



List 7020: Stub Length, 2 Flute

List 7120: Regular Length, 2 Flute

List 7010: Long Length, 2 Flute

List 7110: Ball End, Regular Length, 2 Flute

Standard

| Work Material | Graphite | Green Ceramic Thermoset Plastic | Fiber Filler Plastics | Aluminum Alloys | Metal Matrix Composite (MMC, AlSiC) | Copper Alloys | | | | | | | | | | | | | | | | | | | |
|---------------|--|------------------------------------|--------------------------|-----------------|---|---------------|-----------|---------------|-----------|---------------|-----------|---------------|--|--|---|--|-----|----|----|-------|------|-------|-------|----|------|
| Cutting Speed | 160-300 SFM | 80-140 SFM | 130-800 SFM | 160-800 SFM | 100-750 SFM | 328-649 SFM | | | | | | | | | | | | | | | | | | | |
| Depth of Cut | <table border="1"> <thead> <tr> <th>Dia</th> <th>aa</th> <th>ar</th> </tr> </thead> <tbody> <tr> <td>D≤1/8</td> <td>0.02D</td> <td>0.05D</td> </tr> <tr> <td>D>1/8</td> <td>0.10D</td> <td>0.20D</td> </tr> </tbody> </table> | | | Dia | aa | ar | D≤1/8 | 0.02D | 0.05D | D>1/8 | 0.10D | 0.20D | | | <table border="1"> <thead> <tr> <th>Dia</th> <th>aa</th> <th>ar</th> </tr> </thead> <tbody> <tr> <td>D≤1/8</td> <td>0.5D</td> <td>0.05D</td> </tr> <tr> <td>D>1/8</td> <td>1D</td> <td>0.1D</td> </tr> </tbody> </table> | | Dia | aa | ar | D≤1/8 | 0.5D | 0.05D | D>1/8 | 1D | 0.1D |
| | Dia | aa | ar | | | | | | | | | | | | | | | | | | | | | | |
| D≤1/8 | 0.02D | 0.05D | | | | | | | | | | | | | | | | | | | | | | | |
| D>1/8 | 0.10D | 0.20D | | | | | | | | | | | | | | | | | | | | | | | |
| Dia | aa | ar | | | | | | | | | | | | | | | | | | | | | | | |
| D≤1/8 | 0.5D | 0.05D | | | | | | | | | | | | | | | | | | | | | | | |
| D>1/8 | 1D | 0.1D | | | | | | | | | | | | | | | | | | | | | | | |
| Mill Dia. | Speed RPM | Feed in/tooth | Speed RPM | Feed in/tooth | Speed RPM | Feed in/tooth | Speed RPM | Feed in/tooth | Speed RPM | Feed in/tooth | Speed RPM | Feed in/tooth | | | | | | | | | | | | | |
| 1/32 | 25,000 | 0.0005-0.0010 | 13,450 | 0.0005-0.0010 | 25,000 | 0.0004-0.0008 | 25,000 | 0.0004-0.0008 | 25,000 | 0.0004-0.0008 | 25,000 | 0.0004-0.0008 | | | | | | | | | | | | | |
| 1/16 | 14,060 | 0.0010-0.0020 | 6,720 | 0.0010-0.0020 | 25,000 | 0.0010-0.0020 | 25,000 | 0.0010-0.0020 | 25,000 | 0.0010-0.0020 | 25,000 | 0.0010-0.0020 | | | | | | | | | | | | | |
| 3/32 | 9,370 | 0.0010-0.0020 | 4,480 | 0.0010-0.0020 | 19,560 | 0.0010-0.0020 | 19,560 | 0.0010-0.0020 | 17,320 | 0.0010-0.0020 | 19,890 | 0.0010-0.0020 | | | | | | | | | | | | | |
| 1/8 | 7,030 | 0.0010-0.0020 | 3,360 | 0.0010-0.0020 | 14,670 | 0.0010-0.0020 | 14,670 | 0.0010-0.0020 | 12,990 | 0.0010-0.0020 | 14,910 | 0.0010-0.0020 | | | | | | | | | | | | | |
| 3/16 | 4,690 | 0.0010-0.0020 | 2,240 | 0.0010-0.0020 | 9,780 | 0.0010-0.0020 | 9,780 | 0.0010-0.0020 | 8,660 | 0.0010-0.0020 | 9,940 | 0.0010-0.0020 | | | | | | | | | | | | | |
| 1/4 | 3,510 | 0.0020-0.0040 | 1,680 | 0.0020-0.0040 | 7,330 | 0.0015-0.0030 | 7,330 | 0.0015-0.0030 | 6,500 | 0.0015-0.0030 | 7,460 | 0.0015-0.0030 | | | | | | | | | | | | | |
| 5/16 | 2,810 | 0.0020-0.0040 | 1,350 | 0.0020-0.0040 | 5,870 | 0.0020-0.0040 | 5,870 | 0.0020-0.0040 | 5,200 | 0.0020-0.0040 | 5,960 | 0.0020-0.0040 | | | | | | | | | | | | | |
| 3/8 | 2,340 | 0.0030-0.0050 | 1,120 | 0.0030-0.0050 | 4,890 | 0.0030-0.0050 | 4,890 | 0.0030-0.0050 | 4,330 | 0.0030-0.0050 | 4,970 | 0.0030-0.0050 | | | | | | | | | | | | | |
| 1/2 | 1,760 | 0.0030-0.0050 | 840 | 0.0030-0.0050 | 3,670 | 0.0030-0.0050 | 3,670 | 0.0030-0.0050 | 3,250 | 0.0030-0.0050 | 3,730 | 0.0030-0.0050 | | | | | | | | | | | | | |

1. Please reduce speed and feed by 20% when L/D>3D.
2. Please reduce speed and feed by 30% when slotting > 0.5D.
3. Please reduce depth of cut if running at elevated speed and feed.

