



SPEED TIGER

CUTTING CONDITION - IAP SERIES

FRACTIONAL

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 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) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes
1/4	10000	0.0011	31.9	9000	0.0011	28.7	13446	0.0016	43.0
 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) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes	RPM	Fz	Feed (IPM) 2 flutes
1/4	7200	0.0011	23.0	7200	0.0011	22.9	9779	0.0016	31.3
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