM-25-Z4-95	25	95	4
2800000106	End Mill	AP10-EM-32-Z5-95	32	95	5
2800000108	Face Mill	AP10-FM-40-Z6-40	40	40	6



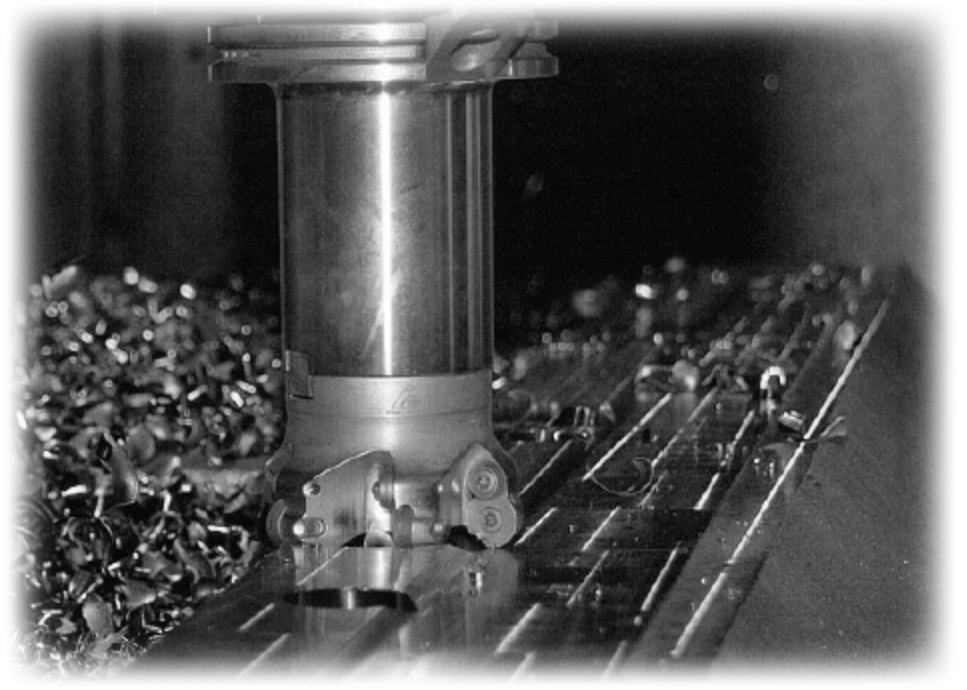
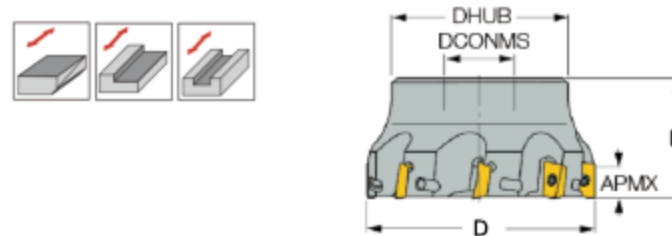
PROGRAMING DATA



Cutter Dia D1	Straight Ramp down			Helical Ramp down		
	Max. Ramp(A)	Max. ap(mm)	Min Length(L)	Max. Dia(HD)	Max. Dia(HD)	Max. Pitch(P)
16	3.3	0.6	112	112	32	1.3
20	2.1	0.6	177	177	40	2.9
				240	60	1.3
26	1.5	0.6	240	240	80	2.0
				372	64	1.3
32	1.0	0.6	372	372	64	1.7



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





FAMILY

			IC	RE	S	BS
2100000126	SEKT 1204 AFTN PF	UN330	12.70	1.00	4.85	1.20
2100000190	SEKT 1204 AFTN PM	UN310	12.70	1.00	4.05	1.20
2100000162	SEKT 1204 AFTN PM	UN330	12.70	1.00	4.85	1.00
2100000120	SEKT 12T3 AGSN PM	UN330	12.70	0.90	3.97	1.20



PRODUCT - LINE UP



CHIP BREAKERS

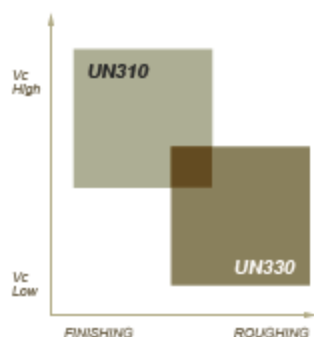
PF

- Sharp Chip-breaker
- for Finishing and sticky material
- **Recommended Feed (Fz) : 0.20 (mm/tooth)**

PM

- Semi Finishing chip Breaker for General Machining
- First Choice for stable conditions
- **Recommended Feed (Fz) : 0.28 (mm/tooth)**

GRADE



UN310

- Sub Micron Substrate & Hyper Pulsed PVD coating.
- Suitable for Medium to High Cutting Speed in MILLING Application with a focus on wear resistance.
- An excellent option for Milling in stable condition.

