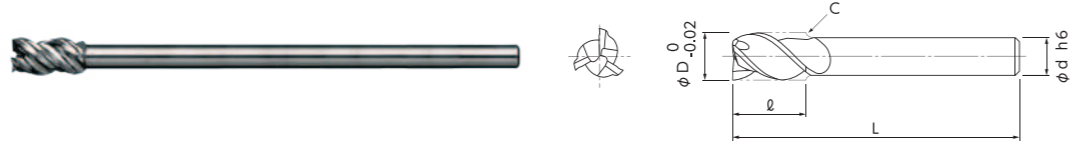
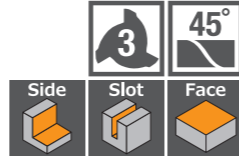


3-Flute Long Shank End Mill for Aluminium

Total 5 sizes

Recommended Milling Conditions

3-flute long shank end mill for aluminium for deeper area milling



- Slimmed shank suits side milling.
- Corner-C at flute end effects an accurate side step milling.

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

Unit : mm

Code No.	Dia. (D)	Length of Cut (L)	Shank Dia. (d)	Overall Length (L)
01-00637-00500	5	7.5	4	80
01-00637-00600	6	9	4	80
01-00637-00800	8	12	6	110
01-00637-01000	10	15	8	130
01-00637-01200	12	18	10	150

How to Order When you order, indicate AL-3LS (D).

Work Material	Aluminium A1070	Aluminium Alloy A2017·A5052·A7075		Aluminium Cast AC8C					
Cutting Speed	100~250m/min		150~300m/min		100~200m/min				
Dia.	Spindle Speed	Feed		Spindle Speed	Feed		Spindle Speed	Feed	
		Slotting	Side Milling		Slotting	Side Milling		Slotting	Side Milling
	min ⁻¹	mm/min		min ⁻¹	mm/min		min ⁻¹	mm/min	
5	16,000	1,200	1,700	19,000	1,700	2,300	13,000	1,200	1,600
6	13,000	1,000	1,400	16,000	1,400	1,900	10,600	900	1,100
8	10,000	1,350	1,800	12,000	2,000	2,500	8,000	1,200	1,500
10	8,000	1,450	1,900	9,500	1,850	2,500	6,300	1,200	1,700
12	6,600	1,400	1,700	7,900	1,750	2,800	5,300	1,200	1,600

Depth of Cut (D: Dia.)

a_p
 $\phi 5, 6=0.1D$
 $\phi 8=0.2D$
 $\phi 10, 12=0.3D$

Above recommended milling conditions are based on 4D overhang. In case of more than 4D overhang, refer to the below table.

Overhang	Spindle Speed	Feed		Depth of Cut	
		Slotting	Side Milling	Slotting	Side Milling
5D	70%	70%		60%	$a_p 1D \times a_e 0.05D$
6D	50%	50%		40%	$a_p 1D \times a_e 0.03D$
7D	30%	30%		20%	$a_p 1D \times a_e 0.015D$

Notes

- ※ 1 Adjust both spindle speed and feed at the same rate.
- ※ 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.

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

