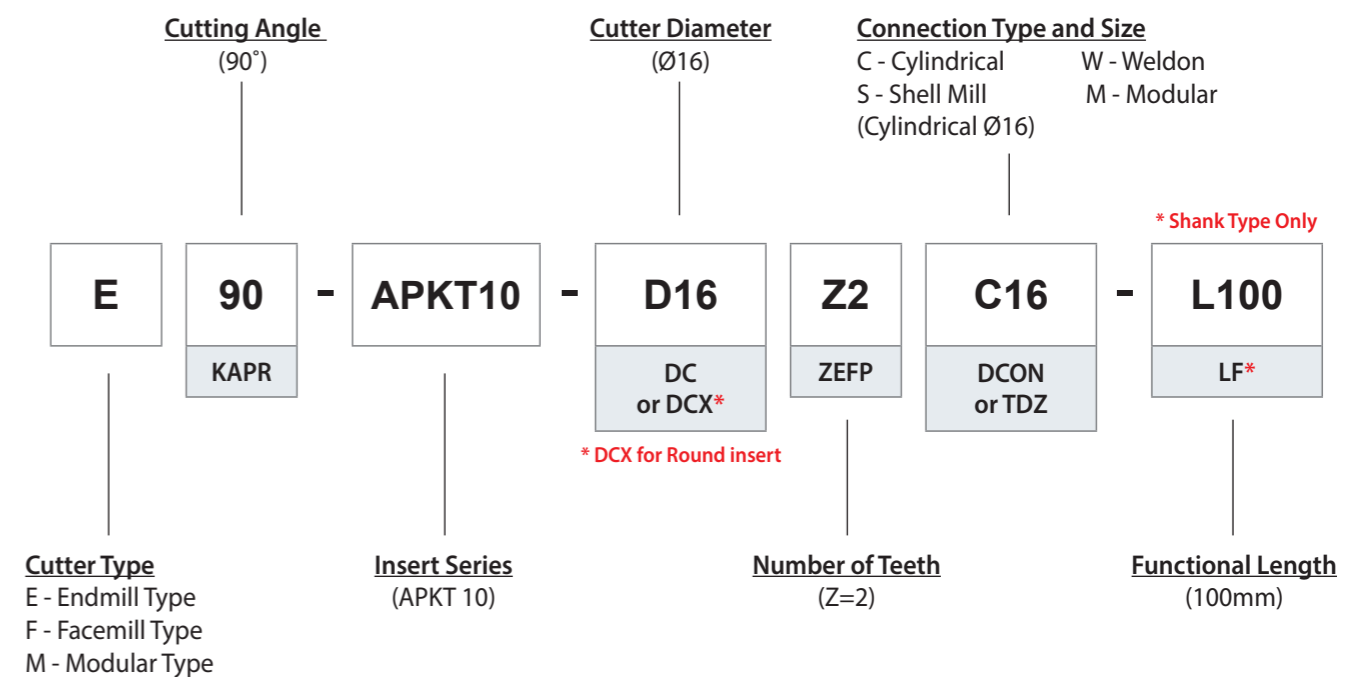
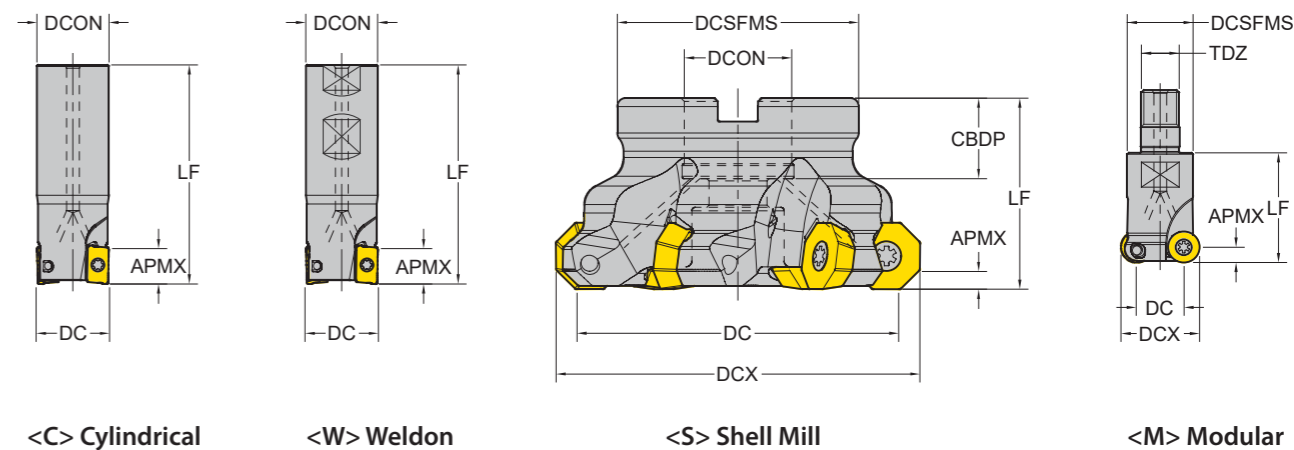




MILLING

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

Code Keys - Milling Cutters



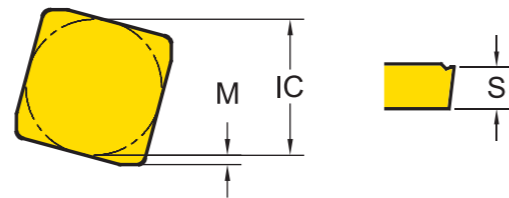
1 A Shape	2 P Relief Angle (AN)	3 K Tolerance	4 T Clamping & Chipbreaker	5 16 Insert Size	6 04 Insert Thickness (S)	7 08 CornerRadius
------------------------	------------------------------------	----------------------------	---	-------------------------------	--	--------------------------------

1 - Shape

Symbol	Shape	Diagram
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)	Diagram
N	No Relief Angle	
B	Relief 5°	
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	



3 - Tolerance Class

Symbol	Inner Grade IC (mm)	Nose Height M (mm)	Thickness S (mm)
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
H	± 0.013	± 0.013	± 0.025
K*	± 0.05~0.15*	± 0.013	± 0.025
M*	± 0.05~0.15*	± 0.08~0.2*	± 0.13
U*	± 0.08~0.25*	± 0.13~0.38*	± 0.13

*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

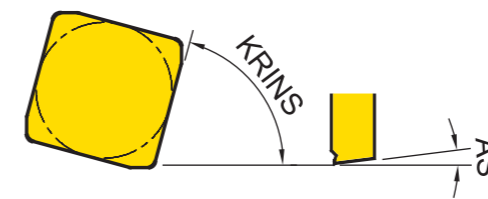
* No Standard for milling insert thickness

8 PDTR Corner Geometry	9 -TR Chipbreaker	10 YG602 Grade
-------------------------------------	--------------------------------	-----------------------------

7 - Corner Radius (RE)

Symbol	Thickness - S (mm)	Symbol	Thickness - S (mm)
04	0.4	16	1.6
08	0.8	20	2.0
12	1.2	24	2.4

8 - Corner Geometry



8-1 P Cutting Edge Angle (KRINS)	8-2 D Wiper Edge Clearance (AS)	8-3 T Edge Condition	8-4 R Feed Direction
---	--	-----------------------------------	-----------------------------------

*Refer to page. 109 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	Diagram
F	Sharp	
E	Rounded	
T	Chamfered	
S	Chamfered and Rounded	

8-4 - Feed Direction

Symbol	Feed Direction	Diagram
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																			
	YG613			613			613														
	YG501										501										
CVD	YG5020										5020										
Uncoated	YG50														50						

YG602 P20 - P35 M20 - M40 K20 - K40 S15 - S25		Universal grade for General Milling Application <ul style="list-style-type: none"> 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		Milling Grade for Medium of Steel Application <ul style="list-style-type: none"> Superior wear resistance and excellent toughness in high speed machining Coating layer with high hardness and oxidation resistance
YG713 P15 - P25		Milling Grade for General Steel Application <ul style="list-style-type: none"> Multi-layer TiAlN structure realizes stronger crater and flank wear resistance Fine-grained carbide and balanced substrate
YG613 P30 - P50 M30 - M40		Milling Grade for Stainless Steel Application <ul style="list-style-type: none"> 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 <ul style="list-style-type: none"> Substrate especially designed for high wear resistance Excellent wear resistance in cast iron milling application
YG5020 K01 - K30		CVD Milling grade for Cast Iron <ul style="list-style-type: none"> CVD coating for Excellent wear resistance Improved Toughness for chipping resistance
YG50 N05 - N20		Uncoated Milling Grade for Aluminium <ul style="list-style-type: none"> Submicron carbide substrate for high wear resistance Preventing built up edge with shining surface

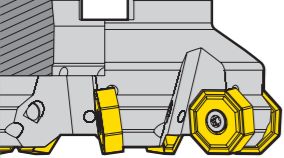
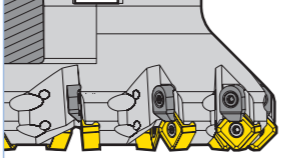
Milling Chipbreakers

-AL		<ul style="list-style-type: none"> For Aluminum Very Sharp Geometry
-ST		<ul style="list-style-type: none"> For Stainless Steel, Super Alloy Sharp Geometry
General Inserts (No Description)		<ul style="list-style-type: none"> First Choice for General Application
-TR		<ul style="list-style-type: none"> For Hardened Steels Reinforced Geometry
...W / ...N		<ul style="list-style-type: none"> For Hardened Material and Cast Irons

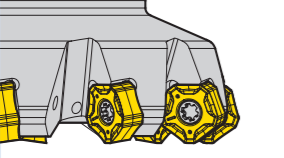
Milling Cutters Overview

Face Milling

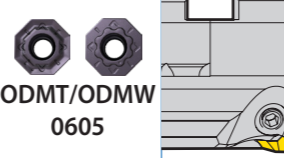

Negative Octagonal

Cutter	 ONMU 0806	 SNMX 1206
APMX	5.5	6
DC	Ø63~315	Ø50~200
page	p. 113	p. 114

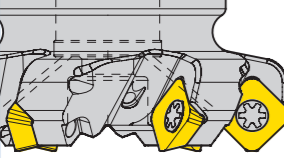


Negative Square

Cutter	 PNMU 1206
APMX	4
DC	Ø50~125
page	p. 116

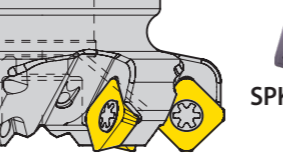
Positive Octagonal

Cutter	 ODMT/ODMW 0605	 OFER 0704
APMX	3.5	5
DC	Ø63~125	Ø63~160
page	p. 115	p. 115

Positive Square

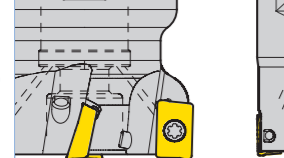
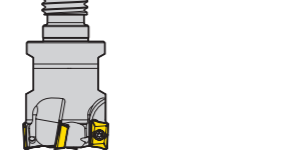
Cutter	 SEKT 1204	 SEKT 12T3	 SEGT 1204
APMX	6	6	6
DC	Ø40~160	Ø50~160	Ø50~160
page	p. 117		

