

HVAL-C-5



SPEEDS & FEEDS

5 Flute - Chipbreaker Rougher - Variable Pitch -
For High Efficiency Milling

HVAL-C-5																	
Material Guide		SFM	Inches per Tooth (IPT)														
			1/8		3/16		1/4		3/8		1/2		3/4		1		
			HEM	Rgh	HEM	Rgh	HEM	Rgh	HEM	Rgh	HEM	Rgh	HEM	Rgh	HEM	Rgh	
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0018	.0013	.0023	.0020	.0030	.0026	.0045	.0039	.0059	.0051	.0084	.0073	.0107	.0094	
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0023	.0021	.0035	.0031	.0047	.0041	.0070	.0061	.0091	.0080	.0131	.0114	.0167	.0145	
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0018	.0014	.0023	.0021	.0031	.0028	.0047	.0041	.0061	.0053	.0087	.0076	.0112	.0097	

Milling Process	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Rgh (Traditional Roughing)	125%-200% Diameter	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. For more accurate running parameters, please refer to Machining Advisor Pro.