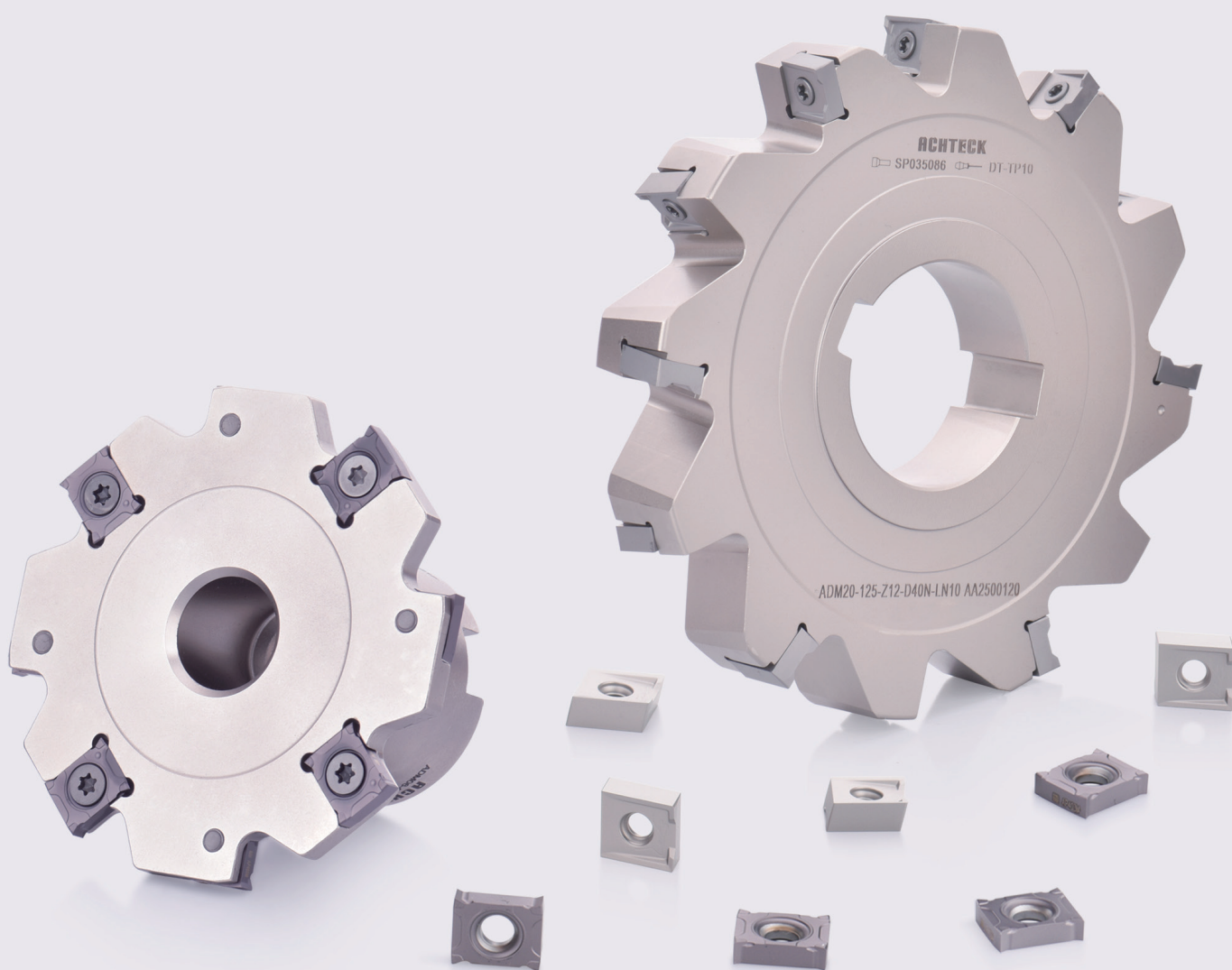
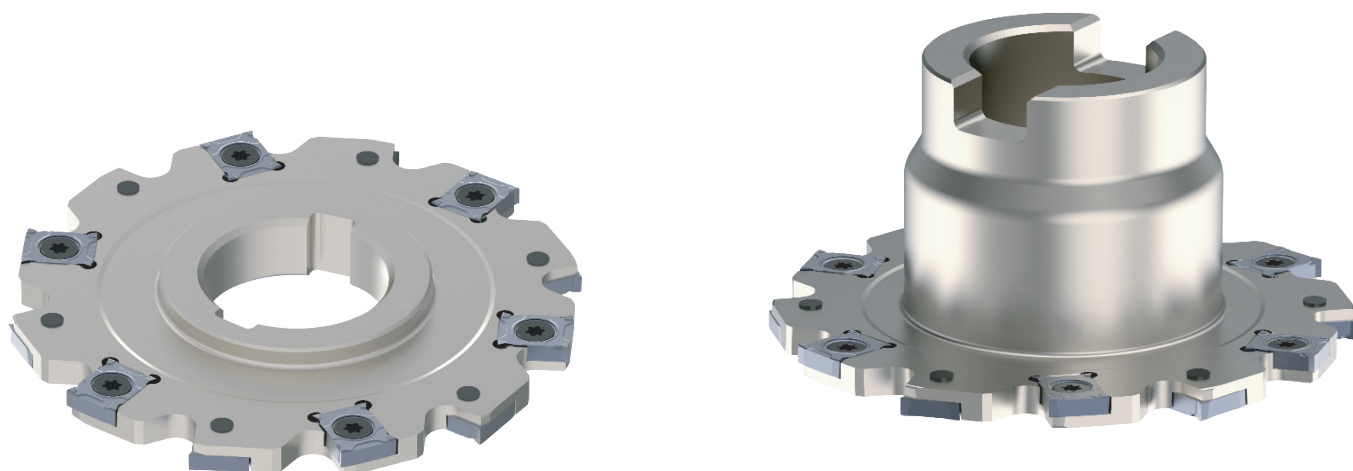
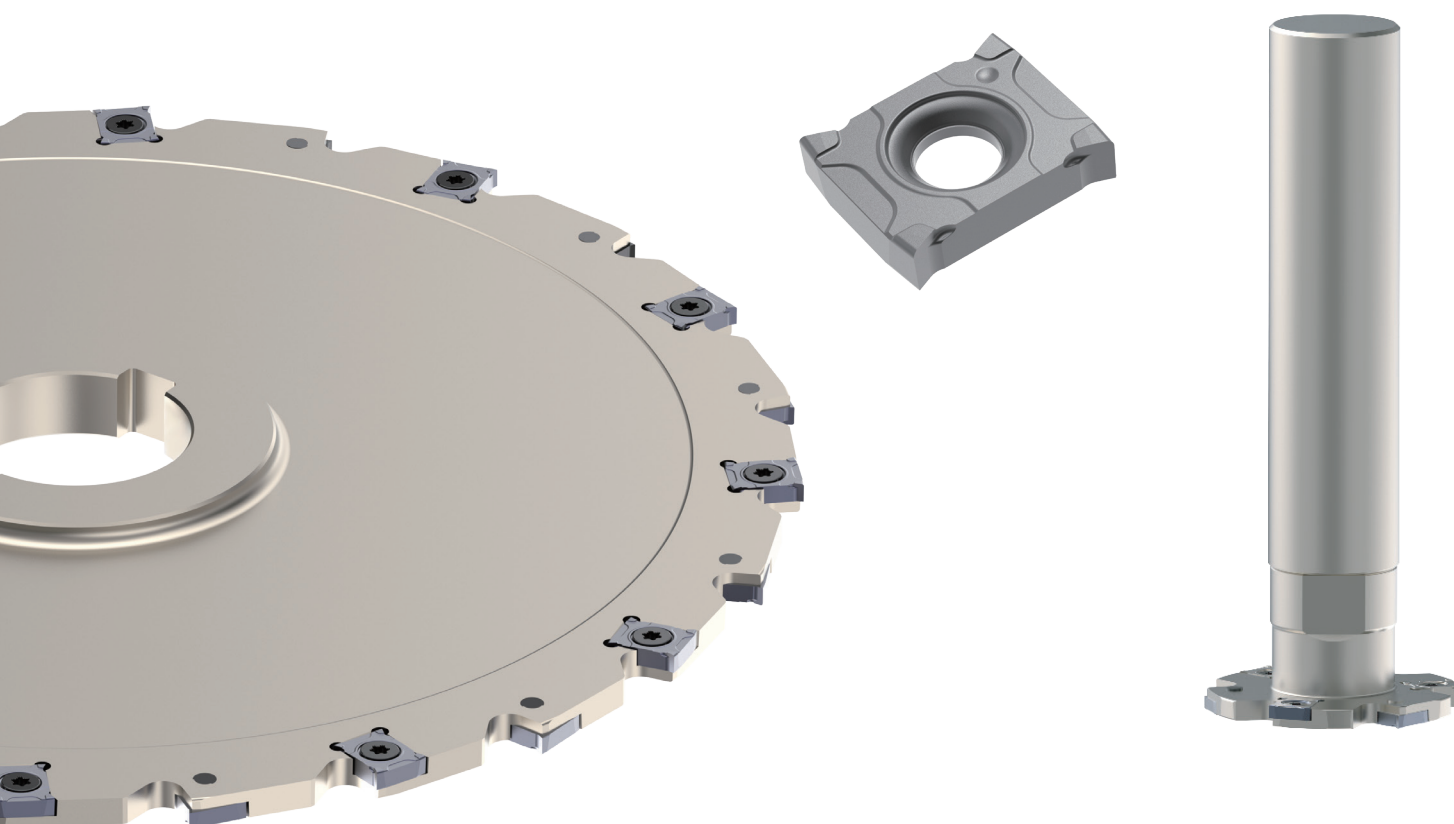


