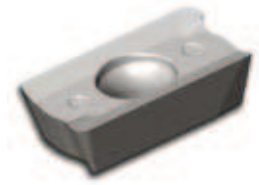


ALU-Milling

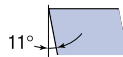


A



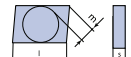
Shape
80° Diamond

P



Clearance Angle
15°

G



Tolerance
l ± 0.05 m ± 0.013
s ± 0.025

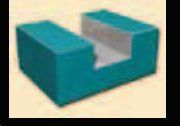
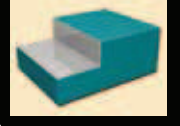

T



Insert Type
Screw Down Clamping
no chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
APGT 1003 PDER ALU LT 05	16	4,76	90°	15°	Right	M0001007	225	
APGT 1604 PDER ALU LT 05	16	4,76	2,4	15°	Right	M0000963	225	

Surfacing Insert Lead angle 90°

Application Guide	Slotting	Shoulder Milling	Surfacing
			

Highly positive inserts with a unique coating and 90° lead angle for Aluminum. Suitable for Roughing to Finishing - Slotting, Shoulder and Face milling operations.

Milling bodies

APGT 10 - see cutters of APLX 10 (page 147)

APGT 16 - see cutters of APKT 16 (page 142)

Machining Recommendation Guide - Please see Pg. 8



APGT 1003 ALU

Machining conditions **Milling**

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.3	9.0	0.12	0.20	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.18	250	600
Si > 8%	14	AlSi 12	----	Recommended to use APLX 1003 PDTR - LT-30					

**For high Si Aluminium, it is recommended to use APLX 1003 PDTR.
See cutting conditions below.**

Si > 8%	14	AlSi 12	----	0.5	9.0	0.08	0.20	200	400
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APGT 1604 Alu

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.5	15.5	0.15	0.32	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.12	0.25	250	600
Si > 8%	14	AlSi 12	----	Recommended to use APKT 1604 PDTR - LT-30					

**For high Si Aluminium, it is recommended to use APKT 1604 PDTR.
See cutting conditions below.**

Si > 8%	14	AlSi 12	----	0.5	16.0	0.15	0.25	200	400
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