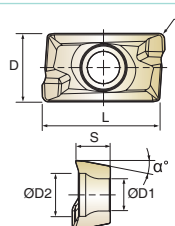





Insert	Continuous	Minor Intermittent	Heavy Intermittent				
	P	Steel	●	●			
	M	Stainless Steel	●	●			
	K	Cast Iron			●	●	
	N	Non Ferrous					●
	S	Heat Resistant					●




## APKT10

SHAPE	DESIGNATION	EDP No.	Grade					Dimension					
			PVD			CVD	Carbide	D	L	S	r	ØD1	ØD2
			YA702	YA703	YA503	YA102	YAK10						
	APKT103504PDER-HAM	XZM1P00001	●					6.7	10.5	3.5	0.4	2.8	3.9
	APKT103504PDER-HAM	XZM1C00001				●		6.7	10.5	3.5	0.4	2.8	3.9
	APKT103504PDER-HAM	XZM1P00005			●			6.7	10.5	3.5	0.4	2.8	3.9
	APKT103504PDER-HAM	XZM1P00007		●				6.7	10.5	3.5	0.4	2.8	3.9
	APKT103508PDER-HAM	XZM1P00009		○				6.7	10.5	3.5	0.8	2.8	3.9

\* Stock situation is subject to change without notice.

\* ● : Stock item ○ : Order made item ○ : Will be launched by end of 2014


## APKT11

SHAPE	DESIGNATION	EDP No.	Grade					Dimension					
			PVD			CVD	Carbide	D	L	S	r	ØD1	ØD2
			YA702	YA703	YA503	YA102	YAK10						
	APKT113504PDER-HAM	XZM1P00003	●					6.2	10.8	3.5	0.4	2.8	3.8
	APKT113508PDER-HAM	XZM1P00004	●					6.2	10.8	3.5	0.8	2.8	3.8

\* Stock situation is subject to change without notice.

\* ● : Stock item ○ : Order made item ○ : Will be launched by end of 2014

## APKT16

SHAPE	DESIGNATION	EDP No.	Grade					Dimension					
			PVD			CVD	Carbide	D	L	S	r	ØD1	ØD2
			YA702	YA703	YA503	YA102	YAK10						
	APKT160408PDER-HAM	XZM1P00002	●					9.5	16.3	5.3	0.8	4.5	6.0
	APKT160408PDER-HAM	XZM1C00002				●		9.5	16.3	5.3	0.8	4.5	6.0
	APKT160408PDER-HAM	XZM1P00006			●			9.5	16.3	5.3	0.8	4.5	6.0
	APKT160408PDER-HAM	XZM1P00008		●				9.5	16.3	5.3	0.8	4.5	6.0
	APKT160412PDER-HAM	XZM1P00010		○				9.5	16.3	5.3	1.2	4.5	6.0
	APKT160404PDFR-HAA	C08A1E4A3B1					○	9.5	16.3	5.3	0.4	4.5	6.0
	APKT160408PDFR-HAA	C08A1A4A3B1					○	9.5	16.3	5.3	0.8	4.5	6.0

\* Stock situation is subject to change without notice.

\* ● : Stock item ○ : Order made item ○ : Will be launched by end of 2014



## Recommended Cutting Conditions

	Work piece	Grade	ISO Classification	Recommended Cutting Speed Vc (m/min)
<b>P</b>	Steel	YA702	P20~30	200 (50~300)
<b>M</b>	Stainless Steel	YA703	M20~30	150 (50~250)
<b>K</b>	Cast Iron	YA102	K10~20	200 (150~250)
		YA503	K20~30	140 (80~200)
	Ductile Cast Iron	YA102	K10~20	140 (80~200)
		YA503	K20~30	120 (60~180)

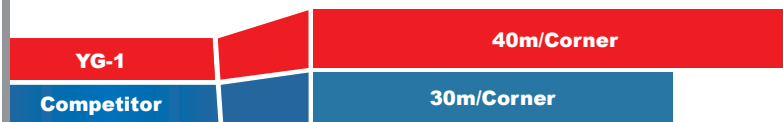
## Application Example

### Machining situation



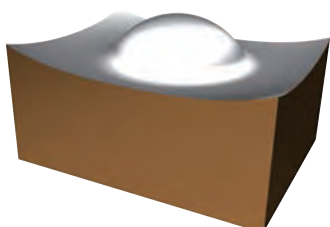
Work piece  
- JIS : SKD11  
- DIN : 1.2379 (x155 CrMoV121)  
- AISI : H13

Work piece		SKD11
Cutting Conditions	Speed (vc)	196 m/min
	Feed (fz)	0.5 mm/tooth
	Depth (ap)	ap = 3mm
	Coolant	Dry
	Insert	RDMT10T30M0 (YA702)
	Cutter	Ø25 Shank type(Z=2)



**130% longer tool life than competitor !**

### Machining situation



Work piece  
- JIS : SKD11  
- DIN : 1.2379 (x155 CrMoV121)  
- AISI : H13

Work piece		SKD11
Cutting Conditions	Speed (vc)	117 m/min
	Feed (fz)	0.53 mm/tooth
	Depth (ap)	0.3mm
	Coolant	Dry
	Insert	RDMT10T30M0 (YA702)
	Cutter	Ø25 Shank type(Z=2)



**200% longer tool life than competitor !**