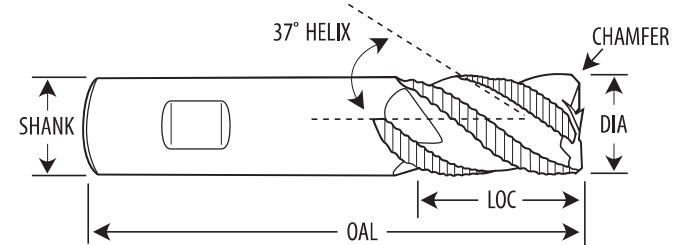
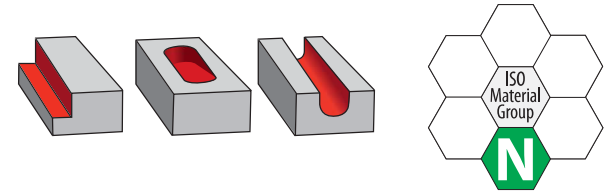
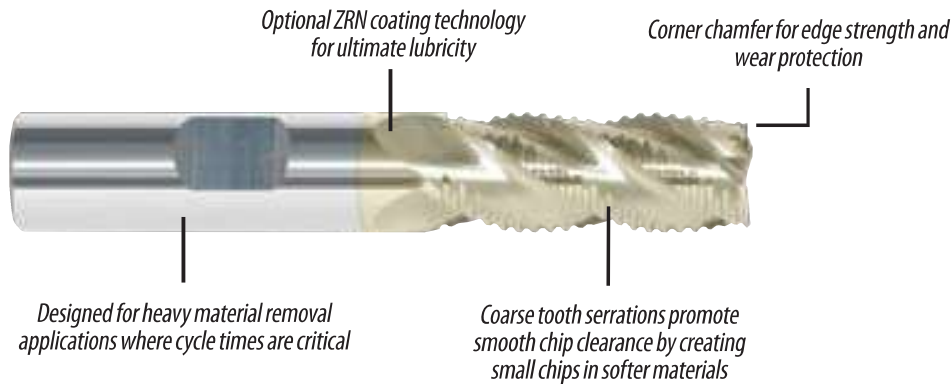
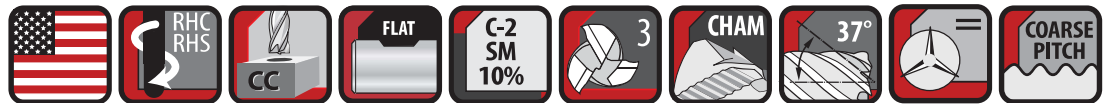


AGGRESSOR^C



DIA TOLERANCE: +0.000 / -0.002" SHANK TOLERANCE: +0.0000 / -0.0004"

DIA	DEC IN	FLUTES	LOC	SHANK	OAL	LENGTH	CHAMFER	BRIGHT	ZRN
3/16	0.1875	3	3/4	3/16	2	Regular	0.020	255-050187	255-050187D
1/4	0.2500	3	3/4	1/4	2-1/2	Regular	0.020	255-050250	255-050250D
5/16	0.3125	3	7/8	5/16	2-1/2	Regular	0.020	255-050312	255-050312D
3/8	0.3750	3	1	3/8	2-1/2	Regular	0.020	255-050375	255-050375D
1/2	0.5000	3	1-1/4	1/2	3	Regular	0.025	255-050500	255-050500D
5/8	0.6250	3	1-1/4	5/8	3-1/2	Regular	0.025	255-050625	255-050625D
3/4	0.7500	3	1-5/8	3/4	4	Regular	0.025	255-050750	255-050750D
1	1.0000	3	1-3/4	1	4	Regular	0.025	255-051000	255-051000D



Surface Feet Per Minute (SFM)
Radial Depth of Cut (RDOC)

Inches Per Tooth (IPT)

PROFILING	Workpiece Material Group	SFM based on RDOC				IPT* (BASELINE)						
		Cutting Diameter Engaged				Cutting Diameter						
		10%	20%	30%	50%	3/16 [†]	1/4 [†]	5/16	3/8	1/2	5/8	3/4
Non-Ferrous 	Aluminum /Aluminum Alloys < 10% Si	2000	1800	1200	900	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
	Aluminum /Aluminum Alloys > 10% Si	1500	1200	1000	800	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
	Brass	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
	Cu/Cu Alloys / Magnesium	1000	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
	Plastics	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015

***CHIP THINNING Adjustments**

RDOC	Increase IPT
50%	None
30%	2x
20%	3.1x
10%	3.8x

†1/4" AND SMALLER DIAMETERS: Use caution when Profiling more than 50% or Slotting more than 25%



Surface Feet Per Minute (SFM)
Radial Depth of Cut (RDOC)

Inches Per Tooth (IPT)

SLOTTING	Workpiece Material Group	SFM			IPT							
		Cutting Diameter Engaged			Cutting Diameter							
		25%	50%	100%	3/16 [†]	1/4 [†]	5/16	3/8	1/2	5/8	3/4	1
Non-Ferrous 	Aluminum /Aluminum Alloys < 10% Si	2000	1500	1000	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
	Aluminum /Aluminum Alloys > 10% Si	1500	1200	800	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
	Brass	600	500	400	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
	Cu/Cu Alloys / Magnesium	500	400	300	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
	Plastics	1200	1000	800	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120