



CONSIDER THESE ADVANTAGES:

- **MAXIMUM SPINDLE SPEEDS POSSIBLE**
- **DRAMATIC FEED RATE INCREASE**
- **BETTER SHEARING ACTION**
- **VERTICAL CHIP EJECTION**
- **QUIET OPERATION**
- **LONGER TOOL LIFE**

SPEEDS AND FEEDS		
TOOL DIAMETER	I.P.T (INCH 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



TEST RESULTS	COMPETITION	FEROCIOUS	COMPETITION	FEROCIOUS	COMPETITION	FEROCIOUS
MATERIAL TYPE	6063-T6	6063-T6	7075-T6	7075-T6	6061-T6	6061-T6
TOOL MATERIAL	CARBIDE	CARBIDE	HSS	CARBIDE	CARBIDE	CARBIDE
NUMBER OF FLUTES	2	2	3	2	2	2
CUTTER SIZE	1/2"	1/2"	3/4"	3/4"	3/8"	3/8"
CUTTER DEPTH	.550	.550	.750	.750	.500	.500
RADIAL DEPTH OF CUT	SLOT	SLOT	.650	.650	SLOT	SLOT
R.P.M.	6500	10,000	3056	10,000	3400	7500
I.P.M.	25	120	28	140	10	75
COATING	NONE	YES	YES	YES	NONE	YES

WARNING:

- TOO LOW OF AN RPM COUPLED WITH TOO MUCH FEED MIGHT CAUSE THE TOOL TO SHATTER
- IF THE CUTTING LENGTH EXCEEDS 1-1/2 TIMES THE DIAMETER SIZE OF THE TOOL, CONVENTIONAL MILLING IS RECOMMENDED.

FOR BEST RESULTS:

- DIRECT MULTIPLE COOLANT NOZZLES AT THE END MILL TO ASSURE CONSTANT COOLING OF THE TOOL AND TO FLUSH CHIPS.
- THESE TOOLS ARE SPECIALLY DESIGNED FOR HI-SPEED MILLING OF ALUMINUM.
- THE FEEDS LISTED ARE STARTING POINTS. VARIATIONS OF THESE WILL DEPEND ON THE RADIAL AND AXIAL DEPTH-OF-CUT AND WORK PIECE CONDITIONS.