

HACF-TN-3

SPEEDS AND FEEDS Contour Finishers - 3 Flute - Ball - Tapered Neck

HACF-3									
Material Guide		SFM	Inches per Tooth (IPT)						
			1/8	3/16	1/4	3/8	1/2	3/4	1
			Fin	Fin	Fin	Fin	Fin	Fin	Fin
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0029	.0032	.0036	.0041	.0049	.0059	.0070
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0036	.0040	.0045	.0052	.0061	.0072	.0088
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0029	.0032	.0038	.0043	.0050	.0059	.0072

MILLING PROCESS	HARDNESS	ADOC	RDOC
Fin (Finishing)	< 35 HRC	Up to Max LOC	4%-6% Diameter
	≥ 35 HRC	Up to Max LOC	4%-6% Diameter

NOTE:
ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements