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NPA
New Product Announcement

End mills
for Aluminium machining

Mega Alu Power Mega Alu Mega Alu LFF

part of Mega Tool

NPA
New Product Announcement

OUR BEST SOLUTIONS

*FOR THE MACHINING OF **ALUMINIUM** AND **ALUMINIUM ALLOYS***

Mega | Alu Power | 797ALUCB

Mega | Alu Power | 797ALUCBIC

Mega | Alu | 797ALU

Mega | Alu | 797ALUIC

Mega | Alu LFF | 797ALULFFIC

part of MegaTool

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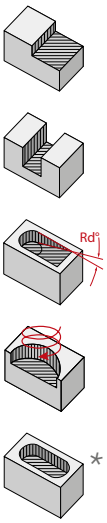
ROUGHING OPERATIONS



* Only 797ALUCB

Mega Alu Power

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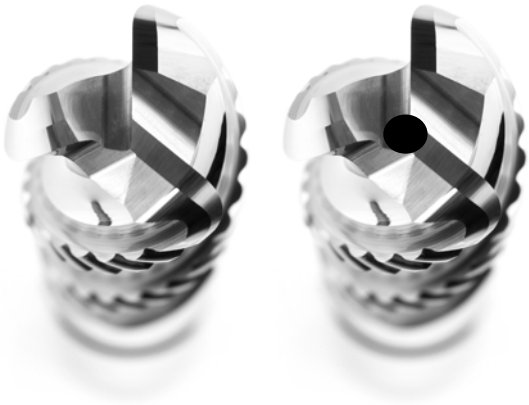
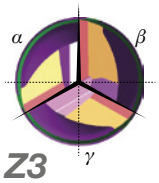
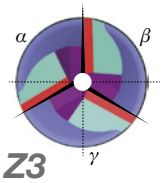


Alu Power
797ALUCB



Z3
IRREGULAR DIVISION

Alu Power
797ALUCBIC



Z3
IRREGULAR DIVISION

TECHNICAL DATA

Irregular division *Designed to reduce resonance when machining Aluminium and Aluminium alloys.*

Different helices *to reduce vibration even in complex tool paths.*

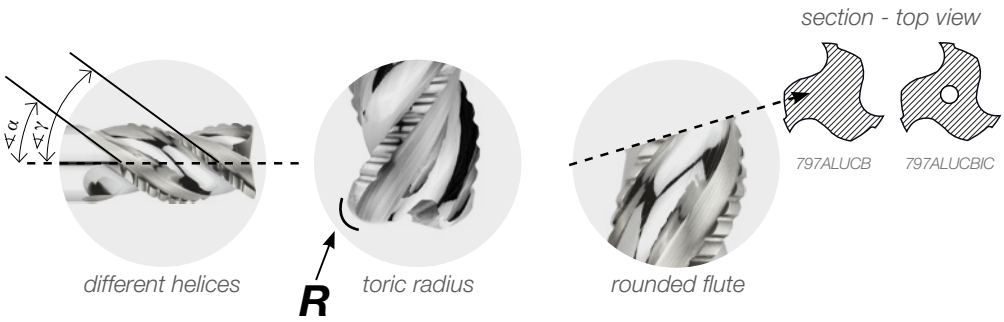
Rounded flute.

Asymmetric Chip Breaker.

Mirror grinding.

Internal coolant hole.
(MegaAluPower 797ALUCBIC)

OPTIMAL CHIP CONTROL IN HIGH METAL REMOVAL RATE MACHINING. VIBRATIONLESS.



