

Series 1500 - ASR5

5-FLUTE COOLANT-THROUGH FOR ALUMINUM

| Material | | Axial ↓ | Radial → | SFM | | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
|----------|-----------------------------------|------------|-------------|-----|------|--------|--------|--------|--------|--------|
| | | | | | | IPT | IPT | IPT | IPT | IPT |
| N | Aluminum Alloy 6061, 7075 | .25 X D | 1 X D | 700 | 3930 | 0.0030 | 0.0050 | 0.0060 | 0.0080 | 0.0090 |
| | | 0.5 X D | 0.5 X D | | | 0.0030 | 0.0050 | 0.0060 | 0.0080 | 0.0090 |
| | | 2 X D | 0.3 X D | | | 0.0033 | 0.0055 | 0.0065 | 0.0087 | 0.0098 |
| | | Loc Max | 0.1 X D | | | 0.0051 | 0.0085 | 0.0102 | 0.0136 | 0.0153 |
| | | Loc Max | 0.05 X D | | | 0.0069 | 0.0115 | 0.0138 | 0.0184 | 0.0207 |
| | | Loc Max | 0.02 X D | | | 0.0105 | 0.0175 | 0.021 | 0.028 | 0.0315 |
| | High Silicon Aluminum > 12% | .25 X D | 1 X D | 525 | 2948 | 0.0026 | 0.0045 | 0.0054 | 0.0072 | 0.0081 |
| | | 0.5 X D | 0.5 X D | | | 0.0026 | 0.0045 | 0.0054 | 0.0072 | 0.0081 |
| | | 2 X D | 0.3 X D | | | 0.0028 | 0.0049 | 0.0059 | 0.0078 | 0.0088 |
| | | Loc Max | 0.1 X D | | | 0.0043 | 0.0077 | 0.0092 | 0.0122 | 0.0138 |
| | | Loc Max | 0.05 X D | | | 0.0059 | 0.0104 | 0.0124 | 0.0166 | 0.0186 |
| | | Loc Max | 0.02 X D | | | 0.0089 | 0.0158 | 0.0189 | 0.0252 | 0.0284 |

Series 1502 - ASR5

5-FLUTE SOLID FOR ALUMINUM

| Material | | Axial ↓ | Radial → | SFM | | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
|----------|-----------------------------------|------------|-------------|-----|------|--------|--------|--------|--------|--------|
| | | | | | | IPT | IPT | IPT | IPT | IPT |
| N | Aluminum Alloy 6061, 7075 | .25 X D | 1 X D | 490 | 2751 | 0.0030 | 0.0050 | 0.0060 | 0.0080 | 0.0090 |
| | | 0.5 X D | 0.5 X D | | | 0.0030 | 0.0050 | 0.0060 | 0.0080 | 0.0090 |
| | | 2 X D | 0.3 X D | | | 0.0033 | 0.0055 | 0.0065 | 0.0087 | 0.0098 |
| | | Loc Max | 0.1 X D | | | 0.0051 | 0.0085 | 0.0102 | 0.0136 | 0.0153 |
| | | Loc Max | 0.05 X D | | | 0.0069 | 0.0115 | 0.0138 | 0.0184 | 0.0207 |
| | | Loc Max | 0.02 X D | | | 0.0105 | 0.0175 | 0.021 | 0.028 | 0.0315 |
| | High Silicon Aluminum > 12% | .25 X D | 1 X D | 368 | 2063 | 0.0026 | 0.0045 | 0.0054 | 0.0072 | 0.0081 |
| | | 0.5 X D | 0.5 X D | | | 0.0026 | 0.0045 | 0.0054 | 0.0072 | 0.0081 |
| | | 2 X D | 0.3 X D | | | 0.0028 | 0.0049 | 0.0059 | 0.0078 | 0.0088 |
| | | Loc Max | 0.1 X D | | | 0.0043 | 0.0077 | 0.0092 | 0.0122 | 0.0138 |
| | | Loc Max | 0.05 X D | | | 0.0059 | 0.0104 | 0.0124 | 0.0166 | 0.0186 |
| | | Loc Max | 0.02 X D | | | 0.0089 | 0.0158 | 0.0189 | 0.0252 | 0.0284 |

