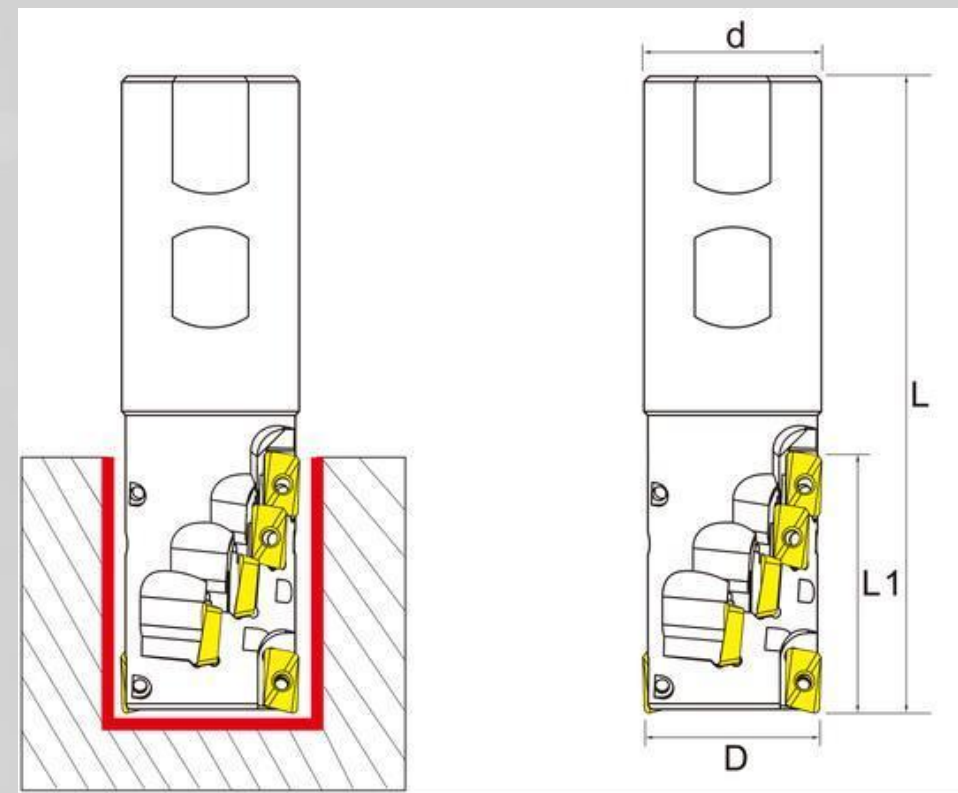


# Application Brochure

Accusize Helical Indexable Weldon Shank End Mill, Right Hand, Heavy Duty Cut

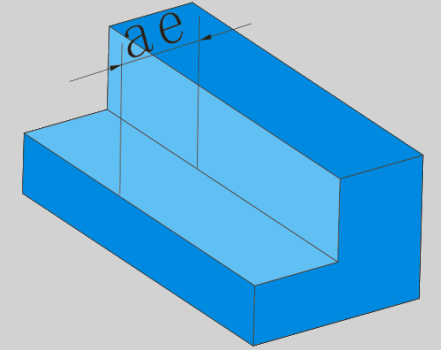


# Specification



Item	Diameter (D)	Shank Dia. (d)	Overall Length (L)	Flute Length	No of Flutes	No of Inserts	Insert Style	Screw	Key
5508-0000	3/4"	3/4"	3-1/2"	1-3/32"	1	4	APKT11T3	M2.5 x 6	T8
5508-0002	1"	1"	4-1/4"	1-7/16"	2	8	APKT11T3	M2.5 x 6	T8
5508-0003	1-1/4"	1-1/4"	4-1/2"	1-3/4"	2	10	APKT11T3	M2.5 x 6	T8
5508-0004	1-1/2"	1-1/4"	5"	2-1/8"	2	14	APKT11T3	M2.5 x 6	T8
5508-0005	1-1/2"	1-1/4"	4-1/2"	1-11/16"	2	6	APKT1604	M4 x 8	T15
5508-0006	1-3/4"	1-1/2"	5-1/2"	2-1/4"	2	8	APKT1604	M4 x 8	T15
5508-0007	2"	1-1/2"	6"	2-1/4"	3	12	APKT1604	M4 x 8	T15
5508-0008	2"	1-1/2"	6-1/2"	2-13/16"	3	15	APKT1604	M4 x 8	T15
5508-0009	2"	2"	7"	3-1/4"	3	15	APKT1604	M4 x 8	T15

