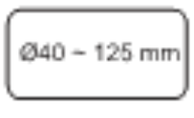
SQUARE SHOULDERING SHELL MILLS

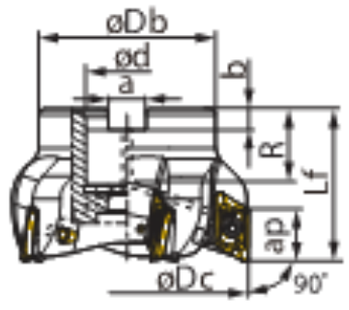
TUNG-ALUMILL

ITEM: B4F58

Shell mills for square shouldering on aluminum

Coupling type	Bore
Insert type	XVCT1605...
Application	Square shouldering on aluminum
Rake angle	A.R. = +10° ~ +11°, R.R = -9° ~ 5,5°



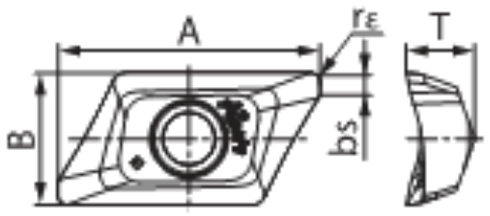
	Tech. Code		Denomination	Z	Dc mm	d mm	Lf mm	Air hole
Bore	B4F5840Z3		TPV16R040M16.0E03	3	40	16	50	With
	B4F5850Z4		TPV16R050M22.0E04	4	50	22		
	B4F5863Z5		TPV16R063M22.0E05	5	63			
	B4F5880Z5		TPV16R080M27.0E05		80	27		

GEOMETRY AND CUTTING CONDITIONS - TUNG-ALUMILL

TUNG-ALUMILL

AJ type

rε = 0,4mm	A=22,2mm	B=11,2mm	T=5,9mm	bs=1,3mm
rε = 0,8mm	A=22,2mm	B=11,2mm	T=5,9mm	bs=1mm
rε = 1,2mm	A=21,7mm	B=11,2mm	T=5,8mm	bs=1mm
rε = 2,0mm	A=20,8mm	B=11,2mm	T=5,75mm	bs=1mm
rε = 3,0mm	A=19,5mm	B=11,2mm	T=5,6mm	bs=1mm
rε = 4,0mm	A=18,4mm	B=11,2mm	T=5,5mm	bs=1,2mm



			Description	Grade	Tech. Code		P <500 N/mm²	P <850 N/mm²	P <1200 N/mm²	M <600 N/mm²	M <850 N/mm²	K <240 HB	K <300 HB	N Alu	S HTA	H <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

Indivisible package Suggested retail package - Unit price