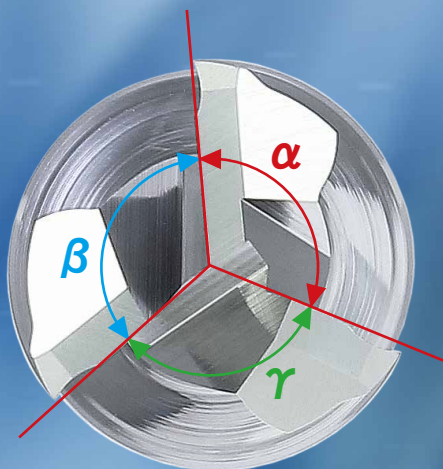


A100 ENS2V Series Varix Carbide Endmills for Aluminum

- *Unequal flute spacing, good for high performance machining.*
- *No chattering surface due to anti-vibration design.*
- *Polished and U flute designs provide excellent chip evacuation.*
- *Good for finishing to roughing of aluminum parts(5052/6061/7075).*

INCH



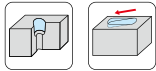
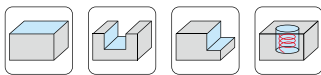
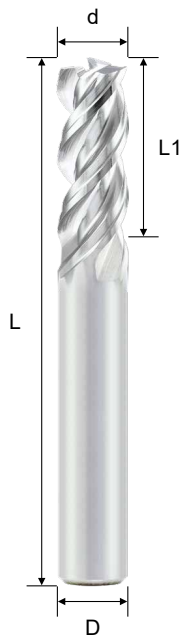
$$\alpha \neq \beta \neq \gamma$$



A100 - Variable Spacing · Square · 3F

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- Polished and U flute designs provide excellent chip evacuation.
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ENS2V



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)
ENS2V30120500	1/8	1/2	2	1/8	3
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								
Application	Shoulder Milling			Shoulder Finishing			Slot Milling		
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%.