ISO

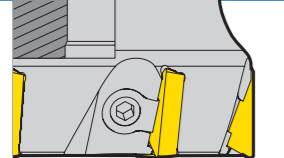

Cutter	 SPKN/SPKR/SPCN 1203
APMX	8
DC	Ø50~200
page	p. 118

Shoulder Milling

2 Corner Positive

Cutter	 APKT 1003	 APKT 1604
APMX	10	16
DC	Ø16~100	Ø25~200
page	p.132-133	p.134-135

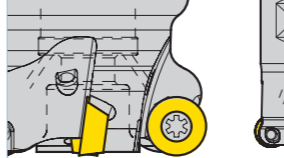
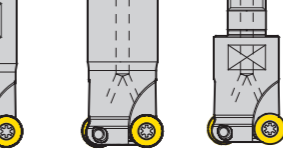

ISO

Cutter	 TPKN/TPKR/TPCN 1603	 TPKN/TPKR/TPCN 2204
APMX	12	18
DC	Ø50~125	Ø63~315
page	p. 136	

Milling Cutters Overview

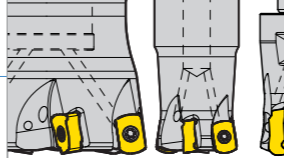

Profiling

Round Positive

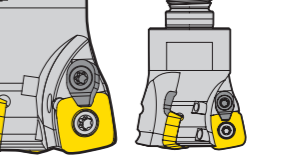
Cutter	 0802	 RDKT/RDKW 10T3	 1204
APMX	4	5	6
DCX	Ø16~25	Ø20~63	Ø25~100
page	p. 143	p. 143	p. 144

High Feed Milling

Negative 4 Corner

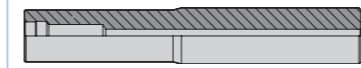
Cutter	 ENMX 0604	 ENMX 0905	
APMX	0.9	1	1.5
DCX	Ø16~18	Ø20~50	Ø25~125
page	p. 149 - 150		

Positive 4 Corner

Cutter	 SDMT/SDMW 1204
APMX	1.8
DCX	Ø32~100
page	p. 151

Modular Shank

Modular Shank for Modular Head

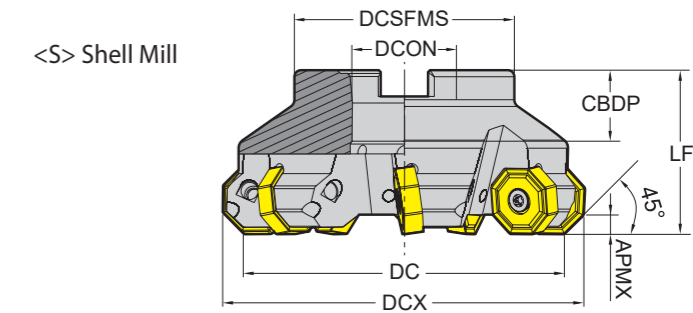
Cutter	 M08 ~ M16
page	p. 155

Milling Inserts Overview

A 2 Corner	 Positive	ADKT	ADKT 1505	p. 137
		AOMT	AOMT 1236	p. 137
		APKT	APKT 1003, 1604	p. 138
		APMT	APMT 1135, 1504, 1604	p. 139
		APXT	APXT 1135, 1604	p. 140
E 4 Corner	 Negative	ENMX	ENMX 0604 ENMX 0905	p. 152
O Octagon	 Positive	ODMT / ODMW	ODMT / ODMW 0605	p. 119
		OFER	OFER 0704	p. 120
		OFMT	OFMT 05T3	p. 120
	 Negative	ONMU / ONHU	ONMU / ONHU 0806	p. 121
P 10 Corner	 Negative	PNMU	PNMU1206	p. 122
R Round	 Positive Round	RDKT / RDKW	RDKT 0802, 10T3, 1204, 1604 RDKW 0501, 0702, 0802, 10T3, 1204	p. 145
		RDMT / RDMW	RDMT 0802, 0803, 10T3, 1204 RDMW 0802, 10T3, 1204	p. 146
		RPMT / RPMW	RPMT 08T2, 10T3, 1204 RPMW 1003, 1204	p. 147
		RBEX50	RBEX50	p. 148
	 Positive 3 Corner			
S Square	 High Feed	SDMT / SDMW	SDMT 1204, SDMW 1204	p. 154
	 Positive	SEKT	SEKT 12T3, 1204	p. 125
		SEGT	SEGT12T3, 1204	p. 126
		SEMT	SEMT1204, 13T3	p. 127
		SPMT	SPMT 1204	p. 130
		SDKN, SDCN (45°)	SDKN, SDCN 1203, 1504	p. 123
		SEKN / SEKR (45°)	SEKR, SEKN 1203	p. 124
	 ISO	SPKN / SPKR / SPCN(75°)	SPKN 1203, 1504 SPKR 1203 SPCN 1203, 1504	p. 129
		SPUN	SPUN 1203	p. 131
 Negative	SNMX	SNMX1206	p. 128	
T Triangle	 ISO	TPKN / TPKR / TPCN(90°)	TPKN 1603, 2204 TPKR 1603, 2204 TPCN 2204	p. 141
		TPUN	TPUN 1603	p. 142

Milling - Face Milling - Cutter Cutters for ONMU

Cutting Angle: 45°
16 Corner Negative



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

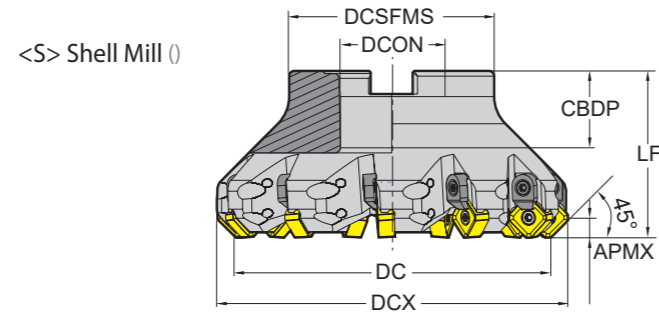
□: p. 121 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	⦿
ONMU 0806	5.5	F45 - ONMU08 - D63Z5S22	0493	63	75	5	40	Shellmill	22	22	49	-	-	●
		F45 - ONMU08 - D80Z6S27	0494	80	92	6	50		27	25	58	-	-	●
		F45 - ONMU08 - D100Z7S32	0495	100	112	7	50		32	26	67	-	-	●
		F45 - ONMU08 - D125Z8S40 - WOC	0496	125	137	8	63		40	32	87	-	-	X
		F45 - ONMU08 - D160Z10S40 - WOC	0497	160	172	10	63		40	32	107	66.7	-	X
		F45 - ONMU08 - D200Z12S60 - WOC	0498	200	212	12	63		60	40	130	101.6	-	X
		F45 - ONMU08 - D315Z16S60 - WOC	0499	315	327	16	63		60	40	220	101.6	177.8	X

► ONHU is Available for Wiper Insert

Milling - Face Milling - Cutter Cutters for SNMX

Cutting Angle : 45°
8 Corner Negative



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

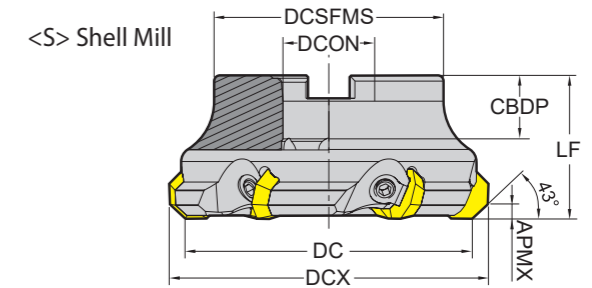
□: p. 128

Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
SNMX 1206	6.0	F45 - SNMX12 - D50Z4S22	0506	50	63	4	42	Shellmill	22	22	42	-	-	●
		F45 - SNMX12 - D50Z5S22	0507	50	63	5	42		22	22	42	-	-	●
		F45 - SNMX12 - D63Z6S22	0508	63	76	6	42		22	22	48	-	-	●
		F45 - SNMX12 - D63Z7S22	0509	63	76	7	42		22	22	48	-	-	●
		F45 - SNMX12 - D80Z7S27	0510	80	93	7	52		27	25	58	-	-	●
		F45 - SNMX12 - D80Z8S27	0511	80	93	8	52		27	25	58	-	-	●
		F45 - SNMX12 - D100Z10S32	0512	100	113	10	52		32	26	67	-	-	●
		F45 - SNMX12 - D100Z8S32	0513	100	113	8	52		32	26	67	-	-	●
		F45 - SNMX12 - D125Z11S40 - WOC	0514	125	138	11	65		40	32	80	-	-	X
		F45 - SNMX12 - D160Z12S40 - WOC	0515	160	173	12	65		40	32	110	66.7	-	X
F45 - SNMX12 - D200Z14S60 - WOC	0516	200	213	14	65	60	40	130	101.6	-	X			

Milling - Face Milling - Cutter Cutters for OFER

Cutting Angle : 43°
8 Corner Positive



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

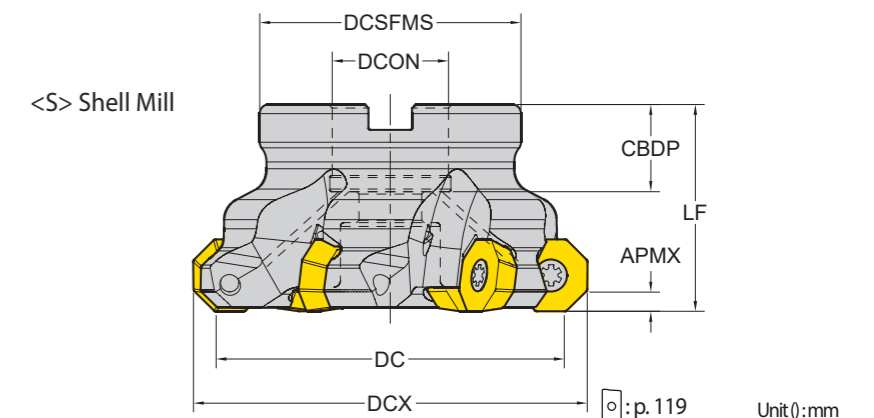
□: p. 120

Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
OFER 0704	5.0	F43 - OFER07 - D63Z4S22 - WOC	0484	63	75	4	45	Shellmill	22	22	48	-	-	X
		F43 - OFER07 - D80Z5S27 - WOC	0485	80	92	5	50		27	25	58	-	-	X
		F43 - OFER07 - D100Z6S32 - WOC	0486	100	112	6	50		32	26	80	-	-	X
		F43 - OFER07 - D125Z8S40 - WOC	0487	125	137	8	63		40	32	85	-	-	X
		F43 - OFER07 - D160Z9S40 - WOC	0488	160	172	9	63		40	32	110	66.7	-	X

Milling - Face Milling - Cutter Cutters for ODMT, ODMW

Cutting Angle : 43°
8 Corner Positive



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

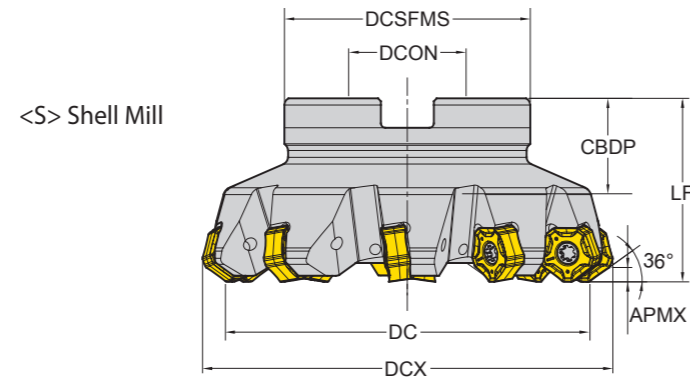
□: p. 119

Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
ODMT ODMW 0605	3.5	F43 - ODMT06 - D63Z5S22	0001	63	73	5	40	Shellmill	22	20	50	-	-	●
		F43 - ODMT06 - D80Z6S27	0002	80	90	6	50		27	23	56	-	-	●
		F43 - ODMT06 - D100Z7S32	0003	100	110	7	50		32	26	78	-	-	●
		F43 - ODMT06 - D125Z8S40	0004	125	135	8	63		40	28	89	-	-	●

Milling - Face Milling - Cutter Cutters for PNMU

Cutting Angle : 36°
10 Corner Negative



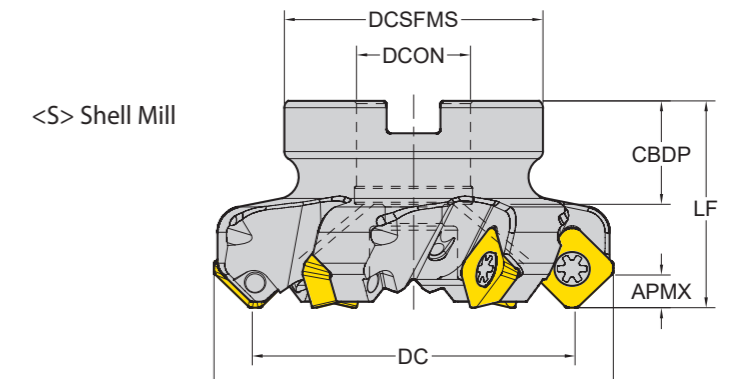
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

□ : p. 122 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
PNMU 1206	4.0	F36-PNMU12-D50Z4S22	0774	50	83.6	4	40	Shell Mill	22	20	42	-	-	●
		F36-PNMU12-D50Z5S22	0785	50	83.6	5	40		22	20	42	-	-	●
		F36-PNMU12-D63Z5S22	0775	63	96.6	5	40		22	20	48	-	-	●
		F36-PNMU12-D63Z6S22	0483	63	96.6	6	40		22	20	48	-	-	●
		F36-PNMU12-D80Z8S27	0466	80	113.6	8	50		27	23	58	-	-	●
		F36-PNMU12-D100Z10S32	0467	100	133.6	10	50		32	26	67	-	-	●
		F36-PNMU12-D125Z10S40	0786	125	158.6	10	63		40	29	89	-	-	●

Milling - Face Milling - Cutter Cutters for SEKT, SEGT

Cutting Angle : 45°
4 Corner Positive



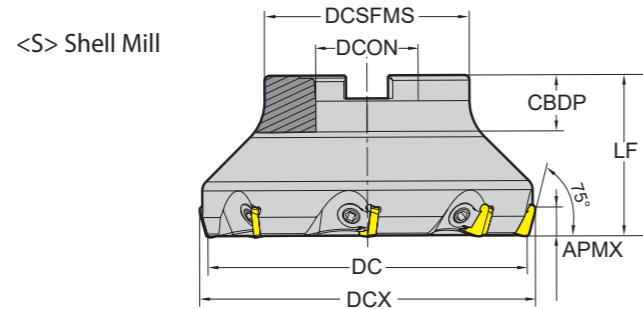
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

□ : p. 125/126 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
SEKT SEGT 12T3	6.0	F45 - SE12T3 - D50Z4S22	0500	50	63	4	40	Shellmill	22	22	48	-	-	●
		F45 - SE12T3 - D63Z5S22	0501	63	76	5	40		22	22	48	-	-	●
		F45 - SE12T3 - D80Z6S27	0502	80	93	6	50		27	25	58	-	-	●
		F45 - SE12T3 - D100Z7S32	0503	100	113	7	50		32	26	65	-	-	●
		F45 - SE12T3 - D125Z8S40 - WOC	0504	125	138	8	63		40	32	85	-	-	X
		F45 - SE12T3 - D160Z10S40 - WOC	0505	160	173	10	63		40	32	110	66.7	-	X
		F45 - SEKT12 - D40Z4S16	0031	40	54	4	40		16	18	32	-	-	●
SEKT SEGT 1204	6.0	F45 - SEKT12 - D50Z5S22	0032	50	64	5	40	Shellmill	22	20	48	-	-	●
		F45 - SEKT12 - D63Z4S22	0033	63	77	4	40		22	20	50	-	-	●
		F45 - SEKT12 - D63Z6S22	0034	63	77	6	40		22	20	50	-	-	●
		F45 - SEKT12 - D80Z4S27	0035	80	94	4	50		27	22	56	-	-	●
		F45 - SEKT12 - D80Z7S27	0036	80	94	7	50		27	22	56	-	-	●
		F45 - SEKT12 - D100Z8S32	0037	100	114	8	50		32	25	78	-	-	●
		F45 - SEKT12 - D125Z10S40	0038	125	139	10	63		40	29	90	-	-	●
		F45 - SEKT12 - D160Z12S40	0039	160	174	12	63		40	30	114	-	-	X

Milling - Face Milling - Cutter
Cutters for SPKN, SPKR, SPCN

Cutting Angle : 75°
 4 Corner Positive ISO

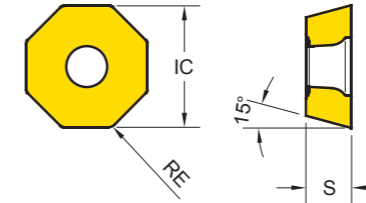


ZEFP : Effective Number of Cutting Edges
 CICT : Number of Inserts
 CDBP : Connection Bore Depth

□ : p. 129 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	☹
SPKN SPKR SPCN 1203	8.0	F75 - SPKN12 - D50Z4S22 - WOC	0611	50	56	4	42	Shellmill	22	22	42	-	-	X
		F75 - SPKN12 - D63Z5S22 - WOC	0612	63	69	5	40		22	22	48	-	-	X
		F75 - SPKN12 - D80Z6S27 - WOC	0613	80	86	6	50		27	25	58	-	-	X
		F75 - SPKN12 - D100Z7S32 - WOC	0614	100	106	7	50		32	26	65	-	-	X
		F75 - SPKN12 - D125Z8S40 - WOC	0615	125	131	8	63		40	32	80	-	-	X
		F75 - SPKN12 - D160Z9S40 - WOC	0616	160	166	9	63		40	32	110	66.7	-	X
		F75 - SPKN12 - D200Z12S60 - WOC	0617	200	206	12	63		60	40	130	101.6	-	X

Milling - Face Milling - Inserts
ODMT, ODMW - Face Milling Positive (8 Corners)



Series	IC	S
ODM*0605	15.9	5.6

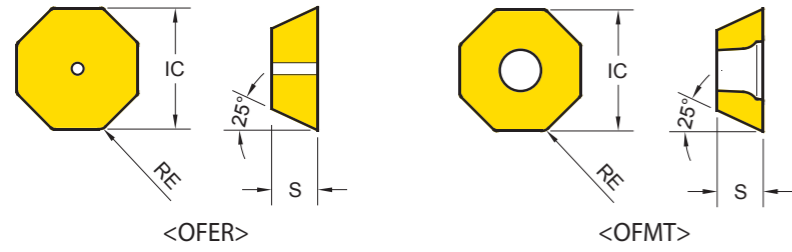
EDP 1200..
 ● : Stock item ○ : Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..						
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020
ODMT General	ODMT 060508	0.8	0.21 ~ 0.35		● 0030			● 0659	● 0675		
ODMW Hard Materials	ODMW 060508	0.8	0.26 ~ 0.40		● 0031						

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	1-5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6-9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10-11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12-13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15-16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17-18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21-30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31-37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38-41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts
OFER, OFMT - Face Milling Positive (8 Corners)



Series	IC	S
OFER 0704	18.05	4.78
OFMT 05T3	12.73	4.06

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

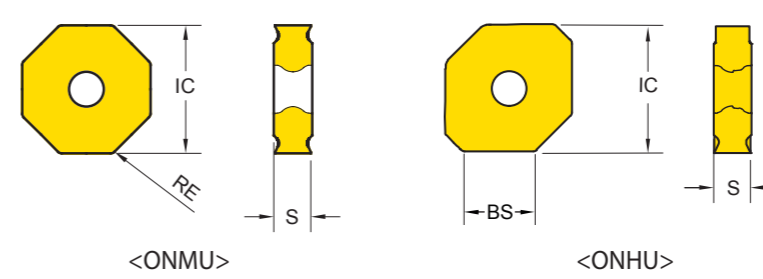
P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

OFER	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
OFER General	OFER 070405	0.5	0.22~0.50		● 0209						

OFMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
OFMT General	OFMT 05T308	0.8	0.15~0.25		● 0032						

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts
ONMU / ONHU - Face Milling Negative (16 Corners)



Series	IC	S
ON*U 0806	20.2	5.8

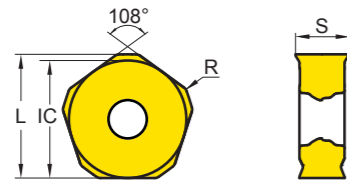
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

ONMU / ONHU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
ONMU General	ONMU 080608	0.8	0.22~0.50		● 0233			○ 0657	○ 0670		○ 0414
	ONMU 080612	1.2	0.05~0.40					○ 0615			○ 0542
ONHU Wiper Insert	ONHU 080612	1.2	0.08~0.25	10.6						○ 0496	○ 0482

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts
PNMU - Face Milling Negative (10 Corners)

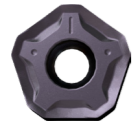


Series	KRINS	IC	S
PNMU 1206	36	14.0	5.84

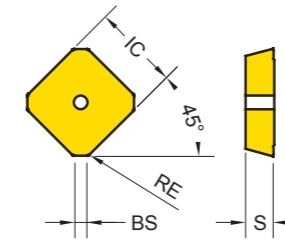
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

PNMU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..						
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020
General	PNMU1206ZNN	0.8	0.05~0.50	2.10	●	●	●	●	●	●	●
					○	○	○	○	○	○	○



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

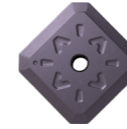


Series	AS	IC	S
SD** 1203	15°	12.70	3.18
SD** 1504	15°	15.88	4.76

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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

SDKN / SDCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..						
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SDKN Hard Materials	SDKN 1203 AETN	0.5	0.22~0.35	1.85	●	○	○	○	○	○	○
	SDKN 1203 AETN -PW	0.4	0.22~0.35	1.98	●	○	○	○	○	○	○
	SDKN 1203 AETN -GW	1.3	0.22~0.35	1.85	●	○	○	○	○	○	○
	SDKN 1504 AETN	0.45	0.22~0.35	2.00	●	○	○	○	○	○	○
	SDKN 1504 AETN -PW	0.4	0.22~0.40	1.95	●	○	○	○	○	○	○
SDCN Ground insert	SDKN 1504 AETN -GW	1.3	0.22~0.40	2.05	●	○	○	○	○	○	○
	SDCN 1203 AESN - M		0.05~0.2	2.04	○	○	●	○	○	○	○
	SDCN 1504 AESN - M		0.05~0.2	2.19	○	○	●	○	○	○	○
	SDCN 1504 AESN -MR	1.0	0.05~0.20	2.19	○	○	●	○	○	○	○

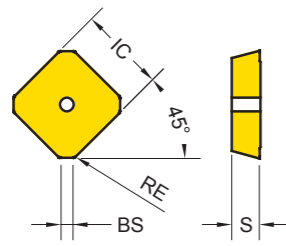


- PW : for Improved Surface Roughness
 - GW : Ground Wiper
 - M : for Mold & Die
 - MR : for Mold & Die Roughing

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

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



Series	AS	IC	S
SEK* 1203	20°	12.7	3.2

EDP 1200..

