MillLine

SOLIDMEISTER

TUNGALOY

4EHP - 4 FLUTE, HIGH PERFORMANCE, CHATTER FREE SERIES

4 Flute - Variable Pitch Endmill for High-Performance Milling in General Purpose Applications

Member IMC Group

INDUSTRY 4.0

SOLIDMEISTER

TUNGALOY

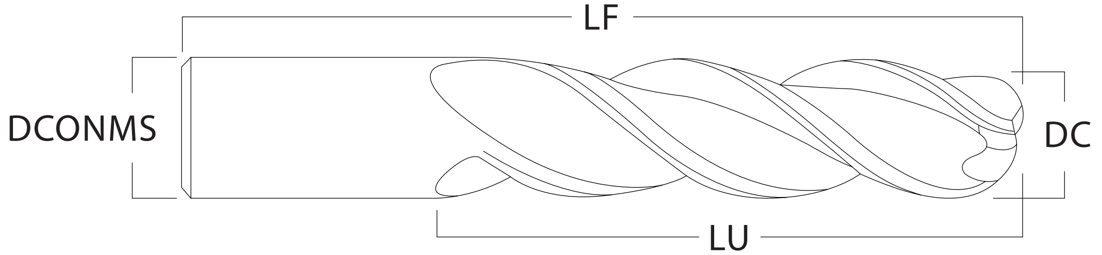
4EHP SERIES

TUNGALOY

4 Flute - Variable Pitch Endmill with
Primary & Secondary Relief Angles
for High Performance Milling

The 4EHP Series is engineered for improved chip evacuation and maximum metal removal rates

The 4EHP Series design consists of primary and secondary relief angles, with unique edge preparations and a variable pitch. It's ideal for increased metal removal rates and minimal chatter.



4EHP SERIES
TUNGALOY

New

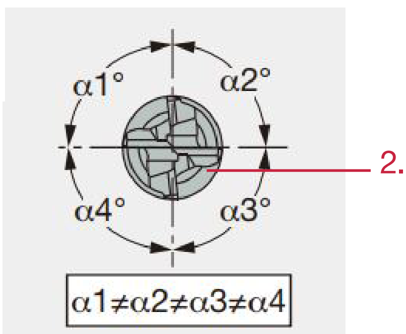
CARBIDE

4 Flutes

TA701

TiAlCN provides higher cutting speeds and excellent wear resistance.

38°



Benefits:
- Increased metal removal rates
- Increased depth-of-cut
- Improved accuracy
- Chatter-free machining
- Higher speeds & feeds
- Superior surface finish on the part

Applications:
- Stainless Steels
- Carbon Steels
- Gray Cast Iron

1. Unique Edge Preparation
for edge strength

2. 4 Flute Variable Pitch, chatter free machining

3. Primary & Secondary Relief
Improved edge strength

4. TA701 Coating
For wet or dry machining operations of steels

5. Extended Neck
Available for deep-pocket applications

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DESIGNATION SYSTEM

The designation for the 4EC Series includes tool dimensions for easy product identification.

① No. of flutes	
2	2 flutes
3	3 flutes
4	4 flutes
4M	4 flutes & medium length
4L	4 flutes & long length
4X	4 flutes & extra long length
4MF	4 flutes & medium length for hardened steel
44	4 variable pitch flutes

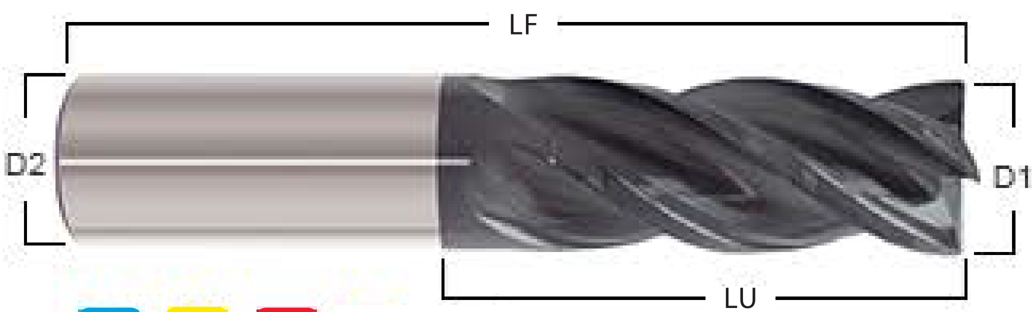
③ Endmill type	
C	Square endmill
B	Ball nose

