

ALCM2F

mm

Type Specification	Diameter of Cut	Flute Length	Overall Length	Shank Diameter	Number of Flute
ALCM2F0100	1	2.5	40	4	2
ALCM2F0150	1.5	4	40	4	2
ALCM2F0200	2	6	40	4	2
ALCM2F0250	2.5	8	40	4	2
ALCM2F0300	3	8	45	6	2
ALCM2F0400	4	11	45	6	2
ALCM2F0500	5	13	50	6	2
ALCM2F0600	6	13	50	6	2
ALCM2F0800	8	19	60	8	2
ALCM2F1000	10	22	70	10	2
ALCM2F1200	12	26	75	12	2
ALCM2F1400	14	26	75	12	2
ALCM2F1500	15	30	80	16	2
ALCM2F1600	16	32	90	16	2
ALCM2F1800	18	32	90	16	2
ALCM2F2000	20	38	100	20	2

THE CUTTING PARAMETERS OF ALCM2F

Side Cutting					Fluting				
Processed Material	Aluminium Alloy		Aluminium Alloy Cast Iron		Processed Material	Aluminium Alloy		Aluminium Alloy Cast Iron	
Diameter of Cut (mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)	Radius of Bulb (mm)	Rotational Speed (min-1)	Feed Speed (mm/min)	Rotational Speed (min-1)	Feed Speed (mm/min)
1	40000	600	40000	460	1	40000	460	40000	350
2	40000	1100	38000	850	2	38000	850	32000	550
3	32000	1400	25000	950	3	25000	950	21000	600
4	24000	1500	19000	1000	4	19000	1000	16000	650
5	19000	1600	15000	1000	5	15000	1000	13000	700
6	16000	1900	13000	1100	6	13000	1100	11000	750
8	12000	1900	9500	1200	8	9500	1200	8000	800
10	9500	1900	7600	1200	10	7600	1200	6400	800
12	8000	1900	6400	1200	12	6400	1200	5300	800
16	6000	1900	4800	1200	16	4800	1000	4000	720
20	4800	1500	3800	1000	20	3800	970	3200	660