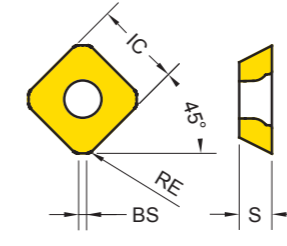
●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

SEKR SEKN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKR General	SEKR 1203 AFTN	0.4	0.14~0.30	1.40	● 0051						
	SEKR 1203 AFTN -PW	0.4	0.14~0.30	2.00	● 0296						
SEKN Hard Materials	SEKN 1203 AFTN	0.4	0.22~0.35	1.40	● 0054						
	SEKN 1203 AFTN -GW	0.4	0.23~0.35	2.00	● 0304						
	SEKN 1203 AFTN -PW	0.4	0.22~0.35	2.00	● 0297						

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

SEKT - Face Milling Positive (4 Corners)



Series	IC	S
SEKT 1204	12.7	4.9
SEKT 12T3	13.4	4

EDP 1200..

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

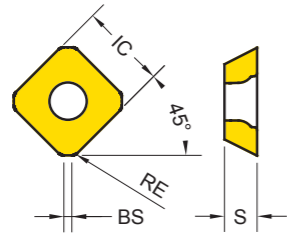
SEKT 1204	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKT 1204 General	SEKT 1204 AFTN	1.1	0.20~0.35	1.18	● 0055	○ 0416					
	SEKT 1204 -ST	1.1	0.08~0.30	2.00	● 0257						

SEKT 12T3	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEKT 12T3 General	SEKT 12T3 AGTN	1.5	0.15~0.30	1.30	● 0056						
	SEKT 12T3 -ST	1.5	0.08~0.30	2.00	● 0271				● 0689		

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Face Milling - Inserts
SEGT - Face Milling Positive (4 Corners)



Series	IC	S
SEGT 1204	12.74	4.91
SEGT 12T3	13.40	4.03

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

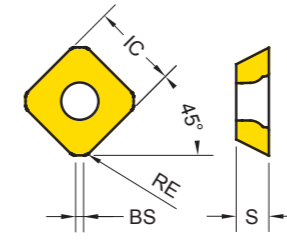
P25	P30	P20	P30	P40	K15	N15
M30				M40		
K30	K30					
S20						

SEGT 1204		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG5020	YG50
-AL Aluminium		SEGT 1204-AL	1.1	0.1~0.35	2.01							● 0467

SEGT 12T3		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG5020	YG50
-AL Aluminium		SEGT 12T3-AL	1.5	0.1~0.35	1.94							● 0468

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	200	350	-	-	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	150	300	-	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	300	800	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Face Milling - Inserts
SEMT - Face Milling Positive (4 Corners)



Series	IC	S
SEMT1204	12.92	5.1
SEMT13T3	13.40	4.0

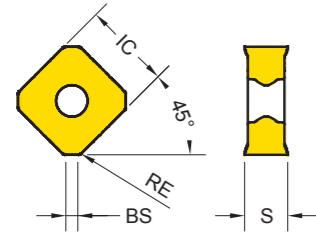
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

SEMT		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SEMT 1204 General		SEMT 1204 AFTN	1.2	0.26~0.4	1.24	● 0052						
SEMT 13T3 General		SEMT 13T3 AGSN	1.5	0.15~0.3	1.31	● 0203						

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Face Milling - Inserts
SNMX - Face Milling Negative (8 Corners)

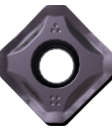


Series	IC	S
SNMX 1206	12.7	6.25

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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

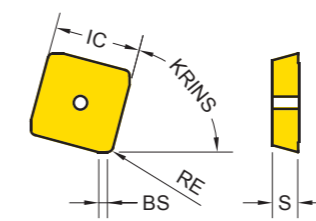
SNMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..						
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020
General	SNMX 1206 ANN	0.8	0.16~0.34	1.70	●			●	●		
					○231			○0658	○0674		



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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

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



Series	KRINS	AS	IC	S
SP** 1203	75°	11°	12.70	3.18
SP** 1504	75°	11°	15.88	4.76

SPKR SPKN SPCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..						
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020
SPKR General	SPKR 1203 EDTR	0.8	0.15~0.35	1.40	●						
	SPKR 1203 EDTR-PW	0.8	0.15~0.35	1.54	○						
SPKN Hard Materials	SPKN 1203 EDTR	0.8	0.16~0.34	1.40	●						
	SPKN 1203 EDTR-GW	0.6	0.15~0.28	1.50	○						
	SPKN 1203 EDTR-PW	0.8	0.20~0.35	1.50	○						
	SPKN 1504 EDTR	0.8	0.15~0.34	1.30	●						
	SPKN 1504 EDTR-GW	0.8	0.25~0.40	2.20	○						
	SPKN 1504 EDTR-PW	0.8	0.25~0.40	2.13	○						
SPCN Ground insert	SPCN 1203 EDSR - M	0.8	0.1~0.2	1.82			●				
	SPCN 1203 EDSR - MR	0.8	0.1~0.2	1.77			○				
	SPCN 1504 EDSR - M	0.8	0.1~0.2	1.92			○				
	SPCN 1504 EDSR - MR	0.8	0.1~0.2	1.86			○				

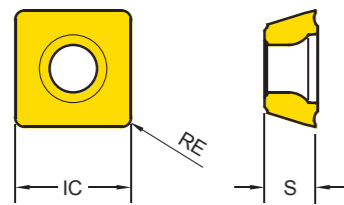
- PW : for Improved Surface Roughness
- GW : Ground Wiper
- M : for Mold & Die
- MR : for Mold & Die Roughing

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Face Milling - Inserts
SPMT - Universal Positive (4 Corners)

Series	AS	IC	S
SPMT 1204	11°	12.7	4.81



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

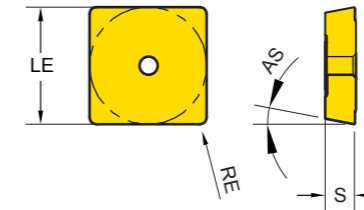
P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

SPMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
General	SPMT 120408	0.8	0.15~0.3		● 0223						



Milling - Face Milling - Inserts
SPUN - Universal Positive (4 Corners ISO)

Series	AS	IC	S
SPUN 1203	11°	12.7	3.2



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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

SPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
General	SPUN 120308	0.8			● 0224						

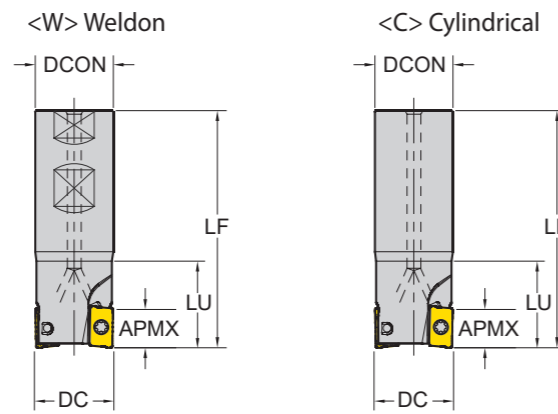


Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Cutter Cutters for APKT

Cutting Angle : 90°
2 Corner Positive



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

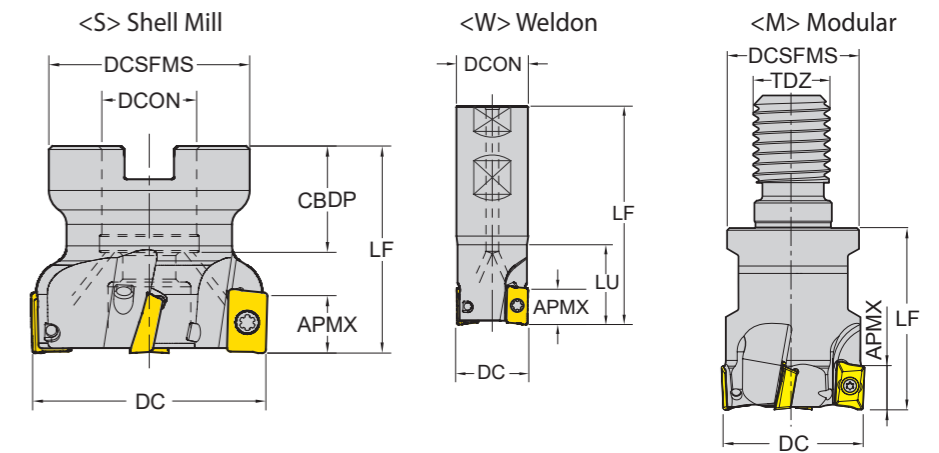
□: p. 138 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZAFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉
APKT 1003	10.0	E90 - APKT10 - D16Z2C16 - L100	0083	16	2	40	100	Cylindrical	16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L120	0532	16	2	30	120		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L150	0154	16	2	40	150		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L200	0533	16	2	100	200		16	-	-	-	-	●
		E90 - APKT10 - D20Z2C20 - L250	0534	20	2	150	250		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L100	0535	20	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L120	0085	20	3	40	120		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L150	0536	20	3	50	150		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L200	0270	20	3	100	200		20	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L100	0537	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L120	0186	25	3	40	120	25	-	-	-	-	●	
		E90 - APKT10 - D30Z4C25 - L100	0122	30	4	30	100	25	-	-	-	-	●	
		E90 - APKT10 - D30Z4C25 - L120	0086	30	4	30	120	25	-	-	-	-	●	
		E90 - APKT10 - D32Z4C25 - L100	0538	32	4	35	100	25	-	-	-	-	●	
		E90 - APKT10 - D32Z4C25 - L150 - WOC	0539	32	4	35	150	25	-	-	-	-	X	
		E90 - APKT10 - D12Z1W16 - L100	0540	12	1	30	100	16	-	-	-	-	●	
		E90 - APKT10 - D14Z1W16 - L100	0541	14	1	30	100	16	-	-	-	-	●	
		E90 - APKT10 - D16Z2W16 - L100	0542	16	2	30	100	16	-	-	-	-	●	
		E90 - APKT10 - D16Z2W16 - L85	0082	16	2	-	85	16	-	-	-	-	●	
		E90 - APKT10 - D18Z2W16 - L100	0543	18	2	30	100	16	-	-	-	-	●	

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Milling - Shoulder Milling - Cutter Cutters for APKT

