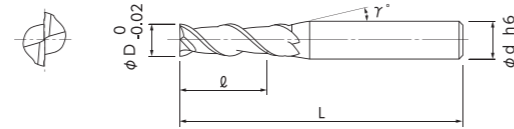
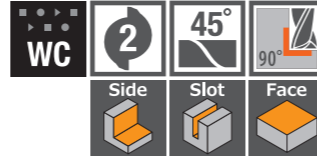


DLC COATING 2-Flute L/D=3 End Mill for Aluminium

Total 14 sizes

Recommended Milling Conditions

2-flute end mill for aluminium. L/D=3  
DLC coating applied for longer tool life



- AL-series realized a stable and high efficient machining.
- Adopted NS TOOL original DLC COATING that suitable for long time machining.

- Aluminium Alloy **N**
- Copper **N**
- Resin **O**

- Aluminium Alloy **N**
- Copper **N**
- Resin **O**

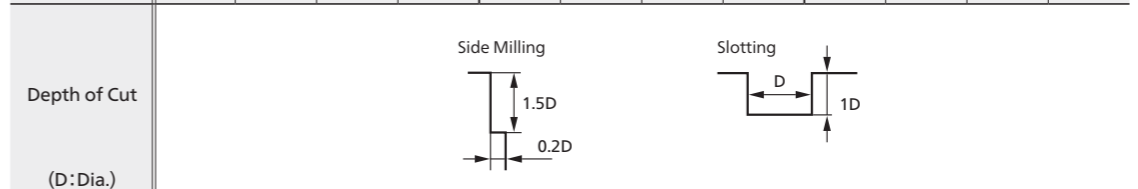


Unit : mm

Code No.	Dia. (D)	Length of Cut (L)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
01-00635-00100	1	3	9°	4	45
01-00635-00150	1.5	4.5	9°	4	45
01-00635-00200	2	6	9°	4	45
01-00635-00250	2.5	7.5	9°	4	45
01-00635-00300	3	9	9°	6	50
01-00635-00400	4	12	9°	6	50
01-00635-00500	5	15	9°	6	55
01-00635-00600	6	18	-	6	60
01-00635-00700	7	21	9°	8	70
01-00635-00800	8	24	-	8	70
01-00635-00900	9	27	9°	10	75
01-00635-01000	10	30	-	10	75
01-00635-01100	11	33	9°	12	90
01-00635-01200	12	36	-	12	90

**How to Order** When you order, indicate AL3D-2DLC (D). ※ (γ) is reference value.

Work Material	Aluminium A1070		Aluminium Alloy A2017·A5052·A7075				Aluminium Cast AC8C					
	Cutting Speed		330m/min		240m/min		250m/min		160m/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 <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min
1	20,000	400	20,000	300	20,000	400	20,000	300	20,000	400	20,000	300
1.5	20,000	500	20,000	400	20,000	500	20,000	400	20,000	500	20,000	400
2	20,000	600	20,000	400	20,000	600	20,000	400	20,000	600	20,000	400
2.5	20,000	700	20,000	500	20,000	700	20,000	500	20,000	700	20,000	500
3	20,000	900	20,000	600	20,000	900	20,000	600	20,000	900	17,000	500
4	20,000	1,000	17,500	700	20,000	1,000	19,000	750	20,000	1,000	13,000	500
5	19,000	1,000	14,000	700	20,000	1,200	15,500	750	16,000	1,000	10,000	500
6	16,000	1,100	11,500	700	17,500	1,400	12,500	750	13,500	1,000	8,500	500
7	13,500	1,100	10,000	750	15,000	1,500	11,000	800	11,500	1,100	7,300	500
8	12,000	1,100	8,800	750	13,000	1,600	9,600	800	9,900	1,200	6,400	500
9	11,000	1,100	7,800	750	11,700	1,600	8,500	800	8,800	1,200	5,700	500
10	9,600	1,100	7,000	800	10,500	1,700	7,600	850	8,000	1,300	5,100	550
11	8,700	1,100	6,400	800	9,600	1,700	6,900	850	7,200	1,300	4,600	550
12	8,000	1,200	5,800	800	8,800	1,700	6,400	900	6,600	1,300	4,200	600



**Notes**

- ※ 1 Adjust both 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 by the conditions of the machine, chuck holder and work clamping.
- ※ 4 Water-soluble fluid is recommended.