UN330

- Sub Micron Substrate & Hyper Pulsed PVD coating.
- Excellent for high-Feed MILLING Applications.
- where wear resistance is required.
- First Choice for Milling all materials.

CUTTING CONDITIONS

(P)
STEEL

Vc 110 - 190
Fz 0.14 - 0.28
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M)
STAINLESS STEEL

Vc 110 - 190
Fz 0.10 - 0.32
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
Iscar, Walter

SEKT 1204 AFTN PF UN330

(K)
CAST IRON

Vc 110 - 200
Fz 0.12 - 0.38
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
Ap 2.0

SEKT 1204 AFTN PM UN 310

(P)
STEEL

Vc 110 - 220
Fz 0.18 - 0.38
Ap 0.5 - 4.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M)
STAINLESS STEEL

Vc 110 - 220
Fz 0.20 - 0.38
Ap 0.5 - 4.0

RECOMMENDED CONDITIONS
Iscar, Walter

(K)
CAST IRON

Vc 110 - 220
Fz 0.10 - 0.40
Ap 0.5 - 4.0

RECOMMENDED CONDITIONS
Ap 1.7

SEKT 1204 AFTN PM UN330

(P)
STEEL

Vc 110 - 190
Fz 0.18 - 0.38
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M)
STAINLESS STEEL

Vc 110 - 190
Fz 0.20 - 0.38
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
Iscar, Walter

(K)
CAST IRON

Vc 110 - 200
Fz 0.10 - 0.40
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
Ap 2.0

SEKT 12T3 AGSN PM UN330

(P)
STEEL

Vc 110 - 190
Fz 0.15 - 0.32
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M)
STAINLESS STEEL

Vc 110 - 190
Fz 0.15 - 0.32
Ap 0.5 - 0.0

RECOMMENDED CONDITIONS
Sandvik

(K)
CAST IRON

Vc 110 - 200
Fz 0.18 - 0.40
Ap 0.5 - 0.0

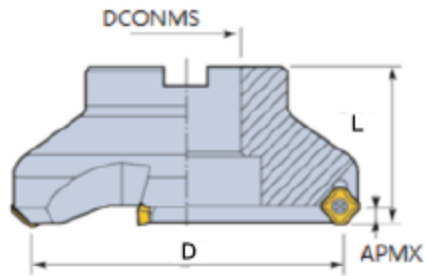
RECOMMENDED CONDITIONS
Ap 2.0

SEKT 1204-CUTTERS



D L Z

2800000130	Face Mill	SE1204-FM-50-Z4-40	50	40	4
2800000132	Face Mill	SE1204-FM-63-Z5-50	63	50	5
2800000134	Face Mill	SE1204-FM-80-Z6-50	80	50	6

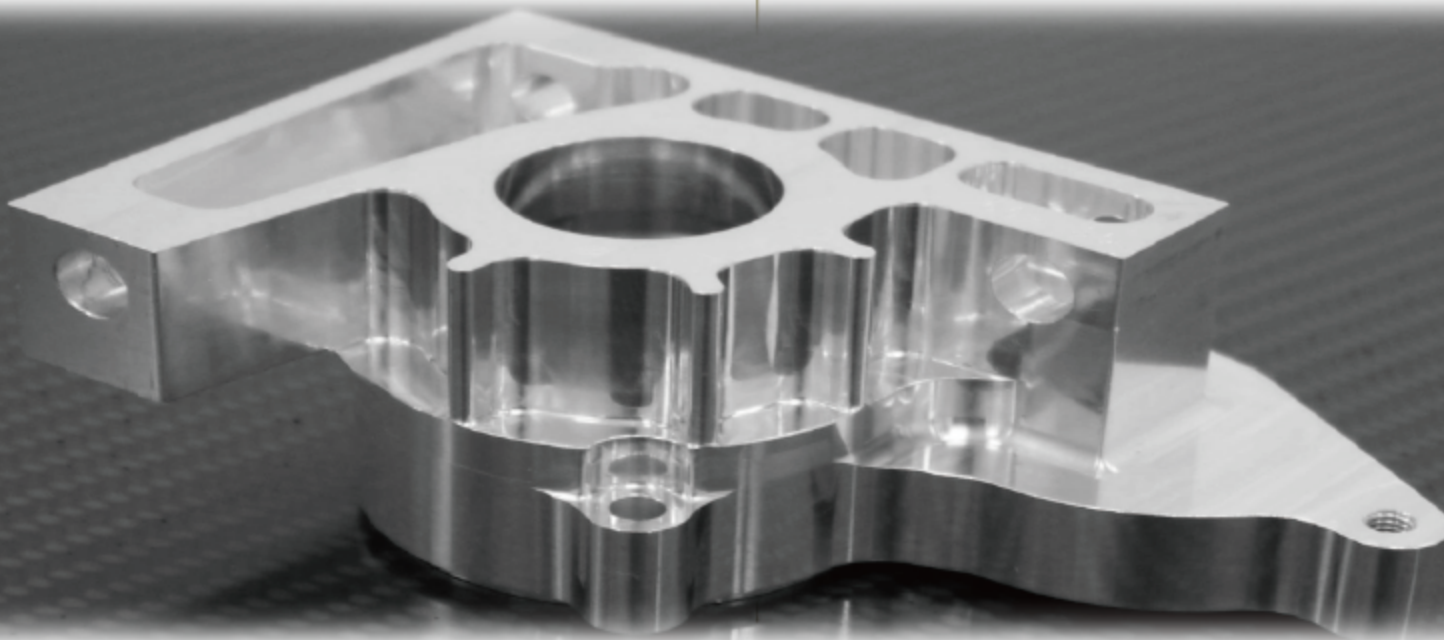
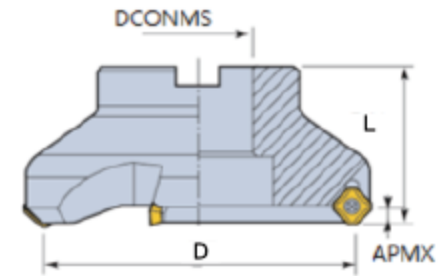


SEKT 12T3-CUTTERS



D L Z

2800000136	Face Mill	SE12T3-FM-50-Z4-40	50	40	4
2800000138	Face Mill	SE12T3-FV-63-75-40	63	40	5
2800000140	Face Mill	SE12T3-FM-80-Z6-50	80	50	6



APKT

APMT

RDHX

RDMT

RPMT

SDMT

SEKN

SEKT

SNMX

SPKN

TPKN

WNMX



FAMILY

			L	RE	S	BS
2100000122	SPKN 1203 PDTR	UN330	12.70	0.80	3.18	1.10
2100000216	SPKN 1604 PDTR	UN330	16.05	1.00	4.76	1.40
2100000124	SPKR 1203 PDTR	UN330	12.70	0.80	3.18	1.10



PRODUCT - LINE UP



CHIP BREAKERS

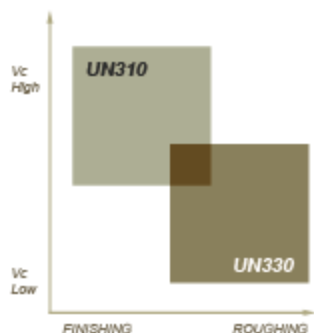
(R)

- Semi Finishing chip Breaker for General Machining
- First Choice for stable conditions
- Recommended Feed (Fz) : 0.20 (mm/tooth)

(N)

- Mid. conditions - flat top
- for General-tough or unstable machining conditions
- Recommended Feed (Fz) : 0.25 (mm/tooth)

GRADE



UN330

- Sub Micron Substrate & Hyper Pulsed PVD coating.
- Excellent for high-Feed MILLING Applications.
- where wear resistance is required.
- First Choice for Milling all materials.

