

GROUP #	MATERIAL GROUP & HARDNESS	MATERIAL EXAMPLES	LOW SFM	HIGH SFM	TYPE OF CUT	IPT Ø 0.250	IPT Ø 0.375	IPT Ø 0.500	IPT Ø 0.625	IPT Ø 0.750	IPT 1.000
N1	WROUGHT ALUMINUM ALLOYS <12% Si	1000-8000 SERIES EXCLUDING 4000 SERIES	1000	8650	SLOTING	0.0030	0.0040	0.0050	0.0060	0.0070	0.0080
			1000	8650	ROUGH	0.0040	0.0048	0.0055	0.0063	0.0072	0.0083
			1000	6500	FINISH OR HEM	0.0030	0.0038	0.0045	0.0050	0.0055	0.0060
N2	High Silicon Aluminum Alloys >12%	4000 SERIES & CASTINGS	1000	8650	SLOTING	0.0025	0.0035	0.0045	0.0053	0.0060	0.0066
			1000	8650	ROUGH	0.0030	0.0037	0.0048	0.0056	0.0063	0.0068
			1000	6500	FINISH OR HEM	0.0025	0.0035	0.0042	0.0048	0.0052	0.0058
N3	Copper, Copper Alloys, & Magnesium Alloys <190 BHN	C110, C93200, C95500	600	2400	SLOTING	0.0020	0.0032	0.0040	0.0048	0.0055	0.0065
			600	2400	ROUGH	0.0020	0.0032	0.0040	0.0048	0.0055	0.0065
			600	2000	FINISH OR HEM	0.0020	0.0030	0.0037	0.0045	0.0050	0.0060

MILL PROCESS	ADOC	RDOC
SLOTING	15%-50% Diameter	100%
ROUGHING	Up to 125% Diameter	16-49%
FINISH OR HEM	Up to 125% Diameter	1-15%

Must use chip thinning calculations when developing feedrates for FINISH OR HEM toolpaths
Cut feedrate up to 40% for finishing if surface finish shows feed lines
Test cuts are highly recommended to account for machine and fixturing dynamics