# Recommended Cutting Parameters Pt 1



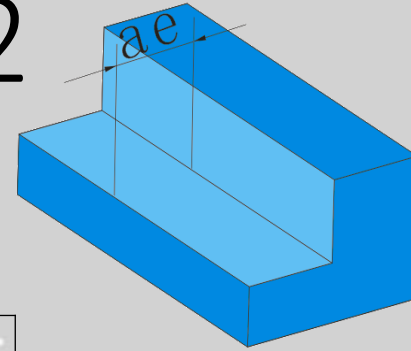
V= Cutting Speed (m/min)

f= Feed per tooth (mm/Z)

ae=Cutting width(mm)

Item No.	Description	Materials	Hardness(HB)	Cutting parameter		
				V(m/min)	f(mm/Z)	ae
	<b>Indexable Weldon Shank End Mills</b>					
5508-0001	3/4x3/4" / 1 flute with 4 inserts	Low-carbon Steel	≤180	60-120	0.2(0.05-0.1)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	60-120	0.2(0.05-0.1)	≤0.5D
		Tool Steel	280-350	60-90	0.2(0.05-0.1)	≤0.5D
5508-0002	1"x1" / 2 flutes with 8 inserts	Low-carbon Steel	≤180	60-120	0.2(0.05-0.1)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	60-120	0.2(0.05-0.1)	≤0.5D
		Tool Steel	280-350	60-90	0.2(0.05-0.1)	≤0.5D
5508-0003	1-1/4" x 1-1/4" / 2 flutes with 10 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D
5508-0004	1-1/2" x 1-1/4" / 2 flutes with 14 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D

# Recommended Cutting Parameters Pt 2



V= Cutting Speed (m/min)  
 f= Feed per tooth (mm/Z)  
 ae=Cutting width(mm)

Item No.	Description	Materials	Hardness(HB)	Cutting parameter		
				V(m/min)	f(mm/Z)	ae
	<b>Indexable Weldon Shank End Mills</b>					
5508-0005	1-1/2" x 1-1/4" / 2 flutes with 6 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D
5508-0006	1-3/4"x 1-1/2" / 2 flutes with 8 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D
5508-0007	2" x 1-1/2" / 3 flutes with 12 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D
5508-0008	2" x 1-1/2" / 3 flutes with 15 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D
5508-0009	2" x 2" / 3 flutes with 15 inserts	Low-carbon Steel	≤180	40-80	0.2(0.1-0.2)	≤0.5D
		High-carbon Steel, Alloy Steel	180-280	40-80	0.2(0.1-0.2)	≤0.5D
		Tool Steel	280-350	30-60	0.2(0.1-0.2)	≤0.5D



# Replacement of Inserts

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## Cutting Steel

Item	Description
0056-1130	APKT11T3 carbide insert TiN Coated
0056-1604	APKT1604 carbide insert TiN Coated



## Cutting Aluminum

Item	Description
0058-1130	APKT11T308 LH carbide insert Uncoated
0058-1604	APKT160408 LH carbide insert Uncoated



