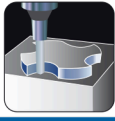


SLOTTING



HYP-ACE-STUB / CR -ACE-STUB / DLC

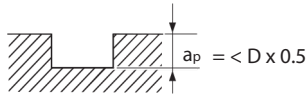
Aluminium Alloys

A6061, A7075

365 m/min

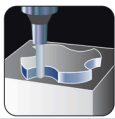
Vc	Speed (min-1)	Fz (mm)	Feed (mm/min.)
∅		0.03	
		0.05	
3	38,700	0.09	3,810
4	29,000	0.13	4,590
6	19,400	0.16	5,280
8	14,500	0.19	5,490
10	11,600	0.24	5,550
12	9,700	0.29	5,540
16	7,300	0.33	5,360
20	5,800		5,040
25	4,600		4,580

Maximum depth of cut



(1) For side milling increase feeds 20-50%

SLOTTING



HYP-ACE-REGULAR / CR-A CE-REG / DLC

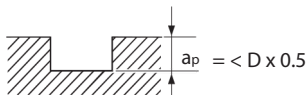
Aluminium Alloys

A6061, A7075

300 m/min

Vc	Speed (min-1)	Fz (mm)	Feed (mm/min.)
∅		0.03	
		0.05	
3	31,800	0.09	3,130
4	23,900	0.13	3,780
6	15,900	0.16	4,330
8	11,900	0.19	4,510
10	9,500	0.24	4,550
12	8,000	0.29	4,570
16	6,000	0.33	4,410
20	4,800		4,170
25	3,800		3,790

Maximum depth of cut



(1) For side milling increase feeds 20-50%