
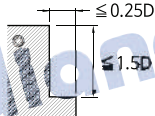


3AHRE/3AHRR							Cutting Condition					
Material	Copper Alloys C1100						Aluminium Alloys AL7075					
			Slotting		Side Milling				Slotting		Side Milling	
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	Ap Axial Depth	Ae Radial Depth
Ø 6	4200	1500	6	6	15	2	8000	1800	6	6	15	2
Ø 8	3200	1500	8	8	20	2	6000	1800	8	8	20	2
Ø 10	2600	1500	10	10	25	3	4800	1800	10	10	25	3
Ø 12	2100	1500	12	12	30	4	4000	1800	12	12	30	4
Ø 16	1600	1500	16	16	40	5	3000	1800	16	16	40	5
Ø 20	1300	1500	20	20	50	6	2400	1800	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.

3AROE					Cutting Condition			
Material	Side Cutting							
	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 4	22500	4200	6.0	1.0	16000	1800	6.0	1.0
Ø 5	20250	4900	7.5	1.3	14400	2000	7.5	1.3
Ø 6	18225	5500	9.0	1.5	11700	2100	9.0	1.5
Ø 8	13500	5400	12.0	2.0	9000	2200	12.0	2.0
Ø 10	10800	5200	15.0	2.5	7200	2100	15.0	2.5
Ø 12	8775	4800	18.0	3.0	5900	1900	18.0	3.0
Ø 16	6750	4600	24.0	4.0	4500	1800	24.0	4.0
Ø 20	5400	4300	30.0	5.0	3600	1700	30.0	5.0
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.