

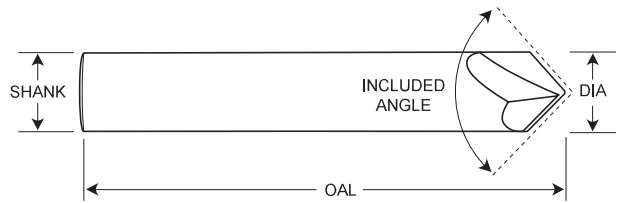
CHAMFER MILLS

Eliminates the hand deburring process

Dramatically increases beveling speeds




Multipurpose tool designed for various operations: chamfering, deburring & countersinking



DIAMETER TOLERANCE: +0.0000 / -0.0005" SHANK TOLERANCE: +0.0000 / -0.0005" INCLUDE ANGLE ± 1.0°

SINGLE END


FLUTES	DIA	Shank	OAL	Included Angle					
				60°		82°		90°	
				Bright	AlTiN	Bright	AlTiN	Bright	AlTiN
1/8	0.1250	1/8	1-1/2	209-062125	209-062125B	209-082125	209-082125B	209-092125	209-092125B
3/16	0.1875	3/16	2	209-062187	209-062187B	209-082187	209-082187B	209-092187	209-092187B
 2	1/4	1/4	2-1/2	209-062250	209-062250B	209-082250	209-082250B	209-092250	209-092250B
	3/8	0.3750	3/8	2-1/2	209-062375	209-062375B	209-082375	209-082375B	209-092375
1/2	0.5000	1/2	3	209-062500	209-062500B	209-082500	209-082500B	209-092500	209-092500B
3/4	0.7500	3/4	3	209-062750	209-062750B	209-082750	209-082750B	209-092750	209-092750B



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CHAMFERMILLS - SINGLE END CONTINUED

FLUTES	DIA	Shank	OAL	Included Angle						
				60°		82°		90°		
				Bright	AlTiN	Bright	AlTiN	Bright	AlTiN	
	1/8	0.1250	1/8	1-1/2	209-064125	209-064125B	209-084125	209-084125B	209-094125	209-094125B
	3/16	0.1875	3/16	2	209-064187	209-064187B	209-084187	209-084187B	209-094187	209-094187B
	1/4	0.2500	1/4	2-1/2	209-064250	209-064250B	209-084250	209-084250B	209-094250	209-094250B
	3/8	0.3750	3/8	2-1/2	209-064375	209-064375B	209-084375	209-084375B	209-094375	209-094375B
	1/2	0.5000	1/2	3	209-064500	209-064500B	209-084500	209-084500B	209-094500	209-094500B
	3/4	0.7500	3/4	3	209-064750	209-064750B	209-084750	209-084750B	209-094750	209-094750B

FLUTES	DIA	Dec In	Shank	OAL	Included Angle		
					60°	90°	AlTiN
					Bright	Bright	AlTiN
	1/8	0.1250	1/8	1-1/2	209-262125	209-292125	209-292125B
	3/16	0.1875	3/16	2	209-262187	209-292187	209-292187B
	1/4	0.2500	1/4	2-1/2	209-262250	209-292250	209-292250B
	3/8	0.3750	3/8	2-1/2	209-262375	209-292375	209-292375B
	1/2	0.5000	1/2	3	209-262500	209-292500	209-292500B
	1/8	0.1250	1/8	1-1/2	—	209-694125	209-694125B
	3/16	0.1875	3/16	2	—	209-694187	209-694187B
	1/4	0.2500	1/4	2-1/2	—	209-694250	209-694250B
	3/8	0.3750	3/8	2-1/2	—	209-694375	209-694375B
	1/2	0.5000	1/2	3	—	209-694500	209-694500B

CHAMFERING RECOMMENDATIONS

Workpiece Material Group	Surface Feet Per Minute (SFM)	Inches Per Tooth (IPT)			
		(IPT) Chamfer Mill Diameter			
		1/8 – 3/16"	1/4 – 5/16"	3/8 – 1/2"	
Steels Free Machining & Low/Med/High Carbon, Tool & Die Steels 	25 – 175	0.0005	0.0010	0.0020	
Stainless Steel Easy/Moderate/Difficult to Machine 	50 – 150	0.0003	0.0007	0.0015	
Super Alloys High Temp, Nimonic, Inconel, Monel, Hastelloy, Titanium 	25 – 125	0.0005	0.0010	0.0015	
Hardened Materials 	25 – 100	0.0005	0.0010	0.0015	
Cast-Iron Gray, Ductile & Malleable 	50 – 250	0.0007	0.0014	0.0021	
Non-Ferrous	Aluminum	500 – 1000	0.0015	0.0025	0.0035
	Composites	100 – 200	0.0030	0.0060	0.0090
	Copper	400 – 800	0.0010	0.0020	0.0030
	Magnesium	400 – 700	0.0015	0.0025	0.0035
	Plastics	150 – 300	0.0020	0.0030	0.0040