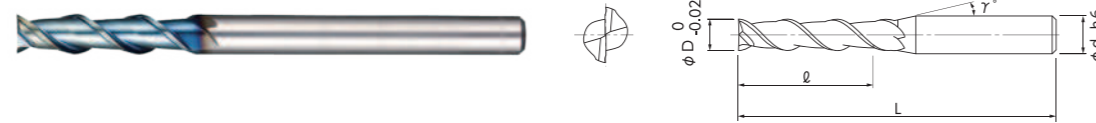
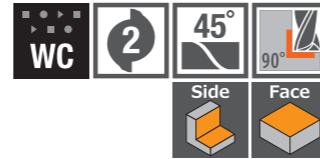


DLC COATING 2-Flute L/D=4 End Mill for Aluminium

Total 14 sizes

Recommended Milling Conditions

2-flute end mill for aluminium.
L/D=4. DLC coating applied for longer tool life



● 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**

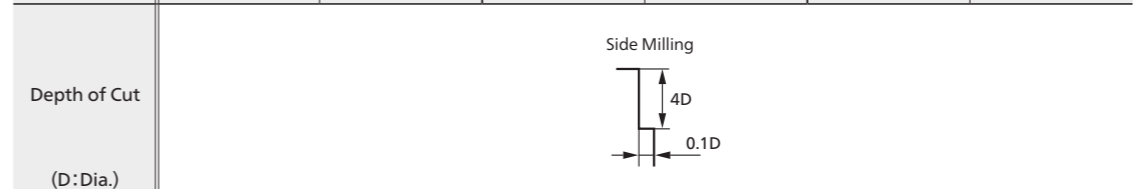


Unit : mm

Code No.	Dia. (D)	Length of Cut (L)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
01-00663-00100	1	4	9°	4	50
01-00663-00150	1.5	6	9°	4	50
01-00663-00200	2	8	9°	4	50
01-00663-00250	2.5	10	9°	4	50
01-00663-00300	3	12	9°	6	55
01-00663-00400	4	16	9°	6	60
01-00663-00500	5	20	9°	6	65
01-00663-00600	6	24	-	6	75
01-00663-00700	7	28	9°	8	90
01-00663-00800	8	32	-	8	90
01-00663-00900	9	36	9°	10	100
01-00663-01000	10	40	-	10	100
01-00663-01100	11	44	9°	12	110
01-00663-01200	12	48	-	12	110

How to Order When you order, indicate AL4D-2DLC (D). ※(γ) is reference value.

Work Material	Aluminium A1070		Aluminium Alloy A2017·A5052·A7075		Aluminium Cast AC8C	
Cutting Speed	190m/min		280m/min		150m/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	220	20,000	220	20,000	220
1.5	20,000	270	20,000	270	20,000	320
2	20,000	320	20,000	320	20,000	340
2.5	20,000	430	20,000	430	18,500	400
3	20,000	570	20,000	570	15,000	520
4	15,500	650	20,000	840	11,500	520
5	12,000	840	17,500	900	9,100	520
6	10,200	840	14,500	1,050	7,700	520
7	8,800	840	12,600	1,150	6,600	580
8	7,700	840	11,000	1,150	5,800	650
9	6,800	900	9,700	1,300	5,200	720
10	6,100	900	8,800	1,300	4,600	720
11	5,500	980	8,000	1,450	4,200	720
12	5,200	1,050	7,300	1,450	3,800	780



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.