

DLTUA550 End mill for aluminum operation parameter:

DLTUA550 S2 For Aluminum Alloy-Side Milling

Grades	Tool Shape S2	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	Square、 Corner radius	Reflectal, Cast aluminum Si<12%	ap≤1.5D	150 (60-350)	Speed (min-1)	16000	12700	12000	10600	10000	9500	9280	7000	5600
			ae≤0.2D		Feed Speed (mm/min)	580	710	1200	1280	1390	1720	2400	2500	2450
		Copper alloy < HB200	ap≤1.5D	150 (60-350)	Speed (min-1)	16000	12700	12000	10600	10000	9500	9280	7000	5600
			ae≤0.2D		Feed Speed (mm/min)	520	650	1070	1150	1250	1550	2170	2250	2200

DLTUA550 S2 For Aluminum Alloy- Slotting

Grades	Tool Shape S2	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	Square、 Corner radius	Reflectal, Cast aluminum Si<12%	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			ae≤1D		Feed Speed (mm/min)	400	500	810	920	1100	1280	1300	1310	1200
		Copper alloy < HB200	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7000	6000	5000	4000	3000
			ae≤1D		Feed Speed (mm/min)	380	450	800	830	1000	1150	1130	1000	1080

DLTUA550 S2 For Aluminum Alloy- Side Milling

Grades	Tool Shape S2	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	square	Reflectal, Cast aluminum Si<12%	$ap \leq 2.5D$	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			$ae \leq 0.15D$		Feed Speed (mm/min)	400	500	810	920	1100	1280	1300	1310	1200
		Copper alloy <HB200	$ap \leq 0.25D$	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7000	6000	5000	4000	3000
			$ae \leq 0.15D$		Feed Speed (mm/min)	380	450	800	830	1000	1150	1130	1000	1080

DLTUA550 S3 For Aluminum Alloy- Side Milling

Grades	Tool Shape S3	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	Square, Corner radius	Reflectal, Cast aluminum Si<12%	$ap \leq 1.5D$	150 (60-350)	Speed (min-1)	16000	13000	12000	10600	10000	9500	9280	7000	5600
			$ae \leq 0.2D$		Feed Speed (mm/min)	650	850	1430	1530	1670	2050	2800	3000	3150
		Copper alloy <HB200	$ap \leq 1.5D$	150 (60-350)	Speed (min-1)	16000	13000	12000	10600	10000	9500	9280	7000	5600
			$ae \leq 0.2D$		Feed Speed (mm/min)	720	900	1200	1200	1500	1800	2225	2500	3000

DLTUA550 S3 For Aluminum Alloy- Slotting

Grades	Tool Shape S3	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	Square、 Corner radius	Reflectal, Cast aluminum Si<12%	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			ae≤1D		Feed Speed (mm/min)	450	570	960	1050	1300	1500	1620	1680	1800
		Copper alloy < HB200	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			ae≤1D		Feed Speed (mm/min)	450	520	860	830	960	1240	1500	1550	1510

DLTUA550 SL3 For Aluminum Alloy- Side Milling

Grades	Tool Shape SL3	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16	20
DLTUA550	Square	Reflectal, Cast aluminum Si<12%	ap≤2.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			ae≤0.15D		Feed Speed (mm/min)	450	570	960	1050	1300	1500	1620	1680	1800
		Copper alloy < HB200	ap≤2.5D	150 (60-350)	Speed (min-1)	16000	10000	9000	8000	7800	8000	6800	5000	4000
			ae≤0.15D		Feed Speed (mm/min)	450	520	860	830	960	1240	1500	1550	1510

DLTUA550 S2 For Aluminum Alloy- Profiling

Grades	Tool Shape S2	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	1	2	4	6	8	10	12	16
DLTUA550	Ball nose	Reflectal, Cast aluminum Si<12%	ap≤0.3D	150 (60-350)	Speed (min-1)	19000	15900	11900	10600	8000	7950	7950	7000
			ae≤0.3D		Feed Speed (mm/min)	950	1600	1900	2500	2550	3200	3800	4450
		Copper alloy <HB200	ap≤0.3D	150 (60-350)	Speed (min-1)	19000	15900	11900	10600	8000	7950	7950	7000
			ae≤0.3D		Feed Speed (mm/min)	860	1430	1720	2300	2300	2850	3450	4010