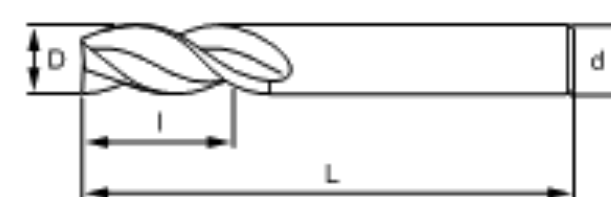
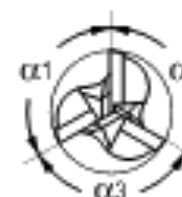



ALU
ITEM: A4612

Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix 45° right-hand
 Variable pitch
Surface treatment Lapped face
Application Slotting and side milling on aluminum alloys and plastic materials.



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

On request available with Weldon shank at a cost of € 2.

Cylindrical shank (A4612....) Weldon shank (A4612....W)

FACTORY STANDARD

A4612	Tech. Code	D mm	L mm	l mm	d mm	Z	
3T - 45°	A461203	3	57	10	6	3	1
	A461204	4		13			
	A461205	5		15			
	A461206	6		18			
	A461208	8	63	20	8		
	A461210	10	72	25	10		
	A461212	12	83	30	12		
	A461216	16	92	35	16		
	A461220	20	104	45	20		

		Side Milling		Slotting	RANGE								
				A4612									
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 3	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16
NON FERROUS	ALU <10% Si	1.25 x D	0.1 x D	0.5 x D	250	800	fz/mm	0.016	0.027	0.040	0.048	0.080	0.095
	ALU >10% Si	1.25 x D	0.1 x D	0.5 x D	150	300	fz/mm	0.016	0.027	0.040	0.048	0.080	0.095

Recommended "fz" values for side milling.

For slotting, adjust the cutting parameters. (ex: fz x 0.75)