

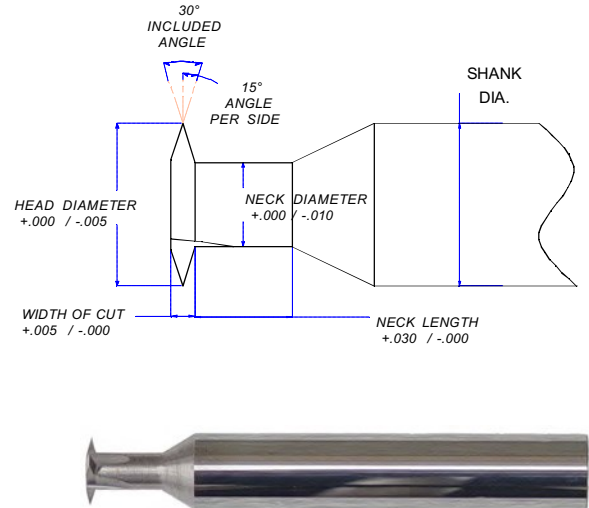
SERIES 92

made from **ITI CARBIDE**

**30° INC. DOUBLE ANGLE CUTTERS**

HEAD DIAMETER	WIDTH OF CUT	ORDER EDP#	ALTiN COATED EDP#	NECK LENGTH	NECK DIAMETER	# OF TEETH	SHANK DIAMETER	OVERALL LENGTH
1/8	.020	92-0880	92-0880-C	.188	.050	4	1/8	2"
		92-0885	92-0885-C	.375				
3/16	.026	92-0890	92-0890-C	.250	.080	4	3/16	2-1/2"
		92-0895	92-0895-C	.750				
1/4	.032	92-0900	92-0900-C	.250	.125	4	1/4	2-1/2"
		92-0905	92-0905-C	.750				
5/16	.040	92-0902	92-0902-C	.312	.160	4	5/16	2-1/2"
		92-0904	92-0904-C	1.000				
3/8	.050	92-0907	92-0907-C	.312	.250	4	3/8	2-1/2"
		92-0910	92-0910-C	1.000				
1/2	.067	92-0912	92-0912-C	.375	.250	4	1/2	3"
		92-0920	92-0920-C	1.250				
5/8*	.070	92-0925	92-0925-C	.250	.250	6	1/2	3"
3/4*	.100	92-0930	92-0930-C	.250	.250	5	1/2	3"

\* CARBIDE HEAD WITH STEEL SHANK

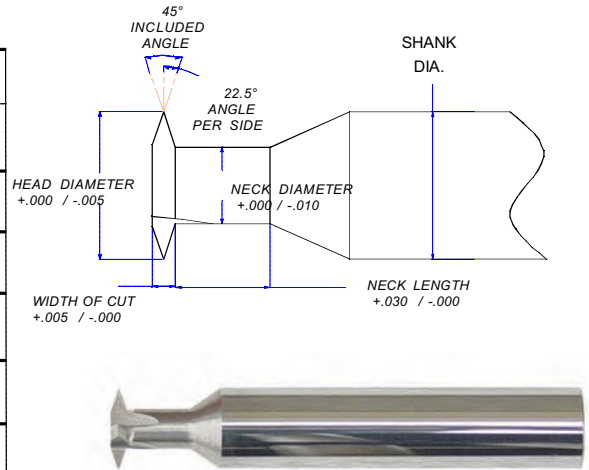


DOUBLE ANGLE

**45° INC. DOUBLE ANGLE CUTTERS**

HEAD DIAMETER	WIDTH OF CUT	ORDER EDP#	ALTiN COATED EDP#	NECK LENGTH	NECK DIAMETER	# OF TEETH	SHANK DIAMETER	OVERALL LENGTH
1/8	.030	92-1500	92-1500-C	.188	.050	4	1/8	2"
		92-1505	92-1505-C	.375				
3/16	.044	92-1510	92-1510-C	.250	.080	4	3/16	2-1/2"
		92-1515	92-1515-C	.750				
1/4	.050	92-1520	92-1520-C	.250	.125	4	1/4	2-1/2"
		92-1525	92-1525-C	.750				
5/16	.062	92-1530	92-1530-C	.312	.160	4	5/16	2-1/2"
		92-1535	92-1535-C	1.000				
3/8	.075	92-1540	92-1540-C	.312	.187	4	3/8	2-1/2"
		92-1545	92-1545-C	1.000				
1/2	.100	92-1550	92-1550-C	.375	.250	4	1/2	3"
		92-1555	92-1555-C	1.250				
5/8*	.125	92-1560	92-1560-C	.250	.250	5	1/2	3"
3/4*	.150	92-1565	92-1565-C	.250	.250	5	1/2	3"

