

## ALG-2R

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si $\leq$ 10%		
	Diameter (mm)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)
1		40000	710	40000	550
2		40000	1040	32000	820
3		26500	1650	21000	1210
4		20000	1760	16000	1370
6		13000	1370	10600	1100
8		10000	1540	8000	1210
10		8000	1760	6500	1370
12		6600	1810	5300	1430
Maximum cutting depth					

- The above table shows the standard value of side milling. When milling slot, 50%~70% of rotating speed and 40%~60% of feed speed stated above are recommended as standard.
- Please select high-precision machine and tool holder.
- Please use air blow or cutting liquid with high mist retardant property.
- Down milling is recommended in the case of side milling.
- When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
- Make overhang of tool as short as possible in conditions of non-interference.

#### ALG-3R

Workpiece material	Aluminum alloy		Silicon aluminum alloy Si≤10%		
	Diameter (mm)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)
1		40000	880	40000	660
2		40000	1320	32000	990
3		26500	1980	21000	1430
4		20000	2200	16000	1650
6		13000	1650	10600	1320
8		10000	1810	8000	1430
10		8000	2090	6500	1650
12		6600	2140	5300	1700
Maximum cutting depth					

Indexable milling tools

Solid carbide end mills

Cutting parameters for ALG series end mills

1. The above table shows the standard value of side milling. When milling slot, 50%~70% of rotating speed and 40%~60% of feed speed stated above are recommended as standard.
2. Please select high-precision machine and tool holder.
3. Please use air blow or cutting liquid with high mist retardant property.
4. Down milling is recommended in the case of side milling.
5. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
6. Make overhang of tool as short as possible in conditions of non-interference.