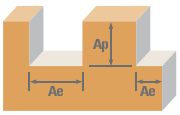

Series 43APR-3 43APR-4 Metric			Ae x D_1	Ap x D_1	Vc (m/min)		Diameter (D_1) (mm) APR-3 20	APR-3 25	APR-4 20	APR-4 25
N	ALUMINIUM ALLOYS 6068, 7075	Slot	1	≤ 1	1600	RPM	25461	20369	25461	20369
					(300-2100)	Fz	0.12	0.12	0.12	0.12
						Feed (mm/min)	9166	7333	12222	9777
		Profile	≤ 0.5	≤ 1.5	1800	RPM	28644	22915	28644	22915
					(300-2100)	Fz	0.15	0.15	0.15	0.15
						Feed (mm/min)	12890	10312	17187	13749
		HSM	≤ 0.1	≤ 2	2100	RPM	33418	26735	33418	26735
					(300-2100)	Fz	0.18	0.18	0.18	0.18
						Feed (mm/min)	18046	14437	24061	19249

For best results use the peak power of the specific machine torque chart.
Typically 10kw is required to remove 1 litre of material (MMR).
Eg. >> (Ae x Ap x Feed) / 1000000 >> Therefore Full slotting Ø25: 25 x 25 x 7333 = 4.58 Litres so it needs a min of 46Kw.
Larger cuts and chip load consume more power.
Review the power chart of each machine to determine MAX power for ultimate performance.
Example below shows peak power @ 10,000 rpm.
The APR-4 design is for ultimate metal removal but typicaly requires more power, and is also better suited to horizontal machines.
The new coolant supply is designed for MQL as well as normal emulsion coolant on the same data.
Ensure max MQL flow prior to cutting.
Refer to the KYOCERA SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com).