

# Series *AL3F*

## Cutting Parameters

### Suggested Starting Speeds & Feed Rates

Material Group	ISO Code	Material Examples	Finishing Cuts		Medium Cuts		Heavy Cuts		Slotting		Facing		Ramping		High Feed	
			.1D Radial x 2D Axial		.25D Radial x 1.5D Axial		.5D Radial x 1.5D Axial		.5D Axial		.75D Radial x .25D Axial		Max. Ramp Angle - 10°		.05D Radial x 3D Axial	
			SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM
Non-Ferrous	N	Aluminum 6061, 6063, 7050, 7075	1500	400.00	1500	350.00	1500	300.00	1200	250.00	1200	350	1200	350.00	2000	500
		Copper, Brass, Bronze, Plastics, Fibreglass	500	70.00	500	50.00	500	40.00	500	30.00	500	50	500	40.00	n/a	n/a

### Recommended Chip Loads

Material Group	ISO Code	Material Examples	Cutting Diameter						
			3/16	1/4	3/8	1/2	5/8	3/4	1
Non-Ferrous	N	Aluminium, Copper, Brass, Bronze	0.0040	0.0050	0.0070	0.0090	0.0100	0.0120	0.0150
		Plastics, Fibreglass	0.0020	0.0025	0.0035	0.0045	0.0055	0.0065	0.0080