① 4 ② E ③ C ④ 1000 - ⑤ 1500

② Helix angle	
N	0°
C	10°
T	20°
A	30°
E	38°
B	45°
D	50°
F	55°
H	Variable Helix

④ Cutting diameter	
625	0.625"
300	0.300"
1000	1.000"
1250	1.250"

⑤ Effective length of cut	
0500	0.500"
1000	1.000"
1500	1.500"



P M K

⑥	⑦	⑧	⑨
L6.0	C	125	N

⑥ Overall length

6.0	6.000"
4.5	4.500"
5.8	5.750"

⑦ Shank type

C	Cylindrical
W	Weldon

⑧ Corner Radius

015	0.015"
030	0.030"
125	0.125"

⑨ Neck down version

-	Regular
N	Neck down version

Variable pitch design with high performance features for chatter free machining at higher speeds and feeds.

- Extremely versatile tool for roughing, slotting, finishing and heavy profile applications.
- Provides sharper cutting edge for improved sheer action with primary and secondary relief angles.
- Excellent tool in job shops for increased metal removal rates.
- TiAlCN provides low coefficient of friction, reducing tool wear for longer tool life. Ideal for materials below 45Rc.

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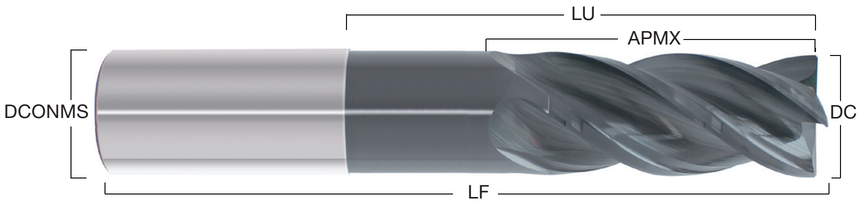
ENDMILL AND BALLNOSE

Insert the corner radius value in the last 3 spaces for full item designation	Corner radius	Item Designation
	Square	4EC125-0500L1.5C**000**
	0.015	4EC125-0500L1.5C**015**
	0.030	4EC125-0500L1.5C**030**
	0.060	4EC125-0500L1.5C**060**
	0.090	4EC125-0500L1.5C**090**
	0.125	4EC125-0500L1.5C**125**

