

N1	Wrought Aluminum Alloys
N2	Low-Silicon Aluminum Alloys Si <12.2% - 6061, 7075
N3	High-Silicon Aluminum Alloys Si >12.2% - 6061, 7075
N4	Copper & Copper Alloys

SLOTTING

	Milling SFM (Vc)		CHIPLOAD PER TOOTH RECOMMENDATIONS (CPT)										Slotting Axial	
	Uncoated	Coated	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	
N1	1500-1800	1500-1800	.001	.001	.002	.003	.002	.003	.004	.004	.005	.008	.75-1.5xD	
N2	1800-Max	1800-Max	.001	.001	.002	.002	.003	.003	.004	.004	.005	.008	.75-1.5xD	
N3	1800-Max	1800-Max	.001	.001	.001	.002	.002	.002	.002	.003	.003	.005	.75-1.5xD	
N5	450-700	450-700	.001	.001	.001	.002	.002	.002	.003	.003	.004	.006	.75-1.5xD	

HEAVY PERIPHERAL

	Milling SFM (Vc)		CHIPLOAD PER TOOTH RECOMMENDATIONS (CPT)										Profiling Radial	
	Uncoated	Coated	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC
N1	1500-1800	1500-1800	.001	.002	.003	.004	.005	.006	.007	.008	.010	.014	1-2xD	.35-.5xD
N2	1800-Max	1800-Max	.001	.002	.002	.002	.003	.003	.004	.005	.007	.009	1-2xD	.35-.5xD
N3	1800-Max	1800-Max	.001	.001	.001	.002	.002	.002	.003	.003	.004	.006	1-2xD	.35-.5xD
N5	450-700	450-700	.001	.001	.002	.002	.003	.003	.004	.005	.006	.008	1-2xD	.35-.5xD

LIGHT PERIPHERAL

	Milling SFM (Vc)		CHIPLOAD PER TOOTH RECOMMENDATIONS (CPT)										Profiling Radial	
	Uncoated	Coated	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC
N1	1500-1800	1500-1800	.001	.001	.002	.002	.003	.003	.004	.005	.006	.008	1xD	.05xD
N2	1800-Max	1800-Max	.001	.001	.001	.001	.002	.002	.003	.003	.004	.005	1xD	.05xD
N3	1800-Max	1800-Max	.001	.001	.001	.001	.001	.001	.002	.002	.003	.003	1xD	.05xD
N5	450-700	450-700	.001	.001	.001	.001	.002	.002	.002	.002	.003	.004	1xD	.05xD