

# HMAF-AL-3



## SPEEDS & FEEDS

### Multi-Axis Finisher - 3 Flute

| HMAF-AL-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 | .0016                  | .0018 | .0020 | .0023 | .0027 | .0033 | .0039 |
| CAST ALUMINUM ALLOY    | 319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0 | 1400 | .0020                  | .0022 | .0025 | .0029 | .0034 | .0040 | .0049 |
| COPPER ALLOY           | Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5               | 770  | .0016                  | .0018 | .0021 | .0024 | .0028 | .0033 | .0040 |

| Style          | Toolpath        | ADOC (Stock Removal) | RDOC (Stepover Per Pass)      |
|----------------|-----------------|----------------------|-------------------------------|
| HMAF-AL-3 Lens | 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