KORLOY
TECH-NEWS

A+ Endmill



Endmill Series for Aluminum Machining

Endmills for rough, medium to finish cutting of aluminum

- **Optimized Solutions for Each Application Type**
  A wide selection of tools provided for various machining processes
- **Higher Machining Efficiency**
  Advanced flute design and cutting edge technology applied



KORLOY

Endmill Series for Aluminum for Rough, Medium to Finish Cutting

A+ Endmill



APFE For rough, medium to finish cutting



AFE For medium to finish cutting



RPAE For medium to rough cutting

Aluminum, which is a non-ferrous metal, is softer and easier to cut, compared to other metals. However, a failure to properly evacuate chips that melted at high speeds can cause severe problems.
A+ Endmill features state-of-the-art sharp cutting edges and mirror-like flute surface to reduce cutting force and facilitate smooth chip flow.

APFE effectively evacuates chips even at high feeds using U-shaped flutes. The buffed flute surface inhibits build-up edges caused by molten chips. In addition, double relief angles improve productivity by enhancing edge rigidity while the sharp edges enable perfect cutting performance even in finishing. APFE also offers a variety of shapes including balls and flat type to expand the range of applicable workpieces.

AFE is a flat endmill that is more economical than other products. The sharp cutting edges and mirror-like flutes not only enable efficient machining but also meet the customer needs, supported by the wide line up.

RPAE is a roughing endmill optimized for rough milling applications. The blade design of wave form breaks chips down into smaller pieces and lowers cutting force. This helps to maximize productivity with reduced loads over equipment.

With this wide selection of tools ideally suited for many different machining types, A+ Endmill is the solution you've looked for in aluminum machining.



Features

APFE

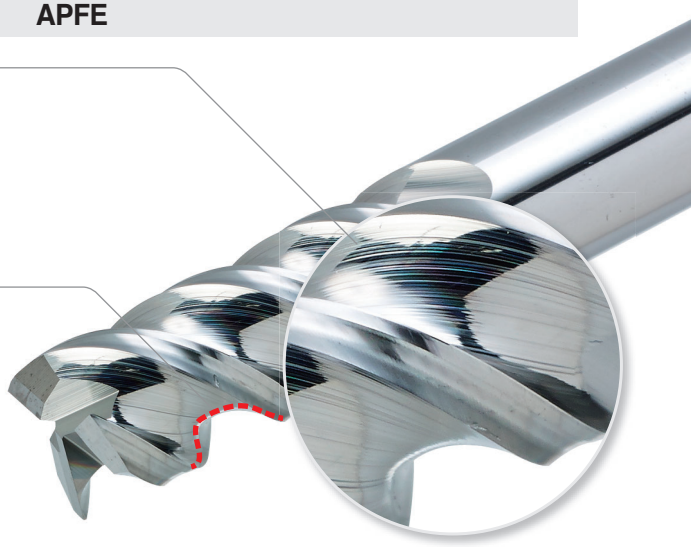
- Streamlined blade design optimized for rough, medium to finish cutting
- Extended tool life due to efficient chip evacuation

Sharp cutting edges and double relief angles

- Reduced cutting force
- Inhibited tool breakage due to reinforced cutting edges

U-shaped flutes with mirror-like finishing

- Efficient chip evacuation through wide chip pockets
- Inhibited build-up edges due to mirror-like finishing



AFE

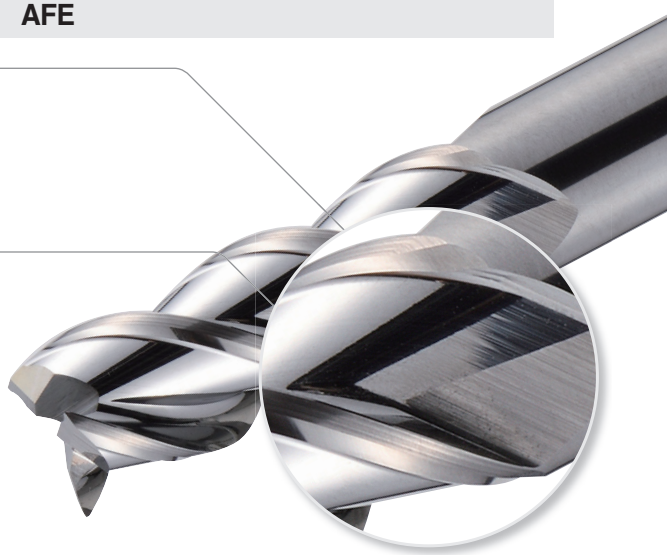
- More economical compared to other products
- Reduced tool breakage and increased machinability

Sharp cutting edges

- Long tool life and improved cost efficiency
- Reduced cutting force

Mirror-like flute surface

- Inhibited chip welding
- Reduced cutting force due to less build-up edges



RPAE

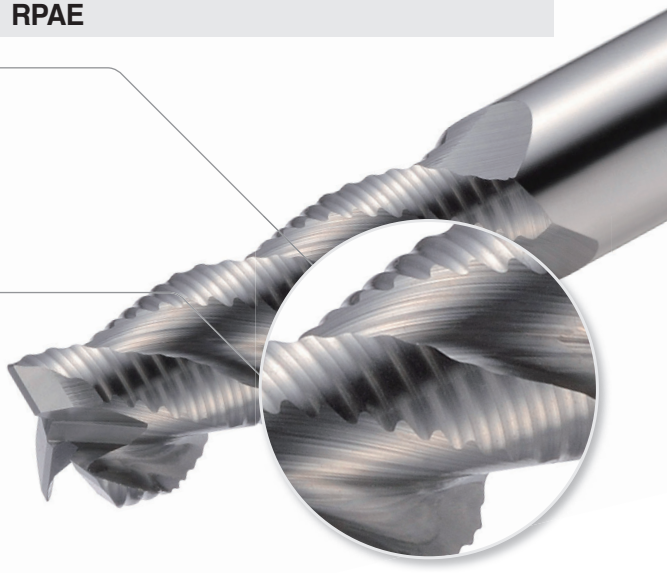
- Specially designed cutting edges for roughing
- Improved surface finish due to sharp edges

Blade design of wave form

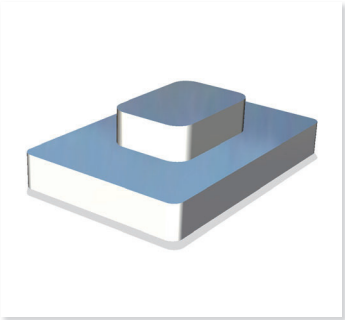
- Lower cutting force
- Efficient chip evacuation through chip breaking

Sharp cutting edges

- Lower cutting force
- Reduced loads over equipment.



Application Examples



Jig (A7075)

- Cutting conditions: vc (m/min) = 200, fz (mm/t) = 0.05, ap (mm) = 8, ae (mm) = 2, wet
- Tools: APFE3080-060

APFE	7 hours long
Competitor	5.5 hours long

30% longer

More than 30% longer cutting time compared to the competitor



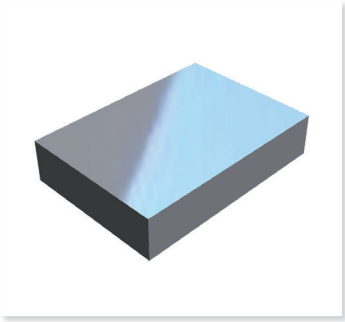
Inside milling of smart phones (Al60 series)

- Cutting conditions: vc (m/min) = 65, fz (mm/t) = 0.02, a p(mm) = 1, ae (mm) = 1, wet
- Tools: AFE3010-050-V3S6

