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Aluminium Milling

MAAM & MSAM

ISO **N**



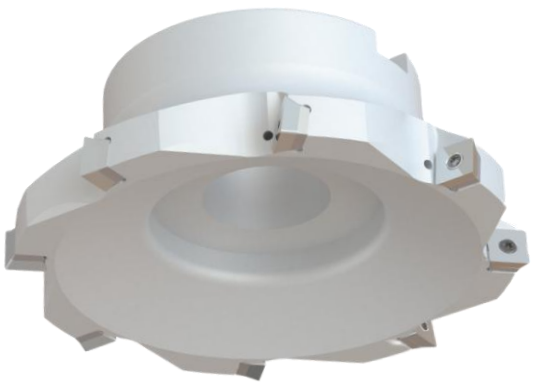
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MAAM & MSAM Cutter and Insert Details

Aluminium Milling Range with Polished Inserts



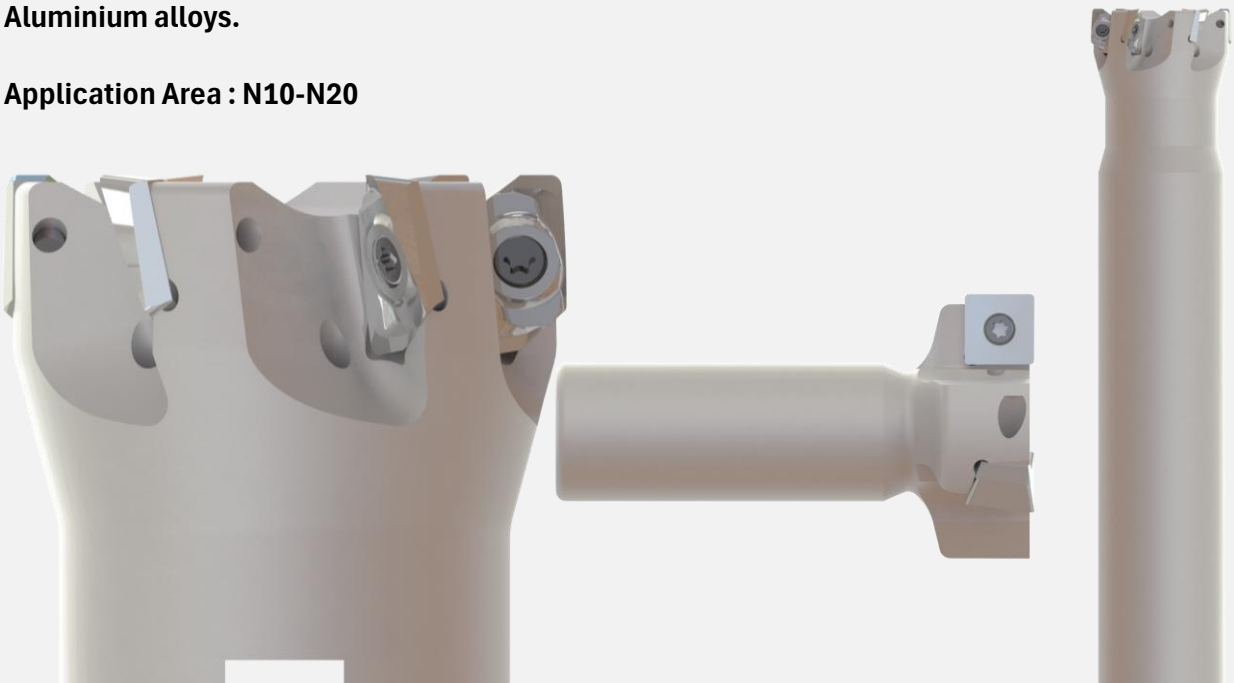
- **Versatile Cutter System** capable of performing Shoulder milling, ramping, cavity milling and helical interpolation operations in Aluminium.
- **Inserts have high rake angle and a polished rake surface** for optimum and importantly, a burr free cutting performance.
- **Unique cutting edge** shape lowers cutting force and achieves high quality machined surfaces.

Grade Details

DMU6020N is a specially developed grade for Aluminium Milling Operations.

Microfine grain size with appropriate quantity of binder provides the combination of hardness and wear resistance required to **perform roughing to finishing in Aluminium alloys.**

Application Area : N10-N20



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Why select the grade?

