


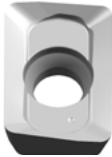






APK(E)T Series Geometry

Light Cutting for General Material	Medium Cutting for General Material	Heavy Cutting for General Material	Aluminum Cutting
			
GL	GM	GH	NL
			
Light cutting of low cutting force, good processing quality.	High stability in most cases.	Suitable on roughing, good edge strength.	Suitable on Al processing, sharp edge with polishing.

Shoulder Milling

MEB190

Arbor

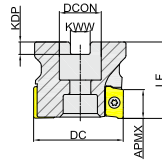


Fig1

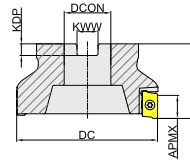


Fig2

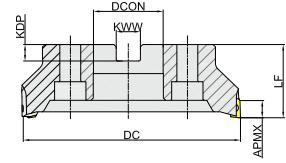


Fig3

Ordering Code	Dia- meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	KWW	KDP					
MEB190040R05A16AP11	40	5	40	16	40	8.4	5.6	9	APK(E)T1135	✓	Fig1	●
MEB190050R04A22AP16	50	4	50	22	40	10.4	6.3	14	APK(E)T1604	✓	Fig1	●
MEB190050R07A22AP11	50	7	50	22	40	10.4	6.3	9	APK(E)T1135	✓	Fig1	●
MEB190063R05A22AP16	63	5	63	22	40	10.4	6.3	14	APK(E)T1604	✓	Fig1	●
MEB190063R07A22AP11	63	7	63	22	40	10.4	6.3	9	APK(E)T1135	×	Fig1	●
MEB190080R07A27AP16	80	7	80	27	50	12.4	7	14	APK(E)T1604	✓	Fig1	●
MEB190080R08A27AP11	80	8	80	27	50	12.4	7	9	APK(E)T1135	✓	Fig1	●
MEB190100R08A32AP16	100	8	100	32	50	14.4	8	14	APK(E)T1604	✓	Fig1	●
MEB190100R12B32AP11	100	12	100	32	63	14.4	8	9	APK(E)T1135	✓	Fig2	●
MEB190125R06B40AP16	125	6	125	40	63	16.4	9	14	APK(E)T1604	×	Fig2	●
MEB190125R09B40AP16	125	9	125	40	63	16.4	9	14	APK(E)T1604	×	Fig2	●
MEB190125R11B40AP11	125	11	125	40	63	16.4	9	9	APK(E)T1135	×	Fig2	●
MEB190160R10C40AP16	160	10	160	40	63	16.4	9	14	APK(E)T1604	×	Fig3	●
MEB190200R12C60AP16	200	12	200	60	63	25.7	13	14	APK(E)T1604	×	Fig3	●

● Stock ○ Available Upon Order

Shoulder Milling

MEB190

Side Clamp Type

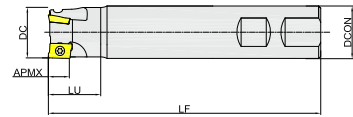


Fig4

Ordering Code	Dia-meter	Teeth	Dimension(mm)				APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	LU					
MEB190016R02W16AP11	16	2	16	16	130	25	9	APK(E)T1135	×	Fig4	●
MEB190016R02W16AP11L	16	2	16	16	200	50	9	APK(E)T1135	×	Fig4	●
MEB190020R02W20AP11	20	2	20	20	130	25	9	APK(E)T1135	×	Fig4	●
MEB190020R03W20AP11	20	3	20	20	130	25	9	APK(E)T1135	✓	Fig4	●
MEB190020R03W20AP11L	20	3	20	20	200	85	9	APK(E)T1135	✓	Fig4	●
MEB190025R02W25AP16	25	2	25	25	130	45	14	APK(E)T1604	✓	Fig4	●
MEB190025R02W25AP16L	25	2	25	25	200	83	14	APK(E)T1604	✓	Fig4	●
MEB190025R03W25AP11	25	3	25	25	130	28	9	APK(E)T1135	✓	Fig4	●
MEB190025R03W25AP11L	25	3	25	25	200	89	9	APK(E)T1135	×	Fig4	●
MEB190025R04W25AP11	25	4	25	25	130	28	9	APK(E)T1135	✓	Fig4	●
MEB190032R03W32AP16	32	3	32	32	130	40	14	APK(E)T1604	✓	Fig4	●
MEB190032R03W32AP16L	32	3	32	32	200	54	14	APK(E)T1604	✓	Fig4	●
MEB190032R04W32AP11	32	4	32	32	130	30	9	APK(E)T1135	✓	Fig4	●
MEB190032R04W32AP11L	32	4	32	32	200	90	9	APK(E)T1135	✓	Fig4	●
MEB190040R03W32AP16	40	3	40	32	150	45	14	APK(E)T1604	✓	Fig4	●

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MEB190

Replaceable Tool Head

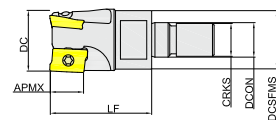


Fig5

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCSFMS	DCON	LF	CRKS					
MEB190016R02M08AP11	16	2	16	14.5	8.5	26	M8	9	APK(E)T1135	×	Fig5	●
MEB190020R03M10AP11	20	3	20	17.8	10.5	31	M10	9	APK(E)T1135	✓	Fig5	●
MEB190025R02M12AP16	25	2	25	23	17	35	M12	14	APK(E)T1604	✓	Fig5	●
MEB190025R03M12AP11	25	3	25	23	12.5	35	M12	9	APK(E)T1135	✓	Fig5	●
MEB190025R04M12AP11	25	4	25	23	12.5	35	M12	9	APK(E)T1135	✓	Fig5	●
MEB190032R03M16AP16	32	3	32	28.5	17	43	M16	14	APK(E)T1604	✓	Fig5	●
MEB190032R04M16AP11	32	4	32	28.5	17	43	M16	9	APK(E)T1135	✓	Fig5	●
MEB190032R05M16AP11	32	5	32	28.5	17	43	M16	9	APK(E)T1135	✓	Fig5	●
MEB190035R05M16AP11	35	5	35	28.5	17	43	M16	9	APK(E)T1135	✓	Fig5	●

