



Helical *mill*

Let Helical Impress You

Trusted by the
World's Leading
Aerospace Manufacturers

NEW End Mills for Aluminum
Chipbreaker Coolant Through

10,000+ High Performance Carbide End Mills



Exceptional, Fully Stocked Tooling

Helical has earned and maintained a reputation as an industry leading manufacturer of high performance carbide end mills. We consistently outperform other manufacturers by offering **extremely high quality, fully stocked cutting tools** at competitive prices, ensuring that you enjoy the best results while maximizing your shop's profitability.

Unbeatable Custom Tool Experience

Helical's Custom-Engineered Solutions Program is designed to give you the best possible custom tool experience from beginning-to-end. We set ourselves apart with a team of engineers eager to understand every aspect of your project. Within 48 hours, we will return a quote with **expertly crafted geometries designed to produce extraordinary results** in your specific application. We'll then work with you to ensure proper tool setup and running parameters that deliver maximized performance.

Outstanding Technical Expertise

Our team of experienced engineers live and breathe cutting tools and are enthusiastic about maximizing your shop floor productivity. Whether it be in your shop or over the phone, we have **knowledgeable technical field representatives and in-house tool experts** available to help you with tool selection, tool design, application support, and troubleshooting.

HARVEY PERFORMANCE COMPANY



Think Harvey Tool First

More than 28,000 miniature
and specialty end mills.
Ship today, in your
machine tomorrow.



Let Helical Impress You

Material-optimized high
performance carbide
end mills. Run faster, push
harder, machine smarter.



Make More with Micro 100

Exceptional quality turning
tools designed for durability
and performance in a range of
difficult-to-machine materials.



Trust in Titan USA

Broad assortment
of quality, fully stocked
cutting tools
at exceptional value.



Innovative Tools for Innovative Materials

The industry's most
innovative and advanced
composite and honeycomb
core cutting tools.



Victory Starts with Valor Holeshaping

High performance drills &
complementary tooling
solutions that revolutionize
CNC holeshaping.



Let Helical Impress You

At Helical, it is our goal to design and manufacture industry-leading products at competitive prices so you don't have to settle for ordinary cutting tools.

Helical end mills are built to last and **excel**

at aggressive running parameters, meaning you will experience greatly reduced cycle times, heightened productivity, and superior part finish. This translates directly to savings and efficiencies in your shop, and positively affects your bottom line.

We offer **more than 10,000 fully stocked tools** optimized for a variety of operations and designed for the unique challenges of non-ferrous and ferrous material groups. If you can't find what you're looking for, consider our custom-engineered solutions program (details on page 327).

Our Tools Deliver

- + Increased Material Removal Rates
- + Superior Part Finish
- + Extended Tool Life
- + Improved Bottom Line

Send Your Shopping Cart Directly to Your Distributor

Did you know that you can place a Helical Solutions order directly to your distributor from our website? After creating your **Helicaltool.com** account, you're able to build and send "shopping carts" directly to your participating distributor to order.



-  Shopping Cart
-  MAP Connection
-  Check Stock
-  Table Filtering
-  Build a Tool
-  Smart-Search

11 End Mills for Aluminum Alloys & Non-Ferrous Materials



84 End Mills for Steels, Tool Steels & Cast Iron



186 End Mills for Stainless Steels & High Temp Alloys



252 End Mills for Nickel Alloys



259 End Mills for Titanium & Titanium Alloys



297 High Feed End Mills



312 Specialty Profiles



END MILLS FOR ALUMINUM

Aluminum Alloys & Non-Ferrous Materials



ROUGHERS

					PG
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2 FLUTE

					PG
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H45AL-RN-2	2 Flute	Ball	45° Helix - Reduced Neck		33

3 FLUTE

					PG
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H40ALVC-3	3 Flute	Corner Radius	40° Helix - Variable Pitch - Coolant Through	New!	59
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H45AL-RN-3	3 Flute	Square	45° Helix - Reduced Neck	New Item!	74

5 FLUTE

					PG
HVAL-5	5 Flute	Square	Variable Pitch - HEM	New!	76
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FINISHERS

					PG
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HMAF-AL-4	4 Flute	Taper	Multi-Axis Finisher	New Item!	81
HMAF-AL-4	4 Flute	Oval	Multi-Axis Finisher	New Item!	83



END MILLS FOR STEELS

Steels, Tool Steels, & Cast Iron

ROUGHERS

PG

HSVR-C-4	4 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch	84
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3 FLUTE

PG

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HSV-3	3 Flute	Corner Radius	Variable Pitch	105
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HST-3	3 Flute	Corner Radius		108
HST-RN-3	3 Flute	Ball	Reduced Neck	109
HST-RN-3	3 Flute	Corner Radius	Reduced Neck	110

4 FLUTE

PG

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5 FLUTE

PG

HEV-5	5 Flute	Square	Variable Pitch New Item!	133
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END MILLS FOR STEELS Steels, Tool Steels, & Cast Iron (cont.)

6 FLUTE

PG

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HEV-6	6 Flute	Corner Radius	Variable Pitch	New Item!	157
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HEV-RN-6	6 Flute	Square	Variable Pitch - Reduced Neck	New Item!	163
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7 FLUTE

PG

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MHEV-7	7 Flute	Corner Radius	Variable Pitch	Metric	174
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FINISHERS

PG

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END MILLS FOR STAINLESS STEELS & HIGH TEMP ALLOYS



ROUGHERS

PG

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HEV-C-6	6 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch	New Item!	190
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HEV-C-7	7 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch	New Item!	194
HXVR	Multi-Flute	Corner Radius	Knuckle Rougher - Variable Pitch	New Item!	196

4 FLUTE

PG

HSV-4 / HSM-4	4 Flute	Square	Variable Pitch	New Item!	197
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END MILLS FOR STAINLESS STEELS & HIGH TEMP ALLOYS (cont.)

5 FLUTE

PG

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HEV-5 / HSM-5	5 Flute	Corner Radius	Variable Pitch New Item!	214
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6 FLUTE

PG

HEV-6	6 Flute	Square	Variable Pitch	223
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HEV-6	6 Flute	Corner Radius	Variable Pitch New Item!	228
HEVC-6	6 Flute	Corner Radius	Variable Pitch - Coolant Through	232
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HEV-RN-6	6 Flute	Ball	Variable Pitch - Reduced Neck New Item!	234
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7 FLUTE

PG

HEV-7	7 Flute	Square	Variable Pitch New Item!	236
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FINISHERS

PG

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HMAF-FE-4	4 Flute	Oval	Multi-Axis Finisher New Item!	246
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HMAF-FE-6	6 Flute	Oval	Multi-Axis Finisher New Item!	249
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END MILLS FOR NICKEL ALLOYS

6 FLUTE

PG

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8 FLUTE

PG

HVNI-8	8 Flute	Corner Radius	Variable Pitch - HEM	256

END MILLS FOR TITANIUM

Titanium & Titanium Alloys



ROUGHERS

				PG
HEV-C-5	5 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch New Item!	259
HVTI-C-6	6 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch - HEM	262
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HEV-C-6	6 Flute	Corner Radius	Chipbreaker Rougher - Variable Pitch New Item!	265
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5 FLUTE

				PG
HEV-5	5 Flute	Corner Radius	Variable Pitch New Item!	269
MHEV-5	5 Flute	Corner Radius	Variable Pitch Metric	276

6 FLUTE

				PG
HVTI-6	6 Flute	Square	Variable Pitch - HEM	277
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MHEV-6	6 Flute	Corner Radius	Variable Pitch Metric	291

7 FLUTE

				PG
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FINISHERS

				PG
HXF	Multi-Flute	Corner Radius	Finisher New Item!	296

CAM Tool Libraries

Harvey Performance Company works closely with industry-leading CAM software companies to optimize Helical Solutions and Harvey Tool product libraries for their platforms.



Download Now: harveyperformance.com/tool-libraries



HIGH FEED END MILLS

ALUMINUM

PG

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FOR STEELS UP TO 45 RC

PG

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HPVC	Steels Up to 45 Rc - Variable Pitch - Coolant Through - Reduced Neck		303
MHPVC	Steels Up to 45 Rc - Variable Pitch - Coolant Through - Reduced Neck	Metric	304

COMBINATION FEED & HEM

PG

HEVF-C-4	4 Flute	Chipbreaker Rougher - Variable Pitch	306
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SPECIALTY PROFILES

TAPERED END MILLS

PG

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HTPR-5	5 Flute	Square	Variable Pitch	314

CHAMFER MILLS

PG

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COMBINATION CHAMFER / END MILLS

PG

HCCM	4 Flute	Combo	Combination Chamfer / End Mill - High Performance	322

CORNER ROUNDING END MILLS

PG

HPCR	3 & 5 Flute	Corner Rounding End Mills - Helical Flute - High Performance	New Item!	324

TECHNICAL INFORMATION

OUR COATINGS

New Coating!

	Dplus	Nplus	Zplus	Tplus	Aplus
Application Benefits	Dplus delivers unmatched tool life in non-ferrous applications. Featuring a tetrahedral amorphous carbon (taC) bond structure, this coating offers an extremely low coefficient of friction and exceptionally high hardness, allowing it to resist abrasion while maintaining a sharp cutting edge.	Nplus is specially engineered for optimal performance and extended tool life in aluminum alloys and non-ferrous materials, especially high-silicon aluminums and copper alloys. Its high hardness and excellent edge retention provide improved wear resistance.	Zplus provides higher hardness, lubricity, and abrasion resistance. While it's specifically engineered for aluminum applications, it is also an optimal coating for other non-ferrous materials. Zplus holds up well in abrasive materials and reduces the chance of built-up edge in softer, gummy alloys.	Tplus is an ideal choice for increased wear resistance and edge strength in stainless steels, high temp alloys, and hardened steels up to 65Rc. Also an excellent choice for increased wear resistance in a wide variety of ferrous materials.	Aplus allows for high temperature resistance, decreased wear, and improved tool life. Proven to work in high speed machining and dry conditions, these benefits are seen in a wide range of ferrous materials and titanium alloys.
Materials	Aluminum Alloys, Composites, Graphite, and Other Non-Ferrous Alloys	Wrought Aluminum, Cast Aluminum, Graphite, and Other Non-Ferrous Alloys	Wrought Aluminum, Cast Aluminum, Graphite, and Other Non-Ferrous Alloys	Stainless Steels, High Temp Alloys, Hardened Steels	Low Alloy Steels, Medium Alloy Steels, Tool Steels, Cast Iron, and Titanium
Coating Appearance	charcoal/slight iridescent 	light grey/silver 	light gold / champagne 	copper 	black / grey 
Max. Usage Temp.	842° F	2,012° F	1,110° F	2,192° F	2,012° F
Microhardness (HV 0.05)	5000+ (50 GPa)	4079 (40 GPa)	2243 (22 GPa)	4487 (44 GPa)	4079 (40 GPa)
Coefficient of Friction	<0.10	0.45	0.40	0.35	0.45

Experience the Benefits of Helical's New Dplus Coating!

