AL2D-2DLC

Size ϕ 0.5 ～ ϕ 12

DLC

AL2D-2DLC

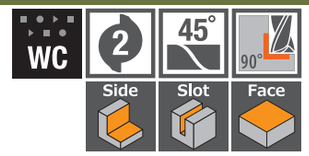
Aluminium Milling

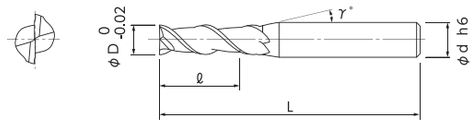
DLC COATING 2-Flute L/D=2 End Mill for Aluminium

Total 22 sizes

Recommended Milling Conditions

2-flute end mill for aluminium. L/D=2
DLC coating applied for longer tool life





● Adopted NS TOOL original DLC COATING that suitable for long time machining.

Unit : mm

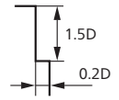
Code No.	Dia. (D)	Length of Cut (ℓ)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
01-00661-00050	0.5	1	9°	4	45
01-00661-00060	0.6	1.2	9°	4	45
01-00661-00070	0.7	1.4	9°	4	45
01-00661-00080	0.8	1.6	9°	4	45
01-00661-00090	0.9	1.8	9°	4	45
01-00661-00100	1	2	9°	4	45
01-00661-00150	1.5	3	9°	4	45
01-00661-00200	2	4	9°	4	45
01-00661-00250	2.5	5	9°	4	45
01-00661-00300	3	6	9°	6	50
01-00661-00350	3.5	7	9°	6	50
01-00661-00400	4	8	9°	6	50
01-00661-00450	4.5	9	9°	6	55
01-00661-00500	5	10	9°	6	55
01-00661-00550	5.5	11	9°	6	55
01-00661-00600	6	12	–	6	55
01-00661-00700	7	14	9°	8	70
01-00661-00800	8	16	–	8	70
01-00661-00900	9	18	9°	10	75
01-00661-01000	10	20	–	10	75
01-00661-01100	11	22	9°	12	80
01-00661-01200	12	24	–	12	80

How to Order When you order, indicate AL2D-2DLC (D). ※(γ) is reference value.

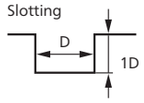
Work Material	Aluminium A1070				Aluminium Alloy A2017·A5052·A7075				Aluminium Cast AC8C			
Cutting Speed	340m/min		270m/min		380m/min		300m/min		280m/min		200m/min	
Dia.	Side Milling		Slotting		Side Milling		Slotting		Side Milling		Slotting	
	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed	Spindle Speed	Feed
	min^{-1}	mm/min	min^{-1}	mm/min	min^{-1}	mm/min	min^{-1}	mm/min	min^{-1}	mm/min	min^{-1}	mm/min
0.5	20,000	400	20,000	200	20,000	400	20,000	300	20,000	400	20,000	300
1	20,000	700	20,000	400	20,000	700	20,000	400	20,000	700	20,000	400
1.5	20,000	800	20,000	500	20,000	800	20,000	500	20,000	800	20,000	500
2	20,000	1,000	20,000	600	20,000	1,000	20,000	600	20,000	1,000	20,000	600
2.5	20,000	1,200	20,000	700	20,000	1,200	20,000	700	20,000	1,200	20,000	700
3	20,000	1,300	20,000	800	20,000	1,500	20,000	900	20,000	1,500	20,000	800
4	20,000	1,500	20,000	900	20,000	1,700	20,000	1,100	20,000	1,700	15,900	800
5	20,000	1,700	17,200	900	20,000	2,000	19,100	1,300	17,800	1,700	12,700	800
6	18,000	1,800	14,300	900	20,000	2,200	15,900	1,300	14,900	1,700	10,600	800
7	15,500	1,800	12,300	900	17,300	2,300	13,600	1,300	12,700	1,700	9,100	800
8	13,500	1,800	10,700	1,000	15,100	2,400	11,900	1,300	11,100	1,800	8,000	800
9	12,000	1,800	9,600	1,000	13,400	2,400	10,600	1,300	9,900	1,800	7,100	800
10	10,800	1,800	8,600	1,000	12,100	2,400	9,600	1,300	8,900	1,800	6,400	800
11	9,800	1,900	7,800	1,000	11,000	2,500	8,700	1,300	8,100	1,800	5,800	800
12	9,000	2,000	7,200	1,100	10,100	2,500	8,000	1,400	7,400	1,800	5,300	900

Depth of Cut (D:Dia.)

Side Milling



Slotting



Notes

※ 1 Adjust both the spindle speed and feed at the same rate.
(When using spindle speed 20,000 or more, the same adjustment is required.)
※ 2 Use a rigid and precise machine and chuck holder.
※ 3 Adjust milling conditions when vibration and abnormal sounds occur according to the rigidity of the machine and the chuck holder, or work clamping condition.
※ 4 Water-soluble fluid is recommended.

N Aluminium Alloy
N Copper
O Resin
Square Coating