



INCH

METRIC

# Aero-Chipper

## Recommended Cutting Data for Aero-Chipper

Material	Grade	SFM	IPT	DOC	WOC
Aluminum	FZ05	1500 - 4000	.015" - .025"	.060" - .120"	60%
Kirksite	JC5118	1000 - 1500	.020"	.060" - .120"	60%
Plastics (free machining)	FZ05	500 - 1000	.010" - .020"	.040" - .100"	60%

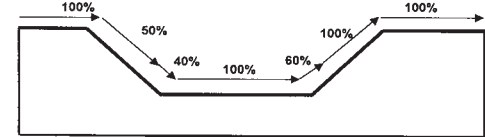
- NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

## Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

## Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern