

AXMT1235/AXMT1705 Shoulder Milling

- 90° shoulder milling with high feed rate
- Unique shape and strength cutting edge design
- Generates high quality surface finishes

AXMT1235 \$6.34

AXMT1705 \$6.85

*The above pricing is valid through 9/30/19



Specification

P	Steel	●	●	●	○	
M	Stainless Steel	○	●	○	●	● First Choice ○ Second Choice
K	Cast Iron	●	●	○	○	

Inserts	Designation	Grade				Dimensions (mm)						Drawing
		CX22HS	CX32HS	CX31NA	CX41NA	A	B	S	r	d1	t1	
	AXMT 123508PEER-RG	✓	✓	✓		12.18	6.93	3.58	0.8	3.4	-	
	AXMT 170508PEER-RG		✓	✓	✓	17.5	10.2	5.56	0.8	4.6	-	
	AXMT 170516PEER-RG		✓	✓	✓	17.5	10.2	5.56	1.6	4.6	-	

* Limited Supply

Recommended Cutting Conditions

for AXMT 1235

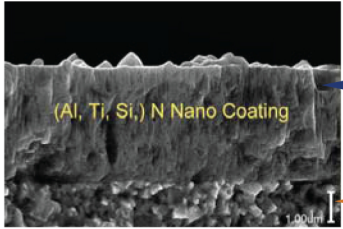
Working Material	VC(speed)		fz (Feed)		ap (Axial DOC)	
	m/min	SFM	FPT mm	FPT in	mm	in
Carbon Steel (HB85-225)	80 ~ 200	260 ~ 660	0.08 ~ 0.20	0.003" ~ 0.008"	~ 7.0	~ .2756"
Stainless 300 Series	50 ~ 110	165 ~ 360	0.05 ~ 0.15	0.002" ~ 0.006"	~ 4.0	~ .1575"
Cast Iron (HB 140-220)	80 ~ 180	260 ~ 590	0.08 ~ 0.20	0.003" ~ 0.008"	~ 6.0	~ .2362"

for AXMT 1705

Working Material	VC(speed)		fz (Feed)		ap (Axial DOC)	
	m/min	SFM	FPT mm	FPT in	mm	in
Carbon Steel (HB85-225)	80 ~ 200	260 ~ 660	0.12 ~ 0.28	0.005" ~ 0.011"	~ 11.0	~ .4331"
Stainless 300 Series	50 ~ 110	165 ~ 360	0.10 ~ 0.22	0.004" ~ 0.009"	~ 7.0	~ .2576"
Cast Iron (HB 140-220)	80 ~ 180	260 ~ 590	.012 ~ 0.28	0.005" ~ 0.011"	~ 10.0	~ .3937"

Coated Carbide

- ✔ New HS Grade for High Speed Milling
- ✔ High adhesion strength to the substrate improves stable cutting performance and achieves longer tool life.
- ✔ Provide excellent heat resistance and oxidation resistance.
- ✔ Maintain highest performance in wet cutting, dry cutting, even hardened material.



Smooth surface prevents chip adhesion.
Multi-layered structure prevents crack expansion which causes chipping and fracture.

Newly development substrate with heat resistance and strength

Grade Type	Substrate (HRA)	Coating Type	Thickness	Coolant		Suitable Condition
				Dry	Wet	
CX22HS	92	Al.Ti.Si.X.N	3~4	★ ★ ★ ★	★ ★ ★ ★ ★ ★	●

- High-performance premium grade with a high level of shock and heat resistance.
- Specially designed to operates at medium to high cutting speeds and is capable of retaining a secure cutting edge at high metal removal condition.
- First choice for cast iron, mold steal, hardened steel and high-temperature alloys

CX32HS	91.6	Ti.Si.X.N	3~4	★ ★ ★ ★	★ ★ ★ ★ ★ ★	●
CX31NA	91.7	Al.Ti.X.N	3~4	★ ★ ★ ★ ★ ★	★ ★ ★ ★	●

- Wide cutting range, both wear resistance and impact resistance are well-balanced at all general machining application.
- Priority grade for semi-finishing or medium cutting.
- Stainless 400 series machining is recommended.

CX41NA	90.2	Al.Ti.X.N	3~4	★ ★ ★ ★ ★ ★	★ ★ ★ ★	●+
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- Priority grade for roughing purpose, this grade incorporates high temperature strength.
- Excellent shock resistance ability, especially during heavy interrupted machining.
- Stainless 300 series machining is recommended.



RG - Negative cutting edge protection. General purpose chip breaker for steels and cast iron.



MG - Positive edge with radius, low cutting force and chatter reduction.