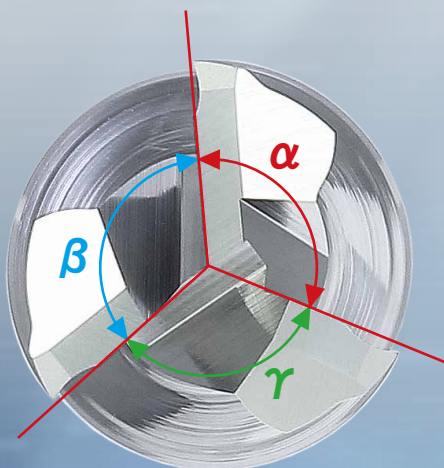


A100 Solid Carbide Endmills for Aluminum Machining

- *Good for finishing, medium and roughing cutting for aluminum parts*
- *No chattering surface due to polished cutting edges*
- *Unequal flute spacing good for anti-vibration*
- *U-flute design for excellent chip evacuation*

INCH



$\alpha \neq \beta \neq \gamma$

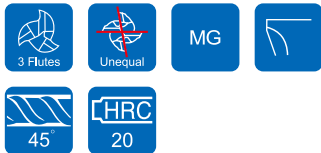
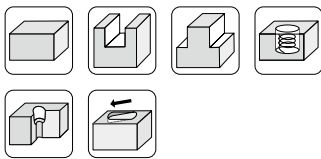
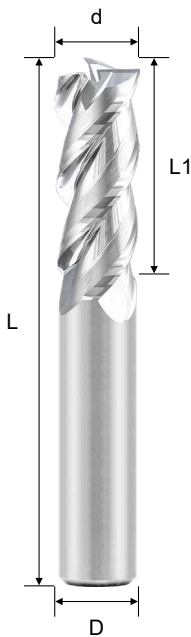


W191005E

A100 Carbide Endmills - Anti-Vibration Square Type - 3F

- Good for finishing, medium and roughing cutting for aluminum parts.
- No chattering surface due to polished cutting edges.
- Unequal flute spacing good for anti-vibration.
- U-flute design for excellent chip evacuation.

ENS2V3



Ød	Tolerance
Ød ≤ 1/2	.000 ~ -.0012"
Ød > 1/2	.000 ~ -.0016"

Work Material		
Aluminum Alloy	Copper	Non-ferrous Material
◎	◎	◎

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
ENS2V30250300	1/4	3/8	2	1/4	3
ENS2V30310500	5/16	1/2	2	5/16	3
ENS2V30370600	3/8	5/8	3	3/8	3
ENS3V30371000	3/8	1	3	3/8	3
ENS2V30501000	1/2	1	3	1/2	3
ENS3V30621600	5/8	1 5/8	3 1/2	5/8	3

Recommended Cutting Conditions

Material	Aluminum alloy								
	Shoulder Milling			Shoulder Finishing			Slot Milling		
Application									
VC	1140 ~ 1960 SFM			1370 ~ 2350 SFM			980 ~ 1640 SFM		
Dia (inch)	fz (IPT)	ap	ae	fz (IPT)	ap	ae	fz (IPT)	ap	
1/4	.0017	≤ 1.5×d	≤ 0.3×d	.0017	≤ 1.5×d	≤ 0.1×d	.0028	≤ 1×d	
5/16	.0022	≤ 1.5×d	≤ 0.3×d	.0022	≤ 1.5×d	≤ 0.1×d	.0037	≤ 1×d	
3/8	.0028	≤ 1.5×d	≤ 0.3×d	.0028	≤ 1.5×d	≤ 0.1×d	.0047	≤ 1×d	
1/2	.0033	≤ 1.5×d	≤ 0.3×d	.0033	≤ 1.5×d	≤ 0.1×d	.0055	≤ 1×d	
5/8	.0043	≤ 1.5×d	≤ 0.3×d	.0043	≤ 1.5×d	≤ 0.1×d	.0071	≤ 1×d	

*When machining Aluminum alloy with Si ≥ 8% , reduce RPM 30% and Feed 30%.

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