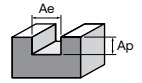


Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

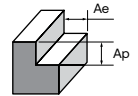


AL SE Endmills, 3 Flutes - 303, G50, G69, G70, K30, K31



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
1	330	0.008	290	0.006	200	0.003	310	0.007
2		0.010		0.008		0.006		0.009
3		0.016		0.014		0.010		0.015
4		0.026		0.022		0.017		0.024
5		0.033		0.029		0.023		0.031
6		0.041		0.036		0.029		0.038
8		0.056		0.049		0.040		0.052
10		0.071		0.063		0.053		0.067
12		0.088		0.078		0.067		0.084
14		0.100		0.089		0.075		0.095
16		0.112		0.098		0.083		0.106
18		0.123		0.107		0.089		0.116
20	0.133	0.116	0.094	0.125				

AL SE Endmills, 3 Flutes - 303, G50, G69, G70, K30, K31



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
1	380	0.011	340	0.009	250	0.006	360	0.010
2		0.013		0.010		0.008		0.010
3		0.018		0.016		0.014		0.017
4		0.030		0.027		0.022		0.028
5		0.038		0.035		0.029		0.036
6		0.047		0.042		0.036		0.045
8		0.064		0.058		0.050		0.061
10		0.081		0.074		0.064		0.078
12		0.099		0.091		0.080		0.096
14		0.114		0.103		0.091		0.110
16		0.128		0.116		0.101		0.123
18		0.141		0.128		0.109		0.135
20	0.154	0.139	0.117	0.147				

ALU LINE
EZ LINE - ENDMILL
SE 30
NITICO 30
OPTIMUM
SE 45
SE 45X
NITICO 45
SE 60
SE 60X
DN70 - SE70
SE GR
TE 45
PLUNGE -MILL
THREAD MILL