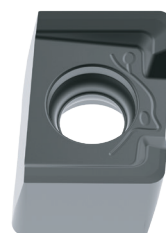
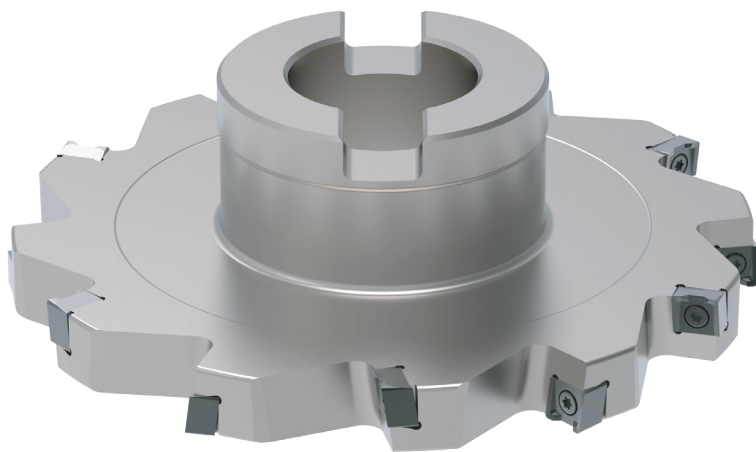
LXHX & LNGX Series Disc Milling Cutter



