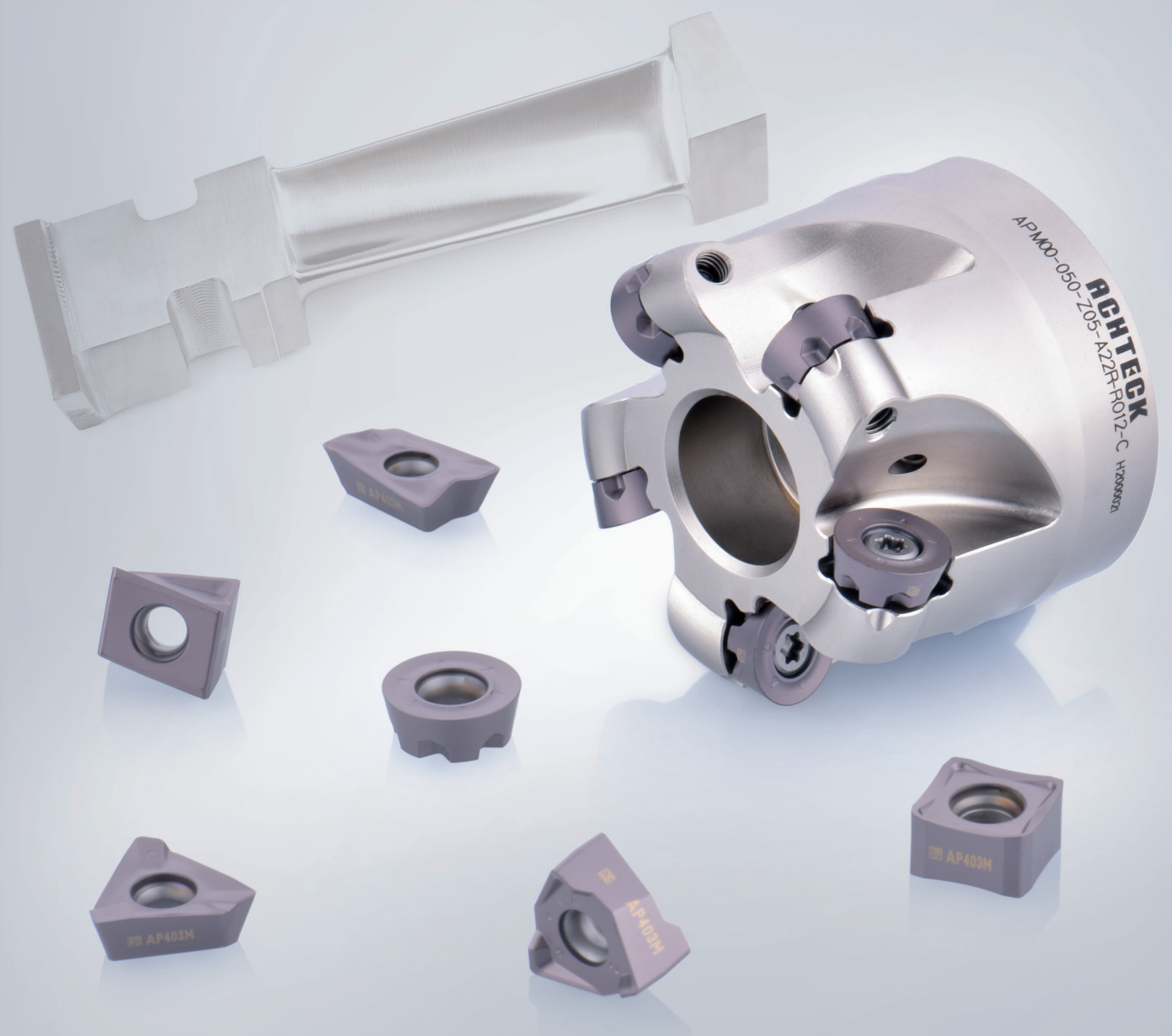


**NEW
PRODUCT!**

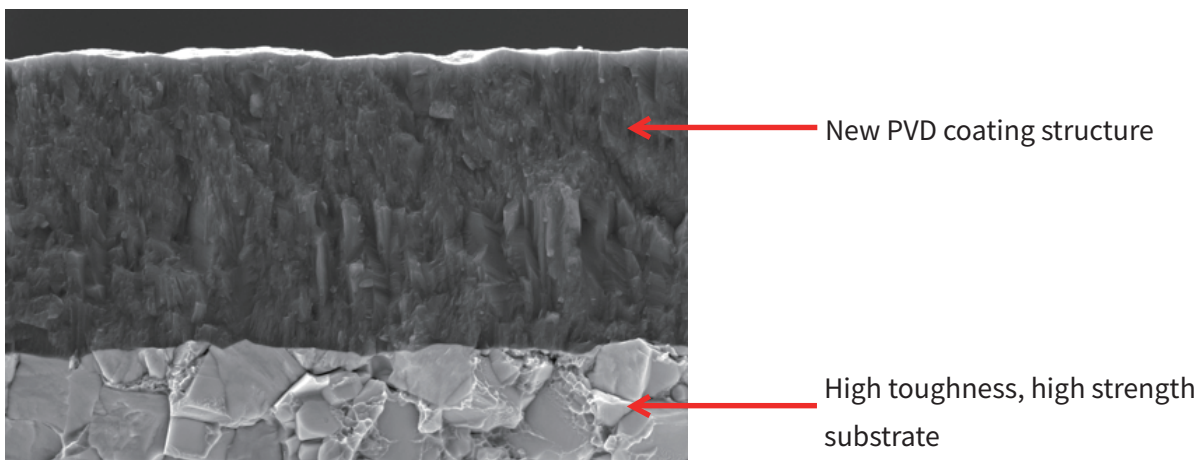
AP403M Grade

For Stainless Steel Milling



◆ **AP403M Grade Introduction**

Achteck has launched a new grade AP403M for stainless steel milling. This grade used high toughness and high heat resistant substrate, combined with new PVD coating. It offers excellent coating adhesion, built-up edge resistance and high temperature oxidation resistance. It has superior machinability for milling stainless steel materials.



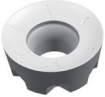
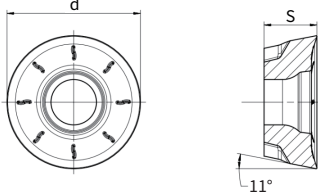



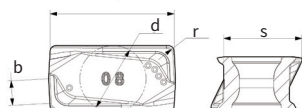


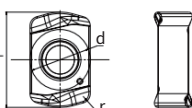

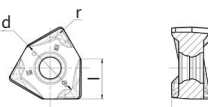

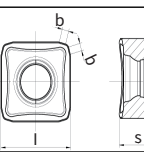
◆ **AP403M Grade Features**

- PVD coating with excellent coating adhesion.
- With excellent built-up edge resistance and high temperature oxidation resistance.
- Super smooth coating surface, low friction coefficient, good wear resistance.
- Longer tool life even under complex and harsh working conditions such as strong impact and rough oxidation skin on the work piece.
- Submicron carbide grains offer excellent wear resistance.

◆ **AP403M Grade Application**

AP403M	ISO range	Application range										Cutting speed		
												m/min		
		5	10	15	20	25	30	35	40	45	50	VCmin	VCmax	
M	M35-M50								AP403M				120	230
