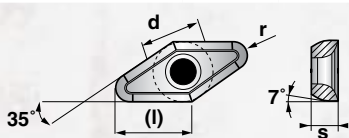


## Indexable Milling Program Tools for Aluminum Alloys

### Indexable Milling Program Tools for Aluminum Alloys Contents

<b>ASMC</b>	Shell Milling Cutters With Side Clearance	31	
<b>ASMN</b>	Shell Milling Cutter With No Side Clearance	31	
<b>AEMC</b>	End Milling Cutter With Side Clearance	31	
<b>AEMN</b>	End Milling Cutter With No Side Clearance	31	

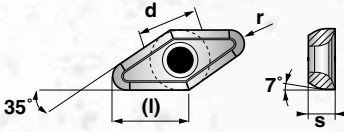


### Insert Data

Tool Ordering Number	Dimensions				
	l	s	d	r	Screw
VCGT-110308	11	3.18	2.8	0.8	AIS-1
VCGT-160412	16.6	4.76	4.4	1.2	AIS-2
VCGT-220530	22	5.56	5.5	3	AIS-3

### Shank

Measurement System	Denotes Cutter for Non-Ferrous Metals & Plastics	EMC = End Milling Shank Cutter	Denotes Diameter Size		Denotes Tool Cutter Length		Denotes Tool Diameter Shank	Clearance
Inch	<b>A</b>	<b>EMC</b>	<b>42</b>	-	<b>220</b>	-	<b>25</b>	<b>93°</b>
Shank	<b>A</b>	<b>EMN</b>	<b>42</b>	-	<b>220</b>	-	<b>25</b>	<b>90°</b>



### Insert Data

Tool Ordering Number	Dimensions				
	l	s	d	r	Screw
VCGT-110308	11	3.18	2.8	0.8	AIS-1
VCGT-160412	16.6	4.76	4.4	1.2	AIS-2
VCGT-220530	22	5.56	5.5	3	AIS-3

### Cutting Conditions: Recommended Cutting Speed

Alloy Group	Rm (Mpa)	Roughing					Finishing				
		Speed Vc(m/min)		Feed Fz(mm/tooth)		D.O.C. Ap(m/min)	Speed Vc(m/min)		Feed Fz(mm/tooth)		D.O.C. Ap(m/min)
		Min	Max	Min	Max	Max	Min	Max	Min	Max	Max
AL Alloy	<280	600	2000	0,2	0,4	10	600	2000	0,15	0,2	10
Al-Cu	300-460	400	2000	0,25	0,3	10	400	2500	0,15	0,25	10
Al-Mg-Si	200-400	400	2000			10	400	2500			10
Al-Zn	400-600	400	2000	0,25	0,35	10	400	3000	0,15	0,25	10
Al-Si <12%Si	350-380	200	800	0,2	0,25	10	200	1000	0,15	0,2	10
Copper alloy		400	500		0,2	10	400	500		0,2	10
Mg. alloys		400	450		0,2	10	400	450		0,2	10
Thermoplastics		300	350		0,15	10	300	350		0,15	10
Duro-plastics		180	200		0,15	10	180	200		0,15	10