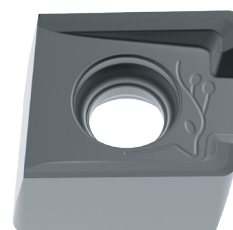
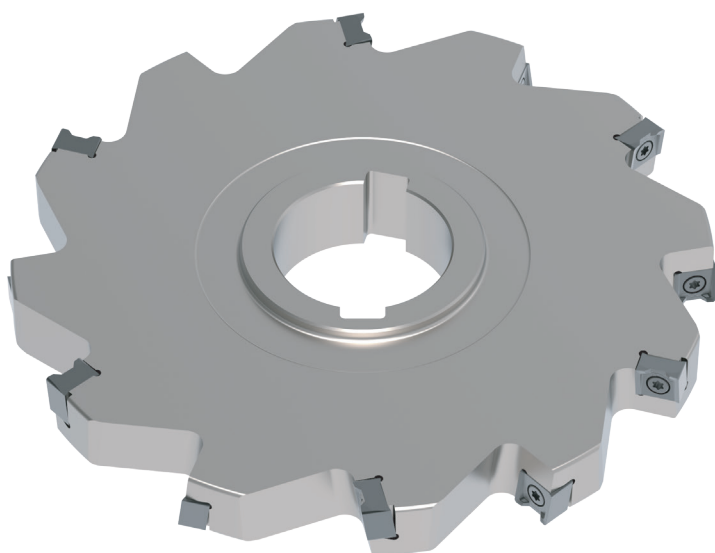


LXHX12 Series Disc Milling Range from 4mm to 10mm

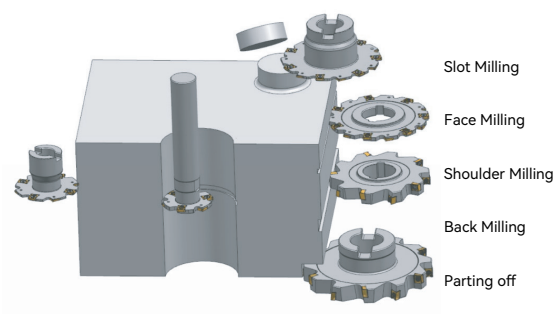




LNGX06/08/10 Series Disc Milling Range from 10mm to 20mm



Product Introduction



Brand-new Disc Milling Cutters

Delivers powerful slot milling and excellent versatile milling performance.

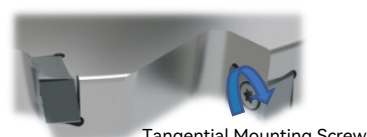
An integrated tool balancing precision, cost, efficiency and cycle time.

LXHX Series: 4/5/6/8/10 mm cutters, diameter ranging from 80 mm to 250 mm

LNGX Series: 10/12/14/16/20 mm cutters, diameter ranging from 80 mm to 250 mm

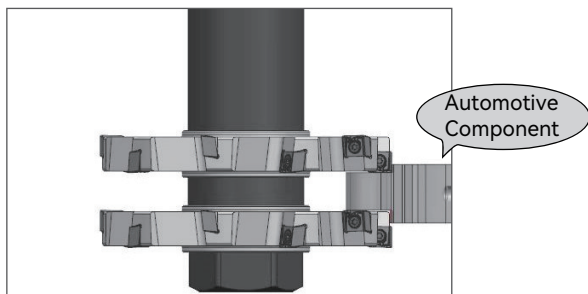


LXHX Series

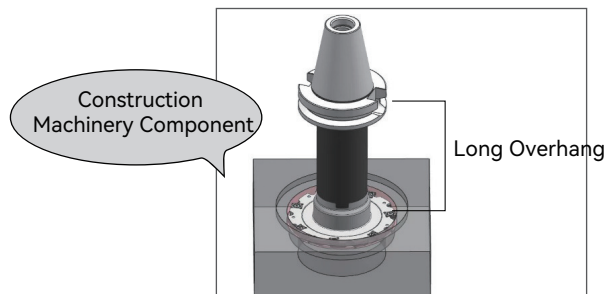


LNGX Series

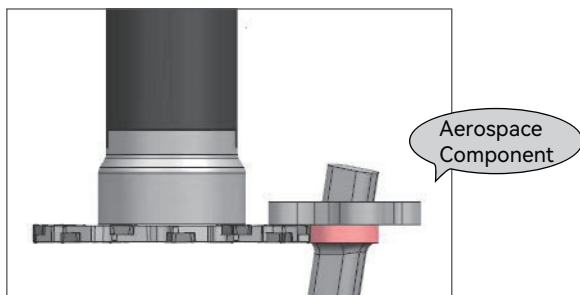
Industry Applications



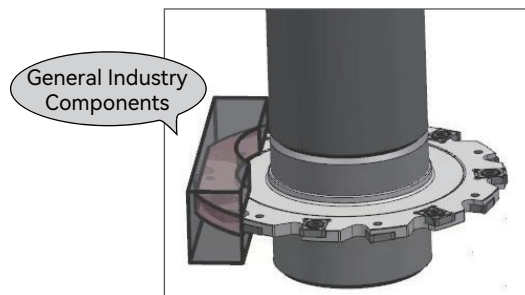
Simultaneous machining with multiple cutters
Higher efficiency and shorter cycle time



Long overhang for cavities of valves and pumps
Ensure excellent surface quality



Back Milling
Free from machine tool limitations



High-precision slot milling
Balances dimensional accuracy and surface quality

Versatile & High-Precision Disc Milling Cutters
Meeting diverse demands and tackling various challenges

Denomination

A	DM	10	100	Z12	D	27	N	LX12
1	2	3	4	5	6	7	8	9

1- A--ACHTECK

2- Machining Method
DM Disc milling

4- Cutter Dia.
050 50mm
063 63mm
080 80mm
* *
250 250mm

7- Connection Dimension
22 22mm
27 27mm
* *
50 50mm

3-Thickness
04 4mm
05 5mm
06 6mm
08 8mm
10 10mm
12 12mm
14 14mm
16 16mm
20 20mm

5- Number of Teeth
Z02 2 teeth
Z04 4 teeth
Z08 8 teeth
* *
Z28 28 teeth

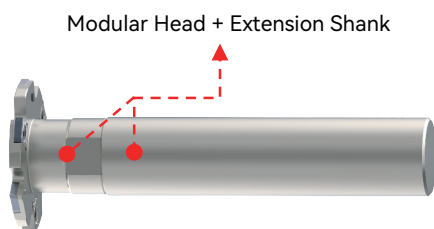
8- Direction of Tool
R Right
L Left
N Neutral

