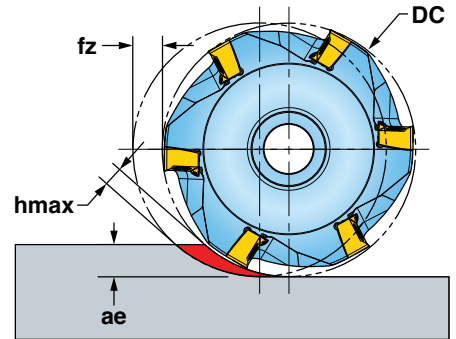


## OPERATING GUIDELINES - 33MM INSERT

### Chip Thinning



\* When  $ae$  is less than 25%  $DC$ , recommend use of Chip Thinning Calculator to ensure  $h_{max}$  falls within  $f_z$  range.

Materials				Vc Cutting Speed SFM	fz * Feed/Tooth (inch)	Grade	Coolant
ISO	Mat'l Group	Type	Examples			IN15K	
<b>N</b>	21-30	Aluminum	7075, 6061	2000-15000	.008-.020	1	Yes

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.