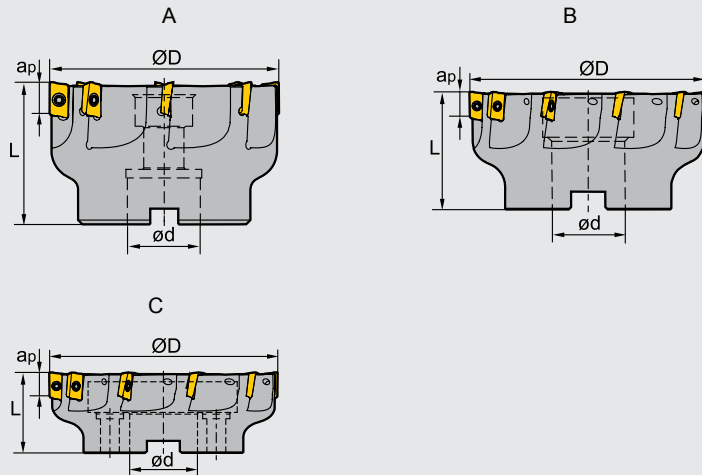


### Square shoulder milling tools · Eckfräser

**Kr:90°**



**EMPO2** P M K N



### Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen				No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)
		Ø D	Ø d	L	apmax			
<b>EMPO2</b> 050-A22-AP11-06	●	50	22	40	11	6	A	0.3
050-A22-AP11-06C	●	50	22	40	11	6	A	0.3
063-A22-AP11-08	●	63	22	40	11	8	A	0.6
063-A22-AP11-08C	●	63	22	40	11	8	A	0.6
080-A27-AP11-08	●	80	27	50	11	8	A	1.2
080-A27-AP11-08C	●	80	27	50	11	8	A	1.2
100-B32-AP11-10	●	100	32	50	11	10	B	1.7
100-B32-AP11-10C	●	100	32	50	11	10	B	1.7
050-A22-AP16-05	●	50	22	40	15.5	5	A	0.3
050-A22-AP16-05C	●	50	22	40	15.5	5	A	0.3
063-A22-AP16-06	●	63	22	40	15.5	6	A	0.5
063-A22-AP16-06C	●	63	22	40	15.5	6	A	0.5
080-A27-AP16-07	●	80	27	50	15.5	7	A	1.1
080-A27-AP16-07C	●	80	27	50	15.5	7	A	1.1
100-B32-AP16-08	●	100	32	50	15.5	8	B	1.6
100-B32-AP16-08C	●	100	32	50	15.5	8	B	1.6
125-B40-AP16-10	○	125	40	63	15.5	10	B	3.2
125-B40-AP16-10C	○	125	40	63	15.5	10	B	3.2
160-B40-AP16-10	○	160	40	63	15.5	10	B	6.3
160-B40-AP16-10C	○	160	40	63	15.5	10	B	6.3
200-C60-AP16-12	○	200	60	63	15.5	12	C	8.1
250-C60-AP16-12	○	250	60	63	15.5	12	C	11.2

### Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Wrench Schlüssel	
Ø50-Ø250	AP11	I60M2.5×6.5T	WT08IS	
Ø50-Ø250	AP16	I60M4×10	WT15IS	

Applicable tool **B11-B18**  
Werkzeug

Tools code key **B26-B27**  
Werkzeug ISO

Grade selection guide **B19-B23**  
Sortenauswahl

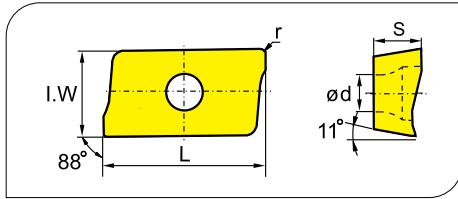
Technical data **B215-B220**  
Technische Daten

