

HMAF-AL-4



SPEEDS & FEEDS

Multi-Axis Finisher - 4 Flute

HMAF-AL-4									
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	.0024	.0027	.0030	.0035	.0041	.0050	.0059
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0030	.0033	.0038	.0044	.0051	.0060	.0074
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0024	.0027	.0032	.0036	.0042	.0050	.0060

Style	Toolpath	ADOC (Stock Removal)	RDOC (Stepover Per Pass)
HMAF-AL-4 Oval	Finishing (Fin)	.005"-.010"	.025 x Dia x Benefit Multiple
HMAF-AL-4 Taper	Finishing (Fin)	.005"-.010"	.025 x Dia x Benefit Multiple

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

If converting from a ball end mill, the benefit multiple can be used to recalculate stepover pass-to-pass