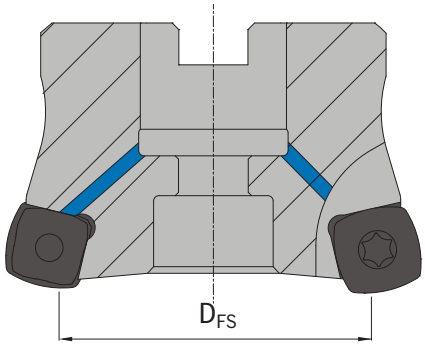
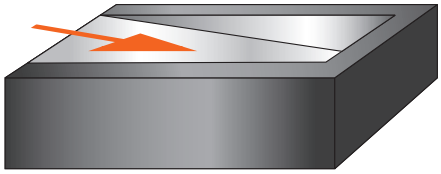
WIDTH OF CUT FOR FLAT SURFACES



CUTTER DIAMETER	D_{FS}
1.250	0.53
1.500	0.78
2.000	1.28
2.500	1.78
3.000	2.28
4.000	3.28
5.000	4.28

RAMPING



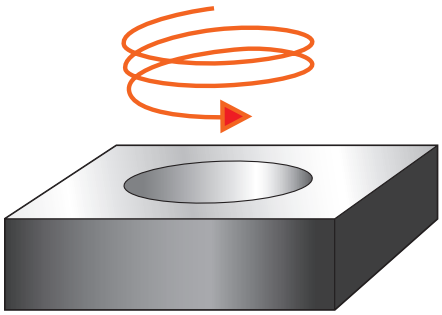
CUTTER DIAMETER	MAX RAMPING ANGLE
1.250	1.8°
1.500	1.5°
2.000	1.2°
2.500	0.9°
3.000	0.8°
4.000	0.6°
5.000	0.4°

FEED RECOMMENDATION
Reduce feed for ramping applications to 75% of normal value.

EXAMPLE: If the calculated face milling feed rate is 200 inches/min, reduce the feed rate for ramping to:

200 inches/min x 75% = 150 inches/min

HELICAL MILLING



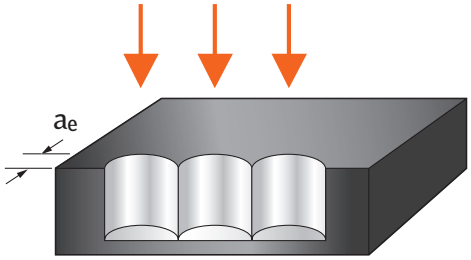
CUTTER DIAMETER	MINIMUM HOLE SIZE	MAXIMUM HOLE SIZE
1.250	1.71	2.42
1.500	2.21	2.92
2.000	3.21	3.92
2.500	4.21	4.92
3.000	5.21	5.92
4.000	7.21	7.92
5.000	9.21	9.92

FEED RECOMMENDATION
Reduce feed for helical milling applications to 30% - 50% of normal value.

EXAMPLE: If the calculated face milling feed rate is 200 inches/min, reduce the feed rate for helical milling to a range of:

200 inches/min x 30% = 60 inches/min
200 inches/min x 50% = 100 inches/min

PLUNGE MILLING

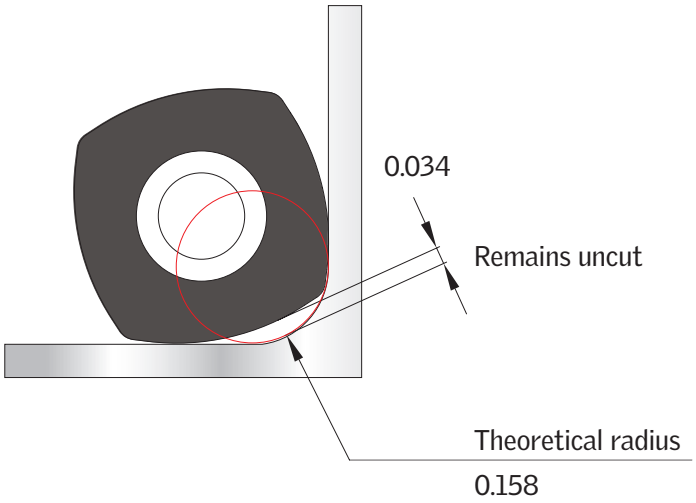


Maximum width of cut a_e = 0.330

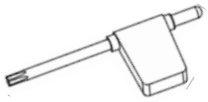
FEED RECOMMENDATION
Recommended starting feed per insert
f_z = .006 (.002-.010)

PROGRAMMING INFORMATION

CAD/CAM systems require a defined theoretical radius value when programming pocketing applications (cavity machining). The theoretical radius value is noted on the drawing to the right, as well as the approximate amount of material that will remain uncut.



SPARE PARTS

INSERT SCREW	WRENCH
	
NS521	FWT15