

# HFAL-2

# SPEEDS & FEEDS

## High Feed End Mills - Aluminum

HFAL-2/MHFAL-2																
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
<b>WROUGHT ALUMINUM ALLOY</b>	2014, 5062, 6061, 7050, 7075, 7475	2100	.0023	.0032	.0036	.0046	.0050	.0055	.0082	.0091	.0100	.0114	.0160	.0182	.0205	.0228
<b>CAST ALUMINUM ALLOY</b>	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0041	.0046	.0068	.0082	.0082	.0100	.0128	.0160	.0160	.0205	.0251	.0319	.0319	.0410
<b>COPPER ALLOY</b>	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0027	.0036	.0041	.0055	.0055	.0068	.0091	.0100	.0114	.0137	.0182	.0205	.0228	.0274

Milling Process	ADOC	RDOC
Slot (Full Slotting)	3.00%-5.00% Diameter	100% Diameter
Rgh (Traditional Roughing)	3.00%-5.00% Diameter	Up to 65% Diameter

**NOTES:**

IPT values shown are for 4xD reach tools, for tools with reaches greater than 4xD, IPT should be reduced.

Please note for slotting applications, axial engagement will increase while axial stepdown (ADOC) remains the same.

