3 FLUTE - CORNER RADIUS

Coolant Through - High Balance - Reduced Neck

HMGC-RN-3

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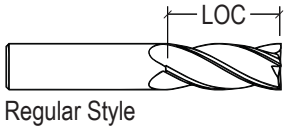
Material Guide		SFM	Inches per Tooth (IPT)																					
			1/8			3/16			1/4			3/8			1/2			3/4			1		
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0007	.0015	.0016	.0011	.0022	.0018	.0014	.0029	.0021	.0021	.0043	.0024	.0028	.0056	.0028	.0040	.0080	.0033	.0051	.0102	.0040
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0011	.0023	.0020	.0017	.0034	.0023	.0022	.0045	.0026	.0033	.0066	.0030	.0043	.0087	.0035	.0062	.0124	.0041	.0079	.0158	.0050
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0008	.0015	.0017	.0011	.0023	.0019	.0015	.0030	.0021	.0022	.0044	.0024	.0029	.0058	.0028	.0041	.0083	.0034	.0053	.0106	.0041

Milling Process	ADOC	RDOC
Slot (Full Slotting)	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Up to Max LOC	35%-50% Diameter
Fin (Finishing)	Up to Max LOC	4%-6% Diameter

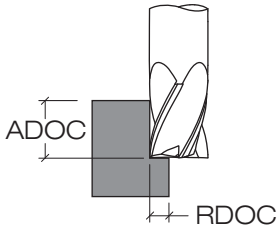
NOTES:

IPT values shown are for 4xD reach tools, and should be adjusted for longer or shorter reaches. For tools with reaches greater than 4xD, 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