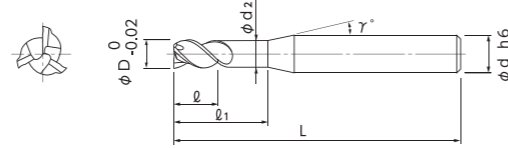


DLC COATING high efficient 3-Flute End Mill for Aluminium L/D=1.5

Total 17 sizes

Recommended Milling Conditions

For machining on aluminium alloy. Continuous machining from plunging without guide-hole and stepping to slotting



※ Listed at "High Efficient Milling" as well (Page I-020)

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

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

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

Unit : mm

Code No.	Dia. (D)	Under neck Length (l1)	Length of Cut (l)	Neck Dia. (d2)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
01-00666-00100	1	3	1.5	0.95	12°	4	45
01-00666-00150	1.5	4.5	2.3	1.45	12°	4	45
01-00666-00200	2	6	3	1.94	12°	4	45
01-00666-00250	2.5	7.5	3.8	2.4	12°	4	45
01-00666-00300	3	9	4.5	2.85	12°	6	55
01-00666-00350	3.5	10.5	5.3	3.35	12°	6	55
01-00666-00400	4	12	6	3.8	12°	6	55
01-00666-00450	4.5	13.5	6.8	4.3	12°	6	55
01-00666-00500	5	15	7.5	4.8	12°	6	55
01-00666-00550	5.5	16.5	8.3	5.3	12°	6	55
01-00666-00600	6	18	9	5.8	-	6	60
01-00666-00700	7	21	10.5	6.8	12°	8	70
01-00666-00800	8	24	12	7.8	-	8	70
01-00666-00900	9	27	13.5	8.8	12°	10	75
01-00666-01000	10	30	15	9.8	-	10	75
01-00666-01100	11	33	16.5	10.8	12°	12	80
01-00666-01200	12	36	18	11.8	-	12	80

How to Order

When you order, indicate ALZ345-DLC (D). ※(γ) is reference value.

Work Material	Aluminium A1070			Aluminium Alloy A2017·A5052·A7075			Aluminium Cast AC8C						
	310m/min			350m/min			230m/min						
	Dia.	Spindle Speed	Feed			Spindle Speed	Feed			Spindle Speed	Feed		
Plunging			Slotting	Side Milling	Plunging		Slotting	Side Milling	Plunging		Slotting	Side Milling	
		min ⁻¹	mm/min			min ⁻¹	mm/min			min ⁻¹	mm/min		
1	20,000	200	600	1,100	20,000	200	600	1,100	20,000	150	600	1,100	
2	20,000	300	900	1,500	20,000	300	900	1,500	20,000	250	900	1,500	
3	20,000	300	1,200	2,000	20,000	300	1,400	2,200	20,000	250	1,200	2,200	
4	20,000	300	1,400	2,200	20,000	400	1,800	2,500	18,300	200	1,400	2,300	
5	19,700	300	1,500	2,500	20,000	400	2,200	3,100	14,600	150	1,400	2,100	
6	16,500	300	1,600	2,500	18,600	400	2,500	3,500	12,200	150	1,400	2,100	
7	14,100	200	1,600	2,500	15,900	400	2,500	3,500	10,500	140	1,400	2,100	
8	12,300	200	1,700	2,500	13,900	400	2,600	3,500	9,200	120	1,400	2,200	
9	11,000	200	1,700	2,500	12,400	300	2,600	3,500	8,100	120	1,400	2,200	
10	9,900	100	1,700	2,500	11,100	300	2,600	3,800	7,300	80	1,400	2,200	
11	9,000	100	1,800	2,600	10,100	300	2,600	4,100	6,700	80	1,400	2,200	
12	8,200	100	1,900	2,700	9,300	300	2,600	4,100	6,100	60	1,500	2,200	

Depth of Cut
(D:Dia.)



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 When tending to have chip packing during plunging, step milling is recommended.
- ※ 5 Water-soluble fluid is recommended.

