



List 8233 - A Brand AE-VTSS: 3 Flute, Stub Length

List 8333 - A Brand AE-VTSS: 3 Flute, Stub Length

Slotting

Hardness		-		Up to 30 HRC		30-45 HRC		-		-		-	
Work Material		Mild Steels Carbon Steels Cast Iron		Alloys Steel Tool Steel		Prehardened Steel Hardened Steel		Stainless Steel		Precipitation Stainless Steel		Titanium Alloy	
Cutting Speed		330 SFM		230 SFM		200 SFM		200 SFM		165 SFM		165 SFM	
Depth of Cut		$a_a=0.5xD$						$a_a=0.25xD$					
Mill Dia.		Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Inch	mm	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min
-	3	10,600	25.6	7,400	18.9	6,400	13.8	6,400	13.0	5,300	11.8	5,300	11.0
1/8	-	10,076	25.7	7,011	18.9	6,107	13.7	6,107	13.7	5,038	12.1	5,038	12.1
-	4	8,000	26.4	5,600	19.7	4,800	13.8	4,800	13.4	4,000	12.6	4,000	12.2
3/16	-	6,718	26.2	4,674	21.0	4,071	14.7	4,071	15.9	3,359	12.1	3,359	12.1
-	5	6,400	28.0	4,500	22.0	3,800	16.5	3,800	15.4	3,200	13.4	3,200	13.0
-	6	5,300	29.1	3,700	24.4	3,200	18.1	3,200	10.2	2,700	13.0	2,700	12.6
1/4	-	5,038	30.2	3,505	24.2	3,053	18.3	3,053	10.5	2,519	13.2	2,519	12.8
5/16	-	4,031	24.2	2,804	19.3	2,443	17.6	2,443	10.3	2,015	12.1	2,015	11.5
-	8	4,000	24.8	2,800	19.7	2,400	17.3	2,400	10.2	2,000	12.2	2,000	11.8
3/8	-	3,359	23.2	2,337	19.6	2,036	15.3	2,036	9.8	1,679	11.6	1,679	11.1
-	10	3,200	22.8	2,200	19.3	1,900	15.0	1,900	9.4	1,600	11.4	1,600	11.0
-	12	2,700	22.0	1,900	18.1	1,600	15.0	1,600	9.1	1,300	11.4	1,300	11.0
1/2	-	2,519	21.9	1,753	17.9	1,527	15.3	1,527	9.2	1,260	11.3	1,260	11.3

1. Use a rigid and precise machine and holder.
2. The rotational speed is calculated by the median of the recommended cutting speed.
3. Please use a suitable fluid with smoke retardant properties.
4. During dry (no fluid) milling, please use air blow to remove disposable chips from the milling area and to eliminate chip packing.
5. Please use water soluble coolant when machining stainless steel, precipitation stainless steel, and titanium alloy.
6. Reduce speed and feed as well as depth of cut when high precision is required.