Diameter DC	Shank DCONMS	Flute Length APMX	Usable length LU	OAL / LF	Designation	Corner Radii Square	0.015	0.030	0.060	0.090	0.125	Ballnose
1/8	1/8	1/2	1/2	1.5	4EC125-0500L1.5C□□□	•	•	•				4EB125-0500L1.5C063
3/16	3/16	5/8	5/8	2	4EC187-0625L2.0C□□□	•	•	•				4EB187-0625L2.0C094
1/4	1/4	3/8	3/8	2	4EC250-0375L2.0C□□□	•	•	•	•			4EB250-0375L2.0C125
1/4	1/4	3/4	3/4	2.5	4EC250-0750L2.5C□□□	•	•	•	•			4EB250-0750L2.5C125
1/4	1/4	1	1	3	4EC250-1000L3.0C□□□	•	•	•	•			4EB250-1000L3.0C125
1/4	1/4	1-1/4	1-1/4	4	4EC250-1250L4.0C□□□	•	•	•	•			4EB250-1250L4.0C125
1/4	1/4	1-3/4	1-3/4	4	4EC250-1750L4.0C□□□	•	•	•	•			4EB250-1750L4.0C125
5/16	5/16	1/2	1/2	2	4EC312-0500L2.0C□□□	•	•	•	•			4EB312-0500L2.0C156
5/16	5/16	7/8	7/8	2.5	4EC312-0875L2.5C□□□	•	•	•	•			4EB312-0875L2.5C156
5/16	5/16	1	1	3	4EC312-1000L3.0C□□□	•	•	•	•			4EB312-1000L3.0C156
5/16	5/16	1-1/4	1-1/4	4	4EC312-1250L4.0C□□□	•	•	•	•			4EB312-1250L4.0C156
5/16	5/16	1-5/8	1-5/8	4	4EC312-1625L4.0C□□□	•	•	•	•			4EB312-1625L4.0C156
3/8	3/8	1/2	1/2	2	4EC375-0500L2.0C□□□	•	•	•	•			4EB375-0500L2.0C188
3/8	3/8	1	1	2.5	4EC375-1000L2.5C□□□	•	•	•	•			4EB375-1000L2.5C188
3/8	3/8	1	1	3	4EC375-1000L3.0C□□□	•	•	•	•			4EB375-1000L3.0C188
3/8	3/8	1-1/2	1-1/2	4	4EC375-1500L4.0C□□□	•	•	•	•			4EB375-1500L4.0C188
3/8	3/8	2-1/2	2-1/2	5	4EC375-2500L5.0C□□□	•	•	•	•			4EB375-2500L5.0C188
7/16	7/16	5/8	5/8	2.75	4EC437-0625L2.7C□□□	•	•	•	•			4EB437-0625L2.7C219
7/16	7/16	1	1	2.75	4EC437-1000L2.7C□□□	•	•	•	•			4EB437-1000L2.7C219
7/16	7/16	1-1/2	1-1/2	4	4EC437-1500L4.0C□□□	•	•	•	•			4EB437-1500L4.0C219
7/16	7/16	3	3	6	4EC437-3000L6.0C□□□	•	•	•	•			4EB437-3000L6.0C219
1/2	1/2	5/8	5/8	2.5	4EC500-0625L2.5C□□□	•	•	•	•	•	•	4EB500-0625L2.5C250
1/2	1/2	1	1	3	4EC500-1000L3.0C□□□	•	•	•	•	•	•	4EB500-1000L3.0C250
1/2	1/2	1-1/4	1-1/4	3	4EC500-1250L3.0C□□□	•	•	•	•	•	•	4EB500-1250L3.0C250
1/2	1/2	1-1/2	1-1/2	4	4EC500-1500L4.0C□□□	•	•	•	•	•	•	4EB500-1500L4.0C250
1/2	1/2	2	2	4	4EC500-2000L4.0C□□□	•	•	•	•	•	•	4EB500-2000L4.0C250
1/2	1/2	2-1/2	2-1/2	5	4EC500-2500L5.0C□□□	•	•	•	•	•	•	4EB500-2500L5.0C250
1/2	1/2	3	3	6	4EC500-3000L6.0C□□□	•	•	•	•	•	•	4EB500-3000L6.0C250
5/8	5/8	3/4	3/4	3	4EC625-0750L3.0C□□□	•	•	•	•	•	•	4EB625-0750L3.0C313
5/8	5/8	1-1/4	1-1/4	3.5	4EC625-1250L3.5C□□□	•	•	•	•	•	•	4EB625-1250L3.5C313
5/8	5/8	1-3/4	1-3/4	4	4EC625-1750L4.0C□□□	•	•	•	•	•	•	4EB625-1750L4.0C313
5/8	5/8	2-1/4	2-1/4	5	4EC625-2250L5.0C□□□	•	•	•	•	•	•	4EB625-2250L5.0C313
5/8	5/8	3	3	6	4EC625-3000L6.0C□□□	•	•	•	•	•	•	4EB625-3000L6.0C313
3/4	3/4	7/8	7/8	3	4EC750-0875L3.0C□□□	•	•	•	•	•	•	4EB750-0875L3.0C375
3/4	3/4	1-1/2	1-1/2	4	4EC750-1500L4.0C□□□	•	•	•	•	•	•	4EB750-1500L4.0C375
3/4	3/4	1-5/8	1-5/8	4	4EC750-1625L4.0C□□□	•	•	•	•	•	•	4EB750-1625L4.0C375
3/4	3/4	2-1/4	2-1/4	5	4EC750-2250L5.0C□□□	•	•	•	•	•	•	4EB750-2250L5.0C375
3/4	3/4	3	3	6	4EC750-3000L6.0C□□□	•	•	•	•	•	•	4EB750-3000L6.0C375
3/4	3/4	4	4	7	4EC750-4000L7.0C□□□	•	•	•	•	•	•	4EB750-4000L7.0C375
1	1	1-1/2	1-1/2	4	4EC1000-1500L4.0C□□□	•	•	•	•	•	•	4EB1000-1500L4.0C500
1	1	2	2	4.5	4EC1000-2000L4.5C□□□	•	•	•	•	•	•	4EB1000-4500L4.5C500
1	1	2-1/4	2-1/4	5	4EC1000-2250L5.0C□□□	•	•	•	•	•	•	4EB1000-2250L5.0C500
1	1	3	3	6	4EC1000-3000L6.0C□□□	•	•	•	•	•	•	4EB1000-3000L6.0C500
1	1	4	4	7	4EC1000-4000L7.0C□□□	•	•	•	•	•	•	4EB1000-4000L7.0C500

