

VFA TECHNICAL DATA

VARIABLE FLUTE FOR ALUMINUM SPEEDS AND FEEDS

Profiling = 1 x Tool Diameter

Slotting = 1/2 x Tool Diameter

Materials	Brass/Bronze	Copper Alloys	Aluminum	Plastics
Diameter	(200-1500 SFM)	(200-1200 SFM)	(200-2000 SFM)	(200-1600 SFM)
1/8	.0015 ipt	.0015 ipt	.0015 ipt	.002 ipt
1/4	.003 ipt	.003 ipt	.003 ipt	.006 ipt
5/16	.004 ipt	.004 ipt	.004 ipt	.008 ipt
3/8	.005 ipt	.005 ipt	.005 ipt	.010 ipt
1/2	.006 ipt	.006 ipt	.006 ipt	.012 ipt
5/8	.007 ipt	.007 ipt	.007 ipt	.014 ipt
3/4	.008 ipt	.008 ipt	.008 ipt	.016 ipt
1	.010 ipt	.010 ipt	.010 ipt	.020 ipt

ipt = inches per tooth

Coolant blast is beneficial.

Tools perform best when balanced.

These approximate numbers are a good starting point.