

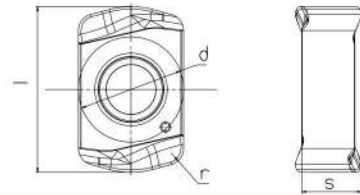
**NEW
PRODUCT!**

LN06

High Feed Milling Cutter



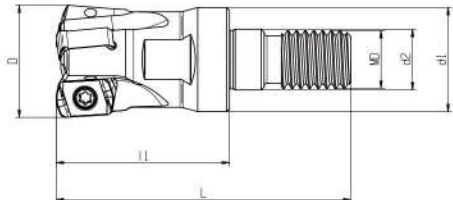
● **Insert stock item**
LNMX 06



Insert	Designation	Dimensions (mm)				Grades						
						CVD coated		PVD coated			Un-coated	
		l	d	s	r	AC301P	AC301K	AP301U	AP351U	AP401U	AP351K	AW100K
	LNMX 060410R-MM3	10	6.35	3.6	1.0			•	•	•		
	LNMX 060410R-MM4	10	6.35	3.6	1.0			•	•			

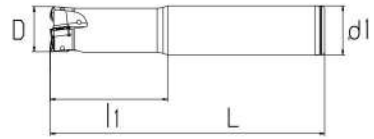
Remark: • represent for standard stock

● **Cutter stock item**
AHM20-LN06-C (Screw modular)



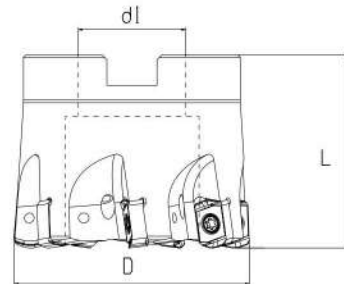
Designation	Dimension (mm)							Coolant	Z	Insert
	D	d1	d2	MD	L	l1	apmax			
AHM20-016-Z02-M08R-LN06-C	16	14.5	8.5	M08	42	25	1.0		2	LNMX 0604
AHM20-017-Z02-M08R-LN06-C	17	14.5	8.5	M08	42	25	1.0		2	
AHM20-020-Z03-M10R-LN06-C	20	18	10.5	M10	51	30	1.0		3	
AHM20-021-Z03-M10R-LN06-C	21	18	10.5	M10	51	30	1.0		3	
AHM20-025-Z04-M12R-LN06-C	25	23	12.5	M12	59	35	1.0		4	
AHM20-026-Z04-M12R-LN06-C	26	23	12.5	M12	59	35	1.0		4	
AHM20-032-Z05-M16R-LN06-C	32	29	17	M16	70	43	1.0		5	
AHM20-033-Z05-M16R-LN06-C	33	29	17	M16	70	43	1.0		5	
AHM20-035-Z05-M16R-LN06-C	35	29	17	M16	70	43	1.0		6	
AHM20-040-Z06-M16R-LN06-C	40	29	17	M16	70	43	1.0		6	

AHM20-LN06-C (Cylindrical type)



Designation	Dimension(mm)					Coolant	Z	Insert
	D	d1	L	l1	apmax			
AHM20-016-Z02-C16R-LN06-L100-C	16	16	100	30	1.0		2	LNMX 0604
AHM20-017-Z02-C16R-LN06-L150-C	17	16	150	25	1.0		2	
AHM20-020-Z03-C20R-LN06-L130-C	20	20	130	50	1.0		3	
AHM20-021-Z03-C20R-LN06-L160-C	21	20	160	30	1.0		3	
AHM20-025-Z03-C25R-LN06-L140-C	25	25	140	60	1.0		3	
AHM20-026-Z03-C25R-LN06-L180-C	26	25	180	35	1.0		3	
AHM20-032-Z04-C32R-LN06-L150-C	32	32	150	70	1.0		4	
AHM20-033-Z04-C32R-LN06-L200-C	33	32	200	35	1.0		4	
AHM20-035-Z05-C32R-LN06-L200-C	35	32	200	35	1.0		5	

AHM20-LN06-C (Shell mill)



Designation	Dimension(mm)					Coolant	Z	Insert
	D	d1	L	l1	apmax			
AHM20-040-Z06-A16R-LN06-C	40	16	40	-	1.0		6	LNMX 0604
AHM20-050-Z07-A22R-LN06-C	50	22	40	-	1.0		7	
AHM20-052-Z07-A22R-LN06-C	52	22	40	-	1.0		7	
AHM20-063-Z08-A22R-LN06-C	63	22	40	-	1.0		8	

