

KERFOLG ROUGHING END MILLS FOR ALUMINUM ALLOYS Z3

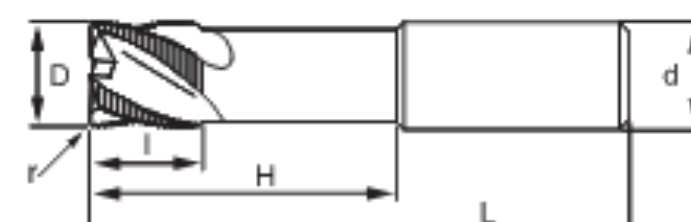
Alufly



ALU

ITEM: A4525

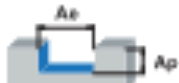
Material Micro-grain carbide
Standard Factory standard
Tolerance h6
Shank Cylindrical / Weldon
Helix 40° right-hand
Surface treatment Bright
Application Very high performing rougher for slot and side milling on aluminum alloy up to 7% silicon content.



< 500	< 850	< 1200	< 600	< 850	Duplex	< 240	< 300	< 10% Si	> 10% Si	Brass Copper	Ti6Al4V	HTA	< 45	< 60	< 65
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On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4525....) Weldon shank (A4525...W)

FACTORY STANDARD										
A4525	Tech. Code		D mm	L mm	l mm	d mm	H mm	r mm	Z	
3T - 40°	A452506		6	57	9	6	18	0.25	3	1
	A452508		8	63	12	8	23			
	A452510		10	72		10	29	0.50		
	A452512		12	83		12	35			
	A452516		16	92	14	16				
	A452520		20	104	17	20	59			

		Side Milling		Slotting	RANGE								
				A4525									
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20
NON FERROUS	ALU < 10% Si	1 x D	0.5 x D	1 x D	250	1000	fz/mm	0.070	0.120	0.150	0.170	0.200	0.220
	ALU < 10% Si	1 x D	0.5 x D	1 x D	200	350	fz/mm	0.060	0.100	0.130	0.150	0.180	0.200

Recommended "fz" values for slotting.
 For side milling, adjust the cutting parameters. (ex: fz x 1.5)