

TuffCut® XR-AL

334 Series Recommended Cutting Data - Profile Milling - Inch

Workpiece Material Group	ISO	Coolant • Preferred	Profile Milling (ap)		
					
		Emulsion	1 x D	1.5 x D	2 x D
			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 (inch)	1/4	1/4	3/8	3/8	1/2	1/2	5/8	5/8	3/4	3/4	1	1
Max. ae	30%	50%	30%	50%	30%	50%	30%	50%	30%	50%	30%	50%
fz=in/tooth	.008	.006	.012	.009	.016	.012	.018	.013	.020	.015	.024	.018

Spindle Maximum - Should the calculated spindle speed be more than your actual spindle maximum, use this formula:
(Calculated Feed x Spindle Maximum)/Calculated Speed.

334 Series Recommended Cutting Data - Slotting - Inch

Workpiece Material Group	ISO	Coolant • Preferred	Slotting (ap)	
				
		Emulsion	.5 x D	1 x D
			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 (inch)	1/4	1/4	3/8	3/8	1/2	1/2	5/8	5/8	3/4	3/4	1	1
Max. ap	50%	100%	50%	100%	50%	100%	50%	100%	50%	100%	50%	100%
fz=in/tooth	.008	.005	.012	.008	.020	.010	.022	.012	.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.

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