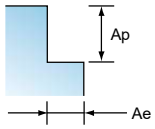
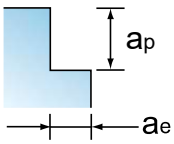
TSAE/TAE 2 Flutes Series

TSAE/TAE
Specification page
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Side Milling 	COPPER,COPPER ALLOY		Aluminum alloy expanding material A7075 Aluminum alloy casting<Sil 13%	
Max Cutting Speed(V)	140m/min		380m/min	
Diameter (mm)	Speed (min^{-1})	Feed Rate (mm/min)	Speed (min^{-1})	Feed Rate (mm/min)
3	14,770	2,100	39,910	6,380
4	11,080	1,580	29,940	4,790
5	8,860	1,260	23,950	3,830
6	7,380	1,060	19,960	3,190
8	5,550	790	15,000	2,400
10	4,430	630	11,980	1,920
12	3,690	530	9,980	1,600
16	2,770	400	7,490	1,200
20	2,220	320	5,980	960
25	1,780	260	4,790	770
Depth of cut	*Side milling  Ap=1.0D Ae=0.5D			
	V	140	V	380
	Z	2	Z	2
	Fz	0.07	Fz	0.08

Slotting 	COPPER,COPPER ALLOY		Aluminum alloy expanding material A7075 Aluminum alloy casting<Sil 13%	
Max Cutting Speed(V)	90m/min		310m/min	
Diameter (mm)	Speed (min^{-1})	Feed Rate (mm/min)	Speed (min^{-1})	Feed Rate (mm/min)
3	9,740	700	32,910	2630
4	7,300	520	24,680	1970
5	5,850	420	19,750	1580
6	4,870	350	16,450	1320
8	3,660	260	12,340	990
10	2,960	210	9,870	790
12	2,440	180	8,230	660
16	1,820	130	6,170	490
20	1,460	100	4,940	400
25	1,170	90	3,950	320
Depth of cut	 Ap=1.0D Ae=1.0D			
	V	90	V	310
	Z	2	Z	2
	Fz	0.04	Fz	0.04

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