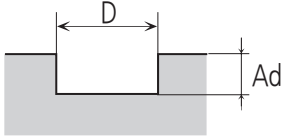
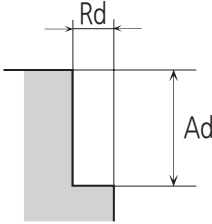


## 3ALE

### Milling Condition

피삭재	알루미늄		알루미늄	
Workpiece	Aluminium		Aluminium	
Outside Diameter	Speed (min <sup>-1</sup> )	Feed (mm/min)	Speed (min <sup>-1</sup> )	Feed (mm/min)
1.0	15,000~20,000	400~800	15,000~20,000	800~1,200
1.5	10,000~15,000	400~800	10,000~15,000	800~1,200
2.0	8,000~12,000	300~700	8,000~12,000	600~1,000
3.0	6,500~9,000	300~700	6,500~9,000	300~700
4.0	6,500~9,000	300~700	6,500~9,000	300~700
6.0	6,500~9,000	500~800	6,500~9,000	600~1,000
8.0	5,000~8,000	600~1,000	5,000~8,000	600~1,000
10.0	5,000~8,000	600~1,000	5,000~8,000	800~1,200
12.0	5,000~8,000	800~1,200	5,000~8,000	600~1,000
14.0	3,500~5,000	800~1,200	3,500~5,000	800~1,200
16.0	3,500~5,000	800~1,200	3,500~5,000	800~1,200
18.0	2,500~4,000	600~1,000	2,500~4,000	800~1,200
20.0	2,500~4,000	600~1,000	2,500~4,000	800~1,200

Depth of Cut	 <p style="text-align: center;"><math>Ad = 0.2D</math></p>	 <p style="text-align: center;"><math>Ad = 0.15D</math> <math>Rd = 1.0 \sim 2.5D</math></p>
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### ⚠ 경고 Warning

1. 강성을 지닌 정밀한 장비와 홀더를 사용하십시오.
  2. 절삭유 사용을 추천합니다.
1. Use a rigid precise machine and holder.
  2. Recommend water soluble fluids.