

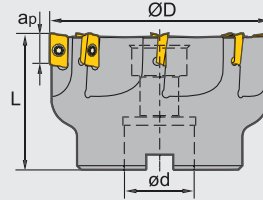
Square shoulder milling tools **Kr:90°**



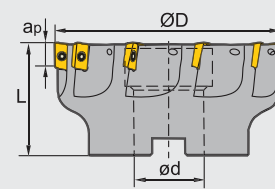
EMP02 **P** **M** **K** **N**



A type of mounting



B type of mounting



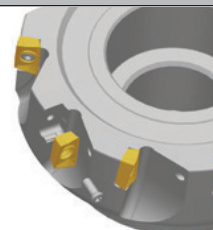


Specification of tools

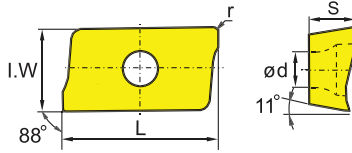
Type		Dimensions(inch)				
		ØD	ød	L	ap	Z
EMP02	-2.00"-A0.75"-AP11-06	2.00	0.75	1.50	0.433	6
	-2.50"-A0.75"-AP11-08	2.50	0.75	1.50	0.433	8
	-3.00"-A1.00"-AP11-08	3.00	1.00	2.00	0.433	8
	-4.00"-B1.25"-AP11-10	4.00	1.25	2.00	0.433	10
	-2.00"-A0.75"-AP16-05	2.00	0.75	1.50	0.630	5
	-2.50"-A0.75"-AP16-06	2.50	0.75	1.50	0.630	6
	-3.00"-A1.00"-AP16-07	3.00	1.00	2.00	0.630	7
	-4.00"-B1.25"-AP16-08	4.00	1.25	2.00	0.630	8
	-5.00"-B1.50"-AP16-08	5.00	1.50	2.50	0.630	8
	-6.00"-B1.50"-AP16-09	6.00	1.50	2.50	0.630	9
	-8.00"-C2.50"-AP16-12	8.00	2.50	2.50	0.630	12



Spare parts

Diameter ØD	Inserts	Screw	Wrench	Sketch of installation
				
Ø=2"~4"	AP11	I60M2.5×6.5T	WT08IS	
Ø=2"~4"	AP16	I60M4×10	WT15IS	
Ø=5"~8"	AP16	I60M4×10	WT15IS	

Selection of inserts



😊 Good working conditions 😐 General working conditions 😞 Adverse working conditions

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Ferrite materials	S Heat-resistant steel
P Steel	😊	😊	😊	😊	😊
M Stainless steel	😊	😊	😊	😊	😊
K Cast iron	😊	😊	😊	😊	😊
N Ferrite materials	😊	😊	😊	😊	😊
S Heat-resistant steel	😊	😊	😊	😊	😊

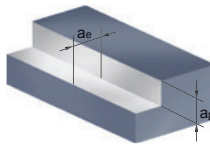
Insert shape	Type	Dimensions (inch)					Coated grade								Uncoated grade		
		L	I.W	S	ød	r	YBC302	YBM251	YBM253	YBM351	YBD252	YBG102	YBG202	YBG205	YB9320	YD101	YD201
	APKT11T304-APF	0.482	0.256	0.142	0.110	0.016									●		
	APKT11T308-APF	0.482	0.256	0.142	0.110	0.031									●		
	APKT160408-APF	0.704	0.367	0.227	0.173	0.031									●		
	APKT11T304-APM	0.482	0.256	0.142	0.110	0.016									●		
	APKT11T308-APM	0.482	0.256	0.142	0.110	0.031									●		
	APKT11T312-APM	0.482	0.256	0.142	0.110	0.047									●		
	APKT11T316-APM	0.482	0.256	0.142	0.110	0.063									●		
	APKT11T320-APM	0.482	0.256	0.142	0.110	0.079									●		
	APKT160408-APM	0.704	0.367	0.227	0.173	0.031									●		
	APKT160416-APM	0.704	0.367	0.227	0.173	0.063									●		
	APKT160420-APM	0.704	0.367	0.227	0.173	0.079									●		
	APKT160424-APM	0.704	0.367	0.227	0.173	0.094									●		
APKT160430-APM	0.704	0.367	0.227	0.173	0.118									●			
	APKT11T304-ALH	0.482	0.256	0.142	0.110	0.016									●	●	
	APKT11T308-ALH	0.482	0.256	0.142	0.110	0.031									●	○	
	APKT160408-ALH	0.704	0.367	0.227	0.173	0.031									●	●	

● Always stock available ○ Produce according to order

D

Chipbreaker selection

Classification	Function	For finishing	For Semi-finishing
P		-APF	-APM
M		-APF	-APM
K		-APF	-APM
AL		-ALH	



Square shoulder milling

Recommended cutting parameters (D: Diameter)

Workpiece material	Hardness HB	Insert grade	Cutting parameters				
			V(SFPM)	f(in/z)		a _e (inch)	
				-APF	-APM		
P	Low-carbon steel, Soft steel	≤ 180	YB9320	1000(650-1300)	0.004(0.003-0.008)	0.008(0.004-0.012)	≤ 0.5D
	High-carbon steel, Alloy steel	180-280	YB9320	900(600-1100)	0.004(0.003-0.008)	0.008(0.004-0.012)	≤ 0.5D
	Alloy tool steel	280-350	YB9320	850(500-1100)	0.004(0.003-0.008)	0.008(0.004-0.012)	≤ 0.5D
M	Stainless steel	≤ 270	YB9320	650(360-1000)	0.004(0.003-0.008)	0.008(0.004-0.012)	≤ 0.5D
N				-ALH			
	Aluminium alloy	---	YD101	1000-	0.008(0.003-0.016)		≤ 0.5D
			YD201	1000-	0.008(0.003-0.016)		≤ 0.5D