Mega Alu Power

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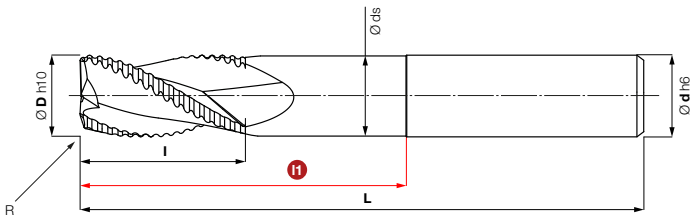
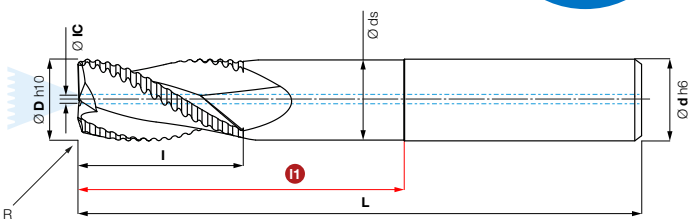
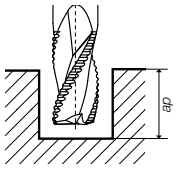
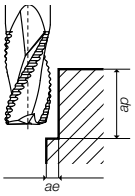


AluPower 797ALUCB



AluPower 797ALUCBIC

CUTTING PARAMETERS

Materials	Slotting ap = 1 - 2Ø	Shoulder Milling ap = 1 - 2Ø ae = 0,7 - 0,10Ø
		

Leghe Al Al alloys	Group and description	Vc (mt /min.)	Vc (mt /min.)
	Aluminium alloys	150 - 1000	150 - 1000

D	FEED mm/tooth			
	ap = 2Ø	ap = 1Ø	ae > 0,4Ø	ae < 0,4Ø
6*	0,02 - 0,04	0,03 - 0,05	0,03 - 0,045	0,05 - 0,10
8*	0,02 - 0,05	0,04 - 0,06	0,03 - 0,05	0,05 - 0,10
10*	0,03 - 0,06	0,04 - 0,07	0,04 - 0,06	0,05 - 0,12
12	0,04 - 0,08	0,04 - 0,12	0,05 - 0,12	0,08 - 0,20
14*	0,05 - 0,10	0,05 - 0,12	0,06 - 0,13	0,08 - 0,20
16	0,05 - 0,14	0,05 - 0,14	0,08 - 0,14	0,08 - 0,20
20	0,06 - 0,15	0,06 - 0,16	0,08 - 0,15	0,08 - 0,20
25	0,06 - 0,16	0,06 - 0,16	0,08 - 0,16	0,08 - 0,20

A tool holder with heavy duty clamping or a shrink holder are recommended. The abundant use of coolant is recommended.
Only **797ALUCBIC*

ASYMMETRIC CHIPBREAKER

Standard chip size

VS

Mega Alu Power

CENTRAL COOLANT HOLE

The use of internal coolant allows for:
- *temperature control in the cutting area.*
- *optimal chip evacuation, thus resulting in a clean work area.*

It is recommended for heavy duty machining (deep pockets, complex profiles, etc.) where external refrigeration is obstructed or insufficient.

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DISCOVER MORE ABOUT THIS FAMILY
Tools dimensions and all data
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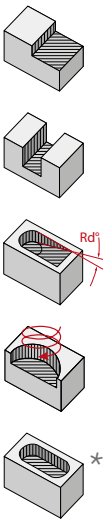
ROUGHING OPERATIONS



* Only 797ALU

Mega Alu

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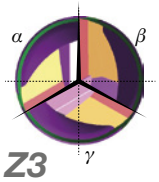
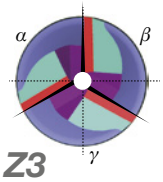
Alu
797ALU



Z3
IRREGULAR DIVISION

Alu
797ALU



Z3
IRREGULAR DIVISION

TECHNICAL DATA

Irregular division *Designed to reduce resonance when machining Aluminium and Aluminium alloys.*

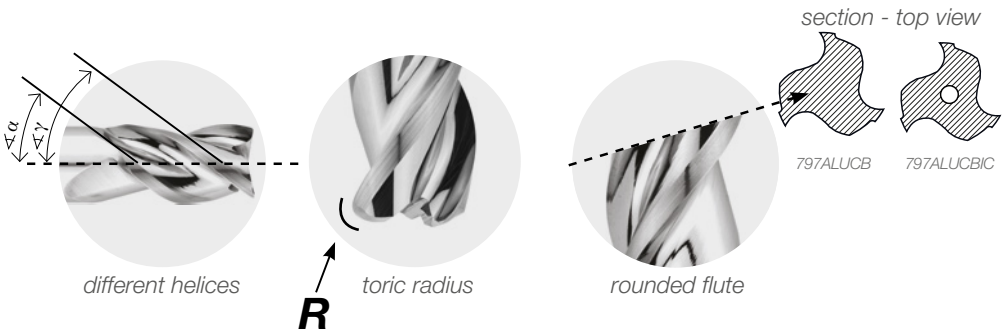
Different helices *to reduce vibration even in complex tool paths.*

Rounded flute.