NECKDOWN



	Corner radius	Item Designation
Insert the corner radius value in the last 3 spaces for full item designation	**Square**	4EC125-0500L1.5C**000**
	0.015	4EC125-0500L1.5C**015**
	0.030	4EC125-0500L1.5C**030**
	0.060	4EC125-0500L1.5C**060**
	0.090	4EC125-0500L1.5C**090**
	0.125	4EC125-0500L1.5C**125**

Diameter DC	Shank DCONMS	Flute Length APMX	Usable length LU	OAL / LF	Designation	Corner Radii Square	0.015	0.030	0.060	0.090	0.125	Ballnose
1/4	1/4	1/2	1-1/4	3	4EC250-0500L3.0C□□□N	●	●	●	●			4EB250-0500L3.0C125N
1/4	1/4	1/2	2-1/8	4	4EC250-0500L4.0C□□□N	●	●	●	●			4EB250-0500L4.0C125N
3/8	3/8	3/4	1-1/4	3	4EC375-0750L3.0C□□□N	●	●	●	●			4EB375-0750L3.0C188N
3/8	3/8	3/4	2-1/8	4	4EC375-0750L4.0C□□□N	●	●	●	●			4EB375-0750L4.0C188N
1/2	1/2	7/8	1-3/8	3	4EC500-0875L3.0C□□□N	●	●	●	●	●	●	4EB500-0875L3.0C250N
1/2	1/2	7/8	2-1/8	4	4EC500-0875L4.0C□□□N	●	●	●	●	●	●	4EB500-0875L4.0C250N
1/2	1/2	7/8	3-1/8	5	4EC500-0875L5.0C□□□N	●	●	●	●	●	●	4EB500-0875L5.0C250N
1/2	1/2	7/8	4-1/8	6	4EC500-0875L6.0C□□□N	●	●	●	●	●	●	4EB500-0875L6.0C250N
5/8	5/8	1	2	4	4EC625-1000L4.0C□□□N	●	●	●	●	●	●	4EB625-1000L4.0C313N
5/8	5/8	1	3	5	4EC625-1000L5.0C□□□N	●	●	●	●	●	●	4EB625-1000L5.0C313N
5/8	5/8	1	4	6	4EC625-1000L6.0C□□□N	●	●	●	●	●	●	4EB625-1000L6.0C313N
3/4	3/4	1-1/4	2	4	4EC750-1250L4.0C□□□N	●	●	●	●	●	●	4EB750-1250L4.0C375N
3/4	3/4	1-1/4	3	5	4EC750-1250L5.0C□□□N	●	●	●	●	●	●	4EB750-1250L5.0C375N
3/4	3/4	1-1/4	4	6	4EC750-1250L6.0C□□□N	●	●	●	●	●	●	4EB750-1250L6.0C375N
1	1	1-1/2	3	5	4EC1000-1500L5.0C□□□N	●	●	●	●	●	●	4EB1000-1500L5.0C500N
1	1	1-1/2	4	6	4EC1000-1500L6.0C□□□N	●	●	●	●	●	●	4EB1000-1500L6.0C500N
1	1	1-1/2	5	7	4EC1000-1500L7.0C□□□N	●	●	●	●	●	●	4EB1000-1500L7.0C500N

STANDARD CUTTING CONDITIONS

P1	●	Low-Carbon Steel - 1000 Series (>25 HRc)
P2	●	Low-Carbon Steel - 1000 Series (<25 HRc)
P3	●	Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)
P4	▲	Alloy Tool Steels - 1300, 2000, 3000 (36-48 HRc)
P5	●	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (≤35 HRc)
P6	▲	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 HRc)
M1	●	Austenitic Stainless Steel - Inox, 200 Series, 300 Series
M2	▲	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
M3	▲	Duplex Steel (Austenitic & Ferritic) - 323, 329, F55, 2205

K1	●	Gray Cast Iron
K2	●	Ductile Iron (<28 HRc)
K3	●	Ductile Iron (<38 HRc)
S1	▲	Iron-Based, Heat-Resistant Alloys - Incoloy 800-802, A-286, N-155
S2	▲	Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 (≤48hRc)
S4	▲	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2SN-4Zr-2Mo (≤48 HRc)