What is your primary Aluminum machining goal?

Machining of Aluminium and its alloys in a versatile manner

➢ **Choose DMU6020N**

- ✓ **Burr free machining** – thanks to high positive polished inserts
- ✓ **Roughing to finishing with a single tool**
- ✓ **Multiple operations** possible with only 1 tool.

Recommended Cutting parameters

Insert	Parameters	For DMU6020N (HRC ~ 40)		
		Min.	Ideal	Max.
AOGX11	Speed (m/min)	100	450	800
	Feed (mm/tooth)	0.08	0.2	0.35
	Ap (mm)	0.1	3.0	10.0
AOGX19	Speed (m/min)	100	450	800
	Feed (mm/tooth)	0.08	0.2	0.35
	Ap (mm)	0.1	4.0	14.0
SDGT1204	Speed (m/min)	100	450	800
	Feed (mm/tooth)	0.08	0.2	0.35
	Ap (mm)	0.1	2.0	11.0

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Cutter range MAAM type

Shank type



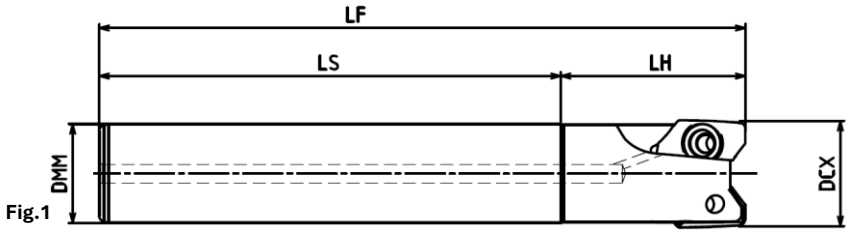


Fig.1

Shank type Catalogue No.	Stock	Min. Dia. DC	Shank Dia. DMMh7	Working Length LH	Overall Length LF	Number of Teeth Zn	Weight (kg)	Fig.
MAAM11016E02		16	16	25	85	02	0.13	1
MAAM11020E02		20	20	30	110	02	0.23	1
MAAM11025E03		25	25	35	120	03	0.38	1
MAAM11032E04		32	32	40	130	04	0.73	1

Spare

Item Description	Clamp screw	Wrench
AOGX11	S-M2506N	MHT-T08

Shell type



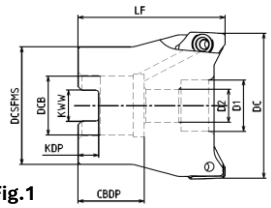


Fig.1

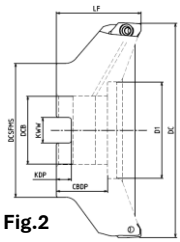


Fig.2

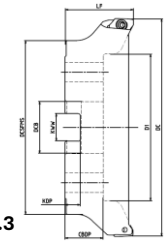


Fig.3

Shell type Catalogue No.	Stock	Dia. DC	BOSS DCSFMS	Height LF	Bore Dia DCB	Keyway Width KWW	Keyway Depth KDP	Mounting Depth CBDP	Bolt D1	Bolt D2	No. of Teeth Zn	Weight (kg)	Fig.	Applicable Insert
MAAM11040RS06		40	32	40	16	8.4	5.6	18	14	9	06	0.16	1	AOGX11
MAAM19040RS03		40	32	40	16	8.4	5.6	18	14	9	03	0.19	1	AOGX19
MAAM19050RS04		50	41	40	22	10.4	6.3	20	18	11	04	0.26	1	
MAAM19063RS05		63	50	40	22	10.4	6.3	20	18	11	05	0.54	1	
MAAM19080RS06		80	55	50	27	12.4	7	22	20	14	06	1.1	1	
MAAM19100RS08		100	70	50	32	14.4	8	32	46	_	08	1.57	2	
MAAM19125RS10		125	80	63	40	16.4	9	29	52	29	10	3.07	3	
MAAM19160RS12		160	130	63	40	16.4	9	29	90	_	12	5.24	3	

Spare

Item Description	Clamp screw	Wrench
AOGX11	S-M2506N	MHT-T08
AOGX19	S-M0409N	MHT-T15

