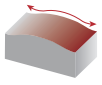


# AL-INTEG

## Aluminium Specialized Endmills



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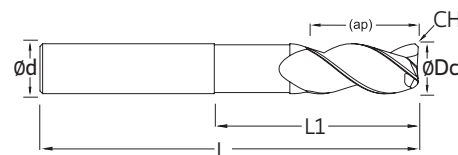
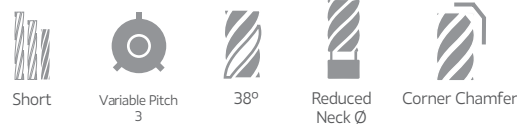
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## HC38AS 3 Corner chamfer aluminium specialized endmills

N



<sup>(1)</sup> Order code		<sup>(2)</sup> Grade code		12	Dimensions   Dimensões   Dimensiones (mm)					
HA (Cylindrical)	HB (Weldon)	Reference Referência Referencia		PH0920	ØDc	Ød (h6)	ap <sub>max</sub>	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	0,60 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 <sub>z</sub> (mm/t)			V <sub>c</sub> (m/min)		
		a <sub>e</sub> = 25%	a <sub>e</sub> = 50%	a <sub>e</sub> = 100%	a <sub>e</sub> = 25%	a <sub>e</sub> = 50%	a <sub>e</sub> = 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

Note<sup>1</sup>: Recommended feed values for maximum a<sub>p</sub>. For reduced a<sub>p</sub>, consider increasing f<sub>z</sub> up to 25%.  
Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.

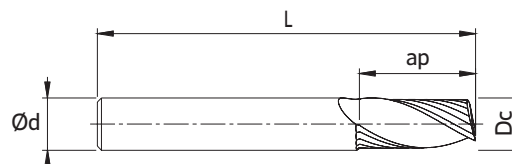




## HF30AS Single edge aluminium endmills



N



(1) Geometry code	(2) Grade code		12 PH0920	Dimensions   Dimensões   Dimensiones (mm)			
	Reference Referência Referencia			ØDc	Ød (h6)	ap <sub>max</sub>	L
1180751	HF30AS 1 020 05	1		2	6	5	57
1180752	HF30AS 1 030 08	1		3	6	8	57
1180753	HF30AS 1 040 11	1		4	6	11	57
1180754	HF30AS 1 050 13	1		5	6	13	57
1180755	HF30AS 1 060 13	1		6	6	13	57
1180756	HF30AS 1 080 19	1		8	8	19	63
1180757	HF30AS 1 100 25	1		10	10	22	72
1180758	HF30AS 1 120 26	1		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 <sub>z</sub> (mm/t)			V <sub>c</sub> (m/min)		
		a <sub>e</sub> = 25%	a <sub>e</sub> = 50%	a <sub>e</sub> = 100%	a <sub>e</sub> = 25%	a <sub>e</sub> = 50%	a <sub>e</sub> = 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

Note<sup>1</sup>: Recommended feed values for maximum ap. For reduced ap, consider increasing f<sub>z</sub> up to 25%.

Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



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