

C4LATB

SOLID CARBIDE TAPER BALL END MILL
HIGH EFFICIENCY MACHINING OF ALUMINIUM ALLOYS

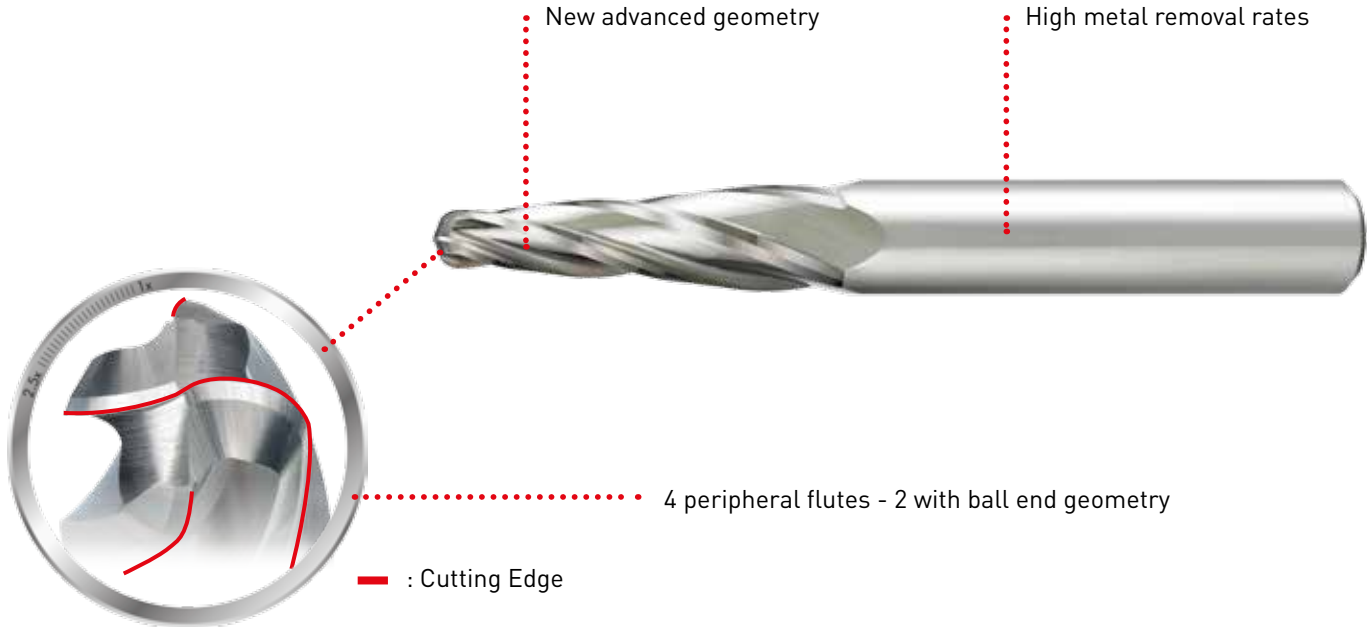


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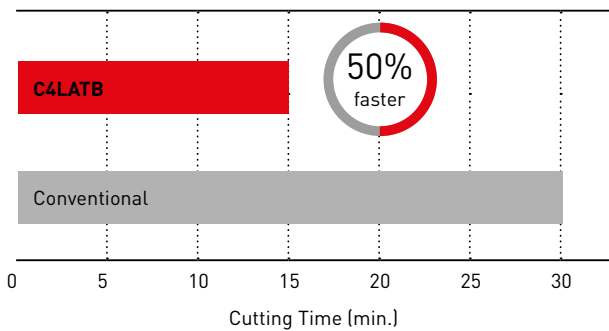
 **MITSUBISHI MATERIALS**

C4LATB

HIGH EFFICIENCY MACHINING OF ALUMINIUM ALLOYS



APPLICATION EXAMPLE / CUTTING PERFORMANCE



Material	Aluminium Alloy
Tool	C4LATBR200T040AP30
Revolution n (min ⁻¹)	25.000
Table Feed Vf (mm/min)	5.600
Feed per Tooth fz (mm/t)	0.056 max.
Depth of Cut ap (mm)	8 (Slotting)
	22 (Finishing, Side Milling)
Coolant	Emulsion, peripheral cooling

Ø 91 x Ø 66 x 36 (h)



