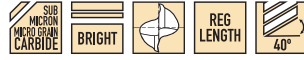


2-Flute For Aluminum

This carbide aluminum end mill has been designed specially for milling aluminum and all non-ferrous materials. The unique geometry permits much higher speed and feed rates without loading. Spindle and feed rates can be increased by fifty percent for greater productivity with excellent piece/part finishes.



Speeds & Feeds > P. A19

Cutting Dia. (in.)	Shank Dia. (in.)	Flute Length (in.)	Overall Length (in.)	Code No.	Price \$
Inch					
1/4	1/4	3/4	2-1/2	101020	21.00
1/4	1/4	1-1/2	4	101022	37.92
5/16	5/16	13/16	2-1/2	101024	44.33
5/16	5/16	1-5/8	4	101026	49.46
3/8	3/8	1	2-1/2	101028	36.67
3/8	3/8	1-3/4	4	101030	54.80
1/2	1/2	1	3	101032	58.74
1/2	1/2	2	4	101034	80.18
5/8	5/8	1-1/4	3-1/2	101036	113.29
5/8	5/8	2-1/4	5	101038	165.26
3/4	3/4	1-1/2	4	101040	166.11
3/4	3/4	2-1/4	5	101042	263.27
1	1	2-1/4	5	101044	248.45
1	1	3	6	101046	447.59
Metric					
6	6	19	63	101390	22.03
6	6	38	102	101391	39.93
8	8	21	63	101392	30.92
10	10	25	70	101394	44.65
10	10	51	102	101395	69.82
12	12	51	102	101397	84.99
16	16	32	89	101398	118.94
16	16	57	127	101399	165.26
20	20	38	102	101400	221.75
20	20	57	127	101401	277.34
25	25	57	127	101402	257.61
25	25	76	152	101403	427.37

2-Flute Aluminum Speeds & Feeds

Side Milling

Slotting

Work Material		Aluminum		Aluminum	
Hardness					
Depth of Cut					
Mill Dia. (inch)	mm	V=660 SFM		V=660 SFM	
		Speed	Feed	Speed	Feed
		RPM	in/min	RPM	in/min
1/4	6	10000	60	10000	30
5/16	8	8000	64	8000	32
3/8	10	8000	80	8000	40
1/2	12	8000	96	8000	48
5/8	16	6000	84	6000	42
3/4	20	4000	64	4000	32
1	25	4000	64	4000	32

3-Flute Square End 40° Helix Carbide End Mills



Speeds & Feeds > P. A19

Cutting Dia. (in.)	Shank Dia. (in.)	Flute Length (in.)	Overall Length (in.)	Bright Finish Code No.	Price \$	TiCN Coated Code No.	Price \$
Inch							
1/32	1/8	3/32	1-1/2	153300	14.77	153350	18.17
3/64	1/8	1/8	1-1/2	153302	14.77	153352	18.17
1/16	1/8	3/16	1-1/2	153304	14.77	153354	18.17
3/32	1/8	3/8	1-1/2	153306	14.77	153356	18.17
1/8	1/8	1/2	1-1/2	153308	14.77	153358	18.17
9/64	3/16	9/16	2	153310	17.41	153360	21.41
5/32	3/16	9/16	2	153312	17.41	153362	21.41
11/64	3/16	9/16	2	153314	17.41	153364	21.41
3/16	3/16	5/8	2	153316	17.41	153366	21.41
13/64	1/4	5/8	2-1/2	153318	21.00	153368	25.83
7/32	1/4	5/8	2-1/2	153320	21.00	153370	25.83
15/64	1/4	3/4	2-1/2	153322	21.00	153372	25.83
1/4	1/4	3/4	2-1/2	153324	21.00	153374	25.83
17/64	5/16	3/4	2-1/2	153326	29.46	153376	36.23
5/16	5/16	13/16	2-1/2	153328	29.46	153378	36.23
5/16	5/16	1-5/8	4	153330	49.46	153380	60.84
3/8	3/8	1	2-1/2	153332	36.67	153382	45.10
3/8	3/8	1-1/8	3	153334	54.80	153384	67.39
1/2	1/2	1	3	153336	58.74	153386	72.25
1/2	1/2	2	4	153338	80.18	153388	98.62
5/8	5/8	1-1/4	3-1/2	153340	113.29	153390	139.34
5/8	5/8	2-1/4	5	153342	165.26	153392	203.28
3/4	3/4	1-1/2	4	153344	166.11	153394	204.31

3-Flute Aluminum Speeds & Feeds

Material	Chip Load Per Tooth				
	SFM	1/8"	1/4"	1/2"	1"
Aluminum Alloys	600/1200	0.0010	0.0020	0.0040	0.0080

RPM = 3.82 x sfm ÷ dia SFM = rpm x 0.262 ÷ dia
IPM = chip load x No. of teeth x rpm

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Tolerances - Inch			Tolerances - Metric		
Size	Diameter	Shank Diameter	Size	Diameter	Shank Diameter
3/32 thru 1"	+0.000"-0.002"	+0.0000"-0.0005"	1mm-25mm	+0.000mm-0.051mm	+0.000mm-0.013mm
Steel		Stainless Steel	Cast Iron/Hardened		Aluminum