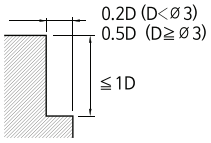
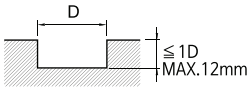
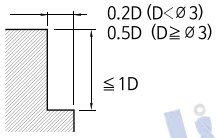
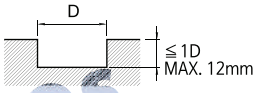
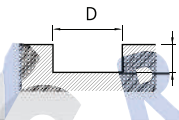
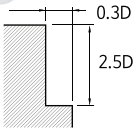
RPM : rev./min FEED : mm/min

2APE	Cutting Condition							
Material	Aluminium Alloys AL7075				Aluminium Alloys AC4B			
	Side Milling		Slotting		Side Milling		Slotting	
Outside Dia.	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
Ø 1	34000	500	34000	400	34000	400	34000	300
Ø 2	34000	950	32300	720	32300	720	27200	470
Ø 3	27200	1200	21300	800	21300	800	18000	510
Ø 4	20400	1,300	16000	850	16000	850	14000	550
Ø 5	16200	1400	13000	850	13000	850	11000	600
Ø 6	13600	1,600	11000	940	11000	940	9400	640
Ø 8	10200	1600	8000	1000	8000	1000	6800	680
Ø 10	8100	1,600	6500	1,000	6500	1,000	5400	680
Ø 12	6800	1600	5400	1000	5400	1000	4500	680
Ø 16	5100	1,600	4100	1,000	4100	1,000	3400	610
Ø 20	4100	1300	3200	850	3200	850	2700	560
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.

3AMPE	Cutting Condition							
	Slotting				Side Cutting			
Material	Aluminium Alloys AL7075				Aluminium Alloys AC4B			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 6	8000	1000	6.0	6.0	8000	1200	15.0	1.8
Ø 8	6000	1000	8.0	8.0	6000	1200	20.0	2.4
Ø 10	4800	1000	10.0	10.0	4800	1200	25.0	3.0
Ø 12	4000	1000	12.0	12.0	4000	1200	30.0	3.6
Ø 16	3000	1000	16.0	16.0	3000	1200	40.0	4.8
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.