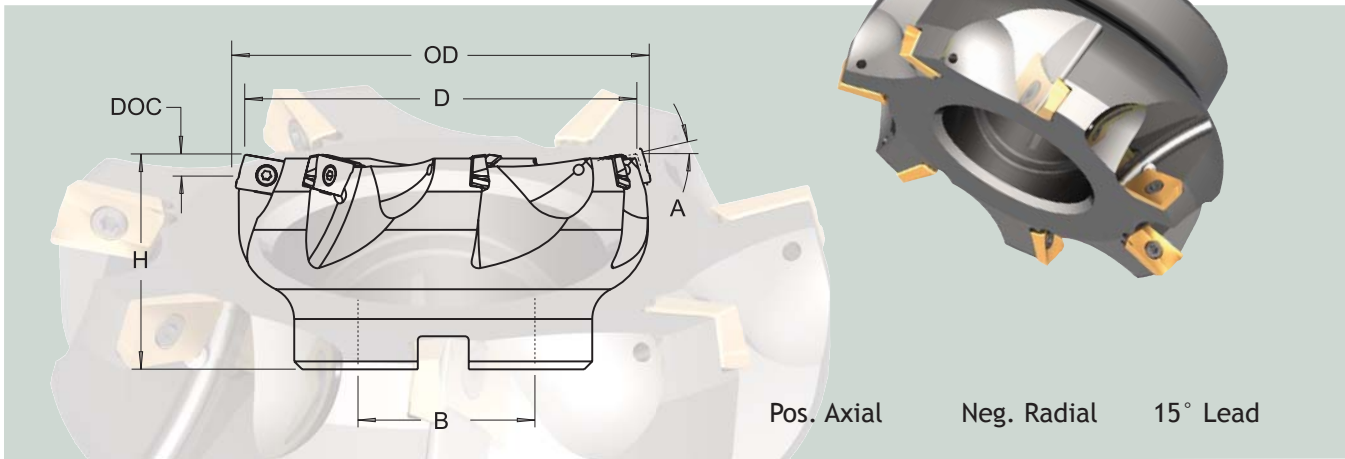
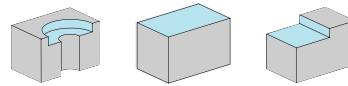


Positive Face Mills - 15° Shoulder



218 Series

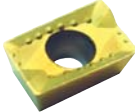




218 Series Face Mills - Dimensional Specifications

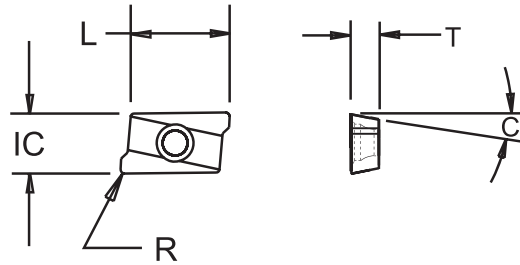
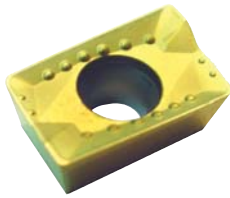
| Product Number | D | OD | B | H | A | DOC | Teeth |
|-------------------|-------|-------|-------|-------|-----|-------|-------|
| 218F0300AAP3-100R | 3.000 | 3.128 | 1.000 | 1.625 | 15° | 0.120 | 7 |

Face Mills use opposite corners of APKX style inserts

Accessory Parts

| Insert IC x Thickness |  |  |  |
|-----------------------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| | Insert - 15mm Long see page 23 | Torx Screw | Wrench |
| .375 x .220 | APKX-1505PDER_ | 3605-0001-0055 | 1557-TX08 |

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