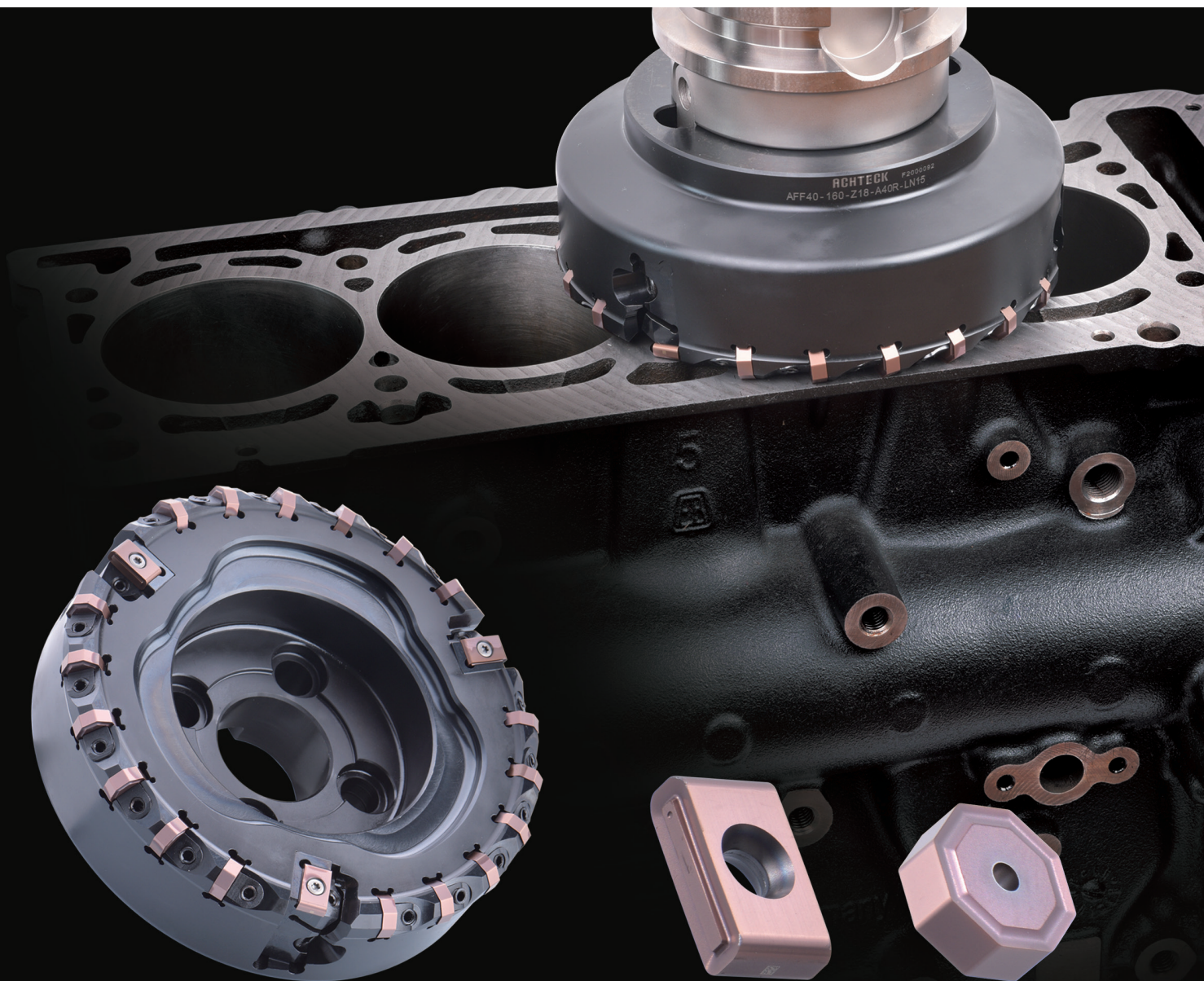


**NEW
PRODUCT!**

AFF40-LN12/15

Cast Iron Finishing Milling Cutter



◆ AFF40-LN12/15 Milling cutter

- Close pitch design, approach angle 40°;
- AFF40-LN12, diameter range: $\Phi 80-100\text{mm}$;
- AFF40-LN15, diameter range: $\Phi 125-250\text{mm}$;
accept special tool inquiry;
- Wedge clamping design for roughing insert, easily to install ;
- Wiper cartridge designed with pre-load mounting technology, wiper insert can be easily adjusted and stable accuracy ;
- Tool body surface with blackening treatment;



◆ AFF40-LN12/15 Insert

- Rough insert

Octagonal negative roughing insert with 16 indexes, economic choice