Dplus is our newest innovation for superior tool life in non-ferrous alloys. Its tetrahedral amorphous carbon (taC) bond structure represents an advanced leap, delivering remarkable enhancements in tool life compared to conventional DLC coatings.

Featuring an exceptionally low coefficient of friction and extremely high hardness, this coating maintains a sharp cutting edge, while still resisting abrasion, making it outperformed only by CVD diamond itself. Experience outstanding tool life in materials ranging from aerospace aluminum all the way to graphite or abrasive composites, with this new premium coating.

In The Loupe

ANALYTICAL



SCAN TO READ

H35ALV-C-3



New Coating!

3 FLUTE - CORNER RADIUS

35° Helix - Variable Pitch - Chipbreaker Rougher

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Engineered with optimized variable pitch and chipbreaker geometry for reduced harmonics and elevated material removal rates
- Unique tool design requires less torque and horsepower
- Unique "3 teeth-to-center" end geometry for ramping applications
- h6 shank tolerance for high precision tool holders
- Dplus coating for superior tool life and edge retention in abrasive non-ferrous materials
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .001$ in	LOC L1 $\pm .001$ in	OAL L2 $\pm .001$ in	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
new new new 1/8	1/8	.010	1/4	1-1/2	3	82101	82102	87770	H35ALV-C-020-30125-R.010
	1/8	.010	3/8	2	3	82103	82104	87771	H35ALV-C-030-30125-R.010
	1/8	.010	1/2	2-1/2	3	82105	82106	87772	H35ALV-C-040-30125-R.010
	1/8	.010	5/8	2-1/2	3	84792	84793		H35ALV-C-050-30125-R.010
	1/8	.010	3/4	2-1/2	3	84794	84795		H35ALV-C-080-30125-R.010
	1/8	.030	1/4	1-1/2	3	84796	84797		H35ALV-C-020-30125-R.030
	1/8	.030	3/8	2	3	84798	84799		H35ALV-C-030-30125-R.030
	1/8	.030	1/2	2-1/2	3	84800	84801		H35ALV-C-040-30125-R.030
new new new new 3/16	3/16	.010	5/16	2	3	82107	82108	87773	H35ALV-C-015-30187-R.010
	3/16	.010	7/16	2	3	84802	84803	87774	H35ALV-C-023-30187-R.010
	3/16	.010	9/16	2-1/2	3	82109	82110	87775	H35ALV-C-030-30187-R.010
	3/16	.010	3/4	2-1/2	3	82111	82112	87776	H35ALV-C-040-30187-R.010
	3/16	.010	1	2-1/2	3	84804	84805		H35ALV-C-053-30187-R.010
	3/16	.010	1-3/16	3	3	84806	84807		H35ALV-C-063-30187-R.010
	3/16	.030	5/16	2	3	84808	84809		H35ALV-C-015-30187-R.030
	3/16	.030	9/16	2-1/2	3	84810	84811		H35ALV-C-030-30187-R.030
	3/16	.030	3/4	2-1/2	3	84812	84813		H35ALV-C-040-30187-R.030
new new new new 1/4	1/4	.010	1/2	2-1/2	3	81991	81992	87777	H35ALV-C-025-30250-R.010
	1/4	.010	3/4	2-1/2	3	81993	81994	87778	H35ALV-C-030-30250-R.010
	1/4	.010	1	3	3	81995	81996	87779	H35ALV-C-040-30250-R.010
	1/4	.010	1-1/4	3	3	82113	82114	87780	H35ALV-C-050-30250-R.010
	1/4	.015	1/2	2-1/2	3	82115	82116		H35ALV-C-025-30250-R.015
	1/4	.015	3/4	2-1/2	3	82117	82118		H35ALV-C-030-30250-R.015
	1/4	.020	1/2	2-1/2	3	82119	82120		H35ALV-C-025-30250-R.020
	1/4	.020	3/4	2-1/2	3	82121	82122		H35ALV-C-030-30250-R.020
	1/4	.030	1/2	2-1/2	3	81997	81998	87781	H35ALV-C-025-30250-R.030
	1/4	.030	3/4	2-1/2	3	81999	82000	87782	H35ALV-C-030-30250-R.030
	1/4	.030	1	3	3	82001	82002	87783	H35ALV-C-040-30250-R.030
	1/4	.030	1-1/4	3	3	84814	84815	87784	H35ALV-C-050-30250-R.030

*.0003 max TIR

continued on next page



Speeds & Feeds on Page 16

3 FLUTE - CORNER RADIUS

New Coating!



H35ALV-C-3

35° Helix - Variable Pitch - Chipbreaker Rougher (cont.)

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R ^{+ .002"} _{-.001"}	LOC L ₁ ^{+ .002"} _{-.001"}	OAL L ₂ ^{+ .002"} _{-.001"}	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
5/16	5/16	.010	7/16	2	3	£4816	£4817		H35ALV-C-014-38312-R-010	
	5/16	.010	3/4	2-1/2	3	£4818	£4819		H35ALV-C-024-38312-R-010	
	5/16	.010	1	3	3	£4820	£4821		H35ALV-C-032-38312-R-010	
	5/16	.030	7/16	2	3	£4822	£4823		H35ALV-C-014-38312-R-030	
	5/16	.030	3/4	2-1/2	3	£4824	£4825		H35ALV-C-024-38312-R-030	
	5/16	.030	1	3	3	£4826	£4827		H35ALV-C-032-38312-R-030	
3/8	3/8	.010	1/2	2	3	£2123	£2124	£7785	H35ALV-C-019-38375-R-010	new
	3/8	.010	1	3	3	£2125	£2126	£7786	H35ALV-C-026-38375-R-010	new
	3/8	.010	1-1/4	3-1/2	3	£2127	£2128	£7787	H35ALV-C-039-38375-R-010	new
	3/8	.010	1-1/2	4	3	£4828	£4829		H35ALV-C-040-38375-R-010	
	3/8	.020	1/2	2	3	£2129	£2130	£7788	H35ALV-C-019-38375-R-020	new
	3/8	.020	1	3	3	£2131	£2132	£7789	H35ALV-C-026-38375-R-020	new
	3/8	.020	1-1/4	3-1/2	3	£2133	£2134	£7790	H35ALV-C-039-38375-R-020	new
	3/8	.030	1/2	2	3	£2003	£2004	£7791	H35ALV-C-019-38375-R-030	new
	3/8	.030	1	3	3	£2005	£2006	£7792	H35ALV-C-026-38375-R-030	new
	3/8	.030	1-1/4	3-1/2	3	£2007	£2008	£7793	H35ALV-C-039-38375-R-030	new
	3/8	.030	1-1/2	4	3	£4830	£4831		H35ALV-C-040-38375-R-030	
	3/8	.060	1/2	2	3	£2009	£2010		H35ALV-C-019-38375-R-060	
	3/8	.060	1	3	3	£2011	£2012		H35ALV-C-026-38375-R-060	
	3/8	.060	1-1/4	3-1/2	3	£2013	£2014		H35ALV-C-039-38375-R-060	
1/2	1/2	.010	5/8	2-1/2	3	£2135	£2136	£7794	H35ALV-C-012-38500-R-010	new
	1/2	.010	1	3	3	£2137	£2138	£7795	H35ALV-C-020-38500-R-010	new
	1/2	.010	1-1/4	3	3	£2139	£2140	£7796	H35ALV-C-025-38500-R-010	new
	1/2	.010	1-5/8	4	3	£2141	£2142	£7797	H35ALV-C-032-38500-R-010	new
	1/2	.020	5/8	2-1/2	3	£2143	£2144		H35ALV-C-012-38500-R-020	
	1/2	.020	1	3	3	£2145	£2146		H35ALV-C-020-38500-R-020	
	1/2	.020	1-1/4	3	3	£2147	£2148		H35ALV-C-025-38500-R-020	
	1/2	.020	1-5/8	4	3	£2149	£2150		H35ALV-C-032-38500-R-020	
	1/2	.030	5/8	2-1/2	3	£2015	£2016	£7798	H35ALV-C-012-38500-R-030	new
	1/2	.030	1	3	3	£2017	£2018	£7799	H35ALV-C-020-38500-R-030	new
	1/2	.030	1-1/4	3	3	£2019	£2020	£7800	H35ALV-C-025-38500-R-030	new
	1/2	.030	1-5/8	4	3	£2021	£2022	£7801	H35ALV-C-032-38500-R-030	new
	1/2	.030	2	4	3	£2023	£2024	£7802	H35ALV-C-040-38500-R-030	new
	1/2	.030	2-1/2	5	3	£2151	£2152		H35ALV-C-050-38500-R-030	
	1/2	.030	3-1/8	6	3	£4832	£4833		H35ALV-C-062-38500-R-030	
	1/2	.060	5/8	2-1/2	3	£2025	£2026	£7803	H35ALV-C-012-38500-R-060	new
	1/2	.060	1	3	3	£2027	£2028	£7804	H35ALV-C-020-38500-R-060	new
	1/2	.060	1-1/4	3	3	£2029	£2030	£7805	H35ALV-C-025-38500-R-060	new
	1/2	.060	1-5/8	4	3	£2031	£2032	£7806	H35ALV-C-032-38500-R-060	new
	1/2	.060	2	4	3	£2033	£2034	£7807	H35ALV-C-040-38500-R-060	new
	1/2	.125	5/8	2-1/2	3	£4834	£4835		H35ALV-C-012-38500-R-125	
	1/2	.125	1	3	3	£4836	£4837		H35ALV-C-020-38500-R-125	
	1/2	.125	1-1/4	3	3	£4838	£4839		H35ALV-C-025-38500-R-125	
	1/2	.125	1-5/8	4	3	£4840	£4841		H35ALV-C-032-38500-R-125	

*.0003 max TIR

continued on next page

H35ALV-C-3



New Coating!

