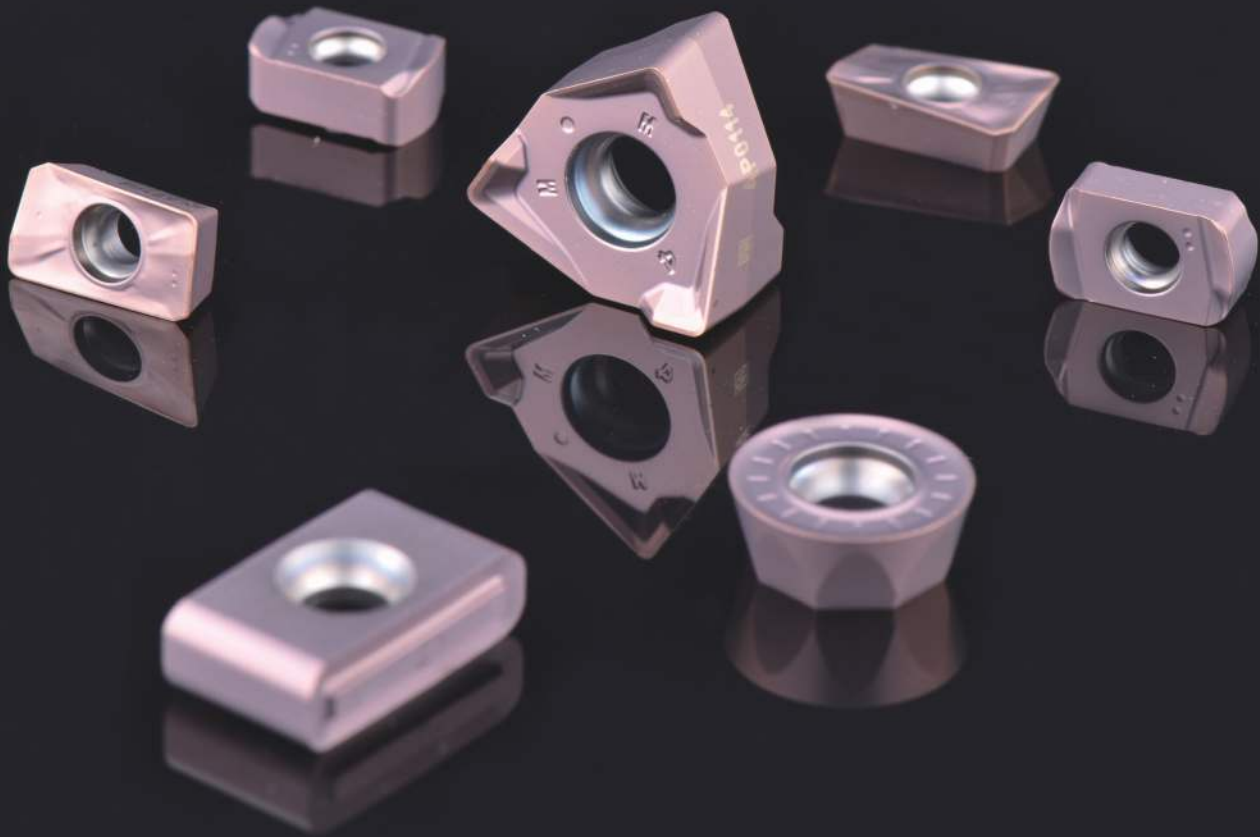


**NEW  
PRODUCT!**

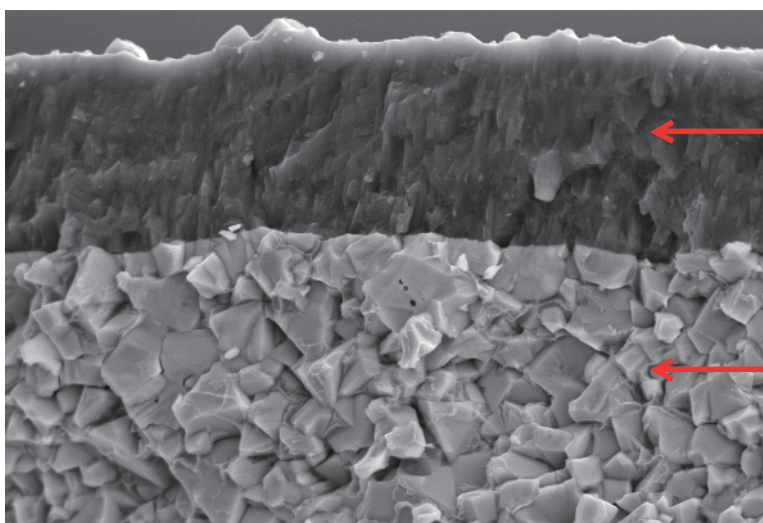
**AP151H grade**

**For Hardened steel**



## • AP151H Grade introduction

ACHTECK has newly launched Milling PVD coating grade of AP151H With submicron cemented carbide substrate and Nano superhard coating, it has high hardness, excellent wear resistance, high resistance of crack propagation and oxidation resistance ability, provides good machinability for processing hardened steel.



← Nano level high hardness structure coating

← High wear resistant substrate


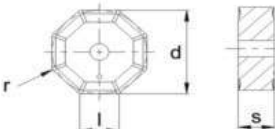

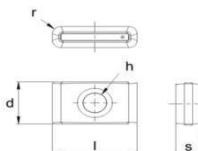

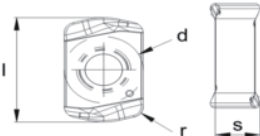

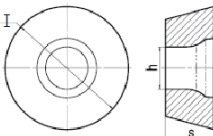


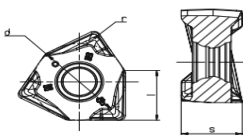

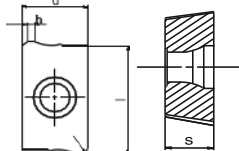

## • AP151H grade features

- The coating has high hardness, excellent wear resistance and crack propagation resistance.
- The coating has high red hardness and outstanding oxidation resistance.
- Smooth coating surface reduces cutting force.
- Submicron level cemented carbide grains, excellent wear resistance.

## • AP151H application

AP151H	ISO grade	Application range										Vc		
