STELLRAM

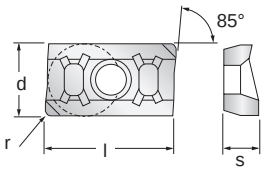

APET16-42


APHT16-42


APEX16-701


APHT16-F


APFW16-T



Shoulder Mills

Product			Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼					
EDP	Item Description	Grade	Depth of Cut (mm)			d (IC)	l	s	r	h_m min
			a_p max* or a_e max.*	a_p max. and a_e max. 15% D**	a_p min. - max.					
033180	APET160408TR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	0,80	0,10
033181	APET160410TR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	1,00	0,10
033182	APET160415TR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	1,50	0,10
033183	APET160420TR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	2,00	0,10
033184	APET160425TR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	2,50	0,10
015155	APHT1604PDTR-42	X500	●○	-	-	9,52	16,66	4,76	Facet	0,10
031466	APHT1604PDTR-42	SP6519	●●●○	■■●○	-	9,52	16,66	4,76	Facet	0,10
017293	APHT1604PDTR-42	MP91M	-	■●	-	9,52	16,66	4,76	Facet	0,10
033189	APEX1604PDFR-701	SP4019	●	●	-	9,52	16,66	4,76	Facet	0,02
014066	APEX1604PDFR-701	GH1	◆	◆	-	9,52	16,66	4,76	Facet	0,02
015154	APHT1604PDFR	GH1	■	■	-	9,52	16,66	4,76	Facet	0,02
033190	APFW1604PDTR	X400	●	◆	-	9,52	16,66	4,76	Facet	0,10
033191	APFW1604PDTR	SP4019	●	■	-	9,52	16,66	4,76	Facet	0,10
027883	APFW1604PDTR	SC3025	■	◆	-	9,52	16,66	4,76	Facet	0,10
017628	APFW1604PDTR	GH1	-	●	-	9,52	16,66	4,76	Facet	0,10

Machining Choice: ◆ 1st Choice ■ 2nd Choice ● 3rd Choice | Material Guide Key descriptions found on page A5.



* Note: Please do not surpass the recommended max. a_p for slotting as shown on the steel body page A188.
* Note: Please respect the following rule for profiling with a_p max:
for Shell mill cutter a_e < 75% of the Diameter
for Taper 50 cutter a_e < 60% of the Diameter

** Note: For semi finishing, axial engagement **a_p** for slotting and radial engagement **a_e** for profiling should be max. 15% of the Diameter.

APHT1604PDTR-42 X500 to be used for Stainless Steel with heavy scale or for unstable conditions.
APFW1604PDTR X400 should be used for Alloyed Steel with heavy scale or hardened steel.
APFW1604PDTR SP4019 should be used for High Temperature Alloys with heavy scale or hardened steel.

Note: Feed recommendations can be found on page A191. Speed recommendations can be found on page A193.