

## Tool table for AF 450-tools Aluminium

Schüco	Cutter Ø	Shaft Ø	Cutting length	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction
Art.-Nr.	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
Cutter								
289 830	3	6	7	2	1500	150-500	18000	dm
296 589	4	6	8	3	1200	150-400	15000	dm
296 590	5	6	8	4	850	150-400	10000	dm
296 591	6	6	10	6	600	150-450	13000	dm
296 592	8	8	10	8	1600	150-400	18000	dm
296 593	10	10	12	10	2000	150-600	11000	dm
282 421	10	10	12	8	600	150-500	7500	dm
289 281	10	12	15	6	800	150-350	14000	dm
Cutter with 2 edge								
289 811	8	8	45	3	800	150-400	6000	dm
289 670/- 671	16	16	8.5	7.5	1500	150-500	7500	dm
280 272	20	20	35	16	2000	150-500	12000	dm
special contour milling cutter								
282 296	RL-Cutter	20	1,5 x 30°	--	750	--	15000	dm
282 297	RL-Cutter	20	5,0 x 30°	--	750	--	15000	dm
282 486	SL-Cutter	20	R = 10	--	1000	--	13500	dm
289 516	T-slot cutter	10	∅ 28,5 x 8	--	1100	--	6000	dm
Disc milling cutter / Saw								
264 230	120	--	4	--	1000	--	11000	um
280 857	120	--	5.7	--	1000	--	11000	um
289 295	120	--	18.5	--	1000	--	7000	um
283 954	160	--	5.7	--	1000	--	9500	um
Drill								
283 780	2.2	6	20	18	--	800	15000	um
283 781	2.5	6	20	18	--	800	14000	um
283 782	3	6	20	18	--	750	10000	um
283 783	3.2	6	20	18	--	700	9500	um
289 456	3.5	6	20	18	--	700	9300	um
264 335	3.5	6	20	18	--	700	9300	um
283 784	4.2	6	20	18	--	700	9000	um
289 498	4.2	6	20	18	--	700	9000	um
289 852	4.5	6	20	18	--	680	8800	um
289 457	4.7	6	20	18	--	650	8700	um
283 785	5	6	20	18	--	600	8500	um
264 308	5.5	6	20	18	--	600	8500	um
264 354	6.5	8	20	18	--	580	8000	um
283 786	6.8	8	20	18	--	570	7500	um
289 458	7.1	8	20	18	--	550	7200	um
264 295	7.5	8	20	18	--	520	7000	um
283 787	8	8	20	18	--	500	3500	um
283 788	8.2	10	20	18	--	500	3000	um
283 789	8.5	10	21	18	--	500	2500	um
264 319	9	10	21	18	--	480	2400	um
289 017	10	10	21	18	--	450	2000	um

These figures are guidelines only for Schüco tools (commercial HSS drill different), which may vary depending on the depth of cut and / or clamping situation. The cutting data must therefore be adjusted by the operator to the situation (for example by readjusting means of the feed potentiometer on the terminal or changing the tool parameters in Schüco CAM)

\*dm: downmilling



um: upmilling



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Art.-Nr.	[mm]		[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
	Pitch		Tap						
	[mm]								
	Ø	m							
283 794	M4	0.7	4.5	12	12	420	420	600	--
283 795	M5	0.8	6	13	13	480	480	600	--
283 796	M6	1	6	15	15	600	600	600	--
283 798	M8	1.25	8	18	18	750	750	600	--
283 790	M10	1.5	10	20	20	900	900	600	--
289 018	M12	1.75	9	23	23	1050	1050	600	--

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