Melin Tool Speed & Feed Information

Series: HVMG3

Carbide | 3 | Center Cutting

3 Flute, 37° for High Velocity Machining
Series: HVMG3

MATERIAL	CONDITION	CUTTING DIAMETER 3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	1"	1-1/4"
Aluminum+Aluminum Alloys	ISO-N	CHIP PER TOOTH							
2024-T4/T6, 2014, 6061-T6/T651, 7075-T6 4000-8000 SFM	Slotting up to 50% of Dia. Deep	0.0027	0.0030	0.0044	0.0060	0.0076	0.0090	0.0120	0.0150
4000-8000 SFM	Profiling up to 60% of Dia	0.0040	0.0045	0.0066	0.0090	0.0114	0.0135	0.0180	0.0225

MATERIAL	CONDITION	CUTTING DIAMETER - METRIC 10mm	12mm	16mm	20mm	25mm
Aluminum+Aluminum Alloys	ISO-N	CHIP PER TOOTH				
2024-T4/T6, 2014, 6061-T6/T651, 7075-T6 4000-8000 SFM	Slotting up to 50% of Dia. Deep	0.1118	0.1524	0.1930	0.2286	0.3048
4000-8000 SFM	Profiling up to 60% of Dia	0.1676	0.2286	0.2896	0.3429	0.4572

METRIC

Note: These cutters should be used on 120 Kw spindles only

MELIN TOOL COMPANY
Speeds & Feeds

Note: All listed technical data provided are suggested starting points. They may be increased or decreased depending on machine condition, depth of cut, finish required, coolant, etc.

Additional Info: Our Technical Service Team is available to answer any questions. You can contact one of our expert application specialists at 216-362-4200 or techsupport@melintool.com

Warning: Tools may shatter. Appropriate safeguards required.