

D	$D \leq 6$	0~-0.048	$6 < D \leq 10$	0~-0.058
	$10 < D \leq 18$	0~-0.07	$18 < D$	0~-0.084



ALBCM3N

mm

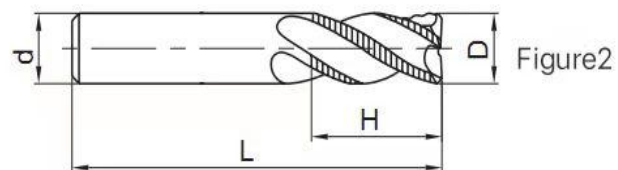
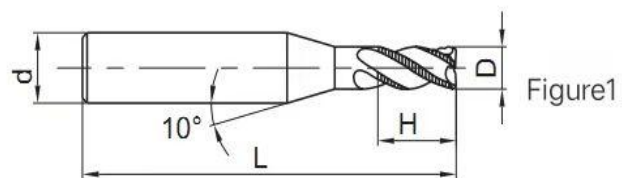
Type Specification	D(Diameter of Cut)	d(Shank Diameter)	H(Flute Length)	L(Overall Length)	Number of Flute
ALBCM3N0600	6.0	6	16	50	3
ALBCM3N0800	8.0	8	20	60	3
ALBCM3N1000	10.0	10	25	75	3
ALBCM3N1200	12.0	12	30	75	3
ALBCM3N1600	16.0	16	45	100	3
ALBCM3N2000	20.0	20	45	100	3

THE CUTTING PARAMENTERS OF ALBCM3N

Processed Material	Aluminium Alloy		Silicon Aluminum Alloy(Si≤10%)	
Cutting Speed	250m/min		200m/min	
Diameter of Cut (mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)
6	13000	3000	10600	1900
8	10000	3000	8000	1900
10	8000	2900	6500	1850
12	6600	2700	6300	1700
14	5700	2600	4600	1650
16	5000	2552	4000	1650
18	4400	2500	3500	1550
20	4000	2400	3200	1500



Sharp corner protection design



D	D ≤ 6	0~-0.048	6 < D ≤ 10	0~-0.058
	10 < D ≤ 18	0~-0.07	18 < D	0~-0.084



BCM4F						mm	
Type Specification	Basic Dimension (mm)				Number of Flute	Figure(1 or 2)	
	D(Diameter of Cut)	d(Shank Diameter)	H(Flute Length)	L(Overall Length)			
BCM4F-D6.0	6.0	6	16	50	4	2	
BCM4F-D7.0	7.0	8	20	60	4	1	
BCM4F-D8.0	8.0	8	20	60	4	2	
BCM4F-D9.0	9.0	10	22	75	4	1	
BCM4F-D10.0	10.0	10	25	75	4	2	
BCM4F-D11.0	11.0	12	26	75	4	1	
BCM4F-D12.0	12.0	12	30	75	4	2	
BCM4F-D16.0	16.0	16	45	100	4	2	
BCM4F-D20.0	20.0	20	45	100	4	2	

THE CUTTING PARAMETERS OF BCM-4F

BCM4F-Side Milling

Processed Material	Cast Iron Nodular Iron		Carbon Steel、 Alloy Steel ~750N/mm2		Carbon Steel、 Alloy Steel ~30HRC		Pre-hardened Steel 、 Tempered Steel ~30HRC		Stainless Steel	
	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)
6	6350	760	5300	640	4500	360	3450	280	2650	210
7	5460	760	4550	640	3650	360	3000	280	2250	310
8	4750	760	4000	640	3400	410	2650	310	2000	240
9	4250	760	3540	640	2850	410	2300	310	1750	240
10	3800	760	3200	640	2700	430	2050	330	1600	260
11	3470	760	2900	640	2400	430	1850	330	1450	260
12	3200	770	2250	650	1950	470	1500	360	1150	280
16	2400	770	2000	640	1700	480	1300	360	1000	290
20	1900	760	1600	610	1350	470	1050	350	900	260

THE CUTTING PARAMETERS OF BCM-4F

BCM4F-Slot Milling

Processed Material	Cast Iron Nodular Iron		Carbon Steel、 Alloy Steel ~750N/mm2		Carbon Steel、 Alloy Steel ~30HRC		Pre-hardened Steel 、 Tempered Steel ~30HRC		Stainless Steel	
	Diameter of Cut (mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)
6	6350	760	5300	640	4500	360	3450	280	2650	210
7	5460	760	4550	640	3650	360	3000	280	2250	310
8	4750	760	4000	640	3400	410	2650	310	2000	240
9	4250	760	3540	640	2850	410	2300	310	1750	240
10	3800	760	3200	640	2700	430	2050	330	1600	260
11	3470	760	2900	640	2400	430	1850	330	1450	260
12	3200	770	2250	650	1950	470	1500	360	1150	280
16	2400	770	2000	640	1700	480	1300	360	1000	290
20	1900	760	1600	610	1350	470	1050	350	900	260