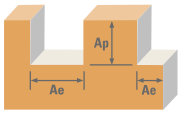
S-Carb APF®



	Series 43MAPF Metric	Hardness		Ae x DC	Ap x DC	Vc (m/min)		DC • mm 6	8	10	12	16	20	25
N	**ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075**	≤ 150 Bhn or ≤ 7 HRc	Profile	≤ 0.1	≤ 2.5	800	RPM	42440	31830	25464	21220	15915	12732	10186
						(640-960)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
							Feed (mm/min)	8488	7003	6111	5942	6366	7130	6926
			Profile	≤ 0.1	≤ 4	800	RPM	42440	31830	25464	21220	15915	12732	10186
						(640-960)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
							Feed (mm/min)	6790	5729	5093	4244	4456	5093	4889
	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	≤ 150 Bhn or ≤ 7 HRc	Profile	≤ 0.1	≤ 2.5	600	RPM	31830	23873	19098	15915	11936	9549	7639
						(480-720)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
							Feed (mm/min)	6366	5252	4584	4456	4774	5347	5195
			Profile	≤ 0.1	≤ 4	600	RPM	31830	23873	19098	15915	11936	9549	7639
						(480-720)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
							Feed (mm/min)	5093	4297	3820	3183	3342	3820	3667

Bhn (Brinell) HRc (Rockwell C)
surface speed is dependent on machine spindle and fixturing
balancing is recommended at ultra high surface speeds
*tool life may be reduced when machining Lithium Alloys
rpm = (Vc x 1000) / (DC x 3.14)
mm/min = Fz x 4 x rpm
maximum recommended depths shown
reduce speed and feed for materials harder than listed
finish cuts typically require reduced feed and cutting depths of 0.02 X DC maximum
ramp angle = 6° (feed rate = 50%)
plunging not recommended
refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)