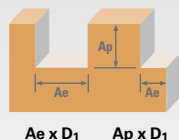


Speed & Feed Recommendations



Series
44M, 43MCR, 43MCB,
43M, 47M, 47MB,
47MES, 47MEB
Metric



N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6073, 7975				Vc (m/min)		Diameter (D ₁) (mm)								
					3	6	10	12	20	25	30	35	40		
						1	≤ 1	490	RPM	52022	26011	15607	13005	7803	6243
								(392-588)	Fz	0.022	0.060	0.120	0.144	0.187	0.213
									Feed 2 flutes (m/min)	2247	3121	3746	3745	2913	2653
						≤ 0.5	≤ 1.5	610	RPM	64762	32381	19429	16190	9714	7771
								(488-732)	Fz	0.022	0.060	0.120	0.144	0.187	0.213
									Feed 2 flutes (m/min)	2797	3885	4663	4662	3627	3303
						≤ 0.5	≤ 2	1005	RPM	106698	53349	32009	26674	16005	12804
								(804-1206)	Fz	0.050	0.132	0.280	0.336	0.440	0.488
Feed 2 flutes (m/min)	10754	14083	17925	17924					14084	12484					
N	ALUMINUM DIE CAST ALLOYS (HIGH SILICONE) A-390, A-392, B- 390				Vc (m/min)		Diameter (D ₁) (mm)								
					3	6	10	12	20	25	30	35	40		
						1	≤ 1	185	RPM	19641	9820	15607	13005	7803	6243
								(148-222)	Fz	0.022	0.060	0.120	0.144	0.187	0.213
									Feed 2 flutes (m/min)	848	1178	3746	3745	2913	2653
						≤ 0.5	≤ 1.5	230	RPM	24418	12209	7326	6105	3663	2930
								(184-276)	Fz	0.022	0.060	0.120	0.144	0.187	0.213
									Feed 2 flutes (m/min)	1055	1465	1758	1758	1367	1245
						≤ 0.5	≤ 2	380	RPM	40343	20172	12103	10086	6052	4841
								(304-456)	Fz	0.050	0.132	0.280	0.336	0.440	0.488
Feed 2 flutes (m/min)	4066	5325	6778	6777					5325	4720					
N	COPPER ALLOYS Aluminum Bronze Brass Naval Brass Red Brass				Vc (m/min)		Diameter (D ₁) (mm)								
					3	6	10	12	20	25	30	35	40		
						1	≤ 1	265	RPM	28134	14067	8440	7034	7803	6243
								(212-318)	Fz	0.019	0.048	0.107	0.120	0.160	0.175
									Feed 2 flutes (m/min)	1080	1350	1801	1688	2497	2185
						≤ 0.5	≤ 1.5	330	RPM	35035	17518	10511	8759	5255	4204
								(264-396)	Fz	0.019	0.048	0.107	0.120	0.160	0.175
									Feed 2 flutes (m/min)	1345	1682	2242	2102	1682	1472
						≤ 0.5	≤ 2	545	RPM	57861	28930	17358	14465	8679	6943
								(436-654)	Fz	0.041	0.108	0.227	0.276	0.373	0.400
Feed 2 flutes (m/min)	4721	6248	7869	7984					6480	5555					

continued on next page