

Speeds and Feeds



HSSCo8, 3 FLUTE ROUGHING For Aluminum (TiCN Coated)

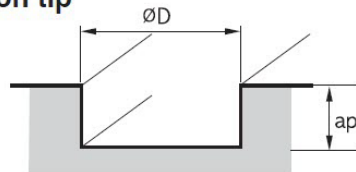
Side Milling

ISO	Material Description	Width of Cut (ae)	Depth of Cut (ap)	Parameter	Diameter (inch)						
					0.250	0.3125	0.375	0.500	0.625	0.750	1.000
N	Aluminum alloys	0.5xD	1.5xD	SFM	385	330	320	340	340	340	340
				RPM	5883	4034	3260	2598	2078	1732	1299
				IPT	.0006	.0010	.0018	.0026	.0039	.0049	.0059
				IPM	10.59	12.10	17.60	20.26	24.31	25.46	22.99

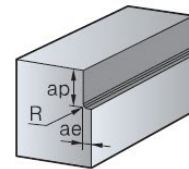
Slot Milling

ISO	Material Description	Width of Cut (ae)	Depth of Cut (ap)	Parameter	Diameter (inch)						
					0.250	0.3125	0.375	0.500	0.625	0.750	1.000
N	Aluminum alloys	1.0xD	1.0xD	SFM	270	230	225	240	240	230	240
				RPM	4126	2812	2292	1834	1467	1171	917
				IPT	.0005	.0008	.0014	.0021	.0031	.0035	.0047
				IPM	6.19	6.75	9.63	11.55	13.64	12.30	12.93

Application tip



- Slotting depth (ap)
 - ap: $\leq 1.0D$



- Shouldering depth (ap)
 - ap: $\leq 1.5D$ (All dia.)
 - ae: $\leq 0.5D$ (All dia.)

* Workpiece should be clamped rigidly. In case of vibrations, reduce R.P.M and feed rate by the same ratio