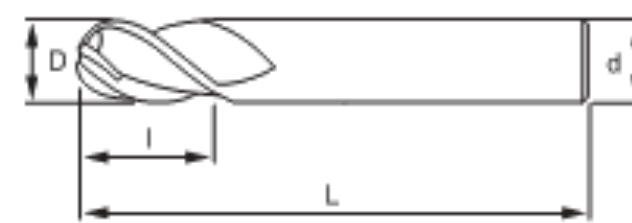




ALU

ITEM: A4620

Material Micro-grain carbide
Standard Factory standard
Tolerance e8
Shank Cylindrical / Weldon
Helix 40° right-hand variable pitch
Surface treatment Bright
Application Finishing and semi-finishing on aluminum alloys up to 12% silicon content.



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

Cylindrical shank (A4620....) Weldon shank (A4620...W)

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

FACTORY STANDARD

A4620	Tech. Code		D mm	L mm	l mm	d mm	Z	
3T - 40° - VARIABLE	A46203		3	38	12	3	3	1
	A46204		4	51	15	4		
	A46205		5	64	20	5		
	A46206		6			6		
	A46208		8			8		
	A462010		10	70	25	10		
	A462012		12	76		12		
	A462016		16	89	35	16		

		Profiling		Slotting	RANGE								
					A4620								
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	0.1 x D	0.1 x D	0.25 x D	250	1000	fz/mm	0.030	0.060	0.080	0.095	0.110	0.165
	ALU > 10% Si	0.1 x D	0.1 x D	0.25 x D	150	350	fz/mm	0.030	0.060	0.080	0.095	0.110	0.165

Recommended "fz" values for profiling.

For slotting, adjust the cutting parameters. (ex: fz x 0.6)