Insert description ONHF 050408-MM3

Insert grade AP151H

- Wiper Insert

With 4 indexes

Insert description

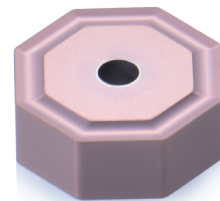
LNHQ 120408FN-W

LNHQ 150416FN-W

Insert grade AP151H

AP151H with high hardness substrate and high wear resistance coating

Roughing and wiper insert are fine ground insert



◆ Application

Used for cast iron materials, example: gray cast iron, nodular cast iron, CGI material;

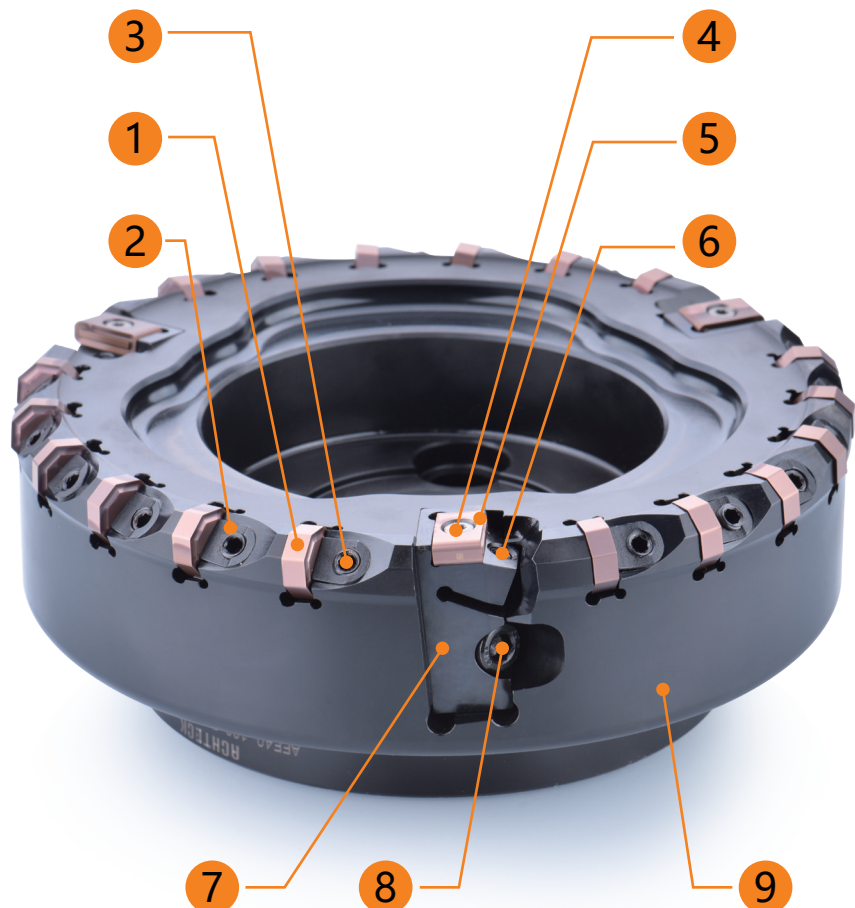
Used for finish milling of high-precision box parts such as engine cylinder block and cylinder head, hydraulic pump body and valve body ;

