

AX4 Recommended Starting Speeds and Feeds

Material Group		Side Milling (A) and Slotting (B)			Uncoated		Feed per Tooth (IPT=inch/th) for side milling (A), for slotting (B) reduce IPT by 20%					
							D - Diameter					
		A		B	Speed (SFM)	frac.	1/4"	3/8"	1/2"	5/8"	3/4"	1"
		ap	ae	ap		dec.	0.250	0.375	0.500	0.625	0.750	1.000
N	Aluminum (<10% Si)	Ap1 max	<0.5 x D	<1 x D	Up to 6000	IPT	0.0023	0.0033	0.0044	0.0055	0.0068	0.0081
	Aluminum (> or= to 10% Si)	Ap1 max	<0.5 x D	<1 x D	Up to 5000	IPT	0.0019	0.0029	0.0039	0.0049	0.0059	0.0069
	Copper / Brass	Ap1 max	<0.5 x D	<1 x D	Up to 3000	IPT	0.0019	0.0029	0.0039	0.0049	0.0059	0.0069

Note:

- Ap1 max = Full length of cut of the tool
- For cutting aluminum with high silicon content, coating is recommended.
- For better surface finish, reduce feed per tooth.
- All values are recommended starting points based on ideal conditions.
Adjust parameters accordingly for specific applications.