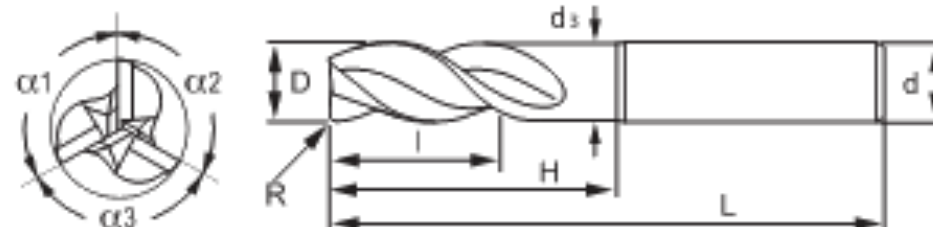


ALU

ITEM: A4616

Material Micro-grain carbide
Standard Factory standard
Tolerance e8
Shank Cylindrical / Weldon
Helix 45° right-hand variable pitch
Surface treatment Bright
Application Slotting, pocketing on aluminum alloys, superior performances for steep wall finishing.



< 500	< 890	< 1200	< 600	< 890	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 (A4616....) Weldon shank (A4616...W)

FACTORY STANDARD

A4616	Tech. Code		D mm	R mm	L mm	d3 mm	l mm	H mm	d mm	Z	
3T - 45° - VARIABLE	A4616302		3	0.2	55	2.8	4.5	12	3	3	1
	A4616305			0.5							
	A4616402		4	0.2	58	3.8	6	15	4		
	A4616405			0.5							
	A4616502		5	0.2	63	4.8	7.5	18	5		
	A4616505			0.5							
	A4616602		6	0.2	76	5.8	9	24	6		
	A4616605			0.5							
	A4616610			1.0							
	A4616615			1.5							
	A4616802		8	0.2	89	7.7	12	30	8		
	A4616805			0.5							
	A4616810			1.0							
	A4616815			1.5							
	A4616820		10	2.0	100	9.7	15	36	10		
	A46161002			0.2							
	A46161005			0.5							
	A46161010			1.0							
	A46161015			1.5							
	A46161020		12	2.0	110	11.6	18	48	12		
	A46161202			0.2							
	A46161205			0.5							
	A46161210			1.0							
	A46161215			1.5							
	A46161220		16	2.0	110	15.5	24	16			
	A46161602			0.2							
	A46161610			1.0							
	A46161620			2.0							

		Side Milling		Slotting	RANGE								
				A4616									
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)