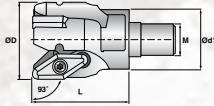
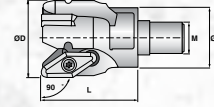
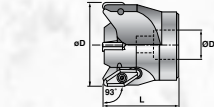
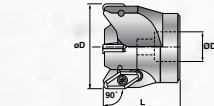
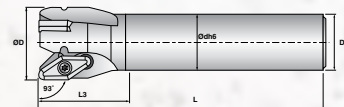
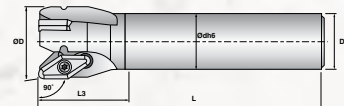
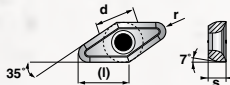


Indexable Milling Program Tools for Aluminum Alloys

Indexable Milling Program Tools for Aluminum Alloys Contents

ASOC	Modular Screw-on Heads With Side Clearance	85	
ASON	Modular Screw-on Heads With No Side Clearance	85	
ASMC	Shell Milling Cutters With Side Clearance	85	
ASMN	Shell Milling Cutter With No Side Clearance	86	
AEMC	End Milling Cutter With Side Clearance	86	
AEMN	End Milling Cutter With No Side Clearance	86	
Insert Data		87	
Cutting Conditions		87	

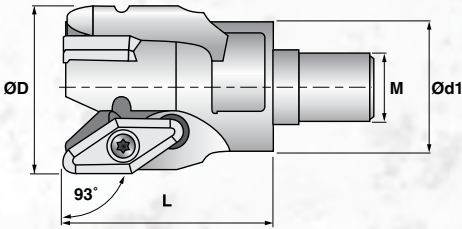
Milling Cutters Identification System

Modular

Measurement System	Denotes Cutter for Non-Ferrous Metals & Plastics	SOC = Screw-On Cutter with Side Clearance SON = Screw-on Cutter with no Side Clearance SMC = Shell Milling Cutter with Side Clearance SMN = Shell Milling Cutter with no Side Clearance	Denotes Diameter Size	/	Denotes Number of Flutes
Metric	A	SOC	32	/	3

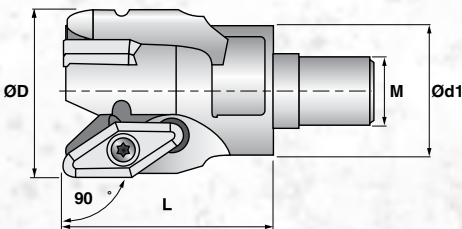
Shank

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
Metric	A	EMC	42	-	220	-	25
Metric	A	EMN	42	-	220	-	25



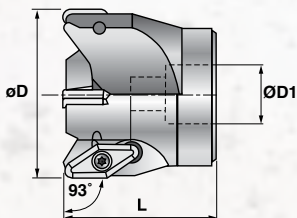
ASOC Modular Screw-On Heads

Tool Ordering Number	Dimensions (mm)					Use with			RPM Max
	ØD	L	Ød1	M	Z	Screw	Key	Inserts	
ASOC-25/3	25	50	21	M12	3	AIS-1	T7	VCGT-110308	30000
ASOC-32/3	32	50	29	M16	3	AIS-2	T15	VCGT-160412	28000
ASOC-42/3	42	50	29	M16	3	AI-3	T20	VCGT-220530	24000



ASON Modular Screw-On Heads

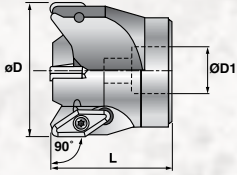
Tool Ordering Number	Dimensions (mm)					Use with			RPM Max
	ØD	L	Ød1	M	Z	Screw	Key	Inserts	
ASON-25/2	25	35	18	M10	2	AIS-1	T7	VCGT-110308	30000
ASON-25/3	25	50	21	M12	3	AIS-1	T7	VCGT-110308	30000
ASON-32/3	32	50	29	M16	3	AIS-2	T15	VCGT-160412	24000
ASON-42/3	42	50	29	M16	3	AIS-3	T20	VCGT-220530	24000



