

			DCON	6		8		10		12		16	
			Ae max	0,20	0,45	0,25	0,55	0,30	0,60	0,35	0,65	0,40	0,70
			Diameter	3,0	6,0	4,0	8,0	5,0	10,0	6,0	12,0	8,0	16,0
Metric	Hardness (HRb)	Vc (m/min)	Cut Zone	RE	RE2	RE	RE2	RE	RE2	RE	RE2	RE	RE2
N Aluminum	≤88 (388-632)	510	RPM	54111	27056	40583	20292	32467	16233	27056	13528	20292	10146
		330	Fz	0,017	0,040	0,021	0,050	0,025	0,060	0,033	0,080	0,042	0,100
			Feed (mm/min)	2706	3247	2536	3044	2435	2922	3607	4329	3382	4058
	≥88 (284-376)	330	RPM	35013	17507	26260	13130	21008	10504	17507	8753	13130	6565
		2101	Fz	0,013	0,030	0,017	0,040	0,021	0,050	0,025	0,060	0,033	0,080
			Feed (mm/min)	1313	1576	1313	1576	1313	1576	1751	2101	1751	2101

$$\text{rpm} = (\text{Vc} \times 1000) / (\text{DC} \times 3.14)$$

$$\text{Feed} = \text{Fz} \times \text{No. of flutes} \times \text{rpm}$$

Adjust speed and feed cutting

Adjust rates according to cutting area of tool being used

Avoid using tip of the tool where possible due to reduced chip space

Be aware of max cut Ae, especially on the lower portion of the tool

Refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgtool.com)