

## 2 FLUTE, 45° HELIX for ALUMINUM

151303



MATERIAL	ALUMINUM LOW SILICON ALUMINUM			
	DIAMETER	RPM	FEED	RPM
3	10000	700	10000	900
4	10000	900	10000	1100
5	10000	1000	10000	1300
6	10000	1200	10000	1500
8	8000	1400	8000	1800
10	8000	1700	8000	2100
12	8000	2100	8000	2600
14	6000	1800	6000	2200
16	6000	1900	6000	2400
18	4000	1400	4000	1800
20	4000	1600	4000	1900

  

<p><math>0.5 \times D</math></p>	<p>A : <math>\phi 3 \sim \phi 10 = 0.25 \times D</math> <math>\phi 12 \sim \phi 20 = 0.5 \times D</math></p> <p><math>1.0 \times D</math></p>
----------------------------------	---

RPM=REVOLUTION PER MIN., FEED=mm/min.