

# HIPOS<sup>o</sup>ALU OPERATING GUIDELINES

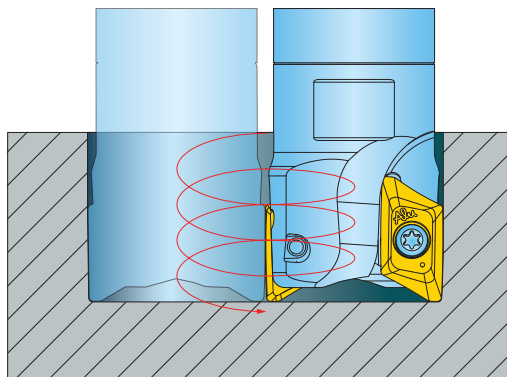
Series 1AX2K, AX2K					IN10K	Coolant
Material	Brinell Hardness	SFM	Feed per Insert (FRM Included)			
Aluminum	7075-T6, 6061-T2, 2024	-	2000 - 15000	.004 - .020	1	YES

Series 1AX2Q, AX2Q					IN10K	Coolant
Material	Brinell Hardness	SFM	Feed per Insert (FRM Included)			
Aluminum	7075-T6, 6061-T2, 2024	-	2000 - 15000	.008 - .025	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 reductions or increases in feeds and speeds. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

## HIPOS<sup>o</sup>ALU TECHNICAL INFORMATION

### Helical Milling



### Safe Stop Pocket Design

Stronger insert design including a unique "V" shape insert pocket bottom and key system means safer, more secure performance under high-speed cutting conditions.



HELICAL MILLING TABLE					
Insert I.C.	Nominal Dia.	Max. Dia. w/Cusp	Max. Dia. w/o Cusp	Min. Dia. w/Cusp	Min. Dia. w/o Cusp
16 mm	1.00	2.000	1.935	1.160	1.845
	1.25	2.500	2.437	1.620	2.347
	1.50	3.000	2.937	2.120	2.849
	2.00	4.000	3.935	3.158	3.847
	2.50	5.000	4.933	4.158	4.845
	3.00	6.000	5.932	5.158	5.844
	4.00	8.000	7.931	7.158	7.844
22 mm	6.00	12.000	11.930	11.158	11.842
	1.25	2.500	2.439	1.484	2.343
	1.50	3.000	2.937	1.938	2.839
	2.00	4.000	3.932	2.974	3.834
	2.50	5.000	4.929	3.974	4.831
	3.00	6.000	5.928	4.974	5.830
	4.00	8.000	7.926	6.974	7.828
6.00	12.000	11.924	10.974	11.826	