AFE	12 hours long
Competitor	10 hours long

20% longer

More than 20% longer cutting time compared to the competitor



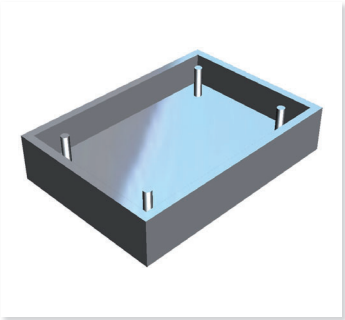
Outside milling of smart phones (Al60 series)

- Cutting conditions: vc (m/min) = 170, fz (mm/t) = 0.04, ap (mm) = 10, ae (mm) = 1, wet
- Tools: AFE3060-060-V17S6

AFE	6 hours long
Competitor	5 hours long

20% longer

More than 20% longer cutting time compared to the competitor



Roughing aluminum rectangular tubes (Al70 series)

- Cutting conditions: vc (m/min) = 330, fz (mm/t) = 0.05, ap (mm) = 15, ae (mm) = 1.5, wet
- Tools: RPAE3100-080

RPAE	120 ea machined
Competitor	80 ea machined

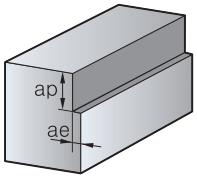
50% more

More than 50% longer cutting time compared to the competitor

Recommended Cutting Conditions (APFE/AFE)

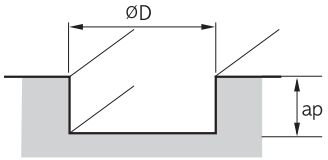
Workpiece	Shouldering				Slotting			
	Aluminum alloy (A7075)		Aluminum alloy mold (AC4B)		Aluminum alloy (A7075)		Aluminum alloy mold (AC4B)	
Cutting conditions / Tool diameter (Ø)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)
1	40,000	480	40,000	368	40,000	368	40,000	280
2	40,000	880	38,000	680	38,000	680	32,000	440
3	32,000	1,120	25,000	760	25,000	760	21,000	480
4	24,000	1,200	19,000	800	19,000	800	13,000	520
5	19,000	1,280	15,000	880	15,000	800	13,000	560
6	16,000	1,520	13,000	960	13,000	880	11,000	600
8	12,000	1,520	9,500	960	9,500	960	8,000	640
10	9,500	1,520	7,600	960	7,600	960	6,400	640
12	8,000	1,520	6,400	960	6,400	960	5,300	640
16	6,000	1,520	4,800	960	4,800	800	4,000	576
20	4,800	1,200	3,800	800	3,800	776	3,200	528

■ **Shouldering depth (ap)**



- ae ≤ 0.2D (D < 3)
  ≤ 0.5D (D ≥ 3)
- ap: ≤ 2.0D
- Workpiece should be clamped rigidly. In case of vibrations, reduce RPM and feed rate by the same ratio.

■ **Slotting depth (ap)**

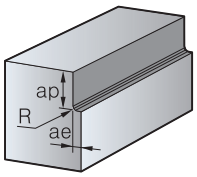


- ap ≤ D (Maximum 12 mm)
- Workpiece should be clamped rigidly. In case of vibrations, reduce RPM and feed rate by the same ratio.

Recommended Cutting Conditions (RPAE/APRE)

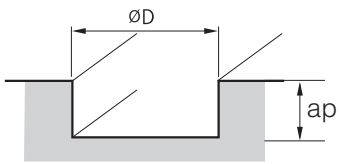
Workpiece	Shouldering				Slotting			
	Aluminum alloy (A7075)		Aluminum alloy mold (AC4B)		Aluminum alloy (A7075)		Aluminum alloy mold (AC4B)	
Cutting conditions / Tool diameter (Ø)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)	RPM n (min^{-1})	Feed vf (mm/min)
4	20,000	8,000	16,000	6,400	15,000	5,000	12,000	4,000
5	16,000	6,500	12,800	5,200	12,000	4,000	9,600	3,200
6	13,500	6,000	10,800	4,800	10,500	3,800	8,400	3,100
8	10,500	4,700	8,400	3,800	8,000	3,000	6,400	2,400
10	8,500	3,800	6,800	3,100	6,500	2,500	5,200	2,000
12	6,800	3,050	5,500	2,500	5,250	2,000	4,200	1,600
14	5,800	2,600	4,700	2,100	4,500	1,700	3,600	1,400
16	5,200	2,350	4,200	1,900	4,000	1,500	3,200	1,200
18	4,700	2,100	3,800	1,700	3,550	1,300	2,900	1,100
20	4,200	1,900	3,400	1,600	3,200	1,200	2,600	1,000
25	3,400	1,500	2,800	1,200	2,550	1,000	2,100	800

