

variFLUTE® NF SPEEDS & FEEDS

MATERIAL	CUTTING SPEED SFM M/MIN	CHIP LOAD PER TOOTH IN / MM						
		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
Aluminum	1600" - 2000" 490mm - 610mm	0.003" 0.08mm	0.004" 0.10mm	0.005" 0.13mm	0.006" 0.15mm	0.007" 0.18mm	0.008" 0.20mm	0.010" 0.25mm
Copper Alloys	800" - 1200" 240mm - 365mm	0.003" 0.08mm	0.004" 0.10mm	0.005" 0.13mm	0.006" 0.15mm	0.007" 0.18mm	0.008" 0.20mm	0.010" 0.25mm
Brass/Bronze	800" - 1500" 240mm - 460mm	0.003" 0.08mm	0.004" 0.10mm	0.005" 0.13mm	0.006" 0.15mm	0.007" 0.18mm	0.008" 0.20mm	0.010" 0.25mm
Plastics	1200" - 1600" 365mm - 490mm	0.006" 0.16mm	0.008" 0.20mm	0.010" 0.26mm	0.012" 0.30mm	0.014" 0.36mm	0.016" 0.40mm	0.020" 0.50mm

Morse variFLUTE NF mills are capable of very high removal rates.

- Proper coolant under sufficient volume and pressure is important for optimal performance.
- High quality balanced tool holding is recommended.
- Increase chip load based on available machine capability.

RECOMMENDED MAXIMUM DEPTHS OF CUT	PROFILING Radial Depth = .5XD Axial Depth = 1.5XD	SLOTTING Axial Depth = 1XD
---	---	-------------------------------

SPEEDS and FEEDS are suggested starting points and may be increased or decreased depending on actual material and machining conditions.