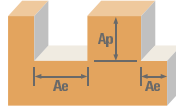


Series 43MAPF Metric	Hardness		Ae x D ₁	Ap x D ₁	Vc (m/min)	Diameter (D ₁) (mm)							
						6	8	10	12	16	20	25	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075		≤ 0.1	≤ 2.5	800	RPM	42440	31830	25464	21220	15915	12732	10186
					(640-960)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
						Feed (mm/min)	8488	7003	6111	5942	6366	7130	6926
			≤ 0.1	≤ 4	800	RPM	42440	31830	25464	21220	15915	12732	10186
					(640-960)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
						Feed (mm/min)	6790	5729	5093	4244	4456	5093	4889
	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090		≤ 0.1	≤ 2.5	600	RPM	31830	23873	19098	15915	11936	9549	7639
					(480-720)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
						Feed (mm/min)	6366	5252	4584	4456	4774	5347	5195
			≤ 0.1	≤ 4	600	RPM	31830	23873	19098	15915	11936	9549	7639
					(480-720)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
						Feed (mm/min)	5093	4297	3820	3183	3342	3820	3667

Bhn (Brinell) HRC (Rockwell C)
 surface speed is dependent on machine spindle and fixturing
 balancing is recommended at ultra high surface speeds
 *tool life may be reduced when machining Lithium Alloys
 $\text{rpm} = (\text{Vc} \times 1000) / (\text{D}_1 \times 3.14)$
 $\text{mm/min} = \text{Fz} \times 4 \times \text{rpm}$
 maximum recommended depths shown
 reduce speed and feed for materials harder than listed
 finish cuts typically require reduced feed and cutting depths of $0.02 \times \text{D}_1$ maximum
 ramp angle = 6° (feed rate = 50%)
 plunging not recommended
 refer to the KYOCERA SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)