



Speeds and Feeds

90° Rectangular MSAPXXX Indexable Cutters

Aluminums

SFPM 500-1100 for 6000 series alloys use flood coolant

SFPM 400-800 for 7000 series alloys use flood coolant

Insert APET160504PDFR-S H1 .005-.011 IPT – Most Recommended

Insert APET160508PDFRSN-DLC100 .004-.006 IPT

For light depths of cut. Leaves a mirror finish.

Steels

Run dry or air blast

SFPM 300-600 for medium to low carbon steels

SFPM 200-500 for high carbon steels

Insert APMT160508PDER-H ACZ330 for low to high carbon steels .003-.007 IPT

Stainless Steels

Use air with mist or flood coolant

SFPM 250-500

Insert APMT160508PDER-H ACZ310 .003-.007 IPT

Cutting speeds, feeds, and lubrication data are given as starting values only. Parameters should be adjusted to suite your particular and unique application. Cutting tools may shatter and or create dangerous fumes when being used. Appropriate protection is advised.