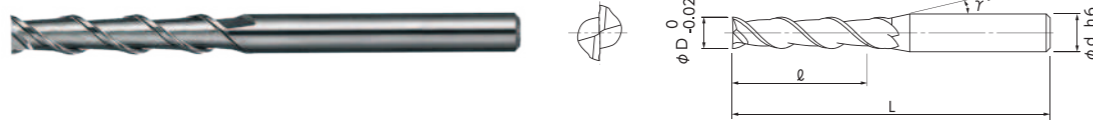
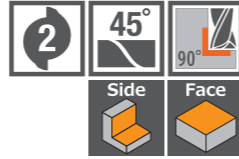


2-Flute L/D=5 End Mill for Aluminium

Total 14 sizes

Recommended Milling Conditions

2-flute end mill for aluminium. L/D=5
Reducing chattering and burr by cutting edge design for aluminium



- AL-series realized a stable and high efficient machining.
- It exhibits stable excellent surface on a wide area and no chattering occurs even during high speed cutting.

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

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

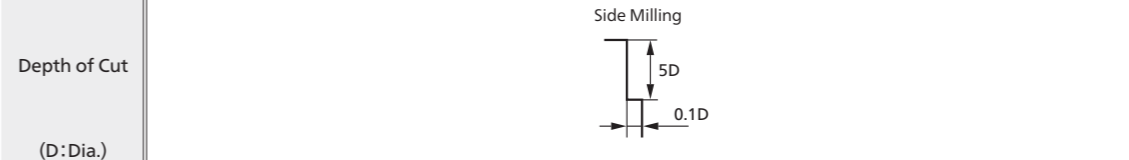


Unit : mm

| Code No. | Dia. (D) | Length of Cut (L) | Neck Taper Angle (γ) | Shank Dia. (d) | Overall Length (L) |
|----------------|----------|-------------------|----------------------|----------------|--------------------|
| 01-00634-00100 | 1 | 5 | 9° | 4 | 50 |
| 01-00634-00150 | 1.5 | 7.5 | 9° | 4 | 50 |
| 01-00634-00200 | 2 | 10 | 9° | 4 | 50 |
| 01-00634-00250 | 2.5 | 12.5 | 9° | 4 | 50 |
| 01-00634-00300 | 3 | 15 | 9° | 6 | 55 |
| 01-00634-00400 | 4 | 20 | 9° | 6 | 60 |
| 01-00634-00500 | 5 | 25 | 9° | 6 | 65 |
| 01-00634-00600 | 6 | 30 | - | 6 | 75 |
| 01-00634-00700 | 7 | 35 | 9° | 8 | 90 |
| 01-00634-00800 | 8 | 40 | - | 8 | 90 |
| 01-00634-00900 | 9 | 45 | 9° | 10 | 100 |
| 01-00634-01000 | 10 | 50 | - | 10 | 100 |
| 01-00634-01100 | 11 | 55 | 9° | 12 | 110 |
| 01-00634-01200 | 12 | 60 | - | 12 | 110 |

How to Order When you order, indicate AL5D-2 (D). ※(γ) is reference value.

| Work Material | Aluminium A1070 | | Aluminium Alloy A2017·A5052·A7075 | | Aluminium Cast AC8C | |
|---------------|-------------------|--------|-----------------------------------|--------|---------------------|--------|
| Cutting Speed | 160m/min | | 230m/min | | 120m/min | |
| Dia. | Side Milling | | Side Milling | | Side Milling | |
| | Spindle Speed | Feed | Spindle Speed | Feed | Spindle Speed | Feed |
| | min ⁻¹ | mm/min | min ⁻¹ | mm/min | min ⁻¹ | mm/min |
| 1 | 20,000 | 200 | 20,000 | 200 | 20,000 | 200 |
| 1.5 | 20,000 | 250 | 20,000 | 250 | 20,000 | 300 |
| 2 | 20,000 | 300 | 20,000 | 300 | 19,000 | 300 |
| 2.5 | 20,000 | 400 | 20,000 | 400 | 15,300 | 300 |
| 3 | 17,000 | 450 | 20,000 | 450 | 12,700 | 400 |
| 4 | 12,700 | 500 | 18,000 | 700 | 9,600 | 400 |
| 5 | 10,000 | 650 | 14,600 | 700 | 7,600 | 400 |
| 6 | 8,500 | 650 | 12,000 | 800 | 6,400 | 400 |
| 7 | 7,300 | 650 | 10,500 | 900 | 5,500 | 450 |
| 8 | 6,400 | 650 | 9,100 | 900 | 4,800 | 500 |
| 9 | 5,700 | 700 | 8,100 | 1,000 | 4,300 | 550 |
| 10 | 5,100 | 700 | 7,300 | 1,000 | 3,800 | 550 |
| 11 | 4,600 | 750 | 6,700 | 1,100 | 3,500 | 550 |
| 12 | 4,300 | 800 | 6,100 | 1,100 | 3,200 | 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.