3 FLUTE - CORNER RADIUS

35° Helix - Variable Pitch - Chipbreaker Rougher (cont.)

continued from previous page

Cutter Dia.* D ₁ (H6)	Shank Dia. D ₂ (H6)	Corner Radius R ⁺ _{0.02} ⁻ R ⁺ _{0.02} ⁻	LDC L ⁺ _{0.02} ⁻ L ⁺ _{0.02} ⁻	OAL L ⁺ _{0.02} ⁻ L ⁺ _{0.02} ⁻	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
5/8	5/8	.030	3/4	3	3	82035	82036		H35ALV-C-012-30625-R.030
	5/8	.030	1-5/8	3-1/2	3	82037	82038		H35ALV-C-026-30625-R.030
	5/8	.060	3/4	3	3	82039	82040		H35ALV-C-012-30625-R.060
	5/8	.060	1-5/8	3-1/2	3	82041	82042		H35ALV-C-026-30625-R.060
3/4	3/4	.010	1-5/8	4	3	82153	82154		H35ALV-C-021-30750-R.010
	3/4	.010	2-1/4	5	3	82155	82156		H35ALV-C-030-30750-R.010
	3/4	.030	1-5/8	4	3	82043	82044	87509	H35ALV-C-021-30750-R.030
	3/4	.030	2-1/4	5	3	82045	82046	87509	H35ALV-C-030-30750-R.030
	3/4	.030	3-1/4	6	3	82047	82048	87510	H35ALV-C-040-30750-R.030
	3/4	.060	1-5/8	4	3	82049	82050	87511	H35ALV-C-021-30750-R.060
	3/4	.060	2-1/4	5	3	82051	82052	87512	H35ALV-C-030-30750-R.060
	3/4	.060	3-1/4	6	3	82053	82054	87513	H35ALV-C-040-30750-R.060
	3/4	.125	1-5/8	4	3	82157	82158		H35ALV-C-021-30750-R.125
	3/4	.125	2-1/4	5	3	82159	82160		H35ALV-C-030-30750-R.125
1	1	.030	2	5	3	82055	82056		H35ALV-C-020-31000-R.030
	1	.030	3-1/4	6	3	84842	84843		H35ALV-C-032-31000-R.030
	1	.060	2	5	3	82057	82058		H35ALV-C-020-31000-R.060
	1	.060	3-1/4	6	3	84844	84845		H35ALV-C-032-31000-R.060
	1	.125	2	5	3	84846	84847		H35ALV-C-020-31000-R.125
	1	.250	2	5	3	84848	84849		H35ALV-C-020-31000-R.250

*.0003 max TIR

unsharp.com



SKU: 82164
Coating: Zplus
Cutter Dia: 3/4"
Length of Cut: 5/8"
Radius: .030"
Machine RPM: 3-3150

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3 FLUTE - CORNER RADIUS

New!



H35ALVC-C-3

35° Helix - Variable Pitch - Chipbreaker Rougher - Coolant Through

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Unique tool design reduces tool pressure, requiring less torque and horsepower
- Excellent performance in High Efficiency Milling (HEM)
- Engineered with variable pitch and chipbreaker geometry for reduced harmonics and elevated material removal rates
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Unique "3 teeth-to-center" end geometry for ramping applications
- H8 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 (in)	Shank Diameter D2 (in)	Corner Radius R $\pm .003$ $\pm .002$	Length of Cut L2 $\pm .003$ $\pm .002$	Overall Length L1 $\pm .003$ $\pm .002$	Flutes	Uncoated	Nplus Coated	Tool Description	
1/4	1/4	.010	3/8	2	3	88055	88056	H35ALVC-C-015-30250-R.010	new
	1/4	.010	1/2	2-1/2	3	88059	88060	H35ALVC-C-020-30250-R.010	new
	1/4	.030	3/8	2	3	88057	88058	H35ALVC-C-015-30250-R.030	new
	1/4	.030	1/2	2-1/2	3	88061	88062	H35ALVC-C-020-30250-R.030	new
3/8	3/8	.010	1/2	2	3	88063	88064	H35ALVC-C-015-30375-R.010	new
	3/8	.010	3/4	2-1/2	3	88067	88068	H35ALVC-C-020-30375-R.010	new
	3/8	.030	1/2	2	3	88065	88066	H35ALVC-C-015-30375-R.030	new
	3/8	.030	3/4	2-1/2	3	88069	88070	H35ALVC-C-020-30375-R.030	new
1/2	1/2	.010	5/8	2-1/2	3	88071	88072	H35ALVC-C-012-30500-R.010	new
	1/2	.010	1	3	3	88077	88078	H35ALVC-C-020-30500-R.010	new
	1/2	.010	1-1/4	3	3	88083	88084	H35ALVC-C-025-30500-R.010	new
	1/2	.030	5/8	2-1/2	3	88073	88074	H35ALVC-C-012-30500-R.030	new
	1/2	.030	1	3	3	88079	88080	H35ALVC-C-020-30500-R.030	new
	1/2	.030	1-1/4	3	3	88085	88086	H35ALVC-C-025-30500-R.030	new
	1/2	.060	5/8	2-1/2	3	88075	88076	H35ALVC-C-012-30500-R.060	new
	1/2	.060	1	3	3	88081	88082	H35ALVC-C-020-30500-R.060	new
3/4	3/4	.030	1	3	3	88089	88090	H35ALVC-C-012-30750-R.030	new
	3/4	.030	1-5/8	4	3	88093	88094	H35ALVC-C-021-30750-R.030	new
	3/4	.060	1	3	3	88091	88092	H35ALVC-C-012-30750-R.060	new
	3/4	.060	1-5/8	4	3	88095	88096	H35ALVC-C-021-30750-R.060	new

* .0003 max TR



Speeds & Feeds on Page 16

H35ALV-C-RN-3**3 FLUTE - CORNER RADIUS****35° Helix - Variable Pitch - Chipbreaker Rougher - Reduced Neck**

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Engineered with optimized variable pitch and chipbreaker geometry for reduced harmonics and elevated material removal rates
- Unique tool design requires less torque and horsepower
- Excellent performance in High Efficiency Milling (HEM)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\frac{.003}{.002}$	LOC L2 $\frac{.832}{.837}$	OAL L1 $\frac{.832}{.827}$	Reach (LBS) L3	Neck Dia. L4	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	5/32	3	1/2	.118	3	84850	84851	H35ALV-C-RN-040-30125-R.010
	1/8	.010	5/32	3	5/8	.118	3	84852	84853	H35ALV-C-RN-050-30125-R.010
	1/8	.010	5/32	3	3/4	.118	3	84854	84855	H35ALV-C-RN-060-30125-R.010
3/16	3/16	.010	7/32	3	3/4	.178	3	84856	84857	H35ALV-C-RN-040-30187-R.010
	3/16	.010	7/32	3	1	.178	3	84858	84859	H35ALV-C-RN-050-30187-R.010
	3/16	.010	7/32	3	1-1/8	.178	3	84860	84861	H35ALV-C-RN-060-30187-R.010
1/4	1/4	.010	3/8	4	3/4	.237	3	84862	84863	H35ALV-C-RN-030-30250-R.010
	1/4	.010	3/8	4	1-1/8	.237	3	82161	82162	H35ALV-C-RN-045-30250-R.010
	1/4	.010	3/8	4	1-5/8	.237	3	82163	82164	H35ALV-C-RN-060-30250-R.010
	1/4	.010	3/8	4	2-1/8	.237	3	82165	82166	H35ALV-C-RN-085-30250-R.010
	1/4	.010	3/8	4	2-1/2	.237	3	82167	82168	H35ALV-C-RN-100-30250-R.010
5/16	5/16	.030	7/16	4	1-7/16	.296	3	84864	84865	H35ALV-C-RN-045-30312-R.030
	5/16	.030	7/16	4	1-3/4	.296	3	84866	84867	H35ALV-C-RN-056-30312-R.030
	5/16	.030	7/16	4	2-1/8	.296	3	84868	84869	H35ALV-C-RN-068-30312-R.030
3/8	3/8	.030	1/2	4	1-1/8	.356	3	82169	82170	H35ALV-C-RN-030-30375-R.030
	3/8	.030	1/2	4	1-5/8	.356	3	82171	82172	H35ALV-C-RN-045-30375-R.030
	3/8	.030	1/2	4	2-1/8	.356	3	82173	82174	H35ALV-C-RN-056-30375-R.030
	3/8	.030	1/2	5	2-1/2	.356	3	82175	82176	H35ALV-C-RN-068-30375-R.030
1/2	1/2	.030	5/8	4	1-3/8	.475	3	82177	82178	H35ALV-C-RN-027-30500-R.030
	1/2	.030	5/8	4	1-3/4	.475	3	82179	82180	H35ALV-C-RN-035-30500-R.030
	1/2	.030	5/8	4	2-1/4	.475	3	82181	82182	H35ALV-C-RN-045-30500-R.030
	1/2	.030	5/8	6	2-3/8	.475	3	82183	82184	H35ALV-C-RN-067-30500-R.030
	1/2	.030	5/8	6	4-1/4	.475	3	82185	82186	H35ALV-C-RN-085-30500-R.030
	1/2	.060	5/8	4	1-3/8	.475	3	82187	82188	H35ALV-C-RN-027-30500-R.060
	1/2	.060	5/8	4	1-3/4	.475	3	82189	82190	H35ALV-C-RN-035-30500-R.060
	1/2	.060	5/8	4	2-1/4	.475	3	82191	82192	H35ALV-C-RN-045-30500-R.060
	1/2	.060	5/8	6	2-3/8	.475	3	82193	82194	H35ALV-C-RN-067-30500-R.060
	1/2	.060	5/8	6	4-1/4	.475	3	82195	82196	H35ALV-C-RN-085-30500-R.060

* .0003 max TR

continued on next page



3 FLUTE - CORNER RADIUS

35° Helix - Variable Pitch - Chipbreaker Rougher -
Reduced Neck (cont.)



