F607ZX

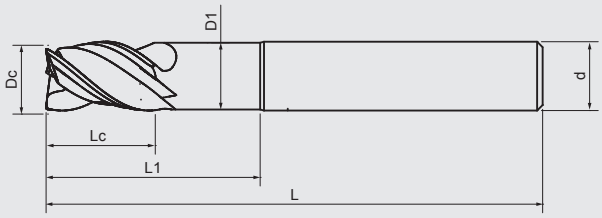
Toric End Mills For Aluminium

Designed with three variable helix geometry and three unequal flutes.

Designed with sharp cutting edge, high removal cutting geometry, and fine grinding smooth surface to prevent sticking problem.

Cutting edge with corner radius for profile machining.

Adopting ZrN coating without AlTi in the formula would prevent from chemical affinity with Alu metal and enhance tool life by gaining better surface hardness.



Suitable for cutting aluminium.

Application for HPC/ roughing cutting process with high chip removal rate as well as for HSC/ finishing cutting process with fine and smooth surface finishing.

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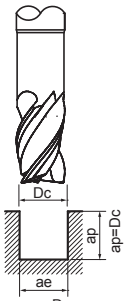
DIN 6527 Standard Length

Dc $^{0}_{-0.02}$	Lc mm	L mm	d h5	L1 mm	D1 mm	F607ZX ZrN
3	4.5	57	6	9	2.8	●
4	6	57	6	12	3.7	●
5	7.5	57	6	15	4.6	●
6	9	57	6	20	5.5	●
8	12	63	8	26	7.4	●
10	15	72	10	31	9.2	●
12	18	83	12	37	11	●
16	24	92	16	43	14.5	●
20	30	104	20	53	18.2	●

Cutting Conditions

F607ZX		 ae=Dc		 ae=0.4xDc		 ae=0.1xDc		 ae=0.02xDc	
		cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)
Aluminium Steel Materials									
N	GRI0-1 Wrought Aluminium alloys	400	0.005xDc	400	0.006xDc	400	0.007xDc	400	0.008xDc
	GRI0-2 Aluminium cast alloys <10%	400	0.005xDc	400	0.006xDc	400	0.007xDc	400	0.008xDc
	GRI0-3 Aluminium cast alloys >10%	350	0.005xDc	380	0.006xDc	380	0.007xDc	380	0.008xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location
1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.