



Aluminum Series

Professional in Aluminum machining

Pro-A Mill

Features

Mirroring on the chip breaker ensures excellent chip removal and reduces built-up edge

- High rake angle ensures excellent finishing and reduces cutting resistance.
- For shouldering, curved surface and slanted shouldering.
- Multi functional aluminum machining tool.



Shouldering



Ramping



Copying



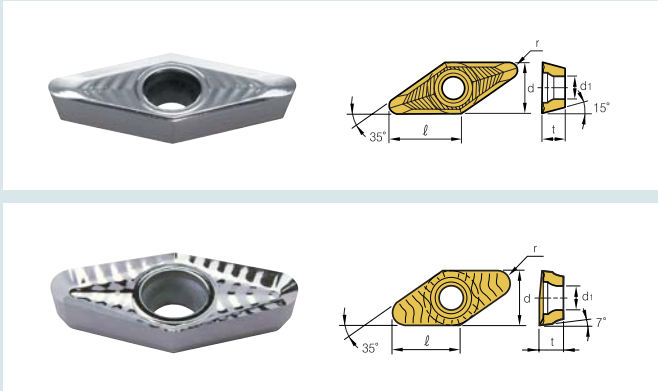
Through Coolant System



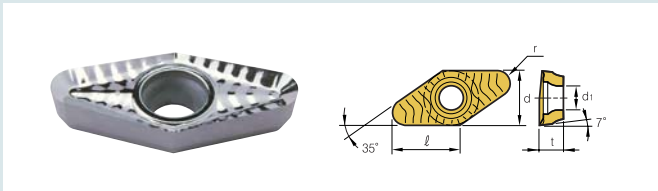
Pro-A Mill

Insert | PAM 2000 | Matching of modular head & shank adaptor

Insert

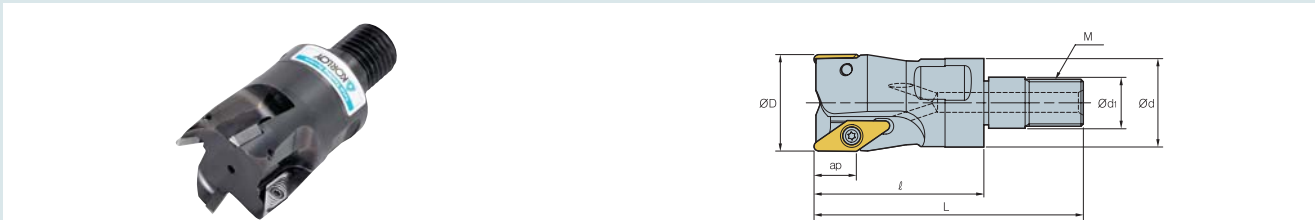




Grade	Dimensions(inch)				
	l	d	t	r	ød ₁
H01	0.346	1/4	0.113	0.039	0.110
VDKT11T210N-MA					



Grade	Dimensions(inch)				
	l	d	t	r	ød ₁
H01	0.614	1/2	7/32	0.118	0.220
VCKT220530N-MA					

PAMA 2000



Designation	Stock	Dimensions(inch)								Insert		
		øD	ød	ød ₁	l	L	M	ap				
PAMA 2050HR-M06	○	0.500	0.433	0.256	1.299	0.571	M06	1	0.315	VDKT11T210N-MA	ETNA02505	TW07S
2062HR-M08	○	0.625	0.571	0.335	1.417	0.689	M08	2	0.315	VDKT11T210N-MA	ETNA02505	TW07S
2075HR-M10	○	0.750	0.689	0.413	1.417	0.787	M10	2	0.315	VDKT11T210N-MA	ETNA02506	TW07S
2100HR-M12	○	1.000	0.906	0.492	1.614	0.866	M12	3	0.315	VDKT11T210N-MA	ETNA02506	TW07S
2125HR-M16	○	1.250	1.142	0.669	1.772	0.945	M16	4	0.315	VDKT11T210N-MA	ETNA02506	TW07S