Cutting Angle : 90°
2 Corner Positive



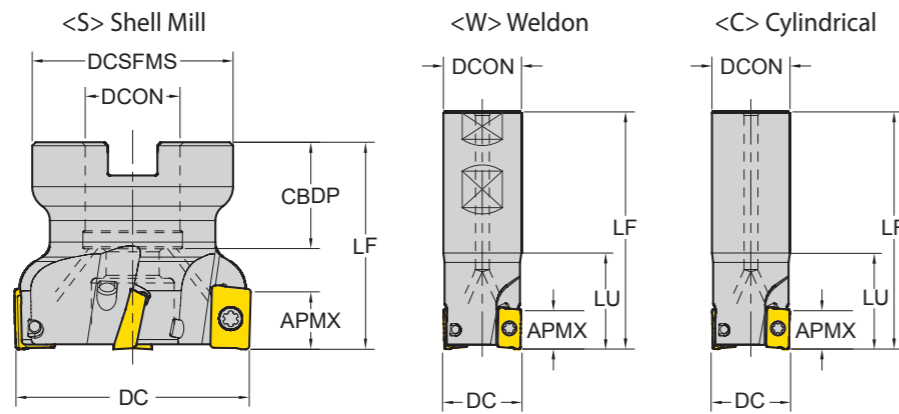
ZAFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

□: p. 138 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZAFP	LU	LF	TYPE	DCON / TDZ	CBDP	DCSFMS	PCD1	PCD2	☉
APKT 1003	10.0	E90 - APKT10 - D20Z3W20 - L100	0461	20	3	30	100	Weldon	20	-	-	-	-	●
		E90 - APKT10 - D20Z3W20 - L90	0084	20	3	40	90		20	-	-	-	-	●
		E90 - APKT10 - D22Z3W20 - L100	0544	22	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D25Z3W25 - L100	0545	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z4W25 - L100	0546	25	4	30	100		25	-	-	-	-	●
		E90 - APKT10 - D32Z4W32 - L150 - WOC	0547	32	4	50	150		32	-	-	-	-	X
		F90 - APKT10 - D40Z4S16	0087	40	4	-	40		16	18	34	-	-	-
		F90 - APKT10 - D40Z5S16	0472	40	5	-	40	16	20	36	-	-	-	●
		F90 - APKT10 - D50Z6S22	0215	50	6	-	40	22	22	42	-	-	-	●
		F90 - APKT10 - D50Z7S22	0088	50	7	-	40	22	20	42	-	-	-	●
		F90 - APKT10 - D63Z7S22	0548	63	7	-	40	22	22	48	-	-	-	●
		F90 - APKT10 - D80Z8S27	0549	80	8	-	50	27	25	58	-	-	-	●
		F90 - APKT10 - D100Z9S32	0550	100	9	-	50	32	26	65	-	-	-	●
		M90 - APKT10 - D16Z2M08	0551	16	2	-	30	M08	-	14.75	-	-	-	●
		M90 - APKT10 - D20Z3M10	0552	20	3	-	30	M10	-	18	-	-	-	●
		M90 - APKT10 - D25Z3M12	0553	25	3	-	35	M12	-	21	-	-	-	●
		M90 - APKT10 - D32Z4M16	0554	32	4	-	35	M16	-	29	-	-	-	●
		M90 - APKT10 - D40Z5M16	0555	40	5	-	43	M16	-	29	-	-	-	●
		M90 - APKT10 - D42Z5M16	0556	42	5	-	43	M16	-	29	-	-	-	●

Milling - Shoulder Milling - Cutter
Cutters for APKT

Cutting Angle : 90°
2 Corner Positive



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

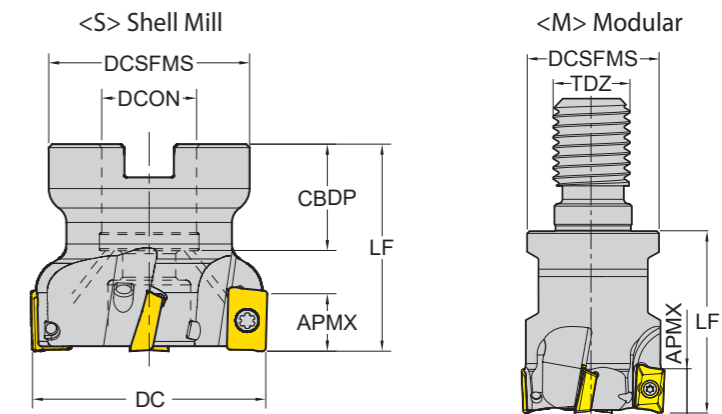
□ : p. 138 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	ZEPF	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	☉	
APKT 1604	16.0	E90 - APKT16 - D25Z2C20 - L100	0091	25	2	-	100	Cylindrical	20	-	-	-	-	●	
		E90 - APKT16 - D25Z2C20 - L100 - WOC	0243	25	2	35	100		20	-	-	-	-	X	●
		E90 - APKT16 - D25Z2C25 - L250 - WOC	0557	25	2	100	250		25	-	-	-	-	X	●
		E90 - APKT16 - D32Z2C32 - L250 - WOC	0558	32	2	100	250		32	-	-	-	-	X	●
		E90 - APKT16 - D32Z3C25 - L110	0094	32	3	-	110		25	-	-	-	-	●	●
		E90 - APKT16 - D32Z3C25 - L200	0559	32	3	40	200		25	-	-	-	-	●	●
		E90 - APKT16 - D32Z3C32 - L150 - WOC	0250	32	3	50	150		32	-	-	-	-	X	●
		E90 - APKT16 - D32Z3C32 - L250 - WOC	0560	32	3	100	250		32	-	-	-	-	X	●
		E90 - APKT16 - D40Z4C32 - L150 - WOC	0561	40	4	40	150		32	-	-	-	-	X	●
		E90 - APKT16 - D25Z2W25 - L100	0562	25	2	35	100		25	-	-	-	-	●	●
		E90 - APKT16 - D25Z2W25 - L110	0092	25	2	-	110	25	-	-	-	-	●	●	
		E90 - APKT16 - D28Z3W25 - L100	0563	28	3	40	100	25	-	-	-	-	●	●	
		E90 - APKT16 - D30Z3W25 - L110	0564	30	3	40	110	25	-	-	-	-	●	●	
		E90 - APKT16 - D32Z3W25 - L110	0093	32	3	-	110	25	-	-	-	-	●	●	
		E90 - APKT16 - D32Z3W32 - L110	0565	32	3	40	110	32	-	-	-	-	●	●	
		E90 - APKT16 - D36Z3W32 - L110	0566	36	3	40	110	32	-	-	-	-	●	●	
		F90 - APKT16 - D40Z4S16	0275	40	4	-	40	16	20	36	-	-	●	●	
		F90 - APKT16 - D50Z5S22	0095	50	5	-	40	22	20	45	-	-	●	●	

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Milling - Shoulder Milling - Cutter
Cutters for APKT

Cutting Angle : 90°
2 Corner Positive



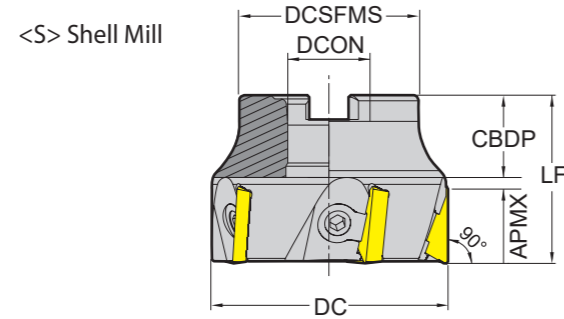
ZEPF : Effective Number of Cutting Edges
CICT : Number of Inserts
CBDP : Connection Bore Depth

□ : p. 138 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	ZEPF	LU	LF	TYPE	DCON / TDZ	CBDP	DCSFMS	PCD1	PCD2	☉	
APKT 1604	16.0	F90 - APKT16 - D52Z5S22	0567	52	5	-	40	Shellmill	22	22	42	-	-	●	
		F90 - APKT16 - D63Z6S22	0096	63	6	-	40		22	20	50	-	-	●	
		F90 - APKT16 - D80Z7S27	0097	80	7	-	50		27	23	56	-	-	●	
		F90 - APKT16 - D100Z8S32	0181	100	8	-	50		32	26	65	-	-	●	
		F90 - APKT16 - D125Z9S40 - WOC	0238	125	9	-	63		40	32	80	-	-	X	
		F90 - APKT16 - D160Z10S40 - WOC	0568	160	10	-	63		40	32	110	66.7	-	X	
		F90 - APKT16 - D200Z12S60 - WOC	0569	200	12	-	63		60	40	130	101.6	-	X	
		M90 - APKT16 - D25Z2M12	0570	25	2	-	43		Modular	M12	-	21	-	-	●
		M90 - APKT16 - D32Z3M16	0571	32	3	-	43			M16	-	29	-	-	●
		M90 - APKT16 - D42Z4M16	0572	42	4	-	43			M16	-	29	-	-	●

Milling - Shoulder Milling - Cutter
Cutters for TPKN, TPKR, TPCN

Cutting Angle : 90°
3 Corner Positive ISO

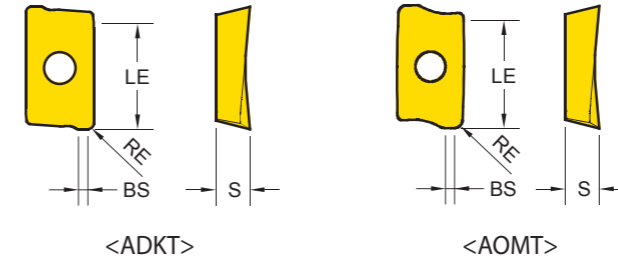


ZEFP : Effective Number of Cutting Edges
CIC : Number of Inserts
CBDP : Connection Bore Depth

□: p. 141 Unit:mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	⊖
TPKN TPKR TPCN 1603	12.0	F90 - TPKN16 - D50Z4S22 - WOC	0618	50	4	-	40	Shellmill	22	22	42	-	-	X
		F90 - TPKN16 - D63Z6S22 - WOC	0619	63	6	-	45		22	22	48	-	-	X
		F90 - TPKN16 - D80Z7S27 - WOC	0620	80	7	-	50		27	25	58	-	-	X
		F90 - TPKN16 - D125Z8S40 - WOC	0621	125	8	-	63		40	32	80	-	-	X
TPKN TPKR TPCN 2204	18.0	F90 - TPKN22 - D63Z5S22 - WOC	0622	63	5	-	45	Shellmill	22	22	48	-	-	X
		F90 - TPKN22 - D80Z6S27 - WOC	0623	80	6	-	50		27	25	58	-	-	X
		F90 - TPKN22 - D100Z7S32 - WOC	0624	100	7	-	50		32	26	65	-	-	X
		F90 - TPKN22 - D125Z8S40 - WOC	0625	125	8	-	63		40	32	80	-	-	X
		F90 - TPKN22 - D160Z9S40 - WOC	0626	160	9	-	63		40	32	110	66.7	-	X
		F90 - TPKN22 - D200Z12S60 - WOC	0627	200	12	-	63		60	40	130	101.6	-	X
		F90 - TPKN22 - D250Z15S60 - WOC	0628	250	15	-	63		60	40	160	101.6	-	X
		F90 - TPKN22 - D315Z18S60 - WOC	0629	315	18	-	63		60	40	220	101.6	177.8	X