● Installation and adjustment method on cast iron finishing machining cutter:

1. Clean wiper cartridge (7), completely release adjusting screw(6);
2. Clean each inserts pocket, cartridge pocket, clean inserts and cartridges,
3. Install roughing inserts(1), wiper cartridges(7) and use finger to push them to the locating surface and lock the bolt;
4. Install wiper inserts(5);
5. Measure the axial runout of each roughing and wiper insert;
6. Adjusting wiper inserts height through adjusting screw(6), Wiper inserts Max. runout value should be higher than roughing inserts, height range 0.03-0.06;

● Corresponding items of each serial number:

1. Roughing inserts(ON..05..)
2. Locking wedge
3. Double-headed wedge Locking bolts
4. Wiper inserts clamping screw
5. Wiper inserts (LN12/15)
6. Adjusting screw
7. Wiper inserts cartridge
8. Locking bolt for wiper cartridge
9. Cutter



Case Study

Workpiece name: Construction machinery casing

Workpiece material: HT275

Material hardness: HB180-220

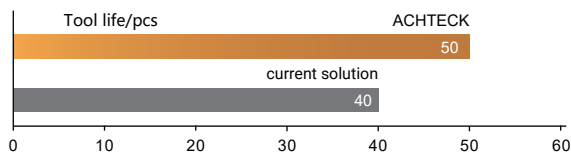
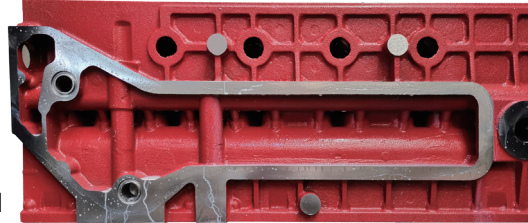
Cooling type: Wet cutting

Cutter number: AFF40-160-Z18-A40R-LN15

Roughing Insert number: ONHF 050408-MM3 AP151H

Wiper insert number: LNHQ 150416FN-W AP151H

Cutting data: $V_c=200\text{m/min}$ $f_z=0.15\text{mm/z}$ $a_p=0.5\text{mm}$



Comparison results: ACHTECK inserts tool life is 25% higher than competitor

Workpiece name: Engine cylinder head

Workpiece material: Alloy cast iron

Material hardness: HB250

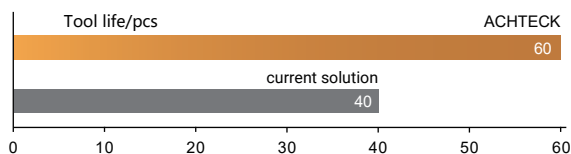
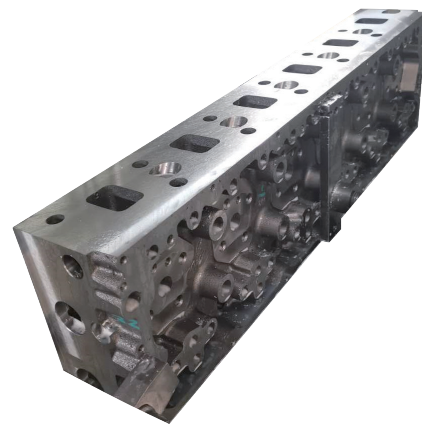
Cooling type: Wet cutting

Cutter number: AFF40-160-Z18-A40R-LN15

Roughing Insert number: ONHF 050408-MM3 AP151H

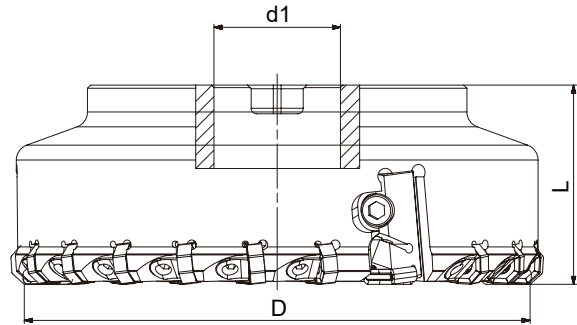
Wiper insert number: LNHQ 150416FN-W AP151H