CUTTING CONDITIONS

(P) STEEL

Vc	110 - 190
Fz	0.15 - 0.30
Ap	0.5 - 7.0

(M) STAINLESS STEEL

Vc	
Fz	
Ap	

(K) CAST IRON

Vc	110 - 200
Fz	0.18 - 0.43
Ap	0.5 - 7.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	100	Fz	0.23	Ap	2.0
----	-----	----	------	----	-----

ISO

(P) STEEL

Vc	110 - 190
Fz	0.17 - 0.30
Ap	0.5 - 12.0

(M) STAINLESS STEEL

Vc	
Fz	
Ap	

(K) CAST IRON

Vc	110 - 200
Fz	0.18 - 0.43
Ap	0.5 - 12.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	160	Fz	0.24	Ap	1.7
----	-----	----	------	----	-----

ISO

(P) STEEL

Vc	110 - 190
Fz	0.15 - 0.30
Ap	0.5 - 7.0

(M) STAINLESS STEEL

Vc	150 - 210
Fz	0.15 - 0.30
Ap	0.5 - 7.0

(K) CAST IRON

Vc	110 - 200
Fz	0.18 - 0.43
Ap	0.5 - 7.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

Vc	100	Fz	0.23	Ap	2.0
----	-----	----	------	----	-----

ISO

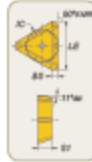
APKT
APMT
RDHX
RDMT
RPMT
SDMT
SEKN
SEKT
SNMX
SPKN
TPKN
WNMX

SPKN / SPKR



FAMILY

			IC	LE	RE	S	BS
2100000110	TPKN 1603 PDTR	UN330	9.52	13.90	0.50	3.18	0.90
2100000146	TPKN 2204 PDTR	UN330	12.70	19.12	0.60	4.76	1.20
2100000112	TPKR 1603 PPR	UN330	9.52	13.90	0.50	3.18	0.90
2100000146	TPKR 2204 PDTR	UN330	12.70	19.12	0.60	4.76	1.20



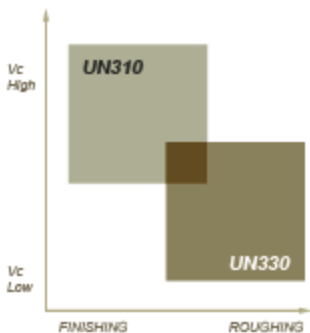
PRODUCT - LINE UP



CHIP BREAKERS

- | | |
|---|--|
| <p>(R)</p> <ul style="list-style-type: none"> - Semi Finishing chip Breaker for General Machining - First Choice for stable conditions - Recommended Feed (Fz) : 0.20 (mm/tooth) | <p>(N)</p> <ul style="list-style-type: none"> - Mid. conditions - flat top - for General-tough or unstable machining conditions - Recommended Feed (Fz) : 0.25 (mm/tooth) |
|---|--|

GRADE



UN330

- Sub Micron Substrate & Hyper Pulsed PVD coating.
- Excellent for high-Feed MILLING Applications.
- Where wear resistance is required.
- First Choice for Milling all materials.

CUTTING CONDITIONS

(P) STEEL

Vc	110 - 190
Fz	0.16 - 0.25
Ap	0.5 - 12.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M) STAINLESS STEEL

Vc	
Fz	
Ap	

ISO

TPKN 1603 PDTR UN330

(K) CAST IRON

Vc	110 - 220
Fz	0.15 - 0.27
Ap	0.5 - 12.0

Vc	160	Fz	0.21	Ap	2.0
----	-----	----	------	----	-----

(P) STEEL

Vc	110 - 190
Fz	0.18 - 0.30
Ap	0.5 - 18.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M) STAINLESS STEEL

Vc	
Fz	
Ap	

ISO

TPKN 2204 PDTR UN330

(K) CAST IRON

Vc	110 - 220
Fz	0.18 - 0.32
Ap	0.5 - 18.0

Vc	160	Fz	0.24	Ap	2.0
----	-----	----	------	----	-----

(P) STEEL

Vc	110 - 190
Fz	0.12 - 0.19
Ap	0.5 - 12.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M) STAINLESS STEEL

Vc	140 - 200
Fz	0.13 - 0.19
Ap	0.5 - 12.0

ISO

TPKR 1603 PPR UN330

(K) CAST IRON

Vc	110 - 220
Fz	0.14 - 0.27
Ap	0.5 - 12.0

Vc	160	Fz	0.16	Ap	2.0
----	-----	----	------	----	-----

(P) STEEL

Vc	110 - 190
Fz	0.16 - 0.25
Ap	0.5 - 18.0

RECOMMENDED CONDITIONS
CUTTER COMPATIBLE

(M) STAINLESS STEEL

Vc	140 - 200
Fz	0.16 - 0.25
Ap	0.5 - 18.0

ISO

TPKR 2204 PDTR UN330

(K) CAST IRON

Vc	110 - 220
Fz	0.16 - 0.27
Ap	0.5 - 18.0

Vc	160	Fz	0.21	Ap	2.0
----	-----	----	------	----	-----