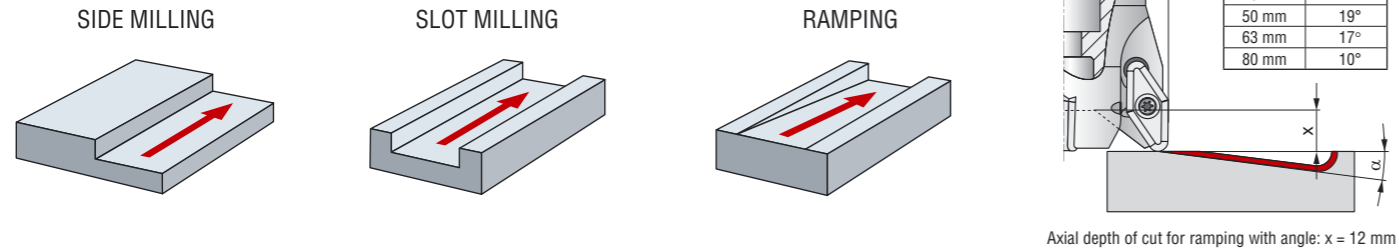


SAFETY AND THE PROTECTION OF HEALTH:

- Keep relevant rules of safety for HSC (for example setting of the tool na machines with protective shield only).
- In case you use higher rotation speed than recommended maximum the tools must be additionally balanced for relevant rotation speed.
- Indexable cutting inserts must be clamped in tool by torque screwdriver (screwdriver MR-5,0; torque = 5 Nm).

TECHNOLOGICAL POSSIBILITIES:



RECOMMENDATIONS:

General:

- Maximum rotation speed use with respect to possibilities of used arbor.

Modular tool

- Modular tools use with the lowest No. of parts and the shortest overhang.
- For G6,3 do not use modular tool with short overhang at rotation speed higher than 8000 RPM without additional balancing.

Shell milling cutter

- For G6,3 do not use shell milling cutter at rotation speed higher than 12.000 RPM without additional balancing.

End milling cutters

- The shortest overhang is recommended.
- Use the balanced arbor only (for example hydraulic, min. G2,5 for 15.000 RPM).



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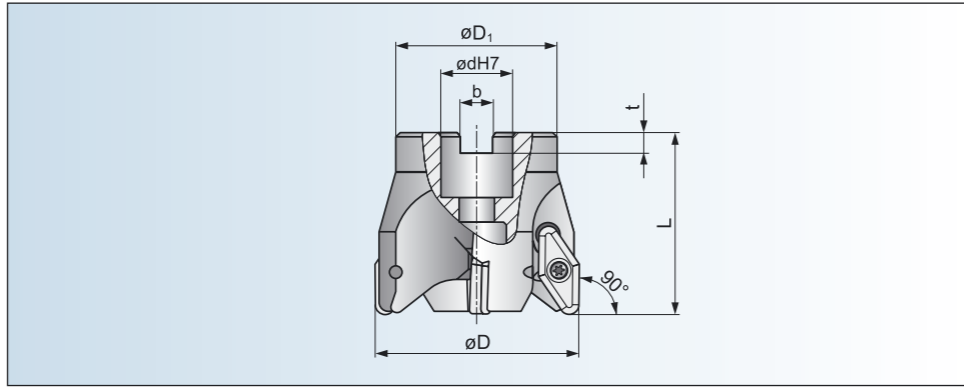
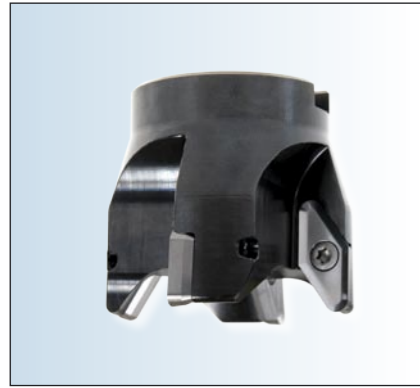
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S90VC22C

