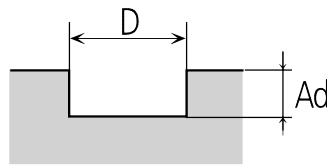


## 1ALE

### Milling Condition

파삭재	아크릴, 알루미늄		합금강, 주철	
Workpiece	Acrylic, Aluminium		Alloy Steels, Cast Iron	
Outside Diameter	Speed (min <sup>-1</sup> )	Feed (mm/min)	Speed (min <sup>-1</sup> )	Feed (mm/min)
1.0	30,000~35,000	1,500~2,000	25,000~30,000	1,500~2,000
2.0	28,000~32,000	1,800~2,300	20,000~25,000	1,300~1,800
3.0	22,000~26,000	2,200~2,500	16,000~20,000	1,500~2,000
4.0	18,000~22,000	2,200~2,500	13,000~18,000	1,500~2,000
6.0	12,000~15,000	2,200~2,500	8,000~12,000	1,500~2,000
8.0	8,000~12,000	2,300~2,700	6,000~9,000	1,800~2,200
10.0	7,000~9,000	2,300~2,700	5,000~8,000	1,800~2,200
12.0	6,000~8,500	2,300~2,700	4,000~7,000	1,800~2,200

Depth of Cut



$$Ad = 0.25D$$

### ⚠ 경고 Warning

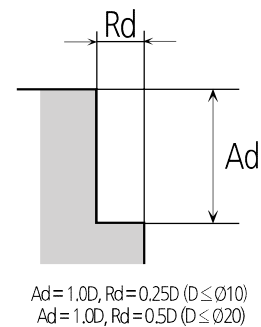
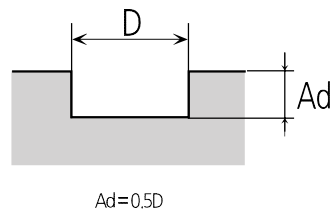
- 강성을 지닌 정밀한 장비와 홀더를 사용하십시오.
- 절삭유 사용을 추천합니다.

- Use a rigid precise machine and holder.
- Recommend water soluble fluids.

### Milling Condition

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

Depth of Cut



### 경고 Warning

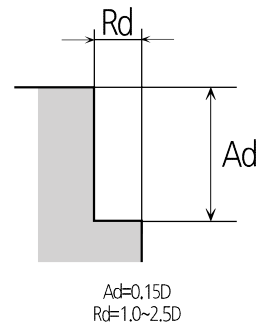
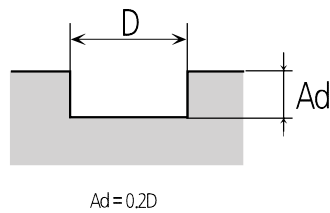
1. 강성을 지닌 정밀한 장비와 홀더를 사용하십시오.
  2. 절삭유 사용을 추천합니다.
1. Use a rigid precise machine and holder.
  2. Recommend water soluble fluids.

## 3ALE

### Milling Condition

파삭재	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



### 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.