

AL-2E★AL-2EL

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
	Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)
1	40000	650	40000	500
2	40000	950	32000	750
3	26500	1500	21000	1100
4	20000	1600	16000	1250
5	16000	1500	13000	1100
6	13000	1250	10600	1000
8	10000	1400	8000	1100
10	8000	1600	6500	1250
12	6600	1650	5300	1300
14	5700	1700	4600	1350
16	5000	1700	4000	1350
18	4400	1700	3500	1350
20	4000	1700	3200	1350
Maximum cutting depth				

- 1.The above table shows the reference value of side milling. The feed speed in slot milling is 70% of the reference value stated in the table.
- 2.Please select high rigidity and precision machine and tool holder. Vibration and abnormal noise may be generated if the machine rigidity and workpiece fixture stability is low. Please reduce the rotating speed and feed speed stated above correspondingly.
- 3.It is possible to increase the rotating speed and feed speed correspondingly if the cutting depth is low.
- 4.Please use water-soluble cutting liquid.
- 5.Down milling is recommended in the case of side milling.
- 6.Make overhang of tool as short as possible in conditions of non-interference.

AL-3E★AL-3EL

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%		
	Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
1		40000	800	40000	600
2		40000	1200	32000	900
3		26500	1800	21000	1300
4		20000	2000	16000	1500
5		16000	1750	13000	1300
6		13000	1500	10600	1200
8		10000	1650	8000	1300
10		8000	1900	6500	1500
12		6600	1950	5300	1550
14		5700	2000	4600	1600
16		5000	2000	4000	1600
18		4400	2000	3500	1600
20		4000	2000	3200	1600
Maximum cutting depth					

- 1.The above table shows the reference value of side milling. The feed speed in slot milling is 70% of the reference value stated in the table.
- 2.Please select high rigidity and precision machine and tool holder. Vibration and abnormal noise may be generated if the machine rigidity and workpiece fixture stability is low. Please reduce the rotating speed and feed speed stated above correspondingly.
- 3.It is possible to increase the rotating speed and feed speed correspondingly if the cutting depth is low.
- 4.Please use water-soluble cutting liquid.
- 5.Down milling is recommended in the case of side milling.
- 6.Make overhang of tool as short as possible in conditions of non-interference.

Indexable milling tools

Solid carbide end mills

Cutting parameters for AL series end mills