■ **Shouldering depth (ap)**



- ap: ≤ 1.5D
- ae: ≤ 0.5D
- Workpiece should be clamped rigidly. In case of vibrations, reduce RPM and feed rate by the same ratio.

■ **Slotting depth (ap)**

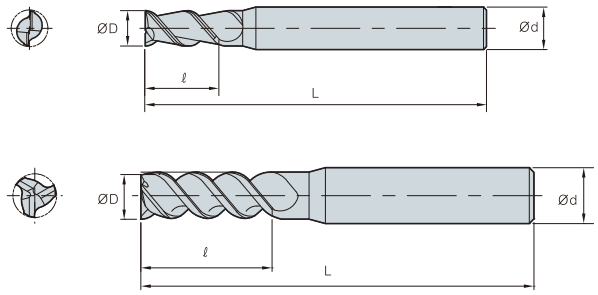


- ap: ≤ 1.5D
- Workpiece should be clamped rigidly. In case of vibrations, reduce RPM and feed rate by the same ratio.

APFE2000/3000 (Flat)

Shouldering | Slotting | Ramped surface | Helical milling





2 | 3 | Helix Angle 50° | Grade H05S | h6 shank

ØD	Tolerance
Ø1 ~ Ø6	0.00 ~ 0.02
Ø6.1 ~ Ø8	0.00 ~ 0.025
Ø8.1 ~ Ø20	0.00 ~ 0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

(mm)

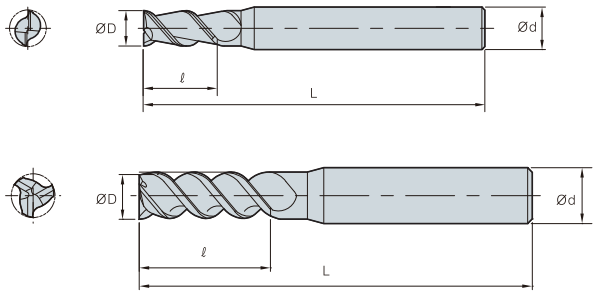
Designation		ØD	Ød	ℓ	L
APFE 2	2010-050-S6	1	6	3	50
	2015-050-S6	1.5	6	4	50
	2020-050-S4	2	4	6	50
	2025-050	2.5	6	8	50
	2030-050	3.0	6	9	50
	2040-050	4.0	6	12	50
	2050-050	5.0	6	15	50
	2060-050	6.0	6	18	50
	2080-060	8.0	8	20	60
	2100-075	10.0	10	30	75
	2120-075	12.0	12	32	75
	2160-100	16.0	16	45	100
	2200-100	20.0	20	45	100

Designation		ØD	Ød	ℓ	L
APFE 3	3010-050-S4	1	4	3	50
	3015-050-S4	1.5	4	4	50
	3020-050-S4	2	4	6	50
	3025-050	2.5	6	8	50
	3030-050	3.0	6	9	50
	3040-050	4.0	6	12	50
	3050-050	5.0	6	15	50
	3060-050	6.0	6	18	50
	3080-060	8.0	8	20	60
	3100-075	10.0	10	30	75
	3120-075	12.0	12	32	75
	3160-100	16.0	16	45	100
	3200-100	20.0	20	45	100

