



Series 43MAPR Metric	Hardness		Ae x D ₁	Ap x D ₁	Vc (m/min)		Diameter (D ₁) (mm)			
							12	16	20	25
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	Slot 	1	≤ 1	1500	RPM	39788	29841	23873	19098
					(1200-1800)	Fz	0.080	0.110	0.150	0.180
						Feed (mm/min)	9549	9848	10743	10313
		Profile 	≤ 0.5	≤ 1.5	2000	RPM	53050	39788	31830	25464
					(1600-2400)	Fz	0.080	0.110	0.150	0.180
						Feed (mm/min)	12732	13130	14324	13751
	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	Slot 	1	≤ 1	1200	RPM	31830	23873	19098	15278
					(960-1440)	Fz	0.060	0.083	0.110	0.140
						Feed (mm/min)	11459	5944	6302	6417
		Profile 	≤ 0.5	≤ 1.5	1500	RPM	39788	29841	23873	19098
					(1200-1800)	Fz	0.060	0.083	0.110	0.140
						Feed (mm/min)	7162	7430	7878	8021

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

rpm = (Vc x 1000) / (D₁ x 3.14)

mm/min = Fz x 3 x rpm

maximum recommended depths shown

reduce speed and feed for materials harder than listed

ramp angle = 15° (feed rate = 50%)

plunge depth = 1 x D₁ (feed rate = 30%)refer to the KYOCERA SGS Tool Wizard[®] for complete technical information (www.kyocera-sgstool.com)