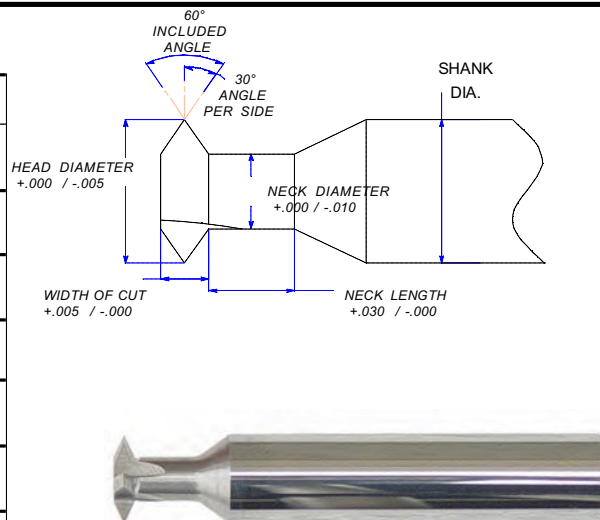
\* CARBIDE HEAD WITH STEEL SHANK



**60° INC. DOUBLE ANGLE CUTTERS**

HEAD DIAMETER	WIDTH OF CUT	ORDER EDP#	ALTiN COATED EDP#	NECK LENGTH	NECK DIAMETER	# OF TEETH	SHANK DIAMETER	OVERALL LENGTH
1/8	.062	92-1180	92-1180-C	.188	.062	4	1/8	2"
		92-1185	92-1185-C	.375				
3/16	.093	92-1190	92-1190-C	.250	.093	4	3/16	2-1/2"
		92-1195	92-1195-C	.750				
1/4	.125	92-1200	92-1200-C	.250	.125	4	1/4	2-1/2"
		92-1205	92-1205-C	.750				
5/16	.088	92-1207	92-1207-C	.312	.160	4	5/16	2-1/2"
		92-1208	92-1208-C	1.000				
3/8	.109	92-1210	92-1210-C	.312	.188	4	3/8	2-1/2"
		92-1215	92-1215-C	1.000				
1/2	.140	92-1220	92-1220-C	.375	.250	4	1/2	3"
		92-1225	92-1225-C	1.250				
5/8*	.144	92-1230	92-1230-C	.250	.250	5	1/2	3"
3/4*	.217	92-1235	92-1235-C	.250	.250	5	1/2	3"

\* CARBIDE HEAD WITH STEEL SHANK



**DOUBLE ANGLE CUTTERS**

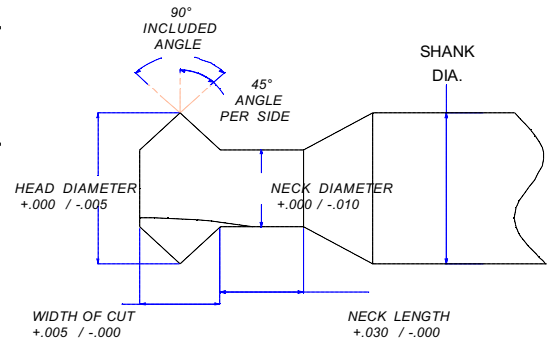
SERIES 92 *made from ITI CARBIDE*

APPLICATION: **FOR CUTTING CHAMFERS, SERRATIONS, ANGLES ETC.**

**90° INC. DOUBLE ANGLE CUTTERS**

HEAD DIAMETER	WIDTH OF CUT	ORDER EDP#	ALTIM COATED EDP#	NECK LENGTH	NECK DIAMETER	# OF TEETH	SHANK DIAMETER	OVERALL LENGTH
3/32	.047	92-0955	92-0955-C	.125	.045	2	1/8	2"
		92-0960	92-0960-C	.250				
1/8	.062	92-0965	92-0965-C	.188	.062	4	1/8	2"
		92-0970	92-0970-C	.500				
3/16	.093	92-0975	92-0975-C	.250	.093	4	3/16	2-1/2"
		92-0980	92-0980-C	.500				
		92-0985	92-0985-C	.750				
		92-0990	92-0990-C	1.000				
1/4	.120	92-1000	92-1000-C	.250	1/8	4	1/4	2-1/2"
		92-1002	92-1002-C	.500				
		92-1005	92-1005-C	.750				
		92-1006	92-1006-C	1.000				
5/16	.125	92-1007	92-1007-C	.500	3/16	4	5/16	2-1/2"
		92-1008	92-1008-C	.750				
		92-1009	92-1009-C	1.000				
3/8	.185	92-1010	92-1010-C	.312	3/16	4	3/8	2-1/2"
		92-1011	92-1011-C	.500				
		92-1012	92-1012-C	.750				
		92-1015	92-1015-C	1.000				
1/2	.250	92-1020	92-1020-C	.375	1/4	4	1/2	3"
		92-1022	92-1022-C	.625				
		92-1023	92-1023-C	.875				
		92-1025	92-1025-C	1.250				
1/2 *	.125	92-1100	92-1100-C	.250	1/4	6	1/2	3-1/8
	.187	92-1105	92-1105-C	.250				
5/8	.312	92-1106	92-1106-C	.500	.300	4	5/8	3-1/2"
		92-1107	92-1107-C	.750				
		92-1108	92-1108-C	1.250				
5/8*	.187	92-1110	92-1110-C	.250	.250	6	1/2	3-1/8
	.250	92-1115	92-1115-C	.250	.280	6		
3/4 *	.125	92-1117	92-1117-C	.250	.250	8	1/2	3-1/8
	.250	92-1120	92-1120-C	.250	.280	8		
1" *	.125	92-1125	92-1125-C	.250	.250	8	1/2	3-1/8
	.250	92-1130	92-1130-C	.250	.490	8		

\* CARBIDE HEAD WITH STEEL SHANK

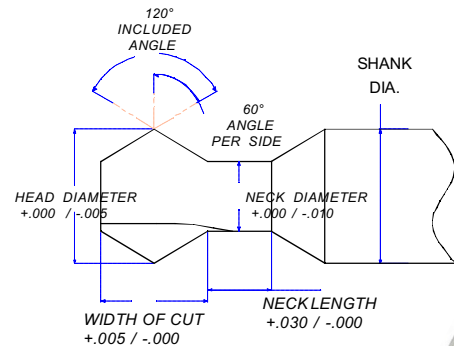


DOUBLE ANGLE

SERIES 92 *made from ITI CARBIDE*

**120° INC. DOUBLE ANGLE CUTTERS**

HEAD & SHANK DIA.	WIDTH OF CUT	ORDER EDP#	ALTIM COATED EDP#	NECK LENGTH	NECK DIAMETER	# OF TEETH	SHANK DIAMETER	OVERALL LENGTH
1/8	.109	92-1280	92-1280-C	.188	.062	4	1/8	2"
		92-1285	92-1285-C	.500				
3/16	.163	92-1290	92-1290-C	.250	.094	4	3/16	2-1/2"
		92-1295	92-1295-C	.750				
1/4	.215	92-1300	92-1300-C	.250	.125	4	1/4	2-1/2"
		92-1302	92-1302-C	.750				
5/16	.281	92-1304	92-1304-C	.312	.150	4	5/16	2-1/2"
		92-1306	92-1306-C	1.000				
3/8	.320	92-1310	92-1310-C	.312	.188	4	3/8	2-1/2"
		92-1315	92-1315-C	1.000				
1/2	.430	92-1320	92-1320-C	.375	.250	4	1/2	3"
		92-1325	92-1325-C	1.250				



**SPEEDS AND FEEDS FOR KEY CUTTERS**

MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE
PLASTIC	TEFLON	200
	NYLON	200
	PHENOLIC	180
	GLASS FILLED	150
MAGNESIUM	AZ,AM,EZ,ZE,HK	300
ALUMINUM	2021 THRU 6061	300
COPPER	101-707	100
	834-978	200
BRASS		250
BRONZE		230
CAST IRON	GRAY	180
	DUCTILE	140
	MALLEABLE	100
STEEL	1005-1029	180
	1030-1055	180
	1060-1095	170
	10L45-10L50	165
	12L13-12L15	160
	41L30-41L50	150
	4140-4150	140
	4140 (35 HRC)	130
	8617-8622	120
	M1-M6	110
	H10-H19	100
	D2-D7	90
	A2-A9, 01-07	80
	W1, W2	70
M-50, 52100	60	
TITANIUM	TI-9Al-6V	90
STAINLESS	201-385	100
	405-446	110
	15-5PH, 16-6PH, 14-4PH	120
NICKEL	NICKEL 200-230	80
MONEL		80
INCONEL		80
WASPALOY		80
HASTELLOY		80

FORMULA FOR COMPUTING SPINDLE SPEED IS.  
 SURFACE FEET PER MINUTE FACTOR X 4 = ?  
 ? DIVIDED BY DIAMETER OF CUTTER = \_\_\_RPM

EXAMPLE CUTTING ALUMINUM  
 WITH A 3/4" KEY CUTTER  
 300 X 4 = 1200 divided by .750 = 1600 RPM

SURFACE FEET      MULTIPLIER      CUTTER DIAMETER

FORMULA FOR COMPUTING TABLE SPEED IS.  
 .001 X NUMBER OF TEETH IN CUTTER X RPM

EXAMPLE CUTTING ALUMINUM  
 WITH A 3/4" KEY CUTTER  
 .001 X 10 X 1600 = 16

MULTIPLIER      NUMBER OF TEETH      RPM      INCHES PER MINUTE

NOTE: ALL SPEEDS AND FEEDS LISTED HERE ARE PROVIDED FOR REFERENCE ONLY.