● Stock item, ○ Under preparing for stock

Matching of modular head & shank adaptor

Designation : PAMA 2012HR - M06

Modular head screw size (M06)



Shank designation : MATA- M06 - 020 - S12S

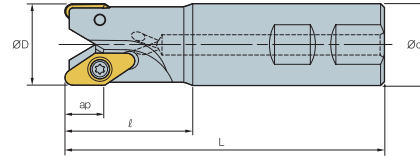
Shank adaptor screw size (M06)




Pro-A Mill

PAS 2000 / 4000 | PACM 4000

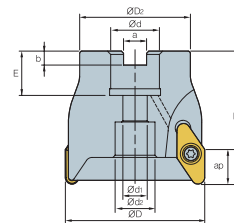
PASA 2000 / 4000






Designation	Stock	Dimensions(inch)						Insert		
		$\varnothing D$	$\varnothing d$	L	ℓ		ap			
PASA 2050HR	○	0.500	0.625	3.346	0.984	1	0.315	VDKT11T210N-MA	ETNA02505	TW07S
2062HR	○	0.625	0.625	3.543	0.984	2	0.315	VDKT11T210N-MA	ETNA02505	TW07S
2075HR	○	0.750	0.750	3.937	1.181	2	0.315	VDKT11T210N-MA	ETNA02506	TW07S
2100HR	○	1.000	1.000	4.528	1.378	3	0.315	VDKT11T210N-MA	ETNA02506	TW07S
2125HR	○	1.250	1.250	4.921	1.575	4	0.315	VDKT11T210N-MA	ETNA02506	TW07S
2150HR	○	1.500	1.250	5.118	1.654	5	0.315	VDKT11T210N-MA	ETNA02506	TW07S
4125HR	○	1.250	1.250	4.921	1.969	2	0.590	VCKT220530N-MA	FTNC04509	TW20S
4150HR	○	1.500	1.250	5.512	1.969	3	0.590	VCKT220530N-MA	FTNC04509	TW20S

● Stock item, ○ Under preparing for stock

PACA 4000



Designation	Stock	Dimensions(inch)								Insert			
		$\varnothing D$	$\varnothing D_2$	$\varnothing d$	F	a	b	E					Ad
PACA 4150HR	○	1.50	1.378	0.50	2.165	0.250	0.169	0.630	3	0.59	VCKT220530N-MA	FTNC04509	TW20S
4200HR	○	2.00	1.772	0.75	2.165	0.313	0.220	0.787	3	0.59	VCKT220530N-MA	FTNC04511	TW20S
4250HR	○	2.50	1.969	0.75	2.362	0.313	0.220	0.787	4	0.59	VCKT220530N-MA	FTNC04511	TW20S
4300HR	○	3.00	2.205	1.00	2.362	0.375	0.248	0.866	4	0.59	VCKT220530N-MA	FTNC04511	TW20S
4400HR	○	4.00	2.874	1.25	2.362	0.500	0.319	1.181	5	0.59	VCKT220530N-MA	FTNC04511	TW20S

● Stock item, ○ Under preparing for stock



Pro-A Mill

Modular adaptor (Steel)

Modular adaptor (Steel)

■ Standard type

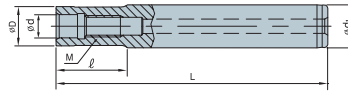


Fig 1. Straight Neck adaptor

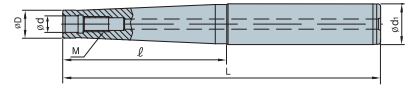


Fig 2. Taper Neck adaptor

(mm)