Mirror grinding.

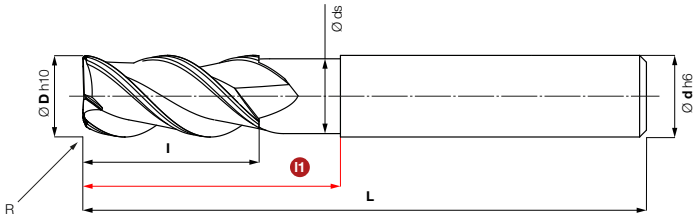
Internal coolant hole.
(MegaAluPower 797ALUIC)

HIGHLY STABLE PROCESS EVEN WITH OVERHANG UP TO 5Ø. VIBRATIONLESS.

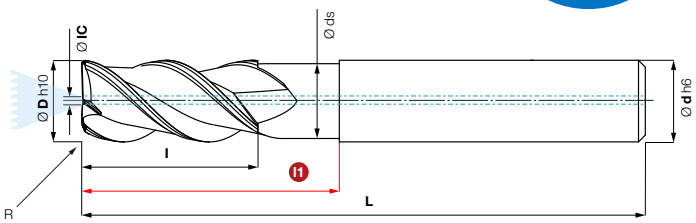


Mega | Alu

NPA
New Product Announcement

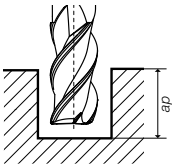
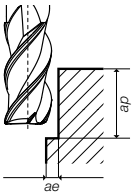
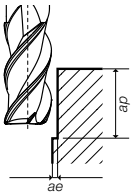


Alu 797ALU



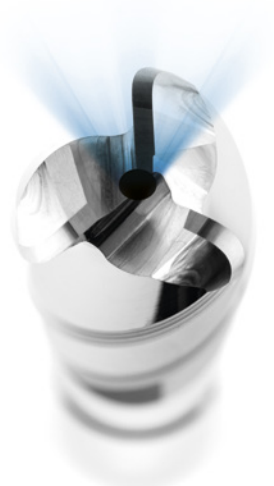
Alu 797ALUIC

CUTTING PARAMETERS

Materials	Slotting ap = 1 - 1,5Ø	Shoulder Milling ap = 1,5Ø ae = 0,25 - 0,1Ø	Finishing ap = 1,5Ø ae = 0,075 - 0,025Ø
			
Group and description	**Vc (mt /min.)**	**Vc (mt /min.)**	**Vc (mt /min.)**
Leghe Al / *Al alloys* — *Aluminium alloys*	150 - 1000	150 - 1000	150 - 1000

D	FEED mm/tooth								
	ap=1,5Ø	ap=1Ø	ae=0,25Ø	ae=0,2Ø	ae=0,15Ø	ae=0,1Ø	ae=0,075Ø	ae=0,05Ø	ae=0,025Ø
2*	0,015	0,018	0,022	0,023	0,025	0,031	0,034	0,041	0,058
3*	0,018	0,021	0,025	0,026	0,029	0,036	0,040	0,048	0,067
4*	0,021	0,024	0,029	0,030	0,034	0,041	0,046	0,055	0,077
5*	0,024	0,028	0,034	0,035	0,039	0,048	0,053	0,064	0,090
6	0,028	0,031	0,037	0,039	0,043	0,053	0,059	0,071	0,099
8	0,032	0,035	0,042	0,044	0,049	0,060	0,067	0,081	0,112
10	0,036	0,040	0,048	0,050	0,056	0,068	0,076	0,092	0,128
12	0,040	0,043	0,052	0,054	0,060	0,073	0,082	0,099	0,138
16	0,045	0,050	0,060	0,063	0,070	0,085	0,095	0,115	0,160
20	0,048	0,050	0,060	0,063	0,070	0,085	0,095	0,115	0,160
25	0,050	0,052	0,062	0,065	0,073	0,088	0,099	0,120	0,166

