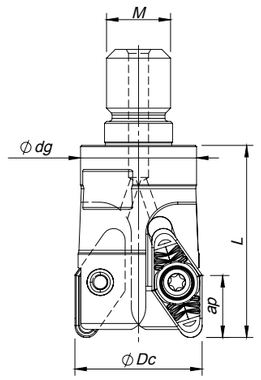
ALUPRO 08390



Threaded Coupling

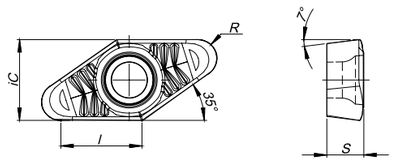
K_r=90° | γ_p=0°

Order code Código	Reference Referência Referencia		Dimensions | Dimensões | Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ØDc	Ød/M	Ødg	L		Ap max (mm)		
181019900	032R08390-02-M16048	2	32	M16	29	48	0,19	15,00	VCGX 22...	⚠

⚠ Stock item | Produto de stock | Itens de stock

◯ Available under request (see page A-6) | Disponível sobre consulta (consulte a página A-6) | Disponible bajo consulta (mire pagina A-6)

VCGX 220530 ‖ Inserts | Pastilhas | Plaquitas



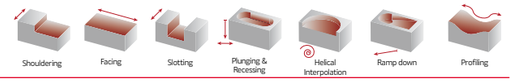
		P						M				K						N		S			H	Dimensions Dimensões Dimensiones (mm)				
		CVD	PVD					CVD	PVD			CVD			PVD			UNC	PCD	PVD			PVD					
(1) Geometry code	(2) Grade code	T9	P7	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	10	D6	P3	G6	P7		iC	S	l	R	F
	ISO Reference	PHS740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH0910	PDP410	PH7930	PH7740	PH7603						
1121907	VCGX 220530 LN																	⚠						12,70	5,60	12,7	3,00	-

First choice | Primeira opção | 1ª opción

⚠ Stock item | Produto de stock | Itens de stock

◯ Available under request (see page A-7) | Disponível sobre consulta (consulte a página A-7) | Disponible bajo consulta (mire pagina A-7)

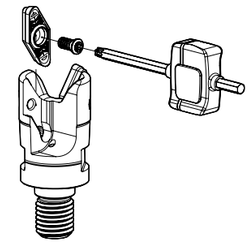
Insert order code = (1) Geometry Code + (2) Grade Code



SPARE PARTS ‖ Complementos | Repuestos

Cutter ØDc	Order separately Insert Screw	Key (Torx)	Key (Torx - Nm)	Torque Value
R08390 – 32	P0451001	XT20	DT2050	5,00

Note: The toolholder is supplied with the XT/PT key. To order the DT key please check the page A-243.
Check the procedures for the clamping screws on the page A-243.



RECOMMENDED CUTTING CONDITIONS ‖ Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min) PH0910	Feed fz(mm/t) VCGX 22...
N	10	Aluminium and Non Ferrous	30-130	350-1400	0,20-0,50

ØDc	Ø32
RPM (min^{-1})	9500

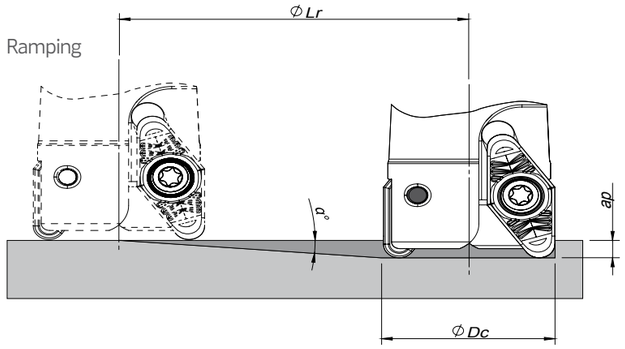
(Note 1) Cutting conditions a_e/Dc=70%.
(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:
- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) Use internal coolant supply

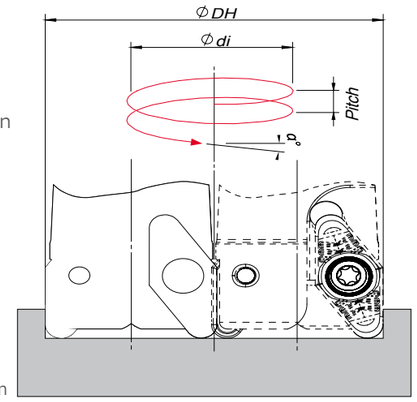
RAMPING AND HELICAL INTERPOLATION

Descida em rampa e interpolação helicoidal | Bajada en rampa e interpolación circular

Ramping



Helical Interpolation



Ødi = ØDH - ØDc

ØDc	Ramping			Helical Interpolation		
	Max Ramp a°	Max a_p	Min Lr	ØDHmin	ØDHmax	Max Pitch/Rev.
35	6,8	15,0	25,4	53,0 -	- 62,0	7,0 11,0

Note: During helical interpolation do not exceed max Pitch.