

A100 ENSSV Series Varix Carbide Endmills for Aluminum

高進給抗震鋁用銑刀

- **Unequal flute spacing, good for high performance machining.**

METRIC

不等分溝距降低加工震動，增加加工效能

- **No chattering surface due to anti-vibration design.**

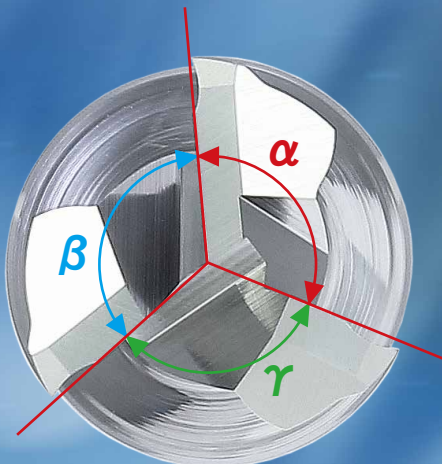
抗震設計避免工件表面震痕

- **U-flute design for excellent chip evacuation.**

U型溝槽，最佳的排屑效果

- **Good for semi-finishing and roughing of aluminum parts(5052/6061/7075).**

適用於鋁材 5052/6061/7075 中、粗加工

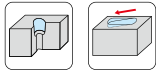
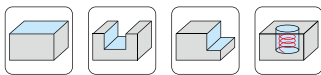
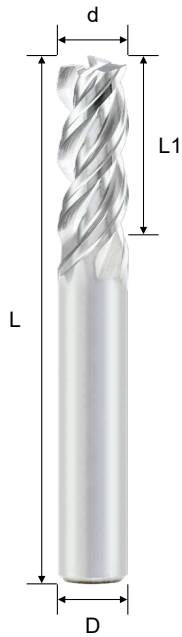


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ENSSV



Ød	Tolerance
3 ≤ Ød ≤ 10	0 ~ -0.03
Ød > 10	0 ~ -0.04

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

Order No.	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
ENSSV303000	3	9	50	6	3
ENSSV304000	4	12	50	6	3
ENSSV305000	5	15	50	6	3
ENSSV306000	6	18	50	6	3
ENSSV308000	8	24	60	8	3
ENSSV310000	10	30	75	10	3
ENSSV312000	12	35	75	12	3
ENSSV316000	16	40	100	16	3

Recommended Cutting Conditions

Material	Aluminum alloy (AL5052 / 6061 / 7075)				
	Shoulder Milling			Slot Milling	
Application	VC			VC	
VC	200 ~ 400 m/min			150 ~ 300 m/min	
Dia (mm)	ap (mm)	ae (mm)	fz (mm/tooth)	ap (mm)	fz (mm/tooth)
3	1.5×d	0.1~0.5×d	0.02	0.5~1.0×d	0.01
4	1.5×d	0.1~0.5×d	0.03	0.5~1.0×d	0.02
5	1.5×d	0.1~0.5×d	0.03	0.5~1.0×d	0.02
6	1.5×d	0.1~0.5×d	0.05	0.5~1.0×d	0.03
8	1.5×d	0.1~0.5×d	0.07	0.5~1.0×d	0.04
10	1.5×d	0.1~0.5×d	0.09	0.5~1.0×d	0.06
12	1.5×d	0.1~0.5×d	0.11	0.5~1.0×d	0.08
16	1.5×d	0.1~0.5×d	0.15	0.5~1.0×d	0.10

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

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