A tool holder with heavy duty clamping or a shrink holder are recommended. The abundant use of coolant is recommended.
**Only 797ALU*



CENTRAL COOLANT HOLE

The use of internal coolant allows for:
- *temperature control in the cutting area.*
- *optimal chip evacuation, thus resulting in a clean work area.*

It is recommended for heavy duty machining (deep pockets, complex profiles, etc.) where external refrigeration is obstructed or insufficient.

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DISCOVER MORE ABOUT THIS FAMILY
Tools dimensions and all data
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ROUGHING OPERATIONS

Mega Alu LFF

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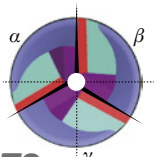
Alu
LFF
797ALULFFIC



Z3
IRREGULAR
DIVISION

Long Flute Finishers

TECHNICAL DATA

Irregular division *Designed to reduce resonance when machining Aluminium and Aluminium alloys.*

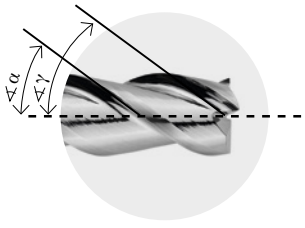
Different helices *to reduce vibration even in complex tool paths.*

Rounded flute.

Mirror grinding.

Internal coolant hole.

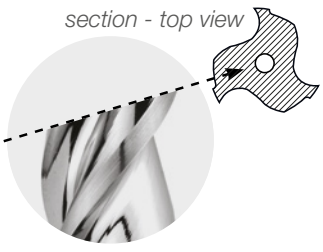
HIGHLY STABLE PROCESS EVEN WITH AN AXIAL WIDTH OF CUT UP TO 6Ø. VIBRATIONLESS.



different helices

toric radius

R



section - top view

rounded flute

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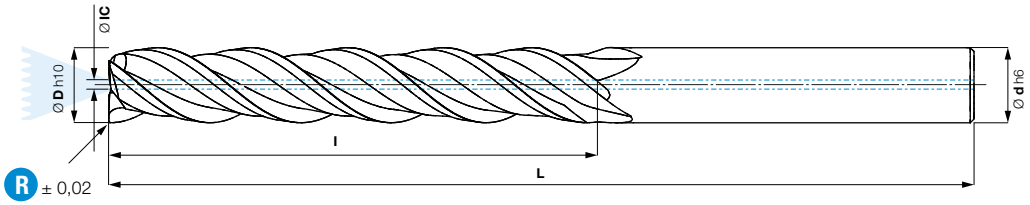
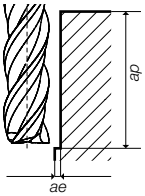
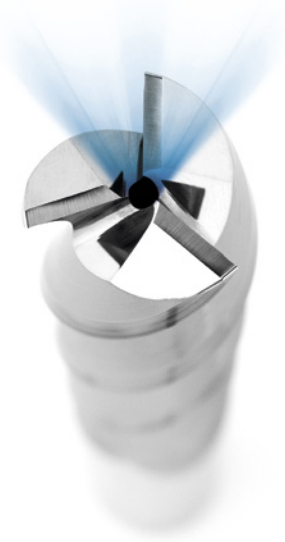


CUTTING PARAMETERS

Materials	Finishing ap = 4 - 6 Ø ae = 0,005 - 0,03 Ø
	
Group and description	**Vc (mt /min.)**
Leghe Al *Al alloys* — *Aluminium alloys*	150 - 1000
D	*FEED mm/tooth* **ae = 0,01 - 0,02Ø**
6	0,04 - 0,08
8	0,04 - 0,08
10	0,05 - 0,10
12	0,05 - 0,12
14	0,06 - 0,12
16	0,06 - 0,15
20	0,06 - 0,15
25	0,06 - 0,15



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