

SwiftCARB Speeds & Feeds for RampMill Tools Uncoated

AV3 Series			AV3 Series Feeds and Speeds -Uncoated-										N
			ISO			Aluminum Wrought Alloy & Aluminum Alloy <12% Si, 6061-T6, 7075							
			TEA-105	TEA-85	TEA-65	MAX AXIAL DOC	105°	85°	65°	When ramping, reduce program to			
			Chip Thickness at TEA				Surface Feet Per Min						
Diameter		#FL					Min	Mid	Max	RPM = 100%	Feed = 70%		
1/4"	0.250	3	0.0031	0.0036	0.0051	0.500	800	1120	1600		10-15°		
3/8"	0.375	3	0.0041	0.0048	0.0068	0.750	900	1260	1800		10-15°		
1/2"	0.500	3	0.0072	0.0084	0.0120	1.000	1000	1400	2000		12-17°		
5/8"	0.625	3	0.0072	0.0084	0.0120	1.250	1000	1400	2000		12-17°		
3/4"	0.750	3	0.0084	0.0098	0.0140	1.500	1000	1400	2000		12-17°		
1"	1.000	3	0.0102	0.0119	0.0170	2.000	1000	1400	2000		12-17°		
1-1/4"	1.250	3	0.0114	0.0133	0.0190	2.500	1000	1400	2000		12-17°		

AV3 Series			AV3 Series Feeds and Speeds -Uncoated-										N	
			ISO Aluminum Wrought Alloy & Aluminum Alloy >12% Si, Copper, Brass, Bronze											
			TEA-105	TEA-85	TEA-65	MAX AXIAL DOC	105°	85°	65°	When ramping, reduce program to				
Diameter	#FL	Chip Thickness at TEA				Surface Feet Per Min			RPM = 100%	Feed = 70%				
						Min	Mid	Max						
1/4"	0.250	3	0.0031	0.0036	0.0051	0.500	400	560	800		10-15°			
3/8"	0.375	3	0.0041	0.0048	0.0068	0.750	450	630	900		10-15°			
1/2"	0.500	3	0.0072	0.0084	0.0120	1.000	500	700	1000		12-17°			
5/8"	0.625	3	0.0072	0.0084	0.0120	1.250	500	700	1000		12-17°			
3/4"	0.750	3	0.0084	0.0098	0.0140	1.500	500	700	1000		12-17°			
1"	1.000	3	0.0102	0.0119	0.0170	2.000	500	700	1000		12-17°			
1-1/4"	1.250	3	0.0114	0.0133	0.0190	2.500	500	700	1000		12-17°			

