

## SPEEDS & FEEDS

40° Helix - Variable Pitch



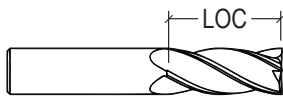
**H40ALV-3**

H40ALV-3 / H40ALV-RN-3																								
Material Guide		SFM	Inches per Tooth (IPT)																					
			1/8			3/16			1/4			3/8			1/2			3/4			1			
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0008	.0014	.0017	.0011	.0021	.0019	.0015	.0028	.0022	.0022	.0041	.0025	.0029	.0054	.0029	.0041	.0077	.0035	.0053	.0098	.0042	
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0012	.0022	.0021	.0017	.0033	.0024	.0023	.0043	.0027	.0034	.0064	.0031	.0045	.0084	.0036	.0064	.0120	.0043	.0082	.0153	.0052	
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0008	.0015	.0017	.0012	.0022	.0020	.0016	.0029	.0022	.0023	.0043	.0025	.0030	.0056	.0030	.0043	.0081	.0035	.0055	.0103	.0043	

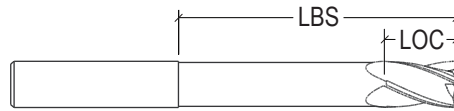
Milling Process	Style	ADOC	RDOC
Slot (Full Slotting)	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-40% Diameter
	Reached	Up to Max LOC	30%-40% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

**NOTES:**

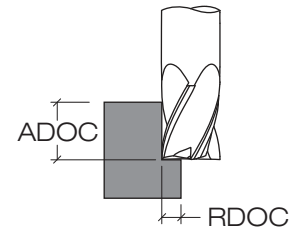
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut