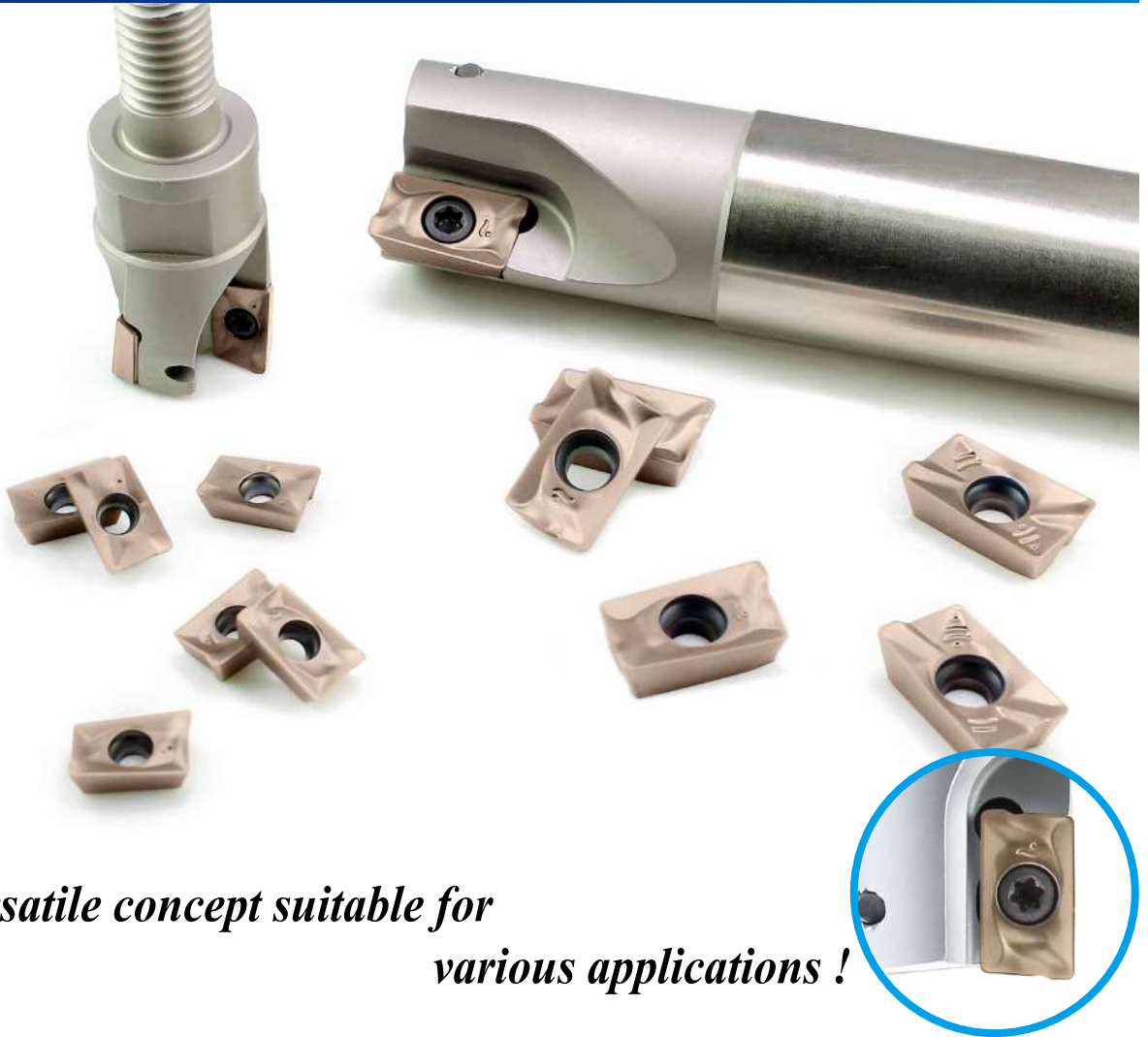


CAPK Shoulder Milling



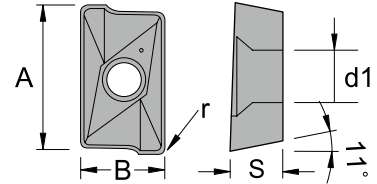
*Versatile concept suitable for various applications !*

