

END MILLING GUIDELINE

D_1 = cutting diameter L_2 = flute length

Speeds and Feeds for Cut Types are based on Radial Width (Rw) and Axial Depth (Ad)

Reductions to Speeds and Feeds may be necessary when:

- Rw and Ad exceed recommendations
- Using long flute or extended reach tools
- Using long tool holders
- Machining materials harder than listed

ENTRY METHODS

Pre-Drilled Hole

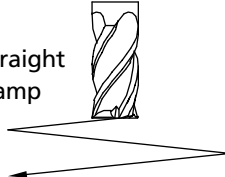


Pre-drilling is the preferred entry method for most applications.

Helical Ramp



Straight Ramp



Alternative methods are helical and straight ramping. High ramp angles require reduced feed. Lower ramp angles will allow higher feed rates and extend tool life. Use slotting speeds and feeds for ramp angles of 1° to 2° . Reduce feed to 25% when ramp angles approach 6° . General purpose tools and/or difficult to machine materials will require lower ramp angles and reduced feed.

Plunge



Plunge only in non-ferrous and short-chipping materials using slotting speeds and 25% slotting feeds.