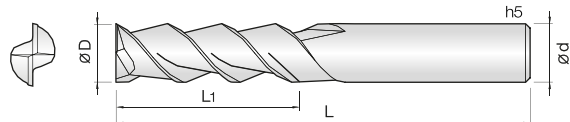


2ALE

2 Flutes 45 ° Helix End Mills for Aluminum



2

WC

RTAC
Coating

|D|
+0 -0.01

45°
Helix Angle

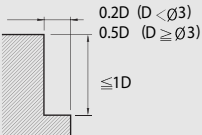
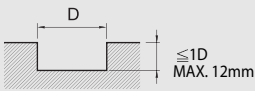
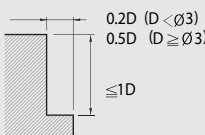
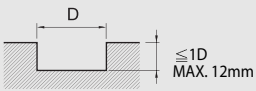
Shield Edge

ø0.5~ ø20

D Size	D Tolerance
ø0.5 ~ 20	+0 ~ -0.01 mm

2ALE / 2ALEC

•RPM: rev./min •Feed: mm/min

Material	Aluminum Alloys				Aluminum Alloys			
	Side Milling		Slotting		Side Milling		Slotting	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
ø1	34,000	500	34,000	400	34,000	400	34,000	300
ø2	34,000	950	32,300	720	32,300	720	27,200	470
ø3	27,200	1,200	21,300	800	21,300	800	18,000	510
ø4	20,400	1,300	16,000	850	16,000	850	14,000	550
ø5	16,200	1,400	13,000	850	13,000	850	11,000	600
ø6	13,600	1,600	11,000	940	11,000	940	9,400	640
ø8	10,200	1,600	8,000	1,000	8,000	1,000	6,800	680
ø10	8,100	1,600	6,500	1,000	6,500	1,000	5,400	680
ø12	6,800	1,600	5,400	1,000	5,400	1,000	4,500	680
ø16	5,100	1,600	4,100	1,000	4,100	1,000	3,400	610
ø20	4,100	1,300	3,200	850	3,200	850	2,700	560
Depth of Cut								

- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.