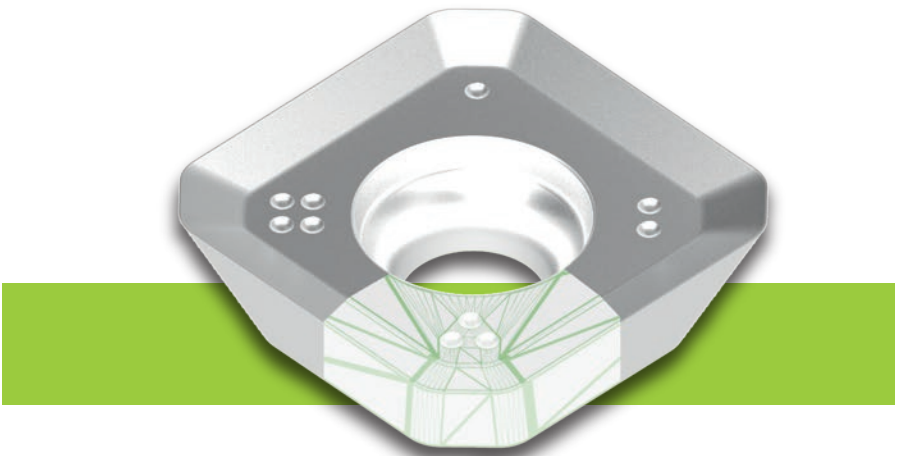


ALU-MILLING

LT 05

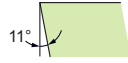




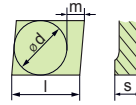
A P G T



Shape

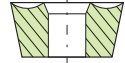


Clearance Angle



Tolerance

d ± 0.025
m ± 0.025
s ± 0.13

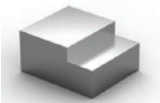


**Fixing,
Chipbreaker**

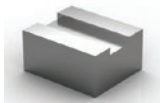
LT 05						
Insert Designation	l	s	r	Direction	Catalog Nr.	
APGT 100304 PDER-ALU LT05	10.80	3.52	0.40	Right	M0003089	
APGT 160408 PDER-ALU LT05	16.40	4.89	0.80	Right	M0001010	

Application Guide

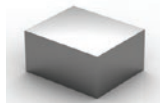
Shoulder Mill



Slotting



Surfacing



Machining Recommendations

F ⇒

Productivity

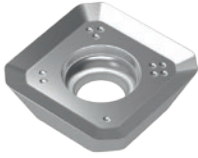
	1, 2, 3, 4	No
	6, 7, 8, 11	No
	10, 12	Yes
	5, 9	Yes

APGT 100304 PDER-ALU – LT 05

Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/tooth]		V _c [m/min]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C	Feed	V _c
NF Al (<8%Si) Copper Alloys Non-Metallic	13	21, 22	Si < 4 %	60 HB	0.3	9.0	0.12	0.20	400	1200	3.0	0.14	500
		23, 24	4% < Si < 8 %	100 HB	0.3	9.0	0.10	0.18	250	600	3.0	0.14	400
	14	26,27,28	CuZn30	100 HB	0.3	9.0	0.10	0.18	100	800	3.0	0.14	300
		29	Fiber Plastics	-	0.3	9.0	0.12	0.20	80	500	3.0	0.12	200
		30	Hard Rubber	-	0.3	9.0	0.12	0.20	80	300	3.0	0.12	150
H.T.A Ti Based Alloys	10	36	Ti 1	-	0.3	5.0	0.08	0.20	35	60	2.0	0.12	45
		37	TiAl 6 V4	-	0.3	5.0	0.08	0.15	28	45	2.0	0.12	35

APGT 160408 PDER-ALU – LT 05

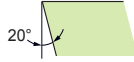
Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/tooth]		V _c [m/min]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C	Feed	V _c
NF Al (<8%Si) Copper Alloys Non-Metallic	13	21, 22	Si < 4 %	60 HB	0.5	15.0	0.15	0.32	400	1200	4.0	0.16	500
		23, 24	4% < Si < 8 %	100 HB	0.5	15.0	0.13	0.29	250	600	4.0	0.16	400
	14	26,27,28	CuZn30	100 HB	0.5	15.0	0.13	0.29	100	800	4.0	0.16	300
		29	Fiber Plastics	-	0.5	15.0	0.15	0.32	80	500	4.0	0.14	200
		30	Hard Rubber	-	0.5	15.0	0.15	0.32	80	300	4.0	0.14	150
H.T.A Ti Based Alloys	10	36	Ti 1	-	0.5	15.0	0.10	0.32	35	60	4.0	0.14	45
		37	TiAl 6 V4	-	0.5	15.0	0.10	0.24	28	45	4.0	0.14	35



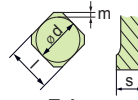
SEGT



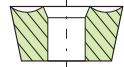
Shape



Clearance Angle



Tolerance
 $d \pm 0.025$
 $m \pm 0.025$
 $s \pm 0.13$



Fixing,
Chipbreaker

LT 05					
Insert Designation	l	s	r	Direction	Catalog Nr.
SEGT 1204 AFEN-ALU LT05	12.70	4.79	0.84	Neutral	M0001008

Application Guide

Surfacing



Chamfering



Machining Recommendations

F ⇒

Productivity

	1, 2, 3, 4	No
	6, 7, 8, 11	No
	10, 12	Yes
	5, 9	Yes

SEGT 1204 AFEN-ALU – LT 05

Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/tooth]		V _c [m/min]		Suggested Starting Parameters		
					min	max	min	max	min	max	D.O.C	Feed	V _c
NF	13	21, 22	Si < 4 %	60 HB	0.3	9.0	0.12	0.35	400	1200	3.0	0.25	500
		23, 24	4% < Si < 8 %	100 HB	0.3	9.0	0.10	0.35	250	600	3.0	0.25	400
	14	26,27,28	CuZn30	100 HB	0.3	9.0	0.10	0.35	100	800	3.0	0.25	300
	15	29	Fiber Plastics	-	0.3	9.0	0.12	0.35	80	500	3.0	0.20	200
		30	Hard Rubber	-	0.3	9.0	0.12	0.35	80	300	3.0	0.20	150
-		Graphite	-	0.3	9.0	0.12	0.35	100	200	3.0	0.20	150	
H.T.A	10	36	Ti 1	-	0.3	5.0	0.08	0.35	35	60	2.0	0.20	45
		37	TiAl 6 V4	-	0.3	5.0	0.08	0.28	28	45	2.0	0.20	35



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