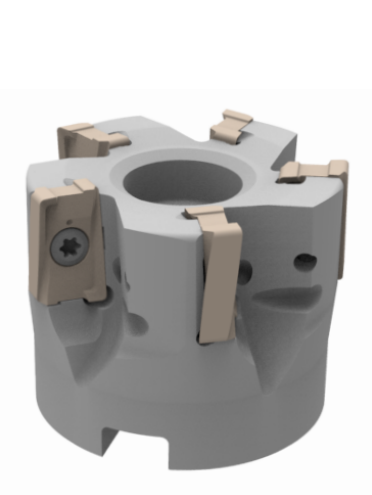
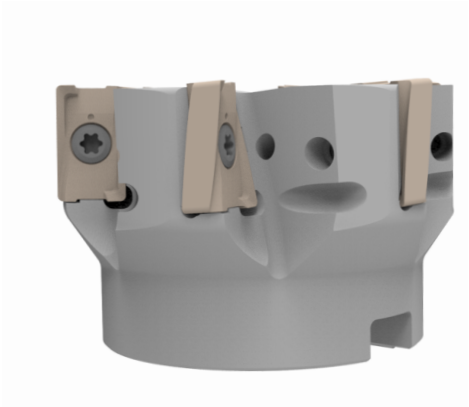
LAMINA TECHNOLOGIES

NEW PRODUCT RELEASE

PIONEERS OF MULTI-MAT™



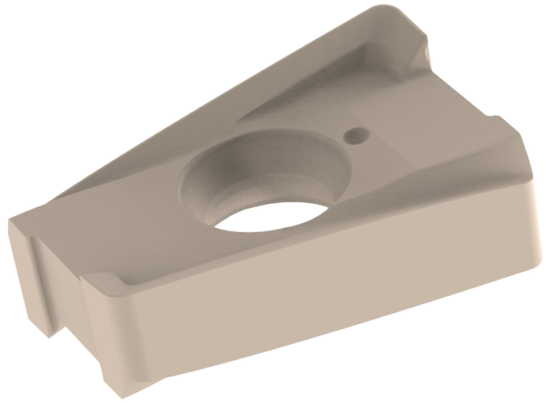


NEW SHOULDER MILLING INSERT – 4 CUTTING EDGES

NEW SHOULDER MILLING INSERT

4 CUTTING EDGES

LT 3130 LT 3000



ADVANTAGES

- 4 Cutting edges – Economic shoulder milling
- True and precise 90° – No mismatches after multiple passes
- Wiper flat – Optimized for better surface finishing

PRODUCT OVERVIEW

- Available in MAGIA and MAGIA PRO
- Available from diameter 25mm to 125mm
- Replaces 2-cutting edge inserts (e.g. APKT 10... APKT 16...)
- Not recommended for Helical Interpolation or Ramping Down

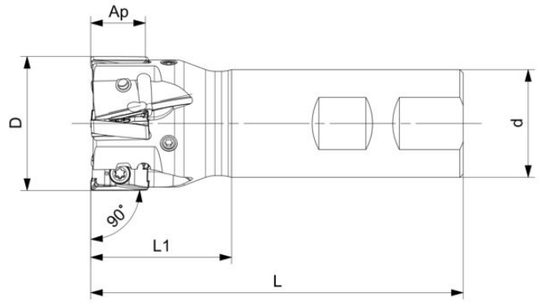
MAGIA PRO

DESIGNATION	GRADE	RADIUS (mm)	CUTTING EDGES	CUTTER LINE	MATERIAL RECOM-MENDATION	CATALOG #
ANKX 170608 PNTR	LT 3130	0.80	4	LT 787		M0004025

MAGIA

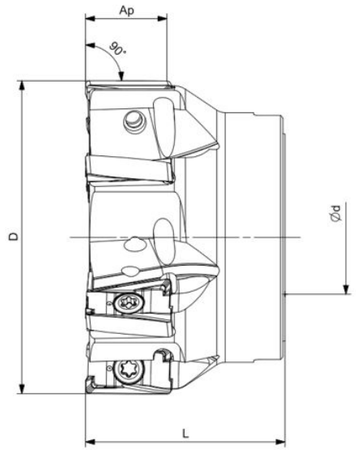
DESIGNATION	GRADE	RADIUS (mm)	CUTTING EDGES	CUTTER LINE	MATERIAL RECOM-MENDATION	CATALOG #
ANKX 170608 PNTR	LT 3000	0.80	4	LT 787		M0004467

PRODUCT RANGE



END MILL – ANKX 170608 PNTR

DESIGNATION	D	d	L	L1	Ap	Z	CATALOG #
LT 787 W-D-D025/2	25	25	44	100	12	2	M2001787
LT 787 W-W-D032/3	32	32	50	110	12	3	M2001789
LT 787 W-W-D040/4	40	32	50	115	12	4	M2001792



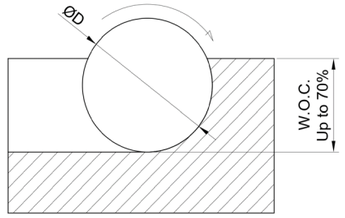
SHELL MILL – ANKX 170608 PNTR

DESIGNATION	D	d	L	Ap	Z	CATALOG #
LT 787 M-W-D040/4	40	16	40	12	4	M2001790
LT 787 M-W-D050/5	50	22	40	12	5	M2001793
LT 787 M-W-D063/6	63	22	40	12	6	M2001794
LT 787 M-W-D080/7	80	27	50	12	7	M2001795
LT 787 M-W-D0100/8	100	32	50	12	8	M2003825
LT 787 M-W-D0125/9	125	40	63	12	9	M2003826
LT 787 M-D-D160/10 *	160	40	63	12	10	M2003827

* ON REQUEST
Key: M2000602 Screw: M2000597

CUTTING PARAMETERS

Side Milling up to 70%
ANKX 170608 PNTR



	Material Group	Lamina Gr. N°	VDI	Material Examples	Hardness	Suggested Starting Parameters D.O.C (Ap) [mm]	Suggested Starting Parameters Feed rate [mm/z]	Maximum Values D.O.C (Ap) [mm]	Maximum Values MAX. Feed Rate [mm/z]	Maximum Values MAX. D.O.C (Ap) [mm]	Maximum Values Feed Rate [mm/z]
P	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	4.00	0.23	4.00	0.28	6.00	0.17
			2		190 HB						
			3		250 HB						
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	4.00	0.20	4.00	0.24	6.00	0.15
			4,6		230 HB						
			5,7		280 HB		0.18		0.22		0.13
			8		350 HB						
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	3.00	0.18	3.00	0.22	5.00	0.12
					280 HB						
			11		320 HB		0.16		0.19	4.50	
					350 HB						
M	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	4.00	0.20	4.00	0.24	6.00	0.15
					240 HB						
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	3.00	0.16	3.00	0.19	4.50	0.12
					310 HB						
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4PH, 430	200 HB	4.00	0.20	4.00	0.24	6.00	0.15
			13		42 HRc	3.00	0.16	3.00	0.19	4.50	0.12
K	Grey	7	15	GG20, GG40, EN-GJL-250, N030B	150 HB	4.00	0.23	4.00	0.28	6.00	0.17
					200 HB						
			16		250 HB						
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	4.00	0.20	4.00	0.24	6.00	0.15
					200 HB						
			18,20		250 HB						
S	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	3.00	0.16	3.00	0.19	4.50	0.12
			33	Inconel 700	250 HB						
			34	Stellite 21	350 HB						
	Ti based	10	36	TiAl6V4	-	3.00	0.18	3.00	0.22	4.50	0.12
			37	T40	-		0.16		0.19		
H	Steel	11	38	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	2.00	0.14	2.00	0.17	2.50	0.12
					50 HRc	1.50	0.13	1.50	0.16	1.80	
					55 HRc	1.00	0.12	1.00	0.14	1.20	
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	1.50	0.14	1.50	0.17	2.00	0.12
	White Cast Iron		41	G-X300CrMo15	55 HRc	1.00	0.12	1.00	0.14	1.20	0.12
NF	Al (>8%Si)	12	25	AlSi12	130 HB	4.00	0.25	4.00	0.30	6.00	0.30

For slot milling: Reduce the feed rate to 60%.
Max feed rate after chip thickness compensation = 0.8mm/tooth.
Not recommended for Ramping Down or Helical Interpolation.
Minimum recommended feed rate for side milling (Width of Cut up to 70%) = 0.12mm/tooth.
Cutting parameters recommended for stable part clamping and short tool/cutter overhang.
Must be reduced in case of vibrations.

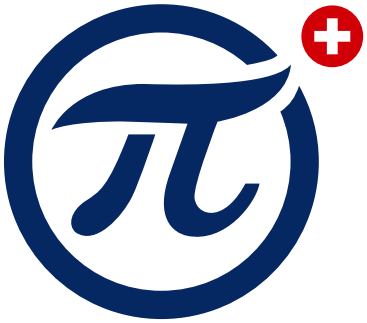
LAMINA TECHNOLOGIES

Lamina Technologies is a Swiss manufacturer of carbide cutting tools specializing in milling and turning inserts made of state-of-the-art sub-micron grades and coatings by our team of specialists in our factory in Switzerland.

With the Multi-Mat™ concept, Lamina Technologies provides products that machine multiple materials with the same insert, thus allowing you to increase flexibility as well as reduce stock of unused and redundant cutting tools, allowing you to reduce the cost of production and increase production efficiency.

- Simplify your process
- Decrease your tooling costs
- Minimize your machining down time
- Increase your production efficiency

Lamina continues its fast pace worldwide expansion and is currently represented in over 32 countries.



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TECHNOLOGIES

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