HFAL-2

SPEEDS & FEEDS

High Feed End Mills - Aluminum

	HFAL-2/MHFAL-2															
	SFM	Inches per Tooth (IPT)														
Material Guide		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	.0023	.0032	.0036	.0046	.0050	.0055	.0082	.0091	.0100	.0114	.0160	.0182	.0205	.0228
CAST ALUMINUM ALLOY	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
COPPER ALLOY	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.

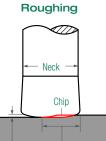


Chip

ADOC

Axial

Engagement



RDOC

ADOC