

SPEED & FEED INFORMATION

Notes

Note: All technical data provided are suggested starting points. They may be increase or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our TECHNICAL SERVICE Team with questions

SPEED & FEEDS FOR SERIES: Z3TVAL ZRN

DESCRIPTION: 3 FLUTE - 35° HELIX - FOR LIGHT DUTY CNC MACHINES ZIRCONIUM COATED



Material Guide			Condition	SFM	CHIP PER TOOTH									
					1/8"	3/16"	1/4"	5/16	3/8"	7/16	1/2"	5/8"	3/4"	1"
ISO-N	Aluminum+Aluminum Alloys	2024-T4/T6, 2014, 6061-T6/T651, 7075-T6	Slotting	600	0.0007	0.0014	0.0014	0.0018	0.0022	0.0025	0.0029	0.0036	0.0043	0.0050
			25-50% Dia. Profiling	800	0.0018	0.0022	0.0029	0.0036	0.0043	0.0050	0.0058	0.0072	0.0086	0.0101
	Copper	Red Brass, High Lead Brass, Yellow Brass, C-17200, Navel Brass, A-17, High Silicon Bronze	Slotting	575	0.0007	0.0007	0.0014	0.0018	0.0018	0.0020	0.0022	0.0029	0.0029	0.0036
			26-50% Dia. Profiling	625	0.0010	0.0010	0.0020	0.0023	0.0025	0.0028	0.0031	0.0041	0.0041	0.0050
	Magnesium		Slotting	600	0.0007	0.0014	0.0014	0.0018	0.0022	0.0023	0.0029	0.0043	0.0058	0.0065
			27-50% Dia. Profiling	800	0.0018	0.0022	0.0029	0.0036	0.0043	0.0050	0.0058	0.0072	0.0086	0.0101

Material Guide			Condition	M/MIN	CHIP PER TOOTH - METRIC									
					3mm	4mm	5mm	6mm	8mm	10mm	12mm	16mm	20mm	25mm
ISO-N	Aluminum+Aluminum Alloys	2024-T4/T6, 2014, 6061-T6/T651, 7075-T6	Slotting	275	0.0183	0.0365	0.0410	0.0457	0.0549	0.0732	0.0914	0.1006	0.1097	0.1280
			25-50% Dia. Profiling	350	0.0457	0.0732	0.0824	0.0914	0.1097	0.1463	0.1829	0.1966	0.2194	0.2561
	Copper	Red Brass, High Lead Brass, Yellow Brass, C-17200, Navel Brass, A-17, High Silicon Bronze	Slotting	243	0.0183	0.0365	0.0391	0.0411	0.0457	0.0549	0.0732	0.0732	0.0732	0.0914
			26-50% Dia. Profiling	325	0.0256	0.0512	0.0542	0.0572	0.0640	0.0768	0.1024	0.1029	0.1024	0.1280
	Magnesium		Slotting	275	0.0183	0.0365	0.0410	0.0457	0.0549	0.0732	0.1097	0.1280	0.1463	0.1646
			27-50% Dia. Profiling	350	0.0457	0.0732	0.0824	0.0914	0.1097	0.1463	0.1829	0.2012	0.2194	0.2561