

SPEEDS AND FEEDS

2-FLUTE 55 DEGREE
CGS "FEROCIOUS" END MILL
For High-Speed Milling of Aluminum

DIAMETER	FEED PER TOOTH	STARTING RPM
1/8	.001	12,000
3/16	.002	10,000
1/4	.003	10,000
5/16	.004	8,000
3/8	.005	8,000
1/2	.006	8,000
5/8	.007	6,000
3/4	.008	4,000
1	.010	4,000

**Note: If the cutting length exceeds 1-1/2 times the diameter size of the tool, conventional milling is recommended.*

WARNING:

TOO LOW OF AN RPM COUPLED WITH TOO MUCH FEED

MIGHT CAUSE THE TOOL TO SHATTER

FOR BEST RESULTS

***DIRECT MULTIPLE COOLANT NOZZLES
AT THE END MILL TO ASSURE CONSTANT
COOLING OF THE TOOL AND TO FLUSH CHIPS***