Milling - Shoulder Milling - Inserts
ADKT / AOMT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
ADKT 1505	13.7	9.7	5.8
AOMT 1236	10.5	6.6	3.6

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

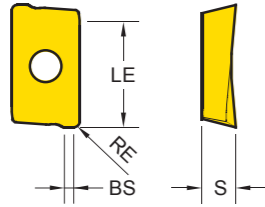
P25	P30	P20	P30	P40	K15	K15
M30	K30	M40	H15	K15		
S20						

ADKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
ADKT General	ADKT 150508 PDTR	0.8	0.16~0.30	1.87	● 0220						

AOMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
AOMT General	AOMT 123604 PDTR	0.4	0.08~0.22	1.07	● 0217						
	AOMT 123608 PDTR	0.8	0.08~0.24	0.91	● 0218				● 0613		

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	1-5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6-9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10-11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12-13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15-16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17-18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21-30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31-37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38-41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Shoulder Milling - Inserts
APKT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APKT 1003	9.9	6.7	3.6
APKT 1604	15.2	9.4	5.3

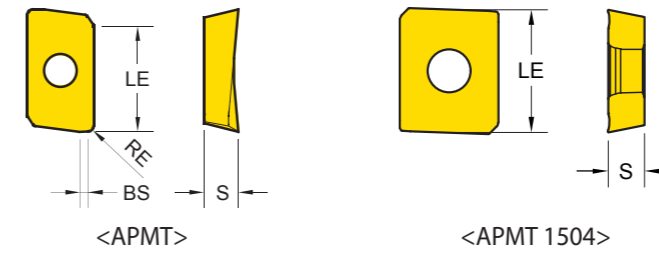
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

APKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..								
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020		
APKT General	APKT 100305 PDTR	0.5	0.15~0.24	0.86	●	○		●	●				
	APKT 100308 PDTR	0.8	0.15~0.24	0.90	●	○		●	●				
	APKT 160404 PDTR	0.4	0.15~0.25	1.11	●			●					
	APKT 160408 PDTR	0.8	0.15~0.30	1.32	●			●	●				
	APKT 160412 PDTR	1.2	0.15~0.32	1.13	●			●					
	APKT 160416 PDTR	1.6	0.15~0.34	1.13	●			●					
	APKT 160424 PDTR	2.4	0.15~0.38		●			●					
-ST Stainless Steel Super Alloy	APKT 100305 -ST	0.5	0.08~0.22	0.86	●					●			
	APKT 160408 -ST	0.8	0.08~0.25	1.32	●					●			
-TR Hardened Steel	APKT 160404 -TR	0.4	0.26~0.40	2.12	●	○							
	APKT 160408 -TR	0.8	0.26~0.40	1.32	●	○		●					
	APKT 160412 -TR	1.2	0.26~0.40	2.40	●	○							
	APKT 160416 -TR	1.6	0.26~0.40	2.40	●	○							
	APKT 160424 -TR	2.4	0.26~0.40	1.50	●	○							

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Shoulder Milling - Inserts
APMT - Shoulder Milling Positive (2 Corner)



Series	LE	IC	S
APMT 1135	9.5	6.2	3.50
APMT 1604	14.6	9.2	4.76
APMT 1504	14.0	12.7	4.76

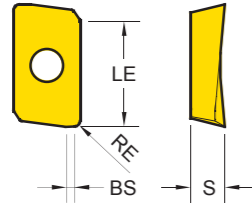
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	K15
K30	K30					
S20						

APMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..								
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020		
APMT General	APMT 113504 PDTR	0.4	0.15~0.22	1.26	●	○		●					
	APMT 113508 PDTR	0.8	0.15~0.25	1.07	●			●	●				
	APMT 160408 PDTR	0.8	0.16~0.30	1.11	●	○	●	●	●	●			
APMT 1504 General	APMT 1504		0.14~0.28		●	○							

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Shoulder Milling - Inserts
APXT - Shoulder Milling Positive (2 Corner)



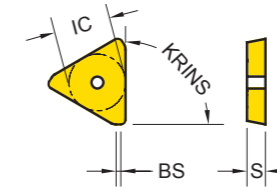
Series	LE	IC	S
APXT 1135	9.5	6.20	3.58
APXT 1604	14.6	9.2	4.8

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

P25	P30	P20	P30	P40	K15	N15
M30				M40		
K30	K30					
S20						

APXT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..							
					YG602	YG622	YG712	YG713	YG613	YG5020	YG50	
-AL Aluminium	APXT 113508-AL	0.8	0.05~0.30	1.52							●	0605
	APXT 160408-AL	0.8	0.10~1.30	1.75							●	0528

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



Series	KRINS	IC	S
TP** 1603	90°	9.53	3.18
TP** 2204	90°	12.70	4.76

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

P25	P30	P20	P30	P40	K15	K15
M30				M40		
K30	K30					
S20						

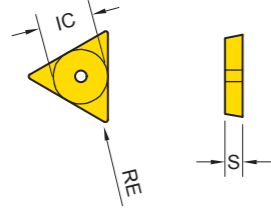
TPKR TPKN TPCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	EDP 1200..							
					YG602	YG622	YG712	YG713	YG613	YG501	YG5020	
TPKR General	TPKR 1603 PDTR		0.15~0.28	1.2	●						●	0690
	TPKR 1603 PDTR-PW		0.11~0.20	1.2	●							
	TPKR 2204 PDTR		0.18~0.35	1.7	●						●	0715
TPKN Hard Materials	TPKR 2204 PDTR-PW		0.18~0.35	1.7	●							
	TPKN 1603 PDTR		0.15~0.30	1.2	●							
	TPKN 1603 PDTR-GW		0.15~0.30	1.6	●							
	TPKN 1603 PDTR-PW		0.15~0.28	1.2	●							
	TPKN 2204 PDTR		0.17~0.30	1.7	●							
	TPKN 2204 PDTR-GW		0.24~0.40	2.5	●							
TPCN Ground insert	TPCN 2204 PDSR-M		0.05~0.20	1.76						●	0180	
	TPCN 2204 PDSR-MR		0.05~0.20	1.76						●	0202	

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

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	70	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	70	200	-	-	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	200	350	-	-	-	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	150	300	-	-	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	300	800	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	70	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	70	200	-	-	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Series	IC	S
TPUN 1603	9.53	3.18



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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

TPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
	TPUN 160308	0.8	0.08~0.15		●						
					0064						



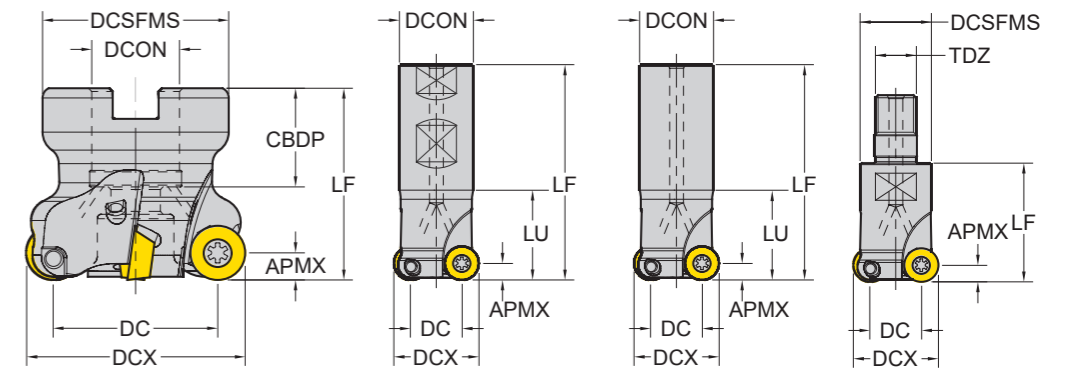
Round Positive

<S> Shell Mill

<W> Weldon

<C> Cylindrical

<M> Modular



ZAFP : Effective Number of Cutting Edges
 CDBP : Connection Bore Depth

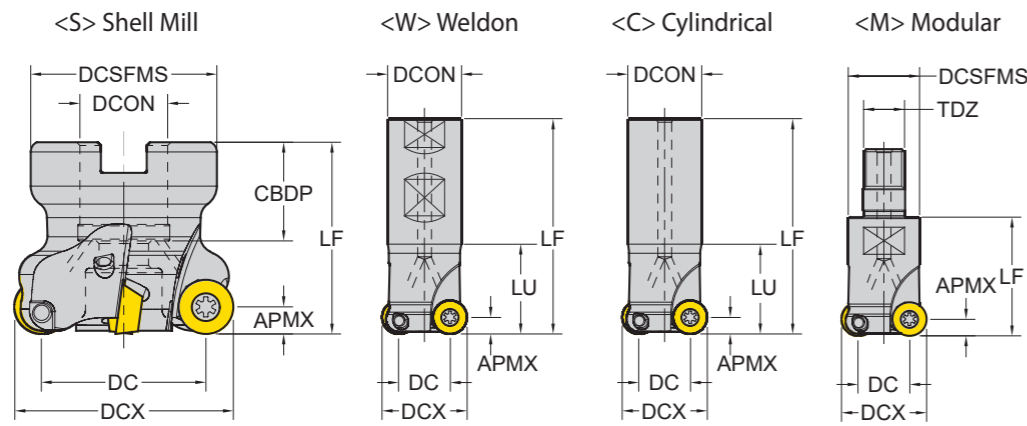
□: p. 145 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZAFP	LU	LF	TYPE	DCON / TDZ	CDBP	DCSFMS	●
RDKT RDKW 0802	4.0	E - RDKT08 - D16Z2C16 - L160	0005	8	16	2	-	160	Cylindrical	16	-	-	●
		E - RDKT08 - D20Z2C20 - L180	0007	12	20	2	-	180		20	-	-	●
		E - RDKT08 - D25Z3C20 - L180	0009	17	25	3	-	180		20	-	-	●
		M - RDKT08 - D16Z2M08	0010	8	16	2	-	23	Modular	M08	-	13	●
		M - RDKT08 - D20Z2M10	0011	12	20	2	-	30		M10	-	18	●
M - RDKT08 - D25Z3M12	0012	17	25	3	-	35	M12	-	21	●			
RDKT RDKW 10T3	5.0	E - RDKT10 - D20Z2C20 - L150 - WOC	0576	10	20	2	60	150	Cylindrical	20	-	-	X
		E - RDKT10 - D20Z2C20 - L180	0013	10	20	2	-	180		20	-	-	●
		E - RDKT10 - D25Z2C25 - L150 - WOC	0299	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D25Z2C25 - L180	0015	15	25	2	-	180		25	-	-	●
		E - RDKT10 - D20Z2W20 - L150 - WOC	0577	10	20	2	60	150	Weldon	20	-	-	X
		E - RDKT10 - D25Z2W25 - L150 - WOC	0578	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D32Z3W32 - L150 - WOC	0579	22	32	3	60	150	Shellmill	32	-	-	X
		F - RDKT10 - D40Z5S16	0019	30	40	5	-	40		16	18	34	●
		F - RDKT10 - D50Z5S22	0580	40	50	5	-	50		22	22	42	●
		F - RDKT10 - D50Z6S22	0020	40	50	6	-	50		22	22	42	●
F - RDKT10 - D63Z6S22	0581	53	63	6	-	50	22	22		48	●		
M - RDKT10 - D20Z2M10	0017	10	20	2	-	30	Modular	M10		-	18	●	
M - RDKT10 - D25Z3M12	0018	15	25	3	-	35		M12	-	21	●		

