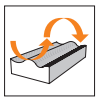
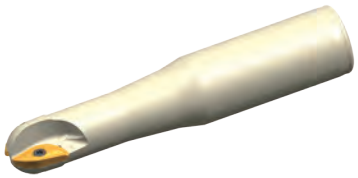
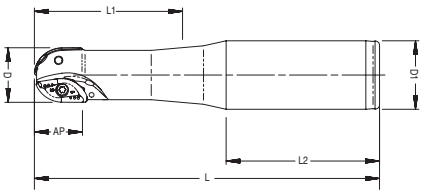
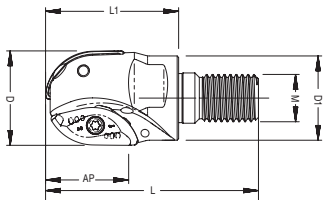
APM00-RP
Ballnose milling cutter



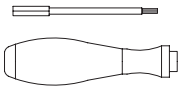
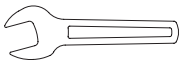




Product code	D	d1	L	l1	l2	apmax	M	Internal coolant	Z	Inserts
APM00-016-Z02-C20R-RP080-L120-C	16	20	120	50	70	14	-		2	RPM 080ER-MM4
APM00-020-Z02-C25R-RP100-L126-C	20	25	126	62	64	18	-		2	RPM 100ER-MM4
APM00-020-Z02-C25R-RP100-L176-C	20	25	176	70	106	18	-		2	



Product code	D	d1	L	l1	l2	apmax	M	Internal coolant	Z	Inserts
APM00-016-Z02-M10R-RP080-C	16	18	49	28	-	14	M10		2	RPM 080ER-MM4
APM00-020-Z02-M10R-RP100-C	20	18	51	30	-	18	M10		2	RPM 100ER-MM4

Dimension(mm)	Spare parts			
Cutter diameter	Screw	Wrench	wrench	Torque
				1.8Nm
φ 16	SP02506450H	DT-TP08	AFW-15	
φ 20	SP030072H	DT-TP09	AFW-15	

Note: With internal coolant
Without internal coolant

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Product code	Dimension(mm)		Grade						
	Insert corner radius mm	Wiper length mm	AP301U	AC301P	AP351U	AP401U	AP351M	AP351K	AP403S
RPM 080ER-MM4	8	-				●	●		●
RPM 100ER-MM4	10	-				●	●		●

Marked：● Stock available ○ Non-stocked standard

Materials				Cutting depth and feed			
ISO	Material classification	Tensile strength (N/mm^2)	Hardness (HB)	RPM....			
				ap		Geometry	
						MM4	
						fz	
				(mm)			
				min	max	min	max
P	Unalloyed steel	<600	<180	0.20	15.00	0.10	0.20
		<950	<280				
	Alloyed steel	700-950	200-280			0.10	0.18
		950-1200	280-355				
		1200-1400	355-415				
M	Duplex stainless steel	778	230			0.10	0.18
	Austenitic stainless steel	675	200				
	Precipitation-hardening stainless steel	1013	300				
K	Grey cast iron	700	220			-	-
	Nodular cast iron	880	260				
	Malleable cast iron	800	250				
S	Fe-based alloy	943	280			0.06	0.12
	Co-based alloy	1076	320				
	Ni-based alloy	1177	350				
	Ti-alloy	1262	370				
N	Aluminum	260	75			-	-
	Aluminum alloy	447	130				
H	Hardened steel	-	50-60HRC			-	-
	Chilled cast iron	-	55HRC				

*The recommended cutting conditions always refer to general conditions. These cutting conditions should be adjusted according to the practical machine rigidity, tools, workpiece clamping and coolants. $f_z = \frac{h_m}{\sqrt{\frac{a_e}{D_c}}}$,(calculate for $\frac{a_e}{D_c}$ <30%)

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