



# MILLING



## INDEX

### MILLING INDEXABLE

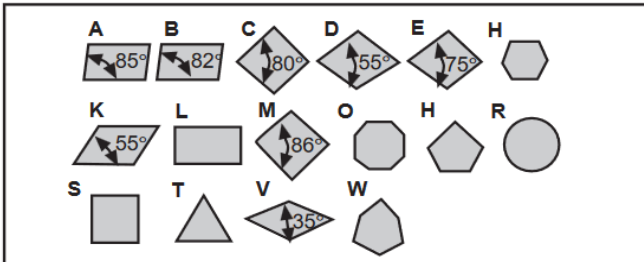
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- APMT/AXMT 11/16 (Sholder Milling) D03-D06
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## Milling cutter inserts Metric series ISO 1832-1991

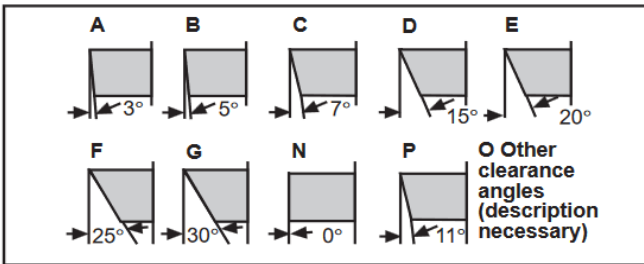
**S E A N 12 03 A F T N - M 16**

1 2 3 4 5 6 7 8 9 10

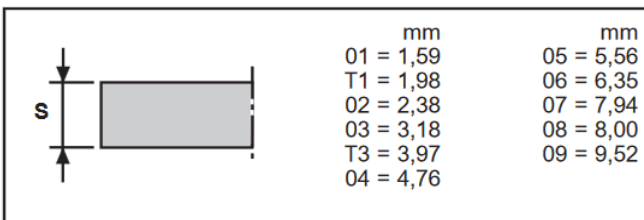
### 1. Shape



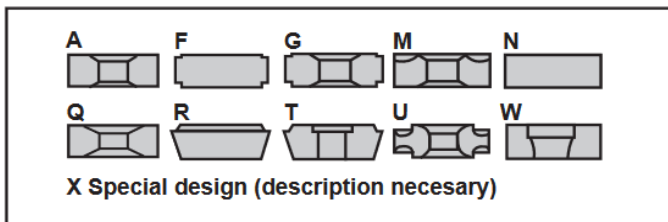
### 2. Clearance angle



### 6. Thickness





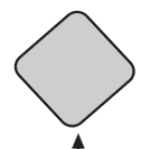
### 4. Type of insert



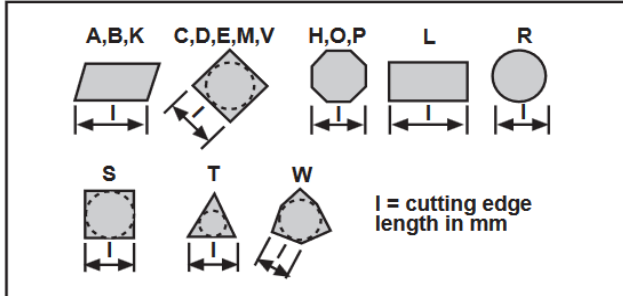
### 3. Tolerances

| Tol class | Tolerance ±mm |       |       | For d, dimension mm |       |       |        |       |       |
|-----------|---------------|-------|-------|---------------------|-------|-------|--------|-------|-------|
|           | m             | s     | d     | 6,53                | 9,525 | 12,70 | 15,875 | 19,05 | 25,40 |
| A         | 0,005         | 0,025 | 0,025 | •                   | •     | •     | •      | •     | •     |
| E         | 0,025         | 0,025 | 0,025 | •                   | •     | •     | •      | •     | •     |
| F         | 0,005         | 0,025 | 0,013 | •                   | •     | •     | •      | •     | •     |
| G         | 0,025         | 0,13  | 0,025 | •                   | •     | •     | •      | •     | •     |
| H         | 0,013         | 0,025 | 0,013 | •                   | •     | •     | •      | •     | •     |
| J         | 0,005         | 0,025 | 0,05  | •                   | •     |       |        |       |       |
|           | 0,005         | 0,025 | 0,08  |                     |       | •     |        |       |       |
|           | 0,005         | 0,025 | 0,10  |                     |       |       | •      | •     |       |
|           | 0,005         | 0,025 | 0,13  |                     |       |       |        |       | •     |
| K         | 0,013         | 0,025 | 0,05  | •                   | •     |       |        |       |       |
|           | 0,013         | 0,025 | 0,08  |                     |       | •     |        |       |       |
