HVAL-5

SPEEDS & FEEDS

5 Flute - Variable Pitch - For High Efficency Milling

HVAL-5																							
Material Guide		SFM	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			3/8			1/2			3/4			1		
			HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2100	.0018	.0013	.0018	.0023	.0020	.0020	.0030	.0026	.0023	.0045	.0039	.0027	.0059	.0051	.0031	.0084	.0073	.0037	.0107	.0094	.0045
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1400	.0023	.0021	.0023	.0035	.0031	.0025	.0047	.0041	.0029	.0070	.0061	.0033	.0091	.0080	.0039	.0131	.0114	.0046	.0167	.0145	.0056
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0018	.0014	.0018	.0023	.0021	.0021	.0031	.0028	.0024	.0047	.0041	.0027	.0061	.0053	.0032	.0087	.0076	.0038	.0112	.0097	.0046

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
Fin (Finishing)	Up to Max LOC	4%-6% 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.