6- Connection Type
A Arbor
W Weldon shank
C Cylindrical shank
N Whistle notch shank
M Screw clamping modular head
D Key Drive

9- Insert
LX12 LX12 Series
LN06 LN06 Series
LN08 LN08 Series
LN10 LN10 Series

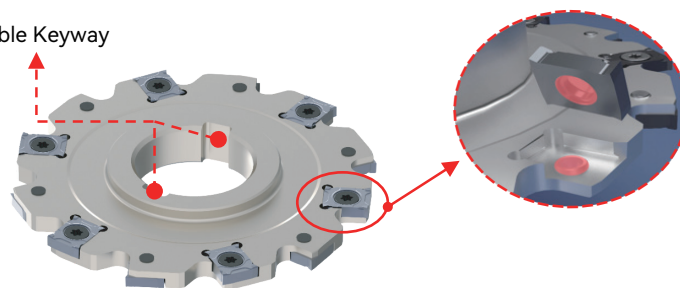
*Insert denomination: see catalog

Disc Milling Cutter

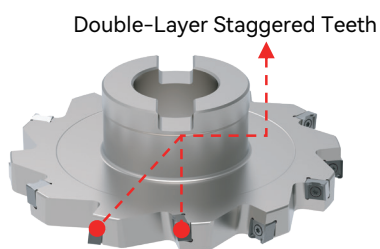


C Type—Cylindrical shank

Double Keyway



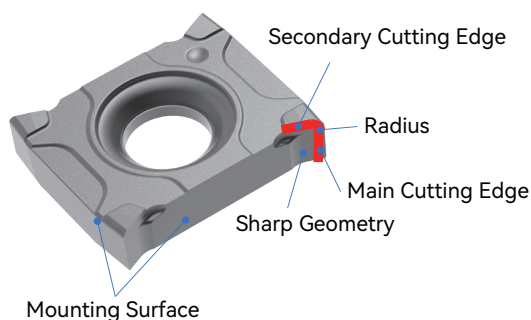
D Type—Key Drive



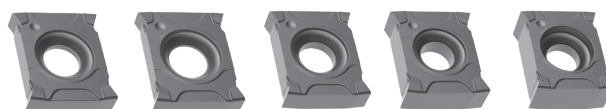
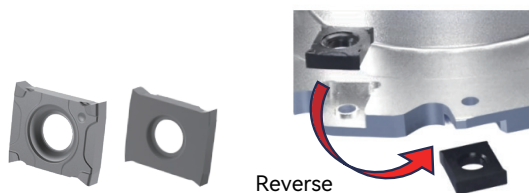
A Type—Arbor

- C-type compatible with partial LXHX inserts, detachable with strong adaptability.
- Unique insert and cutter body assembly design for LXHX series, extended threads, stable and reliable.
- D-type with double keyway, superior connection rigidity, enabling combined machining of multiple cutters, great flexibility.
- All series adopt a double-layer fixed and staggered teeth design, ensuring superior stability during cutting.

LXHX Inserts



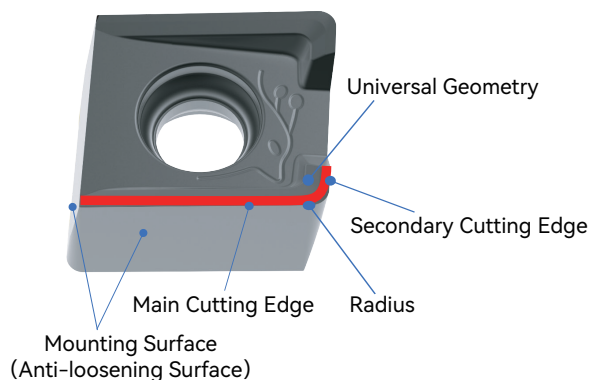
- Main Cutting Edge: In the direction of insert thickness, a larger thickness corresponds to a longer cutting edge.
- Radius: R0.4/R0.8, expandable as required.
- Secondary Cutting Edge: Wiper for excellent surface quality.
- Sharp Geometry: MM3 low cutting force, prevents deformation.
- Mounting Surface: High-precision ground surface with high dimensional accuracy of the cutter.



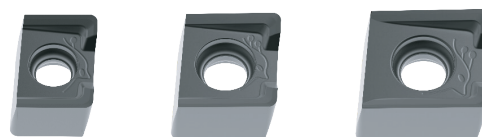
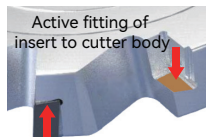
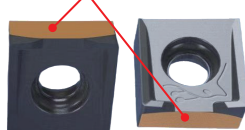
Single-sided design with 4 cutting edges

No need to switch between left-hand and right-hand inserts, featuring easy installation and lower costs.

◆ LNGX Inserts



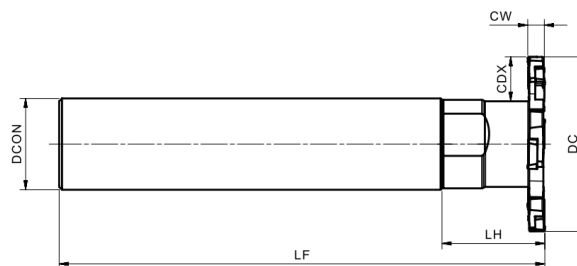
Anti-loosening Surface
(Invention Patent)



- Main Cutting Edge: Along the insert length, one type of insert can be applied for multiple cutters.
- Radius: R0.4/R0.8, expandable as required.
- Secondary Cutting Edge: Wiper for excellent surface quality.
- Universal Geometry: MM4 for medium machining, suitable for most working conditions.
- Anti-loosening Surface: Produces active fitting force with the cutter body to prevent insert shifting and loosening.
- Mounting Surface: High-precision ground surface with high dimensional accuracy of the cutter.

Double-sided design with 4 cutting edges
Unique anti-loosening surface improves safety and surface quality.

