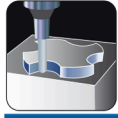


MILLING CONDITIONS

2 flute and 3 flute carbide end mills for Aluminium (including corner radius versions)

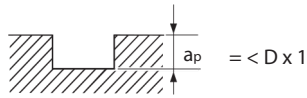
SLOTTING

HYP-EDS-55 / EDL-55 / ETS-55 / ETL-55 / AL-EDS / EDL / LS-EDS



Aluminium Alloys			Copper Alloys	
Vc	150 m/min		75 m/min	
Ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
6	7,950	630	3,950	310
8	5,950	665	2,950	350
10	4,750	745	2,350	365
12	3,950	790	1,950	390
16	2,950	795	1,450	390
20	2,350	785	1,150	385
25	1,900	785	950	385

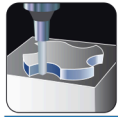
Maximum depth of cut



- (1) Reduce speeds & feeds 20-30% for HYP-AL-EDL / HYP-EDL-55 (Long series) and HYP-AL-LS-EDS (Long with neck).
- (2) Increase speeds & feeds 30-40% for HYP-ETS-55.

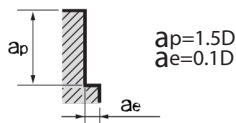
SIDE MILLING

HYP-EDS-55 / EDL-55 / ETS-55 / ETL-55 / AL-EDS / EDL / LS-EDS



Aluminium Alloys			Copper Alloys	
Vc	200 m/min		75 m/min	
Ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
6	10,500	830	3,950	310
8	7,950	890	2,950	350
10	6,350	995	2,350	365
12	5,300	1,050	1,950	390
16	3,950	1,050	1,450	390
20	3,150	1,050	1,150	385
25	2,250	1,050	950	385

Maximum depth of cut



- (1) Reduce speeds & feeds 20-30% for HYP-AL-EDL / HYP-EDL-55 (Long series) and HYP-AL-LS-EDS (Long with neck).
- (2) Increase speeds & feeds 30-40% for HYP-ETS-55.