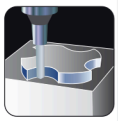
2 flute ball end carbide end mill for Aluminium

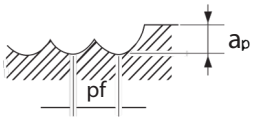
PROFILING

HYP-AL-LS-EBD



	Aluminium Alloys		Copper Alloy	
	A6061, A7075		C1100	
Vc	200 m/min		150 m/min	
Ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
3	21,200	1,550	15,900	1,150
4	15,900	1,550	11,900	1,150
5	12,750	1,575	9,500	1,150
6	10,600	1,600	7,950	1,150
8	7,950	1,950	5,950	1,450
10	6,350	1,750	4,750	1,300
12	5,300	1,650	3,950	1,200

Maximum depth of cut



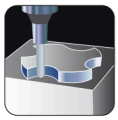
ap=0.1D

pf=0.2D

2 flute ball end carbide end mill for difficult materials

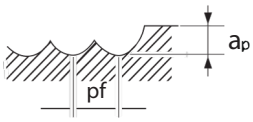
PROFILING

HYP-Ti-EBD



	Cast Iron		Mild Steels Carbon Steels		Tool Steels Ti (Annealed)		Pre-hardened / Die / Alloy Steels Titanium (treated & aged) Inconel				Hardened Steels	
			< 225 HB		< 30 HRC		< 38 HRC		< 45 HRC		< 55 HRC	
Vc	210 m/min		168 m/min		138 m/min		108 m/min		96 m/min		84 m/min	
Ø	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)	Speed (min-1)	Feed (mm/min.)
3	21,212	1,350	17,244	1,100	14,475	906	11,628	588	10,188	432	8,736	312
4	16,740	1,350	13,800	1,100	11,560	906	9,228	636	8,064	528	6,910	384
5	13,320	1,512	10,656	1,230	8,890	918	7,068	642	6,228	534	5,316	408
6	10,944	1,572	8,736	1,280	7,280	990	5,770	690	5,076	576	4,332	432
8	8,652	1,860	6,912	1,500	5,740	1,128	4,570	792	3,996	648	3,420	462
10	6,648	1,704	5,316	1,360	4,420	1,056	3,500	744	3,072	618	2,640	474
12	4,000	1,554	4,296	1,240	3,610	990	2,870	696	2,508	594	2,120	438

Maximum depth of cut



ap=0.1D

pf=0.2D

ap=0.05D

pf=0.1D