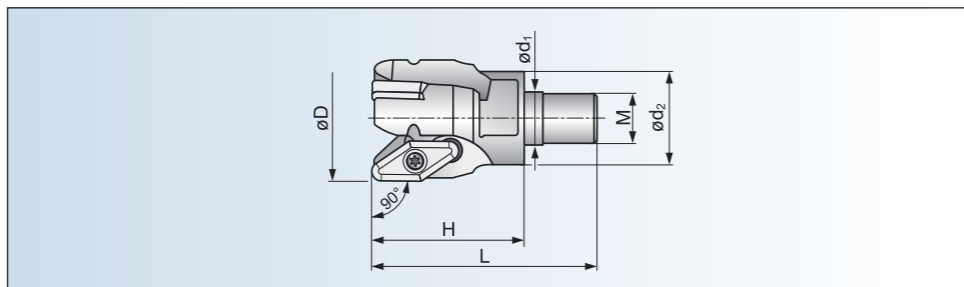
Shell milling cutters



ISO	Assortment	Dimensions						Cooling	[kg]	No. of inserts	Spare parts			Torque [Nm]
		D	dH7	D ₁	L	b	t				Torque handle	Shank	Screw	
50A03R-S90VC22C	●	50	22	40	56	10,4	6,3	+	0,37	3				5,0
63A04R-S90VC22C	●	63	22	50	56	10,4	6,3	+	0,65	4	MR-5,0	D-T20	US 4511-T20	
80A05R-S90VC22C	●	80	27	63	56	12,4	7,0	+	1,10	5				

SVC22C

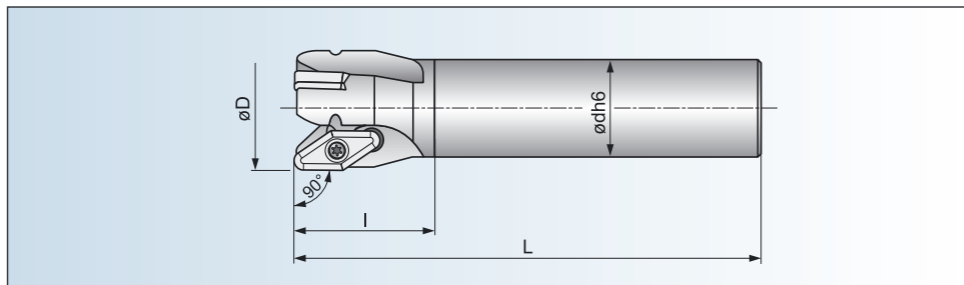
Modular milling cutters



ISO	Assortment	Dimensions						Cooling	[kg]	No. of inserts	Spare parts			Torque [Nm]
		D	d ₁	d ₂	M	L	H				Torque handle	Shank	Screw	
32A2R048M16-SVC22C	●	32	17	29	M16	71	48	+	0,20	2				5,0
40A3R048M16-SVC22C	●	40	17	29	M16	71	48	+	0,24	3	MR-5,0	D-T20	US 4511-T20	

SVC22C

End milling cutters



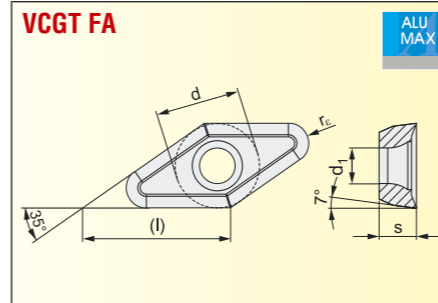
ISO	Assortment	Dimensions				Cooling	[kg]	No. of inserts	Spare parts			Torque [Nm]
		D	dh6	L	I				Torque handle	Shank	Screw	
32A2R045A25-SVC22C	●	32	25	150	45	+	0,41	2				5,0
40A3R045A32-SVC22C	●	40	32	150	45	+	0,84	3	MR-5,0	D-T20	US 4511-T20	

