





TuffCut® XR-AL

334 Series Recommended Cutting Data - Profile Milling Inch

Workpiece Material Group	ISO	Coolant • Preferred 	Profile Milling (ap)		
					
			1 x D	1.5 x D	2 x D
Max.			vc - SFM		
Non-Ferrous - Aluminum	N	•	2000-2500	1750-2000	1250-1750
Non-Ferrous - Aluminum Cast	N	•	1800-2000	1400-1600	1000-1400
Non-Ferrous - Brass Yellow/Red	N	•	750-1250	500-1000	400-800
Non-Ferrous - Bronze, Aluminum Bronze	N	•	500-1000	400-800	300-800
Non-Ferrous - Copper	N	•	1500-2000	1250-1500	800-1200

Diameter	1/4	1/4	3/8	3/8	1/2	1/2	5/8	5/8	3/4	3/4	1	1
Max. ae	30%	50%	30%	50%	30%	50%	30%	50%	30%	50%	30%	50%
fz=in/tooth	.008	.006	.012	.009	.016	.012	.018	.013	.020	.015	.024	.018

Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula:
 $(\text{Calculated Feed} \times \text{Spindle Maximum}) / \text{Calculated Speed}$. Above 20,000 rpm, tool balancing required.

ISO 9001:2015 Certified



Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.