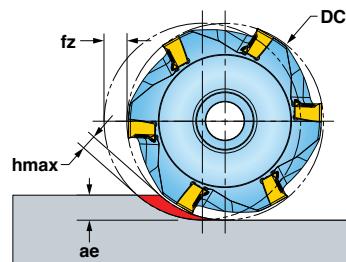


HIPOS[®] ALU 16MM OPERATING GUIDELINES

Chip Thinning



* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz * Feed/Tooth (inch)	Harder <-----> Tougher		Coolant		
ISO	Mat'l Group	Type	Examples			DLC	Uncoated			
						IN3310	IN10K			
N	21-30	Aluminum	7075, 6061	1000 - 10000	.008 - .020		1	Yes		
				5000 - 15000	.008 - .020	1				

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.