● Stock assortment ○ Non-stock assortment

All dimensions in [mm]

Indexable cutting inserts

VCGT FA



Indexable cutting insert	(l)	d	s	d ₁	r _c
VCGT 220530F-FA	22,0	12,700	5,50	5,20	3,0

ISO	ANSI	Grade	Radius	Feed per tooth		Depth of cut	
				f _{min}	f _{max}	a _{p min}	a _{p max}
VCGT 220530F-FA	VCGT 4(3.5)XF-FA	●	3,0	0,05	0,27	0,5	16,0

● Stock assortment ○ Non-stock assortment

All dimensions in [mm]

Technical information

BALANCING QUALITY:

Maximum rotation speed of tool for each index of balancing quality G.

Instructions:

You find the maximum rotation speed on horizontal axis. The value is given by relation of unbalancing [g.mm] and weight [kg] (vertical axis) for relevant index of balancing quality (colour straight line).

CUTTING CONDITIONS:

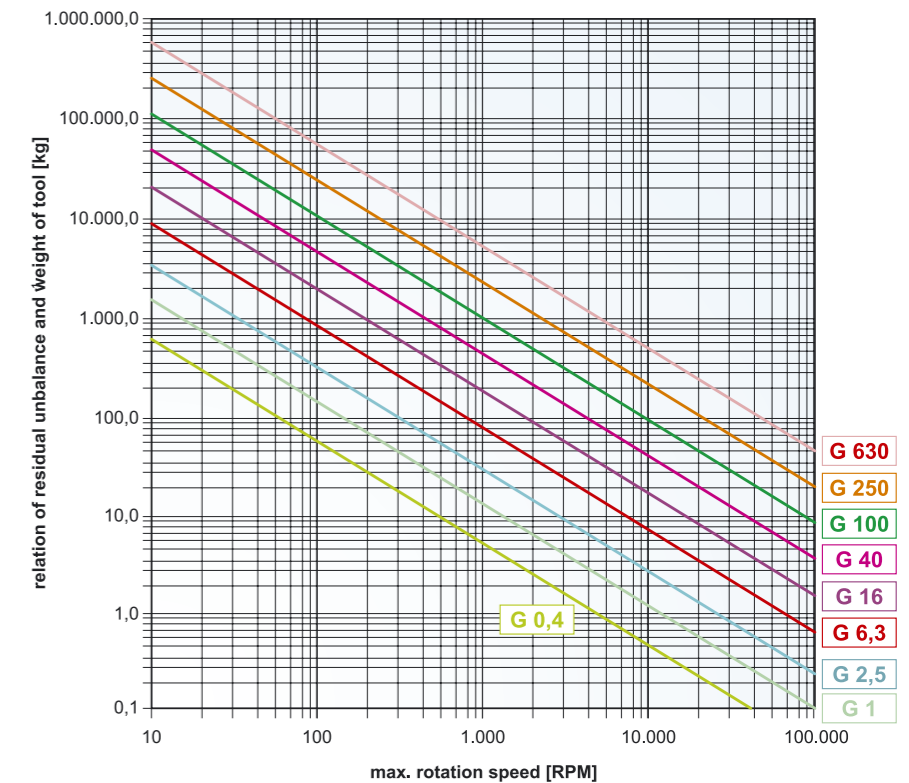
Recommended cutting conditions	
cutting speed v _c [m.min ⁻¹]	< 2500
feed per tooth f _z [mm]	0,05 ÷ 0,27
axial depth of cut a _p [mm]	0,5 ÷ 16,0

COOLING:

Roughing - not necessary.
Finishing - recommended.

EXAMPLE:

For chosen type of tool and relevant index of balancing quality G we find in graph maximum rotation speed. At that rotation speed you can work without any additional balancing.



BALANCING QUALITY OF TOOL

