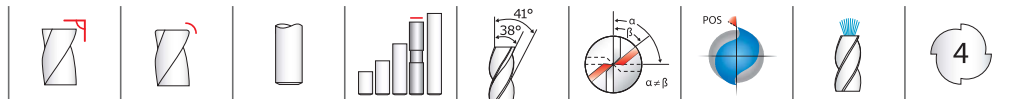


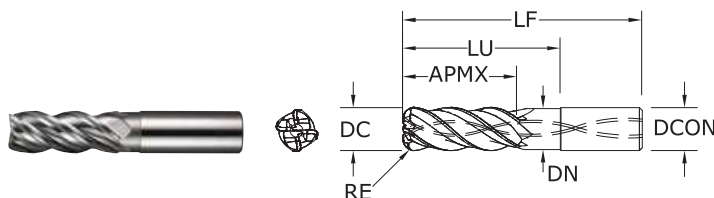
METRIC

S-Carb APF®



43MAPF

METRIC SERIES



- Ultra high-productivity finisher for Aluminum alloys, specifically for aircraft components
- Two levels of chatter suppression: variable helix and indexing
- Designed for single axial pass semi-finishing and finishing
- Polished flutes maximize chip evacuation and provides enhanced finish
- Recommended for materials ≤ 150 Bhn (≤ 7 HRC)

mm							EDP NO.
CUTTING DIAMETER DC	LENGTH OF CUT APMX	OVERALL LENGTH LF	SHANK DIAMETER DCON	REACH LU	NECK DIAMETER DN	CORNER RADIUS RE	Ti-NAMITE-B (TiB ₂)
6,0	24,0	58,0	6,0	30,0	5,66	—	44627
8,0	32,0	64,0	8,0	40,0	7,57	—	44628
10,0	40,0	80,0	10,0	50,0	9,47	—	44629
12,0	30,0	83,0	12,0	40,0	11,38	—	44630
12,0	30,0	83,0	12,0	40,0	11,38	2,0	44745
12,0	30,0	83,0	12,0	40,0	11,38	3,0	44746
12,0	30,0	83,0	12,0	40,0	11,38	4,0	44747
12,0	30,0	83,0	12,0	50,0	11,38	0,5	44641
12,0	30,0	83,0	12,0	50,0	11,38	5,0	44642
12,0	48,0	100,0	12,0	62,0	11,38	—	44631
12,0	48,0	100,0	12,0	62,0	11,38	2,0	44748
12,0	48,0	100,0	12,0	62,0	11,38	3,0	44749
12,0	48,0	100,0	12,0	62,0	11,38	4,0	44750
16,0	40,0	92,0	16,0	51,0	15,16	—	44634
16,0	40,0	92,0	16,0	51,0	15,16	2,0	44751
16,0	40,0	92,0	16,0	51,0	15,16	3,0	44752
16,0	40,0	92,0	16,0	51,0	15,16	4,0	44753
16,0	42,0	93,0	16,0	51,0	15,16	5,0	44643
16,0	64,0	125,0	16,0	82,0	15,16	—	44635
16,0	64,0	125,0	16,0	82,0	15,16	2,0	44754
16,0	64,0	125,0	16,0	82,0	15,16	3,0	44755
16,0	64,0	125,0	16,0	82,0	15,16	4,0	44756
20,0	50,0	108,0	20,0	63,0	18,97	—	44636
20,0	50,0	108,0	20,0	63,0	18,97	3,0	44757
20,0	50,0	108,0	20,0	63,0	18,97	4,0	44758
20,0	50,0	108,0	20,0	63,0	18,97	5,0	44759
20,0	80,0	150,0	20,0	102,0	18,97	—	44637
20,0	80,0	150,0	20,0	102,0	18,97	3,0	44760
20,0	80,0	150,0	20,0	102,0	18,97	4,0	44761
20,0	80,0	150,0	20,0	102,0	18,97	5,0	44762
25,0	63,0	130,0	25,0	79,0	23,75	—	44638
25,0	63,0	130,0	25,0	79,0	23,75	3,0	44763
25,0	63,0	130,0	25,0	79,0	23,75	4,0	44764
25,0	63,0	130,0	25,0	79,0	23,75	5,0	44765
25,0	100,0	175,0	25,0	120,0	23,75	—	44639
25,0	100,0	175,0	25,0	120,0	23,75	3,0	44766
25,0	100,0	175,0	25,0	120,0	23,75	4,0	44767
25,0	100,0	175,0	25,0	120,0	23,75	5,0	44768

Available on request: • JetStream Technology

TOLERANCES (mm)

6–25 DIAMETER

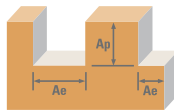
DC = $-0,010/-0,050$

DCON = h_6

RE = $+0,000/-0,030$

NON-FERROUS

For patent information visit
www.ksptpatents.com



Series 43MAPF Metric	Hardness	Ae x DC	Ap x DC	Vc (m/min)	DC • mm							
					6	8	10	12	16	20	25	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	≤ 150 Bhn or ≤ 7 HRc	Profile  ≤ 0.1 ≤ 2.5	800	RPM	42440	31830	25464	21220	15915	12732	10186
				(640-960)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
					Feed (mm/min)	8488	7003	6111	5942	6366	7130	6926
			Profile  ≤ 0.1 ≤ 4	800	RPM	42440	31830	25464	21220	15915	12732	10186
				(640-960)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
					Feed (mm/min)	6790	5729	5093	4244	4456	5093	4889
	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	≤ 150 Bhn or ≤ 7 HRc	Profile  ≤ 0.1 ≤ 2.5	600	RPM	31830	23873	19098	15915	11936	9549	7639
				(480-720)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
					Feed (mm/min)	6366	5252	4584	4456	4774	5347	5195
			Profile  ≤ 0.1 ≤ 4	600	RPM	31830	23873	19098	15915	11936	9549	7639
				(480-720)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
					Feed (mm/min)	5093	4297	3820	3183	3342	3820	3667

Bhn (Brinell) HRc (Rockwell C)
 surface speed is dependent on machine spindle and fixturing
 balancing is recommended at ultra high surface speeds
 *tool life may be reduced when machining Lithium Alloys
 $\text{rpm} = (\text{Vc} \times 1000) / (\text{DC} \times 3.14)$
 $\text{mm/min} = \text{Fz} \times 4 \times \text{rpm}$
 maximum recommended depths shown
 reduce speed and feed for materials harder than listed
 finish cuts typically require reduced feed and cutting depths of 0.02 X DC maximum
 ramp angle = 6° (feed rate = 50%)
 plunging not recommended
 refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)