◆ List of 4mm to 10mm Milling Cutters



Product Code		Dimensions (mm)						Weight (kg)	Stock	Inserts
		DC	LF	LH	DCON	CW	CDX			
ADM04-	050-Z04-C25R-LX12-L150	50	150	30	25	4	15	0.71	○	LXHX 1202..
	063-Z06-C32R-LX12-L170	63	170	36	32	4	16.5	1.15	○	
ADM05-	050-Z04-C25R-LX12-L150	50	150	30	25	5	15	0.65	○	LXHX 12T2..
	063-Z06-C32R-LX12-L170	63	170	36	32	5	16.5	1.16	○	
ADM06-	050-Z04-C25R-LX12-L150	50	150	30	25	6	15	0.66	○	LXHX 1203..
	063-Z06-C32R-LX12-L170	63	170	36	32	6	16.5	1.18	●	

●: Stock available ○: Made to order

● List of 4mm to 10mm Milling Cutters

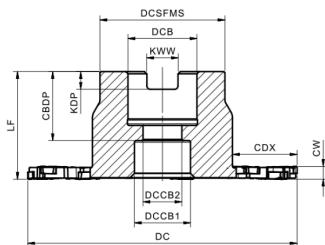
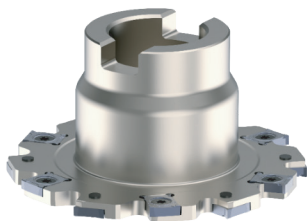


Fig. 1

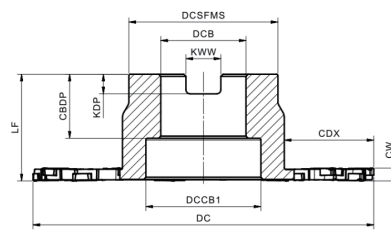
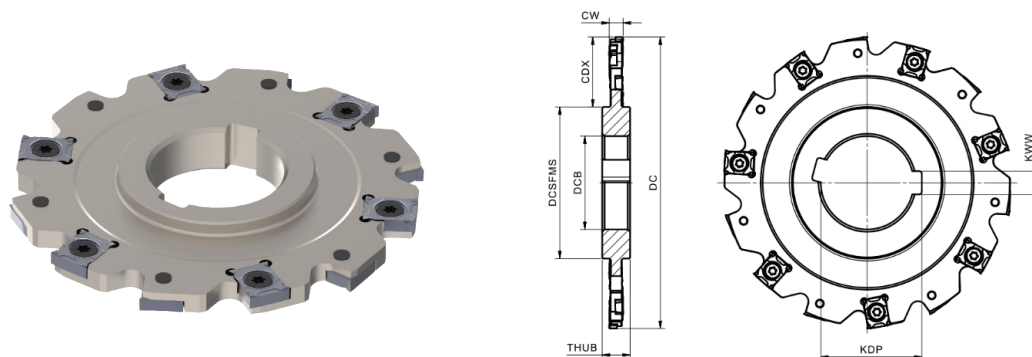


Fig. 2

Product Code	Dimensions (mm)											Weight (kg)	Stock	Fig.	Inserts
	DC	LF	DCSFMS	DCB	KWW	KDP	CBDP	DCCB1	DCCB2	CW	CDX				
ADM04- 080-Z08-A22R-LX12	80	50	41	22	10.4	6.5	26	18	11	4	22.5	0.47	○	1	LXHX 1202..
100-Z12-A27R-LX12	100	50	48	27	12.4	7.2	29	20	14	4	27	0.58	○		
125-Z14-A32R-LX12	125	50	58	32	14.4	8.2	32	26	18	4	30	1.15	●		
160-Z18-A40R-LX12	160	50	70	40	16.4	9.2	30	54	-	4	42	1.35	○	2	
ADM05- 080-Z08-A22R-LX12	80	50	41	22	10.4	6.5	26	18	11	5	22.5	0.49	○	1	LXHX 12T2..
100-Z12-A27R-LX12	100	50	48	27	12.4	7.2	29	20	14	5	23	0.84	○		
125-Z14-A32R-LX12	125	50	58	32	14.4	8.2	32	26	18	5	30	1.20	●		
160-Z18-A40R-LX12	160	50	70	40	16.4	9.2	30	54	-	5	42	1.43	○	2	
ADM06- 080-Z08-A22R-LX12	80	50	41	22	10.4	6.5	26	18	11	6	22.5	0.50	●	1	LXHX 1203..
100-Z12-A27R-LX12	100	50	48	27	12.4	7.2	29	20	14	6	23	0.86	○		
125-Z14-A32R-LX12	125	50	58	32	14.4	8.2	32	26	18	6	30	1.25	○		
160-Z18-A40R-LX12	160	50	70	40	16.4	9.2	30	54	-	6	42	1.53	○	2	
ADM08- 063-Z06-A16R-LX12	63	35	30	16	8.4	5.8	24	14	9	8	17.5	1.00	●	1	LXHX 1204..
080-Z08-A22R-LX12	80	50	41	22	10.4	6.5	26	18	11	8	22.5	0.53	○		
100-Z12-A27R-LX12	100	50	48	27	12.4	7.2	29	20	14	8	22	0.96	○		
125-Z14-A32R-LX12	125	50	58	32	14.4	8.2	32	26	18	8	30	1.37	○		
160-Z18-A40R-LX12	160	50	70	40	16.4	9.2	30	54	-	8	42	1.73	○	2	
ADM10- 100-Z12-A27R-LX12	100	50	48	27	12.4	7.2	29	20	14	10	23	1.00	○	1	LXHX 1205..
125-Z14-A32R-LX12	125	50	58	32	14.4	8.2	32	26	18	10	30	1.50	●		
160-Z18-A40R-LX12	160	50	70	40	16.4	9.2	30	54	-	10	42	1.95	○	2	

