

Shoulder milling tool for high helix

# Alpha Mill-X

KORLOY  
TECH-NEWS



- High helix cutting edge realizes high speed and high feed machining (15% higher speed than conventional tool's machining) and increases 20% higher productivity.
- Highly precise cutting edge ensures high quality surface finish in milling.

Shoulder milling tool for high helix

# Alpha Mill-X

The recent trend of cutting conditions has been changing to high speed and high feed conditions to decrease tooling cost from high productivity. However, without tool productivity and rigidity, chattering from impact in interrupted machining reduces surface finish and occurs tool fracture.

KORLOY introduces Alpha Mill-X ensuring high speed and high feed machining with high quality to increase productivity.

**Alpha Mill-X** with exclusive chip breaker and cutting edge with high rake angle reduces cutting load and controls chattering in machining.

The insert for the Alpha Mill-X is thicker than the conventional ones which increases tool rigidity and realizes stable machining from stable clamping system with flat flank surface clamping structure. In addition, wide wiper minor cutting edge and precise perpendicular cutting edge of Alpha Mill-X ensure milling with high quality.

The Alpha Mill-X with various sized nose-R and optimal grades for each cutting conditions increases productivity in high speed and feed machining with high performance.



## Longer tool life

- New shape and optimal grade

## Soft cutting and high speed and high feed machining

- High rake angle chip breaker and cutting edge

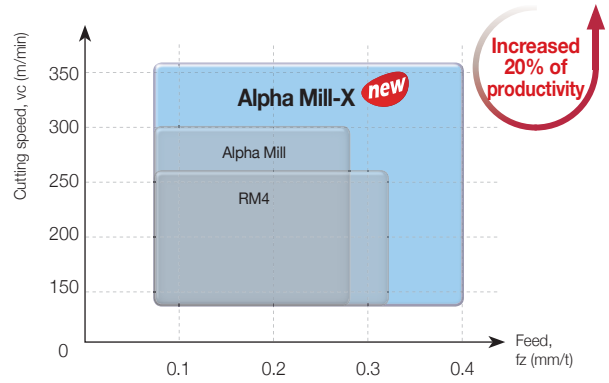
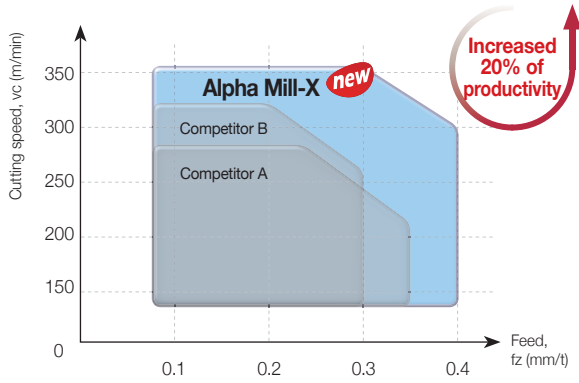
## Stable machinability

- Increased clamping force due to thicker insert and flat flank surface clamping structure

## Good surface finish and perpendicularity

- Wide wiper minor cutting edge and precise cutting edge

## Application range



## Applications

Facing	Shouldering	Slotting	Ramping	Helical cutting

## Code system

### [ Shank type ]

AMX	S	032	R	-	2	C	32	-	150	-	AD17
Alpha Mill-X	Tool type S: Shank	Machining diameter 032: $\text{\O}32$ mm	Oil hole & Hand R: With Oil hole, right-handed NR: Without oil hole, right-handed	No. of tooth 2: 2 teeth	Shank type C: Cylinder W: Weldon	Shank diameter 32: $\text{\O}32$ mm	Overall length 150: 150 mm	Available insert AD17: ADKT17 AD12: ADKT12 AD10: ADKT10			

### [ Cutter type ]

AMX	C	M	050	R	-	22	-	4	-	AD17
Alpha Mill-X	Tool type C: Cutter	Arbor type M: Metric A: Inch None: Asia	Machining diameter 050: $\text{\O}50$ mm	Oil hole & Hand R: With Oil hole, right-handed NR: Without oil hole, right-handed	Internal diameter 22: $\text{\O}22$ mm	No. of tooth 4: 4 teeth	Available insert AD17: ADKT17 AD12: ADKT12 AD10: ADKT10			

## Insert features

### High rake angle chip breaker

- Applied high rake angle
- Improved chip control



### Max. ap

- ADKT17: 16.5 mm
- ADKT12: 11.5 mm
- ADKT10: 9.5 mm

### Proprietary relief surface shape

- High rigidity of insert



### Flat clamping area

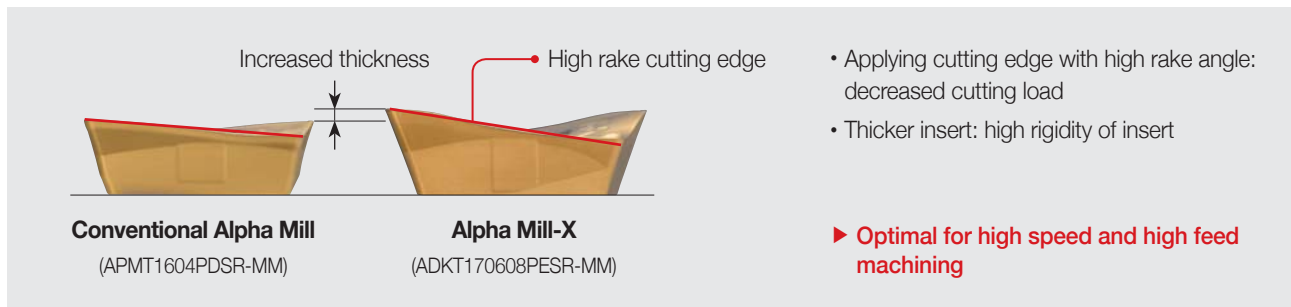
- Stable clamping in high speed and high feed machining

