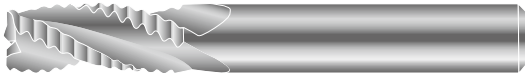


3AESL

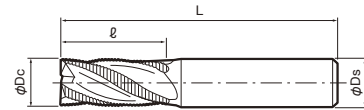
Number of Flutes: 3

Roughing of Aluminum (Long)



Recommended Material

★ 1st Recommendation

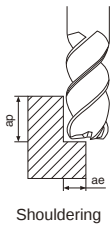


Lineup

(Unit: mm)

Description	Std.	Outside Dia.	Outside Dia. tolerance	Edge Length	Shank Dia.	Total length	Spec of Corners	Number of Flutes
		øDc		l	øDs	L	C	Z
3AESL060-240-06	●	6	-0.030 -0.105	24	6	76	0.6	3
3AESL080-280-08	●	8	-0.040 -0.130	28	8	76	0.6	3
3AESL100-340-10	●	10	-0.040 -0.130	34	10	89	0.6	3
3AESL120-450-12	●	12	-0.050 -0.160	45	12	100	1	3
3AESL160-560-16	●	16	-0.050 -0.160	56	16	125	1	3
3AESL200-600-20	●	20	-0.065 -0.195	60	20	125	1	3
3AESL250-800-25	●	25	-0.065 -0.195	80	25	150	1	3

Recommended Cutting Conditions



Shouldering

Workpiece Materials	Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
Aluminum Alloy	2.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	23,000	17,500	14,000	11,600	8,700	7,000	5,600
		Feed Rate (mm/min)	3,760	3,600	3,560	3,490	3,420	3,390	3,350
High-silicon Aluminum	2.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,800
		Feed Rate (mm/min)	1,000	970	950	920	910	900	900

Not Recommended for Slotting.

