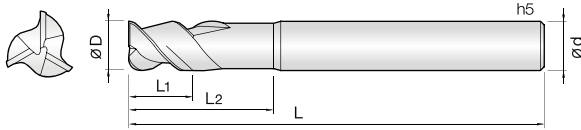




3 Flutes Semi-Finishing & Roughing End Mills for Aluminum



3

WC

JCRO
Coating

D
-0.02 -0.04

D
-0.02 -0.05

45°
Helix Angle

Shield Edge

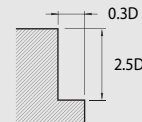
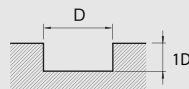
| D Size | D Tolerance |
|----------|------------------|
| Ø6 ~ 8 | -0.02 ~ -0.04 mm |
| Ø10 ~ 20 | -0.02 ~ -0.05 mm |

3ARE / 3ARC Cutting Condition

• RPM : rev./min • Feed : mm/min

| Material | Copper | | | | | | Aluminum | | | | | |
|----------|------------------|-------|----------|-------------------|--------------------|-------------------|--------------------|-------|----------|-------------------|--------------------|-------------------|
| | | | Slotting | | Side Cutting | | | | Slotting | | Side Cutting | |
| | Outside Diameter | RPM | FEED | Ap Axial Depth | Ae Radial Depth | Ap Axial Depth | Ae Radial Depth | RPM | FEED | Ap Axial Depth | Ae Radial Depth | Ap Axial Depth |
| Ø6 | 4,200 | 1,500 | 6 | 6 | 15 | 1.8 | 8,000 | 1,800 | 6 | 6 | 15 | 1.8 |
| Ø8 | 3,200 | 1,500 | 8 | 8 | 20 | 2.4 | 6,000 | 1,800 | 8 | 8 | 20 | 2.4 |
| Ø10 | 2,600 | 1,500 | 10 | 10 | 25 | 3 | 4,800 | 1,800 | 10 | 10 | 25 | 3 |
| Ø12 | 2,100 | 1,500 | 12 | 12 | 30 | 3.6 | 4,000 | 1,800 | 12 | 12 | 30 | 3.6 |
| Ø16 | 1,600 | 1,500 | 16 | 16 | 40 | 4.8 | 3,000 | 1,800 | 16 | 16 | 40 | 4.8 |
| Ø20 | 1,300 | 1,500 | 20 | 20 | 50 | 6 | 2,400 | 1,800 | 20 | 20 | 50 | 6 |

Depth of Cut



- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- In case of long effective length, reduce the RPM and feed by 20% or less.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same proportion.
- Depending on the workpiece and shape, use adequate coolant.