

Single Flutes Speeds and feeds

CARBIDE

Cutting Data

When selecting cutting data, consideration must be made to the machine, the component, & the stability of set up.

Drilling: Cutting Data for Aluminium		
Cutter Dia (mm)	Cutting Speed 150 M/min	
	RPM	Feed mm/Min
3	25,000	1,200
4	22,000	1,100
5	20,000	1,000
6	18,000	900
8	16,000	800
10	12,800	640
12	10,600	530
14	9,100	450
16	8,000	400

Milling: Cutting Data for Aluminium		
Cutter Dia (mm)	Cutting Speed 150 M/min	
	RPM	Feed mm/Min
3	25,000	2,000
4	22,000	1,800
5	20,000	1,600
6	18,000	1,300
8	16,000	1,200
10	12,800	900
12	10,600	750
14	9,100	640
16	8,000	560

HSS

Cutting Data

When selecting cutting data, consideration must be made to the machine, the component, & the stability of set up.

Drilling: Cutting Data for Aluminium		
Cutter Dia (mm)	Cutting Speed 200 M/min	
	RPM	Feed mm/Min
3	21,000	450
4	16,000	450
5	12,750	450
6	10,600	450
8	8,000	450
10	6,400	450

Milling: Cutting Data for Aluminium		
Cutter Dia (mm)	Cutting Speed 200 M/min	
	RPM	Feed mm/Min
3	21,000	640
4	16,000	640
5	12,750	640
6	10,600	640
8	8,000	640
10	6,400	640