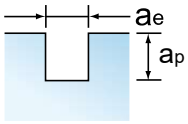
CUTTING CONDITION – IAP SERIES

Side Milling 	ALUMINUM ALLOYS 2017,2024,356,6061,7075			COPPER ALLOYS Alum Bronze,C110,Muntz Brass			PLASTICS Polycarbonate, PVE, Polypropylene		
Hardness BRINELL	≦ 150			≦ 140					
Vc (sfm)	656	(525-787)		589	(471-707)		880	(704-1056)	
ae/ap	ae ≦ 0.05D ap ≦ 1.5D			ae ≦ 0.05D ap ≦ 1.5D			ae ≦ 0.05D ap ≦ 1.5D		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 1 Flute	RPM	Fz	Feed (IPM) 1 Flute	RPM	Fz	Feed (IPM) 1 Flute
1/4	10000	0.0060	60	9000	0.0067	60	13446	0.0045	60
Slot Milling 	ALUMINUM ALLOYS 2017,2024,356,6061,7075			COPPER ALLOYS Alum Bronze,C110,Muntz Brass			PLASTICS Polycarbonate, PVE, Polypropylene		
Hardness BRINELL	≦ 150			≦ 140					
Vc (sfm)	472	(378-566)		471	(377-565)		640	(512-768)	
ae/ap	ae=1D ap ≦ 1D			ae=1D ap ≦ 1D			ae ≦ 0.05D ap ≦ 1.5D		
MILL DIA. (inch)	RPM	Fz	Feed (IPM) 1 Flute	RPM	Fz	Feed (IPM) 1 Flute	RPM	Fz	Feed (IPM) 1 Flute
1/4	7200	0.0063	45	7200	0.0063	45	9779	0.0046	45
Depth of cut	2 x D Reduce chip load by 25% 3 x D Reduce chip load by 50%								



rpm=sfm×3.82/D1
ipm=(inch/flute)×4×rpm