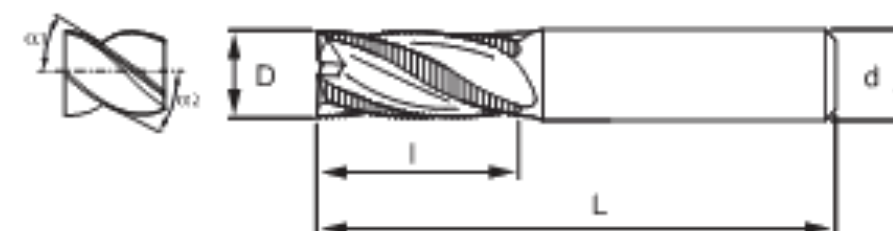




ITEM: A4516

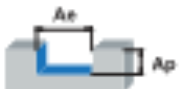
Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix Variable 28° - 31° right-hand
Surface treatment WIND +
Application High performance roughing and semi finishing on carbon steels, stainless steels and nickel alloys

On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4516....) Weldon shank (A4516...W)



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

FACTORY STANDARD								
A4516	Tech. Code		D mm	L mm	l mm	d mm	Z	
MULTI-VARIABLE	A451606		6	57	13	6	4	1
	A451608		8	63	19	8		
	A451610		10	72	22	10		
	A451612		12	83	26	12		
	A451616		16	92	32	16	6	
	A451620		20	104	38	20		

		Side Milling		Slotting	RANGE								
					A4516								
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20
CARBON STEEL	< 500 N/mm²	1.5 x D	0.3 x D	1 x D	140	175	fz/mm	0.020	0.025	0.030	0.040	0.050	0.065
	< 850 N/mm²	1.5 x D	0.3 x D	1 x D	120	145	fz/mm	0.015	0.020	0.025	0.030	0.040	0.050
STAINLESS STEEL	< 600 N/mm²	1.5 x D	0.3 x D	1 x D	75	100	fz/mm	0.031	0.034	0.045	0.050	0.052	0.055
	< 800 N/mm²	1.5 x D	0.3 x D	1 x D	60	75	fz/mm	0.020	0.030	0.040	0.045	0.050	0.052
	DUPLEX	1.5 x D	0.3 x D	0.5 x D	40	70	fz/mm	0.030	0.035	0.040	0.050	0.070	0.080
SUPER ALLOY	Ti6Al4V	1.5 x D	0.3 x D	0.3 x D	30	55	fz/mm	0.030	0.035	0.040	0.050	0.070	0.080
	HTA	1.5 x D	0.3 x D	0.3 x D	25	35	fz/mm	0.015	0.020	0.025	0.030	0.040	0.050

Recommended "fz" values for side milling.
 For slotting, adjust the cutting parameters. (ex: fz x 0.8)