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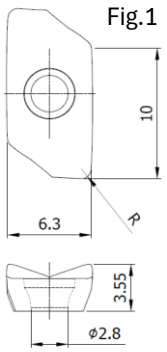
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Insert range

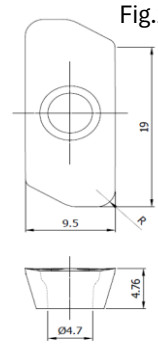
Item Description	Corner Radius
AOGX113502-AM1	0.2
AOGX113504-AM1	0.4
AOGX113508-AM1	0.8
AOGX113510-AM1	1
AOGX113520-AM1	2
AOGX113530-AM1	3

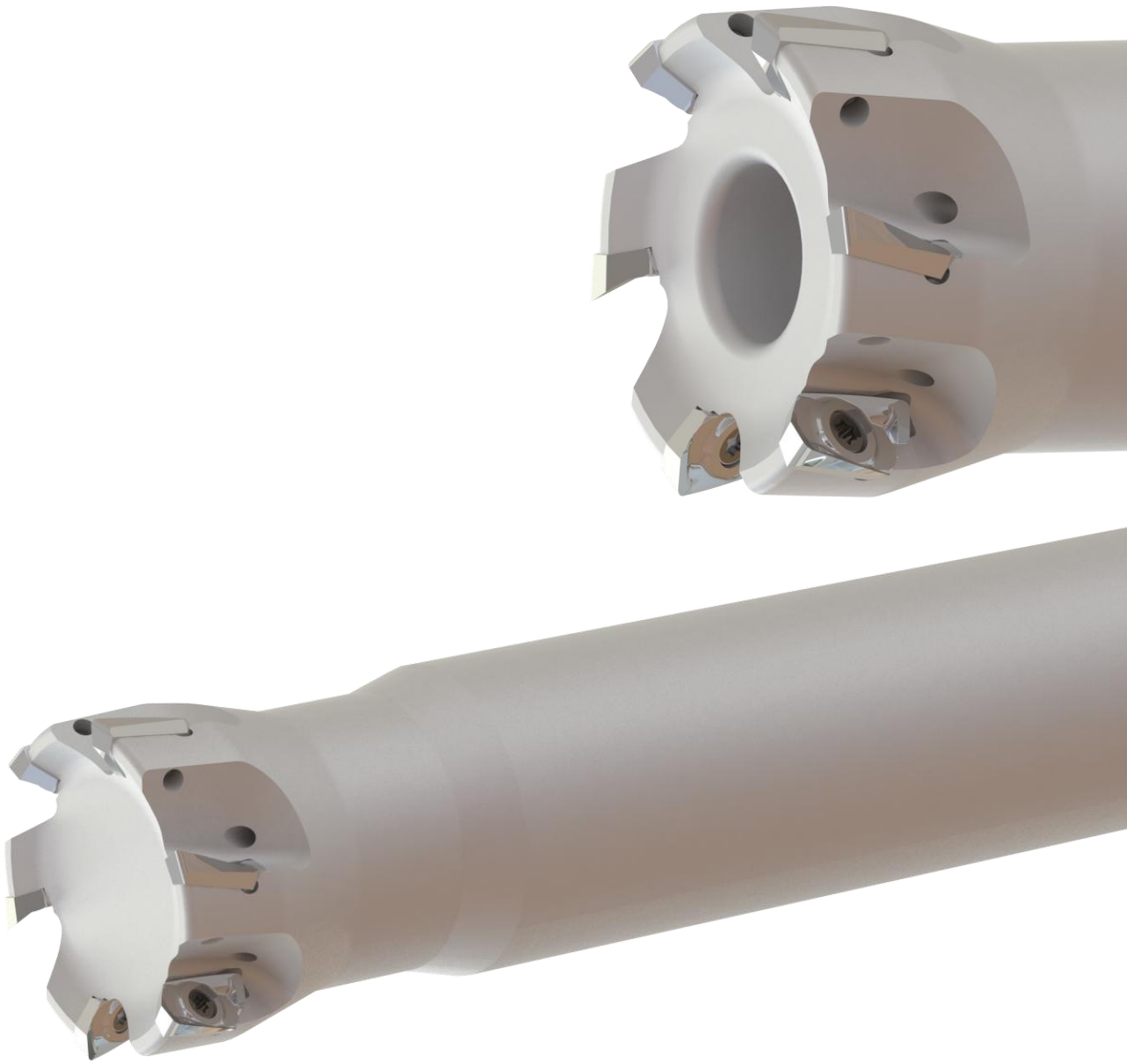
Fig.1



Item Description	Corner Radius
AOGX190404-AM1	0.4
AOGX190408-AM1	0.8
AOGX190412-AM1	1.2
AOGX190416-AM1	1.6
AOGX190420-AM1	2
AOGX190424-AM1	2.4
AOGX190430-AM1	3

