

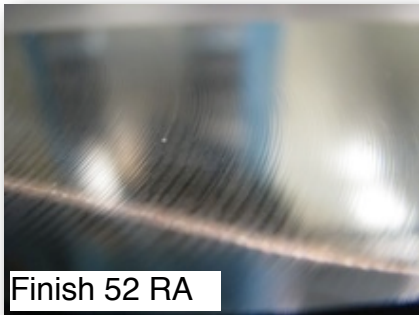
Freedom Cutter Finish Examples in 6061 T6 Aluminum

Parameters:

Mil-Tec Freedom Cutter FC-3-5
SFPM: 2500
Axial DOC: .020"
Feed: .003 CPT

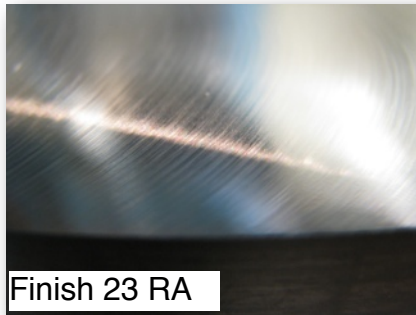


Insert: O-SS-062-20UC



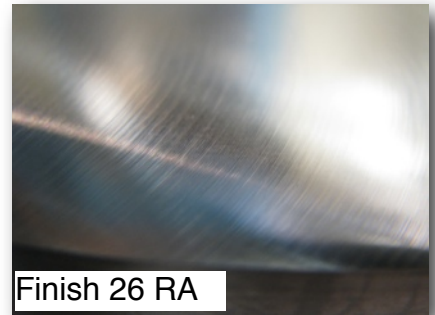
Finish 52 RA

Insert: W/ single NP wiper



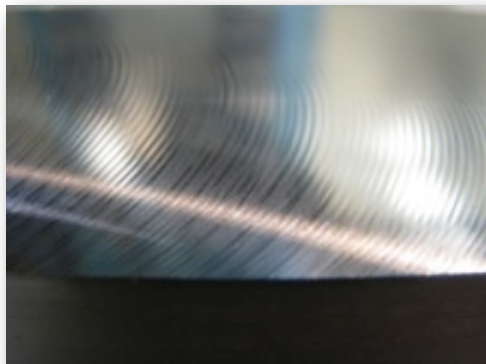
Finish 23 RA

Insert: SS90032W-20UC



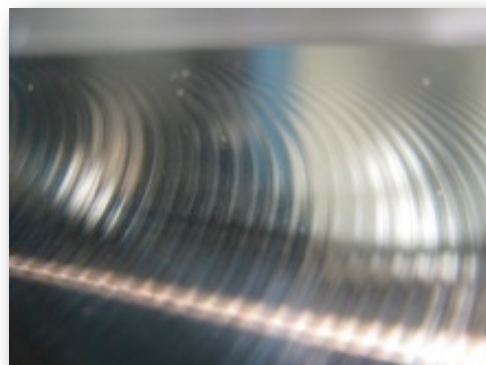
Finish 26 RA

Note: A low measured finish is not always the best visual finish.



Impact with Increase Feed Rate

Insert: O-SS-062-20UC
Feed Rate .006 CPT
Measured Finish 111 RA



Heavy Roughing Feed Rate

Insert: O-SS-062-20UC
Feed Rate .012 CPT
Measured Finish 119 RA

Note: All Photo's taken in Super Macro Mode.