

MAGIC DRILLS - ALU

RPM : rev/min.			FEED : mm/min			
Cutting Condition						
RTDA30/RTDA50/RTDA80						
Material	Aluminium Alloy Casting Aluminium Die Casting			Wrought Aluminium Alloy		
Diameter	RPM	SPEED	FEED	RPM	SPEED	FEED
Ø3.0~Ø6.0	8000~15000	80~150	0.2~0.5	8000~15000	80~150	0.15~0.3
~Ø10.0	6000~10500	100~200	0.3~1.0	6000~10500	100~200	0.2~0.4
~Ø14.0	4500~5800	150~250	0.3~1.0	4500~5800	150~250	0.2~0.4
~Ø20.0	3200~4600	150~200	0.3~1.0	3200~4600	150~200	0.2~0.4

N=R.P.M

S=Feed per Revolution(mm/rev.)

Recommended to reduce the feed rate as following,

Feed 100% : RTDA30

Feed 85% : RTDA50

Feed 70% : RTDA80

			RPM : rev/min.		FEED : mm/min	
Cutting Condition						
RTDA31/RTDA51/RTDA81						
Material	Aluminium Alloy Casting Aluminium Die Casting			Wrought Aluminium Alloy		
Diameter	RPM	SPEED	FEED	RPM	SPEED	FEED
Ø3.0~Ø6.0	8000~15000	80~150	0.2~0.5	8000~15000	80~150	0.15~0.3
~Ø10.0	6000~10500	100~200	0.3~1.0	6000~10500	100~200	0.2~0.4
~Ø14.0	4500~5800	150~250	0.3~1.0	4500~5800	150~250	0.2~0.4
~Ø20.0	3200~4600	150~200	0.3~1.0	3200~4600	150~200	0.2~0.4

N=R.P.M

S=Feed per Revolution(mm/rev.)

Recommended to reduce the feed rate as following,

Feed 100% : RTDA31

Feed 85% : RTDA51

Feed 70% : RTDA81