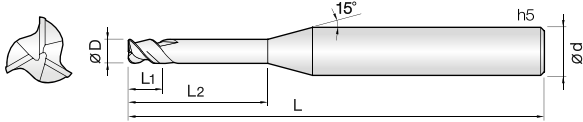
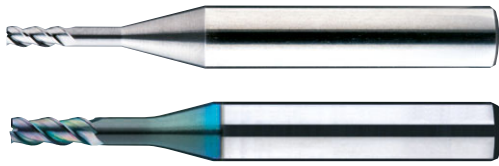


3ALR

3 Flutes 45° Helix Rib End Mills for Aluminum



3

WC

RTAC
Coating

IDI
+0 -0.01

45°
Helix Angle

Shield Edge

Ø0.8~ Ø12

D Size	D Tolerance
Ø0.8 ~ 12	+0 ~ -0.01 mm

3ALR / 3ALE

•RPM: rev./min •Feed: mm/min

Material	Aluminum Alloys etc.							
Outside Diameter	3ALR				3ALE			
	RPM	FEED			RPM	FEED		
		Vertical	Solting	Side Milling		Vertical	Solting	Side Milling
Ø1	30,000	150	900	1,100	25,500	130	770	930
Ø2	30,000	225	1,800	2,150	25,500	190	1,530	1,800
Ø3	21,600	225	2,000	2,400	18,400	190	1,700	2,000
Ø4	16,200	300	2,000	2,400	14,000	255	1,700	2,000
Ø5	13,000	300	2,000	2,400	11,000	255	1,700	2,000
Ø6	10,800	300	2,000	2,400	9,200	255	1,700	2,000
Ø8	8,100	300	2,000	2,400	7,000	255	1,700	2,000
Ø10	6,480	250	2,000	2,400	5,500	210	1,700	2,000
Ø12	5,400	200	2,000	2,400	4,400	170	1,700	2,000
Ø16	-	-	-	-	3,200	130	1,530	1,900
Ø20	-	-	-	-	2,000	85	1,360	1,700
Milling Amount (mm)		Ap=0.75D	Ap=0.75D	Ap=0.75D/ Ae=0.3D		Ap=0.75D	Ap=0.75D	Ap=0.75D/ Ae=0.3D
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.