

GENERAL PURPOSE

Solid Carbide Chamfer Mills For Ferrous And Non-Ferrous Materials



INTRO

MILLING

SPECIALTY

HOLEMAKING

THREADING

INSERTS



FEATURES/DESCRIPTION	APPLICATION	FEATURES								
<p>Chamfer Mills</p> <ul style="list-style-type: none"> • 2FL & 4FL chamfer mills • Sub-micron grade carbide substrate for wear resistance • Optimizes drilling, spotting, and countersinking processes • Multiple included angles • Diameter Tol.: +0/-0.0005" • Shank Tol.: +0/-0.0005" • Angle: +/- 1.0° 		<table border="1"> <tr> <td>CARBIDE</td> <td>CHF</td> </tr> <tr> <td>2FL</td> <td>4FL</td> </tr> <tr> <td>P201</td> <td>Bright</td> </tr> <tr> <td>AITiN</td> <td></td> </tr> </table>	CARBIDE	CHF	2FL	4FL	P201	Bright	AITiN	
CARBIDE	CHF									
2FL	4FL									
P201	Bright									
AITiN										

STEEL			STAINLESS		CAST IRON		NON-FERROUS		HBSA		HARDENED STEEL	
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2
○	○	○			○	○	○	○			○	

● Best ○ Good

Series 209 2 and 4 FL | 60°, 82°, 90°

Diameter(D ₁)	OAL(L)	Shank(D)	Flutes	Incl. Angle	Bright	AITiN
1/8	1-1/2	1/8	2	60°	209-062125	209-062125B
1/8	1-1/2	1/8	2	82°	209-082125	209-082125B
1/8	1-1/2	1/8	2	90°	209-092125	209-092125B
3/16	2	3/16	2	60°	209-062187	209-062187B
3/16	2	3/16	2	82°	209-082187	209-082187B
3/16	2	3/16	2	90°	209-092187	209-092187B
1/4	2-1/2	1/4	2	60°	209-062250	209-062250B
1/4	2-1/2	1/4	2	82°	209-082250	209-082250B
1/4	2-1/2	1/4	2	90°	209-092250	209-092250B
3/8	2-1/2	3/8	2	60°	209-062375	209-062375B
3/8	2-1/2	3/8	2	82°	209-082375	209-082375B
3/8	2-1/2	3/8	2	90°	209-092375	209-092375B
1/2	3	1/2	2	60°	209-062500	209-062500B
1/2	3	1/2	2	82°	209-082500	209-082500B
1/2	3	1/2	2	90°	209-092500	209-092500B
3/4	3	3/4	2	60°	209-062750	209-062750B
3/4	3	3/4	2	82°	209-082750	209-082750B
3/4	3	3/4	2	90°	209-092750	209-092750B
1/8	1-1/2	1/8	4	60°	209-064125	209-064125B
1/8	1-1/2	1/8	4	82°	209-084125	209-084125B
1/8	1-1/2	1/8	4	90°	209-094125	209-094125B
3/16	2	3/16	4	60°	209-064187	209-064187B
3/16	2	3/16	4	82°	209-084187	209-084187B
3/16	2	3/16	4	90°	209-094187	209-094187B
1/4	2-1/2	1/4	4	60°	209-064250	209-064250B
1/4	2-1/2	1/4	4	82°	209-084250	209-084250B
1/4	2-1/2	1/4	4	90°	209-094250	209-094250B
3/8	2-1/2	3/8	4	60°	209-064375	209-064375B
3/8	2-1/2	3/8	4	82°	209-084375	209-084375B
3/8	2-1/2	3/8	4	90°	209-094375	209-094375B
1/2	3	1/2	4	60°	209-064500	209-064500B
1/2	3	1/2	4	82°	209-084500	209-084500B
1/2	3	1/2	4	90°	209-094500	209-094500B
3/4	3	3/4	4	60°	209-064750	209-064750B
3/4	3	3/4	4	82°	209-084750	209-084750B
3/4	3	3/4	4	90°	209-094750	209-094750B

*bold numbers are EDPs for ordering

Series 209, 209D

GP | Chamfer Mills | 2 - 4 FL | 60° - 90°

Material		SFM	1/4 – 5/16"	3/8 – 1/2"
P	Free Machining & Low/Med/High Carbon, Tool & Die Steels	25-175	0.0010	0.0020
M	Easy/Moderate/Difficult to Machine	50-150	0.0007	0.0015
S	High Temp, Nimonics, Inconel, Monel, Hastelloy, Titanium	25-125	0.0010	0.0015
H	55 Rc	25-100	0.0010	0.0015
K	Gray, Ductile & Malleable	50-250	0.0014	0.0021
N	Aluminum	50-1000	0.0025	0.0035
	Composites	100-200	0.0060	0.0090
	Copper	400-800	0.0020	0.0030
	Magnesium	400-700	0.0025	0.0035
	Plastics	150-300	0.0030	0.0040

INTRO

MILLING

SPECIALTY

HOLEMAKING

THREADING

INSERTS