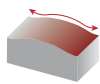


AL-INTEG

Aluminium Specialized Endmills



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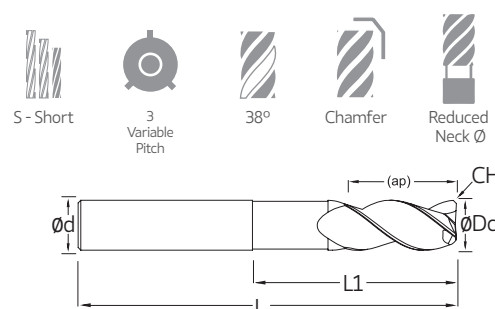
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Integral Solid Carbide Solutions



SINCE 1916

HC38AS Corner chamfer aluminium specialized endmills



		(2) Grade code		T1	Dimensions Dimensões Dimensiones (mm)					
(1) Geometry code		Reference Referência Referencia		PH0920						
HA (Cylindrical)	HB (Weldon)				ØDc	Ød (h6)	ap max	CH	L	L1
1180401	1180410	HC38AS 3 030 07	3		3	6	7	0,15 x 45°	57	15
1180402	1180411	HC38AS 3 040 08	3		4	6	8	0,15 x 45°	57	17
1180403	1180412	HC38AS 3 050 10	3		5	6	10	0,15 x 45°	57	19
1180404	1180413	HC38AS 3 060 10	3		6	6	10	0,15 x 45°	57	21
1180405	1180414	HC38AS 3 080 16	3		8	8	16	0,15 x 45°	63	27
1180406	1180415	HC38AS 3 100 19	3		10	10	19	0,20 x 45°	72	32
1180407	1180416	HC38AS 3 120 22	3		12	12	22	0,20 x 45°	83	38
1180408	1180417	HC38AS 3 160 26	3		16	16	26	0,35 x 45°	92	44
1180409	1180418	HC38AS 3 200 32	3		20	20	32	0,60 x 45°	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

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

Example: "HC38AS 3 030 07-W"

CUTTING CONDITIONS || Condições de corte | Condiciones de corte

ISO	Material	fz (mm/t)			Vc (m/min)		
		ae = 25%	ae = 50%	ae = 100%	ae = 25%	ae = 50%	ae = 100%
N	Alluminium <6%Si	0,011 x ØDc	0,009 x ØDc	0,006 x ØDc	230	220	190
	Alluminium <12%Si	0,009 x ØDc	0,008 x ØDc	0,005 x ØDc	210	200	180
	Alluminium >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 Fz 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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