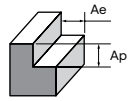


Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

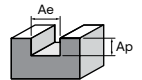


AL SE Long Endmills , 3 Flutes - G51



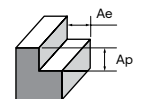
Side Milling	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	1.00 x D		1.00 x D		1.00 x D		1.00 x D	
Cutting Width, ae	0.30 x D		0.30 x D		0.30 x D		0.30 x D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	305	0.015	270	0.013	200	0.011	285	0.014
4		0.024		0.021		0.018		0.022
5		0.031		0.028		0.024		0.029
6		0.038		0.034		0.029		0.035
8		0.051		0.047		0.040		0.048
10		0.065		0.059		0.052		0.062
12		0.080		0.073		0.065		0.077
14		0.092		0.083		0.073		0.088

AL SE Endmills, 4 Flutes - C45, C51, S42



Slotting	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	1.00 x D		1.00 x D		1.00 x D		1.00 x D	
Cutting Width, ae	1.00 x D		1.00 x D		1.00 x D		1.00 x D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	350	0.013	310	0.012	220	0.010	330	0.012
4		0.022		0.020		0.016		0.020
5		0.028		0.025		0.021		0.026
6		0.034		0.031		0.027		0.032
8		0.047		0.042		0.037		0.044
10		0.059		0.054		0.048		0.057
12		0.073		0.067		0.060		0.071
14		0.084		0.076		0.068		0.081
16		0.094		0.085		0.074		0.090
20		0.112		0.101		0.086		0.108

AL SE Endmills, 4 Flutes - C45, C51, S42



Side Milling	N						O	
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Thermoplastic	
Properties	Si < 9%		Si ≥ 9%		-		-	
Cutting depth, ap	1.00 x D		1.00 x D		1.00 x D		1.00 x D	
Cutting Width, ae	0.30 x D		0.30 x D		0.30 x D		0.30 x D	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
3	400	0.014	360	0.013	260	0.011	380	0.013
4		0.024		0.021		0.019		0.022
5		0.031		0.027		0.025		0.028
6		0.038		0.033		0.031		0.035
8		0.051		0.046		0.043		0.048
10		0.065		0.059		0.055		0.062
12		0.080		0.073		0.069		0.077
14		0.092		0.084		0.078		0.088
16		0.104		0.094		0.086		0.099
20		0.128		0.115		0.104		0.121