

338 SERIES



PRECISION CUTTING TOOLS
Member IMC Group

GROUP #	MATERIAL CARBON STEEL	MATERIAL EXAMPLES	LOW SFM	HIGH SFM	TYPE OF CUT	IPT Ø 0.250	CT IPT Ø 0.375	CT IPT Ø 0.500	CT IPT Ø 0.625	CT IPT Ø 0.750	CT IPT 1.000
N1	Wrought Aluminum Alloys <12% Si	1000-8000 Series Excluding 4000 Series	400	2500	SLOTING	0.0032	0.0047	0.0063	0.0080	0.0010	0.0123
			400	2500	ROUGHING & HEM	0.0043	0.0063	0.0085	0.0105	0.0013	0.0165
N2	High Silicon Aluminum Alloys >12%	4000 Series & Castings	300	2000	SLOTING	0.0025	0.0038	0.0049	0.0060	0.0075	0.0090
			300	2000	ROUGHING & HEM	0.0038	0.0048	0.0060	0.0075	0.0093	0.0120

MILL PROCESS	ADOC	RDOC
SLOTING	50%-150 Diameter	100%
ROUGHING	200% Diameter	16-49%
FINISH OR HEM	250% Diameter	2-15%

Must use chip thinning calculations when developing feedrates for HEM toolpaths

