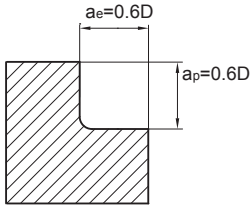


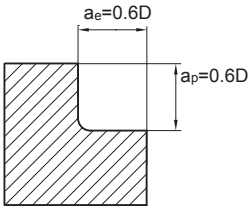
Cutting parameters for AL series end mills

AL-3R-AIR

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
Cutting speed	800~1200m/min		800~1200m/min	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
12	25000	6000	25000	6000
16	20000	6400	20000	6400
20	15000	7000	15000	7000
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-3RL-AIR

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
Cutting speed	800~1200m/min		800~1200m/min	
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
12	22000	5300	22000	5300
16	18000	5700	18000	5700
20	13000	6000	13000	6000
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.