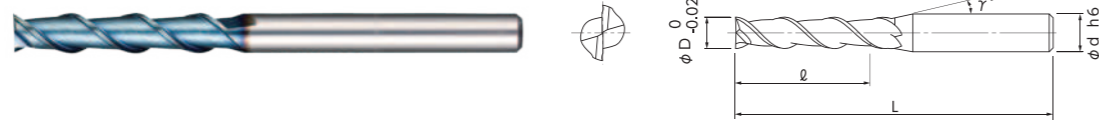
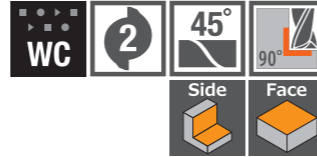


DLC COATING 2-Flute L/D=5 End Mill for Aluminium

Total 14 sizes

Recommended Milling Conditions

2-flute end mill for aluminium. L/D=5.
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**

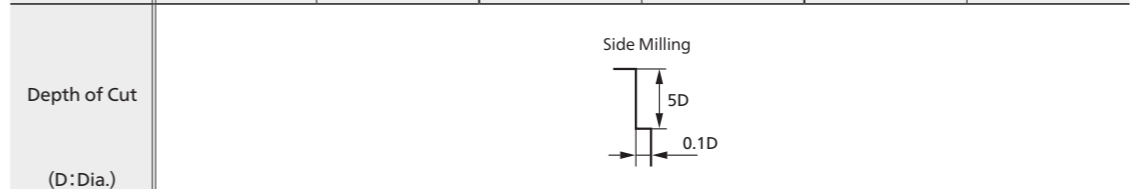


Unit : mm

Code No.	Dia. (D)	Length of Cut (L)	Neck Taper Angle (γ)	Shank Dia. (d)	Overall Length (L)
01-00664-00100	1	5	9°	4	50
01-00664-00150	1.5	7.5	9°	4	50
01-00664-00200	2	10	9°	4	50
01-00664-00250	2.5	12.5	9°	4	50
01-00664-00300	3	15	9°	6	55
01-00664-00400	4	20	9°	6	60
01-00664-00500	5	25	9°	6	65
01-00664-00600	6	30	—	6	75
01-00664-00700	7	35	9°	8	90
01-00664-00800	8	40	—	8	90
01-00664-00900	9	45	9°	10	100
01-00664-01000	10	50	—	10	100
01-00664-01100	11	55	9°	12	110
01-00664-01200	12	60	—	12	110

How to Order When you order, indicate AL5D-2DLC (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.