●: Stock available ○: Made to order

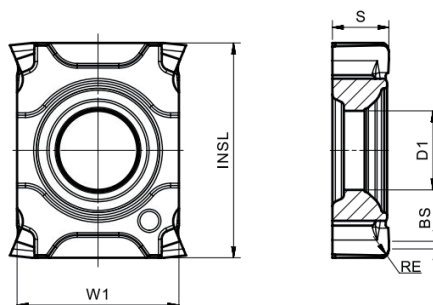
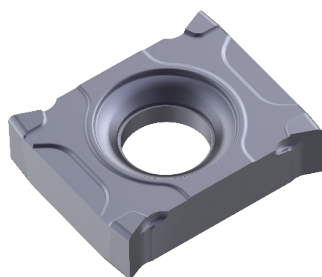
List of 4mm to 10mm Milling Cutters



Product Code	Dimensions (mm)								Weight (kg)	Stock	Inserts
	DC	THUB	DCSFMS	DCB	KWW	KDP	CW	CDX			
ADM04- 080-Z08-D22N-LX12	80	10	41	22	6	24.1	4	19.5	0.20	○	LXHX 1202..
	100	12	47	27	7	29.8	4	26.5	0.27	○	
	125	12	55	40	10	43.5	4	35	0.35	●	
	160	12	65	40	10	43.5	4	47.5	0.58	○	
ADM05- 080-Z08-D22N-LX12	80	10	36	22	6	24.1	5	22	0.20	○	LXHX 12T2..
	100	12	41	27	7	29.8	5	29.5	0.28	○	
	125	12	55	40	10	43.5	5	35	0.39	●	
	160	12	65	40	10	43.5	5	47.5	0.67	○	
ADM06- 080-Z08-D22N-LX12	80	10	34	22	6	24.1	6	23	0.22	○	LXHX 1203..
	100	12	47	27	7	29.8	6	26.5	0.34	○	
	125	12	65	40	10	43.5	6	30	0.57	●	
	160	12	65	40	10	43.5	6	47.5	0.78	○	
	200	12	69	50	12	23.5	6	65.5	1.14	○	
	250	12	69	50	12	53.5	6	90.5	1.76	○	
ADM08- 080-Z08-D22N-LX12	80	12	35	22	6	24.1	8	22.5	0.27	○	LXHX 1204..
	100	12	41	27	7	29.8	8	29.5	0.39	○	
	125	12	55	40	8	34.8	8	35	0.59	●	
	160	12	65	40	10	43.5	8	47.5	1.00	○	
	200	12	69	50	12	53.5	8	65.5	1.52	○	
	250	12	69	50	12	53.5	8	90.5	2.39	○	
ADM10- 100-Z12-D27N-LX12	100	12	41	27	7	29.8	10	29.5	0.47	○	LXHX 1205..
	125	12	55	40	8	34.8	10	35	0.71	●	
	160	12	65	40	10	43.5	10	47.5	1.21	○	
	200	12	69	50	12	53.5	10	65.5	1.89	○	
	250	12	69	50	12	53.5	10	90.5	3.03	○	

●: Stock available ○: Made to order

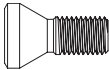
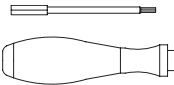
• List of LXHX Inserts



Product Code		Dimensions (mm)						Grade	Cutters
		INSL	W1	S	RE	BS	D	AP403M	
LXHX	120204N-MM3	12.5	9.87	2.3	0.4	0.48	4.6	○	ADM04
	12T204N-MM3	12.5	9.87	2.8	0.4	0.48	4.6	○	ADM05
	120304N-MM3	12.5	9.87	3.3	0.4	0.48	4.6	○	ADM06
	120308N-MM3	12.5	9.87	3.3	0.8	0.48	4.6	○	
	120404N-MM3	12.5	9.87	4.3	0.4	0.48	4.6	●	ADM08
	120408N-MM3	12.5	9.87	4.3	0.8	0.48	4.6	●	
	120504N-MM3	12.5	9.87	5.3	0.4	0.48	4.6	●	ADM10
	120508N-MM3	12.5	9.87	5.3	0.8	0.48	4.6	●	

●: Stock available ○: Made to order

• Spare Parts

Cutters	Spare Parts		Torque
	Screw	Wrench	
			
ADM04	ST04003391F	DT-T15	4.0 Nm
ADM05	ST04004391F		
ADM06	ST04005391F		
ADM08	ST04006391F		
ADM10			

*All screws are fine-threaded.

• List of 10mm to 20mm Milling Cutters

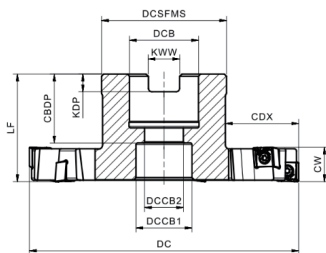
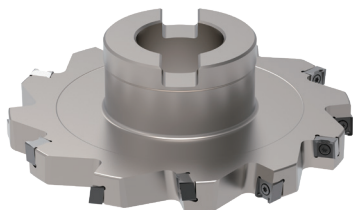


Fig.1

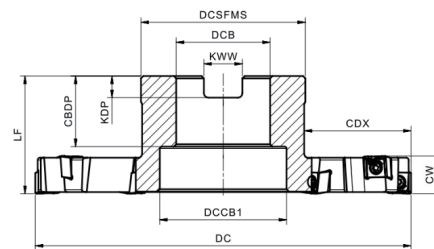
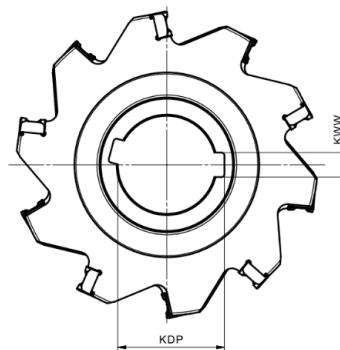
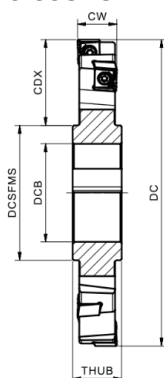
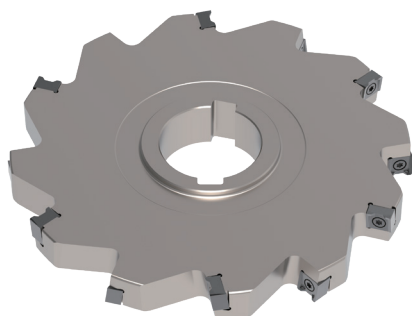


