

SPEEDS & FEEDS

3 Flute - 35° Helix



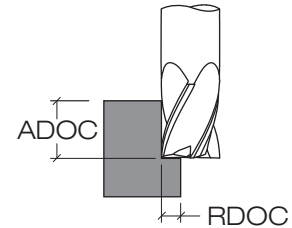
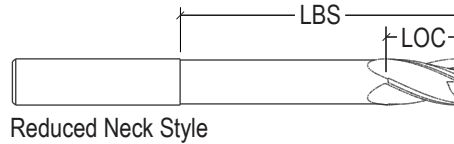
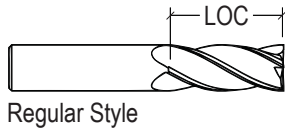
H35AL-3

Material Guide		SFM	Inches per Tooth (IPT)																							
			1/8			3/16			1/4			3/8			1/2			3/4			1					
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin			
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0007	.0013	.0016	.0011	.0019	.0018	.0014	.0026	.0020	.0021	.0038	.0023	.0027	.0050	.0027	.0039	.0072	.0033	.0050	.0091	.0039			
			.0011	.0020	.0020	.0017	.0030	.0022	.0022	.0040	.0025	.0033	.0059	.0029	.0043	.0078	.0034	.0061	.0111	.0040	.0078	.0142	.0049			
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0027	.0021	.0022	.0040	.0024	.0029	.0052	.0028	.0041	.0074	.0033	.0052	.0095	.0040			

Milling Process	Style	ADOC	RDOC
Slot (Full Slotting)	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-40% Diameter
	Reached	Up to Max LOC	30%-40% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut