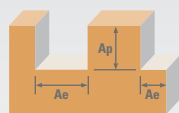


Speed & Feed Recommendations



Series
44, 45, 43CR, 43CB,
43LC, 43, 43L, 47,
47B, 47ES, 47EB
Fractional



44, 45, 43CR, 43CB, 43LC, 43, 43L, 47, 47B, 47ES, 47EB Fractional							Vc (SFM)	Diameter (D ₁) (inch)							
					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, 6073, 7975		1	≤ 1	(1280-1920)	1600	RPM	48896	24448	16299	12224	8149	6112		
						Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085			
						Feed 2 flutes (IPM)	88	122	147	147	114	104			
						Feed 3 flutes (IPM)	132	183	220	220	171	156			
			≤ 0.5	≤ 1.5	(1600-2400)	2000	RPM	61120	30560	20373	15280	10187	7640		
						Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085			
						Feed 2 flutes (IPM)	110	153	183	183	143	130			
						Feed 3 flutes (IPM)	165	229	275	275	214	195			
			≤ 0.5	≤ 2	(2640-3960)	3300	RPM	100848	50424	33616	25212	16808	12606		
						Fz	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195			
						Feed 2 flutes (IPM)	424	555	706	706	555	492			
						Feed 3 flutes (IPM)	635	832	1059	1059	832	737			
		N	ALUMINUM DIE CAST ALLOYS (HIGH SILICONE) A-390, A-392, B- 390		1	≤ 1	(480-720)	600	RPM	18336	9168	6112	4584	3056	2292
								Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085	
Feed 2 flutes (IPM)	33							46	55	55	43	39			
Feed 3 flutes (IPM)	50							69	83	83	64	58			
	≤ 0.5			≤ 1.5	(600-900)	750	RPM	22920	11460	7640	5730	3820	2865		
						Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085			
						Feed 2 flutes (IPM)	41	57	69	69	53	49			
						Feed 3 flutes (IPM)	62	86	103	103	80	73			
	≤ 0.5			≤ 2	(992-1488)	1240	RPM	37894	18947	12631	9474	6316	4737		
						Fz	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195			
						Feed 2 flutes (IPM)	159	208	265	265	208	185			
						Feed 3 flutes (IPM)	239	313	398	398	313	277			
N	COPPER ALLOYS Aluminum Bronze Brass Naval Brass Red Brass		1	≤ 1	(692-1038)	865	RPM	26434	13217	8811	6609	8149	6112		
						Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070			
						Feed 2 flutes (IPM)	42	53	70	66	98	86			
						Feed 3 flutes (IPM)	63	79	106	99	147	128			
			≤ 0.5	≤ 1.5	(864-1296)	1080	RPM	33005	16502	11002	8251	5501	4126		
						Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070			
						Feed 2 flutes (IPM)	53	66	88	83	66	58			
						Feed 3 flutes (IPM)	79	99	132	124	99	87			
			≤ 0.5	≤ 2	(1424-2136)	1780	RPM	54397	27198	18132	13599	9066	6800		
						Fz	0.0017	0.0045	0.0085	0.0115	0.0140	0.0160			
						Feed 2 flutes (IPM)	185	245	308	313	254	218			
						Feed 3 flutes (IPM)	277	367	462	469	381	326			

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