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Shoulder Milling

MHB190

Corn Milling Cutter Body MHB190-Arbor

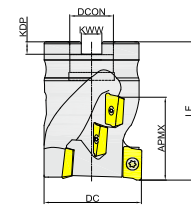


Fig6

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	KWW	KDP					
MHB190050R03A22AP16	50	3/9	50	22	70	10.4	6.3	43	APKT1604	✓	Fig6	●
MHB190050R04A22AP11	50	4/16	50	22	70	10.4	6.3	39.9	APKT1135	×	Fig6	●
MHB190063R04A27AP16	63	4/16	63	27	85	12.4	6.3	57	APKT1604	✓	Fig6	●
MHB190063R05A27AP11	63	5/20	63	27	70	12.4	6.3	39.9	APKT1135	✓	Fig6	●
MHB190080R05A32AP16	80	5/20	80	32	85	14.4	7	57	APKT1604	✓	Fig6	●

● Stock ○ Available Upon Order

MHB190

Corn Milling Cutter Body MHB190-Side Clamp Type

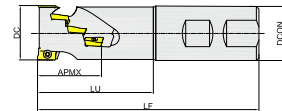


Fig7

Ordering Code	Dia-meter	Teeth	Dimension(mm)				APMX	Suitable for	Coolant	Shape	Stock
			DC	DCON	LF	LU					
MHB190032R02W32AP11	32	2/8	32	32	130	65	39.9	APKT1135	✓	Fig7	●
MHB190040R03W32AP11	40	3/12	40	32	130	66	39.9	APKT1135	✓	Fig7	●

● Stock ○ Available Upon Order

Spare Parts

Part Name		Inserts Screw	Insert Screw Wrench	
Inserts	Shape			
	Specification	SI60M3.0X7.2-04210	TT09P	TT09T
APKT1135	Ordering Code	SI60M030072-04210S	TT09PQ	TT09TQ
	Specification	SI60M3.5X8-05314	TT15P	TT15T
APKT1604	Ordering Code	SI60M035080-05314S	TT15PQ	TT15TQ

Recommended Cutting Data

Workpiece	Hardness	Grade	Specification	Ap (mm)	Cutting Speed Vc(m/min)	Feed Rate/Edges fz(mm)			
						Light Cutting(L)	Medium Cutting(M)	Heavy Cutting(H)	
P	Soft Steel	≤ HB180	GA4225 GA4230	APKT1135	2.7	180 (140-220)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
				APKT1604	4.2		0.2 (0.1-0.3)	0.25 (0.15-0.35)	0.3 (0.2-0.4)
	Carbon Steel, Alloy Steel	HB180-350	GA4225 GA4230 GP2115	APKT1135	2.7	150 (110-190)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
				APKT1604	4.2		0.2 (0.1-0.3)	0.25 (0.15-0.35)	0.3 (0.2-0.4)
	Pre-harden Steel	HRC35-45	GA4230 GA4225 GP2115	APKT1135	2.7	130 (90-170)	0.08 (0.05-0.15)	0.1 (0.05-0.15)	0.15 (0.1-0.2)
				APKT1604	4.2		0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
M	Stainless (Ferrite, Martensite)	≤ HB270	GM2140 GM4135 GA4230	APKT1135	2.7	160 (120-200)	0.12 (0.1-0.2)	0.15 (0.1-0.2)	0.2 (0.1-0.3)
				APKT1604	4.2		0.15 (0.1-0.2)	0.25 (0.15-0.35)	0.3 (0.2-0.4)
	Stainless (Austenite, Diphasic)	≤ HB270	GM2140 GM4135	APKT1135	2.7	160 (120-200)	0.1 (0.05-0.15)	0.12 (0.1-0.2)	0.15 (0.1-0.2)
				APKT1604	4.2		0.12 (0.1-0.2)	0.15 (0.1-0.2)	0.2 (0.1-0.3)
K	Grey Cast Iron	≤ HB280	GK2115 GK4125	APKT1135	2.7	180 (150-220)	0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
				APKT1604	4.2		0.2 (0.1-0.3)	0.25 (0.1-0.4)	0.3 (0.2-0.5)
	Nodular Cast Iron, Vermicular Graphite Cast Iron	≤ HB350	GK4125 GK2115	APKT1135	2.7	120 (100-180)	0.1 (0.05-0.15)	0.1 (0.05-0.15)	0.15 (0.1-0.2)
				APKT1604	4.2		0.2 (0.1-0.3)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
N	Aluminium alloy	HB60-210	GN9125	APET1135	2.7	500 (200-900)	0.08 (0.05-0.15)	0.1 (0.05-0.15)	0.15 (0.1-0.2)
				APET1604	4.2		0.1 (0.05-0.15)	0.15 (0.1-0.2)	0.2 (0.1-0.25)
S	Heat-resistant Alloy and Titanium Alloy	HRC30-45	GS4130	APKT1135	2.7	60 (50-100)	0.08 (0.05-0.15)	0.08 (0.05-0.15)	0.1 (0.05-0.15)
				APKT1604	4.2		0.1 (0.05-0.15)	0.1 (0.05-0.15)	0.15 (0.1-0.2)