

SPEED & FEED GUIDE



Optimum Performance

Series 2010, 2012, 2014, 2015

250 2 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	1 x D	600	18336	44	9168	48	7334	53	6112	53	4584	55	3667	53	3056	53	
	1.25 x D	.3 x D	720	22003	66	11002	70	8801	77	7334	77	5501	80	4401	77	3667	77	
	1.5 x D	.1 x D	1200	36672	147	18336	150	14669	154	12224	154	9168	162	7334	155	6112	155	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	1 x D	600	18336	37	9168	40	7334	44	6112	44	4584	46	3667	44	3056	44
		1.25 x D	.3 x D	720	22003	53	11002	56	8801	63	7334	63	5501	67	4401	64	3667	64
		1.5 x D	.1 x D	1200	36672	117	18336	121	14669	132	12224	132	9168	139	7334	133	6112	133

Series 2030, 2031, 2047, 2032, 2050, 2053

350 3 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	1 x D	600	18336	66	9168	66	7334	79	6112	79	4584	83	3667	80	3056	80	
	1.25 x D	.3 x D	720	22003	99	11002	96	8801	115	7334	115	5501	121	4401	116	3667	116	
	1.5 x D	.1 x D	1200	36672	220	18336	193	14669	231	12224	231	9168	243	7334	233	6112	233	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	1 x D	600	18336	55	9168	55	7334	66	6112	66	4584	69	3667	67	3056	67
		1.25 x D	.3 x D	720	22003	79	11002	79	8801	95	7334	95	5501	100	4401	96	3667	96
		1.5 x D	.1 x D	1200	36672	176	18336	165	14669	198	12224	198	9168	208	7334	200	6112	200

Series 2060

550 5 FLUTE SERIES NON-FERROUS

Material	Axial ↓	Radial →	SFM	1/8		1/4		5/16		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
N Aluminum, Brass, Copper 6061, 7050, 7075	.5 x D	.5 x D	600	18336	110	9168	110	7334	132	6112	132	4584	139	3667	133	3056	133	
	1.25 x D	.3 x D	720	22003	165	11002	160	8801	191	7334	191	5501	201	4401	193	3667	193	
	1.5 x D	.1 x D	1200	36672	367	18336	321	14669	385	12224	385	9168	404	7334	388	6112	388	
	High Silicon Aluminum 4% - 13% A242, A319, A356, A390	.5 x D	.5 x D	600	18336	92	9168	92	7334	110	6112	110	4584	116	3667	111	3056	111
		1.25 x D	.3 x D	720	22003	132	11002	132	8801	158	7334	158	5501	166	4401	160	3667	160
		1.5 x D	.1 x D	1200	36672	293	18336	275	14669	330	12224	330	9168	347	7334	333	6112	333

