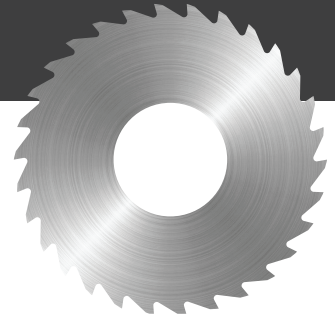


2455 NON-FERROUS SAW

2455 Non-Ferrous Saw

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.



FULLERTON®
SPEEDS / FEEDS

Material	Speed SFM	SMPM
Low Si Aluminum < 10%	2250	686
High Si Aluminum > 10%	1500	457
Brass	850	259
Copper	750	228
Magnesium	2000	609
Plastics	1500	457
Composites	800	243
Feed Rate- Chip Load per tooth .0015" / 0.0381 mm		