



ZrN Coated Radius and Chamfer Edge Aluminum Cutting CNC End Mill Feed / Speed Rates & Chipload

Tool No.	Feed rate Inch/Min	Chip load Inch/Rev
Aluminum	9" - 36"	0.0005" - 0.002"
Brass	9" - 36"	0.0005" - 0.002"
Copper	9" - 36"	0.0005" - 0.002"
Plastic	36" - 90"	0.002" - 0.005"

Chip-Load at 18,000 RPM Maximum

Simple Machining Calculations:
To find **RPM**: SFM x 3.282 / diameter of tool
To find **SFM**: 0.262 x diameter of tool x RPMs
To find **Feed Rate**: RPM x # of flutes x chip load

