

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 2012 250 | 2FL | Reduced Neck | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Length Below Shank	Radius	Bright EDP	ZrN EDP
1/8	1/8	1/4	1-1/2	-	-	313733	313736
1/8	1/8	1/4	1-1/2	1/2	-	313739	313743
1/8	1/8	1/4	1-1/2	1/2	0.020	-	313745
1/8	1/8	1/4	1-1/2	1/2	0.030	-	313749
1/8	1/8	1/4	3	-	-	313751	313755
1/8	1/8	1/4	3	1-3/8	-	313758	313761
1/8	1/8	1/4	3	1-3/8	0.020	-	313763
1/8	1/8	1/4	3	1-3/8	0.030	-	313766
3/16	3/16	5/16	2	-	-	313768	313771
3/16	3/16	5/16	2	1/2	-	313773	313777
3/16	3/16	5/16	2	1/2	0.010	-	313781
3/16	3/16	5/16	2	1/2	0.030	-	313785
3/16	3/16	5/16	3	-	-	313788	-
3/16	3/16	5/16	3	1-3/8	-	313792	313794
3/16	3/16	5/16	3	1-3/8	0.010	-	313797
3/16	3/16	5/16	3	1-3/8	0.030	-	313800
1/4	1/4	3/8	2-1/2	-	-	313802	313805
1/4	1/4	3/8	2-1/2	1-1/8	-	313808	-
1/4	1/4	3/8	2-1/2	1-1/8	0.015	-	313811
1/4	1/4	3/8	2-1/2	1-1/8	0.030	-	313813
1/4	1/4	3/8	2-1/2	1-1/8	0.060	-	313817
1/4	1/4	3/8	2-1/2	1-1/8	0.090	-	313819
1/4	1/4	3/8	4	-	-	313822	313826
1/4	1/4	3/8	4	2-1/8	-	313828	313831
1/4	1/4	3/8	4	2-1/8	0.015	-	313834
1/4	1/4	3/8	4	2-1/8	0.030	-	313836
1/4	1/4	3/8	4	2-1/8	0.060	-	313839
1/4	1/4	3/8	4	2-1/8	0.090	-	313843
1/4	1/4	3/4	4	2-1/8	0.015	-	313847
1/4	1/4	3/4	4	2-1/8	0.030	-	313851
1/4	1/4	3/4	4	2-1/8	0.060	-	313855
1/4	1/4	3/4	4	2-1/8	0.090	-	313858
5/16	5/16	7/16	2-1/2	-	-	313862	313864
5/16	5/16	7/16	2-1/2	1-1/8	-	313867	313869
5/16	5/16	7/16	2-1/2	1-1/8	0.015	-	313873
5/16	5/16	7/16	4	-	-	313877	313879
5/16	5/16	7/16	4	2-1/8	-	313882	313886
5/16	5/16	13/16	4	2-1/8	0.015	-	313888
3/8	3/8	1/2	2-1/2	-	-	313892	313894
3/8	3/8	1/2	2-1/2	1-1/8	-	313897	-

