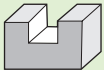
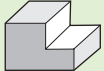
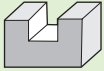
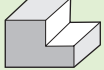


### 334 Series Recommended Cutting Data - Inch

Workpiece Material Group	I S O	Application	Type of cut		Vc (SFM)	Tool Diameter (inch)					
			Radial (Ae)	Axial (Ap)		1/4	3/8	1/2	5/8	3/4	1
						fz - in/tooth					
Aluminum - Wrought (< 10 Si)	N	 Slotting	1 x D	.5 x D	1750-2000	.008	.012	.020	.022	.025	.030
			1 x D	1 x D	1250-1750	.005	.008	.010	.012	.015	.020
		 Profiling	.75 x D	1 x D	2000-2500	.006	.009	.012	.013	.015	.018
			.5 x D	1.5 x D	1750-2000	.006	.009	.012	.013	.015	.018
			.3 x D	2 x D	1250-1750	.008	.012	.016	.018	.020	.024
		Aluminum - Cast (> 10 Si)	N	 Slotting	1 x D	.5 x D	1400-1600	.008	.012	.020	.022
1 x D	1 x D				1000-1400	.005	.008	.010	.012	.015	.020
 Profiling	.75 x D			1 x D	1600-2000	.006	.009	.012	.013	.015	.018
	.5 x D			1.5 x D	1400-1600	.006	.009	.012	.013	.015	.018
	.3 x D			2 x D	1000-1400	.008	.012	.016	.018	.020	.024

Above 20,000 RPM, tool balancing required.

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

- Recommended starting ramp angles = 5-15° @ 30-50% feed reduction
- Under optimal process conditions, increased ramp angles (up to 30°) are possible.