

HELI-MILL Technical Guide for Tool Modifications, Metric

To prevent collisions and guarantee optimal operation with large-radius inserts, verify that the cutter complies with the following modification requirements prior to use:

Insert Type	Insert Corner Radius RE, mm	Tool Body Rounding Radius r_c , mm
APC/K.. 1003..	2.4	$0.8^{+0.2}$
	3.1	$2.5^{+0.2}$
	4.0	$4.0^{+0.2}$
ADC/K.. 1505..	3.2	$1.5^{+0.2}$
	4.0	$2.5^{+0.2}$
	5.0	$3.5^{+0.2}$
	6.0	$4.3^{+0.2}$
	6.4	$5.0^{+0.2}$
APKT 1604..	1.6	$1.2^{+0.2}$
	2.4	$2.0^{+0.2}$
	3.2	$2.7^{+0.2}$
	4.8	$5.5^{+0.2}$
	6.4	$6.3^{+0.2}$