

Machining Guidelines					
Working Material	Application	Cutting Speed		Chip Load	
		fpm	m/min	ipt	m/t
<i>Aluminum (5-8%Si)</i>	Rough Milling	2000-5000	600-1500	0.01-0.02	0.25-0.5
	Finish Milling	2000-6000	600-1800	0.005-0.01	0.125-0.25
	Rough Turning	2000-5000	600-1500	0.01-0.02	0.25-0.6
	Finish Turning	2000-6000	600-1800	0.005-0.01	0.127-0.254
	Drilling	2000-6000	200-325	0.001-0.01	0.025-0.25
<i>Aluminum Cast (5-8%Si)</i>	Drilling	1500-5000	600-1200	0.001-0.01	0.025-0.25
<i>Brass</i>	Milling	2000-4000	600-1200	0.001-0.008	0.075-0.2
	Turning	2000-4000	600-1200	0.003-0.015	0.075-0.375
	Drilling	2000-4000	275-400	0.001-0.01	0.025-0.25
<i>Bronze</i>	Milling	900-1300	275-400	0.003-0.008	0.075-0.2
	Turning	900-1300	275-400	0.003-0.010	0.075-0.25
	Drilling	900-1300	150-600	0.001-0.01	0.025-0.25
<i>Carbon</i>	Milling	500-2000	150-600	0.0003-0.012	0.008-0.3
	Turning	500-2000	150-600	0.005-0.015	0.125-0.375
	Drilling	500-2000	150-600	0.001-0.01	0.025-0.25
<i>Copper</i>	Milling	750-1500	200-450	0.001-0.008	0.025-0.2
	Turning	750-1500	200-450	0.003-0.01	0.075-0.25
	Drilling	750-1000	225-450	0.001-0.01	0.025-0.25
<i>Carbon Fiber Materials</i>	Milling	500-2000	150-601	0.0003-0.015	0.075-0.375
	Turning	500-2000	150-600	0.003-0.02	0.075-0.25
	Drilling	500-2000	225-450	0.001-0.01	0.025-0.25
<i>Glass Fiber Materials</i>	Milling	750-1500	200-450	0.001-0.01	0.025-0.25
	Turning	750-1500	200-450	0.001-0.015	0.05-0.5
	Drilling	750-1000	150-450	0.001-0.01	0.025-0.25
<i>Green Ceramic Materials</i>	Milling	500-1500	150-450	0.002-0.01	0.05-0.25
	Turning	500-1500	150-450	0.002-0.02	0.05-0.5
	Drilling	500-1500	300-1200	0.001-0.01	0.025-0.25
<i>Wood</i>	Milling	3300-9800	1000-3000	0.004-0.03	0.102-0.75
	Turning	3300-9800	1000-3000	0.004-0.03	0.1-0.75
	Drilling	3300-9800	1000-3000	0.003-0.025	0.075-0.635