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	160	300	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	130	210	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

Milling - Profiling - Cutter
Cutters for RDKT, RDKW

Round Positive

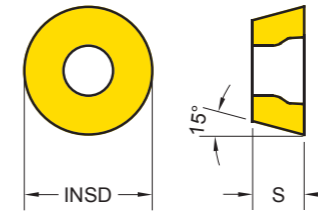


ZEFP : Effective Number of Cutting Edges
CDBP : Connection Bore Depth

p. 145 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CDBP	DCSFMS	Material
RDKT RDKW 1204	6.0	E - RDKT12 - D25Z2C25 - L180	0021	13	25	2	80	180	Cylindrical	25	-	-	●
		E - RDKT12 - D32Z2C32 - L200	0023	20	32	2	60	200		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160	0024	20	32	3	60	160		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160 - WOC	0582	20	32	3	70	160		32	-	-	X
		E - RDKT12 - D33Z3C32 - L160 - WOC	0583	21	33	3	70	160		32	-	-	X
		E - RDKT12 - D32Z3W32 - L160 - WOC	0584	20	32	3	50	160	32	-	-	X	
		F - RDKT12 - D40Z4S16	0028	28	40	4	-	40	16	18	32	●	
		F - RDKT12 - D50Z5S22	0029	38	50	5	-	50	22	20	40	●	
		F - RDKT12 - D52Z5S22	0585	40	52	5	-	50	22	22	42	●	
		F - RDKT12 - D63Z6S22	0030	51	63	6	-	50	22	20	48	●	
		F - RDKT12 - D80Z7S27	0586	68	80	7	-	50	27	25	58	●	
		F - RDKT12 - D100Z7S32	0587	88	100	7	-	50	32	26	65	●	
F - RDKT12 - D100Z8S32	0588	88	100	8	-	50	32	26	65	●			
M - RDKT12 - D25Z2M12	0026	13	25	2	-	35	M12	-	21	●			
M - RDKT12 - D32Z3M16	0027	20	32	3	-	42	M16	-	29	●			
M - RDKT12 - D42Z4M16	0589	30	42	4	-	43	M16	-	29	●			

Milling - Profiling - Inserts
RDKT / W - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RDK* 0501	5	1.4	RDK* 10T3	10	4.0
RDK* 0702	7	2.4	RDK* 1204	12	4.8
RDK* 0802	8	2.4			

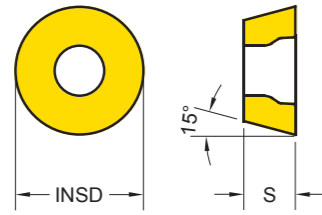
EDP 1200..
● : Stock item ○ : Order made item

P25	P30	P20	P30	P40	K15	K15
M30	K30	M40	H15			
S20						

RDKT / RDKW	Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
RDKT General	RDKT 0802M0	0.15 ~ 0.25	●						
	RDKT 10T3M0	0.15 ~ 0.28	●						
	RDKT 1204M0	0.20 ~ 0.30	●			●			
-ST Stainless Steel Super Alloy	RDKT 1604M0	0.30 ~ 0.60	●						
	RDKT 0802M0 - ST	0.08 ~ 0.25	●						
	RDKT 10T3M0 - ST	0.08 ~ 0.28	●				●		
-TR Hardened Steel	RDKT 1204M0 - ST	0.10 ~ 0.30	●				●		
	RDKT 0802M0 - TR	0.18 ~ 0.35	●	○					
	RDKT 10T3M0 - TR	0.22 ~ 0.40	●	○		●			
RDKW Hard Materials	RDKT 1204M0 - TR	0.22 ~ 0.40	●	○		○			
	RDKW 0501M0	0.10 ~ 0.20	●	○					
	RDKW 0702M0	0.12 ~ 0.25	●	○		●			
	RDKW 0802M0	0.13 ~ 0.25	●	○		○			
	RDKW 10T3M0	0.16 ~ 0.30	●	○		○			
	RDKW 1204M0	0.16 ~ 0.35	●	○		○	●		

ISO	VDI	Sub Group	Cutting Speed Vc (m/min.)													
			YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1-5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6-9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10-11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12-13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15-16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17-18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21-30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31-37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38-41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Profiling - Inserts
RDMT / W - Profiling Positive (Round)



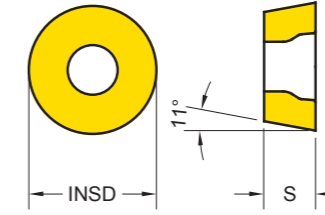
Series	INSD	S	Series	INSD	S
RDM* 0802	8	2.38	RDM* 10T3	10	3.97
RDM* 0803	8	3.18	RDM* 1204	12	4.76

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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

RDMT RDMW	Designation	Fz (mm/tooth)	EDP 1200..							
			YG602	YG622	YG712	YG713	YG613	YG501	YG5020	
RDMT General	RDMT 0802M0	0.15 ~ 0.25	●							
	RDMT 0803M0	0.15 ~ 0.25	●							
	RDMT 10T3M0	0.18 ~ 0.28	●							
	RDMT 1204M0	0.2 ~ 0.3	●							
RDMW Hard Materials	RDMW 0802M0	0.05 ~ 0.15	●							
	RDMW 10T3M0	0.1 ~ 0.25	●							
	RDMW 1204M0	0.16 ~ 0.3	●							

Milling - Profiling - Inserts
RPMT / W - Profiling Positive (Round)



Series	INSD	S	Series	INSD	S
RPM* 08T2	8	2.78	RPM* 10T3	10	3.97
RPM* 1003	10	3.18	RPM* 1204	12	4.76

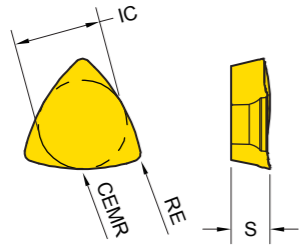
EDP 1200..
 ●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

RPMT RPMW	Designation	Fz (mm/tooth)	EDP 1200..							
			YG602	YG622	YG712	YG713	YG613	YG501	YG5020	
RPMT General	RPMT 08T2M0	0.10 ~ 0.24	●			●	●			
	RPMT 10T3M0	0.16 ~ 0.30	●			●	●			
	RPMT 1204M0	0.20 ~ 0.35	●	○	●	●	●	●		
-ST Stainless Steel Super Alloy	RPMT 1204M0 - ST	0.10 ~ 0.30	●				●			
RPMW Hard Materials	RPMW 1003M0	0.16 ~ 0.30	●	○		●				
	RPMW 1204M0	0.16 ~ 0.35	●			●				

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	



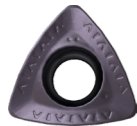
Series	CEMR	IC	S
RBEX50	25	12.7	5.55

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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

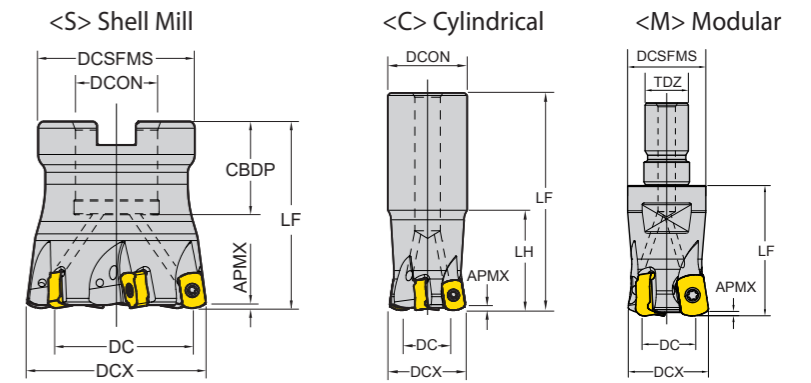
RBEX50	Designation	RE (mm)	Fz (mm/tooth)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
	RBEX 50	1.2	0.2~0.4	○ 0277	○ 0443					

RBEX50
General



Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Cutting Angle : 10°
 4 Corner Negative



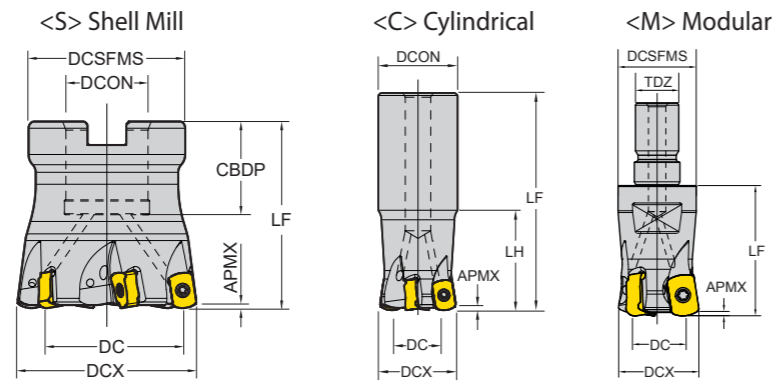
ZEFP : Effective Number of Cutting Edges
 CDBP : Connection Bore Depth

□: p. 152 Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CDBP	DCSFMS	●
ENMX 0604	0.9	EHF-ENMX06-D16Z2C16-L100	0644	9.0	16	2	100	Cylindrical	16	30	-	-	●
		EHF-ENMX06-D16Z2C16-L150	0645	9.0	16	2	150		16	50	-	-	●
		EHF-ENMX06-D17Z2C16-L100	0674	10.0	17	2	100		16	20	-	-	●
		EHF-ENMX06-D17Z2C16-L150	0473	10.0	17	2	150		16	20	-	-	●
	1	Cylindrical	EHF-ENMX06-D20Z3C20-L130	0463	12.6	20	3	130	20	50	-	-	●
			EHF-ENMX06-D20Z3C20-L160	0646	12.6	20	3	160	20	80	-	-	●
			EHF-ENMX06-D21Z3C20-L150	0475	13.6	21	3	150	20	20	-	-	●
			EHF-ENMX06-D21Z3C20-L200	0476	13.6	21	3	200	20	20	-	-	●
			EHF-ENMX06-D25Z4C25-L140	0647	17.6	25	4	140	25	60	-	-	●
			EHF-ENMX06-D25Z4C25-L180	0464	17.6	25	4	180	25	80	-	-	●
			EHF-ENMX06-D25Z4C25-L250	0648	17.6	25	4	250	25	120	-	-	●
			EHF-ENMX06-D26Z4C25-L150	0479	18.6	26	4	150	25	30	-	-	●
	1	Cylindrical	EHF-ENMX06-D26Z4C25-L200	0480	18.6	26	4	200	25	30	-	-	●
			EHF-ENMX06-D32Z5C32-L150	0649	24.6	32	5	150	32	70	-	-	●
1	Cylindrical	EHF-ENMX06-D32Z5C32-L200	0465	24.6	32	5	200	32	100	-	-	●	
0.9	Modular	MHF-ENMX06-D16Z2M08	0691	9.0	16	2	23	M08		-	13	●	
		MHF-ENMX06-D18Z2M08	0730	11.0	18	2	23	M08		-	13	●	
1	Modular	MHF-ENMX06-D20Z3M10	0692	12.6	20	3	30	M10		-	18	●	
		MHF-ENMX06-D25Z4M12	0693	17.6	25	4	35	M12		-	21	●	
		MHF-ENMX06-D32Z5M16	0694	24.6	32	5	42	M16		-	29	●	
		MHF-ENMX06-D35Z5M16	0695	27.6	35	5	42	M16		-	29	●	
		MHF-ENMX06-D40Z6M16	0732	32.6	40	6	42	M16		-	29	●	
		MHF-ENMX06-D42Z6M16	0696	34.6	42	6	42	M16		-	29	●	
1	Shell Mill	FHF-ENMX06-D40Z6S16	0482	32.6	40	6	40	16		18	37	●	
		FHF-ENMX06-D50Z6S22	0471	42.6	50	6	50	22		25	42	●	