Fig.2

Product Code		Dimensions (mm)											Weight (kg)	Stock	Fig.	Inserts		
		DC	LF	DCSFMS	DCB	KWW	KDP	CBDP	DCCB1	DCCB2	CW	CDX						
ADM10-	080-Z08-A22R-LN06	80	50	40	22	10.4	6.5	26	18	11	10	23.5	0.48	○	1	LNGX 06..		
	100-Z10-A27R-LN06	100	50	48	27	12.4	7.2	29	20	14	10	26.5	0.80	○				
	125-Z12-A32R-LN06	125	50	58	32	14.4	8.2	32	26	18	10	34	1.23	○				
ADM12-	100-Z10-A27R-LN06	100	50	48	27	12.4	7.2	29	20	14	12	26.5	0.84	○	1		LNGX 06..	
	125-Z12-A32R-LN06	125	50	58	32	14.4	8.5	32	26	18	12	34	1.36	○				
	160-Z14-A40R-LN06	160	50	71	40	16.4	9.2	30	54	-	12	45	1.86	○	2			
ADM14-	100-Z10-A27R-LN08	100	50	48	27	12.4	7.2	29	20	14	14	26.5	0.91	●	1	LNGX 08..		
	125-Z12-A32R-LN08	125	50	58	32	14.4	8.2	32	26	18	14	34	1.44	●				
	160-Z14-A40R-LN08	160	50	70	40	16.4	9.2	30	54	-	14	45.5	2.03	○	2			
ADM16-	125-Z10-A32R-LN08	125	50	58	32	14.4	8.2	32	26	18	16	34	1.58	●	1		2	LNGX 08..
	160-Z12-A40R-LN08	160	50	70	40	16.4	9.2	30	54	-	16	45.5	2.31	○				
	200-Z14-A40R-LN08	200	50	90	40	16.4	9.2	30	54	-	16	55.5	4.14	○				
ADM20-	125-Z12-A32R-LN10	125	50	58	32	14.4	8.2	32	26	18	20	34	1.82	●	1	2	LNGX 10..	
	160-Z12-A40R-LN10	160	50	70	40	16.4	9.2	30	54	-	20	45.5	2.65	○				
	200-Z14-A40R-LN10	200	50	90	40	16.4	9.2	30	54	-	20	55.5	4.74	●				
	250-Z16-A40R-LN10	250	50	90	40	16.4	9.2	30	54	-	20	80.5	7.16	○				

●: Stock available ○: Made to order

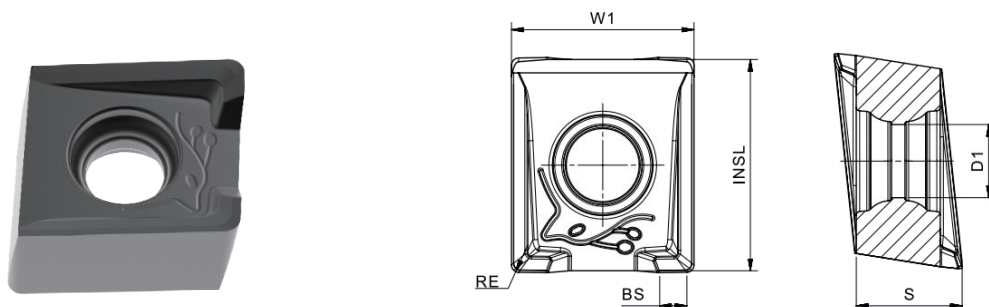
● List of 10mm to 20mm Milling Cutters



Product Code	Dimensions (mm)								Weight (kg)	Stock	Inserts
	DC	THUB	DCSFMS	DCB	KWW	KDP	CW	CDX			
ADM10- 080-Z08-D27N-LN06	80	12	40	27	7	29.8	10	20	0.24	●	LNGX 06..
100-Z10-D32N-LN06	100	12	47	32	8	34.8	10	26.5	0.39	○	
125-Z12-D40N-LN06	125	12	55	40	10	43.5	10	35	0.62	○	
ADM12- 100-Z10-D32N-LN06	100	12	46	32	8	34.8	12	27	0.42	●	
125-Z12-D40N-LN06	125	12	54	40	10	43.5	12	34.6	0.70	○	
160-Z14-D40N-LN06	160	12	54	40	10	43.5	12	51.7	1.25	●	
ADM14- 100-Z10-D32N-LN08	100	20	46	32	8	34.8	14	26.5	0.55	○	LNGX 08..
125-Z12-D40N-LN08	125	20	55	40	10	43.5	14	35	0.90	●	
160-Z14-D40N-LN08	160	20	55	40	10	43.5	14	52.5	1.57	○	
ADM16- 125-Z10-D40N-LN08	125	20	55	40	10	43.5	16	35	1.04	●	
160-Z12-D40N-LN08	160	20	55	40	10	43.5	16	52.5	1.87	○	
200-Z14-D50N-LN08	200	20	69	50	12	53.5	16	65.5	2.96	○	
ADM20- 125-Z12-D40N-LN10	125	20	55	40	10	43.5	20	35	1.28	●	LNGX 10..
160-Z12-D40N-LN10	160	20	55	40	10	43.5	20	52.5	2.24	●	
200-Z14-D50N-LN10	200	20	69	50	12	53.5	20	65.5	3.64	○	
250-Z16-D50N-LN10	250	20	69	50	12	53.5	20	90.5	6.07	●	