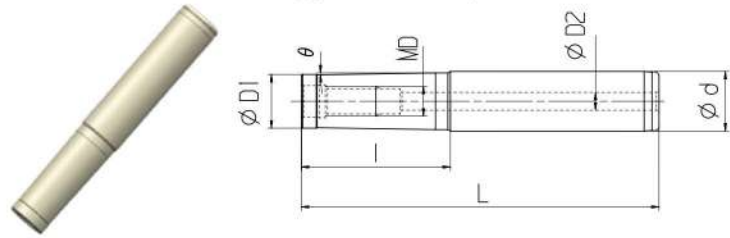
Dimension	Cutter spare parts		
Cutter diameter	Screw	Wrench	Torque
φ16-φ63	AST25064-50P	ADT-T08	1.0Nm

Application		
Face milling	Cavity milling	Ramp milling

Remark: represent for coolant
 represent for no coolant

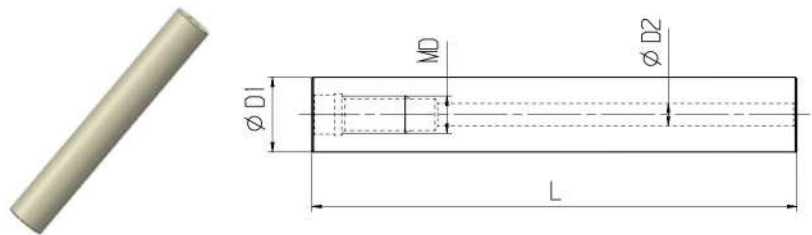
- Shank stock item(used for screw modular type cutter)

1-Taper head shank



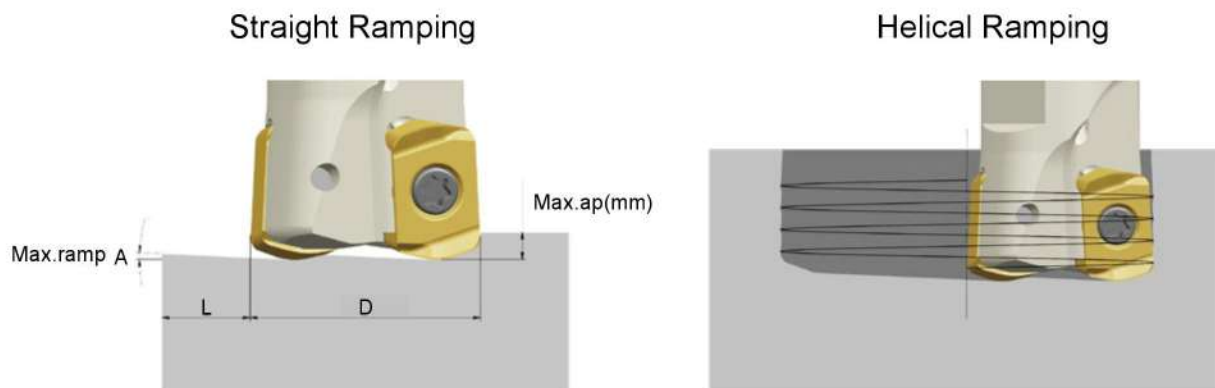
Designation	Dimension(mm)						Materials
	MD	φd	φD1	φD2	L	l	
AMS-M08-020-080-16T	M8	16	14.5	5	80	20	Steel
AMS-M08-040-100-16T	M8	16	14.5	5	100	40	Steel
AMC-M08-080-150-16T	M8	16	14.5	5	150	80	Carbide
AMC-M08-150-200-16T	M8	16	14.5	5	200	150	Carbide
AMS-M10-030-100-20T	M10	20	18	6	100	30	Steel
AMS-M10-050-120-20T	M10	20	18	6	120	50	Steel
AMC-M10-090-150-20T	M10	20	18	6	150	90	Carbide
AMC-M10-140-200-20T	M10	20	18	6	200	140	Carbide
AMS-M12-030-110-25T	M12	25	22.5	6	110	30	Steel
AMS-M12-050-130-25T	M12	25	22.5	6	130	50	Steel
AMC-M12-120-180-25T	M12	25	22.5	6	180	120	Carbide
AMC-M12-140-250-25T	M12	25	22.5	6	250	140	Carbide
AMS-M16-035-125-32T	M16	32	28.5	8	125	35	Carbide
AMS-M16-055-145-32T	M16	32	28.5	8	145	55	Steel
AMC-M16-120-200-32T	M16	32	28.5	8	200	120	Steel
AMC-M16-180-260-32T	M16	32	28.5	8	260	180	Carbide

