

# Speed & Feed Guide

## Series 1010

ART | 3 FL | Radius | Chip Breaker | Alumigator

Material		Axial ↓	Radial →	3/16		1/4		5/16		3/8		1/2		5/8		3/4	
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM
N	Aluminum, Brass, Copper 6061, 7050, 7075	0.5 X D	0.7 X D	12000	169	12000	227	12000	283	12000	341	12000	454	12000	568	12000	680
		1 X D	.6 X D	12000	155	12000	208	12000	260	12000	312	12000	416	12000	520	12000	624
		2 X D	.4 X D	12000	141	12000	189	12000	236	12000	284	12000	378	12000	473	12000	567
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	0.5 X D	0.7 X D	12000	140	12000	188	12000	235	12000	282	12000	376	12000	470	12000	564
		1 X D	.6 X D	12000	133	12000	179	12000	223	12000	268	12000	357	12000	447	12000	536
		2 X D	.4 X D	12000	127	12000	170	12000	212	12000	256	12000	340	12000	426	12000	510