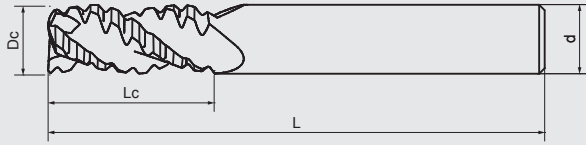


F642ZX / F643ZX

Roughing End Mills For Aluminium

Coarse tooth staggered chip breaker design on cutting flutes are good for easily chip breaking.
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.

VHM
CarbideZrN
ZX0.3-0.5
45°

Aluminium



Suitable for cutting aluminium.
Application for roughing cutting with high chip removal rate.

N

N

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	F642ZX ZrN					
3	8	57	6	●					
4	11	57	6	●					
5	13	57	6	●					
6	13	57	6	●					
8	19	63	8	●					
10	22	72	10	●					
12	26	83	12	●					
16	32	92	16	●					
20	38	104	20	●					

Long Length

Dc 0 -0.02	Lc mm	L mm	d h5	F643ZX ZrN					
6	19	63	6	●					
8	28	72	8	●					
10	34	84	10	●					
12	40	97	12	●					
16	48	108	16	●					
20	56	122	20	●					

Cutting Conditions

F642ZX F643ZX					
	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	0.008xDc	400	0.009xDc
	GRI0-2 Aluminium cast alloys <10%	400	0.008xDc	400	0.009xDc
	GRI0-3 Aluminium cast alloys >10%	350	0.008xDc	380	0.009xDc

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.