

# Speed & Feed Guide

## Series 2133

Aggressor-C | 3 FL | Rougher | Aluminum

Profiling			SFM based on RDOC				Inches Per Tooth (IPT)						
			Cutting Diameter Engaged				Cutting Diameter						
Material			10%	20%	30%	50%	*3/16	*1/4	5/16	3/8	1/2	5/8	3/4
N	Non-Ferrous	Aluminum /Aluminum Alloys < 10% Si	2000	1800	1200	900	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
		Aluminum /Aluminum Alloys > 10% Si	1500	1200	1000	800	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
		Brass	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
		Cu/Cu Alloys / Magnesium	1000	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
		Plastics	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015

Slotting			SFM				Inches Per Tooth (IPT)						
			Cutting Diameter Engaged				Cutting Diameter						
Material			25%	50%	100%	*3/16	*1/4	5/16	3/8	1/2	5/8	3/4	1
N	Non-Ferrous	Aluminum /Aluminum Alloys < 10% Si	2000	1500	1000	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
		Aluminum /Aluminum Alloys > 10% Si	1500	1200	800	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
		Brass	600	500	400	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
		Cu/Cu Alloys / Magnesium	500	400	300	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
		Plastics	1200	1000	800	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120