

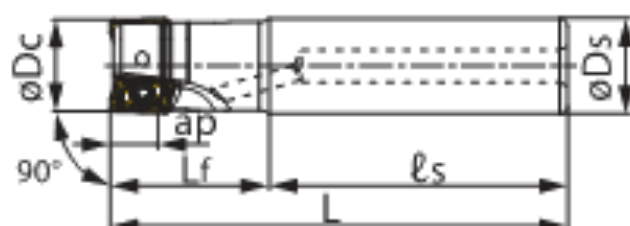
TUNGSTOOL SINGLE SIDE SQUARE SHOULDERING END MILLS

TUNG-ALUMILL

ITEM: B4F57

End mills for square shouldering on aluminum

Coupling type Cylindrical shank
Insert type XVCT1605...
Application Square shouldering on aluminum
Rake angle A.R. = +6° ~ +10°, R.R. = +12° ~ -9°

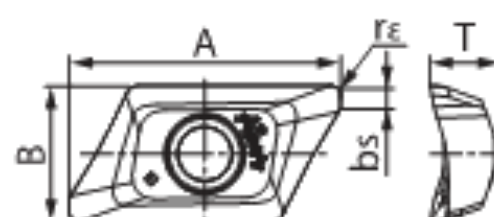


	Tech. Code	Denomination	Z	Dc mm	Ds mm	L mm	Lf mm	Air hole
Cylindrical	B4F5725Z2	EPV16R025M25.0-02	2	25	25	125	55	With
	B4F5725Z2L	EPV16R025M25.0-02L				170	70	
	B4F5732Z2	EPV16R032M32.0-02		32	32	150	50	
	B4F5732Z2L	EPV16R032M32.0-02L				200	80	
	B4F5732Z3	EPV16R032M32.0-03	3			150	50	

TUNGSTOOL GEOMETRY AND CUTTING CONDITIONS - TUNG-ALUMILL

TUNG-ALUMILL

AJ type
 fe = 0.4mm A=22.2mm B=11.2mm T=5.9mm bs=1.3mm
 fe = 0.8mm A=22.2mm B=11.2mm T=5.9mm bs=1mm
 fe = 1.2mm A=21.7mm B=11.2mm T=5.8mm bs=1mm
 fe = 2.0mm A=20.8mm B=11.2mm T=5.75mm bs=1mm
 fe = 3.0mm A=19.5mm B=11.2mm T=5.6mm bs=1mm
 fe = 4.0mm A=18.4mm B=11.2mm T=5.5mm bs=1.2mm



						P			M		K		N	S	H	
			Description	Grade	Tech. Code		<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MEDIUM CUTTING	AJ		XVCT 160504R-AJ	TH10	B4X05XVAJ01									●		
		XVCT 160508R-AJ	B4X05XVAJ02								●					
		XVCT 160512R-AJ	B4X05XVAJ03								●					
		XVCT 160520R-AJ	B4X05XVAJ05								●					
		XVCT 160530R-AJ	B4X05XVAJ06								●					
		XVCT 160540R-AJ	B4X05XVAJ08									●				

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnell HB	Recommended grades	Cutting speed Speed (m/min.)	Feed fz/mm
Non ferrous alloys with Si ≤ 13%	75	TH10	200 ~ 1000	0.15 ~ 0.3
	90	TH10	200 ~ 1500	0.1 ~ 0.25
Non ferrous alloys with Si ≥ 13%	130	TH10	200 ~ 1000	0.07 ~ 0.15

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA211	EPV16R025M...	Clamping insert screw	TS40085I/HG
BRICA212	EPV16R032M...		TS40093I/HG