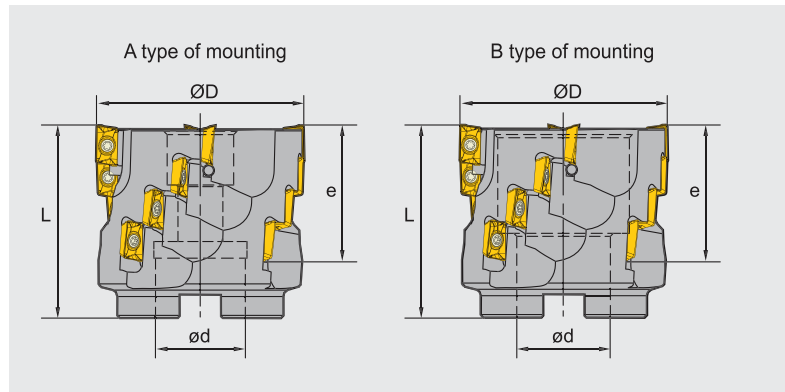


Square shoulder milling tools **Kr:90°**



EMP03 **P M K N**





Specification of tools

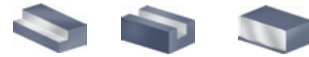
Type		Dimensions(inch)					
		ØD	ød	L	e	Z	Inserts total
EMP03	-2.00"-A0.75"-AP11-04	2.00	0.75	2.5	1.535	4	16
	-2.50"-A1.00"-AP11-04	2.50	1.00	2.5	1.535	4	16
	-3.00"-B1.25"-AP11-05	3.00	1.25	2.5	1.535	5	20
	-4.00"-B1.50"-AP11-06	4.00	1.50	2.5	1.535	6	24

D

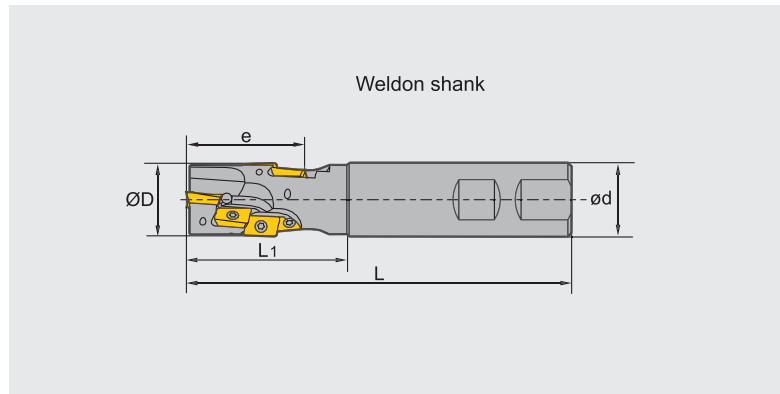
Spare parts

Inserts screw	Wrench	Sketch of installation
		
I60M2.5×6.5T	WT08IS	

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






EMP04 **P** **M** **K** **N**



Specification of tools

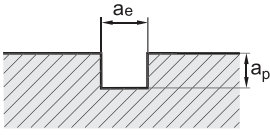
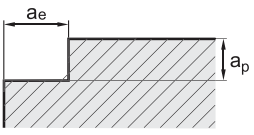
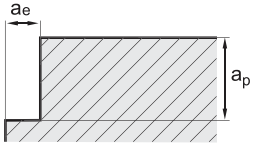
Type		Dimensions(inch)						
		ØD	ød	L1	L	e	Z	Inserts total
EMP04	-0.75" -XP0.75" -AP11-01	0.75	0.75	2.50	4.75	1.157	1	3
	-1.00" -XP1.00" -AP11-02	1.00	1.00	2.75	5.00	1.531	2	8
	-1.25" -XP1.25" -AP11-02	1.25	1.25	3.25	5.50	1.909	2	10
	-1.50" -XP1.50" -AP11-02	1.50	1.50	3.75	6.00	2.283	2	14

Spare parts

Insert screw	Wrench	Sketch of installation
 I60M2.5×6.5T	 WT08IS	

D

Recommended cutting parameters

Slot milling	Square shoulder milling	Deep square shoulder milling
		
$a_e = D$ $a_p \leq 0.5D$	$a_e \leq 0.5D$ $a_p \leq 1.2D$	$a_e \leq 0.2D$ $a_p < \text{Cutting length of insert}$

Workpiece material	Hardness HB	Insert grade	Cutting parameters			
			Square shoulder milling			
			V(SFPM)	f(in/z)		
-APF	-APM					
P Low-carbon steel, Soft steel	≤ 180	YB9320	900(650-1200)	0.004(0.003-0.008)	0.008(0.004-0.012)	
	180-280	YB9320	800(600-1200)	0.004(0.003-0.008)	0.008(0.004-0.012)	
	280-350	YB9320	700(500-1100)	0.004(0.003-0.008)	0.008(0.004-0.012)	
M Stainless steel	≤ 270	YB9320	500(360-900)	0.004(0.003-0.008)	0.008(0.004-0.012)	
N	-ALH					
	Aluminium alloy	YD101	1000-	0.008 (0.003-0.016)		
		YD201	1000-	0.008 (0.003-0.016)		