Milling - High Feed Milling - Cutter
Cutters for ENMX

Cutting Angle : 10°
4 Corner Negative



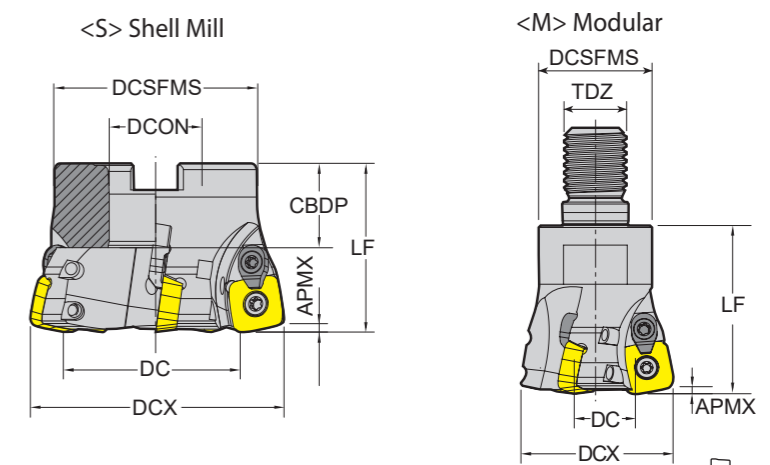
ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CBDP	DCSFMS	⦿
ENMX 0905	1.5	EHF-ENMX09-D25Z2C25-L150	0745	20	25	2	150	Cylindrical	25	70	-	-	●
		EHF-ENMX09-D26Z2C25-L200	0746	21	26	2	200		25	30	-	-	●
		EHF-ENMX09-D26Z3C25-L200	0747	21	26	3	200		25	30	-	-	●
		EHF-ENMX09-D32Z3C32-L160	0748	27	32	3	160		32	70	-	-	●
		EHF-ENMX09-D33Z3C32-L200	0749	28	33	3	200		32	30	-	-	●
		EHF-ENMX09-D33Z4C32-L200	0750	28	33	4	200		32	40	-	-	●
	EHF-ENMX09-D40Z5C32-L180	0751	35	40	5	180	32	40	-	-	●		
	1.5	FHF-ENMX09-D50Z3S22	0820	45	50	3	50	Shell Mill	22	-	20	42	●
		FHF-ENMX09-D50Z4S22	0821	45	50	4	50		22	-	20	42	●
		FHF-ENMX09-D50Z5S22	0752	45	50	5	50		22	-	20	42	●
		FHF-ENMX09-D63Z4S22	0822	57	63	4	50		22	-	20	48	●
		FHF-ENMX09-D63Z5S22	0823	57	63	5	50		22	-	20	48	●
		FHF-ENMX09-D63Z6S22	0753	57	63	6	50		22	-	20	48	●
		FHF-ENMX09-D63Z7S22	0754	57	63	7	50		22	-	20	48	●
FHF-ENMX09-D80Z8S27		0755	74	80	8	50	27		-	23	56	●	
FHF-ENMX09-D100Z10S32	0824	84	100	10	63	32	-	26	78	●			
FHF-ENMX09-D125Z12S40	0825	109	125	12	63	40	-	28	89	●			

Milling - High Feed Milling - Cutter
Cutters for SDMT, SDMW

Cutting Angle : 10°
4 Corner Positive

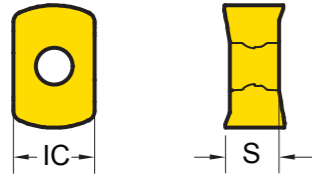


ZEFP : Effective Number of Cutting Edges
CBDP : Connection Bore Depth

Unit : mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	⦿
SDMT SDMW 1204	1.8	FHF - SDMW12 - D50Z4S22	0604	32.4	50	4	40	Shellmill	22	22	42	●
		FHF - SDMW12 - D63Z5S22	0605	45.4	63	5	40		22	22	48	●
		FHF - SDMW12 - D80Z6S27	0606	62.4	80	6	50		27	25	58	●
		FHF - SDMW12 - D100Z8S32	0607	82.4	100	8	50		32	26	65	●
	1.8	MHF - SDMW12 - D32Z2M16	0608	14.4	32	2	43	Modular	M16	-	29	●
		MHF - SDMW12 - D40Z3M16	0609	22.4	40	3	43		M16	-	29	●

Series	IC	S
ENMX 0604	6.3	4.21
ENMX 0905	9.0	5.40



EDP 1200..

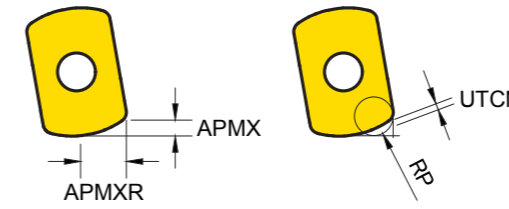
●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

ENMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
General	ENMX 0604		0.3 ~ 2.0		● 0474				● 0606		
	ENMX 0905		0.3 ~ 2.5		● 0702				● 0703		
Stainless Steel	ENMX 0604-ST		0.1 ~ 0.8		● 0623				● 0625		
	ENMX 0905-ST		0.2 ~ 1.2		● 0705				● 0706		
Hardened Steel	ENMX 0604-TR		0.3 ~ 2.5		● 0459		● 0504	● 0636			
	ENMX 0905-TR		0.3 ~ 3.0		● 0600						

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	160	300	200	350	-	-
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	130	210	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	-

ENMX 0604

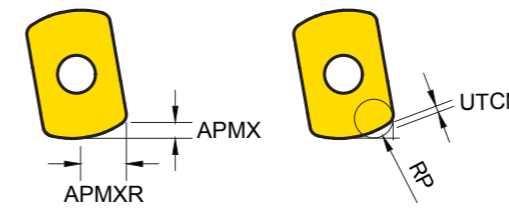


DCX Cutting Diameter Maximum	APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
16	3.5	R2.0	0.31	0.00
16~	3.7	R2.5	0.18	0.18
		R3.0	0.07	0.36



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
16	0.9	3.5	3.5°	R2.0	0.3	21	30	0.9	12.5
20	1	3.7	1.8°	R2.0	0.31	29	38	1	16.3
25	1	3.7	1.2°	R2.0	0.31	39	48	1	21.3
32	1	3.7	0.8°	R2.0	0.31	53	62	1	28.3
40	1	3.7	0.6°	R2.0	0.31	69	78	1	36.3
50	1	3.7	0.5°	R2.0	0.31	89	98	1	46.3

ENMX 0905

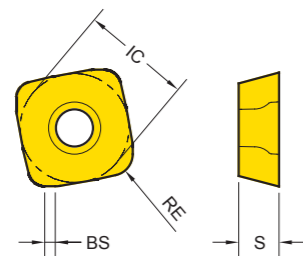


APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness	Overcut
4.7	R2.5	0.56	0
	R3.0	0.40	0.10
	R3.5	0.24	0.25
	R4.0	0.10	0.41
	R4.5	0	0.49



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
25	1.5	4.7	3.8°	2.5	0.56	42	48	1.5	20
26	1.5	4.7	3.5°	2.5	0.56	44	50	1.5	21
32	1.5	4.7	2.4°	2.5	0.56	56	62	1.5	27
33	1.5	4.7	2.2°	2.5	0.56	58	64	1.5	28
40	1.5	4.7	1.6°	2.5	0.56	72	78	1.5	35
50	1.5	4.7	1.1°	2.5	0.56	92	98	1.5	45
63	1.5	4.7	0.8°	2.5	0.56	118	124	1.5	57
80	1.5	4.7	0.6°	2.5	0.56	152	158	1.5	74

Milling - High Feed Milling - Inserts
SDMT / W - High Feed Positive (4 Corners)



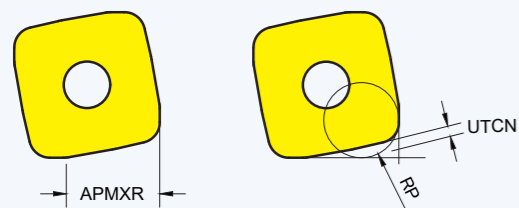
Series	IC	S
SDM* 1204	12.7	4.7

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

P25	P30	P20	P30	P40	K15	K15
M30				M40	H15	
K30	K30					
S20						

SDMT / SDM W	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG613	YG501	YG5020
-ST Stainless Steel Super Alloy	SDMT 120420-ST	1.9	0.60~1.20	1.45	● 0274				● 0666		
SDMW Hard Materials	SDMW 120420	1.9	0.60~1.40	1.4	● 0273	○ 0341		● 0634	● 0691		

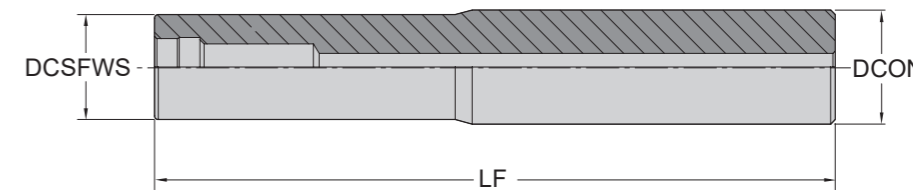
Technical Information



APMXR	RP	UTCN
Radial AP Max	Programmed Corner R	Uncut Thickness
8.6	R3.5	0.94

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG613		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	180	380	140	400	170	300	200	300	100	210	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	170	270	70	180	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	85	145	40	90	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	70	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	70	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	160	300	200	350	
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	130	210	150	300	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	-	-	-	-	-	
H	38~41	Hard Materials	40	80	40	100	-	-	-	-	-	-	-	-	-	

Milling - Modular Shank
Modular Shanks



Series	Designation	EDP 1700..	DCSFWS	LF	TYPE	DCON	Unit:mm
M08	EM - M08 - D16ZC16 - L100	0634	13	100	Cylindrical	16	●
	EM - M08 - D16ZC16 - L130	0635	15	130		16	●
M10	EM - M10 - D20ZC20 - L130	0636	18	130	Cylindrical	20	●
	EM - M12 - D25ZC25 - L150	0637	25	150		25	●
M12	EM - M12 - D25ZC25 - L200	0638	23	200	Cylindrical	25	●
	EM - M12 - D25ZC25 - L250	0639	23	250		25	●
M16	EM - M16 - D32ZC32 - L150	0640	30	150	Cylindrical	32	●
	EM - M16 - D32ZC32 - L200	0641	30	200		32	●
	EM - M16 - D32ZC32 - L250	0642	30	250		32	●
	EM - M16 - D32ZC32 - L300	0643	30	300		32	●