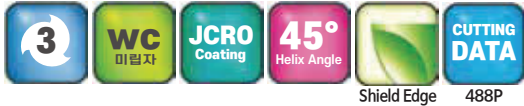


- High speed semi finishing and roughing End mills for Aluminum, AL alloys, non-ferrous and non-metallic materials.
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- Minimize built up edge by chip braker and deep pocket design.
- Minimize fracturing by high TRS fine(0.5 μ m) WC grade.
- Good surface integrity differently from competitor's AL roughing endmills.

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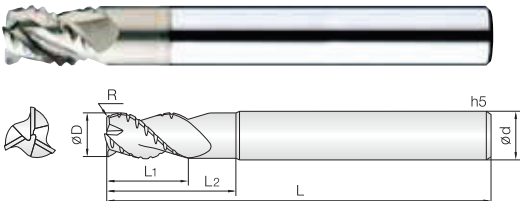


Shield Edge 488P

D Size	D Tolerance
Ø 6 ~ 8	-0.02 ~ -0.04mm
Ø 10 ~ 20	-0.02 ~ -0.05mm

: mm

Order Number	Diameter D	Length of cut L1	Effective Length L2	Overall Length L	Shank Dia d	Order Number	Diameter D	Length of cut L1	Effective Length L2	Overall Length L	Shank Dia d
3ARE 060 150 S06	6	10	15	50	6	3ARE 200 500 S20	20	35	50	110	20
3ARE 060 200 S06	6	15	20	70	6	3ARE 200 600 S20	20	45	60	120	20
3ARE 080 200 S08	8	15	20	60	8						
3ARE 080 250 S08	8	20	25	80	8						
3ARE 100 250 S10	10	18	25	70	10						
3ARE 100 300 S10	10	23	30	90	10						
3ARE 120 300 S12	12	20	30	80	12						
3ARE 120 400 S12	12	30	40	100	12						
3ARE 160 350 S16	16	25	35	110	16						
3ARE 160 500 S16	16	35	50	120	16						



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Contact Trucut Tools to order
sales@trucuttools.co.uk
Tel. 01202 717 110

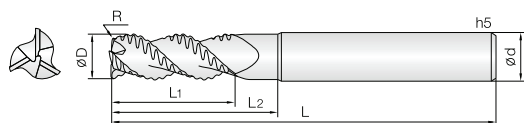


R0.5 R1 R02 ~ 3

D Size	D Tolerance
Ø 6 ~ 8	-0.02 ~ -0.04mm
Ø 10 ~ 20	-0.02 ~ -0.05mm

단위 : mm

Order Number	Diameter D × R	Length of cut L1	Effective Length L2	Overall Length L	Shank Dia d	Order Number	Diameter D × R	Length of cut L1	Effective Length L2	Overall Length L	Shank Dia d
3ARC 060 005 S06	6 × R0.5	9	15	65	6	3ARC 200 020 S20	20 × R2	30	50	110	20
3ARC 060 010 S06	6 × R1	9	15	65	6	3ARC 200 030 S20	20 × R3	30	50	110	20
3ARC 080 005 S08	8 × R0.5	12	20	70	8						
3ARC 080 010 S08	8 × R1	12	20	70	8						
3ARC 100 010 S10	10 × R1	15	25	75	10						
3ARC 100 020 S10	10 × R2	15	25	75	10						
3ARC 120 010 S12	12 × R1	20	30	80	12						
3ARC 120 020 S12	12 × R2	20	30	80	12						
3ARC 120 030 S12	12 × R3	20	30	80	12						
3ARC 160 010 S16	16 × R1	25	35	110	16						
3ARC 160 020 S16	16 × R2	25	35	110	16						
3ARC 160 030 S16	16 × R3	25	35	110	16						



- High speed semi finishing and roughing End mills for Aluminum, AL alloys, non-ferrous and non-metallic materials
- Minimize built up edge by chip braker and deep pocket design.
- TetraBond TAC coating provides excellent work surface finish by high hardness and low friction.
- Minimize fracturing at high feed by high TRS fine WC grade.

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Shield Edge 488P

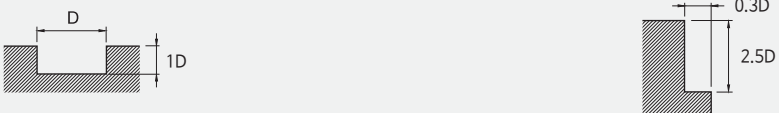
D Size	D Tolerance
Ø 4 ~ 8	-0.02 ~ -0.04mm
Ø 10 ~ 20	-0.02 ~ -0.05mm

: mm

[illegible]

3ARE/3ARC Cutting Condition

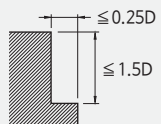
• RPM : rev./min • Feed : mm/min

Material	Copper alloys C1100						Aluminum alloys AL7075					
			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	Ae Radial Depth
ø 6	4,200	1,500	6	6	15	1.8	8,000	1,800	6	6	15	1.8
ø 8	3,200	1,500	8	8	20	2.4	6,000	1,800	8	8	20	2.4
ø 10	2,600	1,500	10	10	25	3	4,800	1,800	10	10	25	3
ø 12	2,100	1,500	12	12	30	3.6	4,000	1,800	12	12	30	3.6
ø 16	1,600	1,500	16	16	40	4.8	3,000	1,800	16	16	40	4.8
ø 20	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.

3ARO Cutting Condition

• RPM : rev./min • Feed : mm/min

	Side Cutting							
Material	Aluminum Alloys AL7075				Aluminum Alloys AC4B			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø 4	22,500	4,200	6	1	16,000	1,800	6	1
ø 5	20,250	4,900	7.5	1.25	14,400	2,000	7.5	1.25
ø 6	18,225	5,500	9	1.5	11,700	2,100	9	1.5
ø 8	13,500	5,400	12	2	9,000	2,200	12	2
ø 10	10,800	5,200	15	2.5	7,200	2,100	15	2.5
ø 12	8,775	4,800	18	3	5,900	1,900	18	3
ø 16	6,750	4,600	24	4	4,500	1,800	24	4
ø 20	5,400	4,300	30	5	3,600	1,700	30	5
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.