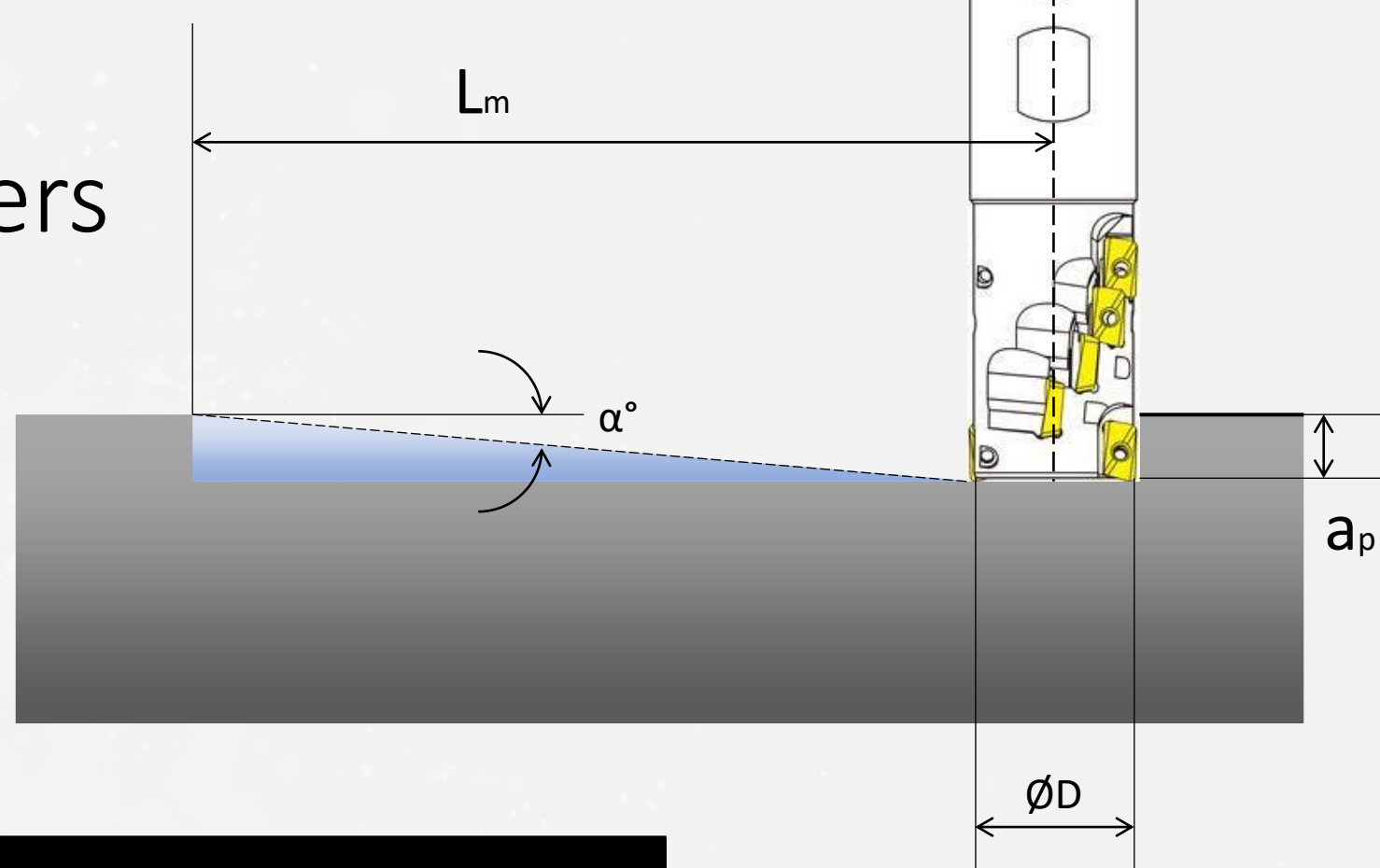
## Cutting Stainless Steel

Item	Description
1056-1135	APMT1135PDER-M2
1056-1604	APMT1604PDER-H2

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# Ramping Parameters



Item	Diameter of Cutter	Max. Cutting Depth	Max. Ramping Angle	Min. Milling Length	Min. Milling Diameter	Max. Pitch
	$\varnothing D$	$a_p$	$\alpha^\circ$	$L_m$	$\varnothing D$	mm
5508-0000	3/4"	0.394"	5.0°	4.50"	1.10"	2.0
5508-0002	1"	0.394"	4.5°	3.22"	1.57"	2.0
5508-0003	1 1/4"	0.394"	3.0°	7.51"	2.20"	2.0