

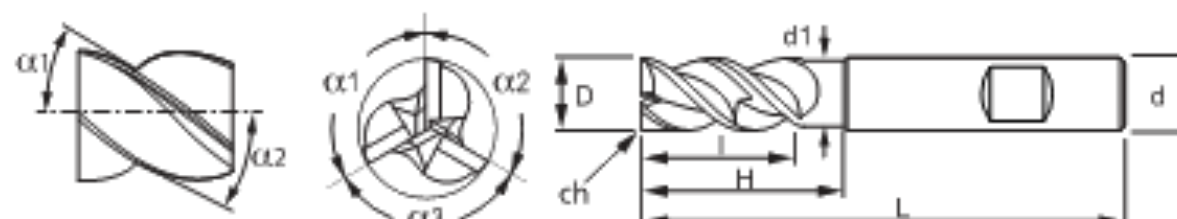


ALU

ITEM: A4625

Material Micro-grain carbide
Standard Factory standard
Tolerance f8
Shank Cylindrical / Weldon
Helix Right hand variable angle and variable pitch

Surface treatment WIND Z
Application Slotting and side milling on aluminum alloys.
 Superior performances in finishing and tool life.



< 500	< 850	< 1200	< 600	< 850	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 (A4625....) Weldon shank (A4625...W)

FACTORY STANDARD											
A4625	Tech. Code		D mm	L mm	H mm	d1 mm	l mm	ch 45° mm	d mm	Z	
3T - VARIABLE	A462503		3	57	12	2,70	8	0,10	6	3	1
	A462504		4		18	3,70	11				
	A462505		5			4,70	13				
	A462506		6			5,70					
	A462508		8	63	25	7,40	21	0,20	8		
	A462510		10	72	30	9,20	22		10		
	A462512		12	83	36	11	26		12		
	A462516		16	92	42	15	36		16		
	A462520		20	104	52	19	41		20		

		Side Milling		Slotting	RANGE									
					A4625									
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	D/mm 20
NON FERROUS	ALU <10% Si	1 x D	0.5 x D	1 x D	250	800	fz/mm	0.025	0.06	0.07	0.08	0.09	0.12	0.062
	ALU > 10% Si	1 x D	0.5 x D	1 x D	150	300	fz/mm	0.025	0.06	0.07	0.08	0.09	0.12	0.048

Recommended "fz" values for slotting.

For side milling, adjust the cutting parameters. (ex: fz x 0.8)