Cutting data: $V_c=226\text{m/min}$ $f_z=0.22\text{mm/z}$ $a_p=0.5\text{mm}$



Comparison results: ACHTECK inserts tool life is 50% higher than competitor

• AFF40-LN12/15 Tool body stock items



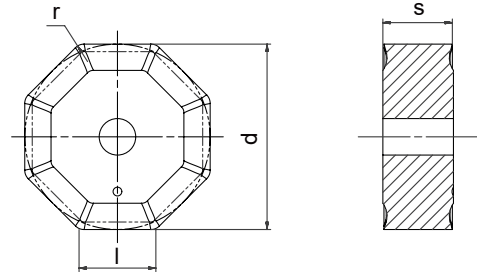
Model	Size				With coolant	Teeth	Teeth of wiper inserts	Inserts
	D	d1	L	apmax				
AFF40-080-Z08-A27R-LN12	80	27	50	0.5		8+2	2	ONHF 050408-MM3 AP151H
AFF40-100-Z10-A32R-LN12	100	32	50	0.5		10+2	2	LNHQ 120408FN-W AP151H
AFF40-125-Z15-A40R-LN15	125	40	63	0.5		15+3	3	ONHF 050408-MM3 AP151H LNHQ 150416FN-W AP151H
AFF40-160-Z18-A40R-LN15	160	40	63	0.5		18+3	3	
AFF40-200-Z24-A60R-LN15	200	60	63	0.5		24+3	3	
AFF40-250-Z30-A60R-LN15	250	60	63	0.5		30+3	3	

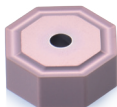
Dimension(mm)	Spare parts				
Cutter diameter	wedge type	wedge clamping screw	wiper inserts locking screw	wiper inserts adjusting screw	wiper inserts cartridge locking screw
φ80-250					
	A WG-6H-13B	WD060200	SP040085H	AH050100F	SH060250

Dimension(mm)	Spare parts				
Cutter diameter	wedge screw wrench	wiper inserts screw wrench	wiper inserts adjusting screw wrench	wiper cartridge locking screw wrench	wiper cartridge
φ80-250					
	LT-H3	DT-TP10	LT-H2.5	LT-H5	φ80-100
					φ125-250
					C-LN1235-2545
					C-LN1535-2545

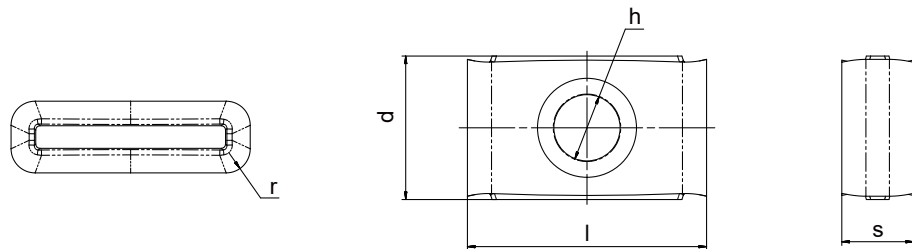
● **AFF40-LN12/15 Insert stock item**


ONHF 05



Inserts	Model	Size				Grades
		l	d	s	r	PVD coating
						AP151H
	ONHF 050408-MM3	5.3	12.7	4.76	0.8	●

LNHQ



Inserts	Model	Size					Grades
		l	d	s	r	h	PVD coating
							AP151H
	LNHQ 120408FN-W	12.7	9.525	4.76	0.8	4.4	●
	LNHQ 150416FN-W	15.875	9.525	4.76	1.6	4.4	●

● Stands for standard stock