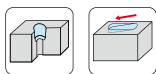
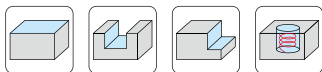
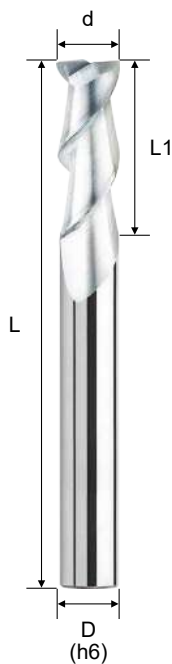


- Suitable for cutting non-ferrous metals, Aluminum, Aluminum Alloy, Copper (HRC< 20).
- High Helix offers excellent and stable finished surfaces in high speed.
- Great chip evacuation and flute polishing increase cutting surface and feed rate.

P	M	K	N	S	H
			●		



d Tolerance	
$d \leq 6$	$0 \sim -0.02$
$6 < d \leq 12$	$0 \sim -0.03$
$d > 12$	$0 \sim -0.04$

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
* ENSSS241000	1	3	50	4	2
* ENSSS242000	2	6	50	4	2
* ENSSS233000	3	9	50	3	2
* ENSSS243000	3	9	50	4	2
* ENSSS244000	4	12	50	4	2
ENSSS204000	4	12	50	6	2
ENSSS205000	5	15	50	6	2
ENSSS206000	6	15	50	6	2
ENSSS208000	8	20	60	8	2
ENSSS210000	10	30	75	10	2
ENSSS212000	12	30	75	12	2
ENSSS216000	16	40	100	16	2
ENSSS220000	20	45	100	20	2

Cutting conditions : Table 076

Recommended Cutting Conditions

Table 076

A100 Seires ENSSS2, ENSSS3, ENSCS3, ENSSH3

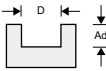
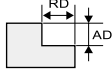
WORKING MATERIAL	ALLUMINUM ALLOY			
CODE	A5052			
	Slotting		Side Milling	
Vc	196 M/min		325 M/min	
DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
3mm	20,800	1,200	34,580	1,350
4mm	15,600	1,000	26,000	1,350
5mm	12,480	900	20,670	1,350
6mm	10,400	820	17,290	1,350
8mm	7,800	750	13,000	1,350
10mm	6,240	680	10,270	1,350
12mm	5,200	620	8,580	1,350
Milling Amount (mm)	$Ad = 0.1D$  			

Table 077

A100 Seires ENSSB3

WORKING MATERIAL	ALLUMINUM ALLOY				
Application	Shoulder Milling			Slot Milling	
Vc	200 ~400 m/min			150 ~ 300 m/min	
DIAMETER	fz (mm/z)	ap (mm)	ae (mm)	fz (mm/z)	ap (mm)
4mm	0.0200	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.030	$\leq 1 \times d$
5mm	0.0250	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.040	$\leq 1 \times d$
6mm	0.0350	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.057	$\leq 1 \times d$
8mm	0.0450	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.075	$\leq 1 \times d$
10mm	0.0570	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.096	$\leq 1 \times d$
12mm	0.0670	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.110	$\leq 1 \times d$
16mm	0.0880	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.145	$\leq 1 \times d$
20mm	0.1200	$\leq 1.5 \times d$	$\leq 0.3 \times d$	0.180	$\leq 1 \times d$

1. Use as highly rigid and accurate machine as possible.
2. If the rpm available is lower than the recommend condition, please reduce the feed rate to the same ratio.
3. Use long shank type please reduce the rpm and feed rate.
4. The Feed and RPM may be changed depending on the M/C conditions ,lubricating and cooling system.