



AD MILLING PROGRAM

PROMO PRICING EXPIRES 06.30.2019

The TyCarb AD series of tools offer high performance capabilities for profiling, ramping, slotting, face milling as well as helical interpolation. These tools have a very soft cutting action requiring low horsepower consumption. Combined with our insert selection of 3 geometries and 5 grades these tools offer excellent results in steel, stainless, aluminum, cast iron as well as exotic materials such as Titanium and Inconel.

- Several Radius choices: ADMT-11T3; .016" to .118" / ADMT-1606; .032" to .126"
- Depth of cut: ADMT-11T3; .350" / ADMT-1606; .500"
- 3 Cutting Geometries
- Soft cutting with low horsepower requirements
- End mills available as regular length as well as extended length
- 5 Carbide Grades
- Capable of aggressive ramping as well as helical interpolation
- All tools with Coolant through capabilities

ADMT End Mills using ADMT / ADET Inserts



Designation	Dia.	Shank	O.A.L	Reach	Flutes	*FREE with Insert Purchase Below!
INSERT: ADMT-11T3__ or ADET-11T3__						
AD11EM-0625-3.00E2	.625	.625	3.00	1.09	2	20 Inserts
AD11CY-0625-6.00E2			6.00	2.00		20 Inserts
AD11EM-0750-3.50F2	.750	.750	3.50	1.47	3	20 Inserts
AD11CY-0750-8.00F2			8.00	2.00		30 Inserts
AD11EM-1000-3.50F3	.750	.750	3.50	1.47	3	20 Inserts
AD11EM-1000-4.00H2						1.00
AD11EM-1000-4.00H3	1.00	1.00	4.00	1.72	3	
AD11EM-1000-4.00H4						4
AD11CY-1000-8.00H3	1.25	1.250	8.00	2.25	3	30 Inserts
AD11EM-1250-4.00J4						4.00
AD11EM-1250-4.00J5	1.25	1.250	8.00	2.25	3	30 Inserts
AD11CY-1250-8.00J3						3
AD11EM-1500-4.00J5	1.50	1.250	4.00	1.72	5	30 Inserts
Spare Parts: Torx Screw: TX8P-2505 / Wrench (f/t): W-37046 (s/d): W-36228						*FREE with Insert Purchase Below!
INSERT: ADMT-1606__ or ADET-1606__						
AD16EM-1000-4.00H2	1.00	1.000	4.00	1.72	2	20 Inserts
AD16CY-1000-8.00H2			8.00	2.25		2
AD16EM-1250-4.00J3	1.25	1.250	4.00	1.72	3	30 Inserts
AD16CY-1250-8.00J3			8.00	2.25		3
AD16EM-1500-4.00J4	1.50	1.250	4.00	1.72	4	30 Inserts
AD16CY-1500-8.00J3						8.00
Spare Parts: Torx Screw: TX15P-4008 / Wrench (f/t): W-36552 (s/d): W-36238						

*Free Cutter only valid with inserts shown on following page

ADMT Face Mills using ADMT / ADET Inserts



Designation	Dia.	Bore	Height	Flutes	*FREE with Insert Purchase Below!
INSERT: ADMT-11T3__ or ADET-11T3__					
AD11SM-2000-1.50F5	2.00	.750	1.50	5	30 Inserts
AD11SM-2000-1.50F7				7	30 Inserts
AD11SM-2500-1.75H7	2.50	1.000	1.75	7	30 Inserts
AD11SM-3000-2.00H9					3.00
Spare Parts: Torx Screw: TX8P-2505 / Wrench (f/t): 37046 (s/d): W-36228					*FREE with Insert Purchase Below!
INSERT: ADMT-1606__ or ADET-1606__					
AD16SM-2000-1.50F3	2.00	.750	1.50	3	30 Inserts
AD16SM-2000-1.50F4				4	30 Inserts
AD16SM-2000-1.50F5				5	40 Inserts
AD16SM-2500-1.75H6	2.50	1.000	1.75	6	40 Inserts
AD16SM-3000-2.00H7				3.00	2.00
AD16SM-4000-2.00L8	4.00	1.500	2.00	8	60 Inserts
AD16SM-5000-2.00L9	5.00			9	70 Inserts
AD16SM-6000-2.00L10	6.00			10	80 Inserts
Spare Parts: Torx Screw: TX15P-4011 / Wrench (f/t): W-37052 (s/d): W-36238					

*Free Cutter only valid with inserts shown on following page

P25MC is a Universal CVD coated grade and is the first choice for general steel milling applications. It provides the user with a unique combination of wear resistance, toughness and reliability. P25MC comprises a fine-grained substrate with a thin MT-CVD coating including a unique Al₂O₃ layer. Suitable for machining material group P and conditionally also groups M & S.

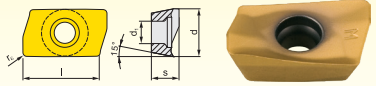
P30MP excels in medium to heavy roughing of steel in the P family of materials. This grade is a sub micron substrate with a PVD applied thin Nano-Structure coating containing a high content of Al. P30MP is a highly versatile grade combining good abrasion resistance, toughness and reliability. Suitable for materials in the P, M & K groups.

P40MP is our toughest grade designed for applications with severe shock and/or heavy interruptions. The substrate is a sub-micron carbide with a high cobalt content. The coating is a Nano structure thin coating with a high Al content and applied by the PVD process. Suitable for machining material groups P, M, S & K. Can be used with or without coolant.

M40MC is our first choice grade for Stainless Steel milling applications. M40MC is a MT-CVD coated grade suitable for low cutting speeds and unstable conditions such as vibrations and/or interrupted cuts. The MT-CVD coating is comprised of a TiCN layer as well as a unique outer Al₂O₃ layer. Suitable for machining in the M, S and conditionally also P material groups. Can be used with or without coolant.

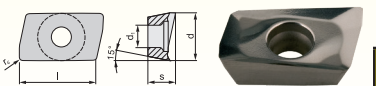
TK10M is the first choice for machining applications in the material group N which consists of Aluminum, low and/or high silicon content as well as automatic brass and other types of soft brass and bronze. Also suitable for plastics and nylon materials. TK10M is an uncoated sub-micron grade with a low cobalt content.

ADMT



Designation	l	d	s	d ¹	r	PRICE	P25MC	P30MP	P40MP	M40MC	TK10M
ADMT-11T304-TRM					.016	\$10.95	●	●			
ADMT-11T308-TRM	.433	.257	.156	.114	.032		●	●	●	●	
ADMT-11T316-TRM					.063		●				
ADMT-11T330-TRM					.118		●				
ADMT-11T308-TRR	.433	.257	.156	.114	.032	\$13.95	●	●			
ADMT-160608-TRM					.032		●	●	●	●	
ADMT-160616-TRM	.630	.392	.246	.177	.063		●				
ADMT-160632-TRM					.126		●				
ADMT-160608-TRR	.630	.392	.246	.177	.032	●					

ADET



Designation	l	d	s	d ¹	r	PRICE	P25MC	P30MP	P40MP	M40MC	TK10M
ADET-11T304-AL					.016	\$13.95					●
ADET-11T308-AL	.433	.257	.156	.114	.032						●
ADET-11T316-AL					.063						●
ADET-160608-AL	.630	.392	.246	.177	.032						●

Work Material	Hardness	P25MC		P30MP		P40MP		M40MC		TK10M			
		SFM	Feed	SFM	Feed	SFM	Feed	SFM	Feed	SFM	Feed		
P	Steel, Unalloyed low carbon	850 - 1115	.004 - .012	740 - 1000	.004 - .012	650 - 880	.004 - .012	825 - 1050	.004 - .012				
	Steel, Low to Medium Alloy 160 - 255 Hbn	730 - 960	.004 - .012	635 - 790	.004 - .012	560 - 700	.004 - .012	700 - 950	.004 - .012				
	Steel, Alloy and Tool Steels 200 - 340 Hbn	545 - 720	.004 - .010	420 - 660	.004 - .010	370 - 580	.004 - .010	530 - 670	.004 - .010				
	High Tensile steels 240 - 375 Hbn	375 - 490	.004 - .010	325 - 420	.004 - .010	285 - 370	.004 - .010	360 - 460	.004 - .010				
M	Austenitic (304, 304L, 316, 316L)	650 - 770	.004 - .012	485 - 600	.004 - .012	425 - 530	.004 - .012	500 - 620	.004 - .012				
	Duplex (323, 329, F55, 2205)	590 - 700	.004 - .012	440 - 540	.004 - .012	390 - 475	.004 - .012	460 - 560	.004 - .012				
	Super Austenitic (310 Modified)	530 - 630	.004 - .010	400 - 485	.004 - .010	350 - 425	.004 - .010	415 - 505	.004 - .010				
	Stainless, PH Series (17-4, 630)	425 - 500	.004 - .010	320 - 390	.004 - .010	280 - 690	.004 - .010	330 - 400	.004 - .010				
K	Grey Cast Iron			560 - 950	.004 - .012	500 - 800	.004 - .012						
		Ferritic/Pearl											
		Pearlitic			460 - 720	.004 - .012	410 - 650	.004 - .012					
	Nodular Cast Iron			490 - 790	.004 - .012	440 - 710	.004 - .012						
		Ferritic			260 - 590	.004 - .012	230 - 530	.004 - .012					
		Pearlitic											
S	High Temp	G 200 HB	140 - 200	.003 - .008			105 - 150	.004 - .011	110 - 160	.004 - .011			
	Alloy FE	AG 280 HB	100 - 160	.003 - .008			75 - 125	.004 - .011	80 - 130	.004 - .011			
	Ni / Co	GO 320 HB	65 - 140	.003 - .008			45 - 140	.004 - .010	50 - 150	.004 - .010			
	Titanium Alloys		130 - 280	.003 - .008			95 - 190	.004 - .011	100 - 230	.004 - .011			
H	Hardened Steel 41 HRC - 50 HRC				160 - 320	.003 - .008							
	Hardened Steel 51 HRC - 55 HRC				125 - 180	.003 - .008							
	Hardened Steel 55 HRC +												
Work Material	Condition	Hardness										TK10M	
												SFM	Feed
N	Wrought	Non AG	60 HB								660 - 2400	.003 - .014	
		AG	100 HB								350 - 1250	.003 - .014	
	Cast Aluminum Alloys	AG Si < 12%	90 HB								350 - 1250	.003 - .014	
		Si > 12%	130 HB								250 - 1050	.003 - .014	

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