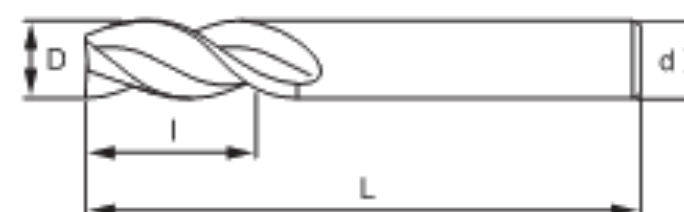


ALU

ITEM: A4615

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 ~20mm - ~ 0.025mm
Shank Cylindrical / Weldon
Helix 45° right-hand
Surface treatment Bright
Application Slotting and side milling on aluminum alloys and plastic materials.



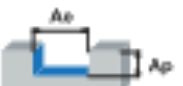
< 500	< 850	< 1200	< 600	< 850	Duplex	< 240	< 300	< 10% Si	> 10% Si	Brass Copper	Ti6Al4V	HTA	< 45	< 60	< 65
								●	●		○				

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

Cylindrical shank (A4615....) Weldon shank (A4615...W)

FACTORY STANDARD

A4615	Tech. Code		D mm	L mm	l mm	d mm	Z	
3T - 45°	A46152		2	50	3	6	3	1
	A46153		3		6			
	A46154		4		8			
	A46155		5	11				
	A46156		6	13	8			
	A46158		8					
	A461510		10			10		
	A461512		12	75	22	12		
	A461516		16	83	26	16		

		Side Milling		Slotting	RANGE								
				A4615									
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	1.5 x D	0.5 x D	1 x D	250	1000	fz/mm	0.027	0.054	0.072	0.090	0.110	0.145
	ALU > 10% Si	1.5 x D	0.5 x D	1 x D	150	350	fz/mm	0.022	0.043	0.058	0.072	0.086	0.115

Recommended "fz" values for slotting.

For side milling, adjust the cutting parameters. (ex: fz x 0.8)