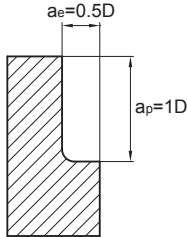


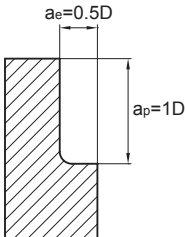
Cutting parameters for AL series end mills

AL-2R-AIR

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
Cutting speed	500~800m/min		500~800m/min	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
6	35000	3500	35000	3500
8	26000	3800	26000	3800
10	21000	4000	21000	4000
12	18000	4300	18000	4300
16	15000	4800	15000	4800
20	12000	5500	12000	5500
Maximum cutting depth				

1. Above cutting parameters are suitable for aluminium high speed machining specific CNC.
2. Please select cutting liquid or strong air cooling system for chip flowing out.
3. The sparkle by machining or heat caused by breakage might result in fire or conflagration. Please pay attention to fire prevention.
4. Dynamic balance detection should be done before machining.

AL-2RL-AIR

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
Cutting speed	500~800m/min		500~800m/min	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
6	30000	3000	30000	3000
8	24000	3200	24000	3200
10	20000	3500	20000	3500
12	16000	3800	16000	3800
16	12000	4000	12000	4000
20	10000	4600	10000	4600
Maximum cutting depth				

1. Above cutting parameters are suitable for aluminium high speed machining specific CNC.
2. Please select cutting liquid or strong air cooling system for chip flowing out.
3. The sparkle by machining or heat caused by breakage might result in fire or conflagration. Please pay attention to fire prevention.
4. Dynamic balance detection should be done before machining.

Indexable milling tools

Solid carbide end mills

Cutting parameters for AL series end mills