



5-Flute Square and Corner Radius, Standard and Neck Relief and Chip Control, 35 Degree Helix Extra High Performance Endmills for Aluminum.



- RedLine 5 Flute End Mills are (DLC) Diamond Like Carbon Coated to provide Extra High Performance when cutting Aluminum.
- With 5 Flutes you will get increased productivity with an excellent surface finish, and are designed to Rough, Slot, Finish and be used with High Efficiency Machining programs.
- 5-Flute Extra High Performance, Variable Helix End Mills
- These Extra High Performance tools can be found on page 26-32.

Aluminum Speeds & Feeds

Material	Grades	Cut Type	Axial DOC	Radial DOC	# of Flutes	SFM	Feed by Endmill Diameter (IPT)					
							1/4	3/8	1/2	5/8	3/4	1
							(.2500)	(.3750)	(.5000)	(.6250)	(.7500)	(1.000)
N - Non-Ferrous												
Aluminum Alloys	6061, 7075, 2024	Slotting	1 x D	1 x D	5	600	.0015	.002250	.0030	.003750	.00450	.0060
		Peripheral - Rough	<=2 x D	.45 x D	5	1000	.0024	.003600	.0048	.006000	.00720	.0096
			>2-3 x D	.375 x D	5	900	.0023	.003450	.0046	.005750	.00690	.0092
			>3-4 x D	.35 x D	5	800	.00225	.003375	.0045	.005625	.00675	.0090
		Peripheral - HEM	<=2 x D	.25 x D	5	850	.00500	.007500	.0100	.012500	.01500	.0200
			>2-2.5 x D	.25 x D	5	800	.00500	.007500	.0100	.012500	.01500	.0200
			>2.5-3 x D	.25 x D	5	800	.00500	.007500	.0100	.012500	.01500	.0200
			>3-3.5 x D	.25 x D	5	800	.00475	.007125	.0095	.011875	.01425	.0190
		>3.5-4 x D	.20 x D	5	780	.00475	.007125	.0095	.011875	.01425	.0190	
		Finish	<= 4 x D	.01 x D	5	650	.00150	.002250	.0030	.003750	.00450	.0060

NOTE: HEM (high efficiency machining) technical information can be found on page 208.