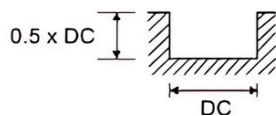


3 FLUTE

CUTTING DATA

	Slotting				Side Cutting			
Material	ALUMINIUM ALLOYS				ALUMINIUM ALLOYS			
Hardness	-				-			
Strength	-				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
3	7000	730	65	0.035	7000	940	65	0.045
4	7000	940	90	0.045	7000	1150	90	0.055
5	7000	1050	110	0.05	7000	1360	110	0.065
6	7000	1250	130	0.06	7000	1580	130	0.075
8	5600	1470	140	0.088	5600	1900	140	0.113
10	5600	1780	175	0.106	5600	2200	175	0.131
12	5600	2200	210	0.131	5600	2740	210	0.163
16	4200	1990	210	0.158	4200	2520	210	0.2
20	2800	1680	175	0.2	2800	2000	175	0.238

SLOTTING



SIDE CUTTING