P	P35-P50								AP403M				110	270

● AP403M inserts

Insert	Product code	Dimension(mm)					Grade	Dimensions	
		l (mm)	d (mm)	s (mm)	r (mm)	h (mm)			
	ROHT 0803M0E-MM3	/	08	3.18	/	/	●		
	ROHT 10T3M8E-MM3	/	10	3.97	/	/	●		
	ROHT 1204M4E-MM3	/	12	4.76	/	/	●		
	ROHT 1204M6E-MM3	/	12	4.76	/	/	●		
	ROHT 1605M8E-MM3	/	16	5.56	/	/	●		
	ROHT 2006M8E-MM3	/	20	6.35	/	/	●		
	ROMT 10T3M4E-MR6	/	10	3.97	/	/	●		
	ROMT 1204M6E-MR6	/	12	4.76	/	/	●		
	ROMT 1605M6E-MR6	/	16	5.56	/	/	●		
	ROMT 2006M8E-MR6	/	20	6.35	/	/	●		
	RPMT 1204MOE-T1000	/	12	4.76	/	/	●		
	LNHU 090408ER-MR2	9	4.5	7.5	0.4	/	●		
	LNHU 090404ER-MM3	9	4.5	7.45	0.8	/	●		
	LNHU 090412ER-MR2	9	4.5	7.4	1.2	/	●		
	LNHU 090416ER-MR2	9	4.5	7.35	1.6	/	●		
	LNHU 090420ER-MR2	9	4.5	7.31	2.0	/	●		
	LNHU 130608ER-MR2	13.02	6.8	10.15	0.8	/	●		
	LNMX 060410R-MM3	10	6.35	3.6	1.0	/	●		
	LNMX 060410R-MM4N	10	6.35	3.6	1.0	/	●		
	WNGU 080608R-MR2	8	12.5	7.88	0.8	/	●		
	SNMX 1206ENN-MM4	/	12.7	6.34	/	1.2	●		
	SNGX 1206ENN-MM4	/	12.7	6.34	/	1.2	●		

● Stocked
○ Non-stocked standard

◆ **AP403M Case Study**

Workpiece: Flange

Material: 316L

Hardness: 187HB

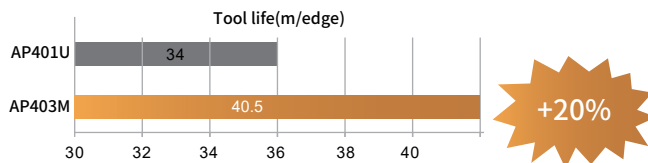
Insert: LNMX 060410R-MM4N AP403M

Cutter: AHM20-025-Z04-C25R-LN06-L140-C

Machining position: R17.5 (L=37.5 / S=23)

Cutting parameters: Vc=80m/min, ap=0.5mm, fz=0.5

Coolant: Emulsion



Test result: AP403M tool life is 20% longer than AP401U

