

# SPEED & FEED GUIDE



Optimum Performance

## Series 1025, 1026

GWA 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
	.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 1027, 1028

BNA 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
	.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

# ULTIMATE PERFORMANCE

Premium High Performance Carbide End Mills for Non-Ferrous Alloys



## Series 1025 | GWA3 | 3FL | Square | Alumigator

Diameter	Shank Dia.	LOC	OAL	Bright EDP	ZrN EDP
3/32	1/8	3/16	1-1/2	102537	103123
1/8	1/8	1/4	1-1/2	101035	101037
1/8	1/8	1/2	1-1/2	100942	105059
5/32	3/16	1/2	2	106407	108028
3/16	3/16	3/16	2	101039	101040
3/16	3/16	5/8	3	100947	100952
1/4	1/4	3/8	2-1/2	101044	101045
1/4	1/4	3/4	2-1/2	100955	103126
1/4	1/4	1-1/8	2-1/2	100994	100996
5/16	5/16	7/16	2-1/2	101046	101048
5/16	5/16	3/4	2-1/2	100960	100963
5/16	5/16	1-1/8	3	100997	100998
3/8	3/8	1/2	2-1/2	101049	101053
3/8	3/8	1	2-1/2	100964	100971
3/8	3/8	1-1/2	4	100999	101002
1/2	1/2	5/8	3	101054	101056
1/2	1/2	1-1/4	3	100972	104458
1/2	1/2	2-1/4	4	101003	101011
5/8	5/8	3/4	3-1/2	101057	101058
5/8	5/8	1-5/8	3-1/2	100986	100987
5/8	5/8	2-1/2	5	101012	101013
3/4	3/4	1	4	101061	101062
3/4	3/4	1-5/8	4	100988	105058
3/4	3/4	2-1/2	5	101014	101018
1	1	1-1/4	4	101063	101065
1	1	2	4	100992	100993
1	1	2-1/2	6	101020	101022



### More About the Series 1025

Wiper flat and circular land for high quality floor and wall finishes

Special radii available on request



★ Best ☆ Good

# ULTIMATE PERFORMANCE

Premium High Performance Carbide End Mills for Non-Ferrous Alloys



## More About the Series 1026

Wiper flat and circular land for high quality floor and wall finishes

Special radii available on request

### Series 1026 | GWA3 | 3FL | Reduced Neck | Square | Alumigator

Diameter	Shank Dia.	LOC	OAL	Length Below Shank	Neck Dia.	Bright EDP	ZrN EDP
1/8	1/8	1/4	1-1/2	3/4	0.115	101066	109102
1/8	1/8	1/4	2	1-1/4	0.115	101023	109101
3/16	3/16	5/16	2	1	0.170	101067	109103
3/16	3/16	5/16	3	1-1/2	0.170	101024	103152
1/4	1/4	3/8	2-1/2	1-1/8	0.235	101068	109104
1/4	1/4	3/8	4	2-1/8	0.235	101026	103153
1/4	1/4	3/8	4	2-7/8	0.235	101091	109110
5/16	5/16	7/16	2-1/2	1-1/8	0.295	101069	108136
5/16	5/16	7/16	4	2-1/8	0.295	101028	103154
5/16	5/16	7/16	4	2-7/8	0.295	101092	103161
3/8	3/8	1/2	2-1/2	1-1/8	0.335	101070	109105
3/8	3/8	1/2	4	2-1/8	0.335	101029	103155
3/8	3/8	1/2	6	3-3/8	0.335	101093	109111
1/2	1/2	5/8	3	1-3/8	0.460	101071	109106
1/2	1/2	5/8	4	2-1/8	0.460	101030	103156
1/2	1/2	5/8	6	3-3/8	0.460	101094	109112
5/8	5/8	3/4	3-1/2	1-5/8	0.590	101073	109107
5/8	5/8	3/4	6	2-3/8	0.590	101031	103157
5/8	5/8	3/4	6	3-3/8	0.590	101095	109113
3/4	3/4	1	4	1-5/8	0.715	101074	109108
3/4	3/4	1	6	2-1/2	0.715	101032	103158
3/4	3/4	1	6	3-3/8	0.715	101096	109114
1	1	1-1/4	4	2	0.960	101080	109109
1	1	1-1/4	6	3-3/8	0.960	101034	103159
1	1	1-1/4	6	4-1/2	0.960	101097	109115



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