

Figure 1

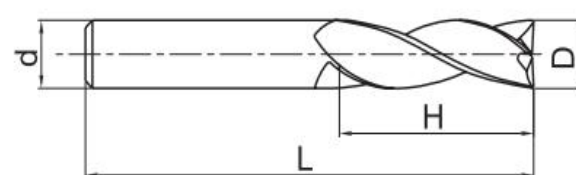
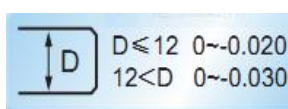


Figure 2

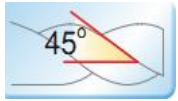
ALCM2FWL


mm

Type Specification	D(Diameter of Cut)	d(Shank Diameter)	H(Flute Length)	L(Overall Length)	Number of Flute	Figure(1 or 2)
ALCM2FWL0300	3.0	6	12	60	2	1
ALCM2FWL0400	4.0	6	16	60	2	1
ALCM2FWL0500	5.0	6	20	60	2	1
ALCM2FWL0600	6.0	6	25	75	2	2
ALCM2FWL0800	8.0	8	32	75	2	2
ALCM2FWL1000	10.0	10	45	100	2	2
ALCM2FWL1200	12.0	12	45	100	2	2
ALCM2FWL1600	16.0	16	65	150	2	2
ALCM2FWL2000	20.0	20	75	150	2	2

THE CUTTING PARAMETERS OF ALCM2FWL

Processed Material	Aluminium Alloy		Silicon Aluminum Alloy(Si≤10%)	
	Diameter of Cut (mm)	Rotational Speed (min ⁻¹)	Feed Speed (mm/min)	Rotational Speed (min ⁻¹)
3	26500	1500	21000	1100
4	20000	1600	16000	1250
5	16000	1500	13000	1100
6	13000	1250	10600	1000
8	10000	1400	8000	1100
10	8000	1600	6500	1250
12	6600	1650	5300	1300
16	5000	1700	4000	1350
20	4000	1700	3200	1350




 $D \leq 12 \quad 0 \sim -0.020$
 $12 < D \quad 0 \sim -0.030$

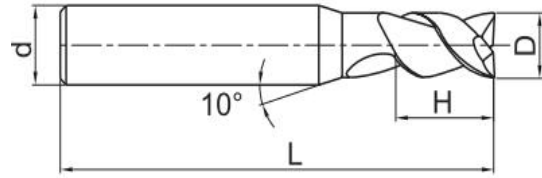


Figure 1

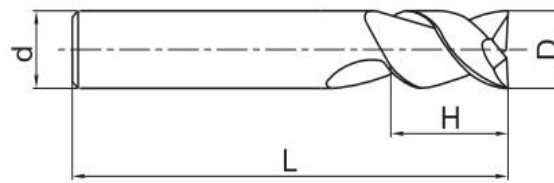


Figure 2

ALCM3Z

mm

Type Specification	D(Diameter of Cut)	d(Shank Diameter)	H(Flute Length)	L(Overall Length)	Number of Flute	Figure(1 or 2)
ALCM3Z0100	1.0	4	3	50	3	1
ALCM3Z0150	1.5	4	4	50	3	1
ALCM3Z0200	2.0	4	6	50	3	1
ALCM3Z0250	2.5	4	7	50	3	1
ALCM3Z0300	3.0	6	9	50	3	1
ALCM3Z0400	4.0	6	12	50	3	1
ALCM3Z0500	5.0	6	15	50	3	1
ALCM3Z0600	6.0	6	18	60	3	2
ALCM3Z0800	8.0	8	20	60	3	2
ALCM3Z1000	10.0	10	30	75	3	2
ALCM3Z1200	12.0	12	32	75	3	2
ALCM3Z1600	16.0	16	45	100	3	2
ALCM3Z2000	20.0	20	45	100	3	2

THE CUTTING PARAMENTERS OF ALCM3Z

Processed Material	Aluminium Alloy		Silicon Aluminum Alloy(Si≤10%)		
	Diameter of Cut (mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)
	1	40000	800	40000	600
	2	40000	1200	32000	900
	3	26500	1800	21000	1300
	4	20000	2000	16000	1500
	5	16000	1750	13000	1300
	6	13000	1500	10600	1200
	8	10000	1650	8000	1300
	10	8000	1900	6500	1500
	12	6600	1950	5300	1550
	14	5700	2000	4600	1600
	16	5000	2000	4000	1600
	18	4400	2000	3500	1600
	20	4000	2000	3200	1600