APMFE2000/3000 (Middle Flat)

Shouldering | Slotting | Ramped surface | Helical milling





2 | 3 | Helix Angle 50° | Grade H05S | h6 shank

ØD	Tolerance
Ø1 ~ Ø6	0.00 ~ 0.02
Ø6.1 ~ Ø8	0.00 ~ 0.025
Ø8.1 ~ Ø20	0.00 ~ 0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

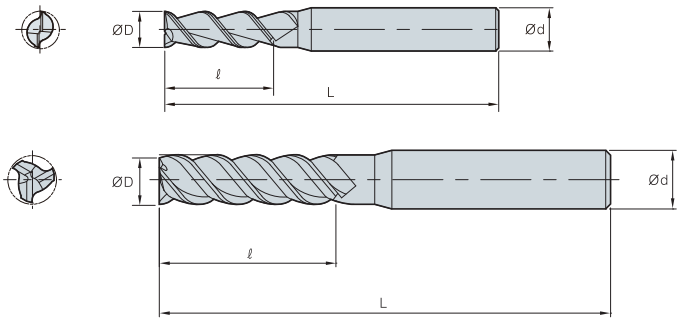
(mm)

Designation		ØD	Ød	ℓ	L
APMFE 2	2030-060	3.0	6	11	60
	2040-060	4.0	6	14	60
	2050-060	5.0	6	17	60
	2060-065	6.0	6	22	65
	2080-065	8.0	8	25	65
	2100-080	10.0	10	37	80
	2120-080	12.0	12	40	80
	2160-110	16.0	16	55	110
	2200-125	20.0	20	60	125

Designation		ØD	Ød	ℓ	L
APMFE 3	3030-060	3.0	6	11	60
	3040-060	4.0	6	14	60
	3050-060	5.0	6	17	60
	3060-065	6.0	6	22	65
	3080-065	8.0	8	25	65
	3100-080	10.0	10	37	80
	3120-080	12.0	12	40	80
	3160-110	16.0	16	55	110
	3200-125	20.0	20	60	125

APLFE2000/3000 (Long Flat)





Shouldering | Slotting | Ramped surface | Helical milling

2 | 3 | Helix Angle 45° | Grade H05S | h6 shank

ØD	Tolerance
Ø1 ~ Ø6	0.00 ~ 0.02
Ø6.1 ~ Ø8	0.00 ~ 0.025
Ø8.1 ~ Ø20	0.00 ~ 0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

(mm)

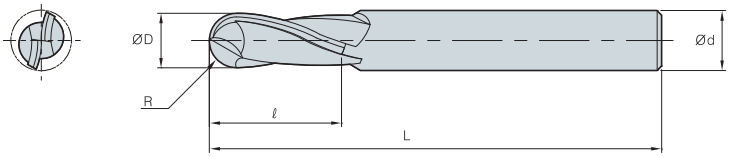
Designation		ØD	Ød	ℓ	L
APLFE 2	2030-060	3.0	6	12	60
	2040-060	4.0	6	16	60
	2050-060	5.0	6	20	60
	2060-075	6.0	6	25	75
	2080-075	8.0	8	32	75
	2100-100	10.0	10	45	100
	2120-100	12.0	12	45	100
	2160-150	16.0	16	65	150
	2200-150	20.0	20	75	150

Designation		ØD	Ød	ℓ	L
APLFE 3	3030-060	3.0	6	12	60
	3040-060	4.0	6	16	60
	3050-060	5.0	6	20	60
	3060-075	6.0	6	25	75
	3080-075	8.0	8	32	75
	3100-100	10.0	10	45	100
	3120-100	12.0	12	45	100
	3160-150	16.0	16	65	150
	3200-150	20.0	20	75	150

APBE2000 (Ball)

