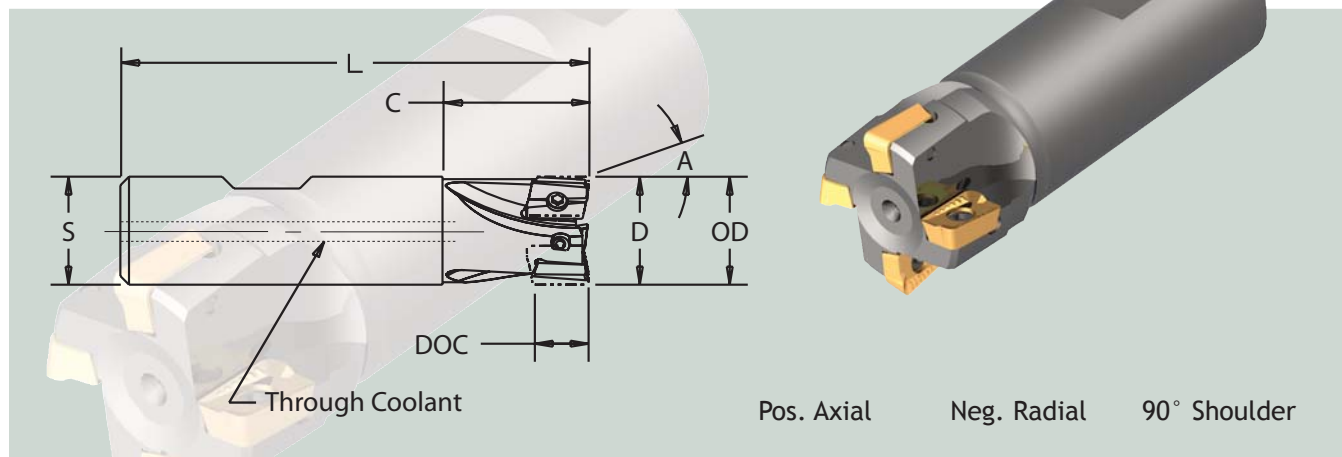
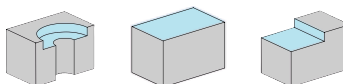


Positive End Mills - 90° Shoulder

215 Series



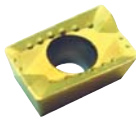
APKX inserts provide longer cut - 15mm

215 Series End Mills - Dimensional Specifications

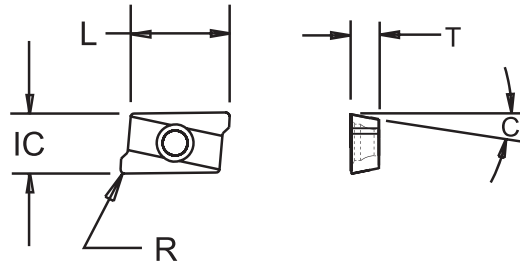
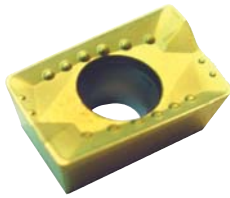
Product Number	D	OD	S	L	C	A	DOC	Teeth
215E0100AAP3-W100RC	1.000	1.000	1.000	3.50	1.22	90°	0.555	2
215E0100BAP3-S100RC	1.000	1.000	1.000	6.50	1.25	90°	0.555	2
215E0125AAP3-W125RC	1.250	1.250	1.250	3.75	1.47	90°	0.555	3
215E0125BAP3-S125RC	1.250	1.250	1.250	7.62	1.80	90°	0.555	3
215E0150AAP3-W125RC	1.500	1.500	1.250	4.00	1.29	90°	0.555	4

A = Standard lengths B = Extended lengths S = Straight Shank W = Weldon Shank RC = Through Coolant

Accessory Parts

Insert IC x Thickness				
	Insert - 15mm Long see page 23	Torx Screw 1" to 1.25" dia.'s	Torx Screw 1.5" dia. only	Wrench
.591 x .375	APKX-1505PDER_	3605-0001-0056	3605-0001-0055	1557-TX15

215 & 218 Series



Insert Dimensional & Grade Specifications											
Insert Number	IC	T	R	C	L	LT-5026			LT-8016		
APKX-1505PDER-F	0.375	0.220	0.031	11°	0.591						
APKX-1505PDER-M	0.375	0.220	0.031	11°	0.591						

• = Primary insert and grade □ = Conditional insert and grade

LT-5026 MT-CVD

- High Cutting Speed
- Primarily without coolant
- Medium to high chip thickness
- Can use it conditionally for stainless & heat treated materials

LT-8016 PVD

- Most wear resistant
- Primarily for finishing and semi-finishing operations
- Fine grain structure
- Can be used on heat treated materials

- “F” Finishing Chipbreaker Geometry has a sharper edge for work hardening alloys, finish cuts, gummy materials
- “M” Medium Chipbreaker Geometry has a reinforced top land for added edge strength when needed
- “R” Roughing Chipbreaker Geometry for severe interruptions, forgings, heavy scale

Machining Parameters			
Material	SFPM	FPT	Insert
Low Carbon Steel	400 - 900	.003 - .008	APKX-1505PDER-M LT-5026
Alloy Steel	300 - 700	.003 - .008	APKX-1505PDER-M LT-5026
Austenitic Stainless	250 - 500	.003 - .008	APKX-1505PDER-F LT-8016
Martensitic Stainless	250 - 500	.003 - .008	APKX-1505PDER-M LT-5026
Aluminum	1000 & up	.003 - .008	APKX-1505PDER-F LT-8016
Copper	500 - 1000	.003 - .008	APKX-1505PDER-F LT-8016
Gray Cast Iron	300 - 800	.003 - .008	APKX-1505PDER-F LT-8016
Ductile Iron	300 - 800	.003 - .008	APKX-1505PDER-M LT-5026
Titanium	80 - 150	.003 - .008	APKX-1505PDER-F LT-8016
Heat Treat Steel (above 45Rc)	90 - 200	.003 - .008	APKX-1505PDER-F LT-8016

H = Hard Steel

P = Steel **M** = Stainless **K** = Cast Iron **N** = Non-Ferrous **S** = High Temp Alloy