

ALU-Milling



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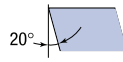
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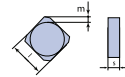
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Shape
Square 90°



Clearance Angle
20°



Tolerance
l ± 0.08 m ± 0.013
s ± 0.025



Insert Type
Screw down clamping
chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
SEGT 1204 AFEN ALU	LT 30	12	4,76	45°	25°	Neutral	M0001008	227

Surfacing Insert Lead angle 45°

Application Guide

Surfacing



Chamfering



Highly positive inserts with a unique coating and 90° lead angle for Aluminum. Suitable for Roughing to Finishing - Slotting, Shoulder and Face milling operations.

Milling bodies
SEGT 1204 - see cutters of SEKT 1204 (page 190)

Machining Recommendation Guide - Please see Pg. 8



Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.3	7.0	0.15	0.40	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.12	0.35	250	600
Si > 8%	14	ALSi 12	----	Recommended to use SEKT 1204 AFTN - LT-30					

For high Si Aluminium, it is recommended to use SEKT 1204 AFTN. See cutting conditions below.

Si > 8%	14	ALSi 12	----	0.5	7.0	0.20	0.45	200	400
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