C4LATB



N



RE<2

± 0.010

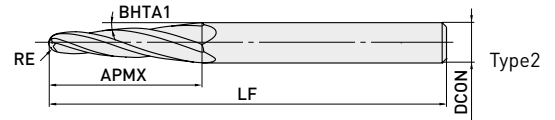
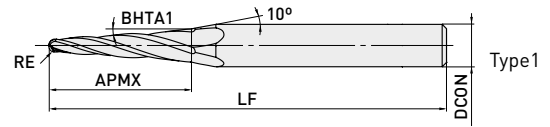


±5°



DCON = 6 DCON = 8

0 - 0.008 0 - 0.009



Order Number

RE

BHTA1

APMX

LF

DCON

ZEFP

Stock

Type

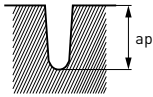
Order Number	RE	BHTA1	APMX	LF	DCON	ZEFP	Stock	Type
NEW C4LATBR050T040AP20	0.5	4°	20	70	6	4	●	1
NEW C4LATBR100T040AP20	1	4°	20	70	6	4	●	1
NEW C4LATBR150T040AP20	1.5	4°	20	75	8	4	●	1
NEW C4LATBR200T040AP30	2	4°	30	75	8	4	●	2

Modified and special design taper ball end mills available. Please contact your Mitsubishi dealer for details.

RECOMMENDED CUTTING CONDITIONS

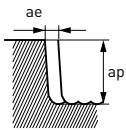
SLOTTING

		N		
Material		Aluminium Alloy		
RE	n (min ⁻¹)	Vf (mm/min)	ap (mm)	
R 0.5	20.000	600	10	
R 1	20.000	2.800	10	
R 1.5	20.000	4.000	10	
R 2	20.000	4.000	15	



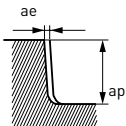
SIDE MILLING

		N			
Material		Aluminium Alloy			
RE	n (min ⁻¹)	Vf (mm/min)	ap (mm)	ae (mm)	
R 0.5	20.000	2.000	15	0.75	
R 1	20.000	4.000	15	1.5	
R 1.5	20.000	5.200	15	2.25	
R 2	20.000	5.200	23	3	



SIDE MILLING (FINISHING)

		N			
Material		Aluminium Alloy			
RE	n (min ⁻¹)	Vf (mm/min)	ap (mm)	ae (mm)	
R 0.5	20.000	800	18	0.1	
R 1	20.000	2.000	18	0.2	
R 1.5	20.000	2.400	18	0.3	
R 2	20.000	2.400	27	0.3	



1. Water-soluble cutting fluid is recommended.
Down cutting is recommended for side milling.



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MEMO

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GERMANY

MMC HARTMETALL GMBH
Comeniusstr. 2 . 40670 Meerbusch
Phone +49 2159 91890 . Fax +49 2159 918966
Email admin@mmchg.de

U.K.

MMC HARDMETAL U.K. LTD.
Mitsubishi House . Galena Close . Tamworth . Staffs. B77 4AS
Phone +44 1827 312312 . Fax +44 1827 312314
Email sales@mitsubishicarbide.co.uk

SPAIN

MITSUBISHI MATERIALS ESPAÑA, S.A.
Calle Emperador 2 . 46136 Museros/Valencia
Phone +34 96 1441711 . Fax +34 96 1443786
Email mme@mmvalencia.com

FRANCE

MMC METAL FRANCE S.A.R.L.
6, Rue Jacques Monod . 91400 Orsay
Phone +33 1 69 35 53 53 . Fax +33 1 69 35 53 50
Email mmfsales@mmc-metal-france.fr

POLAND

MMC HARDMETAL POLAND SP. Z O.O
Al. Armii Krajowej 61 . 50-541 Wrocław
Phone +48 71335 1620 . Fax +48 71335 1621
Email sales@mitsubishicarbide.com.pl

RUSSIA

MMC HARDMETAL RUSSIA OOO LTD.
Electrozavodskaya St. 24 . build. 3 . Moscow . 107023
Phone +7 495 725 58 85 . Fax +7 495 981 39 79
Email info@mmc-carbide.ru

ITALY

MMC ITALIA S.R.L.
Via Montefeltro 6/A . 20156 Milano
Phone +39 0293 77031 . Fax +39 0293 589093
Email info@mmc-italia.it

TURKEY

MMC HARTMETALL GMBH ALMANYA - İZMİR MERKEZ ŞUBESİ
Adalet Mahallesi Anadolu Caddesi No: 41-1 . 15001 35580 Bayraklı/İzmir
Phone +90 232 5015000 . Fax +90 232 5015007
Email info@mmchg.com.tr

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