- *Enhancement chip breaker design for longer tool life.*
- *Offering better cost efficiency on medium to large work pieces.*
- *Medium to large sized cutter for shoulder milling and face milling available.*

CAPK Shoulder Milling

### Insert Specifications

Insert	Dimensions (mm)				
	A	B	S	r	d1
APKT100304	10.5	6.7	3.5	0.4	2.8
APKT100308	10.5	6.7	3.5	0.8	2.8
APET160402	16.3	9.525	5.25	0.2	4.5
APET160404	16.3	9.525	5.25	0.4	4.5
APKT160408	16.3	9.525	5.25	0.8	4.5
APKT170516	18.5	10.7	5.56	1.6	4.5



### Insert Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IAPKT100304EAL10	APKT100304PDER-AL-CX10				●		
	IAPKT100304ESG22HS	APKT100304PDER-SG-CX22HS	●	●	●		○	●
	IAPKT100304EMG22HS	APKT100304PDER-MG-CX22HS	●	●	●		○	●
	IAPKT100304EMG23TS	APKT100304PDER-MG-CX23TS	●	●	●		●	●
	IAPKT100304EMG32HS	APKT100304PDER-MG-CX32HS	●	●	●		○	○
	IAPKT100304EMG33TS	APKT100304PDER-MG-CX33TS	●	●	●		●	●
	IAPKT100304EMG43TS	APKT100304PDER-MG-CX43TS	●	●	●		●	
	IAPKT100308EMG22HS	APKT100308PDER-MG-CX22HS	●	●	●		○	●
	IAPKT100308EMG23TS	APKT100308PDER-MG-CX23TS	●	●	●		●	●
	IAPKT100308EMG32HS	APKT100308PDER-MG-CX32HS	●	●	●		○	○
	IAPKT100308EMG33TS	APKT100308PDER-MG-CX33TS	●	●	●		●	●
	IAPKT100308EMG43TS	APKT100308PDER-MG-CX43TS	●	●	●		●	
	IAPKT100304ERG32HS	APKT100304PDER-RG-CX32HS	●	●	●		○	○
	IAPKT100304ERG33TS	APKT100304PDER-RG-CX33TS	●	●	●		●	●
	IAPKT160408EMG22HS	APKT160408PDER-MG-CX22HS	●	●	●		○	●
	IAPKT160408EMG32HS	APKT160408PDER-MG-CX32HS	●	●	●		○	○
	IAPKT160408EMG33TS	APKT160408PDER-MG-CX33TS	●	●	●		●	●
	IAPKT160408EMG43TS	APKT160408PDER-MG-CX43TS	●	●	●		●	
	IAPKT160408ERG22HS	APKT160408PDER-RG-CX22HS	●	●	●		○	●
	IAPKT160408ERG32HS	APKT160408PDER-RG-CX32HS	●	●	●		○	○
	IAPKT160408ERG33TS	APKT160408PDER-RG-CX33TS	●	●	●		●	●
	IAPKT160408ERG43TS	APKT160408PDER-RG-CX43TS	●	●	●		●	
	IAPKT170516ERG22HS	APKT170516PEER-RG-CX22HS	●	●	●		○	●
	IAPKT170516ERG23TS	APKT170516PEER-RG-CX23TS	●	●	●		●	●
	IAPKT170516ERG32HS	APKT170516PEER-RG-CX32HS	●	●	●		○	○
	IAPKT170516ERG33TS	APKT170516PEER-RG-CX33TS	●	●	●		●	●
	IAPKT170516ERG43TS	APKT170516PEER-RG-CX43TS	●	●	●		●	
	IAPET160402FAL10	APET160402PDFR-AL-CX10				●		
	IAPET160404FAL10	APET160404PDFR-AL-CX10				●		
	IAPET160402FFG22HS	APET160402PDFR-FG-CX22HS	●	●	●		○	●
	IAPET160404FFG22HS	APET160404PDFR-FG-CX22HS	●	●	●		○	●

**CAPK Shoulder Milling**

## Recommended Cutting Conditions

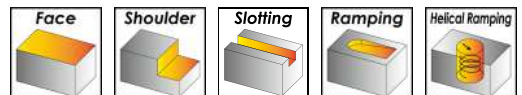
for APKT1003

Working Material	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.10 ~ 0.22	0.3 ~ 7.0
Stainless Steel	100 ~ 180	0.08 ~ 0.18	0.3 ~ 4.0
Cast Iron	120 ~ 250	0.10 ~ 0.22	0.3 ~ 6.0
High Temperature Alloy	40 ~ 100	0.07 ~ 0.14	0.3 ~ 4.0
Hardened Steel	50 ~ 100	0.07 ~ 0.15	0.3 ~ 4.0

for APKT1604

Working Material	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.12 ~ 0.28	0.5 ~ 11.0
Stainless Steel	100 ~ 180	0.10 ~ 0.22	0.5 ~ 7.0
Cast Iron	120 ~ 250	0.12 ~ 0.28	0.5 ~ 10.0
Aluminum Alloy	300 ~ 1000	0.10 ~ 0.40	0.5 ~ 11.0
High Temperature Alloy	40 ~ 100	0.10 ~ 0.18	0.5 ~ 7.0
Hardened Steel	50 ~ 100	0.10 ~ 0.20	0.5 ~ 7.0

## CAPKE - Milling tools



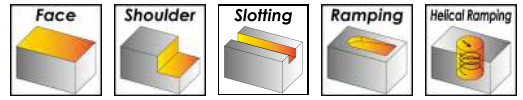
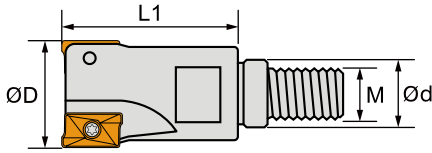
Order No.	D	L1	L	d	T	Inserts	Screw	Wrench	Stock
ICAPKE302016120	16	25	120	16	2	APKT1003	ITS2515	ITK08	●
ICAPKE302020120	20	30	120	20	2				●
ICAPKE304025150	25	35	150	25	4				●
ICAPKE305032150	32	35	150	32	5				○
ICAPKE402025150	25	40	150	25	2	APKT1604 or APET1604	ITS4004	ITK15	●
ICAPKE402032150	32	45	150	32	2				○

● stock ○ by inquiry

Customize available.

CAPK Shoulder Milling

CAPKM - Modular tools

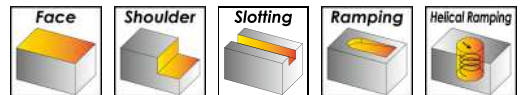
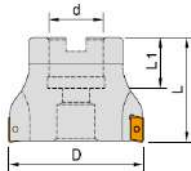


Order No.	D	L1	d	M	T	Inserts	Screw	Wrench	Stock
ICAPKM302016080	16	26	8.5	M8	2	APKT1003	ITS2515	ITK08	●
ICAPKM303020100	20	32	10.5	M10	3				○
ICAPKM304025120	25	38	12.5	M12	4				●
ICAPKM305032160	32	41	17	M16	5				○
ICAPKM402025120	25	38	12.5	M12	2	APKT1604 or APET1604	ITS4004	ITK15	○
ICAPKM403032160	32	41	17	M16	3				○

● stock ○ by inquiry

Customize available.

CAPKF - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench	Stock
ICAPKF306050220	50	20	40	22	6	APKT1003	ITS2515	ITK08	●
ICAPKF306063220	63	21	45	22	6				●
ICAPKF307080270	80	23	50	27	7				●
ICAPKF404050220	50	23	50	22	4	APKT1604 or APET1604	ITS4004	ITK15	●
ICAPKF405063220	63	23	50	22	5				●
ICAPKF406080270	80	32	55	27	6				●
ICAPKF408100320	100	32	55	32	8				●

● stock ○ by inquiry

Customize available.