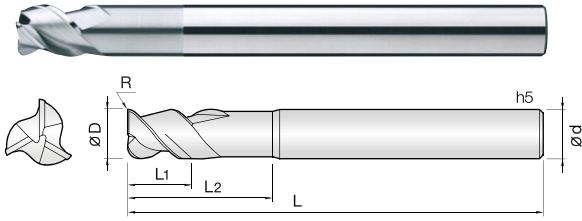




3 Flutes 45° Helix Coner Radius End Mills for Aluminum



D Size	D Tolerance
Ø6 ~ 20	+0 ~ -0.015 mm

3ALC / 3ALCC

Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	Slotting				Side Cutting			
	Aluminum Alloys				Aluminum Alloys			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø6	20,000	6,600	6	6	20,000	8,400	4.8	1.8
Ø8	18,000	5,400	8	8	18,000	7,500	6.4	2.4
Ø10	15,000	4,000	10	10	15,000	6,000	8	3
Ø12	13,000	3,200	12	12	13,000	5,400	9.6	3.6
Ø16	10,000	3,200	16	16	10,000	5,400	12.8	4.8
Ø20	8,000	3,000	10	10	8,000	5,000	16	6
Depth of Cut								

- In case of long effective length, reduce the RPM and feed by 20% or less.
- Refer to the corner radius value for side milling.
- Consider the corner radius value when you set up the Ae value.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.