H35ALV-C-RN-3

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R $\frac{.002}{.002}$	LOC L _c $\frac{.002}{.002}$	OAL L ₁ $\frac{.002}{.002}$	Reach (LBS) L ₂	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
3/4	3/4	.030	1	4	2	.712	3	82197	82198	H35ALV-C-RN-025-30750-R-030
	3/4	.030	1	6	2-1/2	.712	3	82199	82200	H35ALV-C-RN-033-30750-R-030
	3/4	.030	1	6	3	.712	3	82201	82202	H35ALV-C-RN-040-30750-R-030
	3/4	.030	1	6	3-3/8	.712	3	82203	82204	H35ALV-C-RN-045-30750-R-030
	3/4	.060	1	4	2	.712	3	82205	82206	H35ALV-C-RN-025-30750-R-060
	3/4	.060	1	6	2-1/2	.712	3	82207	82208	H35ALV-C-RN-033-30750-R-060
	3/4	.060	1	6	3	.712	3	82209	82210	H35ALV-C-RN-040-30750-R-060
	3/4	.060	1	6	3-3/8	.712	3	82211	82212	H35ALV-C-RN-045-30750-R-060

* .0003 max TIR

H35ALV-C-3 / H35ALV-C-RN-3

Material Guide		SPM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		5/16		3/8		1/2		3/4	
			Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph
WROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	2100	.0007	.0013	.0011	.0020	.0014	.0026	.0021	.0038	.0027	.0051	.0030	.0073	.0058	.0094
CAST ALUMINUM ALLOY	319.0, 320.0, 355.0, 360.0, 360.0, 360.0, 390.0, 505.0, 535.0	1400	.0011	.0021	.0017	.0031	.0022	.0041	.0033	.0061	.0043	.0080	.0061	.0114	.0078	.0145
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn16, CuSn5	770	.0008	.0014	.0011	.0021	.0015	.0026	.0022	.0041	.0029	.0053	.0041	.0076	.0052	.0097

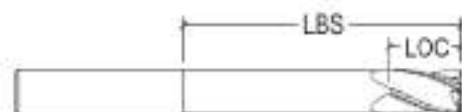
BILLING PROCESS	STYLE	ADOC	RDOC
Slot Full Setting	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rph (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-40% Diameter
	Reached	Up to Max LOC	30%-40% Diameter

NOTES:

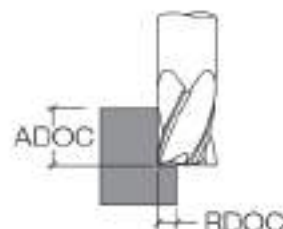
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

H45AL-C-3



3 FLUTE - CORNER RADIUS

45° Helix - Chipbreaker Rougher

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Engineered with high helix and chipbreaker geometry for optimal chip evacuation and a semi-finished surface
- Unique tool design requires less torque and horsepower
- Excellent performance in High Efficiency Milling (HEM)

- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ $\pm .002$	Length of Cut L2 $\pm .002$ $\pm .002$	OAL L1 $\pm .002$ $\pm .002$	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	1/4	1-3/2	3	86562	86563	H45AL-C-S-30125-R.010
	1/8	.010	3/8	2	3	86564	86565	H45AL-C-SR-30125-R.010
	1/8	.010	1/2	2-3/2	3	86566	86567	H45AL-C-R-30125-R.010
3/16	3/16	.010	7/16	2	3	86568	86569	H45AL-C-SR-30187-R.010
	3/16	.010	9/16	2-3/2	3	86570	86571	H45AL-C-R-30187-R.010
	3/16	.010	3/4	2-3/2	3	86572	86573	H45AL-C-M-30187-R.010
1/4	1/4	.010	1/2	2-3/2	3	82717	82718	H45AL-C-SR-30250-R.010
	1/4	.010	3/4	2-3/2	3	82719	82720	H45AL-C-R-30250-R.010
	1/4	.010	1	3	3	82721	82722	H45AL-C-M-30250-R.010
	1/4	.010	1-1/4	3	3	86574	86575	H45AL-C-L-30250-R.010
	1/4	.020	3/8	2	3	29120	29122	H45AL-C-S-30250-R.020
	1/4	.020	1/2	2-3/2	3	29125	29127	H45AL-C-SR-30250-R.020
	1/4	.020	3/4	2-3/2	3	29130	29132	H45AL-C-R-30250-R.020
	1/4	.020	1	3	3	29135	29137	H45AL-C-M-30250-R.020
5/16	5/16	.020	13/16	2-3/2	3	29225	29227	H45AL-C-R-30312-R.020
	5/16	.020	1	3	3	29240	29242	H45AL-C-M-30312-R.020
	5/16	.020	1-1/4	3	3	86576	86577	H45AL-C-L-30312-R.020
3/8	3/8	.010	1/2	2	3	86579	86579	H45AL-C-S-30375-R.010
	3/8	.010	3/4	2-3/2	3	86580	86581	H45AL-C-SR-30375-R.010
	3/8	.010	1	3	3	86582	86583	H45AL-C-R-30375-R.010
	3/8	.010	1-1/4	3-3/2	3	86584	86585	H45AL-C-M-30375-R.010
	3/8	.010	1-1/2	4	3	86586	86587	H45AL-C-L-30375-R.010
	3/8	.020	1/2	2	3	29285	29287	H45AL-C-S-30375-R.020
	3/8	.020	3/4	2-3/2	3	81305	81306	H45AL-C-SR-30375-R.020
	3/8	.020	1	3	3	29300	29302	H45AL-C-R-30375-R.020
	3/8	.020	1-1/4	3-3/2	3	29315	29317	H45AL-C-M-30375-R.020
	3/8	.020	1-1/2	4	3	29330	29332	H45AL-C-L-30375-R.020
	3/8	.020	2	4	3	29345	29347	H45AL-C-LX-30375-R.020
	3/8	.060	1/2	2	3	82723	82724	H45AL-C-S-30375-R.060
	3/8	.060	1	3	3	82725	82726	H45AL-C-R-30375-R.060
	3/8	.060	1-1/4	3-3/2	3	82727	82728	H45AL-C-M-30375-R.060

*.0003 max TIR

continued on next page

3 FLUTE - CORNER RADIUS

45° Helix - Chipbreaker Rougher (cont.)



H45AL-C-3

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R $\pm .002$ -.002	Length of Cut L ₂ $\pm .002$ -.002	QAL L ₁ $\pm .002$ -.002	Flutes	Uncoated	Zr-Coated	Tool Description
1/2	1/2	.010	5/8	2-1/2	3	86588	86589	H45AL-C-S-30500-R.010
	1/2	.010	1	3	3	82729	82730	H45AL-C-SR-30500-R.010
	1/2	.010	1-1/4	3	3	82731	82732	H45AL-C-R-30500-R.010
	1/2	.010	1-5/8	4	3	82733	82734	H45AL-C-M-30500-R.010
	1/2	.010	2	4	3	82735	82736	H45AL-C-L-30500-R.010
	1/2	.020	5/8	2-1/2	3	86590	86591	H45AL-C-S-30500-R.020
	1/2	.020	1	3	3	86592	86593	H45AL-C-SR-30500-R.020
	1/2	.020	1-1/4	3	3	86594	86595	H45AL-C-R-30500-R.020
	1/2	.020	1-5/8	4	3	86596	86597	H45AL-C-M-30500-R.020
	1/2	.020	2	4	3	86598	86599	H45AL-C-L-30500-R.020
	1/2	.030	5/8	2-1/2	3	29375	29377	H45AL-C-S-30500-R.030
	1/2	.030	1	3	3	29380	29382	H45AL-C-SR-30500-R.030
	1/2	.030	1-1/4	3	3	29405	29407	H45AL-C-R-30500-R.030
	1/2	.030	1-5/8	4	3	29420	29422	H45AL-C-M-30500-R.030
	1/2	.030	2	4	3	29435	29437	H45AL-C-L-30500-R.030
	1/2	.030	2-1/2	5	3	29450	29452	H45AL-C-LX-30500-R.030
	1/2	.030	3-1/8	6	3	29465	29467	H45AL-C-X-30500-R.030
	1/2	.060	5/8	2-1/2	3	86600	86601	H45AL-C-S-30500-R.060
	1/2	.060	1	3	3	82737	82738	H45AL-C-SR-30500-R.060
	1/2	.060	1-1/4	3	3	82739	82740	H45AL-C-R-30500-R.060
	1/2	.060	1-5/8	4	3	82741	82742	H45AL-C-M-30500-R.060
	1/2	.060	2	4	3	82743	82744	H45AL-C-L-30500-R.060
5/8	5/8	.030	3/4	3	3	29480	29482	H45AL-C-S-30625-R.030
	5/8	.030	1-5/8	3-1/2	3	29485	29487	H45AL-C-R-30625-R.030
	5/8	.030	2-1/8	4	3	29510	29512	H45AL-C-M-30625-R.030
	5/8	.030	2-1/2	5	3	29525	29527	H45AL-C-L-30625-R.030
	5/8	.060	3/4	3	3	86602	86603	H45AL-C-S-30625-R.060
	5/8	.060	1-5/8	3-1/2	3	86604	86605	H45AL-C-R-30625-R.060
	5/8	.060	2-1/8	4	3	86606	86607	H45AL-C-M-30625-R.060
3/4	3/4	.030	1	4	3	29570	29572	H45AL-C-S-30750-R.030
	3/4	.030	1-5/8	4	3	29585	29587	H45AL-C-R-30750-R.030
	3/4	.030	2	4	3	81307	81308	H45AL-C-A-30750-R.030
	3/4	.030	2-1/4	5	3	29600	29602	H45AL-C-M-30750-R.030
	3/4	.030	2-3/4	5	3	81309	81310	H45AL-C-ML-30750-R.030
	3/4	.030	3-1/4	6	3	29615	29617	H45AL-C-L-30750-R.030
	3/4	.030	4	6-1/2	3	29630	29632	H45AL-C-X-30750-R.030
	3/4	.060	1-5/8	4	3	82745	82746	H45AL-C-R-30750-R.060
	3/4	.060	2-1/4	5	3	82747	82748	H45AL-C-M-30750-R.060
	3/4	.060	3-1/4	6	3	82749	82750	H45AL-C-L-30750-R.060
1	1	.030	1-1/4	4	3	29645	29647	H45AL-C-S-31000-R.030
	1	.030	2	5	3	29660	29662	H45AL-C-R-31000-R.030
	1	.030	2-5/8	6	3	29675	29677	H45AL-C-M-31000-R.030
	1	.030	3-1/4	6	3	29690	29692	H45AL-C-L-31000-R.030
	1	.030	4-1/8	7	3	29705	29707	H45AL-C-X-31000-R.030
	1	.060	2	5	3	86608	86609	H45AL-C-R-31000-R.060
	1	.060	2-5/8	6	3	86610	86611	H45AL-C-M-31000-R.060
	1	.060	3-1/4	6	3	86612	86613	H45AL-C-L-31000-R.060

* .0003 max TIR

H45AL-C-RN-3**3 FLUTE - CORNER RADIUS****45° Helix - Chipbreaker Rougher - Reduced Neck**

