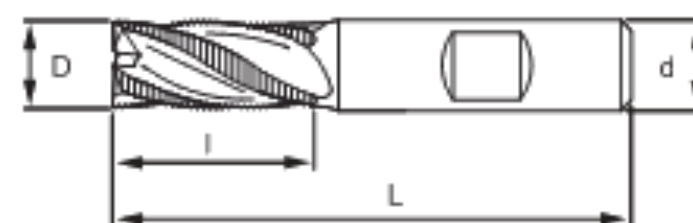




ALU

ITEM: A4520

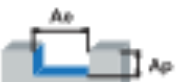
**Material** Micro-grain carbide  
**Standard** Factory standard  
**Tolerance** -0.020 / -0.070 mm  
**Shank** Weldon  
**Helix** 30° right-hand  
**Surface treatment** Bright  
**Application** Roughing and side milling on aluminum alloy up to 7% silicon content.



|       |       |        |       |       |        |       |       |          |          |                 |         |     |      |      |      |
|-------|-------|--------|-------|-------|--------|-------|-------|----------|----------|-----------------|---------|-----|------|------|------|
| < 500 | < 850 | < 1200 | < 600 | < 850 | Duplex | < 240 | < 300 | < 10% Si | > 10% Si | Brass<br>Copper | Ti6Al4V | HTA | < 45 | < 60 | < 65 |
|       |       |        |       |       |        |       |       | ●        | ●        |                 | ○       |     |      |      |      |

FACTORY STANDARD

| A4520    | Tech. Code |  | D<br>mm | L<br>mm | I<br>mm | d<br>mm | Z |   |
|----------|------------|--|---------|---------|---------|---------|---|---|
| 3T - 30° | A45206     |  | 6       | 57      | 13      | 6       | 3 | 1 |
|          | A45208     |  | 8       | 63      | 16      | 8       |   |   |
|          | A452010    |  | 10      | 72      | 22      | 10      |   |   |
|          | A452012    |  | 12      | 83      | 26      | 12      |   |   |
|          | A452016    |  | 16      | 92      | 32      | 16      |   |   |
|          | A452020    |  | 20      | 104     | 38      | 20      |   |   |

|             |              | Side Milling                                                                        |         | Slotting                                                                            | RANGE                |                      |       |           |           |            |            |            |            |
|-------------|--------------|-------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|----------------------|----------------------|-------|-----------|-----------|------------|------------|------------|------------|
|             |              |  |         |  | A4520                |                      |       |           |           |            |            |            |            |
| Material    | Feature      | Ap                                                                                  | Ae      | Ap                                                                                  | Vc<br>m/min.<br>min. | Vc<br>m/min.<br>max. | mm    | D/mm<br>6 | D/mm<br>8 | D/mm<br>10 | D/mm<br>12 | D/mm<br>16 | D/mm<br>20 |
| NON FERROUS | ALU < 10% Si | 1.5 x D                                                                             | 0.5 x D | 1 x D                                                                               | 250                  | 1000                 | fz/mm | 0.054     | 0.069     | 0.085      | 0.100      | 0.130      | 0.160      |
|             | ALU > 10% Si | 1.5 x D                                                                             | 0.5 x D | 1 x D                                                                               | 150                  | 350                  | fz/mm | 0.045     | 0.058     | 0.071      | 0.083      | 0.096      | 0.135      |

Recommended "fz" values for side milling.  
 For slotting, adjust the cutting parameters. (ex: fz x 0.8)