

UA100-S3

For Aluminium Alloy — Side Milling



Workpiece Material		mm	Vc m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
	Si12%	ap≤1.5D	150 (60-350)	min-1	16000	13000	12000	10600	10000	9500	9280	7000	5600
		ae≤0.2D		mm/min	650	850	1430	1530	1670	2050	2800	3000	3150
	HB200	ap≤1.5D	150 (60-350)	min-1	16000	13000	12000	10600	10000	9500	9280	7000	5600
		ae≤0.2D		mm/min	720	900	1200	1200	1500	1800	2225	2500	3000

UA100-S3

For Aluminium Alloy — Slotting



Workpiece Material		mm	Vc m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
	Si12%	ap≤0.5D	150 (60-350)	min-1	16000	10000	9000	8000	7800	8000	6800	5000	4000
		Ae=1D		mm/min	450	570	960	1050	1300	1500	1620	1680	1800
	HB200	ap≤0.5D	150 (60-350)	min-1	16000	10000	9000	8000	7800	8000	6800	5000	4000
		Ae=1D		mm/min	450	520	860	830	960	1240	1500	1550	1510

Make sure work piece and machine are stable and use a precision holder.
 Please adjust the speed, feed and cutting depth according to actual cutting conditions.
 The milling conditions are for an end mill where the tool overhang length is less than 4*D (mill dia).
 When the tool overhang length is longer, please adjust the speed, feed and cutting depth.