





TuffCut® XR-AL

334 Series Recommended Cutting Data - Profile Milling Inch

| Workpiece Material Group | I S O | Coolant • Preferred  | Profile Milling (ap) | | |
|---------------------------------------|-------------|---|---|---|---|
| | | |  |  |  |
| | | | 1 x D | 1.5 x D | 2 x D |
| | | Max. | vc - SFM | | |
| Non-Ferrous - Aluminum | N | • | 2000-2500 | 1750-2000 | 1250-1750 |
| Non-Ferrous - Aluminum Cast | N | • | 1600-2000 | 1400-1600 | 1000-1400 |
| Non-Ferrous - Brass Yellow/Red | N | • | 750-1250 | 500-1000 | 400-800 |
| Non-Ferrous - Bronze, Aluminum Bronze | N | • | 500-1000 | 400-800 | 300-600 |
| Non-Ferrous - Copper | N | • | 1500-2000 | 1250-1500 | 800-1200 |

| | | | | | | | | | | |
|-------------|------|------|------|------|------|------|------|------|------|------|
| Diameter | 1/4 | 1/4 | 3/8 | 3/8 | 1/2 | 1/2 | 3/4 | 3/4 | 1 | 1 |
| Max. ae | 30% | 50% | 30% | 50% | 30% | 50% | 30% | 50% | 30% | 50% |
| fz=in/tooth | .008 | .006 | .012 | .009 | .016 | .012 | .020 | .015 | .024 | .018 |

Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula:
 $(\text{Calculated Feed} \times \text{Spindle Maximum}) / \text{Calculated Speed}$. Above 20,000 rpm, tool balancing required.




ISO 9001:2008 Certified



Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

TuffCut® XR-AL

334 Series Recommended Cutting Data - Slotting Inch

| Workpiece Material Group | ISO | Coolant • Preferred  | Slotting (ap) | |
|---------------------------------------|-----|---|---|---|
| | | |  |  |
| | | | .5 x D | 1 x D |
| Max. | | | vc - SFM | |
| Non-Ferrous - Aluminum | N | • | 1750-2000 | 1250-1750 |
| Non-Ferrous - Aluminum Cast | N | • | 1400-1600 | 1000-1400 |
| Non-Ferrous - Brass Yellow/Red | N | • | 500-1000 | 400-800 |
| Non-Ferrous - Bronze, Aluminum Bronze | N | • | 400-800 | 300-600 |
| Non-Ferrous - Copper | N | • | 1250-1500 | 800-1000 |

| Diameter | 1/4 | 1/4 | 3/8 | 3/8 | 1/2 | 1/2 | 3/4 | 3/4 | 1 | 1 |
|-------------|------|------|------|------|------|------|------|------|------|------|
| Max. ae | 50% | 100% | 50% | 100% | 50% | 100% | 50% | 100% | 50% | 100% |
| fz=in/tooth | .008 | .005 | .012 | .008 | .020 | .010 | .025 | .015 | .030 | .020 |

Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula:
(Calculated Feed x Spindle Maximum)/Calculated Speed. Above 20,000 rpm, tool balancing required.

ISO 9001:2008 Certified



Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

For product information, call your local distributor.