Side Milling

Hardness		-		Up to 30 HRC		30-45 HRC		-		-		-	
Work Material		Mild Steels Carbon Steels Cast Iron		Alloys Steel Tool Steel		Prehardened Steel Hardened Steel		Stainless Steel		Precipitation Stainless Steel		Titanium Alloy	
Cutting Speed		330 SFM		295 SFM		200 SFM		200 SFM		165 SFM		165 SFM	
Depth of Cut		$a_a=1xD$ $a_r=0.2xD$											
Mill Dia.		Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Inch	mm	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min
-	3	10,600	37.8	9,600	24.0	6,400	18.1	6,400	12.2	5,300	13.0	5,300	12.2
1/8	-	10,076	36.3	9,014	24.3	6,107	18.3	6,107	12.8	5,038	13.6	5,038	12.1
-	4	8,000	41.7	7,200	25.6	4,800	18.9	4,800	9.8	4,000	14.2	4,000	13.4
3/16	-	6,718	42.3	6,009	25.2	4,071	18.3	4,071	9.8	3,359	14.1	3,359	14.1
-	5	6,400	45.3	5,700	27.2	3,800	21.3	3,800	14.6	3,200	14.6	3,200	13.4
-	6	5,300	46.9	4,800	34.3	3,200	24.8	3,200	16.5	2,700	15.0	2,700	14.2
1/4	-	5,038	46.9	4,507	35.2	3,053	24.7	3,053	16.5	2,519	15.1	2,519	14.4
5/16	-	4,031	39.9	3,605	33.5	2,443	24.9	2,443	16.1	2,015	11.5	2,015	10.9
-	8	4,000	40.2	3,600	34.3	2,400	24.4	2,400	15.7	2,000	11.8	2,000	11.0
3/8	-	3,359	37.3	3,005	30.6	2,036	20.8	2,036	15.9	1,679	11.1	1,679	10.6
-	10	3,200	37.8	2,900	30.7	1,900	20.9	1,900	15.0	1,600	11.0	1,600	10.6
-	12	2,700	31.9	2,400	28.3	1,600	17.3	1,600	14.2	1,300	11.0	1,300	9.8
1/2	-	2,519	30.2	2,253	26.4	1,527	16.5	1,527	13.7	1,260	11.0	1,260	9.8

1. Use a rigid and precise machine and holder.
2. The rotational speed is calculated by the median of the recommended cutting speed.
3. Please use a suitable fluid with smoke retardant properties.
4. During dry (no fluid) milling, please use air blow to remove disposable chips from the milling area and to eliminate chip packing.
5. Please use water soluble coolant when machining stainless steel, precipitation stainless steel, and titanium alloy.
6. Reduce speed and feed as well as depth of cut when high precision is required.






A Brand AE-VTSS

Anti-Vibration, Multi-functional Carbide End Mill Compatible with CNC Lathes

List 8233 - A Brand AE-VTSS: 3 Flute, Stub Length List 8333 - A Brand AE-VTSS: 3 Flute, Stub Length

Plunging

Hardness	-		Up to 30 HRC		30-45 HRC		-		-		-		
Work Material	Mild Steels Carbon Steels Cast Iron		Alloys Steel Tool Steel		Prehardened Steel Hardened Steel		Stainless Steel		Precipitation Stainless Steel		Titanium Alloy		
Cutting Speed	330 SFM		230 SFM		200 SFM		200 SFM		165 SFM		165 SFM		
Depth of Cut	$a_a \leq 0.5 \times D$ 												
Mill Dia.		Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Inch	mm	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min	RPM	in/min
-	3	10,600	9.8	7,400	4.5	6,400	4.3	6,400	4.3	5,300	2.4	5,300	2.4
1/8	-	10,076	10.1	7,011	4.4	6,107	4.6	6,107	4.6	5,038	2.5	5,038	2.5
-	4	8,000	9.8	5,600	4.5	4,800	4.3	4,800	4.3	4,000	2.4	4,000	2.4
3/16	-	6,718	10.1	4,674	4.4	4,071	4.6	4,071	4.6	3,359	2.5	3,359	2.5
-	5	6,400	11.2	4,500	4.7	3,800	4.3	3,800	4.3	3,200	2.6	3,200	2.6
-	6	5,300	12.6	3,700	4.7	3,200	4.3	3,200	4.3	2,700	2.8	2,700	2.8
1/4	-	5,038	12.6	3,505	4.4	3,053	4.6	3,053	4.6	2,519	2.5	2,519	2.5
5/16	-	4,031	12.6	2,804	4.4	2,443	3.8	2,443	4.6	2,015	2.5	2,015	2.5
-	8	4,000	11.8	2,800	4.3	2,400	3.9	2,400	3.9	2,000	2.6	2,000	2.6
3/8	-	3,359	11.3	2,337	4.4	2,036	3.8	2,036	3.8	1,679	2.5	1,679	2.5
-	10	3,200	11.4	2,200	4.1	1,900	3.7	1,900	3.7	1,600	2.4	1,600	2.4
-	12	2,700	10.8	1,900	3.9	1,600	3.5	1,600	3.5	1,300	2.2	1,300	2.2
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