



HIGH PERFORMANCE TECHNICAL INFORMATION



YOUR #1 SOURCE FOR AMERICAN-MADE PREMIUM QUALITY CUTTING TOOLS

6 FLUTE

SFM FINISHING PASSES ONLY, UP TO 10% OF DIAMETER			
MATERIAL / TYPE	Rc HARDNESS	6 FLUTE REG LENGTH	6 FLUTE LONG LENGTH
COBALT BASE ALLOYS			
STELLITE, HS-21,	UNDER 32	550 - 570	385 - 400
HAYNES 25/188, X-40, L-605	OVER 32	200 - 225	140 - 160
NICKEL BASE ALLOYS			
INCONEL-625/718, WASPALLOY,	UNDER 32	550 - 570	385 - 400
RENE, HASTELLOY	OVER 32	200 - 225	140 - 160
IRON BASE ALLOYS			
INCOLOY 800-802, MULTIMET N-155,	UNDER 32	550 - 570	385 - 400
TIMKIN 16-25-6, CARPENTER 22-b3	OVER 32	200 - 225	140 - 160
MONEL			
MONEL-65% NICKEL	-	550 - 570	385 - 400
TITANIUM ALLOYS			
COMMERCIALLY PURE, 6Al-4V,	-	-	-
ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si	-	550 - 570	385 - 400
STAINLESS STEEL (PRECIPITATION)			
12/8, 15/5, 17/4, AM-350/355	UNDER 32	600 - 625	420 - 440
	OVER 32	550 - 570	385 - 400
STAINLESS STEEL (AUSTENITIC)			
200 SERIES, 302, 303, 304, 316	-	600 - 625	420 - 440
STAINLESS STEEL (AUSTENITIC)			
304L, 316L	UNDER 32	600 - 625	420 - 440
	OVER 32	550 - 570	385 - 400
STAINLESS STEEL (MARTENSITIC)			
403, 410, 416, 440	-	600 - 625	420 - 440
HIGH STRENGTH TOOL STEELS			
4140, 4340, 6150, 5210, A2,	UNDER 32	600 - 625	420 - 440
D2, P20, H11, H13, S2, O1	OVER 32	550 - 570	385 - 400
CARBON STEELS			
1000's, 1100's, 1300's	-	800 - 850	560 - 595
DUCTILE			
DUCTILE CAST IRONS	-	800 - 850	560 - 595
CAST IRONS			
GRAY CAST IRONS	-	800 - 850	560 - 595

6 FLUTE

I.P.T. (INCH PER TOOTH)							
MATERIAL / TYPE	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
COBALT BASE ALLOYS							
STELLITE, HS-21, HAYNES 25/188, X-40, L-605	.0009 - .0016	.0010 - .0018	.0012 - .0019	.0016 - .0028	.0019 - .0031	.0024 - .0037	.0029 - .0041
NICKEL BASE ALLOYS							
INCONEL-625/718, WASPALLOY, RENE, HASTELLOY	.0009 - .0016	.0010 - .0018	.0012 - .0019	.0016 - .0028	.0019 - .0031	.0024 - .0037	.0029 - .0041
IRON BASE ALLOYS							
INCOLOY 800-802, MULTIMET N-155, TIMKIN 16-25-6, CARPENTER 22-b3	.0009 - .0016	.0010 - .0018	.0012 - .0019	.0016 - .0028	.0019 - .0031	.0024 - .0037	.0029 - .0041
MONEL							
MONEL-65% NICKEL	.0014 - .0016	.0015 - .0017	.0017 - .0019	.0026 - .0028	.0029 - .0031	.0035 - .0037	.0039 - .0041
TITANIUM ALLOYS							
COMMERCIALLY PURE, 6Al-4V, ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si	.0014 - .0016	.0015 - .0017	.0017 - .0019	.0026 - .0028	.0029 - .0031	.0035 - .0037	.0039 - .0041
STAINLESS STEEL (PRECIPITATION)							
12/8, 15/5, 17/4, AM-350/355	.0014 - .0016	.0016 - .0020	.0017 - .0025	.0026 - .0032	.0029 - .0037	.0035 - .0039	.0039 - .0041
STAINLESS STEEL (AUSTENITIC)							
200 SERIES, 302, 303, 304, 316	.0014 - .0016	.0016 - .0020	.0017 - .0025	.0026 - .0032	.0029 - .0037	.0035 - .0039	.0039 - .0041
STAINLESS STEEL (AUSTENITIC)							
304L, 316L	.0014 - .0016	.0016 - .0020	.0017 - .0025	.0026 - .0032	.0029 - .0037	.0035 - .0039	.0039 - .0041
STAINLESS STEEL (MARTENSITIC)							
403, 410, 416, 440	.0014 - .0016	.0016 - .0020	.0017 - .0025	.0026 - .0032	.0029 - .0037	.0035 - .0039	.0039 - .0041
HIGH STRENGTH TOOL STEELS							
4140, 4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	.0014 - .0016	.0016 - .0020	.0017 - .0025	.0026 - .0032	.0029 - .0037	.0035 - .0039	.0039 - .0041
CARBON STEELS							
1000's, 1100's, 1300's	.0018 - .0020	.0024 - .0026	.0030 - .0032	.0035 - .0037	.0039 - .0041	.0041 - .0043	.0054 - .0056
DUCTILE							
DUCTILE CAST IRONS	.0018 - .0020	.0024 - .0026	.0030 - .0032	.0035 - .0037	.0039 - .0041	.0041 - .0043	.0054 - .0056
CAST IRONS							
GRAY CAST IRONS	.0018 - .0020	.0024 - .0026	.0030 - .0032	.0035 - .0037	.0039 - .0041	.0041 - .0043	.0054 - .0056

Chip Thinning recommended for optimized tool life:

5% of Diameter Radial engaged: Multiply Feed 3X
 10% of Diameter Radial engaged: Multiply Feed 2X