### Applied minor cutting edge with a wiper function

- Minor cutting edge design optimized for excellent surface finish

### High rake cutting edge

- Better surface toughness
- Lower cutting load



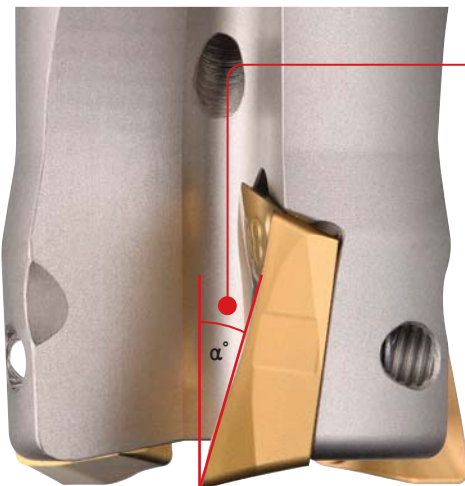
**Conventional Alpha Mill**  
(APMT1604PDSR-MM)

**Alpha Mill-X**  
(ADKT170608PESR-MM)

- Applying cutting edge with high rake angle: decreased cutting load
- Thicker insert: high rigidity of insert

► **Optimal for high speed and high feed machining**

## Cutter features



### High rake angle cutting edge

- Improved surface finish
- Decreased cutting load

### Wider chip pocket

- Maximized chip control
- Outstanding chip control in high speed and high feed machining

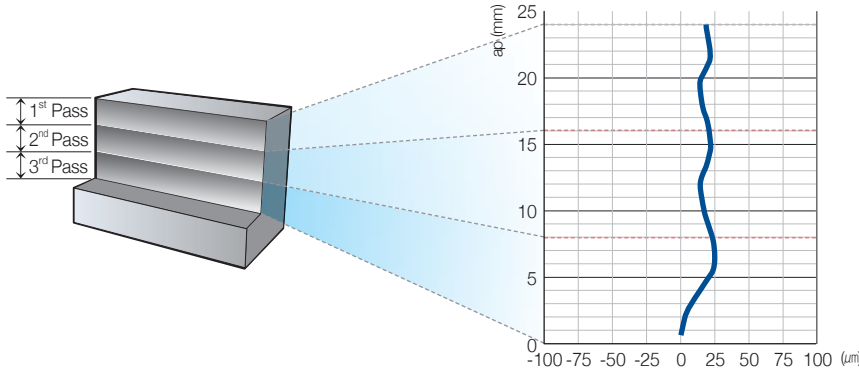


### Perfect perpendicularity

# Performance evaluation

## Perpendicularity

- **Workpiece** Alloy steel (42CrMo4, HB200), 300(L)x200(W)x100(H)
- **Cutting conditions**  $vc$  (m/min) = 150,  $fz$  (mm/t) = 0.15,  $ap$  (mm) = 8 mm x 3 Passes (Total 24 mm),  $ae$  (mm) = 5, dry
- **Tool** **Insert** ADKT170608PESR-MM (PC5300) **Holder** AMXS032R-3W32-125-AD17



[Graph of measured perpendicularities]



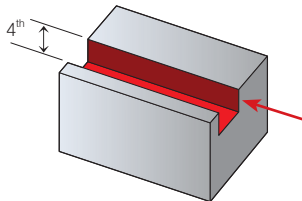
[Comparison picture of flank surface finish]

► Perpendicularity error is less than 30µm.

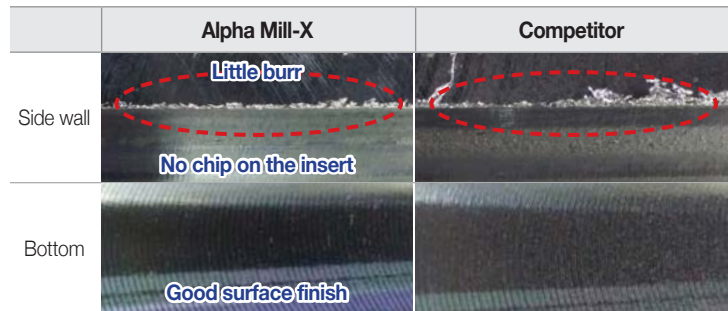
## Surface finish

(\* : DIN)

- **Workpiece** Alloy steel (34CrNiMo6\*, HB200), 300(L)x200(W)x100(H)
- **Cutting conditions**  $vc$  (m/min) = 176,  $fz$  (mm/t) = 0.15,  $ap$  (mm) = 5 mm x 4 Passes (Total 20 mm),  $ae$  (mm) = 50, dry
- **Tool** **Insert** ADKT170616PESR-MM (PC5300) **Holder** AMXCM050R-22-5-AD17

