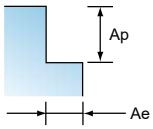
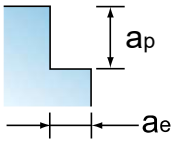
TSAE/TAE 3 Flutes Series

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	3,160	39,910	9,580
4	11,080	2,370	29,940	7,180
5	8,860	1,900	23,950	5,750
6	7,380	1,580	19,960	4,790
8	5,550	1,190	15,000	3,600
10	4,430	940	11,980	2,870
12	3,690	790	9,980	2,390
16	2,770	590	7,490	1,800
20	2,220	470	5,980	1,440
25	1,780	380	4,790	1,150
Depth of cut	*Side milling  Ap=1.0D Ae=0.5D			
	V	140	V	380
	Z	3	Z	3
	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	1,040	32,910	3950
4	7,300	780	24,680	2960
5	5,850	620	19,750	2370
6	4,870	520	16,450	1970
8	3,660	390	12,340	1480
10	2,960	320	9,870	1180
12	2,440	260	8,230	990
16	1,820	190	6,170	740
20	1,460	150	4,940	590
25	1,170	130	3,950	470
Depth of cut	 Ap=1.0D Ae=1.0D			
	V	90	V	310
	Z	3	Z	3
	Fz	0.04	Fz	0.04