More About the Series 2012

Reduced neck for extended reach



★ Best ☆ Good

PERFORMANCE

Premium Carbide End Mills for Non-Ferrous Alloys



Series 2012 250 | 2FL | Reduced Neck | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Length Below Shank	Radius	Bright EDP	ZrN EDP
3/8	3/8	1/2	4	-	-	313900	313904
3/8	3/8	1/2	4	2-1/8	-	313907	313909
3/8	3/8	1/2	4	2-1/8	0.030	-	313913
1/2	1/2	5/8	3	-	-	313917	313920
1/2	1/2	5/8	3	1-3/8	-	313924	313927
1/2	1/2	5/8	3	1-3/8	0.015	-	313929
1/2	1/2	5/8	3	1-3/8	0.020	-	313932
1/2	1/2	5/8	3	1-3/8	0.030	-	313936
1/2	1/2	5/8	3	1-3/8	0.060	-	313938
1/2	1/2	5/8	3	1-3/8	0.090	-	313941
1/2	1/2	5/8	3	1-3/8	0.120	-	313943
1/2	1/2	5/8	4	-	-	313947	313949
1/2	1/2	5/8	4	2-3/8	-	313953	313957
1/2	1/2	5/8	4	2-3/8	0.015	-	313961
1/2	1/2	5/8	4	2-3/8	0.020	-	313963
1/2	1/2	5/8	4	2-3/8	0.030	-	313967
1/2	1/2	5/8	4	2-3/8	0.060	-	313969
1/2	1/2	5/8	4	2-3/8	0.090	-	313972
1/2	1/2	5/8	4	2-3/8	0.120	-	313974
1/2	1/2	5/8	6	-	-	313978	313982
1/2	1/2	5/8	6	3-3/8	0.015	-	313986
1/2	1/2	5/8	6	3-3/8	0.020	-	313989
1/2	1/2	5/8	6	3-3/8	0.030	-	313992
1/2	1/2	5/8	6	3-3/8	0.060	-	313994
1/2	1/2	5/8	6	3-3/8	0.090	-	313996
1/2	1/2	5/8	6	3-3/8	0.120	-	313999
1/2	1/2	1-1/4	6	3-3/8	0.015	-	314001
1/2	1/2	1-1/4	6	3-3/8	0.030	-	314004
1/2	1/2	1-1/4	6	3-3/8	0.060	-	314008
1/2	1/2	1-1/4	6	3-3/8	0.090	-	314010
1/2	1/2	1-1/4	6	3-3/8	0.120	-	314014
5/8	5/8	3/4	3-1/2	-	-	314017	314019
5/8	5/8	3/4	3-1/2	1-5/8	-	314022	314024
5/8	5/8	3/4	5	-	-	314027	314030
5/8	5/8	3/4	5	2-3/8	-	314032	314035
5/8	5/8	3/4	6	-	-	314037	314039
5/8	5/8	3/4	6	3-3/8	-	314043	314045
3/4	3/4	1	4	-	-	314049	314053
3/4	3/4	1	4	1-5/8	-	314057	314060
3/4	3/4	1	4	1-5/8	0.030	-	314064

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Diameter	Shank Dia.	LOC	OAL	Length Below Shank	Radius	Bright EDP	ZrN EDP
3/4	3/4	1	4	1-5/8	0.060	-	314067
3/4	3/4	1	4	1-5/8	0.090	-	314071
3/4	3/4	1	4	1-5/8	0.120	-	314074
3/4	3/4	1	5	-	-	314077	314079
3/4	3/4	1	5	2-1/2	-	314082	314086
3/4	3/4	1	5	2-1/2	0.030	-	314088
3/4	3/4	1	5	2-1/2	0.060	-	314091
3/4	3/4	1	5	2-1/2	0.090	-	314095
3/4	3/4	1	5	2-1/2	0.120	-	314098
3/4	3/4	1	6	-	-	314101	314105
3/4	3/4	1	6	3-3/8	-	314109	314111
3/4	3/4	1	6	3-3/8	0.030	-	314114
3/4	3/4	1	6	3-3/8	0.060	-	314116
3/4	3/4	1	6	3-3/8	0.090	-	314119
3/4	3/4	1	6	3-3/8	0.120	-	314122
3/4	3/4	1-5/8	6	3-3/8	0.030	-	314126
3/4	3/4	1-5/8	6	3-3/8	0.060	-	314128
3/4	3/4	1-5/8	6	3-3/8	0.090	-	314130
3/4	3/4	1-5/8	6	3-3/8	0.120	-	314133
1	1	1-1/4	5	-	-	314136	314140
1	1	1-1/4	5	2-1/8	-	314142	314144
1	1	1-1/4	6	-	-	314146	314149
1	1	1-1/4	6	3-3/8	-	314153	314157
1	1	1-1/4	6	3-3/8	0.030	-	314161
1	1	1-1/4	6	3-3/8	0.060	-	314165
1	1	1-1/4	6	3-3/8	0.090	-	314167
1	1	1-1/4	6	3-3/8	0.120	-	314170
1	1	1-1/4	7	-	-	314172	314176
1	1	1-1/4	7	4-3/8	-	314179	314181
1	1	1-1/4	7	4-3/8	0.030	-	314184
1	1	1-1/4	7	4-3/8	0.060	-	314186
1	1	1-1/4	7	4-3/8	0.090	-	314190
1	1	1-1/4	7	4-3/8	0.120	-	314193
1	1	2	7	4-3/8	0.030	-	314197
1	1	2	7	4-3/8	0.060	-	314199
1	1	2	7	4-3/8	0.090	-	314202
1	1	2	7	4-3/8	0.120	-	314206

More About the Series 2012

Reduced neck for extended reach



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