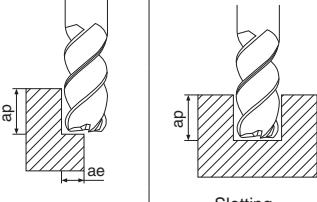
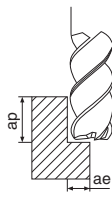


Recommended Cutting Conditions

3NFSM

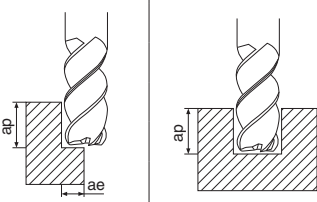
Application		Workpiece Material	Application	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø3	ø6	ø8	ø10	ø12	ø16	ø20
 <p>Shouldering Slotting</p>	Aluminum Alloys	Shouldering	1Dc×0.5Dc	Spindle Revolution (min ⁻¹)	26,500	13,300	10,000	8,000	6,600	5,000	4,000	
				Feed Rate (mm/min)	1,040	1,400	1,400	1,700	1,890	1,490	1,310	
		Slotting	1Dc	Spindle Revolution (min ⁻¹)	21,200	10,600	8,000	6,400	5,300	4,000	3,200	
				Feed Rate (mm/min)	830	1,100	1,100	1,360	1,510	1,290	1,050	
	High-silicon Aluminum Alloys	Shouldering	1Dc×0.5Dc	Spindle Revolution (min ⁻¹)	19,100	9,600	7,200	5,700	4,800	3,600	2,900	
				Feed Rate (mm/min)	630	750	750	890	1,000	1,160	860	
		Slotting	1Dc	Spindle Revolution (min ⁻¹)	15,900	7,900	5,900	4,800	4,000	3,000	2,400	
				Feed Rate (mm/min)	520	630	630	740	830	960	710	

3NFSL (Shouldering)

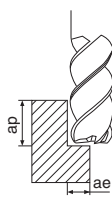
Application	Workpiece Material	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
 <p>Shouldering</p>	Aluminum Alloys	2.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	18,500	9,300	7,000	5,600	4,600	3,500	2,800
			Feed Rate (mm/min)	730	980	980	1,200	1,320	1,040	920
	High-silicon Aluminum Alloys	1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	13,400	6,700	5,000	4,000	3,400	2,500	2,000
			Feed Rate (mm/min)	440	530	530	620	700	810	600

Slotting is not recommended.

3AESM

Application		Workpiece Material	Application	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
 <p>Shouldering Slotting</p>	Aluminum Alloys	Shouldering	1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	33,200	24,900	19,900	16,600	12,400	10,000	8,000	
				Feed Rate (mm/min)	5,370	5,150	5,080	4,980	4,890	4,840	4,780	
		Slotting	1Dc	Spindle Revolution (min ⁻¹)	19,900	14,900	11,900	10,000	7,500	6,000	4,800	
				Feed Rate (mm/min)	3,230	3,090	3,050	2,990	2,930	2,900	2,870	
	High-silicon Aluminum Alloys	Shouldering	1.5Dc×0.5Dc	Spindle Revolution (min ⁻¹)	10,600	8,000	6,400	5,300	4,000	3,200	2,500	
				Feed Rate (mm/min)	1,430	1,390	1,360	1,320	1,300	1,290	1,280	
		Slotting	1Dc	Spindle Revolution (min ⁻¹)	6,400	4,800	3,800	3,200	2,400	1,900	1,500	
				Feed Rate (mm/min)	860	830	810	790	780	770	770	

3AESL (Shouldering)

Application	Workpiece Material	Depth of Cut (apxae) (mm)	Outside Dia. Dc (mm)	ø6	ø8	ø10	ø12	ø16	ø20	ø25
 <p>Shouldering</p>	Aluminum Alloys	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 Alloys		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

Slotting is not recommended.

L

Solid End Mill