

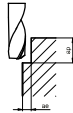
119

Z1 Aluminium
Endmill

S	Order No	Code	d1e8	d2h6	l1	l2	Corner
*	56100	119.1.0300.0500.C0010.0120.0000.0000.00.S04A1Y01.01	3	4	50	12	Ch 0.10
*	56102	119.1.0400.0500.C0010.0150.0000.0000.00.S04A1Y01.01	4	4	50	15	Ch 0.10
*	56104	119.1.0500.0580.C0010.0160.0000.0000.00.S06A1Y01.01	5	6	58	16	Ch 0.10
*	56106	119.1.0600.0580.C0010.0190.0000.0000.00.S06A1Y01.01	6	6	58	19	Ch 0.10
	56108	119.1.0700.0640.C0010.0190.0000.0000.00.S08A1Y01.01	7	8	64	19	Ch 0.10
*	56110	119.1.0800.0640.C0010.0220.0000.0000.00.S08A1Y01.01	8	8	64	22	Ch 0.10
	56112	119.1.0900.0730.C0010.0230.0000.0000.00.S10A1Y01.01	9	10	73	23	Ch 0.10
*	56114	119.1.1000.0730.C0010.0230.0000.0000.00.S10A1Y01.01	10	10	73	23	Ch 0.10
	56116	119.1.1100.0820.C0010.0250.0000.0000.00.S12A1Y01.01	11	12	82	25	Ch 0.10
*	56118	119.1.1200.0820.C0010.0250.0000.0000.00.S12A1Y01.01	12	12	82	25	Ch 0.10

Cutting Parameters

Material	Shoulder Milling ae=0,4xØ ap=1xØ Vc (m/min)
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Non Ferrous
MaterialAluminum Based
Alloys

250-450

Feed Per Tooth (mm/tooth)

Ø	ae=1xØ ap=1xØ	ae=0,4xØ ap=1xØ	ae=0,1xØ ap=1xØ
2	0,016-0,018	0,024-0,026	0,018-0,022
3	0,024-0,026	0,032-0,036	0,027-0,033
4	0,032-0,034	0,042-0,048	0,036-0,044
5	0,04-0,043	0,056-0,06	0,036-0,044
6	0,048-0,051	0,066-0,072	0,054-0,066
8	0,06-0,07	0,09-0,1	0,07-0,09
10	0,08-0,09	0,11-0,12	0,09-0,11
12	0,09-0,1	0,125-0,14	0,11-0,13



Steel	○
Stainless Steel	○
Hardened Steel ≤54 HRC	○
Hardened Steel >54 HRC	○
Cast Iron	○
Graphite	○
Non Ferrous Material	●
HRSA	○
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended