

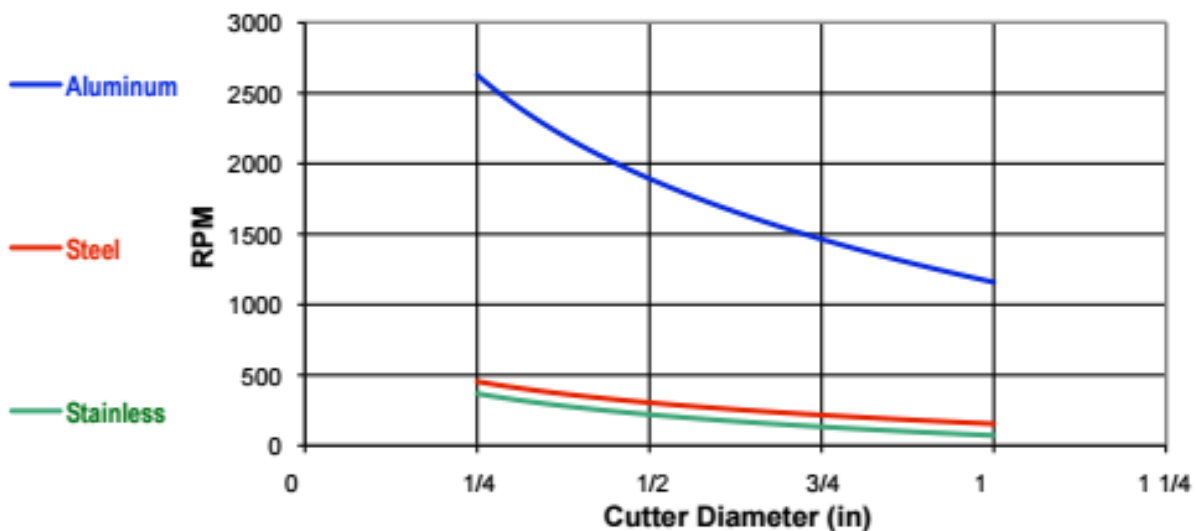
Citrus Circuits Machine Shop Reference Information

Recommended RPM for the Mill

Cutter Diameter
(inches):



Cutter Diameter (inches):	Material:		
	Aluminum	Steel	Stainless
1/4	2500	450	375
3/8	2250	375	300
1/2	2000	300	200
5/8	1750	250	150
3/4	1500	225	120
1	1000	150	100



Depth of Cut for the Mill (in)

	Aluminum	Steel	Stainless
	Rough	0.1	0.08
Finish	0.005	0.005	0.005

Feed Rate for the Mill (ipm)

	Aluminum	Steel	Stainless
	Rough	5	3
Finish	3	2	0.75

Reamer bits are run at ~100 RPM