

# Speed & Feed Guide

## Series 1500

ASR5 | 5 FL | Chip Breaker | Square & Radius | Coolant-Through | Alumigator

Material		Axial ↓	Radial →	SFM		3/8	1/2	5/8	3/4	1
						IPT	IPT	IPT	IPT	IPT
N	Aluminum Alloy 6061, 7075	.25 X D	1 X D	700	3930	0.0030	0.0050	0.0060	0.0080	0.0090
		0.5 X D	0.5 X D			0.0030	0.0050	0.0060	0.0080	0.0090
		2 X D	0.3 X D			0.0033	0.0055	0.0065	0.0087	0.0098
		Loc Max	0.1 X D			0.0051	0.0085	0.0102	0.0136	0.0153
		Loc Max	0.05 X D			0.0069	0.0115	0.0138	0.0184	0.0207
		Loc Max	0.02 X D			0.0105	0.0175	0.021	0.028	0.0315
	High Silicon Aluminum > 12%	.25 X D	1 X D	525	2948	0.0026	0.0045	0.0054	0.0072	0.0081
		0.5 X D	0.5 X D			0.0026	0.0045	0.0054	0.0072	0.0081
		2 X D	0.3 X D			0.0028	0.0049	0.0059	0.0078	0.0088
		Loc Max	0.1 X D			0.0043	0.0077	0.0092	0.0122	0.0138
		Loc Max	0.05 X D			0.0059	0.0104	0.0124	0.0166	0.0186
		Loc Max	0.02 X D			0.0089	0.0158	0.0189	0.0252	0.0284