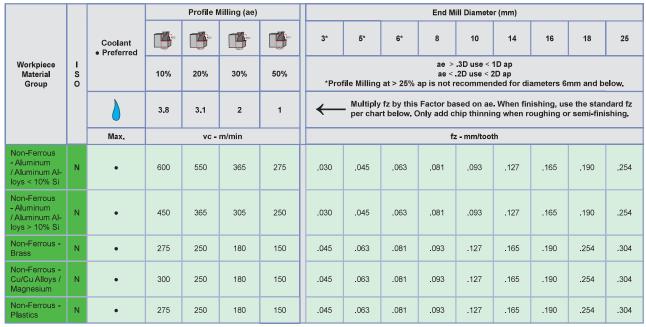
## TuffCut® AL / X-AL

## 134 / 134N / 134S / 135 / 135N Recommended Cutting Data - Profile Milling Inch

Workpiece Material Group	I S O	Coolant ● Preferred	Profile Milling (ae)				End Mill Diameter										
			ADC	RDO	ACC RECO	ASC REC	3/16	,	1/4*	5/16	3/8	1/2	5/8	3/4	1		
			10%	20%	30%	50%	ae > .3D use < 1D ap ae < .2D use < 2D ap *Profile Milling at > 25% ap is not recommended for diameters 1/4" and below.										
		8	3.8	3.1	2	1	<b>←</b>	Multiply fz by this Factor based on ae. When finishing, use the standard fz per chart below. Only add chip thinning when roughing or semi-finishing.									
		Max.	vc - SFM				fz - in/tooth										
Non-Ferrous - Aluminum / Aluminum Alloys < 10% Si	N	•	2000	1800	1200	900	.001	3	.0025	.0032	.0037	.0050	.0065	.0075	.0100		
Non-Ferrous - Alumi- num / Aluminum Alloys > 10% Si	N	•	1500	1200	1000	800	.001	3	.0025	.0032	.0037	.0050	.0065	.0075	.0100		
Non-Ferrous - Brass	N	•	900	800	600	500	.002	5	.0032	.0037	.0050	.0065	.0075	.0100	.0120		
Non-Ferrous - Cu/Cu Alloys / Magnesium	N	•	1000	800	600	500	.002	5	.0032	.0037	.0050	.0065	.0075	.0100	.0120		
Non-Ferrous - Plastics	N	•	900	800	600	500	.002	5	.0032	.0037	.0050	.0065	.0075	.0100	.0120		

Above 20,000 RPM, Tool Balancing Required

## 134 / 134N / 134S / 135 / 135N Recommended Cutting Data - Profile Milling Metric



Above 20,000 RPM, Tool Balancing Required

Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula: (Calculated Feed x Spindle Maximum)/Calculated Speed