

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 2014 | 250BN | 2FL | Reduced Neck | Ball Nose

| Diameter | Shank Dia. | LOC | OAL | Length Below Shank | Bright EDP | ZrN EDP |
|----------|------------|-------|-------|--------------------|------------|---------|
| 1/4 | 1/4 | 3/8 | 2-1/2 | - | 314210 | 314214 |
| 1/4 | 1/4 | 3/8 | 4 | - | 314218 | 314220 |
| 1/4 | 1/4 | 3/8 | 2-1/2 | 1-1/8 | 314223 | 314227 |
| 1/4 | 1/4 | 3/8 | 4 | 2-1/8 | 314231 | 314229 |
| 1/4 | 1/4 | 3/8 | 4 | 2-1/8 | 314231 | 314229 |
| 5/16 | 5/16 | 7/16 | 2-1/2 | - | 314233 | 314237 |
| 5/16 | 5/16 | 7/16 | 4 | - | 314239 | 314243 |
| 5/16 | 5/16 | 7/16 | 2-1/2 | 1-1/8 | 314245 | 314249 |
| 5/16 | 5/16 | 7/16 | 4 | 2-1/8 | 314253 | 314255 |
| 3/8 | 3/8 | 1/2 | 2-1/2 | - | 314259 | 314263 |
| 3/8 | 3/8 | 1/2 | 4 | - | 314266 | 314269 |
| 3/8 | 3/8 | 1/2 | 2-1/2 | 1-1/8 | 314273 | 314275 |
| 3/8 | 3/8 | 1/2 | 4 | 2-1/8 | 314278 | 314280 |
| 1/2 | 1/2 | 5/8 | 3 | - | 314282 | 314285 |
| 1/2 | 1/2 | 5/8 | 4 | - | 314289 | 314293 |
| 1/2 | 1/2 | 5/8 | 6 | - | 314297 | 314301 |
| 1/2 | 1/2 | 5/8 | 3 | 1-3/8 | 314303 | 314307 |
| 1/2 | 1/2 | 5/8 | 4 | 2-3/8 | 314309 | 314312 |
| 1/2 | 1/2 | 5/8 | 6 | 3-3/8 | 314316 | 314319 |
| 5/8 | 5/8 | 3/4 | 3-1/2 | - | 314323 | 314326 |
| 5/8 | 5/8 | 3/4 | 5 | - | 314330 | 314333 |
| 5/8 | 5/8 | 3/4 | 6 | - | 314336 | 314340 |
| 5/8 | 5/8 | 3/4 | 3-1/2 | 1-5/8 | 314343 | 314346 |
| 5/8 | 5/8 | 3/4 | 5 | 2-3/8 | 314350 | 314353 |
| 5/8 | 5/8 | 3/4 | 6 | 3-3/8 | 314357 | 314359 |
| 3/4 | 3/4 | 1 | 4 | - | 314361 | 314363 |
| 3/4 | 3/4 | 1 | 5 | - | 314367 | 314370 |
| 3/4 | 3/4 | 1 | 6 | - | 314374 | 314376 |
| 3/4 | 3/4 | 1 | 4 | 1-5/8 | 314378 | 314382 |
| 3/4 | 3/4 | 1 | 5 | 2-3/8 | 314386 | 314390 |
| 3/4 | 3/4 | 1 | 6 | 3-3/8 | 314392 | 314396 |
| 1 | 1 | 1-1/4 | 5 | - | 314398 | 314401 |
| 1 | 1 | 1-1/4 | 6 | - | 314403 | 314407 |
| 1 | 1 | 1-1/4 | 7 | - | 314410 | 314413 |
| 1 | 1 | 1-1/4 | 5 | 2-1/8 | 314415 | 314417 |
| 1 | 1 | 1-1/4 | 6 | 3-3/8 | 314421 | 314425 |
| 1 | 1 | 1-1/4 | 7 | 4-3/8 | 314428 | 314431 |

More About the Series 2014

Reduced neck for extended reach



★ Best ☆ Good