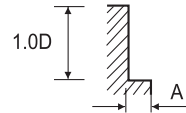
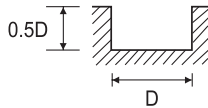


MATERIAL	ALUMINUM ALUMINUM ALLOY							
	DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc
3.0	10000	700	95	0.035	10000	900	95	0.045
4.0	10000	900	125	0.045	10000	1100	125	0.055
5.0	10000	1000	155	0.050	10000	1300	155	0.065
6.0	10000	1200	190	0.060	10000	1500	190	0.075
8.0	8000	1400	200	0.088	8000	1800	200	0.113
10.0	8000	1700	250	0.106	8000	2100	250	0.131
12.0	8000	2100	300	0.131	8000	2600	300	0.163
14.0	6000	1800	265	0.150	6000	2200	265	0.183
16.0	6000	1900	300	0.158	6000	2400	300	0.200
18.0	4000	1400	225	0.175	4000	1800	225	0.225
20.0	4000	1600	250	0.200	4000	1900	250	0.238



A : $\varnothing 3 \sim \varnothing 10 = 0.25 \times D$
 $\varnothing 12 \sim \varnothing 20 = 0.5 \times D$

RPM = rev./min.
 FEED = mm/min.
 Vc = m/min.
 fz = mm/t