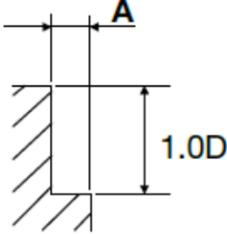
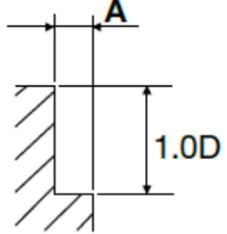


PREMIUM ALU-MILL SPEED & FEED CHARTS

2-Flute - Corner Radius End Mills with Neck

Material	Aluminum Aluminum Alloy				Copper Alloy				
	Diameter	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM
R.012 × 5/32	10000	36.35	10000	42.40	3000	9.10	3000	10.60	
R.020 × 1/4	10000	45.40	10000	60.60	3000	11.50	3000	15.15	
R.024 × 5/16	8000	54.50	8000	69.60	2300	13.60	2300	17.55	
R.031 × 3/8	8000	66.60	8000	81.75	2300	16.65	2300	20.60	
R.040 × 1/2	8000	81.75	8000	103.00	2300	20.55	2300	25.75	
R.051 × 5/8	6000	75.70	6000	93.90	1800	19.05	1800	23.60	
R.063 × 3/4	4000	60.60	4000	75.70	1150	15.15	1150	19.10	
			<p>A: 5/32" 3/8 = 0.25 D 1/2" 3/4 = 0.5 D</p> 				<p>A: 5/32" 3/8 = 0.25 D 1/2" 3/4 = 0.5 D</p> 		

3-Flute - Ball Nose End Mills with Neck

Material	Aluminum Aluminum Alloy		Copper Alloy		
	Diameter	RPM	IPM	RPM	IPM
R3/64 × 3/32	20700	28.80	6200	7.25	
R1/16 × 1/8	13800	28.80	4200	7.25	
R3/32 × 3/16	13800	40.90	4200	10.30	
R1/8 × 1/4	13800	53.00	4200	13.30	
R5/32 × 5/16	10800	60.55	3200	15.15	
R3/16 × 3/8	10800	71.15	3200	17.55	
R1/4 × 1/2	10800	90.85	3200	22.70	
R5/16 × 5/8	8500	81.75	2500	20.30	
	<p>Ae: 0.2xD Ap: 0.05xD</p> 