




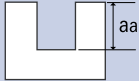
List 8120: Regular Length - 2 Flute

Side Milling

Work Material	Aluminum Alloys		Copper Alloys	
Cutting Speed	650 SFM		245 SFM	
Depth of Cut	$a_a=1.5D$ $a_r=0.1D$ 			
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min
1	25,000	6.8	23,500	8.7
2	25,000	12.9	11,500	8.5
3	21,000	27.6	7,950	9.8
4	15,500	28.5	5,950	11.0
5	12,500	29.9	4,750	11.6
6	10,500	32.7	3,950	12.2
8	7,950	35.0	2,950	13.8
10	6,350	39.2	2,350	14.4
12	5,300	41.3	1,950	15.4
14	4,500	41.3	1,700	15.6
16	3,950	41.3	1,450	15.4
18	3,500	41.3	1,300	15.4
20	3,150	41.3	1,150	15.2

1. Use a rigid and precise machine and holder.
2. Use a water soluble cutting fluid.
3. Please adjust the speed and feed when the cutting depth is large or when machines with low rigidity are used.

Slotting

Work Material	Aluminum Alloys		Copper Alloys	
Cutting Speed	490 SFM		245 SFM	
Depth of Cut	$a_a=1D$ 			
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min
1	25,000	6.8	23,500	8.7
2	23,500	12.2	11,500	8.5
3	15,500	20.3	7,950	9.8
4	11,500	21.3	5,950	11.0
5	9,500	22.6	4,750	11.6
6	7,950	24.8	3,950	12.2
8	5,950	26.2	2,950	13.8
10	4,750	29.3	2,350	14.4
12	3,950	31.1	1,950	15.4
14	3,400	31.3	1,700	15.6
16	2,950	31.3	1,450	15.4
18	2,650	31.3	1,300	15.4
20	2,350	30.9	1,150	15.2

1. Use a rigid and precise machine and holder.
2. Use a water soluble cutting fluid.
3. Please adjust the speed and feed when the cutting depth is large or when machines with low rigidity are used.

