



Series 3815 Aluma-Mill



Material	Aluminum Alloys, Magnesium				Aluminum Si > 10%				Brass, Bronze				Copper Alloys				Plastics				Titanium - Soft			
	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT
1/8"	48896	98	1600	0.0010	30560	61	1000	0.0010	30560	61	1000	0.0010	33616	67	1100	0.0010	42784	257	1400	0.0030	11460	11	375	0.0005
1/4"	24448	147	1600	0.0030	15280	92	1000	0.0030	15280	61	1000	0.0020	16808	67	1100	0.0020	21392	257	1400	0.0060	5730	11	375	0.0010
1/2"	12224	147	1600	0.0060	7640	92	1000	0.0060	7640	46	1000	0.0030	8404	50	1100	0.0030	10696	214	1400	0.0100	2865	11	375	0.0020
3/4"	8149	130	1600	0.0080	5093	81	1000	0.0080	5093	41	1000	0.0040	5603	56	1100	0.0050	7131	200	1400	0.0140	1910	15	375	0.0040
1.0"	6112	122	1600	0.0100	3820	76	1000	0.0100	3820	38	1000	0.0050	4202	59	1100	0.0070	5348	193	1400	0.0180	1433	17	375	0.0060

TOOL DIAMETER	RPM	MM/ MIN	SMM	FPT	RPM	MM/ MIN	SMM	FPT	RPM	MM/ MIN	SMM	FPT	RPM	MM/ MIN	SMM	FPT	RPM	MM/ MIN	SMM	FPT	RPM	MM/ MIN	SMM	FPT
3mm	51753	2629	487.7	0.0254	32345	1643	304.8	0.0254	32345	1643	304.8	0.0254	35580	1807	335.3	0.0254	45284	6901	426.7	0.0762	12130	308	114.3	0.0127
6mm	25876	3944	487.7	0.0762	16173	2465	304.8	0.0762	16173	1643	304.8	0.0508	17790	1807	335.3	0.0508	22642	6901	426.7	0.1524	6065	308	114.3	0.0254
12mm	12938	3944	487.7	0.1524	8086	2465	304.8	0.1524	8086	1232	304.8	0.0762	8895	1356	335.3	0.0762	11321	5751	426.7	0.2540	3032	308	114.3	0.0508
19mm	8171	3321	487.7	0.2032	5107	2075	304.8	0.2032	5107	1038	304.8	0.1016	5618	1427	335.3	0.1270	7150	5085	426.7	0.3556	1915	389	114.3	0.1016
25mm	6209	3154	487.7	0.2540	3881	1972	304.8	0.2540	3881	986	304.8	0.1270	4269	1518	335.3	0.1778	5433	4968	426.7	0.4572	1455	444	114.3	0.1524

*Suggested speeds & feeds are for machining a slot depth of 1X diameter of the tool

