SPEED & FEED GUIDE

Optimum Performance

Series 2230

437

Material		Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4	
					RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM
P	**Carbon Steel** 10XX, 11XX, 2XX, 13XX	1 x D	.3 x D	**220**	6723	13	3362	13	2241	16	1681	17	1345	16	1121	15
		1.25 x D	.2 x D	**264**	8068	19	4034	194	2689	23	2017	24	1614	23	1345	21
		1.5 X D	.08 x D	**317**	9681	39	4841	39	3227	45	2420	47	1936	46	1614	42
		1.5 x D	.05 x D	**380**	11618	60	5809	51	3873	59	2904	62	2324	59	1936	54
	Alloy Steel 4140, 8620	1 x D	.3 x D	**180**	5501	11	2750	15	1834	13	1375	14	1100	13	917	12
		1.25 x D	.2 x D	**225**	6876	17	3438	23	2292	20	1719	21	1375	20	1146	18
		1.5 X D	.08 x D	**270**	8251	33	4126	462	2750	39	2063	40	1650	39	1375	36
		1.5 x D	.05 x D	**297**	9076	47	4538	54	3025	46	2269	48	1815	46	1513	42
	Tool Steel A2 ,A3, D2, H11, H13	.5 x D	.3 x D	**160**	4890	10	2445	14	1630	12	1222	12	978	12	815	11
		1.0 x D	.2 x D	**200**	6112	15	3056	21	2037	18	1528	18	1222	18	1019	16
		1.5 x D	.08 x D	**240**	7334	29	3667	411	2445	34	1834	36	1467	35	1222	32
		1.5 x D	.05 x D	**264**	8068	42	4034	48	2689	41	2017	43	1614	41	1345	38
M	**SS** 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	.3 x D	**140**	4278	9	2139	7	1426	10	1070	11	856	10	713	9
		1.25 x D	.2 x D	**185**	5654	14	2827	11	1885	16	1413	17	1131	16	942	15
		1.5 x D	.08 x D	**230**	7039	28	3519	23	2346	33	1760	34	1408	33	1173	30
		1.5 x D	.05 x D	**276**	8446	44	4223	34	2815	43	2112	45	1689	43	1408	40
	Precipitation SS 15-5, 16-6, 17-4, 17-6	.5 x D	.3 x D	**115**	3514	7	1757	6	1171	7	879	7	703	7	586	6
		1.25 x D	.2 x D	**180**	5501	13	2750	11	1834	12	1375	12	1100	12	917	11
		1.5 x D	.08 x D	**250**	7640	31	3820	24	2547	26	1910	28	1528	27	1273	24
		1.5 x D	.05 x D	**300**	9168	48	4584	37	3056	44	2292	46	1834	44	1528	41
S	**High Temp Alloys** Inconel 718, Hastalloy, A286, Waspalloy, CoCr	.25 x D	.3 x D	**70**	2139	4	1070	3	713	4	535	4	428	4	357	4
		1 x D	.2 x D	**80**	2445	6	1222	5	815	5	611	5	489	5	407	5
		1.25 x D	.08 x D	**125**	3820	15	1910	12	1273	13	955	14	764	13	637	12
		1.5 x D	.05 x D	**160**	4890	25	2445	20	1630	23	1222	25	978	24	815	22

Series 260
437 | 4FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1/8	1/8	1/4	2	-	**316554**
1/8	1/8	1/4	2	0.010	**316556**
1/8	1/8	1/4	2	0.020	**316558**
1/8	1/8	1/4	2	0.030	**316560**
1/8	1/8	1/2	2	-	**316562**
1/8	1/8	1/2	2	0.010	**316566**
1/8	1/8	1/2	2	0.020	**316569**
1/8	1/8	1/2	2	0.030	**316573**
3/16	3/16	5/16	2	-	**316576**
3/16	3/16	5/16	2	0.010	**316579**
3/16	3/16	5/16	2	0.020	**316582**
3/16	3/16	5/16	2	0.030	**316586**
3/16	3/16	9/16	2	-	**316589**
3/16	3/16	9/16	2	0.010	**316592**
3/16	3/16	9/16	2	0.020	**316596**
3/16	3/16	9/16	2	0.030	**316599**
1/4	1/4	3/8	2-1/2	-	**316603**
1/4	1/4	3/8	2-1/2	0.010	**316605**
1/4	1/4	3/8	2-1/2	0.020	**316609**
1/4	1/4	3/8	2-1/2	0.030	**316613**
1/4	1/4	3/4	2-1/2	-	**316617**
1/4	1/4	3/4	2-1/2	0.010	**316619**
1/4	1/4	3/4	2-1/2	0.020	**316622**
1/4	1/4	3/4	2-1/2	0.030	**316626**
1/4	1/4	3/4	4	-	**316630**
1/4	1/4	3/4	4	0.010	**316633**
1/4	1/4	3/4	4	0.020	**316636**
5/16	5/16	13/16	2-1/2	-	**316639**
5/16	5/16	13/16	2-1/2	0.030	**316642**
1/2	1/2	5/8	3	-	**316644**
1/2	1/2	5/8	3	0.020	**316647**
1/2	1/2	5/8	3	0.030	**316650**
1/2	1/2	5/8	3	0.060	**316652**
1/2	1/2	5/8	0	0.090	**316656**
1/2	1/2	5/8	3	0.120	**316658**
1/2	1/2	1-1/4	3	-	**316660**
1/2	1/2	1-1/4	3	0.020	**316662**
1/2	1/2	1-1/4	3	0.030	**316664**
1/2	1/2	1-1/4	3	0.060	**316668**
1/2	1/2	1-1/4	3	0.090	**316671**

