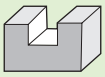
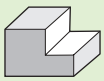
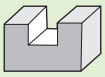
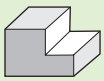
334N Series Recommended Cutting Data - 3xD Neck Length - Inch

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

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.

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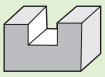
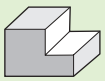
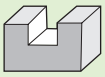
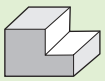
334N Series Recommended Cutting Data - 5xD Neck Length - Inch

Workpiece Material Group	ISO	Application	Type of cut		Vc (SFM)	Tool Diameter (inch)		
						3/8	1/2	3/4
			Radial (Ae)	Axial (Ap)		fz - in/tooth		
Aluminum - Wrought (≤ 10 Si)	N	 Slotting	1 x D	≤ .25 x D	800-1300	.003	.005	.007
		 Profiling	.5 x D	≤ .25 x D	800-1300	.003	.005	.007
			≤ .2 x D	1 x D	1000-1600	.006	.008	.010
Aluminum - Cast (> 10 Si)		 Slotting	1 x D	≤ .25 x D	650-1000	.003	.005	.007
		 Profiling	.5 x D	≤ .25 x D	650-1000	.003	.005	.007
			≤ .2 x D	1 x D	800-1200	.006	.008	.010

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 = 3-5° @ 30-50% feed reduction