

Series 2052, 2053

Ti-Feed | 5-7FL | Corner Radius | High Feed

Material		Axial	Radial	SFM	1/4	3/8	1/2	5/8	3/4	1
					IPM	IPM	IPM	IPM	IPM	IPM
M	SS 300 & 400 Series	.05 X D	.40D	210-290	314	333	283	299	300	299
	303, 304, 316, 420, 417									
M	Precipitation SS	.05 X D	.40D	180-225	194	129	195	206	206	206
	15-5, 16-6, 17-4, 17-6									
S	High Temp Alloys	.05 X D	.30D	80-110	72	76	70	68	63	61
	Inconel 718, Hastalloy, A286, Waspally, CoCr									
S	Titanium & Ti Alloys	.05 X D	.40D	120-200	126	132	125	133	133	132
	Ti-6Al4V, Grades (5-38)									

Part Entry Programming Data

Tool Geometry							Part Entry Guide						
							Circular Interpolation		Linear Ramping (Length per Angle - inch)				
Dia.	Xfm	R	Rfm	Yfm	YD	FL	Hole Dia. (Min)	Hole Dia. (Max)	1 °	2 °	3 °	4 °	5 °
1/4	.0125	0.015	.1490	.0563	.0195	5	.3550	.500	.030	.015	.010	.007	.006
3/8	.0188	0.023	.2235	.0844	.0295	5	.5325	.750	.045	.022	.015	.011	.009
1/2	0.250	0.030	.2981	.1125	.0421	7	.7100	1.00	.060	.030	.020	.015	.012
5/8	.0313	0.037	.3726	.1406	.0495	7	.8875	1.25	.075	.037	.025	.019	.015
3/4	.0375	0.040	.4471	.1688	.0595	7	1.065	1.50	.090	.045	.030	.022	.018
1	.0500	0.060	.5961	.2250	.0795	7	1.420	2.00	.120	.060	.040	.030	.024

Recommended Feed Rate: Reduce 10-30%
Dimensional tool drawings available upon request

