

Speed & Feed Guide

Series 1015

AST | 3 FL | Square & 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	1 X D	1.0 X D	12000	98	12000	132	12000	165	12000	198	12000	263	12000	330	12000	395
		2 X D	1.0 X D	12000	74	12000	99	12000	124	12000	149	12000	198	12000	248	12000	297
		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	1 X D	1.0 X D	12000	89	12000	119	12000	148	12000	178	12000	237	12000	297	12000	356
		2 X D	1.0 X D	12000	67	12000	89	12000	112	12000	134	12000	178	12000	223	12000	267
		2 X D	.4 X D	12000	127	12000	170	12000	212	12000	256	12000	340	12000	426	12000	510