

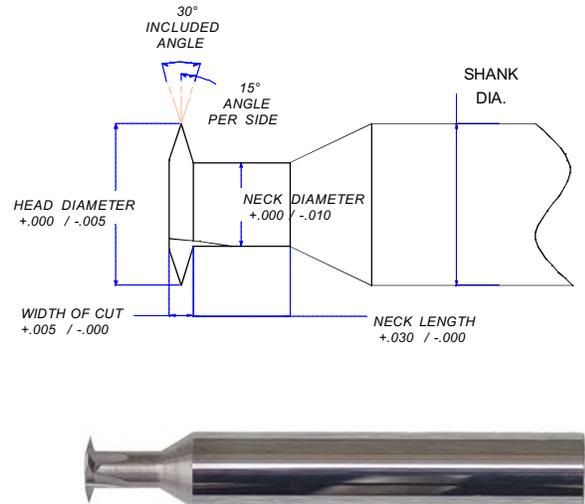
SERIES 92

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

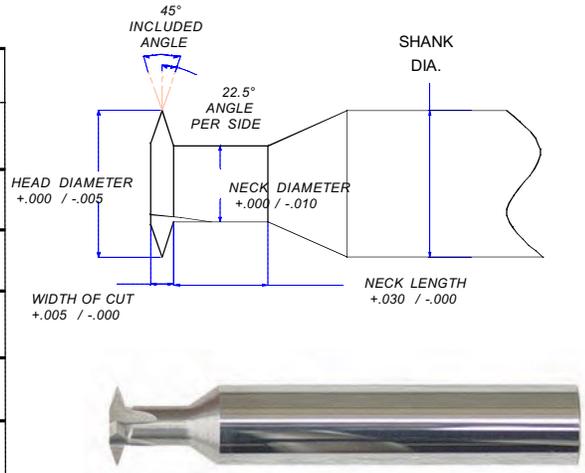


DOUBLE ANGLE

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"

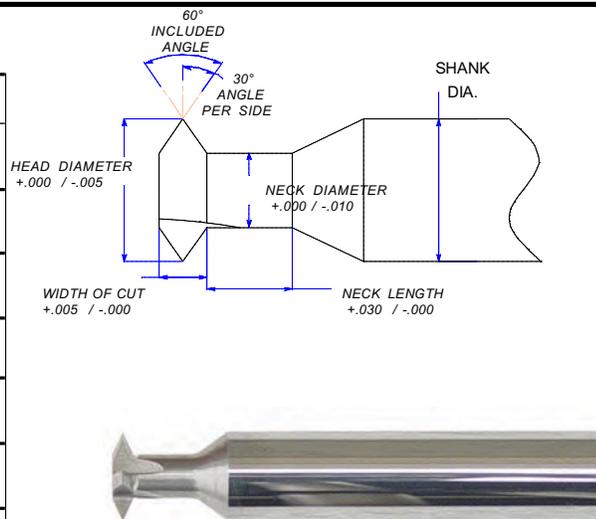
* CARBIDE HEAD WITH STEEL SHANK



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

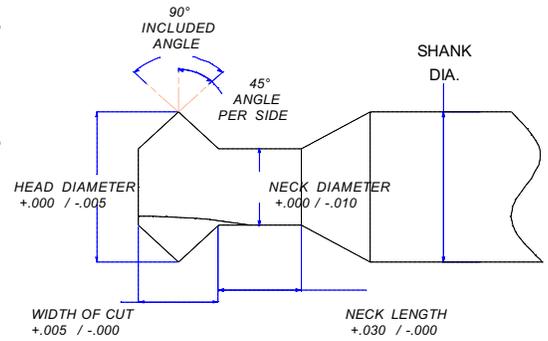
SERIES 92 *made from ITI CARBIDE*

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

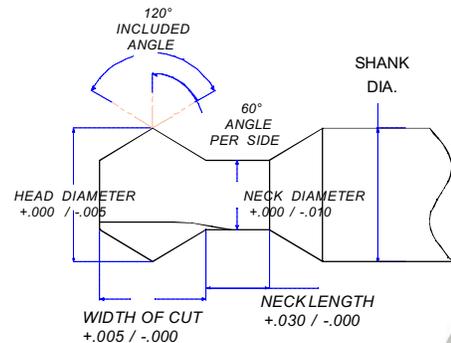


DOUBLE ANGLE

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.