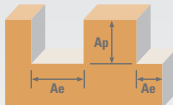


Speed & Feed Recommendations

Series 52, 54 Fractional					Vc (SFM)	Diameter (D ₁) (inch)						
		Flutes	Ae x D ₁	Ap x D ₁		1/8	1/4	3/8	1/2	3/4	1	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075		Profile		1360	RPM	41562	20781	13854	10390	6927	5195
					(1088-1632)	Fz	0.00069	0.0018	0.0034	0.0046	0.0055	0.0064
			2	≤ 0.3		≤ 1.5	Feed (IPM)	57.4	74.8	94.2	95.6	76.2
					1090	RPM	33310	16655	11103	8328	5552	4164
					(872-1308)	Fz	0.00063	0.0017	0.0032	0.0042	0.0050	0.0059
			2	1		≤ 1	Feed (IPM)	42.0	56.6	71.1	70.0	55.5
N	ALUMINUM DIE CAST ALLOYS (HIGH SILICON) A-390, A-392, B-390		Profile		510	RPM	15586	7793	5195	3896	2598	1948
					(408-612)	Fz	0.00069	0.0018	0.0034	0.0046	0.0055	0.0064
			2	≤ 0.3		≤ 1.5	Feed (IPM)	21.5	28.1	35.3	35.8	28.6
					410	RPM	12530	6265	4177	3132	2088	1566
					(328-492)	Fz	0.00063	0.0017	0.0032	0.0042	0.0050	0.0059
			2	1		≤ 1	Feed (IPM)	15.8	21.3	26.7	26.3	20.9
N	COPPER ALLOYS Aluminum Bronze, Nuntz Brass, Naval, Brass, Red Brass		Profile		590	RPM	18030	9015	6010	4508	3005	2254
					(472-708)	Fz	0.00039	0.0010	0.0020	0.0026	0.0031	0.0037
			2	≤ 0.3		≤ 1.5	Feed (IPM)	14.1	18.0	24.0	23.4	18.6
					475	RPM	14516	7258	4839	3629	2419	1815
					(380-570)	Fz	0.00036	0.0010	0.0018	0.0024	0.0029	0.0034
			2	1		≤ 1	Feed (IPM)	10.5	14.5	17.4	17.4	14.0
N	COPPER ALLOYS Beryllium Copper, C110, Manganese Bronze, Tin Bronze		Profile		235	RPM	7182	3591	2394	1795	1197	898
					(188-282)	Fz	0.00039	0.0010	0.0020	0.0026	0.0031	0.0037
			2	≤ 0.3		≤ 1.5	Feed (IPM)	5.6	7.2	9.6	9.3	7.4
					190	RPM	5806	2903	1935	1452	968	726
					(152-228)	Fz	0.00036	0.0010	0.0018	0.0024	0.0029	0.0034
			2	1		≤ 1	Feed (IPM)	4.2	5.8	7.0	7.0	5.6
	PLASTICS ABS, Polycarbonate, PVC, Polypropylene		Profile		1600	RPM	48896	24448	16299	12224	8149	6112
					(1280-1920)	Fz	0.00110	0.0030	0.0056	0.0074	0.0089	0.0100
			2	≤ 0.3		≤ 1.5	Feed (IPM)	107.6	146.7	182.5	180.9	145.1
					1280	RPM	39117	19558	13039	9779	6519	4890
					(1024-1536)	Fz	0.00100	0.0027	0.0051	0.0068	0.0082	0.0095
			2	1		≤ 1	Feed (IPM)	78.2	105.6	133.0	133.0	106.9
	PLASTICS Fiberglass, Glass Filled		Profile		1600	RPM	22003	11002	7334	5501	3667	2750
					(1280-1920)	Fz	0.00082	0.0022	0.0041	0.0055	0.0065	0.0076
			2	≤ 0.3		≤ 1.5	Feed (IPM)	36.1	48.4	60.1	60.5	47.7
					1280	RPM	17572	8786	5857	4393	2929	2197
					(1024-1536)	Fz	0.00075	0.0020	0.0037	0.0050	0.0060	0.0070
			2	1		≤ 1	Feed (IPM)	26.4	35.1	43.3	43.9	35.1

rpm = sfm x 3.82 / D₁

ipm = (inch / flute) x number of flutes x rpm

reduce speed and feed for materials harder than listed

reduce feed and Ae when finish milling (.02 x D₁ maximum)

refer to the SGS Tool Wizard for complete technical information ()