More About the Series 260

Special edge preparation makes this an ideal tool for exotic materials

Features a variable index design with 37 degree helix that reduces chatter and enables more aggressive and stable milling

Alcromax | h6 | P192 | CC | SQ | RAD | 4FL | 37°

Series 260
437 | 4FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1/2	1/2	1-1/4	3	0.120	**316674**
1/2	1/2	1-1/4	4	-	**316677**
1/2	1/2	1-1/4	4	0.020	**316679**
1/2	1/2	1-1/4	4	0.030	**316683**
1/2	1/2	1-1/4	4	0.060	**316686**
1/2	1/2	1-1/4	4	0.090	**316688**
1/2	1/2	1-1/4	4	0.120	**316691**
5/8	5/8	3/4	3	-	**316693**
5/8	5/8	3/4	3	0.030	**316696**
5/8	5/8	3/4	3	0.060	**316699**
5/8	5/8	3/4	3	0.090	**316701**
5/8	5/8	3/4	3	0.120	**316705**
5/8	5/8	1-5/8	3-1/2	-	**316707**
5/8	5/8	1-5/8	3-1/2	0.030	**316710**
5/8	5/8	1-5/8	3-1/2	0.060	**316712**
5/8	5/8	1-5/8	3-1/2	0.090	**316714**
5/8	5/8	1-5/8	3-1/2	0.120	**316718**
3/4	3/4	1	4	-	**316720**
3/4	3/4	1	4	0.030	**316723**
3/4	3/4	1	4	0.060	**316727**
3/4	3/4	1	4	0.090	**316730**
3/4	3/4	1	4	0.120	**316734**
3/4	3/4	1	4	0.156	**316736**
3/4	3/4	1	4	0.190	**316740**
3/4	3/4	1-5/8	4	-	**316742**
3/4	3/4	1-5/8	4	0.030	**316744**
3/4	3/4	1-5/8	4	0.060	**316747**
3/4	3/4	1-5/8	4	0.090	**316751**
3/4	3/4	1-5/8	4	0.120	**316753**
3/4	3/4	1-5/8	4	0.156	**316756**
3/4	3/4	1-5/8	4	0.190	**316758**
3/4	3/4	1-5/8	6	-	**316760**
3/4	3/4	1-5/8	6	0.030	**316764**
3/4	3/4	1-5/8	6	0.060	**316766**
3/4	3/4	1-5/8	6	0.090	**316769**
3/4	3/4	1-5/8	6	0.120	**316773**
3/4	3/4	1-5/8	6	0.156	**316776**
3/4	3/4	1-5/8	6	0.190	**316778**
1	1	1-1/4	4	-	**316782**
1	1	1-1/4	4	0.030	**316786**

More About the Series 260

Special edge preparation makes this an ideal tool for exotic materials

Features a variable index design with 37 degree helix that reduces chatter and enables more aggressive and stable milling

P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2
★	★	☆	☆	☆	☆	☆			★		★	★

★ Best ☆ Good

Series 260 437 | 4FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1	1	1-1/4	4	0.060	**316788**
1	1	1-1/4	4	0.090	**316791**
1	1	1-1/4	4	0.120	**316794**
1	1	1-1/4	4	0.156	**316798**
1	1	1-1/4	4	0.190	**316802**
1	1	2	4	-	**316804**
1	1	2	4	0.030	**316806**
1	1	2	4	0.060	**316810**
1	1	2	4	0.090	**316813**
1	1	2	4	0.120	**316817**
1	1	2	4	0.156	**316820**
1	1	2	4	0.190	**316824**
1	1	3-1/4	6	-	**316827**
1	1	3-1/4	6	0.120	**316831**

More About the Series 260

Special edge preparation makes this an ideal tool for exotic materials

Features a variable index design with 37 degree helix that reduces chatter and enables more aggressive and stable milling