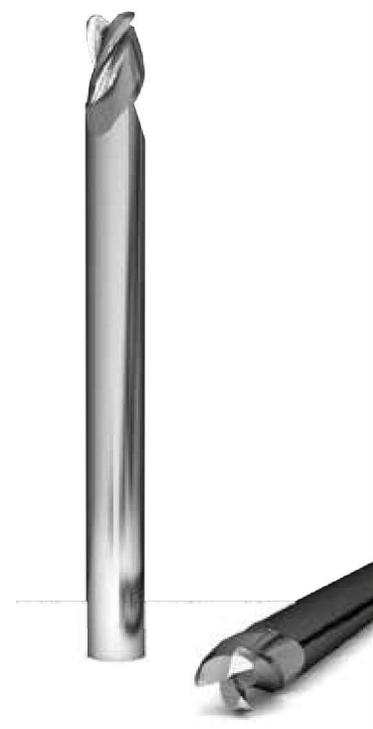
PERFORMANCE

Premium Carbide End Mills for Non-Ferrous Alloys



Series 2030 350 | 3FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	Bright EDP	ZrN EDP
1/8	1/8	1/4	1-1/2	-	314434	314436
1/8	1/8	1/4	1-1/2	0.010	314440	-
1/8	1/8	5/16	1-1/2	-	314442	314445
1/8	1/8	3/8	1-1/2	-	314447	314450
1/8	1/8	3/8	1-1/2	0.010	314453	-
1/8	1/8	3/8	1-1/2	0.020	314456	-
1/8	1/8	3/8	1-1/2	0.030	314458	-
1/8	1/8	1/2	2	-	314462	314466
1/8	1/8	5/8	2	-	314468	314472
1/8	1/8	3/4	2	-	314476	314479
1/8	1/8	1	2-1/2	-	314483	314487
5/32	3/16	5/16	2	-	314491	314493
5/32	3/16	9/16	2	-	314496	-
3/16	3/16	5/16	2	-	314498	314502
3/16	3/16	5/16	2	0.020	-	314504
3/16	3/16	3/8	2	-	314508	314512
3/16	3/16	5/8	2-1/2	-	314516	314518
3/16	3/16	5/8	2-1/2	0.010	-	314520
3/16	3/16	5/8	2-1/2	0.020	-	314523
3/16	3/16	5/8	2-1/2	0.030	-	314527
3/16	3/16	3/4	2-1/2	-	314531	314534
3/16	3/16	1	2-1/2	-	314536	314539
7/32	1/4	3/8	2-1/2	-	314542	314545
7/32	1/4	3/4	2-1/2	-	314547	314549
1/4	1/4	3/8	2-1/2	-	314551	314553
1/4	1/4	3/8	2-1/2	0.015	-	314556
1/4	1/4	3/8	2-1/2	0.020	-	314558
1/4	1/4	3/8	2-1/2	0.030	-	314560
1/4	1/4	3/8	2-1/2	0.060	-	314564
1/4	1/4	1/2	2-1/2	-	314568	314570
1/4	1/4	5/8	2-1/2	-	314572	314575
1/4	1/4	3/4	2-1/2	-	314577	314581
1/4	1/4	3/4	2-1/2	0.010	-	314584
1/4	1/4	3/4	2-1/2	0.015	-	314586
1/4	1/4	3/4	2-1/2	0.020	-	314590
1/4	1/4	3/4	2-1/2	0.030	-	314592
1/4	1/4	3/4	2-1/2	0.045	-	314596
1/4	1/4	3/4	2-1/2	0.060	-	314598
1/4	1/4	1	2-1/2	-	314600	314602
1/4	1/4	1-1/8	2-1/2	-	314605	314607



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Series 2030 350 | 3FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	Bright EDP	ZrN EDP
1/4	1/4	1-1/4	3	-	314610	314614
1/4	1/4	1-1/2	3	-	314616	314618
1/4	1/4	2	4	-	314622	314624
9/32	5/16	7/16	2-1/2	-	314626	314630
9/32	5/16	13/16	2-1/2	-	314633	314636
5/16	5/16	7/16	2-1/2	-	314639	314642
5/16	5/16	7/16	2-1/2	0.020	-	314645
5/16	5/16	7/16	2-1/2	0.030	-	314648
5/16	5/16	1/2	2-1/2	-	314651	314655
5/16	5/16	13/16	2-1/2	-	314657	314661
5/16	5/16	13/16	2-1/2	0.020	-	314663
5/16	5/16	13/16	2-1/2	0.030	-	314666
5/16	5/16	13/16	2-1/2	0.060	-	314670
5/16	5/16	1-1/8	2-1/2	-	314672	314674
5/16	5/16	1-1/4	3-1/2	-	314678	314681
5/16	5/16	1-1/2	3-1/2	-	314684	314687
5/16	5/16	2-1/8	4	-	314690	314692
11/32	3/8	1/2	2-1/2	-	314694	314696
11/32	3/8	1	2-1/2	-	314700	314703
3/8	3/8	1/2	2-1/2	-	314705	314709
3/8	3/8	1/2	2-1/2	0.020	-	314711
3/8	3/8	1/2	2-1/2	0.030	-	314714
3/8	3/8	1/2	2-1/2	0.040	-	314716
3/8	3/8	5/8	2-1/2	-	314719	314723
3/8	3/8	3/4	2-1/2	-	314726	314729
3/8	3/8	1	2-1/2	-	314732	314736
3/8	3/8	1	2-1/2	0.020	-	314738
3/8	3/8	1	2-1/2	0.030	-	314742
3/8	3/8	1	2-1/2	0.045	-	314744
3/8	3/8	1	2-1/2	0.060	-	314747
3/8	3/8	1-1/4	3	-	314749	314753
3/8	3/8	1-1/2	4	-	314755	314758
3/8	3/8	2	4	-	314762	314766
3/8	3/8	2-1/2	6	-	314768	314771
13/32	7/16	9/16	2-3/4	-	314773	314775
13/32	7/16	1	2-3/4	-	314779	314781
7/16	7/16	9/16	2-3/4	-	314783	314786
7/16	7/16	1	2-3/4	-	314790	314793
7/16	7/16	2	4	-	314797	314801
15/32	1/2	5/8	3	-	314803	314805