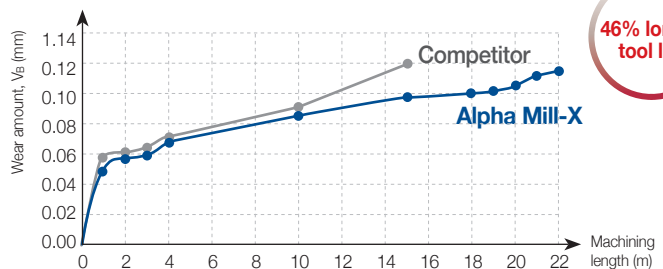
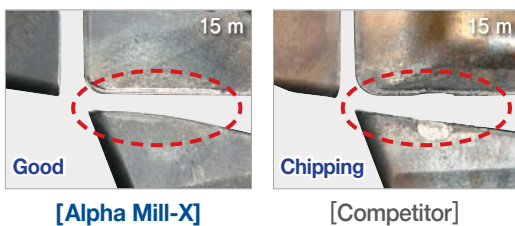


- Decreased burr
- Good surface finish on the side wall and bottom of the workpiece after machining



## Wear resistance



- **Workpiece** Alloy steel (42CrMo4, HB200), 300(L)x200(W)x100(H)
- **Cutting conditions**  $vc$  (m/min) = 200,  $fz$  (mm/t) = 0.17,  $ap$  (mm) = 5,  $ae$  (mm) = 20, dry
- **Tool** **Insert** ADKT170608PESR-MM (PC5300) **Holder** AMXS032R-3W32-125-AD17



46% longer tool life

## Recommended grades and chip breakers

(● : 1<sup>st</sup> Recommendation)

C/B	Cutting edge	P				M		K		N		S	
		Low carbon steel/ Mild steel		High carbon steel/ Alloy steel		Stainless steel		Cast iron		Non-ferrous metal		HRSA	
		C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade
ML		-	● PC3700 ○ PC5300 ○ PC5400 ○ NCM535	-	● PC3700 ○ PC5300 ○ PC5400 ○ NCM535	●	○ PC5300 ○ PC5400 ○ PC9540	-	● PC6510 ○ PC5300 ○ PC5400 ○ NCM535	-	-	●	● UPC845 ○ UNC840 ○ PC5300 ○ PC5400
MM		●	○ PC3700 ○ PC5300 ○ PC5400 ○ NCM535	●	○ PC3700 ○ PC5300 ○ PC5400 ○ NCM535	-	○ PC5300 ○ PC5400 ○ PC9540	●	○ PC6510 ○ PC5300 ○ PC5400 ○ NCM535	-	-	-	○ UPC845 ○ UNC840 ○ PC5300 ○ PC5400

## Recommended cutting conditions

### [In face machining and shouldering]

Workpiece	Grade	Cutting speed vc (m/min)	Feed, fz (mm/t)		
			ADKT17	ADKT12	ADKT10
P Steel	PC5300	150-240	0.3-0.05	0.25-0.05	0.2-0.05
	PC5400	130-210			
	PC3700	160-270			
	NCM535	250-350			
M Stainless steel	PC5300	90-150	0.25-0.05	0.2-0.05	0.15-0.05
	PC5400	70-120			
	PC9540	50-120			
K Cast iron	PC6510	150-200	0.35-0.08	0.3-0.08	0.25-0.08
	PC5300	120-200			
	NCM535	200-300			
S HRSA	PC5300	40-70	0.2-0.05	0.15-0.05	0.1-0.05
	PC5400	30-50			
	UPC845	20-60			
	UNC840	30-60			

※ The above data refer to general cutting conditions and can be adjustable up to 350 m/min and 0.4 mm/t depending on user environment.

### [In grooving, ramping and helical machining]

Workpiece	Grade	Cutting speed vc (m/min)	Feed, fz (mm/t)		
			ADKT17	ADKT12	ADKT10
P Steel	PC5300	150-240	0.15-0.05	0.15-0.05	0.15-0.05
	PC5400	130-210			
	PC3700	160-270			
	NCM535	250-350			
M Stainless steel	PC5300	90-150	0.15-0.05	0.15-0.05	0.15-0.05
	PC5400	70-120			
	PC9540	50-120			
K Cast iron	PC6510	150-250	0.2-0.08	0.2-0.08	0.2-0.08
	PC5300	120-200			
	NCM535	200-300			
S HRSA	PC5300	40-70	0.15-0.05	0.15-0.05	0.1-0.05
	PC5400	30-50			
	UPC845	20-60			
	UNC840	30-60			

※ In deep grooving, set the ap under 5 mm and use coolant and air.

