Cutting values: Slotting*, HPC-roughing and copy milling

ISO Code	Hardness	Cutting Speed SFM	Feed Inch Per Tooth (IPT) with nom. Dia				
			1/4	3/8	1/2	3/4	1
N Aluminium	less than 7% Si	1970	0.0015	0.0023	0.0029	0.0038	0.0040
	Up to 17% Si	850	0.0013	0.0019	0.0025	0.0034	0.0036
Graphite	up to 8 micron grain size	1475	0.0025	0.0038	0.0050	0.0068	0.0072
Composites	over 50% fiber content	980	0.0013	0.0019	0.0025	0.0034	0.0036

* peripheral cooling "Guhrojet" is recommended for optimal chip evacuation and tool life, for graphite and Kevlar-machining air cooling
** at lower feed width the cutting speed vc and feed rate fz can be increased by 30%