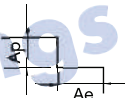
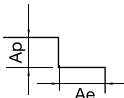
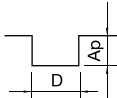


3ARE/3APE					Cutting Condition			
Material	Aluminum Alloys etc AL7075							
	3ARE Type				3APE Type			
Outside Dia.	RPM	FEED			RPM	FEED		
		Vertical	Slotting	Side Milling		Vertical	Slotting	Side Milling
Ø 1	35000	150	585	715	32000	130	501	605
Ø 2	30000	225	1170	1398	25000	190	995	1170
Ø 3	21600	225	1300	1560	18400	190	1100	1300
Ø 4	16200	300	1300	1560	14000	255	1100	1300
Ø 5	13000	300	1300	1560	11000	255	1100	1300
Ø 6	10800	300	1300	1560	9200	255	1100	1300
Ø 8	8100	300	1300	1560	7000	255	1100	1300
Ø 10	6480	250	1300	1560	5500	210	1100	1300
Ø 12	5400	200	1300	1560	4400	170	1100	1300
Ø 16	-	-	-	-	3200	130	995	1235
Ø 20	-	-	-	-	2000	85	884	1105
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								

- 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.