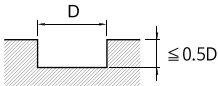
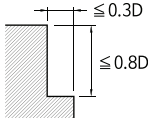
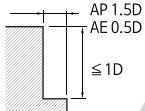
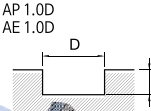
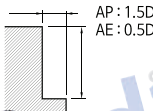
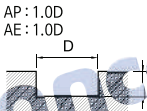
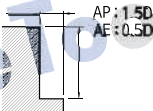
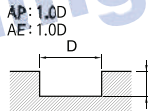


3ACR					Cutting Condition			
	Slotting				Side Cutting			
Material	Aluminium Alloys AL7075				Aluminium Alloys AL7075			
Outside Dia.	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø 6	10000	3300	3.0	6.0	10000	4200	4.8	1.8
Ø 8	9000	2700	4.0	8.0	9000	3750	6.4	2.4
Ø 10	7500	2000	5.0	10.0	7500	3000	8.0	3.0
Ø 12	6500	1600	6.0	12.0	6500	2700	9.6	3.6
Ø 16	5000	1600	8.0	16.0	5000	2700	12.8	4.8
Ø 20	4000	1500	10.0	20.0	4000	2500	16.0	6.0
Depth of Cut								

- In case of long effective length, reduce the RPM and feed by 20% or less.
- Refer to the corner radius value for side milling.
- Consider the corner radius value when you set up the Ae value.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Air blow or mist coolants are recommended and note for chip emission, heat or ignition.

3ARCR						Cutting Condition						
Material	Aluminium Alloys AL7075				Aluminium Alloys AC4B				Non-ferrous			
	Side Milling		Slotting		Side Milling		Slotting		Side Milling		Slotting	
Outside Dia.	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
Ø 3	40300	3600	37000	2200	26500	1600	15900	1200	47700	5700	40000	3600
Ø 4	30250	4080	27800	2500	19900	2400	12000	1450	35820	6450	30000	4000
Ø 5	25500	5080	22300	2780	15900	2800	9550	1720	28600	6880	24200	4350
Ø 6	21200	5700	18500	2900	13270	2900	7960	1790	23800	7100	20170	4800
Ø 8	15900	6200	14000	3700	9950	2300	5970	2150	17900	7500	15100	5450
Ø 10	12800	5700	11200	4000	7960	2150	4770	2290	14300	8100	12100	5800
Ø 12	10600	5400	9250	3600	6630	2980	3980	2000	12000	7500	10080	6050
Ø 16	8560	4700	7000	3100	4970	2680	3000	1700	8950	6780	7560	5200
Ø 20	6850	4100	5570	2800	3980	2300	2400	1450	7170	5800	6050	4550
Depth of Cut	     											

- During tool entry, try to enter from outside the workpiece as much as possible.
- For diameters & effective lengths without specific cutting conditions, set them proportionally UP&DOWN to similar diameters & effective lengths.
- The above cutting conditions are numerical values, so they may need to be adjusted depending on the actual machining shape, machining purpose, and applied machine.
- If the rotation speed of the applied machine is insufficient, reduce the rotation speed and feed rate at the same ratio.
- Please use a rigid and low-vibration machine (vibration tolerance within 5µm for Ø1 or below).
- We recommend using a soluble coolant for smooth chip evacuation.