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Engineered with high helix and chipbreaker geometry for optimal chip evacuation and a semi-finished surface
- Unique tool design requires less torque and horsepower
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L2 $\frac{+0.002}{-0.002}$	OAL L1 $\frac{+0.002}{-0.002}$	Reach (LBS) L3	Neck Dia. L4	Flutes	Uncoated	Zplus Coated	Tool Description
1/4	1/4	.020	3/8	4	3/4	.237	3	26115	26117	H45AL-C-RN-3-30250-R.020
	1/4	.020	3/8	4	1-1/8	.237	3	26120	26122	H45AL-C-RN-3-30250-R.020
	1/4	.020	3/8	4	1-5/8	.237	3	82751	82752	H45AL-C-RN-A-30250-R.020
	1/4	.020	3/8	4	2-1/8	.237	3	26135	26137	H45AL-C-RN-M-30250-R.020
	1/4	.020	3/8	4	2-1/2	.237	3	82753	82754	H45AL-C-RN-ML-30250-R.020
5/16	5/16	.020	7/16	4	1-1/8	.200	3	26145	26147	H45AL-C-RN-3-30312-R.020
	5/16	.020	7/16	4	2-1/8	.200	3	26140	26142	H45AL-C-RN-M-30312-R.020
3/8	3/8	.020	1/2	4	1-1/8	.350	3	26210	26212	H45AL-C-RN-3-30375-R.020
	3/8	.020	1/2	4	1-5/8	.350	3	82755	82756	H45AL-C-RN-A-30375-R.020
	3/8	.020	1/2	4	2-1/8	.350	3	26225	26227	H45AL-C-RN-M-30375-R.020
	3/8	.020	1/2	5	2-1/2	.350	3	82757	82758	H45AL-C-RN-ML-30375-R.020
1/2	1/2	.030	5/8	4	1-3/8	.475	3	26315	26317	H45AL-C-RN-3-30500-R.030
	1/2	.030	5/8	4	1-3/4	.475	3	81391	81392	H45AL-C-RN-A-30500-R.030
	1/2	.030	5/8	4	2-1/4	.475	3	26390	26392	H45AL-C-RN-M-30500-R.030
	1/2	.030	5/8	5	2-3/4	.475	3	86614	86615	H45AL-C-RN-ML-30500-R.030
	1/2	.030	5/8	6	3-3/8	.475	3	26315	26317	H45AL-C-RN-L-30500-R.030
	1/2	.030	5/8	6	4-1/4	.475	3	26325	26327	H45AL-C-RN-E-30500-R.030
	1/2	.060	5/8	4	1-3/8	.475	3	86622	86623	H45AL-C-RN-R-30500-R.060
	1/2	.060	5/8	4	1-2/4	.475	3	86624	86625	H45AL-C-RN-J-30500-R.060
	1/2	.060	5/8	4	2-1/4	.475	3	86616	86617	H45AL-C-RN-M-30500-R.060
	1/2	.060	5/8	5	2-3/4	.475	3	86634	86635	H45AL-C-RN-ML-30500-R.060
	1/2	.060	5/8	6	3-3/8	.475	3	86618	86619	H45AL-C-RN-L-30500-R.060
	1/2	.060	5/8	6	4-1/4	.475	3	86620	86621	H45AL-C-RN-E-30500-R.060
5/8	5/8	.030	3/4	6	2-3/8	.593	3	26380	26382	H45AL-C-RN-M-30625-R.030
	5/8	.030	3/4	6	3-3/8	.593	3	26375	26377	H45AL-C-RN-L-30625-R.030
	5/8	.030	3/4	6	4-1/8	.593	3	86626	86627	H45AL-C-RN-LX-30625-R.030
3/4	3/4	.030	1	6	2	.712	3	26415	26417	H45AL-C-RN-R-30750-R.030
	3/4	.030	1	6	2-1/2	.712	3	26420	26422	H45AL-C-RN-M-30750-R.030
	3/4	.030	1	6	3	.712	3	81393	81394	H45AL-C-RN-ML-30750-R.030
	3/4	.030	1	6	3-3/8	.712	3	26435	26437	H45AL-C-RN-L-30750-R.030
	3/4	.030	1	6	4-3/8	.712	3	26445	26447	H45AL-C-RN-E-30750-R.030
	3/4	.060	1	4	2	.712	3	86628	86629	H45AL-C-RN-R-30750-R.060
	3/4	.060	1	6	2-1/2	.712	3	86630	86631	H45AL-C-RN-M-30750-R.060
	3/4	.060	1	6	3-3/8	.712	3	86632	86633	H45AL-C-RN-L-30750-R.060

*.0003 max TIR

continued on next page

3 FLUTE - CORNER RADIUS

45° Helix - Chipbreaker Rougher - Reduced Neck (cont.)



H45AL-C-RN-3

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L ₂ $\frac{+0.332}{-0.002}$	OAL L ₁ $\frac{+0.907}{-0.002}$	Reach (LBS) L ₃	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1	1	.030	1-1/4	5	2-5/8	.900	3	28465	28467	H45AL-C-RN-R-31030-R.030
	1	.030	1-1/4	6	3-3/8	.900	3	28480	28482	H45AL-C-RN-M-31030-R.030
	1	.030	1-1/4	7	4-3/8	.900	3	28495	28497	H45AL-C-RN-L-31030-R.030

* .0003 max TIR

H45AL-C-3 / H45AL-C-RN-3

Material Grade		SPM	Inches per Tooth (IPT)													
			1/8		1/16		1/4		3/8		1/2		3/4		1	
			Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh
WROUGHT ALUMINUM ALLOY	2014, 5082, 6061, 7050, 7075, 7475	2100	.0007	.0015	.0011	.0012	.0014	.0025	.0021	.0043	.0028	.0055	.0040	.0061	.0055	.0103
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 390.0, 390.0, 393.0, 390.0, 520.0, 535.0	1400	.0011	.0023	.0017	.0034	.0022	.0045	.0033	.0067	.0044	.0088	.0062	.0125	.0080	.0160
CORNER ALLOY	CuETP, CuBe2, CuZn30, CuZn-39Pb3, CuZn10, CuSn5	770	.0008	.0015	.0011	.0023	.0015	.0030	.0022	.0045	.0028	.0059	.0042	.0084	.0059	.0157

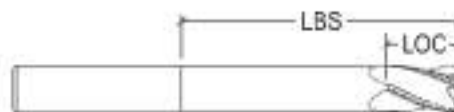
MILING PROCESS	ADOC	RDOC
Slot (Full Milling)	Non-Reached	100%-150% Diameter
	Reached	Up to Max LOC
Rgh (Traditional Roughing)	Non-Reached	100%-150% Diameter
	Reached	Up to Max LOC

NOTES:

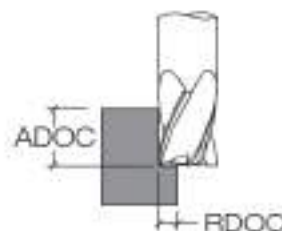
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut



SKU: 28465
Coating: Uncoated
Cutter Dia: 1"
Length of Cut: 1-1/4"
Radius: .030"
Reach (LBS): 2-5/8"

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HVAL-C-5



New Items!

5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch -
For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of aerospace aluminum alloys with excellent performance in other non-ferrous alloys
- Excellent tool life and maximum material removal rates proven through extensive testing
- Engineered with variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Center cutting
- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .002$	Shank Dia. D2 (H6)	Corner Radius R $\pm .002$	Length of Cut L2 $\pm .002$	OAL L1 $\pm .002$	Flutes	Uncoated	Nplus Coated	Tool Description
1/8	1/8	.010	1/4	2-1/2	5	84197	84198	HVAL-C-020-50125-R.010
	1/8	.010	3/8	2-1/2	5	84199	84200	HVAL-C-030-50125-R.010
	1/8	.010	1/2	2-1/2	5	84201	84202	HVAL-C-040-50125-R.010
	1/8	.030	1/4	2-1/2	5	84203	84204	HVAL-C-020-50125-R.030
	1/8	.030	3/8	2-1/2	5	84205	84206	HVAL-C-030-50125-R.030
	1/8	.030	1/2	2-1/2	5	84207	84208	HVAL-C-040-50125-R.030
3/16	1/8	.010	1/4	2-1/2	5	88923	88924	HVAL-C-013-50187-R.010
	1/8	.010	3/8	2-1/2	5	84209	84210	HVAL-C-020-50187-R.010
	1/8	.010	1/2	2-1/2	5	88925	88926	HVAL-C-027-50187-R.010
	1/8	.010	3/4	2-1/2	5	84211	84212	HVAL-C-040-50187-R.010
	1/8	.010	1	2-1/2	5	84213	84214	HVAL-C-053-50187-R.010
	1/8	.030	3/8	2-1/2	5	84215	84216	HVAL-C-020-50187-R.030
	1/8	.030	3/4	2-1/2	5	84217	84218	HVAL-C-040-50187-R.030
	1/8	.030	1	2-1/2	5	84219	84220	HVAL-C-053-50187-R.030
1/4	1/8	.010	3/8	2-1/2	5	88927	88928	HVAL-C-015-50250-R.010
	1/8	.010	1/2	2-1/2	5	84221	84222	HVAL-C-020-50250-R.010
	1/8	.010	3/4	2-1/2	5	84223	84224	HVAL-C-030-50250-R.010
	1/8	.010	1	3	5	84225	84226	HVAL-C-040-50250-R.010
	1/8	.010	1-1/4	3	5	88929	88930	HVAL-C-050-50250-R.010
	1/8	.030	1/2	2-1/2	5	84227	84228	HVAL-C-020-50250-R.030
	1/8	.030	3/4	2-1/2	5	84229	84230	HVAL-C-030-50250-R.030
	1/8	.030	1	3	5	84231	84232	HVAL-C-040-50250-R.030
3/8	3/8	.010	1/2	2-1/2	5	88931	88932	HVAL-C-013-50375-R.010
	3/8	.010	3/4	2-1/2	5	84233	84234	HVAL-C-020-50375-R.010
	3/8	.010	1	3	5	84235	84236	HVAL-C-026-50375-R.010
	3/8	.010	1-1/4	3	5	88933	88934	HVAL-C-033-50375-R.010
	3/8	.010	1-1/2	3-1/2	5	84237	84238	HVAL-C-040-50375-R.010
	3/8	.030	3/4	2-1/2	5	84239	84240	HVAL-C-020-50375-R.030
	3/8	.030	1	3	5	84241	84242	HVAL-C-026-50375-R.030
	3/8	.030	1-1/2	3-1/2	5	84243	84244	HVAL-C-040-50375-R.030

*.0003 max TIR

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Speeds & Feeds on Page 22

5 FLUTE - CORNER RADIUS

New Items!