● : First Priority ▲ : Second Priority

Slotting

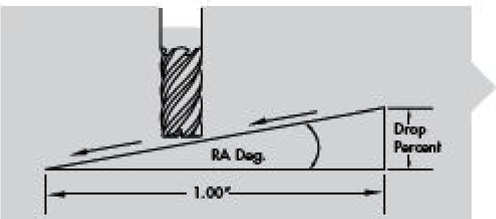
			Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		SFM (Vc)	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	●	400	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
P2	●	400	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
P3	●	350	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
P4	▲	200	.000	.001	.001	.001	.001	.001	.001	.001	.002	.003	N/A	N/A	.6-1.25xD
P5	●	300	.001	.001	.001	.001	.002	.002	.002	.003	.003	.004	N/A	N/A	.6-1.25xD
P6	▲	300	.001	.001	.001	.001	.002	.002	.002	.003	.003	.004	N/A	N/A	.6-1.25xD
M1	●	175-250	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
M2	▲	175-250	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
M3	▲	120-225	.000	.001	.001	.001	.001	.001	.001	.002	.002	.003	N/A	N/A	.6-1.25xD
K1	●	350-450	.001	.001	.002	.002	.003	.003	.004	.005	.006	.008	N/A	N/A	.6-1.25xD
K2	●	275	.001	.001	.001	.001	.001	.001	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
K3	●	275	.001	.001	.001	.001	.001	.001	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
S1	▲	90-175	.001	.001	.001	.001	.001	.001	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
S2	▲	90-175	.001	.001	.001	.001	.001	.001	.002	.002	.003	.004	N/A	N/A	.6-1.25xD
S4	▲	140-200	.000	.001	.001	.001	.001	.001	.002	.002	.003	.004	N/A	N/A	.6-1.25xD

● : First Priority ▲ : Second Priority

We recommend using air blast to cool the tool anytime you are running over 500 SFM

MILL PROCESS	ADOC	RDOC
Slotting	50% - 100% Diameter	100%
Roughing	200% Diameter	30-40%
Finish or HEM	225% Diameter	2-15%

Must use chip thinning calculations when developing feed rates for FINISH OR HEM toolpaths.



Use this guide to determine the maximum ramp length

Ramp Angle	Drop (per inch)	Drop (per min)
2.5"	0.0438	1.113

Tool	Max Ramp Angle	SFM / MMPM	Feed	Max Ramp Depth	Max Ramp Length
4EC	2.5"	Slotting speed	Slotting IPT or CPT x .75	50% of D	(.5 x D) / drop per inch or mm

D = Tool Diameter

STANDARD CUTTING CONDITIONS

Heavy Peripheral

			Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		SFM (Vc)	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	●	400	.001	.001	.001	.001	.002	.002	.003	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
P2	●	400	.001	.001	.001	.001	.002	.002	.003	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
P3	●	350	.0006	.001	.001	.001	.002	.002	.002	.003	.003	.005	.75-1.5xD	.25-.4xD	N/A
P4	▲	200	.0004	.0007	.001	.001	.001	.001	.002	.002	.003	.003	.75-1.5xD	.25-.4xD	N/A
P5	●	300	.0007	.001	.001	.002	.002	.002	.003	.004	.004	.006	.75-1.5xD	.25-.4xD	N/A
P6	▲	300	.0007	.001	.001	.002	.002	.002	.003	.004	.004	.006	.75-1.5xD	.25-.4xD	N/A
M1	●	175-250	.0005	.0007	.001	.001	.001	.002	.002	.002	.003	.004	.75-1.5xD	.25-.4xD	N/A
M2	▲	175-250	.0005	.0007	.001	.001	.001	.002	.002	.002	.003	.004	.75-1.5xD	.25-.4xD	N/A
M3	▲	120-225	.0005	.0007	.001	.001	.001	.001	.002	.002	.003	.004	.75-1.5xD	.25-.4xD	N/A
K1	●	350-450	.001	.001	.001	.002	.003	.003	.004	.005	.006	.008	.75-1.5xD	.25-.4xD	N/A
K2	●	275	.0006	.001	.001	.001	.002	.002	.002	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
K3	●	275	.0006	.001	.001	.001	.002	.002	.002	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
S1	▲	90-175	.0007	.001	.001	.001	.002	.002	.003	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
S2	▲	90-175	.0007	.001	.001	.001	.002	.002	.003	.003	.004	.005	.75-1.5xD	.25-.4xD	N/A
S4	▲	140-200	.0006	.001	.001	.001	.002	.002	.002	.002	.003	.004	.75-1.5xD	.25-.4xD	N/A

