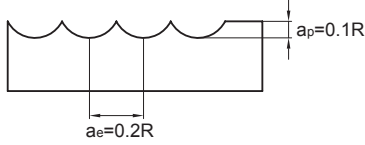


AL-2B

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)
R1.0		40000	2000	32000	1600
R1.5		26500	1950	21000	1550
R2.0		20000	1950	16000	1550
R2.5		16000	1950	13000	1550
R3.0		13000	2000	10600	1600
R4.0		10000	2450	8000	2000
R5.0		8000	2200	6500	1750
R6.0		6600	2050	5300	1650
Maximum cutting depth					

1. 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.
2. If the cutting depth is low, it is possible to increase the rotating speed and feed speed correspondingly.
3. Please use water-soluble cutting liquid.
4. Make overhang of tool as short as possible in conditions of non-interference.