# Shoulder milling tool selection guide

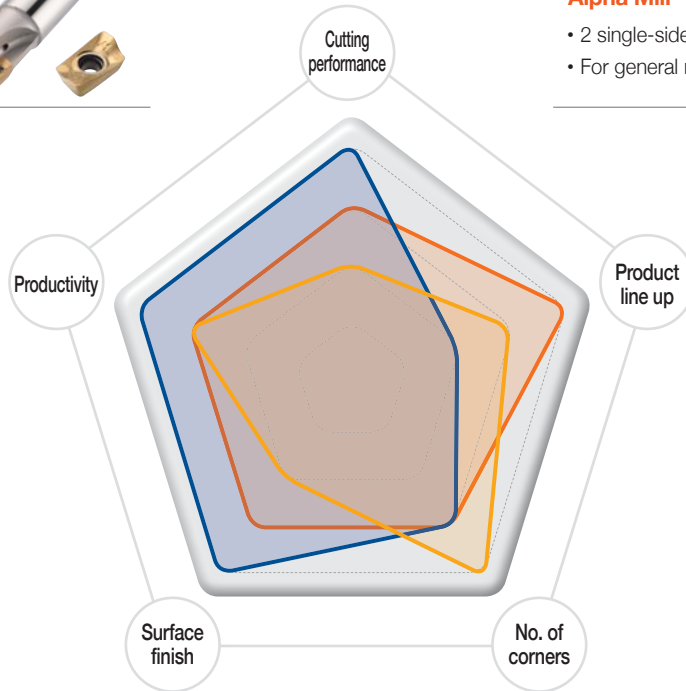
## Alpha Mill-X new

- Higher productivity
- Lower cutting load



## Alpha Mill

- 2 single-sided corners
- For general machining



— Alpha Mill-X

— Alpha Mill

— RM4

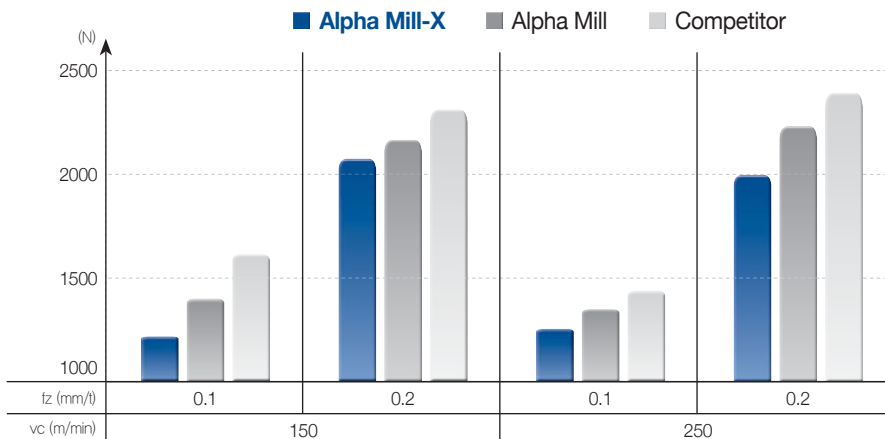
## RM4

- 4 double-sided corners
- High cost efficiency



Tools	Cutting performance	Line up	No. of corners	Surface finish	Productivity
Alpha Mill-X <small>new</small>	★★★★★	★★	★★★	★★★★★	★★★★★
Alpha Mill	★★★	★★★★★	★★★	★★★	★★★
RM4	★★	★★★	★★★★★	★★	★★★

# Cutting load

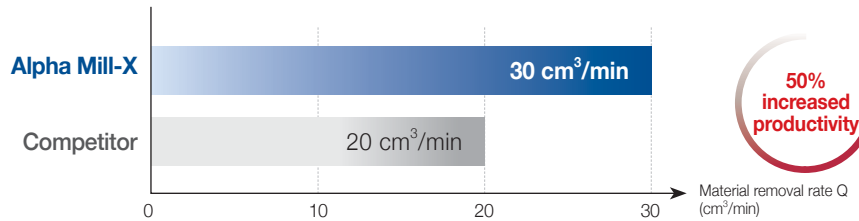
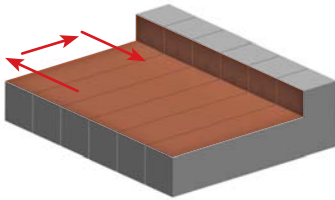


Decreased 10% or above of cutting load

# Application examples

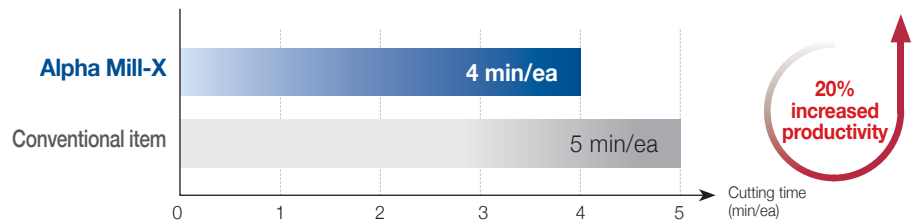
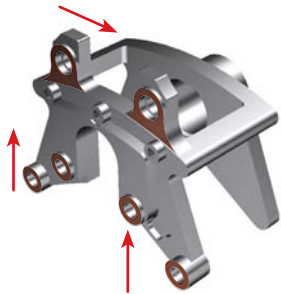
## Alloy steel (42CrMo4)

- **Workpiece use** Lathe holder
- **Cutting conditions**  $vc$  (m/min) = 163,  $fz$  (mm/t) = 0.11,  $ap$  (mm) = 1.5x4 Passes,  $ae$  (mm) = 40, wet
- **Tool** **Insert** ADKT170616PESR-MM (PC5300) **Holder** AMXCM080R-27-7-AD17