ASMC Shell Milling Cutters

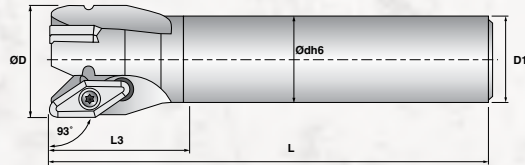
Tool Ordering Number	Dimensions (mm)					Use with			RPM Max
	ØD	L	ØD1	Key Width	Z	Screw	Key	Inserts	
ASMC-50/3	50	55	22	10,4	3	AIS-2	T15	VCGT-160412	23000
ASMC-63/4	63	60	22	10,4	4	AIS-2	T15	VCGT-160412	20000
ASMC-80/4	80	60	27	12,4	4	AIS-3	T20	VCGT-220530	18000

Indexable Milling Program Tools for Aluminum Alloys



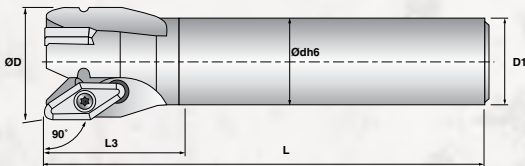
ASMN Shell Milling Cutters

Tool Ordering Number	Dimensions (mm)						Use with			RPM Max
	ØD	L	ØD1	Key Width	L2	Z	Screw	Key	Inserts	
ASMN-42/3	42	55	16	8,4	15	3	AIS-3	T20	VCGT-220530	24000
ASMN-50/3	50	55	22	10,4	13	3	AIS-2	T15	VCGT-160412	23000
ASMN-52/3	52	55	22	10,4	15	3	AIS-3	T20	VCGT-220530	22000
ASMN-63/4	63	60	22	10,4	13	4	AIS-2	T15	VCGT-160412	20000
ASMN-66/4	66	60	27	10,4	15	4	AIS-3	T20	VCGT-220530	19000
ASMN-80/5	80	60	27	12,4	15	5	AIS-3	T20	VCGT-220530	18000
ASMN-100/5	100	65	32	14,4	15	5	AIS-3	T20	VCGT-220530	16000



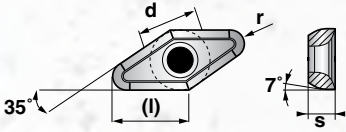
AEMC End Milling Cutters

Tool Ordering Number	Dimensions (mm)						Use with			RPM Max
	ØD	L	L1	D1	L3	Z	Screw	Key	Inserts	
AEMC-25/3	25	140	10	20	40	3	AIS-1	T7	VCGT-110308	30000
AEMC-32/3	32	140	13,5	25	50	3	AIS-2	T15	VCGT-160412	28000
AEMC-42/3	42	140	15	32	50	3	AIS-3	T20	VCGT-220530	24000



AEMN End Milling Cutters

Tool Ordering Number	Dimensions (mm)						Use with			RPM Max
	ØD	L	L1	D1	L3	Z	Screw	Key	Inserts	
AEMN-20/2-L100	20	100	10	18	30	2	AIS-1	T7	VCGT-110308	30000
AEMN-20/2-L200	20	200	10	18	30	2	AIS-1	T7	VCGT-110308	26000
AEMN-25/3-L140	25	140	10	20	40	3	AIS-1	T7	VCGT-110308	30000
AEMN-25/3-L240	25	240	10	20	40	3	AIS-1	T7	VCGT-110308	26000
AEMN-32/3-L140	32	140	13	25	50	3	AIS-2	T15	VCGT-160412	28000
AEMN-32/3-L240	32	240	13	25	50	3	AIS-2	T15	VCGT-160412	24000
AEMN-42/3-L140	42	140	15	32	50	3	AIS-3	T20	VCGT-220530	24000
AEMN-42/3-L240	42	240	15	32	50	3	AIS-3	T20	VCGT-220530	20000



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