

High-Performance Aluminum Solid Carbide End Mills



AUTHORIZED
DISTRIBUTOR

PRIMARY APPLICATION

High-performance aluminum end mills from Kennametal provide the highest Metal Removal Rates (MRR) and high-quality surfaces while reducing machining time. Designed to deliver exceptional chip evacuation and generate the highest floor-to-wall straightness.



PROMOTIONAL OFFER

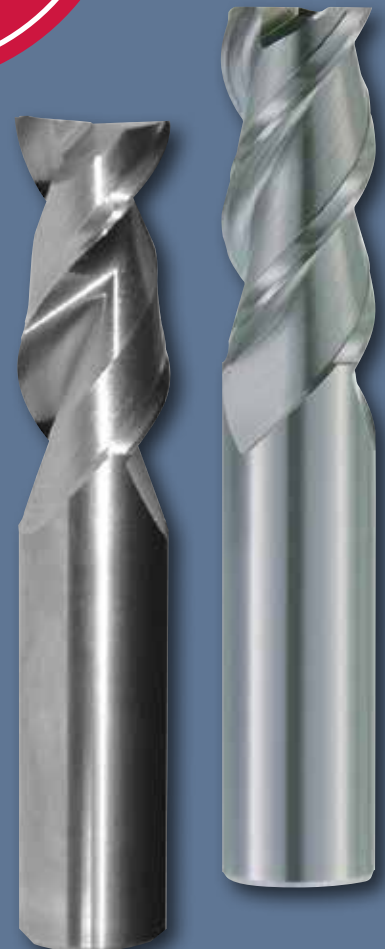
**Buy 3 and
Get 1 Free**
of Equal or
Lesser Value

- » Tools combine roughing and finishing operations beside pure rougher with cord profile.
- » Capable of full slot depths up to 1 x D and side milling up to 0.5 x D radially at 1.5 x D axially.
- » Multiple corner radii and extended neck configurations available as standard.

Offer ends on February 28, 2020



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AADF & AADE



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Double Rake Flute Form
For improved chip formation
and evacuation.

K600 Uncoated Substrate
For highest tool life in aluminum and
other non-ferrous materials.



Center Cutting
For plunging and ramping.

37° and 45° Helix End Mill Versions
For roughing and finishing operations.

Materials

N

Applications



Plunge Milling



Ramping:
Blank



Slotting:
Square End



Side Milling/
Shoulder Milling:
Square End



Corner Style:
Corner Radius



Corner Style:
Square End



Helix Angle:
37°



Helix Angle:
45°



Tool Dimensions:
Flute Configuration:
2



Tool Dimensions:
Flute Configuration:
3

■ AADF

Material Group	Side Milling (A) and Slotting (B)		K600	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.																	
	A			B		D1 – Diameter															
	ap	ae		ap	min	max	dec.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1					
	ap	ae		ap	min	max	dec.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1					
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090					
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072					
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063					
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063					
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081					

■ AADE

Material Group	Side Milling (A) and Slotting (B)		K600	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.																	
	A			B		D1 – Diameter															
	ap	ae		ap	min	max	dec.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1					
	ap	ae		ap	min	max	dec.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1					
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090					
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072					
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063					
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063					
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081					

NOTE: These guidelines may require variations to achieve optimum results.

Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.

Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.