

Three Flute Standard  
三齿标准型

## Type &amp; Specifications/类型与规格

D1	D2	L2	L1	D3	L3	Flute No.	Orde No.
4	6	8	50	3.5	14	3	C3SUAN040006
5	6	10	50	4.5	16	3	C3SUAN050006
6	6	13	50	5.5	20	3	C3SUAN060006
8	8	18	60	7.5	25	3	C3SUAN080008
10	10	22	75	9.3	32	3	C3SUAN100010
12	12	25	75	11.0	35	3	C3SUAN120012
16	16	35	100	15.0	50	3	C3SUAN160016
20	20	40	100	19.0	50	3	C3SUAN200020

## Recommendation/推荐切削条件

Diameter D1 (mm)	Aluminium Alloy			
	Slotting		Side Milling	
	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)
4.0	6445	580	5370	480
5.0	5155	650	4300	540
6.0	4300	620	3580	515
8.0	3220	635	2685	530
10.0	2580	610	2150	510
12.0	2150	550	1790	460
16.0	1610	545	1340	455
20.0	1290	570	1075	475
ap (Depth)	ap=0.6D		ap=1.5D	
ae (Width)	ae=1.0D		ae=0.4D	

Illustration



- Please optimize the over-hang
- Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- Please use suitable coolants

## Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
				◎	◎			

◎ Preferential ○ Suitable

Three Flute Long Length  
三齿加长型

## Type &amp; Specifications/类型与规格

D1	D2	L2	L1	D3	L3	Flute No.	Orde No.
6	6	18	75	5.5	35	3	C3SUWN060006
8	8	23	100	7.5	40	3	C3SUWN080008
10	10	26	100	9.3	50	3	C3SUWN100010
12	12	30	100	11.0	50	3	C3SUWN120012
16	16	40	150	15.0	70	3	C3SUWN160016
20	20	45	150	19.0	70	3	C3SUWN200020

## Recommendation/推荐切削条件

Diameter D1 (mm)	Aluminium Alloy			
	Slotting		Side Milling	
	Speed n (R/min)	Feed Vf (mm/min)	Speed n (R/min)	Feed Vf (mm/min)
6	12853	2069	15884	3621
8	9642	2069	11913	3515
10	7714	1963	9528	3451
12	6431	1810	7942	3196
16	4821	1555	5956	2720
20	3857	1445	4764	2550
ap (Depth)	ap=0.6D		ap=2.0D	
ae (Width)	ae=1.0D		ae=0.3D	

Illustration



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- Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- Please use suitable coolants

## Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
				◎	◎			

◎ Preferential ○ Suitable

HI-EFFICIENCY END MILLS  
FOR ALUMINUM铝合金  
高效加工铣刀

**Multi-Function:** Perform outstandingly both in slotting and side milling, for roughing and finishing.

**Hi-Efficiency:** Distinctive Geometry & Large Chip Pocket for smooth chip removal. Vari Helix & Unequal Index eliminates the Harmonic Vibration in operation, which helps on the efficiency of Slotting/Side Milling significantly. Sharp Cutting Edge & Mirror Grinding enables the working piece in precision and quality surface. Super suitable for efficiently roughing or finishing of aluminum.