HVAL-C-5

Chipbreaker Rougher - Variable Pitch -

For High Efficiency Milling (cont.)

continued from previous page

Cutter Dia.* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (H6)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L2 $\pm \frac{.022}{.037}$	OAL L1 $\pm \frac{.082}{.082}$	Flutes	Uncoated	Plus Coated	Tool Description	
1/2	1/2	.010	5/8	2-1/2	5	88935	88936	HVAL-C-013-50500-R.010	new
	1/2	.010	1	3	5	84245	84246	HVAL-C-020-50500-R.010	
	1/2	.010	1-1/4	3	5	84247	84248	HVAL-C-025-50500-R.010	
	1/2	.010	1-3/8	4	5	84249	84250	HVAL-C-032-50500-R.010	
	1/2	.010	2	4	5	84251	84252	HVAL-C-040-50500-R.010	
	1/2	.010	2-1/2	5	5	88937	88938	HVAL-C-050-50500-R.010	new
	1/2	.030	5/8	2-1/2	5	88939	88940	HVAL-C-013-50500-R.030	new
	1/2	.030	1	3	5	84253	84254	HVAL-C-020-50500-R.030	
	1/2	.030	1-1/4	3	5	84255	84256	HVAL-C-025-50500-R.030	
	1/2	.030	1-3/8	4	5	84257	84258	HVAL-C-032-50500-R.030	
	1/2	.030	2	4	5	84259	84260	HVAL-C-040-50500-R.030	
	1/2	.030	2-1/2	5	5	88941	88942	HVAL-C-050-50500-R.030	new
	1/2	.060	1	3	5	84261	84262	HVAL-C-020-50500-R.060	
	1/2	.060	1-1/4	3	5	84263	84264	HVAL-C-025-50500-R.060	
	1/2	.060	1-3/8	4	5	84265	84266	HVAL-C-032-50500-R.060	
	1/2	.060	2	4	5	84267	84268	HVAL-C-040-50500-R.060	
	1/2	.125	1	3	5	84269	84270	HVAL-C-020-50500-R.125	
	1/2	.125	1-1/4	3	5	84271	84272	HVAL-C-025-50500-R.125	
	1/2	.125	1-3/8	4	5	84273	84274	HVAL-C-032-50500-R.125	
	1/2	.125	2	4	5	84275	84276	HVAL-C-040-50500-R.125	
3/4	3/4	.030	1	3	5	88943	88944	HVAL-C-013-50750-R.030	new
	3/4	.030	1-3/8	4	5	84277	84278	HVAL-C-021-50750-R.030	
	3/4	.030	2-1/4	5	5	84279	84280	HVAL-C-030-50750-R.030	
	3/4	.030	2-3/4	5	5	88945	88946	HVAL-C-037-50750-R.030	new
	3/4	.060	1-3/8	4	5	84281	84282	HVAL-C-021-50750-R.060	
	3/4	.060	2-1/4	5	5	84283	84284	HVAL-C-030-50750-R.060	
	3/4	.125	1-3/8	4	5	84285	84286	HVAL-C-021-50750-R.125	
	3/4	.125	2-1/4	5	5	84287	84288	HVAL-C-030-50750-R.125	

*.0003 max TIR

HVAL-C-5

Material Guide		SPM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		3/8		1/2		3/4		1	
			HEM	Rph	HEM	Rph	HEM	Rph	HEM	Rph	HEM	Rph	HEM	Rph	HEM	Rph
WROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	2108	.0018	.0013	.0023	.0023	.0038	.0028	.0045	.0038	.0066	.0051	.0084	.0073	.0107	.0094
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 380.0, 390.0, 395.0, 398.0, 505.0, 525.0	1808	.0023	.0021	.0038	.0031	.0047	.0041	.0070	.0061	.0091	.0080	.0131	.0114	.0167	.0145
COPPER ALLOY	CuETP, CuBe2, CuZn30, Cu20Ag30, Cu20Al10, CuSn5	770	.0018	.0014	.0023	.0021	.0031	.0028	.0047	.0041	.0061	.0053	.0087	.0078	.0112	.0097

MILLING PROCESS	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Rph (Traditional Roughing)	125%-200% Diameter	30%-40% Diameter

NOTES

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

HMG-RN-2



2 FLUTE - SQUARE

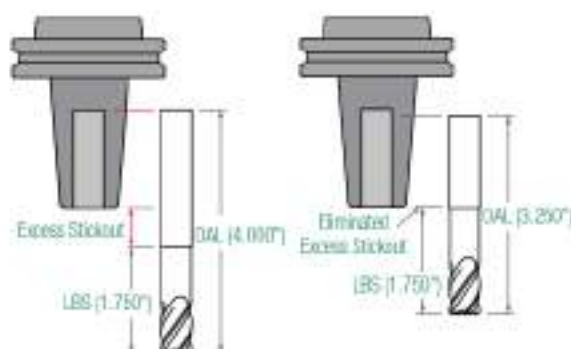
High Balance - Reduced Neck

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for high performance in Makino MAG machining centers capable of elevated RPMs and feed rates
- Precision balanced for high velocity machining in aluminum (up to 33,000 RPM)
- Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity
- Excellent performance in High Efficiency Milling (HEM)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h8 shank tolerance for high precision tool holders
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Length of Cut L2 $\frac{+0.02}{-0.00}$	Overall Length L1 $\frac{+0.02}{-0.00}$	Reach (LBS) L3	Neck Dia. D3	Flutes	Uncoated	Tool Description
3/8	3/8	1/2	2-1/4	1-1/8	.356	2	59968	HMG-PN-030-20375
	3/8	1/2	2-3/4	1-1/2	.356	2	59971	HMG-PN-040-20375
	3/8	1/2	3-1/4	1-3/4	.356	2	59974	HMG-PN-048-20375
	3/8	1/2	3-1/4	2	.356	2	59977	HMG-PN-050-20375
1/2	1/2	5/8	2-3/4	1-3/8	.475	2	59980	HMG-PN-027-20500
	1/2	5/8	3-1/4	1-3/4	.475	2	59983	HMG-PN-035-20500
	1/2	5/8	3-3/4	2	.475	2	59986	HMG-PN-040-20500
	1/2	5/8	3-3/4	2-1/4	.475	2	59989	HMG-PN-045-20500
	1/2	5/8	4-1/4	2-1/2	.475	2	59992	HMG-PN-050-20500
	1/2	5/8	4-1/4	2-3/4	.475	2	59995	HMG-PN-055-20500
	1/2	5/8	4-3/4	3	.475	2	59998	HMG-PN-060-20500
3/4	3/4	1	4	2	.712	2	60001	HMG-PN-026-20750
	3/4	1	4-1/2	2-1/2	.712	2	60004	HMG-PN-033-20750
	3/4	1	5	3	.712	2	60007	HMG-PN-040-20750
	3/4	1	5	3-3/8	.712	2	60010	HMG-PN-045-20750
1	1	1-1/4	4-1/4	2-3/8	.950	2	60013	HMG-PN-023-21000
	1	1-1/4	4-1/4	2-5/8	.950	2	60016	HMG-PN-026-21000
	1	1-1/4	4-3/4	3	.950	2	60019	HMG-PN-030-21000

* .0003 max TIR



Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity.



2 FLUTE - CORNER RADIUS

High Balance - Reduced Neck


HMG-RN-2

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for high performance in Makino MAG machining centers capable of elevated RPMs and feed rates
- Precision balanced for high velocity machining in aluminum (up to 33,000 RPM)
- Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity
- Excellent performance in High Efficiency Milling (HEM)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h8 shank tolerance for high precision tool holders
- Solid carbide
- CNC ground in the USA

See page 23
for shank length
benefits



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ -.002	L0C L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Tool Description
3/8	3/8	.030	1/2	2-1/4	1-1/8	.356	2	59969	HMG-RN-030-29375-R.030
	3/8	.030	1/2	2-3/4	1-1/2	.356	2	59972	HMG-RN-040-29375-R.030
	3/8	.030	1/2	3-1/4	1-3/4	.356	2	59975	HMG-RN-045-29375-R.030
	3/8	.030	1/2	3-1/4	2	.356	2	59978	HMG-RN-050-29375-R.030
	3/8	.060	1/2	2-1/4	1-1/8	.356	2	59970	HMG-RN-030-29375-R.060
	3/8	.060	1/2	2-3/4	1-1/2	.356	2	59973	HMG-RN-040-29375-R.060
	3/8	.060	1/2	3-1/4	1-3/4	.356	2	59976	HMG-RN-045-29375-R.060
	3/8	.060	1/2	3-1/4	2	.356	2	59979	HMG-RN-050-29375-R.060
	3/8	.125	3/8	3-1/4	1-3/4	.356	2	84578	HMG-RN-045-29375-R.125
1/2	1/2	.030	5/8	2-3/4	1-3/8	.475	2	59981	HMG-RN-037-29500-R.030
	1/2	.030	5/8	3-1/4	1-3/4	.475	2	59984	HMG-RN-035-29500-R.030
	1/2	.030	5/8	3-3/4	2	.475	2	59987	HMG-RN-040-29500-R.030
	1/2	.030	5/8	3-3/4	2-1/4	.475	2	59990	HMG-RN-045-29500-R.030
	1/2	.030	5/8	4-1/4	2-1/2	.475	2	59993	HMG-RN-050-29500-R.030
	1/2	.030	5/8	4-1/4	2-3/4	.475	2	59996	HMG-RN-055-29500-R.030
	1/2	.030	5/8	4-3/4	3	.475	2	59999	HMG-RN-060-29500-R.030
	1/2	.060	5/8	2-3/4	1-3/8	.475	2	59982	HMG-RN-037-29500-R.060
	1/2	.060	5/8	3-1/4	1-3/4	.475	2	59985	HMG-RN-035-29500-R.060
	1/2	.060	5/8	3-3/4	2	.475	2	59988	HMG-RN-040-29500-R.060
	1/2	.060	5/8	3-3/4	2-1/4	.475	2	59991	HMG-RN-045-29500-R.060
	1/2	.060	5/8	4-1/4	2-1/2	.475	2	59994	HMG-RN-050-29500-R.060
	1/2	.060	5/8	4-1/4	2-3/4	.475	2	59997	HMG-RN-055-29500-R.060
	1/2	.060	5/8	4-3/4	3	.475	2	60000	HMG-RN-060-29500-R.060
	1/2	.125	1/2	4	2-1/2	.475	2	84579	HMG-RN-050-29500-R.125
3/4	3/4	.030	1	4	2	.712	2	60002	HMG-RN-036-29750-R.030
	3/4	.030	1	4-1/2	2-1/2	.712	2	60005	HMG-RN-033-29750-R.030
	3/4	.030	1	5	3	.712	2	60008	HMG-RN-040-29750-R.030
	3/4	.030	1	5	2-3/8	.712	2	60011	HMG-RN-045-29750-R.030
	3/4	.060	1	4	2	.712	2	60003	HMG-RN-036-29750-R.060
	3/4	.060	1	4-1/2	2-1/2	.712	2	60006	HMG-RN-033-29750-R.060
	3/4	.060	1	5	3	.712	2	60009	HMG-RN-040-29750-R.060
	3/4	.060	1	5	2-3/8	.712	2	60012	HMG-RN-045-29750-R.060