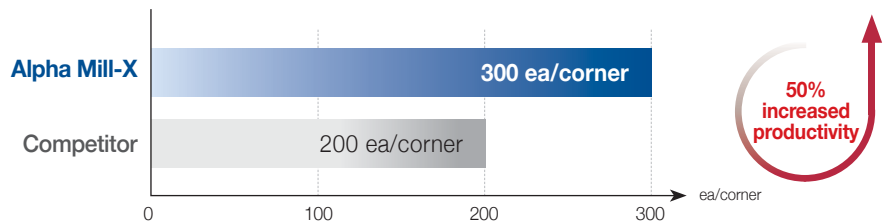
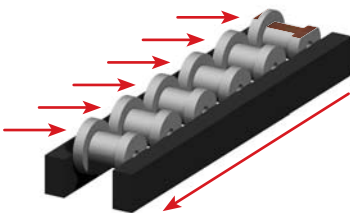
## Ductile cast iron (700-2)

- **Workpiece use** Break carrier
- **Cutting conditions**  $vc$  (m/min) = 118,  $fz$  (mm/t) = 0.1~0.2,  $ap$  (mm) = 2 (Finishing), 4x2 Passes (Roughing), wet
- **Tool** **Insert** ADKT170608PESR-ML (PC5300) **Holder** AMXCM063R-22-6-AD17



## Alloy steel (34CrMo4)

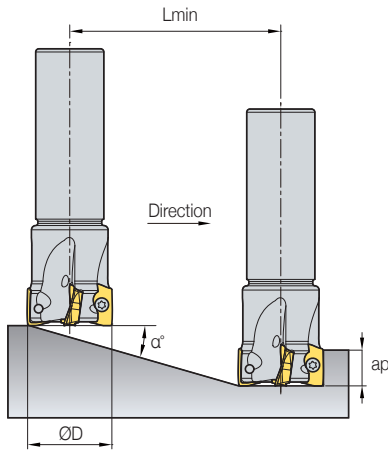
- **Workpiece use** Automobile suspension parts
- **Cutting conditions**  $vc$  (m/min) = 296,  $fz$  (mm/t) = 0.09,  $ap$  (mm) = 2.0x2 Passes,  $ae$  (mm) = 40~50, wet
- **Tool** **Insert** ADKT170616PESR-MM (PC5300) **Holder** AMXCM063R-22-6-AD17



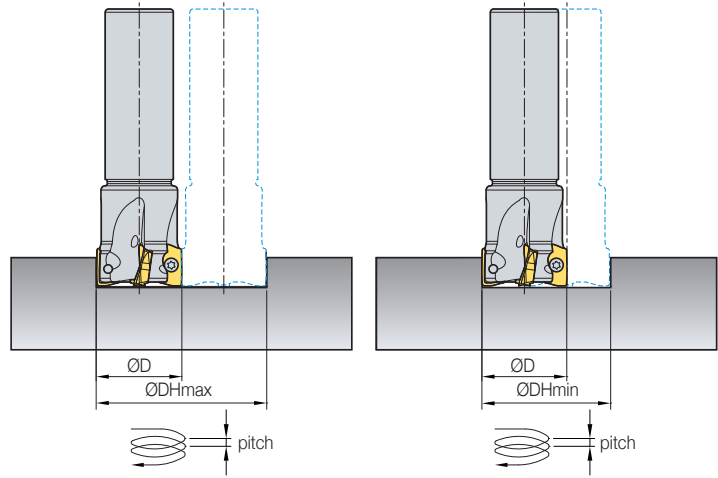


# Ramping and helical cutting

## Ramping



## Helical cutting



(mm)


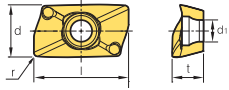

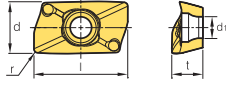
Designation	Tool dia. ØD	ap	Ramping		Blind hole helical cutting				Through hole helical cutting	
			Max. rake angle α°	Lmin	Min. desirable hole dia. ØDHmin	Max. pitch dmax	Max. desirable hole dia. ØDHmax	Max. pitch dmax	Min. desirable hole dia. ØDHmin	Max. pitch dmax
ADKT17	20	16.5	13	71	30	7.0	38	8.9	21	4.8
	25	16.5	8.0	117	40	5.7	48	6.8	31	4.3
	32	16.5	3.7	255	54	3.5	62	4.0	45	2.9
	33	16.5	3.6	262	56	3.5	64	4.1	47	2.9
	40	16.5	2.6	363	70	3.2	78	3.6	61	2.8
	50	16.5	1.9	497	90	3.0	98	3.3	81	2.7
	63	16.5	1.3	727	116	2.6	124	2.8	107	2.4
	80	16.5	1.1	859	150	2.9	158	3.0	141	2.7
	100	16.5	0.7	1350	190	2.3	198	2.4	181	2.2
125	16.5	0.5	1891	240	2.1	248	2.2	231	2.0	
ADKT12	18	11.5	7.0	98	29	3.6	34	4.2	23	2.8
	20	11.5	5.5	125	33	3.2	38	3.7	27	2.6
	25	11.5	3.5	196	43	2.7	48	3.0	37	2.3
	32	11.5	2.5	275	57	2.5	62	2.7	51	2.2
	33	11.5	2.4	286	59	2.5	64	2.7	53	2.2
	40	11.5	1.5	458	73	1.9	78	2.1	67	1.7
	50	11.5	1.2	573	93	2.0	98	2.1	87	1.8
	63	11.5	1.0	687	119	2.1	124	2.2	113	2.0
	80	11.5	0.7	982	153	1.9	158	1.9	147	1.8
ADKT10	16	9.5	4.5	121	28	2.2	31	2.5	24	1.9
	18	9.5	3.5	155	32	2.0	35	2.2	28	1.7
	20	9.5	3.0	181	36	1.9	39	2.1	32	1.7
	25	9.5	2.2	247	46	1.8	49	1.9	42	1.6
	32	9.5	1.5	363	60	1.6	63	1.7	56	1.5
	33	9.5	1.4	389	62	1.5	65	1.6	58	1.4
	40	9.5	1.2	454	76	1.6	79	1.7	72	1.5
	50	9.5	0.8	680	96	1.3	99	1.4	92	1.3
	63	9.5	0.6	907	122	1.3	125	1.3	118	1.2
80	9.5	0.5	1089	156	1.4	159	1.4	152	1.3	

