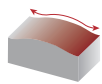


AL-INTEG

Aluminium Specialized Endmills



Copying



AL-INTEG



SINCE 1916

HC38AS 3 Corner chamfer aluminium specialized endmills

N



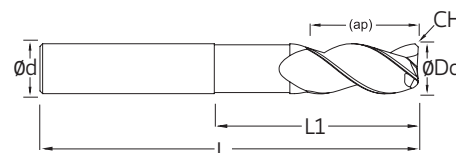
Short


Variable Pitch
3


38°


Reduced
Neck Ø


Corner Chamfer



		⁽²⁾ Grade code		12	Dimensions Dimensões Dimensiones (mm)					
⁽¹⁾ Order code		Reference Referência Referencia		PH0920						
HA (Cylindrical)	HB (Weldon)				ØDc	Ød (h6)	ap _{max}	CH	L1	L
1180401	1180410	HC38AS 3 030 07	3		3	6	7	0,15 x 45°	15	57
1180402	1180411	HC38AS 3 040 08	3		4	6	8	0,15 x 45°	17	57
1180403	1180412	HC38AS 3 050 10	3		5	6	10	0,15 x 45°	19	57
1180404	1180413	HC38AS 3 060 10	3		6	6	10	0,15 x 45°	21	57
1180405	1180414	HC38AS 3 080 16	3		8	8	16	0,15 x 45°	27	63
1180406	1180415	HC38AS 3 100 19	3		10	10	19	0,20 x 45°	32	72
1180407	1180416	HC38AS 3 120 22	3		12	12	22	0,20 x 45°	38	83
1180408	1180417	HC38AS 3 160 26	3		16	16	26	0,35 x 45°	44	92
1180409	1180418	HC38AS 3 200 32	3		20	20	32	0,35 x 45°	54	104

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

Endmill order code = (1) Geometry Code + (2) Grade Code

Note: For HB (Weldon) endmills, the reference ends with "-W"

Example: "HC38AS 3 030 07-W PH0920"

CUTTING CONDITIONS || Condições de corte | Condiciones de corte

ISO	Material	f _z (mm/t)			V _c (m/min)		
		a _e = 25%	a _e = 50%	a _e = 100%	a _e = 25%	a _e = 50%	a _e = 100%
N	Aluminium <6%Si	0,011 x ØDc	0,009 x ØDc	0,006 x ØDc	230	220	190
	Aluminium <12%Si	0,009 x ØDc	0,008 x ØDc	0,005 x ØDc	210	200	180
	Aluminium >12%Si	0,008 x ØDc	0,007 x ØDc	0,005 x ØDc	200	190	170

Note¹: Recommended feed values for maximum a_p. For reduced a_p, consider increasing f_z up to 25%.

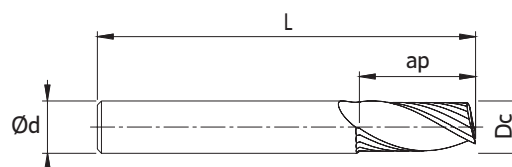
Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.


PDF

HF30AS Single edge aluminium endmills



N



(1) Geometry code	(2) Grade code		12	Dimensions Dimensões Dimensiones (mm)			
	Reference Referência Referencia			ØDc	Ød (h6)	ap _{max}	L
1180751	HF30AS 1 020 05	1	PH0920	2	6	5	57
1180752	HF30AS 1 030 08	1	PH0920	3	6	8	57
1180753	HF30AS 1 040 11	1	PH0920	4	6	11	57
1180754	HF30AS 1 050 13	1	PH0920	5	6	13	57
1180755	HF30AS 1 060 13	1	PH0920	6	6	13	57
1180756	HF30AS 1 080 19	1	PH0920	8	8	19	63
1180757	HF30AS 1 100 25	1	PH0920	10	10	22	72
1180758	HF30AS 1 120 26	1	PH0920	12	12	26	83

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Endmill order code = (1) Geometry Code + (2) Grade Code

CUTTING CONDITIONS || Condições de corte | Condiciones de corte

ISO	Material	f _z (mm/t)			V _c (m/min)		
		a _e = 25%	a _e = 50%	a _e = 100%	a _e = 25%	a _e = 50%	a _e = 100%
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	Aluminium >12%Si	0,008 x ØDc	0,007 x ØDc	0,005 x ØDc	200	190	170

Note¹: Recommended feed values for maximum ap. For reduced ap, consider increasing f_z up to 25%.

Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



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