

**DLTUA600End mill for aluminum operation parameter:DLTUA600-S2**

DLTUA600 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
DLTUA600	Square	Reflectal, Cast aluminum Si<12%	ap≤1.5D	150 (60-350)	Speed (min-1)	19000	16000	12000	10600	10000	9500	9300
			ae≤0.2D		Feed speed (mm/min)	760	950	1300	1380	1500	1900	2600
		Copper alloy < HB200	ap≤1.5D	150 (60-350)	Speed (min-1)	19000	16000	12000	10600	10000	9500	9300
			ae≤0.2D		Feed speed (mm/min)	690	860	1180	1240	1340	1720	2340

DLTUA600 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
DLTUA600	Square	Reflectal, Cast aluminum Si<12%	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	12800	10000	9300	8750	8000	7450
			ae≤1D		Feed speed (mm/min)	350	650	900	1100	1230	1280	1410
		Copper alloy < HB200	ap≤0.5D	150 (60-350)	Speed (min-1)	16000	12800	10000	9300	8750	8000	7450
			ae≤1D		Feed speed (mm/min)	300	570	800	970	1100	1150	1270

DLTUA600 S3 For Aluminum Alloy-Side Milling

Grades	Tool Shape S3	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12
DLTUA600	Square	Reflectal, Cast aluminum Si <12%	ap≤1.5D	150 (60-350)	Speed (min-1)	16000	12000	10600	10000	9500	9300
			ae≤0.2D		Feed speed (mm/min)	1150	1570	1650	1800	2300	3100
		Copper alloy <HB200	ap≤1.5D	150 (60-350)	Speed (min-1)	16000	12000	10600	10000	9500	9300
			ae≤0.2D		Feed speed (mm/min)	1030	1420	1490	1610	2060	2800

DLTUA600 S3 For Aluminum Alloy-Slotting

Grades	Tool Shape S3	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	2	4	6	8	10	12
DLTUA600	Square	Reflectal, Cast aluminum Si <12%	ap≤0.5D	150 (60-350)	Speed (min-1)	12800	10000	9300	8750	8000	7450
			ae≤1D		Feed speed (mm/min)	760	1080	1300	1470	1530	1700
		Copper alloy <HB200	ap≤0.5D	150 (60-350)	Speed (min-1)	12800	10000	9300	8750	8000	7450
			ae≤1D		Feed speed (mm/min)	690	970	1160	1320	1380	1530

DLTUA600 S4 For Aluminum Alloy-Side Milling

Grades	Tool Shape S4	Workpiece Material	Cutting Depth (mm)	VC m/min	Tool Diameter(mm)	4	6	8	10	12
DLTUA600	Square	Reflectal, Cast aluminum Si <12%	$a_p \leq 1.5D$	200 (120-350)	Speed (min-1)	16000	12000	10000	8000	6600
			$a_e \leq 0.1D$		Feed speed (mm/min)	1500	1800	2000	2250	2500