

H45AL-C-3



SPEEDS & FEEDS

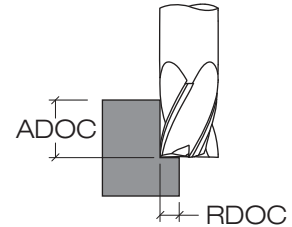
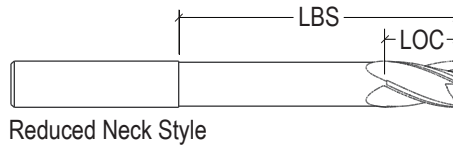
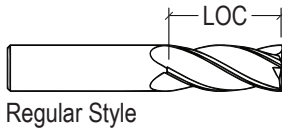
3 Flute - 45° Helix - Chipbreaker Rougher

H45AL-C-3 / H45AL-C-RN-3																
Material Guide		SFM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		3/8		1/2		3/4		1	
			Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0007	.0015	.0011	.0022	.0014	.0029	.0021	.0043	.0028	.0056	.0040	.0081	.0051	.0103
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0011	.0023	.0017	.0034	.0022	.0045	.0033	.0067	.0044	.0088	.0062	.0125	.0080	.0160
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn-36Pb3, CuZn10, CuSn5	770	.0008	.0015	.0011	.0023	.0015	.0030	.0022	.0045	.0029	.0059	.0042	.0084	.0053	.0107

Milling Process	ADOC	RDOC	
Slot (Full Slotting)	Non-Reached	100%-150% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Non-Reached	100%-150% Diameter	35%-50% Diameter
	Reached	Up to Max LOC	30%-40% 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