• In ramping and helical machining, use coolant and air.

- Lmin : Cutting length in machining with Min. rake angle
- α° : Rake angle for ramping
- ap : Depth of cut in axial direction

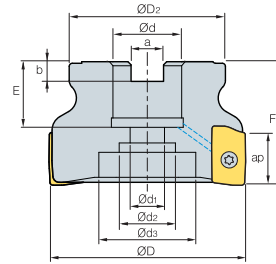
$$Lmin = \frac{ap}{\tan \alpha^\circ} \text{ (mm)}$$

# Inserts

Inserts	Designation	Coated								Dimensions (mm)					Geometries
		NCM535	PC3700	PC6510	PC9540	PC5300	PC5400	UNC840	UPC845	l	d	t	r	d <sub>1</sub>	
	ADKT 10T304PEER-ML	○	○	○	○	○	○	○	○	11.7	6.424	3.819	0.4	2.8	
	120408PESR-ML	●	●	●	●	●	●	●	●	14.5	7.813	4.824	0.8	3.4	
	170608PESR-ML	●	●	●	●	●	●	●	●	19.665	10.843	6.529	0.8	4.5	
	ADKT 10T304PESR-MM	○	○	○	○	○	○	○	○	11.7	6.424	3.819	0.4	2.8	
	10T308PESR-MM					○	○			11.7	6.424	3.819	0.8	2.8	
	10T312PESR-MM					○	○			11.7	6.424	3.819	1.2	2.8	
	120408PESR-MM	●	●	●	●	●	●	●	●	14.5	7.813	4.824	0.8	3.4	
	120412PESR-MM		●	●		●	●	●	●	14.5	7.813	4.824	1.2	3.4	
	120416PESR-MM		●	●		●	●	●	●	14.5	7.813	4.824	1.6	3.4	
	170604PESR-MM		●			●				19.665	10.843	6.529	0.4	4.5	
	170608PESR-MM	●	●	●	●	●	●	●	●	19.665	10.843	6.529	0.8	4.5	
	170616PESR-MM					●	●			19.665	10.843	6.529	1.6	4.5	
	170620PESR-MM					●	●			19.665	10.843	6.529	2.0	4.5	

●: Stock item ○: In stock (December, 2020) None: Order made

# AMXCM



AA  
90°  
• AR: 8°  
• RR: -10° ~ -3°

(mm)

Designation	Stock	⊙	ØD	ØD2	Ød	Ød1	Ød2	Ød3	a	b	E	F	ap	kg	Available insert
AMXCM 040R-16-3-AD17	●		40	35	16	9	14	-	8.4	5.6	19	40	16.5	0.18	ADKT17
040R-16-4-AD17	●		40	35	16	9	14	-	8.4	5.6	19	40	16.5	0.18	
050R-22-4-AD17	●		50	42	22	11	18	-	10.4	6.3	20	40	16.5	0.23	
050R-22-5-AD17	●		50	42	22	11	18	-	10.4	6.3	20	40	16.5	0.20	
063R-22-5-AD17	●		63	49	22	11	18	-	10.4	6.3	20	40	16.5	0.44	
063R-22-6-AD17	●		63	49	22	11	18	-	10.4	6.3	20	40	16.5	0.49	
080R-27-6-AD17	●		80	57	27	14	25	38	12.4	7	23	50	16.5	0.88	
080R-27-7-AD17	●		80	57	27	14	25	38	12.4	7	23	50	16.5	0.90	
100R-32-8-AD17	●		100	70	32	18	28	45	14.4	8	28	63	16.5	1.76	
100R-32-10-AD17	●		100	70	32	18	28	45	14.4	8	28	63	16.5	1.68	
125R-40-8-AD17	●		125	90	40	22	32	54	16.4	9	30	63	16.5	2.89	
125R-40-10-AD17	●		125	90	40	22	32	54	16.4	9	30	63	16.5	4.83	