*.0003 max TIR

continued on next page



Speeds & Feeds on Page 25

HMG-RN-2



2 FLUTE - CORNER RADIUS

High Balance - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D1 (R)	Shank Dia. D2 (R)	Corner Radius R $\pm .002$ $-.002$	LOC L2 $\pm .002$ $-.001$	OAL L1 $\pm .002$ $-.002$	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Tool Description
1	1	.030	1-1/4	4-1/4	2-3/8	.950	2	60014	HMG-RN-023-21000-R.030
	1	.030	1-1/4	4-1/4	2-5/8	.950	2	60017	HMG-RN-026-21000-R.030
	1	.030	1-1/4	4-3/4	3	.950	2	60020	HMG-RN-030-21000-R.030
	1	.060	1-1/4	4-1/4	2-3/8	.950	2	60015	HMG-RN-023-21000-R.060
	1	.060	1-1/4	4-1/4	2-5/8	.950	2	60018	HMG-RN-026-21000-R.060
	1	.060	1-1/4	4-3/4	3	.950	2	60021	HMG-RN-030-21000-R.060

*.0003 max. TIR

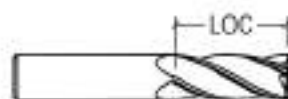
HMG-RN-2

Material Grade		SFN	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			5/8			1/2			3/4			1		
			Skt	Rgh	Fin	Skt	Rgh	Fin	Skt	Rgh	Fin	Skt	Rgh	Fin	Skt	Rgh	Fin	Skt	Rgh	Fin	Skt	Rgh	Fin
WROUGHT ALUMINUM ALLOY	2014, 5042, 6061, 7050, 7075, 7475	2108	.007	.015	.0018	.001	.002	.008	.014	.003	.0021	.0021	.0043	.0024	.008	.0058	.0028	.0040	.0081	.0033	.0051	.0123	.0041
	3190, 328.0, 355.0, 360.0, 380.0, 393.0, 390.0, 520.0, 535.0	1408	.011	.023	.0028	.0017	.0034	.0033	.0022	.0045	.0026	.0033	.0067	.0030	.0044	.0067	.0035	.0062	.0125	.0042	.0019	.0190	.0051
COPPER ALLOY	CuETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0088	.0015	.0017	.0011	.0025	.0019	.0015	.0030	.0021	.0022	.0045	.0024	.0028	.0068	.0028	.0042	.0084	.0034	.0063	.0107	.0041

MILLING PROCESS	ADOC	RDOC
Skt (Full Slitting)	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Up to Max LOC	25%-50% Diameter
Fin (Finishing)	Up to Max LOC	4%-8% Diameter

NOTES:

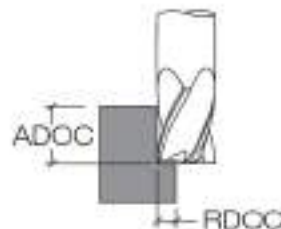
IPT values shown are for 4xD reach tools, and should be adjusted for longer or shorter reaches. For tools with reaches greater than 4xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

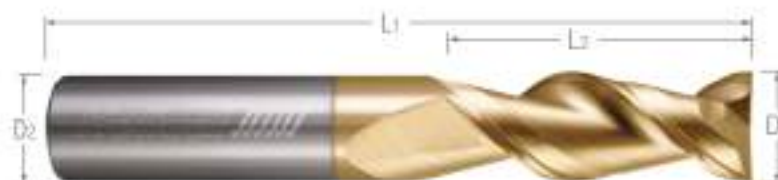
2 FLUTE - SQUARE

New Items!

H45AL-2

45° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a high helix for improved part finish and shearing action
- Cylindrically ground to maintain edge strength
- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 (h6)	Shank Diameter D2 (h6)	Length of Cut L2 = $\frac{1027}{1000}$	Overall Length L1 = $\frac{1027}{1000}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	2	00015	00017	H45AL-S-20125
	1/8	3/8	2	2	00030	00032	H45AL-SR-20125
	1/8	1/2	2-1/2	2	00045	00047	H45AL-R-20125
	1/8	5/8	2-1/2	2	83405	83406	H45AL-M-20125
	1/8	3/4	2-1/2	2	00060	00062	H45AL-L-20125
	1/8	7/8	2-1/2	2	83407	83408	H45AL-LX-20125
3/16	3/16	5/16	2	2	00090	00092	H45AL-S-20187
	3/16	7/16	2	2	83409	83410	H45AL-SR-20187
	3/16	9/16	2-1/2	2	00105	00107	H45AL-R-20187
	3/16	3/4	2-1/2	2	00120	00122	H45AL-M-20187
	3/16	1	2-1/2	2	81311	81312	H45AL-ML-20187
	3/16	1-3/16	3	2	88701	88702	H45AL-L-20187
1/4	1/4	3/8	2	2	00150	00152	H45AL-S-20250
	1/4	1/2	2-1/2	2	00155	00157	H45AL-SR-20250
	1/4	3/4	2-1/2	2	00165	00167	H45AL-R-20250
	1/4	1	3	2	00180	00182	H45AL-M-20250
	1/4	1-1/4	3	2	00195	00197	H45AL-L-20250
	1/4	1-1/2	3	2	88703	88704	H45AL-LX-20250
	1/4	1-3/4	4	2	00210	00212	H45AL-X-20250
	1/4	2	4	2	88705	88706	H45AL-Y-20250
5/16	5/16	7/16	2	2	00240	00242	H45AL-S-20312
	5/16	13/16	2-1/2	2	00255	00257	H45AL-R-20312
	5/16	1	3	2	00270	00272	H45AL-M-20312
	5/16	1-1/4	3	2	00285	00287	H45AL-L-20312
	5/16	1-3/16	4	2	88707	88708	H45AL-LX-20312
	5/16	2-1/8	4	2	00300	00302	H45AL-X-20312
3/8	3/8	1/2	2	2	00330	00332	H45AL-S-20375
	3/8	3/4	2-1/2	2	81313	81314	H45AL-SR-20375
	3/8	1	3	2	00345	00347	H45AL-R-20375
	3/8	1-1/4	2-1/2	2	00360	00362	H45AL-M-20375
	3/8	1-1/2	4	2	00375	00377	H45AL-L-20375
	3/8	2	4	2	00390	00392	H45AL-LX-20375
	3/8	2-1/2	5	2	00405	00407	H45AL-X-20375

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 34

H45AL-2

New Items!

2 FLUTE - SQUARE

45° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Length of Cut L ₂ ^{+ .002" - .001"}	Overall Length L ₁ ^{+ .002" - .001"}	Flutes	Uncoated	Z-plus Coated	Tool Description
1/2	1/2	5/8	2-1/2	2	00435	00437	H45AL-S-20500
	1/2	1	3	2	00450	00452	H45AL-SR-20500
	1/2	1-1/4	3	2	00465	00467	H45AL-R-20500
	1/2	1-5/8	4	2	00480	00482	H45AL-M-20500
	1/2	2	4	2	00495	00497	H45AL-L-20500
	1/2	2-1/2	5	2	00510	00512	H45AL-LX-20500
	1/2	2-3/8	6	2	00525	00527	H45AL-X-20500
	1/2	2-5/8	6	2	88709	88710	H45AL-X-20500
5/8	5/8	3/4	3	2	00555	00557	H45AL-S-20625
	5/8	1-5/8	3-1/2	2	00570	00572	H45AL-R-20625
	5/8	2-1/8	4	2	00585	00587	H45AL-M-20625
	5/8	2-1/2	5	2	00600	00602	H45AL-L-20625
	5/8	2-3/4	6	2	00615	00617	H45AL-X-20625
3/4	3/4	1	4	2	00645	00647	H45AL-S-20750
	3/4	1-5/8	4	2	00660	00662	H45AL-R-20750
	3/4	2	5	2	81315	81316	H45AL-A-20750
	3/4	2-1/4	5	2	00675	00677	H45AL-M-20750
	3/4	2-3/4	6	2	88711	88712	H45AL-MI-20750
	3/4	3-1/4	6	2	00690	00692	H45AL-L-20750
	3/4	4	7	2	00705	00707	H45AL-X-20750
1	1	1-1/4	4	2	00735	00737	H45AL-S-21000
	1	2	5	2	00750	00752	H45AL-R-21000
	1	2-5/8	6	2	00765	00767	H45AL-M-21000
	1	3-1/4	6	2	00780	00782	H45AL-L-21000
	1	4-1/8	7	2	00795	00797	H45AL-X-21000

*.0003 max TIR

2 FLUTE - BALL

New Items!

H45AL-2

45° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials.
- Designed with a high helix for improved part finish and shearing action.
- Cylindrically ground to maintain edge strength.
- Center cutting.
- h8 shank tolerance for high precision tool holders.
- Zplus coating offers higher hardness and added lubricity for maximum performance.
- Solid carbide.
- CNC ground in the USA.