Designation	Stock	Fig.	Dimensions(inch)					
			M	$\varnothing D$	$\varnothing d$	$\varnothing d_1$	L	ℓ
MATA - M06-078-S038S	●	1	M06	0.354	0.375	0.256	2.756	0.787
M06-157-S050T	●	2	M06	0.354	0.500	0.256	3.780	1.575
M06-255-S063T	●	2	M06	0.354	0.625	0.256	4.921	2.559
M6B-078-S050S	●	1	M06	0.433	0.500	0.256	2.992	0.787
M6B-157-S050S	●	1	M06	0.433	0.500	0.256	3.780	1.575
M6B-255-S063T	●	2	M06	0.433	0.625	0.256	4.921	2.559
M6B-315-S063T	●	2	M06	0.433	0.625	0.256	5.512	3.150
M08-078-S063S	●	1	M08	0.571	0.625	0.335	3.150	0.787
M08-157-S063T	●	2	M08	0.571	0.625	0.335	3.937	1.575
M08-255-S063T	●	2	M08	0.571	0.625	0.335	4.921	2.559
M08-315-S075T	●	2	M08	0.571	0.750	0.335	5.906	3.150
M08-433-S100T	●	2	M08	0.571	1.000	0.335	7.480	4.331
M10-118-S075S	●	1	M10	0.689	0.750	0.413	3.937	1.181
M10-196-S075T	●	2	M10	0.689	0.750	0.413	4.724	1.969
M10-275-S075T	●	2	M10	0.689	0.750	0.413	5.512	2.756
M10-354-S100T	●	2	M10	0.689	1.000	0.413	6.693	3.543
M10-433-S100T	●	2	M10	0.689	1.000	0.413	7.480	4.331
M10-511-S125T	●	2	M10	0.689	1.250	0.413	8.661	5.118
M12-118-S100S	●	1	M12	0.906	1.000	0.492	4.331	1.181
M12-196-S100T	●	2	M12	0.906	1.000	0.492	5.118	1.969
M12-275-S100T	●	2	M12	0.906	1.000	0.492	5.906	2.756
M12-354-S100T	●	2	M12	0.906	1.000	0.492	6.693	3.543
M12-433-S125T	●	2	M12	0.906	1.250	0.492	7.874	4.331
M12-689-S150T	●	2	M12	0.906	1.500	0.492	11.811	6.890
M16-137-S125S	●	1	M16	1.142	1.250	0.669	4.921	1.378
M16-216-S125T	●	2	M16	1.142	1.250	0.669	5.709	2.165
M16-315-S125T	●	2	M16	1.142	1.250	0.669	6.693	3.150
M16-472-S125T	●	2	M16	1.142	1.250	0.669	8.268	4.724
M16-689-S150T	●	2	M16	1.142	1.500	0.669	11.811	6.890

• Available to use (FMRMA, LBEA, PAMA, AMMA, RM4PMA, HRMMA, PAXMA)

• S : Straight type

• T : Taper type

● Stock item, ○ Under preparing for stock

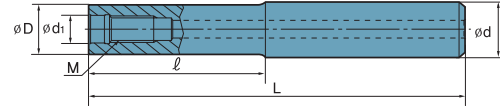


Pro-A Mill

Modular adaptor (Carbide)

Modular adaptor (Carbide)

- Standard type



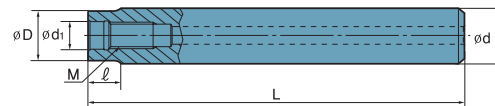
Designation	Stock	Dimensions(inch)					
		M	$\varnothing D$	$\varnothing d$	$\varnothing d_1$	L	ℓ
MATA - M08-315-S063S-C	●	M08	0.571	0.625	0.335	5.906	3.150
M08-433-S063S-C	●	M08	0.571	0.625	0.335	7.087	4.331
M08-590-S063S-C	●	M08	0.571	0.625	0.335	9.843	5.906
M10-354-S075S-C	●	M10	0.689	0.750	0.413	6.693	3.543
M10-433-S075S-C	●	M10	0.689	0.750	0.413	7.874	4.331
M10-689-S075S-C	●	M10	0.689	0.750	0.413	11.811	6.890
M12-354-S100S-C	●	M12	0.906	1.000	0.492	6.693	3.543
M12-433-S100S-C	●	M12	0.906	1.000	0.492	7.874	4.331
M12-689-S100S-C	●	M12	0.906	1.000	0.492	11.811	6.890
M16-354-S125S-C	●	M16	1.142	1.250	0.669	7.087	3.543
M16-472-S125S-C	●	M16	1.142	1.250	0.669	8.268	4.724
M16-689-S125S-C	●	M16	1.142	1.250	0.669	11.811	6.890