●: Stock item None: Order made

## Available Inserts



ADKT-ML



ADKT-MM

Designation	Coated							
	NCM535	PC3700	PC6510	PC9540	PC5300	PC5400	UNC840	UPC845
ADKT 170608PESR-ML	●	●	●	●	●	●	●	●
170604PESR-MM		●			●			
170608PESR-MM	●	●	●	●	●	●	●	●
170616PESR-MM					●	●		
170620PESR-MM					●	●		

## Available arbors

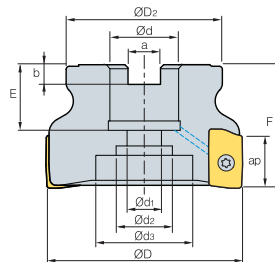
Designation	Ød	Available arbors
AMXCM 040R-16-□-AD□□	16	BT□□-FMC16-□□
050R-22-□-AD□□	22	BT□□-FMC22-□□
063R-22-□-AD□□		

Designation	Ød	Available arbors
AMXCM 080R-27-□-AD□□	27	BT□□-FMC27-□□
100R-32-□-AD□□	32	BT□□-FMC32-□□
125R-40-□-AD□□	40	BT□□-FMC40-□□

## Parts

Specification	Screw	Wrench
Ø40~Ø125	FTKA0408	TW15S

# AMXCM



• AR: 8°  
• RR: -10° ~ -3°

(mm)

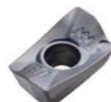
Designation	Stock	⊙	ØD	ØD2	Ød	Ød1	Ød2	Ød3	a	b	E	F	ap	$\frac{kg}{pc}$	Available insert
AMXCM 040R-16-4-AD12	●	4	40	35	16	9	14	-	8.4	5.6	19	40	11.5	0.18	ADKT12
040R-16-5-AD12	●	5	40	35	16	9	14	-	8.4	5.6	19	40	11.5	0.16	
050R-22-5-AD12	●	5	50	42	22	11	18	-	10.4	6.3	20	40	11.5	0.23	
050R-22-7-AD12	●	7	50	42	22	11	18	-	10.4	6.3	20	40	11.5	0.20	
063R-22-6-AD12	●	6	63	49	22	11	18	-	10.4	6.3	20	40	11.5	0.44	
063R-22-7-AD12	●	7	63	49	22	11	18	-	10.4	6.3	20	40	11.5	0.49	
080R-27-7-AD12	●	7	80	57	27	14	25	38	12.4	7	23	50	11.5	0.88	
080R-27-8-AD12	●	8	80	57	27	14	25	38	12.4	7	23	50	11.5	0.90	
040R-16-5-AD10	○	5	40	35	16	9	14	-	8.4	5.6	19	40	9.5	0.18	ADKT10
040R-16-6-AD10	○	6	40	35	16	9	14	-	8.4	5.6	19	40	9.5	0.18	
050R-22-6-AD10	○	6	50	42	22	11	18	-	10.4	6.3	20	40	9.5	0.23	
050R-22-7-AD10	○	7	50	42	22	11	18	-	10.4	6.3	20	40	9.5	0.20	
063R-22-7-AD10	○	7	63	49	22	11	18	-	10.4	6.3	20	40	9.5	0.44	
063R-22-8-AD10	○	8	63	49	22	11	18	-	10.4	6.3	20	40	9.5	0.49	
080R-27-8-AD10	○	8	80	57	27	14	25	38	12.4	7	23	50	9.5	0.88	
080R-27-9-AD10	○	9	80	57	27	14	25	38	12.4	7	23	50	9.5	0.90	

●: Stock item ○: In stock (December, 2020) None: Order made

## Available Inserts



ADKT-ML



ADKT-MM

Designation	Coated							
	NCM535	PC3700	PC6510	PC9540	PC5300	PC5400	UNC840	UPC845
ADKT 120408PESR-ML	●	●	●	●	●	●	●	●
120408PESR-MM	●	●	●	●	●	●	●	●
120412PESR-MM		●	●		●	●	●	●
120416PESR-MM		●	●		●	●	●	●
ADKT 10T304PEER-ML	○	○	○	○	○	○	○	○
10T304PESR-MM	○	○	○	○	○	○	○	○
10T308PESR-MM					○	○		
10T312PESR-MM					○	○		

## Available arbors

Designation	Ød	Available arbors
AMXCM 040R-16-□-AD□□	16	BT□□-FMC16-□□
050R-22-□-AD□□	22	BT□□-FMC22-□□

Designation	Ød	Available arbors
AMXCM 063R-22-□-AD□□	22	BT□□-FMC22-□□
080R-27-□-AD□□	27	BT□□-FMC27-□□

## Parts

Specification	Screw	Wrench
Ø40~Ø80 (12 type)	FTNA0306	TW09S
Ø40~Ø80 (10 type)	FTKA02555S	TW08S

# AMXS

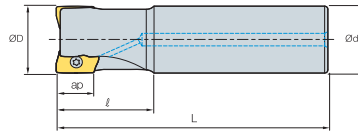


Fig. 1

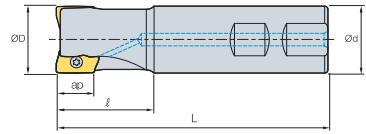


Fig. 2



AA  
90°  
• AR: 8°  
• RR: -10°~-3°

(mm)

