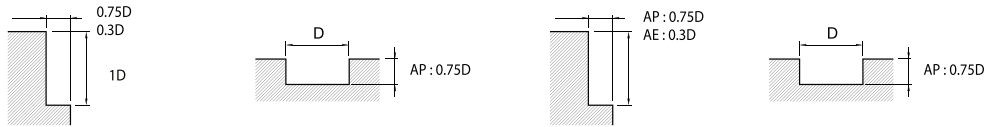


| 4AHE         |                                                                                    |      |          |      | Cutting Condition     |      |          |      |
|--------------|------------------------------------------------------------------------------------|------|----------|------|-----------------------|------|----------|------|
| Material     | Aluminium Alloys AL7075                                                            |      |          |      | Aluminium Alloys AC4B |      |          |      |
|              | Side Milling                                                                       |      | Slotting |      | Side Milling          |      | Slotting |      |
| Outside Dia. | RPM                                                                                | FEED | RPM      | FEED | RPM                   | FEED | RPM      | FEED |
| Ø 3          | 12800                                                                              | 975  | 12880    | 825  | 5796                  | 439  | 5796     | 330  |
| Ø 4          | 9800                                                                               | 975  | 9800     | 825  | 4410                  | 439  | 4410     | 330  |
| Ø 5          | 7700                                                                               | 975  | 7700     | 825  | 3465                  | 439  | 3465     | 330  |
| Ø 6          | 6440                                                                               | 975  | 6440     | 825  | 2898                  | 439  | 2898     | 330  |
| Ø 8          | 4900                                                                               | 975  | 4900     | 825  | 2205                  | 439  | 2205     | 330  |
| Ø 10         | 3850                                                                               | 975  | 3850     | 825  | 1733                  | 439  | 1733     | 330  |
| Ø 12         | 3080                                                                               | 975  | 3080     | 825  | 1386                  | 439  | 1386     | 330  |
| Ø 16         | 2240                                                                               | 926  | 2240     | 746  | 1008                  | 417  | 1008     | 298  |
| Ø 20         | 1400                                                                               | 829  | 1400     | 663  | 630                   | 373  | 630      | 265  |
| 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.