Fig.2





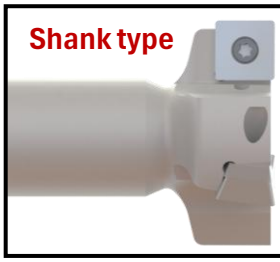
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Cutter range MSAM type

Shank type



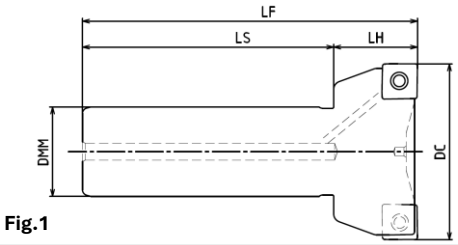


Fig.1

Shank type Catalogue No.	Stock	Min. Dia. DC	Shank Dia. DMMh7	Working Length LH	Overall Length LF	Number of Teeth Zn	Weight (kg)	Fig.
MSAM12040E03		16	16	25	85	02	0.13	1

Spare

Clamp screw	Wrench	Shim	Shim screw	Wrench
S-M03512IP	MHT-T15IP	SH-MSSM-12	HS-M0507	MLT-3.5

Shell type



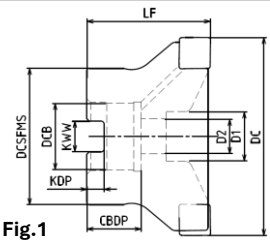


Fig.1

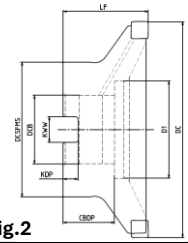


Fig.2

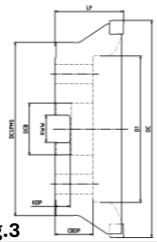


Fig.3

Shell type Catalogue No.	Stock	Dia. DC	BOSS DCSFMS	Height LF	Bore Dia DCB	Keyway Width KWW	Keyway Depth KDP	Mounting Depth CBDP	Bolt D1	Bolt D2	No. of Teeth Zn	Weight (kg)	Fig.	Applicable Insert
MSAM12050RS04		50	41	40	22	10.4	6.3	20	18	11	04	0.26	1	SDG T12
MSAM12063RS05		63	50	40	22	10.4	6.3	20	18	11	05	0.54	1	
MSAM12080RS06		80	55	50	27	12.4	7	22	20	14	06	1.1	1	
MSAM12100RS07		100	70	50	32	14.4	8	32	46	-	07	1.57	2	
MSAM12125RS08		125	80	63	40	16.4	9	29	52	29	08	3.07	3	
MSAM12160RS12		160	100	63	40	16.4	9	29	90	-	12	5.24	3	
MSAM12200RS16		200	160	63	60	25.7	14	35	135	-	16	5.7	3	
MSAM12250RS18		250	180	63	60	25.7	14	35	160	-	18	6.8	3	

Spare

Clamp screw	Wrench	Shim	Shim screw	Wrench
S-M03512IP	MHT-T15IP	SH-MSSM-12	HS-M0507	MLT-3.5

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Insert range

Item Description	Corner Radius
SDGT120404PDFR-AM	0.4
SDGT120408PDFR-AM	0.8
SDGT120412PDFR-AM	1.2

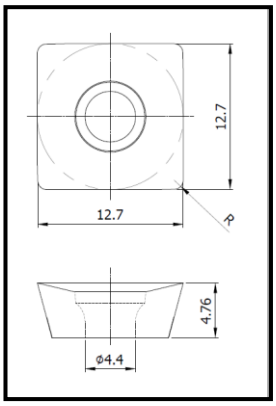


Fig.3

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