WOLFRAM TOOL

FLUTES
see 1st part of ANSI Part #
R2=2 Flute
R3=3 Flute
R4=4 Flute
R5= 5 Flute
R6= 6 Flute

5 PC. MIMIMUM DEPENDING ON SIZE

ANSI PART # & COATING	EDP	MillDia	ShankDia	Flute Length	Overall Length
Roughing End Mills					
R4R02500	15960	1/4	1/4	3/4	2-1/2
R4R02500 TIN	25960	1/4	1/4	3/4	2-1/2
R4R02500 TICN	45960	1/4	1/4	3/4	2-1/2
R4R02500 ALTIN	55960	1/4	1/4	3/4	2-1/2
R4R03125	15961	5/16	5/16	13/16	2-1/2
R4R03125 TIN	25961	5/16	5/16	13/16	2-1/2
R4R03125 TICN	45961	5/16	5/16	13/16	2-1/2
R4R03125 ALTIN	55961	5/16	5/16	13/16	2-1/2
R4R03750	15962	3/8	3/8	1	2-1/2
R4R03750 TIN	25962	3/8	3/8	1	2-1/2
R4R03750 TICN	45962	3/8	3/8	1	2-1/2
R4R03750 ALTIN	55962	3/8	3/8	1	2-1/2
R4R05000	15963	1/2	1/2	1-1/4	3
R4R05000 TIN	25963	1/2	1/2	1-1/4	3
R4R05000 TICN	45963	1/2	1/2	1-1/4	3
R4R05000 ALTIN	55963	1/2	1/2	1-1/4	3
R4R06250	15964	5/8	5/8	1-1/4	3-1/2
R4R06250 TIN	25964	5/8	5/8	1-1/4	3-1/2
R4R06250 TICN	45964	5/8	5/8	1-1/4	3-1/2
R4R06250 ALTIN	55964	5/8	5/8	1-1/4	3-1/2
R4R07500	15965	3/4	3/4	1-1/2	4
R4R07500 TIN	25965	3/4	3/4	1-1/2	4
R4R07500 TICN	45965	3/4	3/4	1-1/2	4
R4R07500 ALTIN	55965	3/4	3/4	1-1/2	4
R5R10000	15966	1	1	1-1/2	4
R5R10000 TIN	25966	1	1	1-1/2	4
R5R10000 TICN	45966	1	1	1-1/2	4
R5R10000 ALTIN	55966	1	1	1-1/2	4

- Multiple Flute, Center Cutting
- Form relieved on high strength carbide for excellent profile milling.
- Made from premium submicron grain carbide.
- Cutting Diameter Tolerance +.000/-.004

Roughing End Mill Speeds & Feed Data

Material	SFM	1/8"	1/4"	1/2"	1"
Aluminum Alloys	125-250	.0010	.0020	.0025	.0030
Magnesium	125-250	.0010	.0020	.0025	.0030
Copper	75-100	.0008	.0015	.0030	.0060
Brass	85-110	.0008	.0015	.0030	.0060
Bronze	75-100	.0008	.0015	.0030	.0060
Cast Iron	100-125	.0008	.0015	.0025	.0050
Cast Steel	75-100	.0008	.0015	.0025	.0050
Malleable Iron	80-120	.0008	.0015	.0025	.0050
Stainless Steel					
Free Machining	75-90	.0005	.0007	.0012	.0020
Other	60-75	.0005	.0007	.0012	.0020
Steel					
Annealed	100-125	.0010	.0020	.0040	.0060
Rc 18-24	75-100	.0070	.0012	.0030	.0050
Rc 25-37	40-75	.0005	.0010	.0020	.0040
Titanium					
Up to Rc 30	40-75	.0005	.0012	.0025	.0050
Rc 30+	20-25	.0005	.0010	.0020	.0035
High Temp Alloys					
Austenitic	12-20	*	.0007	.0015	.0030
Ferritic	50-75	.0004	.0007	.0020	.0050
Nickel Base	20-25	.0004	.0007	.0015	.0030
Cobalt Base	8-15	*	.0007	.0015	.0030