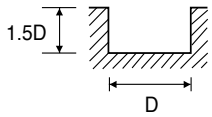
ALU-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE, 1 FLUTE
VOLLHARTMETALL, 1 SCHNEIDEN

E5E47 SERIES

MATERIAL	N							
	ACRYLIC				ALUMINUM ALUMINUM ALLOYS			
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
2.0	32000	2200	200	0.069	23000	1500	145	0.065
3.0	25000	2400	235	0.096	18000	1700	170	0.094
4.0	20000	2400	250	0.120	15000	1800	190	0.120
5.0	15000	2200	235	0.147	12000	1800	190	0.150
6.0	13500	2300	255	0.170	10000	1800	190	0.180
8.0	10000	2400	250	0.240	7800	1900	195	0.244
10.0	8000	2400	250	0.300	6000	2000	190	0.333
12.0	6700	2300	255	0.343	5000	2200	190	0.440

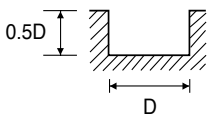


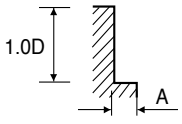
RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/tooth

CARBIDE, 2 FLUTE 45° HELIX
VOLLHARTMETALL, 2 SCHNEIDEN 45˚ RECHTSSPIRALE

E5E48, E5522, E5521 SERIES

MATERIAL	N							
	ALUMINUM ALUMINUM ALLOYS							
DIAMETER	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
3.0	10000	700	95	0.035	10000	900	95	0.045
4.0	10000	900	125	0.045	10000	1100	125	0.055
5.0	10000	1000	155	0.050	10000	1300	155	0.065
6.0	10000	1200	190	0.060	10000	1500	190	0.075
8.0	8000	1400	200	0.088	8000	1800	200	0.113
10.0	8000	1700	250	0.106	8000	2100	250	0.131
12.0	8000	2100	300	0.131	8000	2600	300	0.163
14.0	6000	1800	265	0.150	6000	2200	265	0.183
16.0	6000	1900	300	0.158	6000	2400	300	0.200
18.0	4000	1400	225	0.175	4000	1800	225	0.225
20.0	4000	1600	250	0.200	4000	1900	250	0.238





A : Ø3 ~ Ø10 = 0.25 × D
Ø12 ~ Ø20 = 0.5 × D

RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/tooth