



CNC Insert Carbide Face Milling for Non-Ferrous Metals End Mill / Router Bit

Tool No.	Diameter	IPM*	Wings	Chip Load Per Tooth
RC-3400	2-31/64"	25" – 63"	4	0.0008" - 0.002"

Maximum RPM: 8,000 RPM

Tool No.	Diameter	IPM*	Wings	Chip Load Per Tooth
RC-3402	1-5/8"	60" – 120"	3	0.0022"-0.0037"

Maximum RPM: 12,000 RPM

* **IPM:** Inches Per Minute

⚠ Warning: Maximum recommended material depth in one pass 1/32" (1.0mm)

Simple Machining Calculations:

To find **RPM:** (SFM x 3.82) / diameter of tool

To find **SFM:** 0.262 x diameter of tool x RPM

To find **Feed Rate:** RPM x # of flutes x chip load

To find **Chip Load:** IPM / (RPM x # of Flutes)

Depth of Cut: 1 x D Use recommended feed rate
 2 x D Reduce feed rate by 25%
 3 x D Reduce feed rate by 50%