



Aluminum Cutting Data

APPLICATION	GOOD	BETTER	BEST
BLOCK			
Single Pass	63-600	52-000	AMC
Roughing	40-000	52-000	AMC
Finishing		66-300	AMC
Slotting	63-600	52-000	AMC
Profile/Shape		52-200B	AMC
SHEET			
Single Pass	40-000	65-000	63-600
EXTRUSION			
Single Pass	63-600	81-000	81-100

DEPTH OF CUT: 1 x D Use recommended chip load
 2 x D Reduce chip load by 25%
 3 x D Reduce chip load by 50%

To view our complete line of
AMC Tools, reference our
Milling Tools Catalog which is
 available at www.onsrud.com

CHIP LOAD PER TOOTH

Cutting Edge Diameter																	
Series	Cut	1/16	3/32	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1
40-000*	1 x D			.005 - .007		.005 - .007		.006 - .008	.006 - .008	.007 - .009		.008 - .010					
40-100	1 x D			.001 - .003		.001 - .003		.002 - .004	.002 - .004	.003 - .005		.004 - .008			.006 - .008		
52-000	1 x D			.003 - .005		.003 - .005		.004 - .006		.006 - .008		.010 - .012					
52-200B/BL	1 x D	.002 - .004		.003 - .005		.003 - .005		.004 - .006		.006 - .008		.010 - .012		.012 - .014	.014 - .016		
57-000*	1 x D			.003 - .005		.003 - .005		.004 - .006		.006 - .008		.010 - .012					
61-000	1 x D			.001 - .003		.002 - .005		.002 - .005		.003 - .007		.007 - .009					
62-600	1 x D	.002 - .004		.002 - .004		.003 - .006		.003 - .006	.003 - .006	.004 - .008		.008 - .010					
63-000	1 x D			.006 - .008		.006 - .008		.007 - .009	.007 - .009	.008 - .010		.009 - .011					
63-600	1 x D	.002 - .004		.002 - .004		.003 - .006		.003 - .006	.003 - .006	.004 - .008		.008 - .010					
63-900	1 x D	.002 - .004		.002 - .004		.003 - .006		.003 - .006	.003 - .006	.004 - .008		.008 - .010					
64-000/ 65-000	1 x D	.002 - .004		.002 - .004		.003 - .006		.003 - .006		.004 - .008							
77-100(DE)				.002 - .004													
77-100(3E)								.003 - .005									
81-000	1 x D								.004 - .006	.004 - .006							
81-100	1 x D								.002 - .005	.003 - .008		.003 - .008					

* 16,000 RPM

** Aluminum Extrusion or Aluminum UAD Doors/Windows

NOTE: When cutting soft aluminum a squirt of cutting fluid every now and then will help to eliminate chip rewelding and improve surface finish

FORMULAS: Chip Load = Feed Rate / (RPM x # of cutting edges)
 Feed Rate (IPM) = RPM x # of cutting edges x chip load
 Speed (RPM) = Feed Rate / (# of cutting edges x chip load)

DEFINITIONS: IPM = Inches Per Minute
 IPR = Inches Per Revolution