# Milling · Fräsen

## Indexable Milling Tools · Wendeplattenfräser

■ Applicable inserts · Wendeschneidplatten

- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

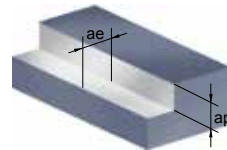
Insert shape / Plattenform	Type / Typ	Dimensions (mm) / Abmessungen					CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.			Cermet / Cermet	Carbide uncoat. / unbe. Hartmetall									
		L	I.W	S	d	r	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102		YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	APKT11T304-PF	12.24	6.5	3.6	2.8	0.4	○		●					●	●	●										
	APKT11T308-PF	12.24	6.5	3.6	2.8	0.8			○						●											
	APKT11T312-PF	12.24	6.5	3.6	2.8	1.2									○											
	APKT11T316-PF	12.24	6.5	3.6	2.8	1.6									○											
	APKT160408-PF	17.877	9.33	5.76	4.4	0.8	●		○	●				●	●											
	APKT11T304-PM	12.24	6.5	3.6	2.8	0.4	●	●	●	●	●			●	●	●										
	APKT11T308-PM	12.24	6.5	3.6	2.8	0.8	●	●		●	●	●	●	●	●	●	●									
	APKT11T312-PM	12.24	6.5	3.6	2.8	1.2				○					○	●										
	APKT11T316-PM	12.24	6.5	3.6	2.8	1.6				●					○	●										
	APKT160408-PM	17.877	9.33	5.76	4.4	0.8	●	●	●	●	●	●	●	●	●	●	●									
	APKT11T304-PR	12.24	6.5	3.6	2.8	0.4			●		○						○									
	APKT11T308-PR	12.24	6.5	3.6	2.8	0.4											○									
	APKT11T312-PR	12.24	6.5	3.6	2.8	0.4											○									
	APKT11T316-PR	12.24	6.5	3.6	2.8	0.4											○									
	APKT160408-PR	17.877	9.33	5.76	4.4	0.8											○									
	APKT11T304-LH	12.24	6.5	3.6	2.8	0.4																	●	●		
	APKT11T308-LH	12.24	6.5	3.6	2.8	0.8																	●	●		
	APET160402-LH	17.877	9.33	5.76	4.4	0.2																	○			
	APKT160408-LH	17.877	9.33	5.76	4.4	0.8																	●	●		
	APET160408PDR-LH	17.877	9.33	5.76	4.4	0.8																	○			

● Ex Stock / ab Lager ○ On demand / auf Anfrage

### Chipbreaker Selection - Spanbrecher Auswahl

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen
<b>P</b>	-PF	-PM	-PR
<b>M</b>	-PF	-PM	-PR
<b>K</b>	-PF	-PM	
<b>AL</b>	-LH		

### Square shoulder milling Eckfräsen



### Recommended cutting data - Empfohlene Schnittdaten

Workpiece material Werkstück Material	Hardness HB Härte	Grade Sorte	Cutting data Schnittdaten				
			V(m/min)	f(mm/z)			ae(mm)
				-PF	-PM	-PR	
<b>P</b>	Low-carbon steel Soft steel Niedrig legierter Kohlenstoffstahl Baustahl	YBM251	320 (240-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	≤0.5D
		YBC301					
		YBM351	260 (180-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	≤0.5D
		YBG202 YBG205	320 (200-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	≤0.5D
	High-carbon steel Alloy steel Hoch Leg. Kohlenstoffstahl Leg. Stahl	YBM251	280 (210-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
		YBC301					
		YBM351	240 (160-320)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	≤0.5D
		YBG202 YBG205	280 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
	Alloy tool steel Leg. Werkzeugstahl	YBM251	260 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
		YBC301					
		YBM351	220 (150-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	≤0.5D
		YBG202	260 (160-330)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
<b>M</b>	Stainless steel Rostfreier Stahl	YBM251	200 (120-270)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
		YBC301					
		YBM351	180 (150-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
		YBG202	200 (110-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
<b>K</b>	Cast iron Gusseisen	YBG302	170 (100-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	≤0.5D
		YBG102	220 (120-250)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	-	≤0.5D
		YBD152	240 (180-300)	-	0.2 (0.1-0.3)	-	≤0.5D
<b>N</b>	Al alloy Al Leg.	YBD252	200 (120-320)	-	0.2 (0.1-0.3)	-	≤0.5D
					-LH		
<b>N</b>	Al alloy Al Leg.	YD101	300-	0.2 (0.08-0.4)			≤0.5D
		YD201	300-	0.2 (0.08-0.4)			≤0.5D

Applicable tool  
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