2-Straight shank



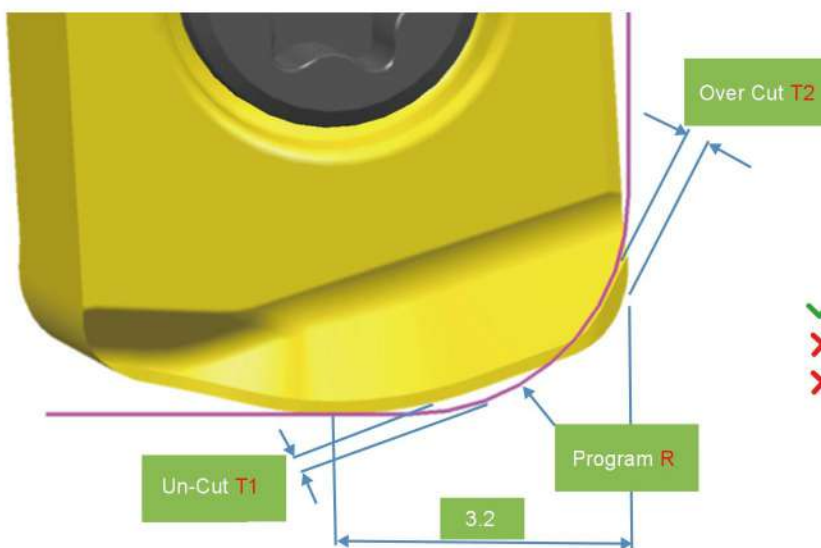
Designation	Dimension(mm)				Materials
	MD	φD1	φD2	L	
AMC-M08-105-16S	M8	16	5	105	Carbide
AMC-M08-160-16S	M8	16	5	160	Carbide
AMC-M10-130-20S	M10	20	6	130	Carbide
AMC-M10-250-20S	M10	20	6	250	Carbide
AMC-M12-145-25S	M12	25	6	145	Carbide
AMC-M12-285-25S	M12	25	6	285	Carbide
AMC-M16-157-32S	M16	32	8	157	Carbide
AMC-M16-287-32S	M16	32	8	287	Carbide

• **Technical information**



Cutter Dia(D)	Straight ramp down			Helical Ramping	
	Max.ramp-A	Max.ap(mm)	Min.length-L(mm)	Min.Dia.(mm)	Max.Dia(mm)
φ16	2.9°	0.7	13.8	23	32
φ17	2.6°	0.7	15.4	25	34
φ20	1.9°	1.0	30.1	31	40
φ21	1.8°	1.0	31.8	33	42
φ25	1.3°	1.0	44.0	41	50
φ26	1.3°	1.0	44.0	43	52
φ32	0.9°	1.0	63.6	55	64
φ33	0.9°	1.0	63.6	57	66
φ40	0.7°	1.0	81.8	71	80
φ50	0.5°	1.0	114.5	91	100
φ63	0.4°	1.0	143.2	117	126

NC Program Radius



Technical information for NC program

Program R	Un-Cut T1	Over-Cut T2
R1.5	0.43	0
R2.0	0.29	0.06
R2.5	0.15	0.24

Note : select R1.5 as program R , without over-cut.

● Recommended cutting speed by materials

Machined Materials		Achteck Milling Grades Application Ranges									Cutting depth and feed rate												
ISO	Material classification	Tensile strength (N/mm ²)	Hardness (HB)	AP301U			AP351U			AP401U			LNMX 0604										
				PVD			PVD			PVD			Chip breaker										
				P15-35			P30-45			P20-40			MM3 MM4										
				M15-35			M30-45			M20-40													
				-			-			-													
				-			-			-													
				-			S30-45			S20-40			MM3 MM4										
				-			-			-													
				Feed rate(mm/z)												ap(mm) Feed rate(mm/z)							
				Min	Med	Max	Min	Med	Max	Min	Med	Max	Min	Med	Max								
Cutting speed(m/min)												Min	-	Max	Min	-	Max	Min	-	Max	Min	-	Max
P	Non-alloyed steel	<600	<180	450	340	290	230	205	170	0.1 -1.0						0.30 - 2.00 0.30 - 2.00							
		<950	<280	320	240	200	200	180	160														
	Alloyed steel	700-950	200-280	290	210	185	200	155	110														
		950-1200	280-355	280	210	200	180	130	90														
M	Duplex stainless steel	778	230	165	150	130	270	215	155	150	115	85	0.30 - 2.00 0.30 - 2.00										
	Austenitic stainless steel	675	200	270	185	90	260	180	90	185	140	105											
	Precipitation-hardening stainless steel	1013	300	300	225	165	170	150	110	125	95	70											
K	Grey cast iron	700	220																				
	Nodular Cast iron	880	260																				
	Malleable cast iron	800	250																				
S	Fe based alloy	943	280																				
	Co based alloy	1076	320																				
	Ni based alloy	1177	350																				
	Ti-alloy	1262	370																				
N	Aluminum	260	75																				
	Aluminum alloy	447	130																				
H	Hardened steel	-	50-60HRC																				
	Chilled cast iron	-	55HRC																				

* The recommended cutting conditions always refer to general conditions. These cutting conditions should be adjusted according to the practical machine rigidity, tools, work piece clamping and coolants.

* When slotting , $ap=1/2ap_{max}$