●: Stock available ○: Made to order

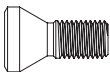
• List of LNGX Inserts



Product Code		Dimensions (mm)						Grade		Cutters
		INSL	W1	S	RE	BS	D1	AP403M	AP251K	
LNGX	060504-MM4	7.55	10	5.20	0.4	1.47	3.5	●	●	ADM10
	060508-MM4	7.55	10	5.20	0.8	1.09	3.5	●	●	ADM12
LNGX	080504-MM4	9.55	10	5.80	0.4	1.49	4.0	●	●	ADM14
	080508-MM4	9.55	10	5.80	0.8	1.11	4.0	●	●	ADM16
LNGX	100504-MM4	11.55	10	5.80	0.4	1.49	4.0	●	●	ADM20
	100508-MM4	11.55	10	5.80	0.8	1.11	4.0	●	●	

●: Stock available ○: Made to order

• Spare Parts

Cutters	Spare Parts		Torque
	Screw	Wrench	
			
ADM10	SP030083	DT-TP09	1.8 Nm
ADM12			
ADM14	SP035086	DT-TP10	3.0 Nm
ADM16			
ADM20			

● Cutting Depth Table for Disc Milling Cutters

Insert Series	ap (mm)	Connection Type	Available Diameter (mm) and Max. Cutting Depth (mm)							
			50	63	80	100	125	160	200	250
LXHX	4	C type	15	16.5						
		A type			22.5	27	30	42		
		D type			19.5	26.5	35	47.5		
	5	C type	15	16.5						
		A type			22.5	23	30	42		
		D type			22	29.5	35	47.5		
	6	C type	20	30						
		A type			22.5	23	30	42		
		D type			23	26.5	30	47.5	65.5	90.5
	8	A type		17.5	22.5	22	30	42		
		D type			22.5	29.5	35	47.5	65.5	90.5
	10	A type				22	30	42		
		D type				29.5	35	47.5	65.5	90.5
LNGX	10	A type			23.5	26.5	34			
		D type			20	26.5	35			
	12	A type				26.5	34	45		
		D type				27	34.6	51.7		
	14	A type				26.5	34	45.5		
		D type				26.5	35	52.5		
	16	A type					34	45	55.5	
		D type					35	52.5	65.5	
	20	A type					34	45.5	55.5	80.5
		D type					35	52.5	65.5	90.5

Case Story 1

Component: Aerospace Engine Nozzle Housing

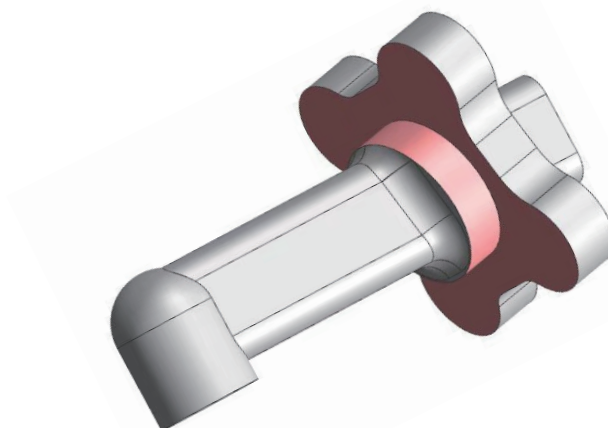
Material: Nickel-based superalloy

Cutter: ADM08-125-Z14-A32R-LX12

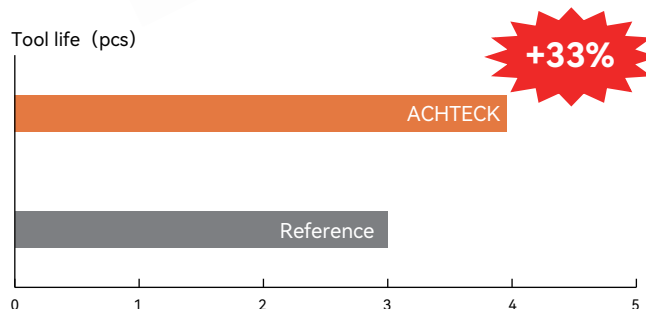
Insert: LXHX 120408N-MM3

Grade: AP403M

Operation: Semi-finishing



Cutting Data	Reference	Achteck
Vc [m/min]	50	50
fz [mm]	0.016	0.012
ae [mm]	23	23
ap [mm]	8	8
Coolant	Emulsion	Emulsion
Tool life (pcs)	3	4



Case Story 2

Component: Automotive Door Hinge

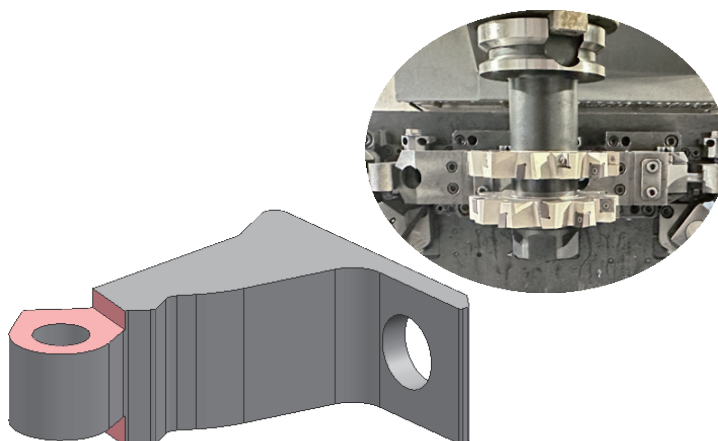
Material: S355J2

Cutter: ADM20-125-Z12-D40N-LN10

Insert: LNGX 100508-MM4

Grade: AP403M

Operation: Finishing



Cutting Data	Reference	Achteck
Vc [m/min]	295	295
fz [mm]	0.07	0.07
ae [mm]	18.7	18.7
ap [mm]	2.5/3.5	2.5/3.5
Coolant	Emulsion	Emulsion
Tool life (pcs)	1000	1275