Designation	Stock		ØD	Ød	ℓ	L	ap		Fig.	Available insert
AMXS 020R-1W20-100-AD17	●	1	20	20	35	100	16.5	0.170	2	ADKT17
020R-1C20-200-AD17	●	1	20	20	35	200	16.5	0.360	1	
025R-2W25-115-AD17	●	2	25	25	35	115	16.5	0.610	2	
025R-2C25-200-AD17	●	2	25	25	35	200	16.5	0.450	1	
032R-3W32-125-AD17	●	3	32	32	45	125	16.5	0.620	2	
032R-3C32-200-AD17	●	3	32	32	45	200	16.5	1.050	1	
033R-3W32-125-AD17	●	3	33	32	45	125	16.5	0.620	2	
033R-3C32-200-AD17	●	3	33	32	45	200	16.5	1.050	1	
040R-3W32-130-AD17	●	3	40	32	50	130	16.5	0.750	2	
040R-3C32-200-AD17	●	3	40	32	50	200	16.5	1.170	1	
040R-4W32-130-AD17	●	4	40	32	50	130	16.5	0.740	2	
040R-4C32-200-AD17	●	4	40	32	50	200	16.5	1.200	1	

●: Stock item    None: Order made

## Available Inserts



ADKT-ML



ADKT-MM

Designation	Coated							
	NCM535	PC3700	PC6510	PC9540	PC5300	PC5400	UNC840	UPC845
ADKT 170608PESR-ML	●	●	●	●	●	●	●	●
170604PESR-MM		●			●			
170608PESR-MM	●	●	●	●	●	●	●	●
170616PESR-MM					●	●		
170620PESR-MM					●	●		

## Parts

Specification	Screw 	Wrench 
Ø20~Ø40	FTKA0408	TW15S

# AMXS

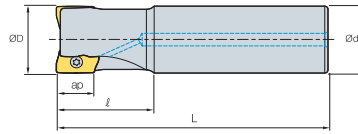


Fig. 1

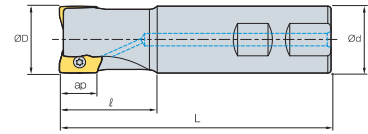


Fig. 2



• AR: 8°  
• RR: -10°~-3°

(mm)

Designation	Stock		ØD	Ød	ℓ	L	ap	$\frac{kg}{m^3}$	Fig.	Available insert
AMXS 018R-2W16-100-AD12	●	2	18	16	35	100	11.5	0.120	2	ADKT12
018R-2C16-200-AD12	●	2	18	16	35	200	11.5	0.210	1	
020R-2W20-100-AD12	●	2	20	20	35	100	11.5	0.250	2	
020R-2C20-200-AD12	●	2	20	20	35	200	11.5	0.490	1	
025R-3W25-115-AD12	●	3	25	25	40	115	11.5	0.400	2	
025R-3C25-200-AD12	●	3	25	25	40	200	11.5	0.590	1	
032R-4W32-125-AD12	●	4	32	32	45	125	11.5	0.700	2	
032R-4C32-200-AD12	●	4	32	32	45	200	11.5	1.000	1	
040R-4W32-130-AD12	●	4	40	32	50	130	11.5	1.050	2	
040R-4C32-200-AD12	●	4	40	32	50	200	11.5	1.200	1	
016R-2W16-90-AD10	○	2	16	16	25	90	9.5	0.110	2	ADKT10
016R-2C16-180-AD10	○	2	16	16	25	180	9.5	0.190	1	
018R-2W16-100-AD10	○	2	18	16	35	100	9.5	0.120	2	
018R-2C16-200-AD10	○	2	18	16	35	200	9.5	0.210	1	
020R-3W20-100-AD10	○	3	20	20	35	100	9.5	0.250	2	
020R-3C20-200-AD10	○	3	20	20	35	200	9.5	0.490	1	
025R-4W25-115-AD10	○	4	25	25	40	115	9.5	0.400	2	
025R-4C25-200-AD10	○	4	25	25	40	200	9.5	0.590	1	
032R-4W32-125-AD10	○	4	32	32	45	125	9.5	0.700	2	
032R-4C32-200-AD10	○	4	32	32	45	200	9.5	1.000	1	
040R-5W32-130-AD10	○	5	40	32	50	130	9.5	1.050	2	
040R-5C32-200-AD10	○	5	40	32	50	200	9.5	1.200	1	

●: Stock item ○: In stock (December, 2020) None: Order made

## Available Inserts



ADKT-ML



ADKT-MM

Designation	Coated							
	NCM535	PC3700	PC6510	PC9540	PC5300	PC5400	UNC840	UPC845
ADKT 120408PESR-ML	●	●	●	●	●	●	●	●
120408PESR-MM	●	●	●	●	●	●	●	●
120412PESR-MM		●	●		●	●	●	●
120416PESR-MM		●	●		●	●	●	●
ADKT 10T304PEER-ML	○	○	○	○	○	○	○	○
10T304PESR-MM	○	○	○	○	○	○	○	○
10T308PESR-MM					○	○		
10T312PESR-MM					○	○		

## Parts

Specification	Screw	Wrench
Ø18~Ø40 (12 type)	FTNA0306	TW09S
Ø16~Ø40 (10 type)	FTKA02555S	TW08S



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