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Diameter	Shank Dia.	LOC	OAL	Radius	Bright EDP	ZrN EDP
15/32	1/2	1-1/4	3	-	314808	314810
1/2	1/2	5/8	3	-	314814	314818
1/2	1/2	5/8	3	0.020	-	314821
1/2	1/2	5/8	3	0.030	-	314823
1/2	1/2	5/8	3	0.060	-	314827
1/2	1/2	5/8	3	0.090	-	314830
1/2	1/2	3/4	3	-	314834	314836
1/2	1/2	1	3	-	314838	314840
1/2	1/2	1-1/4	3	-	314843	314845
1/2	1/2	1-1/4	3	0.020	-	314847
1/2	1/2	1-1/4	3	0.030	-	314850
1/2	1/2	1-1/4	3	0.060	-	314854
1/2	1/2	1-1/4	3	0.090	-	314857
1/2	1/2	1-1/4	3	0.120	-	314860
1/2	1/2	1-1/2	4	-	314863	314865
1/2	1/2	2	4	-	314869	314872
1/2	1/2	2-1/4	6	-	314876	314878
1/2	1/2	2-1/2	6	-	314880	314884
1/2	1/2	3-1/4	6	-	314888	314892
1/2	1/2	4	8	-	314896	314900
5/8	5/8	3/4	3-1/2	-	314904	314908
5/8	5/8	1-1/4	3-1/2	-	314912	314914
5/8	5/8	1-5/8	3-1/2	-	314917	314920
5/8	5/8	1-5/8	3-1/2	0.030	-	314924
5/8	5/8	1-5/8	3-1/2	0.060	-	314928
5/8	5/8	1-5/8	3-1/2	0.090	-	314930
5/8	5/8	1-5/8	3-1/2	0.120	-	314934
5/8	5/8	2	5	-	314938	314941
5/8	5/8	2-1/2	5	-	314944	314948
5/8	5/8	2-3/4	5	-	314952	314954
5/8	5/8	3-1/4	6	-	314956	314960
5/8	5/8	4	8	-	314962	314965
3/4	3/4	1	4	-	314969	314972
3/4	3/4	1	4	0.060	-	314975
3/4	3/4	1	4	0.090	-	314978
3/4	3/4	1	4	0.120	-	314981
3/4	3/4	1-1/2	4	-	314983	314987
3/4	3/4	1-5/8	4	-	314991	314994
3/4	3/4	1-5/8	4	0.060	-	314996
3/4	3/4	1-5/8	4	0.090	-	314998



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Diameter	Shank Dia.	LOC	OAL	Radius	Bright EDP	ZrN EDP
3/4	3/4	1-5/8	4	0.120	-	315002
3/4	3/4	2	5	-	315005	315007
3/4	3/4	2-1/4	5	-	315011	315013
3/4	3/4	2-1/2	5	-	315017	315021
3/4	3/4	3	6	-	315023	315025
3/4	3/4	3-1/4	6	-	315027	315029
3/4	3/4	3-1/2	6	-	315031	315033
3/4	3/4	4	7	-	315036	315039
3/4	3/4	5	8	-	315043	315047
1	1	1-1/4	5	-	315051	315054
1	1	1-1/2	5	-	315057	315060
1	1	2	5	-	315062	315065
1	1	2	5	0.060	-	315067
1	1	2	5	0.090	-	315070
1	1	2	5	0.120	-	315074
1	1	2-1/2	5	-	315077	315081
1	1	3	6	-	315084	315086
1	1	3-1/2	6	-	315090	315093
1	1	4-1/8	7	-	315096	315099
1	1	5-1/2	8	-	315101	315105
1-1/4	1-1/4	1-1/4	4-1/2	-	-	315107
1-1/4	1-1/4	2	4-1/2	-	315109	315112
1-1/4	1-1/4	3-1/4	6	-	315115	315118
1-1/4	1-1/4	5	7-1/2	-	-	315121



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