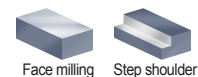
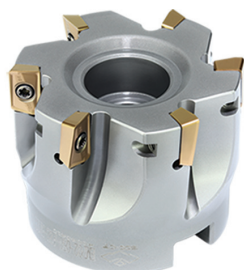


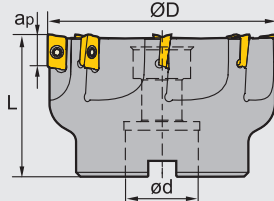
Square shoulder milling tools **Kr:90°**



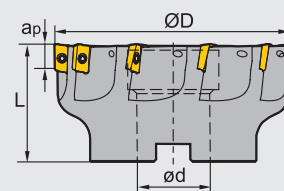
EMP02 P M K S N



A-type coupling



B-type coupling



Specification of tools

Type	Stock	Basic dimensions(mm)				Number of teeth Z	Type of coupling	Weight (kg)
		ØD	ød	L	apmax			
EMP02 -050-A22-AP11-06	▲	50	22	40	10.5	6	A	0.3
-063-A22-AP11-08	▲	63	22	40	10.5	8	A	0.6
-080-A27-AP11-08	▲	80	27	50	10.5	8	A	1.2
-100-B32-AP11-10	▲	100	32	50	10.5	10	B	1.7
-050-A22-AP16-05	▲	50	22	40	15.5	5	A	0.3
-063-A22-AP16-06	▲	63	22	40	15.5	6	A	0.5
-080-A27-AP16-07	▲	80	27	50	15.5	7	A	1.1
-100-B32-AP16-08	▲	100	32	50	15.5	8	B	1.6
-125-B40-AP16-10	▲	125	40	63	15.5	10	B	3.2
-160-B40-AP16-10	▲	160	40	63	15.5	10	B	6.3

▲Stock available △Make-to-order

Spare parts

Diameter ØD	Inserts	Screw	Wrench
Ø50-Ø100	AP11	I60M2.5×6.5T	WT08IS
Ø50-Ø160	AP16	I60M4×10	WT15IS

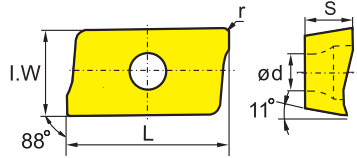


Tools code key
B24-B25

Grade selection guide
B19-B23

Technical data
B234-B240

Selection of inserts



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metal	S Heat resistant alloy, Ti alloy
YBC301	😊	😊	😊	😊	😊
YBC302	😊	😊	😊	😊	😊
YBM251	😊	😊	😊	😊	😊
YBM253	😊	😊	😊	😊	😊
YBM351	😊	😊	😊	😊	😊
YBD152	😊	😊	😊	😊	😊
YBD252	😊	😊	😊	😊	😊
YBG102	😊	😊	😊	😊	😊
YBG202	😊	😊	😊	😊	😊
YBG205	😊	😊	😊	😊	😊
YB9320	😊	😊	😊	😊	😊
YBG302	😊	😊	😊	😊	😊
YBG152	😊	😊	😊	😊	😊
YBG252	😊	😊	😊	😊	😊
YBS203	😊	😊	😊	😊	😊
YBS303	😊	😊	😊	😊	😊
YNG151	😊	😊	😊	😊	😊
YNG151C	😊	😊	😊	😊	😊
YC30S	😊	😊	😊	😊	😊
YD051	😊	😊	😊	😊	😊
YD101	😊	😊	😊	😊	😊
YD201	😊	😊	😊	😊	😊

Insert shape	Type	Basic dimensions(mm)					CVD Coating				PVD Coating				Cermet		Cemented carbide													
		L	I.W	S	ød	r	YBC301	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201		
	APKT11T304-APF	12.24	6.6	3.6	2.8	0.4	●	●									★													
	APKT11T308-APF	12.24	6.6	3.6	2.8	0.8	●	●									★					●	●							
	APKT160408-APF	17.877	9.33	5.76	4.4	0.8	●										★					●	●							
	APKT11T304-APM	12.24	6.6	3.6	2.8	0.4			●								★													
	APKT11T308-APM	12.24	6.6	3.6	2.8	0.8			●	●							★					●	●							
	APKT11T312-APM	12.24	6.6	3.6	2.8	1.2					●						★													
	APKT11T316-APM	12.24	6.6	3.6	2.8	1.6											★													
	APKT11T320-APM	12.24	6.6	3.6	2.8	2.0			●								★													
	APKT160408-APM	17.877	9.33	5.76	4.4	0.8			●	●							★					●	●							
	APKT160416-APM	17.877	9.33	5.76	4.4	1.6			●	●							★					●								
	APKT160420-APM	17.877	9.33	5.76	4.4	2.0					●						★													
	APKT160424-APM	17.877	9.33	5.76	4.4	2.4											★													
	APKT160430-APM	17.877	9.33	5.76	4.4	3.0											★													
	APKT11T304-ALH	12.24	6.6	3.6	2.8	0.4																					★	★		
	APKT11T308-ALH	12.24	6.6	3.6	2.8	0.8																					★	○		
	APKT160408-ALH	17.877	9.33	5.76	4.4	0.8																					★	★		

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

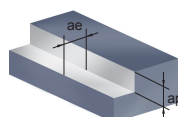
Indexable milling tools

Square shoulder milling tools

Chipbreaker selection

Classification	Function	For finishing	For semi-finishing
P		-APF	-APM
M		-APF	-APM
S		-APF	-APM
K		-APF	-APM
N		-ALH	

1 Square shoulder milling



Recommended cutting parameters (D: Diameter)

Workpiece material	Hardness HB	Insert grade	Cutting parameters				
			Vc(m/min)	fz(mm/z)		ae(mm)	
				-APF	-APM		
P	Low-carbon steel, Soft steel	YBC302	320 (240-400)	0.1 (0.08-0.2)	--	≤ 0.5D	
		YB9320	320 (200-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)		
		YBM253	300 (320-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)		
	High-carbon steel, Alloy steel	180-280	YBC302	280 (210-380)	0.1 (0.08-0.2)	--	≤ 0.5D
			YB9320	280 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
			YBM253	260 (150-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
	Alloy tool steel	280-350	YBC302	260 (180-350)	0.1 (0.08-0.2)	--	≤ 0.5D
			YB9320	260 (160-330)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
			YBM253	220 (150-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
M	Stainless steel	YB9320	200 (110-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBM253	180 (150-300)				
K	Cast iron	YB9320	180 (150-250)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBD152	200 (150-250)	--	0.2 (0.1-0.3)		
S	Difficult-to-machine materials	YBS203	100 (60-120)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBS303	100 (60-120)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
N				-ALH			
	Aluminium alloy	YD101	300-	0.2 (0.08-0.4)		≤ 0.5D	
		YD201	300-	0.2 (0.08-0.4)		≤ 0.5D	

Indexable milling tools

Square shoulder milling tools