● Available to use (FMRMA, LBEA, PAMA, AMMA, RM4PMA, HRMMA, PAXMA)

● Stock item, ○ Under preparing for stock

Modular adaptor (Carbide)

- Standard type



Designation	Stock	Dimensions(inch)					
		M	$\varnothing D$	$\varnothing d$	$\varnothing d_1$	L	ℓ
MATA - M08-394-S063S-C-590	●	M08	0.571	0.625	0.335	5.906	0.394
M08-394-S063S-C-708	●	M08	0.571	0.625	0.335	7.087	0.394
M08-394-S063S-C-984	●	M08	0.571	0.625	0.335	9.843	0.394
M10-394-S075S-C-669	●	M10	0.689	0.750	0.413	6.693	0.394
M10-394-S075S-C-787	●	M10	0.689	0.750	0.413	7.874	0.394
M10-394-S075S-C-1181	●	M10	0.689	0.750	0.413	11.811	0.394
M12-059-S100S-C-669	●	M12	0.906	1.000	0.492	6.693	0.591
M12-059-S100S-C-787	●	M12	0.906	1.000	0.492	7.874	0.591
M12-059-S100S-C-1181	●	M12	0.906	1.000	0.492	11.811	0.591
M16-078-S125S-C-708	●	M16	1.142	1.250	0.669	7.087	0.787
M16-078-S125S-C-826	●	M16	1.142	1.250	0.669	8.268	0.787
M16-078-S125S-C-1181	●	M16	1.142	1.250	0.669	11.811	0.787

● Available to use (FMRMA, LBEA, PAMA, AMMA, RM4PMA, HRMMA, PAXMA)

● Stock item, ○ Under preparing for stock



Pro-A Mill

Pro-A Mill code system | Recommended cutting condition

Pro-A Mill code system

P	A	C	A	4	1	5	0	H	R
Pro-A Mill	Tool type	Arbor type	Insert I/C	Tool diameter	Coolant type	Hand of tool			
	- C : Cutter - S : Shank - M : Modular	- M : Metric - A : Inch	- 20 : 11 size insert - 40 : 22 size insert	- ISO : mm - AISI : inch	- H : Thru-hole - Unmarked : No thru-hole	- R : Right - L : Left			

Recommended cutting condition

Workpiece		vc (m/min)
Aluminum alloys	Rm < 280 N/mm ²	3300
	Rm > 280 N/mm ²	2640
Copper alloys	Long chip	830
Thermo plastics	-	990
Aluminum alloys	Si < 12%	2640
	Si ≥ 12%	-
Copper alloys	Short chip	1320
Magnesium alloys	-	1320
Duroplastics	-	500

Designation	fz (ipt)	ap (inch)
VDKT11T210N-MA	0.002 - 0.008	0.315
VCKT220530N-MA	0.002 - 0.012	0.590



Warning

※ Safety instruction

- Use glasses safely and face cover with protective equipment. If cutting condition and use method are inaccurate, you may be injured by broken tools or scattered chips.
- Excessive cutting load may influence badly on both tool and machine.
Make suitable tool replacement for preventing failure of machining.
- After machine stopped, clean remained chips from machine with special cleaning equipment.
- Keep safety distance from acute and hot chip during machining.
- Make precaution for prevention of fire in advance when you use insoluble cutting oil.
- Assembled parts may be scattered at high speed cutting. Please use protective equipment.

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