

SPEEDS & FEEDS



H45AL-C-3

3 Flute - 45° Helix - Chipbreaker Rougher

H45AL-C-3/ H45AL-C-RN-3																	
Material Guide		SFM	Inches per Tooth (IPT)														
			1/8		3/16		1/4		3/8		1/2		3/4		1		
			Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	
WROUGHT ALUMINUM ALLOY	2014, 5062, 6061, 7050, 7075, 7475	2200-2800	.0006	.0008	.0009	.0012	.0012	.0015	.0018	.0022	.0025	.0030	.0035	.0045	.0050	.0060	
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	900-1200	.0011	.0012	.0015	.0020	.0020	.0025	.0030	.0040	.0040	.0050	.0060	.0080	.0080	.0100	
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn-36Pb3, CuZn10, CuSn5	450-650	.0007	.0009	.0011	.0012	.0015	.0018	.0022	.0028	.0028	.0035	.0045	.0055	.0055	.0070	

Milling Process	ADOC	RDOC
Slot (Full Slotting)	100%-150% Diameter	100% Diameter
Rgh (Traditional Roughing)	100%-150% Diameter	35%-50% Diameter