												m/min		
		5	10	15	20	25	30	35	40	45	50	Vcmin	Vcmax	
H	H10-H20		AP151H										30	80
K	K10-K20		AP151H										100	300

## • AP151H products stocks

Inserts	Model	Dimensions					Grade	Geometry
		l (mm)	d (mm)	s (mm)	r (mm)	h (mm)		
	ONHF 050408-MM3 AP151H	5.3	12.7	4.8	0.8	—	●	
	LNHQ 150416FN-W AP151H	15.87	9.52	4.76	1.6	4.2	●	
	LNHQ 120408FN-W AP151H	12.7	9.52	4.76	0.8	4.2	●	
	LNMX 060410R-MM4N AP151H	10	6.35	3.6	1.0	—	●	
	RPMT 1204MOE AP151H	12	—	4.76	—	—	●	
	RPMW 10T3MOE-HR2 AP151H	10	—	3.18	—	—	●	
	RPMW 1003MOE-HR2 AP151H	10	—	3.97	—	—	●	
	WNGU 080608R-MM4 AP151H	7	12.5	7.88	0.8	—	●	
	APMT 1135PDER AP151H	11.31	6.26	3.5	0.8	1.25	●	
	APMT 1604PDER AP151H	17.32	9.37	5.17	0.8	1.54	●	

注: ● Stands for regular stock  
○ Stands for order based production

## • AP151H Case study

Workpiece Name: forging forged die

Materials: 5CrNiMo

Workpiece hardness: HRC52

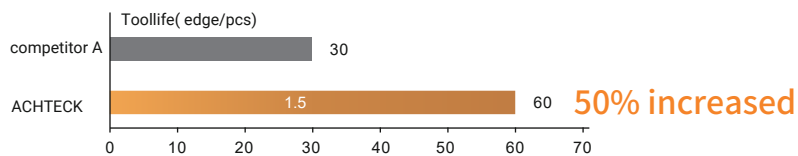
Inserts: LNMX 060410R-MM4N AP151H

Cutter: AHM20-016-Z02-M08R-LN06-C

Machining process name: Cavity milling

Cutting parameters:  $V_c=100\text{m/min}$ ,  $a_p=0.3\text{mm}$ ,  $f_z=0.4$

Cutting mode: air cooling



Results comprision: ACHTECK solution is 50% increased in toollife than current tool