|           | 0,013         | 0,025 | 0,10  |                     |       |       | •      | •     |       |
| M         | 0,013         | 0,025 | 0,13  |                     |       |       |        |       | •     |
|           | 0,08          | 0,13  | 0,05  | •                   | •     |       |        |       |       |
|           | 0,13          | 0,13  | 0,08  |                     |       | •     |        |       |       |
|           | 0,15          | 0,13  | 0,10  |                     |       |       | •      | •     |       |
| U         | 0,18          | 0,13  | 0,13  |                     |       |       |        |       | •     |
|           | 0,13          | 0,13  | 0,08  | •                   | •     |       |        |       |       |
|           | 0,20          | 0,13  | 0,13  |                     |       | •     |        |       |       |
|           | 0,27          | 0,13  | 0,18  |                     |       |       | •      | •     |       |
|           | 0,38          | 0,13  | 0,25  |                     |       |       |        |       | •     |

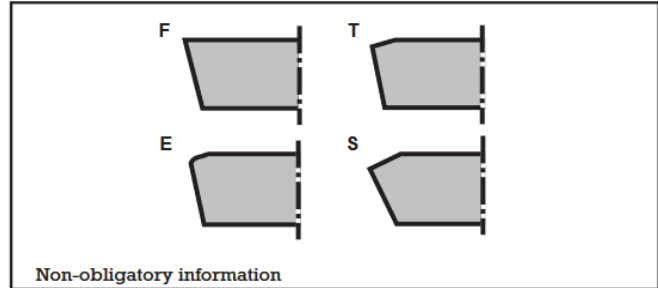
### 7. Insert with wiper edge/radius

|           |  |  |
|-----------|--|--|
| 1st digit |  | A = 45°<br>D = 60°<br>E = 75°<br>F = 85°<br>P = 90°<br>Z = Special   |
| 2nd digit |  | A = 3°      F = 25°<br>D = 5°      G = 30°<br>E = 7°      N = 0°<br>F = 15°     P = 11°<br>P = 20°<br><br>Z = Special  |
| radius mm |  | M0* = round inserts<br>00 = sharp<br>01 = 0,1<br>02 = 0,2<br>04 = 0,4<br>08 = 0,8<br>12 = 1,2<br>etc,<br>*metric sizes |

### 5. Cutting edge length



### 8. Cutting edge condition



### Comparison

#### Cutting edge length/I.C. (d)

| IC<br>(d) | Shape |    |     |     |    |    |
|-----------|-------|----|-----|-----|----|----|
|           | C     | D  | R,S | T   | V  | W  |
| 0,56      |       |    |     |     |    | 03 |
| 6,35      | 06    | 07 | 06  | 011 |    | 04 |
| 12,70     | 09    | 11 | 09  | 016 | 16 | 06 |
| 15,88     | 16    | 19 | 15  | 22  |    | 08 |
| 19,05     | 19    | 23 | 19  | 33  |    |    |
| 25,40     | 25    | 31 | 25  | 44  |    |    |

IC = Theoretical diameter of inscribed circle

### 9. Direction of cutting

