

SPEED & FEED GUIDE



Optimum Performance

Series 2010, 2012, 2014, 2015

250 2 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	1 x D	600	18336	44	9168	48	7334	53	6112	53	4584	55	3667	53	3056	53	
	1.25 x D	.3 x D	720	22003	66	11002	70	8801	77	7334	77	5501	80	4401	77	3667	77	
	1.5 x D	.1 x D	1200	36672	147	18336	150	14669	154	12224	154	9168	162	7334	155	6112	155	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	1 x D	600	18336	37	9168	40	7334	44	6112	44	4584	46	3667	44	3056	44
		1.25 x D	.3 x D	720	22003	53	11002	56	8801	63	7334	63	5501	67	4401	64	3667	64
		1.5 x D	.1 x D	1200	36672	117	18336	121	14669	132	12224	132	9168	139	7334	133	6112	133

Series 2030, 2031, 2047, 2032, 2050, 2053

350 3 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	1 x D	600	18336	66	9168	66	7334	79	6112	79	4584	83	3667	80	3056	80	
	1.25 x D	.3 x D	720	22003	99	11002	96	8801	115	7334	115	5501	121	4401	116	3667	116	
	1.5 x D	.1 x D	1200	36672	220	18336	193	14669	231	12224	231	9168	243	7334	233	6112	233	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	1 x D	600	18336	55	9168	55	7334	66	6112	66	4584	69	3667	67	3056	67
		1.25 x D	.3 x D	720	22003	79	11002	79	8801	95	7334	95	5501	100	4401	96	3667	96
		1.5 x D	.1 x D	1200	36672	176	18336	165	14669	198	12224	198	9168	208	7334	200	6112	200

Series 2060

550 5 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	.5 x D	600	18336	110	9168	110	7334	132	6112	132	4584	139	3667	133	3056	133	
	1.25 x D	.3 x D	720	22003	165	11002	160	8801	191	7334	191	5501	201	4401	193	3667	193	
	1.5 x D	.1 x D	1200	36672	367	18336	321	14669	385	12224	385	9168	404	7334	388	6112	388	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	.5 x D	600	18336	92	9168	92	7334	110	6112	110	4584	116	3667	111	3056	111
		1.25 x D	.3 x D	720	22003	132	11002	132	8801	158	7334	158	5501	166	4401	160	3667	160
		1.5 x D	.1 x D	1200	36672	293	18336	275	14669	330	12224	330	9168	347	7334	333	6112	333

PERFORMANCE

Premium Carbide End Mills for Non-Ferrous Alloys



Series 2015 250BN | 2FL | Ball Nose

Diameter	Shank Dia.	LOC	OAL	Radius	Bright EDP	ZrN EDP
1/8	1/8	1/2	2	-	-	313563
1/8	1/8	1/4	1-1/2	-	-	313567
1/8	1/8	3/4	2	-	-	313571
3/16	3/16	5/16	2	-	-	313573
3/16	3/16	5/8	2-1/2	-	-	313576
3/16	3/16	1	2-1/2	-	-	313580
1/4	1/4	3/8	2-1/2	-	313584	313588
1/4	1/4	3/4	2-1/2	-	313592	313596
1/4	1/4	1-1/4	3	-	313598	313602
5/16	5/16	7/16	2-1/2	-	313604	313607
5/16	5/16	13/16	2-1/2	-	313609	313612
5/16	5/16	1-1/4	3	-	313615	313617
3/8	3/8	1/2	2-1/2	-	313621	313624
3/8	3/8	1	2-1/2	-	313628	313630
3/8	3/8	1-1/2	4	-	313632	313636
7/16	7/16	9/16	2-3/4	-	313640	313643
7/16	7/16	1	2-3/4	-	313645	313649
7/16	7/16	2	4	-	313652	313655
1/2	1/2	5/8	3	-	313659	313662
1/2	1/2	1-1/4	3	-	313666	313668
1/2	1/2	2	4	-	313671	313674
5/8	5/8	3/4	3-1/2	-	313678	313682
5/8	5/8	1-5/8	3-1/2	-	313685	313687
5/8	5/8	2-1/2	5	-	313691	313693
3/4	3/4	1	4	-	313697	313700
3/4	3/4	1-5/8	4	-	313704	313707
3/4	3/4	3-1/4	6	-	313709	313711
1	1	1-1/4	5	-	313714	313717
1	1	2	5	-	313721	313723
1	1	3-1/4	6	-	313725	313729



★ Best ☆ Good