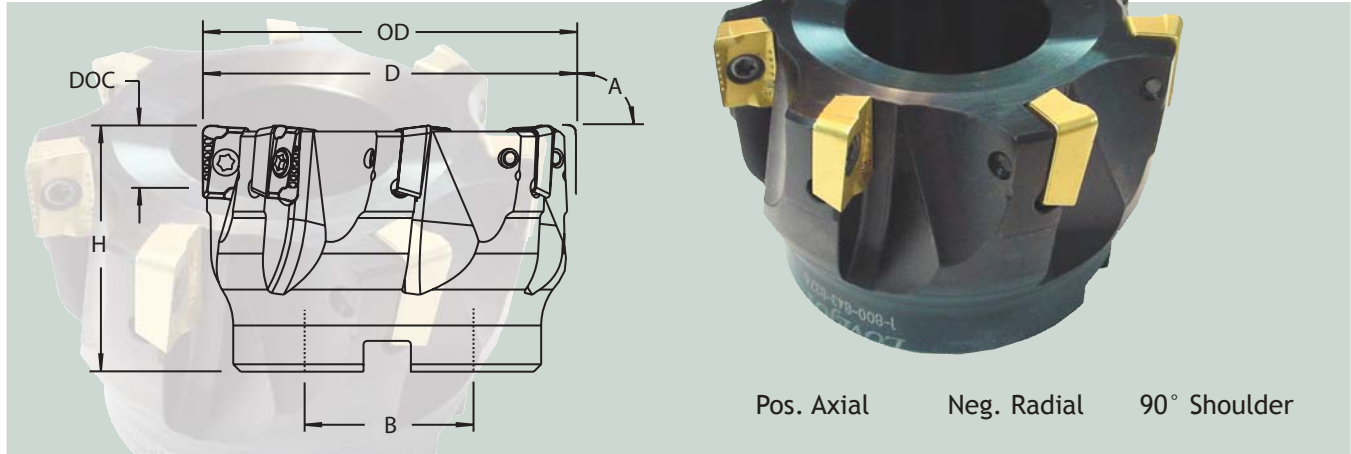
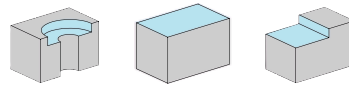


# Positive Face Mills - 90° Shoulder



## 215 Series



APKX inserts provide longer cut - 15mm

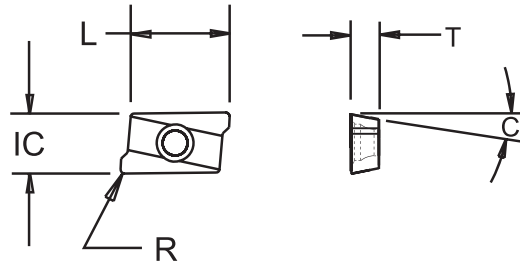
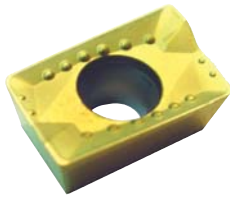
### 215 Series Face Mills - Dimensional Specifications

Product Number	D	OD	B	H	A	DOC	Teeth
215F0150AAP3-075R	1.500	1.500	0.750	1.750	90°	0.555	4
215F0200AAP3-075R	2.000	2.000	0.750	1.750	90°	0.555	5
215F0250AAP3-100R	2.500	2.500	1.000	2.000	90°	0.555	6
215F0300AAP3-100R	3.000	3.000	1.000	2.000	90°	0.555	7
215F0400AAP3-150R	4.000	4.000	1.500	2.000	90°	0.555	8

### Accessory Parts

Insert IC x Thickness			
	Insert - 15mm Long see page 23	Torx Screw	Wrench
.591 x .375	APKX-1505PDER_	3605-0001-0055	1557-TX15

## 215 & 218 Series



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

• = 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