● : First Priority ▲ : Second Priority

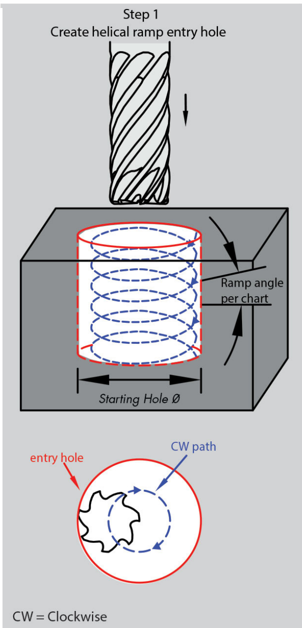
Light Peripheral

			Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		SFM (Vc)	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	●	400	.0005	.0008	.001	.001	.001	.001	.002	.002	.002	.003	1xD	.05xD	N/A
P2	●	400	.0005	.0008	.001	.001	.001	.001	.002	.002	.002	.003	1xD	.05xD	N/A
P3	●	350	.0005	.0007	.001	.001	.001	.001	.002	.002	.003	.004	1xD	.05xD	N/A
P4	▲	200	.0003	.0004	.0005	.0006	.0008	.0009	.001	.001	.001	.002	1xD	.05xD	N/A
P5	●	300	.0004	.0007	.001	.001	.001	.001	.002	.002	.003	.003	1xD	.05xD	N/A
P6	▲	300	.0004	.0007	.001	.001	.001	.001	.002	.002	.003	.003	1xD	.05xD	N/A
M1	●	175-250	.0004	.0005	.0007	.001	.001	.001	.001	.001	.002	.003	1xD	.05xD	N/A
M2	▲	175-250	.0004	.0005	.0007	.001	.001	.001	.001	.001	.002	.003	1xD	.05xD	N/A
M3	▲	120-225	.0003	.0004	.0005	.0006	.0008	.001	.001	.001	.001	.002	1xD	.05xD	N/A
K1	●	350-450	.001	.001	.002	.002	.003	.003	.003	.004	.005	.007	1xD	.05xD	N/A
K2	●	275	.0004	.0006	.0008	.001	.001	.001	.001	.002	.002	.003	1xD	.05xD	N/A
K3	●	275	.0004	.0006	.0008	.001	.001	.001	.001	.002	.002	.003	1xD	.05xD	N/A
S1	▲	90-175	.0003	.0004	.0006	.0007	.0008	.001	.001	.001	.002	.002	1xD	.05xD	N/A
S2	▲	90-175	.0003	.0004	.0006	.0007	.0008	.001	.001	.001	.002	.002	1xD	.05xD	N/A
S4	▲	140-200	.0003	.0004	.0006	.0007	.001	.001	.001	.001	.002	.002	1xD	.05xD	N/A

● : First Priority ▲ : Second Priority

HELICAL RAMP TO CREATE AN ENTRY HOLE

Using a helical ramp move to generate an entry hole is a preferred method to enter the middle of a part. The creation of the entry hole can be either a one-step or a two-step process depending on the number of flutes on the end mill.



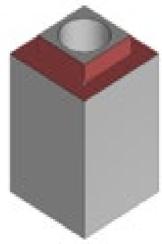
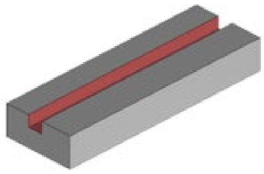
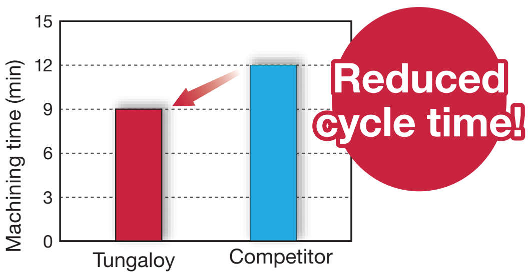
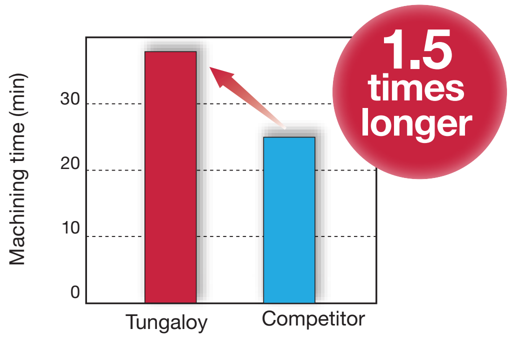
Step 1: Create helical ramp entry hole