Shouldering | Slotting | Ramped surface | Helical milling





2 | Helix Angle 25° | Grade H05S | h6 shank

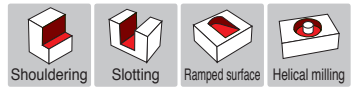
ØD	Tolerance
Ø1 ~ Ø6	0.00 ~ 0.02
Ø6.1 ~ Ø8	0.00 ~ 0.025
Ø8.1 ~ Ø20	0.00 ~ 0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

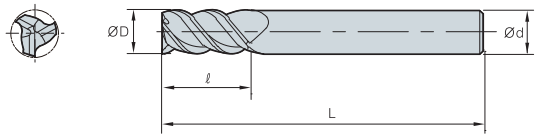
(mm)

Designation		ØD	Ød	ℓ	L
APBE 2	2010-050	1.0	4	2	50
	2015-050	1.5	4	3	50
	2020-050	2.0	4	4	50
	2025-050	2.5	4	5	50
	2030-050	3.0	4	6	50
	2035-050	3.5	4	7	50
	2040-050	4.0	4	8	50
	2045-050	4.5	6	9	50
	2050-050	5.0	6	10	50
	2055-050	5.5	6	11	50
	2060-050	6.0	6	12	50
	2080-060	8.0	8	16	60
	2100-075	10.0	10	20	75
	2120-075	12.0	12	24	75

AFE3000 (Short Flat)







3 | Helix Angle 30° | Grade H05S | h6 shank

ØD	Tolerance
Ø1 ~ Ø12	0.00 ~ -0.02
Ø12.1 ~ Ø20	0.00 ~ -0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

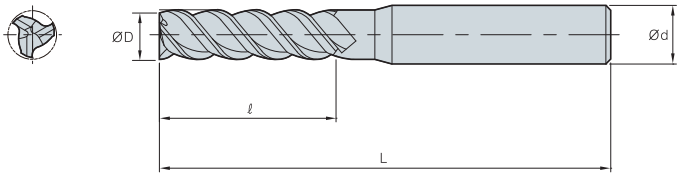
(mm)

Designation		ØD	Ød	ℓ	L
AFE 3	3010-040-V2S6	1	6	2	40
	3010-040-V2.5S6	1	6	2.5	40
	3015-040-V3S6	1.5	6	3	40
	3020-040-V3S6	2	6	3	40
	3030-045-V4S6	3	6	4	45
	3030-045-V8S6	3	6	8	45
	3040-045-V5S6	4	6	5	45
	3040-045-V8S6	4	6	8	45
	3040-045-V11S6	4	6	11	45
	3050-045-V6S6	5	6	6	45
	3060-050-V7S6	6	6	7	50
	3060-050-V13S6	6	6	13	50
	3080-060-V9S8	8	8	9	60
	3080-060-V19S8	8	8	19	60
	3100-065-V11S10	10	10	11	65
	3100-065-V22S10	10	10	22	65
	3120-070-V13S12	12	12	13	70
	3120-070-V26S12	12	12	26	70
	3160-090-V18S16	16	16	18	90
	3160-090-V32S16	16	16	32	90
	3200-090-V22S20	20	20	22	90
	3200-090-V38S20	20	20	38	90

AFE3000 (Flat)







Helix Angle	Grade	h6 shank
30°	H05S	

ØD	Tolerance
Ø1 ~ Ø12	0.00 ~ -0.02
Ø12.1 ~ Ø20	0.00 ~ -0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

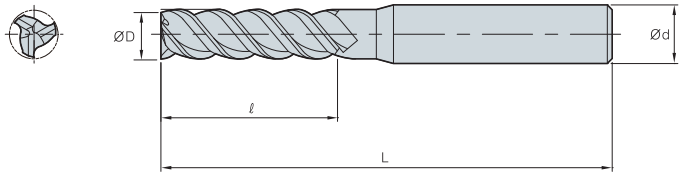
(mm)

Designation		ØD	Ød	ℓ	L
AFE	3010-050-V3S6	1	6	3	50
	3015-050-V5S6	1.5	6	5	50
	3020-050-V6S6	2	6	6	50
	3030-055-V11S6	3	6	11	55
	3040-055-V13S6	4	6	13	55
	3050-055-V17S6	5	6	17	55
	3060-060-V17S6	6	6	17	60
	3080-070-V22S8	8	8	22	70
	3100-075-V27S10	10	10	27	75
	3120-080-V32S12	12	12	32	80
	3160-100-V42S16	16	16	42	100
	3200-100-V48S20	20	20	48	100

AFE3000 (Long Flat)

Shouldering | Slotting | Ramped surface | Helical milling





3	Helix Angle 30°	Grade H05S	h6 shank

ØD	Tolerance
Ø1 ~ Ø12	0.00 ~ -0.02
Ø12.1 ~ Ø20	0.00 ~ -0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

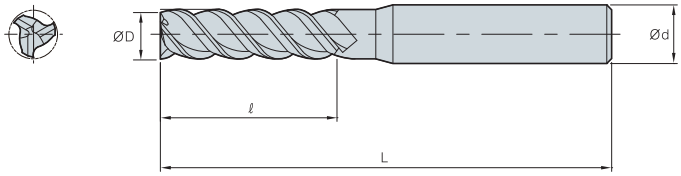
(mm)

Designation		ØD	Ød	ℓ	L
AFE 3	3010-060-V4S6	1	6	4	60
	3010-060-V6S6	1	6	6	60
	3015-060-V6S6	1.5	6	6	60
	3015-060-V8S6	1.5	6	8	60
	3015-060-V10S6	1.5	6	10	60
	3020-060-V8S6	2	6	8	60
	3020-060-V10S6	2	6	10	60
	3020-060-V12S6	2	6	12	60
	3030-065-V15S6	3	6	15	65
	3030-070-V20S6	3	6	20	70
	3030-075-V25S6	3	6	25	75
	3030-080-V30S6	3	6	30	80
	3040-065-V16S6	4	6	16	65
	3040-070-V20S6	4	6	20	70
	3040-075-V26S6	4	6	26	75
	3040-080-V30S6	4	6	30	80
	3060-060-V22S6	6	6	22	60
	3060-070-V25S6	6	6	25	70
	3060-075-V30S6	6	6	30	75
	3060-080-V35S6	6	6	35	80
	3060-090-V42S6	6	6	42	90
	3060-100-V50S6	6	6	50	100
	3080-080-V28S8	8	8	28	80
	3080-080-V30S8	8	8	30	80
	3080-085-V35S8	8	8	35	85
	3080-090-V40S8	8	8	40	90
	3080-095-V45S8	8	8	45	95
	3080-100-V50S8	8	8	50	100
	3080-105-V55S8	8	8	55	105
	3080-110-V65S8	8	8	65	110

AFE3000 (Long Flat)

Shouldering | Slotting | Ramped surface | Helical milling





3 | Helix Angle 30° | Grade H05S | h6 shank

ØD	Tolerance
Ø1 ~ Ø12	0.00 ~ -0.02
Ø12.1 ~ Ø20	0.00 ~ -0.03

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

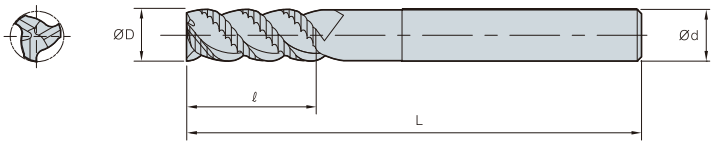
(mm)

Designation		ØD	Ød	ℓ	L
AFE 3	3100-090-V32S10	10	10	32	90
	3100-090-V35S10	10	10	35	90
	3100-090-V40S10	10	10	40	90
	3100-100-V45S10	10	10	45	100
	3100-100-V50S10	10	10	50	100
	3100-110-V55S10	10	10	55	110
	3100-110-V60S10	10	10	60	110
	3100-120-V65S10	10	10	65	120
	3120-095-V40S12	12	12	40	95
	3120-100-V45S12	12	12	45	100
	3120-100-V50S12	12	12	50	100
	3120-110-V55S12	12	12	55	110
	3120-110-V60S12	12	12	60	110
	3120-120-V65S12	12	12	65	120
	3120-120-V70S12	12	12	70	120
	3120-135-V75S12	12	12	75	135
	3160-105-V52S16	16	16	52	105
	3160-110-V55S16	16	16	55	110
	3160-130-V65S16	16	16	65	130
	3160-150-V75S16	16	16	75	150
	3160-160-V85S16	16	16	85	160
	3160-180-V95S16	16	16	95	180
	3160-190-V105S16	16	16	105	190
	3160-200-V115S16	16	16	115	200
	3200-110-V55S20	20	20	55	110
	3200-130-V65S20	20	20	65	130
	3200-150-V75S20	20	20	75	150
	3200-160-V85S20	20	20	85	160
	3200-180-V95S20	20	20	95	180
	3200-190-V105S20	20	20	105	190
	3200-200-V115S20	20	20	115	200
	3200-220-V125S20	20	20	125	220

APRE3000 (Roughing)

Shouldering | Slotting | Ramped surface | Helical milling





3 | Helix Angle 45° | Grade H05S | h6 shank

ØD	Tolerance
Ø4 ~ Ø8	0.00 ~ -0.07
Ø8.1 ~ Ø25	0.00 ~ -0.10

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

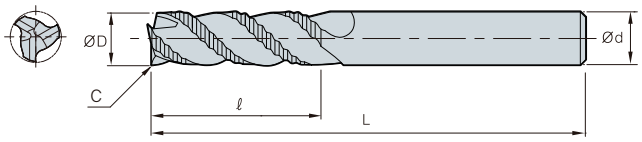
(mm)

Designation		ØD	Ød	ℓ	L
APRE 3	3040-050	4.0	6	8	50
	3050-050	5.0	6	13	50
	3060-050	6.0	6	15	50
	3065-060	6.5	8	16	60
	3070-060	7.0	8	16	60
	3075-060	7.5	8	20	60
	3080-060	8.0	8	20	60
	3085-075	8.5	10	20	75
	3090-075	9.0	10	20	75
	3095-075	9.5	10	22	75
	3100-075	10.0	10	25	75
	3110-075	11.0	12	30	75
	3120-075	12.0	12	30	75
	3130-075	13.0	14	30	75
	3140-075	14.0	16	32	75
	3150-075	15.0	16	32	75
	3160-100	16.0	16	35	100
	3170-100	17.0	20	35	100
	3180-100	18.0	20	35	100
	3200-100	20.0	20	45	100
	3250-105	25.0	25	50	105

RPAE3000 (Wave Roughing)

Shouldering | Slotting | Ramped surface | Helical milling





3 | Helix Angle 45° | Grade FN30T | h6 shank

ØD	Tolerance
Ø6~Ø10	0.000 ~ -0.058
Ø10~Ø18	0.000 ~ -0.070
Ø18~Ø25	0.000 ~ -0.084

Workpiece hardness			Workpiece material				
~HRC45	~HRC55	~HRC65	Carbon steel Alloy steel Pre hardened steel	Stainless steel	Cast iron	Aluminum	Heat resistant alloy
						◎	

(mm)

Designation		ØD	Ød	ℓ	L	C
RPAE 3	3060-063	6.0	6	18	63	0.3
	3070-063	7.0	8	23	63	0.3
	3080-063	8.0	8	23	63	0.3
	3090-080	9.0	10	30	80	0.3
	3100-080	10.0	10	30	80	0.3
	3110-080	11.0	12	32	80	0.5
	3120-080	12.0	12	32	80	0.5
	3140-080	14.0	14	32	80	0.5
	3160-105	16.0	16	48	105	0.5
	3180-105	18.0	18	48	105	0.5
	3200-105	20.0	20	50	105	0.5
	3250-105	25.0	25	50	105	0.5

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