







134/134N Series Recommended Cutting Data - Inch

Workpiece Material Group	I S O	Application	Type of Cut		Vc (SFM)	Tool Diameter (inch)				
			Radial (Ae)	Axial (Ap)		1/4	3/8	1/2	3/4	1
		fz - in/tooth								
Non-Ferrous - Aluminum / Aluminum Alloys < 10% Si	N	 Slotting	1 x D	≤ x D	1000 - 2000	.0025	.0038	.0050	.0075	.0100
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	2000 - 3000	.0025	.0038	.0050	.0075	.0100
Non-Ferrous - Aluminum / Aluminum Alloys > 10% Si		 Slotting	1 x D	≤ 1 x D	800 - 1800	.0025	.0038	.0050	.0075	.0100
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	1600 - 2700	.0025	.0038	.0050	.0075	.0100
Non-Ferrous - Brass/Cu Alloys		 Slotting	1 x D	≤ 1 x D	400 - 600	.0025	.0038	.0050	.0075	.0100
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	500 - 1000	.0025	.0038	.0050	.0075	.0100







Notes:

- Technical data provided should be considered advisory only. Adjustments may be necessary depending on the application, workpiece rigidity, machine tool, etc.

RWOC (ae)	Chip Thickness Compensation Factor
10%	1.67
20%	1.25
30%	1.09
50%	1.00

During profile milling with a radial width of less than 50% of the cutter diameter, the actual chip thickness at the cutting edge is less than the programmed chipload. The accompanying table shows the increase in chipload by given radial width percentage to adjust for chip thinning. Multiply your recommended chip thickness by the appropriate feed factor to establish the correct feed rate.

134/134N Series Recommended Cutting Data - Metric

Workpiece Material Group	I S O	Application	Type of Cut		vc SFM	Tool Diameter (mm)								
						6	8	10	12	14	16	18	20	25
		Radial (Ae)	Axial (Ap)	fz - mm/tooth										
Non-Ferrous - Aluminum / Aluminum Alloys < 10% Si	N	 Slotting	1 x D	≤ 1 x D	400 - 600	.0600	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	480 - 600	.0655	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500
Non-Ferrous - Aluminum / Aluminum Alloys > 10% Si		 Slotting	1 x D	≤ 1 x D	350 - 450	.0600	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	350 - 450	.0655	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500
Non-Ferrous - Brass/ Cu Alloys		 Slotting	1 x D	≤ 1 x D	150 - 180	.0600	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500
		 Profiling	≤ 0.5 x D	≤ 1.5 x D	150 - 300	.0655	.0800	.1000	.1200	.1400	.1600	.1800	.2000	.2500

Notes:

- Technical data provided should be considered advisory only. Adjustments may be necessary depending on the application, workpiece rigidity, machine tool, etc.

RWOC (ae)	Chip Thickness Compensation Factor
10%	1.67
20%	1.25
30%	1.09
50%	1.00

During profile milling with a radial width of less than 50% of the cutter diameter, the actual chip thickness at the cutting edge is less than the programmed chipload. The accompanying table shows the increase in chipload by given radial width percentage to adjust for chip thinning. Multiply your recommended chip thickness by the appropriate feed factor to establish the correct feed rate.