The diameter of the starting hole will be: *(tool diameter x 2) - (corner radius x 2)*

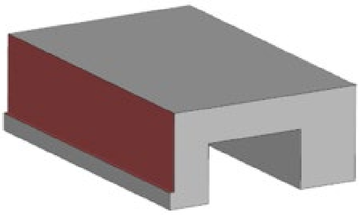
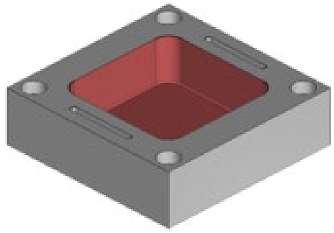
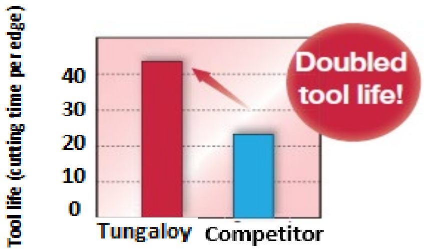
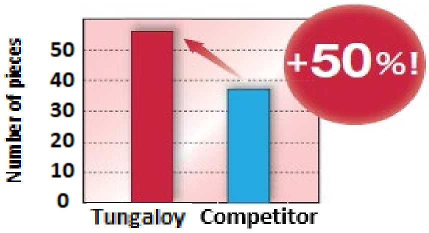
Use the following guide for speed, feed and ramp angle parameters. Note that the terms "Same as chart", "Slotting speed in chart", "Slotting feed in chart" and IPT and CPT reference the data that is shown in the speed and feed charts located in each tool series section.

Tool	Speed	Feed Adjustment	Ramp angle
4EC	Slotting speed in chart	Slotting feed in chart	1" - 1.25"

PRACTICAL EXAMPLES

Workpiece type	Collet Block	Machine part
Cutter	3/8 X 3/8 X 1/2 X 2 - 4F	5/8 X 5/8 X 3/4 X 3 - 4F
Description	4HC375-0500L2.0C030	4HC625-0750L3.0C015
Workpiece material	A2 300BHN	4140 Alloy Steel (28 HRC)
	P 	P 
Cutting speed: Vc (sfm)	350	350
Feed per tooth: fz (ipt)	0.001"	0.008"
Feed speed: Vf (ipm)	15.67"	17"
Depth of cut: ap (inch)	0.38"	0.300"
Width of cut: ae (inch)	0.375"	0.625"
Machining	Shoulder Milling	Slotting
Coolant	Wet	Wet
Machine	Okuma Vertical	Mazak I-800
Results	 Variable design allows chatter free machining at higher speeds and feeds to reduce cycle time.	 Unique flute design and coating improve tool life in slotting applications.

PRACTICAL EXAMPLES

Workpiece type	Housing	Base Plate
Cutter	5/8 X 5/8 X 3/4 X 3 - 4F	5/8 X 5/8 X 1 X 5 - 4F Neck Down
Description	4HC625-0750L3.0C060	4HC625-1000L5.0C030N
	422 ss (36HRC)	304ss 275 Brinnel
Workpiece material	M 	M 
Cutting speed: Vc (sfm)	630	800
Feed per tooth: fz (ipt)	0.0021"	0.0027"
Feed speed: Vf (ipm)	54.65"	112"
Depth of cut: ap (inch)	1.7"	1.75"
Width of cut: ae (inch)	0.0625"	0.03"
Machining	Shoulder Milling	Pocketing
Coolant	Air	Air
Machine	Mazak I-800	Mazak I-800
Results	 Variable pitch eliminates chatter and TiALCN coating provides both heat and oxidation resistance improving tool life.	 High Performance 4 flute solid carbide endmill is designed for improved chip evacuation and maximum metal removal rates. Extended reach provides more stable option in deep pocketing operations.

Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.
Inside Sales: +1-888-554-8394
Technical Support: +1-888-554-8391
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779 Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone:+52-449-929-5410 Fax:+52-449-929-5411
www.tungaloy.com/mx

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