

# A Aluminum Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
<b>BLOCK</b>			
Single Pass	63-600	AMC 2 Flute	AMC 3 Flute
Roughing	AMC 2 Flute	AMC 3 Flute	AMC Rougher
Finishing		66-300	AMC
Slotting	63-600	AMC 2 Flute	AMC 3 Flute
Profile/Shape		52-200B	AMC
<b>SHEET</b>			
Single Pass	61-000	65-000	63-600
<b>EXTRUSION</b>			
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](http://www.onsrud.com)

Recommended Chip Load per Tooth by Cutting Diameter (in)																							
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	1 1/8	1 1/4	1 1/2	1 3/4	2	
37-00/37-20	Varies							.004-.006															
37-70	Varies							.004-.006															
40-000*	1 x D			.005-.007		.005-.007		.006-.008	.006-.008	.007-.009													
40-100	1 x D			.001-.003		.001-.003		.002-.004	.002-.004	.003-.005		.004-.008			.006-.008								
49-000	1 x D			.001-.003						.003-.005													
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													
66-300	1 x D			.002-.004				.004-.006		.006-.008		.006-.008											
77-100	1 x D			.002-.004				.003-.005															
80-000	1 x D			.001-.003																			
81-000	1 x D								.004-.006	.004-.006													
81-100	1 x D								.002-.005	.003-.008		.003-.008											

\* 16,000 RPM

**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