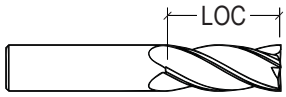
MH30AL-2 / MH30AL-RN-2

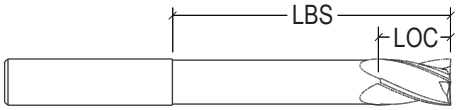
Material Guide	Material Number	V_C m/min.	f_Z (mm/tooth)																										
			Ø 3			Ø 4			Ø 5			Ø 6			Ø 8			Ø 10			Ø 12			Ø 16			Ø 20		
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
WROUGHT ALUMINIUM ALLOY	3.1255 – 3.3523 – 3.3211 – 3.4144 – 3.4345 – 3.4365	640	0.018	0.033	0.041	0.023	0.042	0.044	0.028	0.053	0.047	0.034	0.064	0.053	0.045	0.084	0.057	0.056	0.105	0.061	0.067	0.124	0.071	0.087	0.161	0.077	0.105	0.196	0.085
CAST ALUMINIUM ALLOY	3.2151 – 3.2161 – 3.2381 – 3.3292	440	0.027	0.051	0.052	0.036	0.066	0.055	0.044	0.083	0.058	0.053	0.100	0.066	0.070	0.131	0.071	0.087	0.163	0.076	0.103	0.194	0.088	0.135	0.250	0.096	0.164	0.306	0.105
COPPER ALLOY	2.0065 – 2.1247 – 2.0265 – 2.0375 – 2.0230	235	0.018	0.034	0.042	0.024	0.044	0.045	0.030	0.055	0.047	0.036	0.067	0.054	0.047	0.088	0.058	0.058	0.109	0.062	0.069	0.130	0.073	0.090	0.167	0.080	0.110	0.205	0.087

MILLING PROCESS	STYLE	ADOC (ap)	RDOC (ae)
Slot (Full Slotting)	Non-reached (MH30AL-2)	75%-125% Diameter	100% Diameter
	Reached (MH30AL-RN-2)	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Non-reached (MH30AL-2)	125%-200% Diameter	30%-40% Diameter
	Reached (MH30AL-RN-2)	Up to Max LOC	30%-40% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

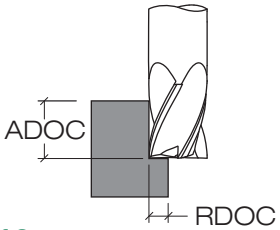
NOTES:
Feed per tooth, fz, values shown are for 3xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, fz should be reduced. For more accurate machining parameters , please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut **ADOC (ap)=Axial Depth of Cut** **RDOC (ae)=Radial Depth of Cut**