Cutter Diameter* D1 (in)	Shank Diameter D2 (in)	Length of Cut L2 ^{+0.002} / _{-0.001}	Overall Length L1 ^{+0.002} / _{-0.001}	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	2	17015	17017	H45AL-S-20125-BN
	1/8	3/8	2	2	17030	17032	H45AL-SR-20125-BN
	1/8	1/2	2-1/2	2	17045	17047	H45AL-R-20125-BN
	1/8	5/8	2-1/2	2	83411	83412	H45AL-M-20125-BN
	1/8	3/4	2-1/2	2	81317	81318	H45AL-L-20125-BN
	1/8	7/8	2-1/2	2	88713	88714	H45AL-LX-20125-BN new
3/16	3/16	5/16	2	2	17090	17092	H45AL-S-20187-BN
	3/16	7/16	2	2	83413	83414	H45AL-SR-20187-BN
	3/16	9/16	2-1/2	2	17105	17107	H45AL-R-20187-BN
	3/16	3/4	2-1/2	2	81319	81320	H45AL-M-20187-BN
	3/16	1	2-1/2	2	83415	83416	H45AL-MIL-20187-BN
1/4	1/4	3/8	2	2	17150	17152	H45AL-S-20250-BN
	1/4	1/2	2-1/2	2	17155	17157	H45AL-SR-20250-BN
	1/4	3/4	2-1/2	2	17165	17167	H45AL-R-20250-BN
	1/4	1	3	2	81321	81322	H45AL-M-20250-BN
	1/4	1-1/4	3	2	83417	83418	H45AL-L-20250-BN
	1/4	1-1/2	3	2	88715	88716	H45AL-LX-20250-BN new
5/16	5/16	7/16	2	2	17240	17242	H45AL-S-20312-BN
	5/16	13/16	2-1/2	2	17255	17257	H45AL-R-20312-BN
	5/16	1	3	2	88719	88720	H45AL-M-20312-BN new
	5/16	1-1/4	3	2	88717	88718	H45AL-L-20312-BN new
3/8	3/8	1/2	2	2	17330	17332	H45AL-S-20375-BN
	3/8	3/4	2-1/2	2	83419	83420	H45AL-SR-20375-BN
	3/8	1	3	2	17345	17347	H45AL-R-20375-BN
	3/8	1-1/4	3-1/2	2	83421	83422	H45AL-M-20375-BN
	3/8	1-1/2	3-1/2	2	81323	81324	H45AL-L-20375-BN

*.0000 max TIR

continued on next page



Speeds & Feeds on Page 34

H45AL-2

New Items!

2 FLUTE - BALL

45° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Length of Cut L ₂ ^{+0.02"} _{-0.00"}	Overall Length L ₁ ^{+0.02"} _{-0.00"}	Flutes	Uncoated	Zplus Coated	Tool Description
1/2	1/2	5/8	2-1/2	2	17435	17437	H45AL-S-20500-BN
	1/2	1	3	2	81325	81326	H45AL-SR-20500-BN
	1/2	1-1/4	3	2	17465	17467	H45AL-R-20500-BN
	1/2	1-5/8	4	2	83423	83424	H45AL-W-20500-BN
	1/2	2	4	2	83425	83426	H45AL-L-20500-BN
5/8	5/8	3/4	3	2	17555	17557	H45AL-S-20625-BN
	5/8	1-5/8	3-1/2	2	17570	17572	H45AL-R-20625-BN
3/4	3/4	1	4	2	17645	17647	H45AL-S-20750-BN
	3/4	1-5/8	4	2	17660	17662	H45AL-R-20750-BN
	3/4	2-1/4	5	2	83427	83428	H45AL-W-20750-BN
1	1	1-1/4	4	2	17735	17737	H45AL-S-21000-BN
	1	2	5	2	17750	17752	H45AL-R-21000-BN
	1	2-5/8	6	2	83721	83722	H45AL-W-21000-BN

* .0003 max TIR



Machine With Confidence

Customized Running Parameters For
Optimized Machining**MACHINING**
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2 FLUTE - CORNER RADIUS

New Items!

H45AL-2

45° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a high helix for improved part finish and shearing action
- Cylindrically ground to maintain edge strength
- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia* D1 (in)	Shank Diameter D2 (in)	Corner Radius R $\frac{.0025}{.002}$	Length of Cut L2 $\frac{+.032}{-.001}$	Overall Length L1 $\frac{+.162}{-.061}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	3/8	2	2	82329	82330	H45AL-SR-20125-R.010
	1/8	.010	1/2	2-1/2	2	82331	82332	H45AL-R-20125-R.010
	1/8	.010	3/4	2-1/2	2	82333	82334	H45AL-L-20125-R.010
	1/8	.030	3/8	2	2	83723	83724	H45AL-SR-20125-R.030
	1/8	.030	1/2	2-1/2	2	83725	83726	H45AL-R-20125-R.030
	1/8	.030	3/4	2-1/2	2	83727	83728	H45AL-L-20125-R.030
3/16	3/16	.010	5/16	2	2	82335	82336	H45AL-S-20187-R.010
	3/16	.010	9/16	2-1/2	2	82337	82338	H45AL-R-20187-R.010
	3/16	.010	3/4	2-1/2	2	82339	82340	H45AL-M-20187-R.010
	3/16	.030	5/16	2	2	83729	83730	H45AL-S-20187-R.030
	3/16	.030	9/16	2-1/2	2	83731	83732	H45AL-R-20187-R.030
	3/16	.030	3/4	2-1/2	2	83733	83734	H45AL-M-20187-R.030
1/4	1/4	.010	3/8	2	2	83735	83736	H45AL-S-20250-R.010
	1/4	.010	1/2	2-1/2	2	82341	82342	H45AL-SR-20250-R.010
	1/4	.010	3/4	2-1/2	2	82343	82344	H45AL-R-20250-R.010
	1/4	.010	1	3	2	82345	82346	H45AL-M-20250-R.010
	1/4	.030	3/8	2	2	83737	83738	H45AL-S-20250-R.030
	1/4	.030	1/2	2-1/2	2	82347	82348	H45AL-SR-20250-R.030
	1/4	.030	3/4	2-1/2	2	82349	82350	H45AL-R-20250-R.030
	1/4	.030	1	3	2	82351	82352	H45AL-M-20250-R.030
3/8	3/8	.030	1/2	2	2	82353	82354	H45AL-S-20375-R.030
	3/8	.030	1	3	2	82355	82356	H45AL-R-20375-R.030
	3/8	.030	1-1/4	3-1/2	2	82357	82358	H45AL-M-20375-R.030
	3/8	.060	1/2	2	2	82359	82360	H45AL-S-20375-R.060
	3/8	.060	1	3	2	82361	82362	H45AL-R-20375-R.060
	3/8	.060	1-1/4	3-1/2	2	82363	82364	H45AL-M-20375-R.060

* .0003 max TIR

continued on next page



H45AL-2

New Items!

2 FLUTE - CORNER RADIUS

45° Helix (cont.)

continued from previous page

Cutter Dia* D ₁ (in)	Shank Diameter D ₂ (in)	Corner Radius R $\pm \begin{smallmatrix} .002" \\ -.002" \end{smallmatrix}$	Length of Cut L ₂ $\pm \begin{smallmatrix} .022" \\ -.002" \end{smallmatrix}$	Overall Length L ₁ $\pm \begin{smallmatrix} .005" \\ -.005" \end{smallmatrix}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/2	1/2	.030	1	3	2	82365	82366	H45AL-SF-20500-R.030
	1/2	.030	1-1/4	3	2	82367	82368	H45AL-R-20500-R.030
	1/2	.030	1-5/8	4	2	82369	82370	H45AL-M-20500-R.030
	1/2	.030	2	4	2	82371	82372	H45AL-L-20500-R.030
	1/2	.060	1	3	2	82373	82374	H45AL-SF-20500-R.060
	1/2	.060	1-1/4	3	2	82375	82376	H45AL-R-20500-R.060
	1/2	.060	1-5/8	4	2	82377	82378	H45AL-M-20500-R.060
	1/2	.060	2	4	2	82379	82380	H45AL-L-20500-R.060
3/4	3/4	.030	1	4	2	82729	82740	H45AL-S-20750-R.030
	3/4	.030	1-5/8	4	2	82381	82382	H45AL-R-20750-R.030
	3/4	.030	2	5	2	82743	82744	H45AL-A-20750-R.030
	3/4	.030	2-1/4	5	2	82383	82384	H45AL-M-20750-R.030
	3/4	.030	2-3/4	6	2	82747	82748	H45AL-ML-20750-R.030
	3/4	.060	1	4	2	82741	82742	H45AL-S-20750-R.060
	3/4	.060	1-5/8	4	2	82385	82386	H45AL-R-20750-R.060
	3/4	.060	2	5	2	82745	82746	H45AL-A-20750-R.060
new	3/4	.060	2-1/4	5	2	82387	82388	H45AL-M-20750-R.060
	3/4	.060	2-3/4	6	2	82749	82750	H45AL-ML-20750-R.060

*.0003 max TIR



SKU: 02141
Coating: uncoated
Cutter Dia: 1/2"
Length of Cut: 1-5/8"
Radius: .010"

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2 FLUTE - SQUARE

45° Helix - Reduced Neck

H45AL-RN-2

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a high helix for improved part finish and shearing action
- Cylindrically ground to maintain edge strength
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h8 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D ₁ (H8)	Shank Dia. D ₂ (H8)	LOC L ₂ ^{+0.015} / _{-0.010}	OAL L ₁ ^{+0.015} / _{-0.010}	Reach (LBS) L ₃	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	3	1/2	.116	2	02015	02017	H45AL-RN-R-20125
	1/8	5/32	3	3/4	.116	2	02030	02032	H45AL-RN-M-20125
	1/8	5/32	3	1	.116	2	81327	81328	H45AL-RN-L-20125
3/16	3/16	7/32	3	1/2	.178	2	02060	02062	H45AL-RN-R-20187
	3/16	7/32	3	3/4	.178	2	02075	02077	H45AL-RN-M-20187
	3/16	7/32	3	1	.178	2	81329	81330	H45AL-RN-ML-20187
1/4	1/4	3/8	4	3/4	.237	2	02105	02107	H45AL-RN-S-20250
	1/4	3/8	4	1-1/8	.237	2	02120	02122	H45AL-RN-R-20250
	1/4	3/8	4	1-5/8	.237	2	81331	81332	H45AL-RN-A-20250
	1/4	3/8	4	2-1/8	.237	2	02135	02137	H45AL-RN-M-20250
	1/4	3/8	4	2-1/2	.237	2	81333	81334	H45AL-RN-ML-20250
5/16	5/16	7/16	4	1-1/8	.296	2	02165	02167	H45AL-RN-R-20312
	5/16	7/16	4	2-1/8	.296	2	02180	02182	H45AL-RN-M-20312
	5/16	7/16	6	3-1/8	.296	2	02190	02192	H45AL-RN-L-20312
3/8	3/8	1/2	4	1-1/8	.356	2	02210	02212	H45AL-RN-R-20375
	3/8	1/2	4	1-5/8	.356	2	81335	81336	H45AL-RN-A-20375
	3/8	1/2	4	2-1/8	.356	2	02225	02227	H45AL-RN-M-20375
	3/8	1/2	5	2-1/2	.356	2	81337	81338	H45AL-RN-ML-20375
	3/8	1/2	6	3-1/8	.356	2	02235	02237	H45AL-RN-L-20375
	3/8	1/2	6	4	.356	2	02245	02247	H45AL-RN-X-20375
1/2	1/2	5/8	4	1-3/8	.475	2	02285	02287	H45AL-RN-R-20500
	1/2	5/8	4	1-3/4	.475	2	81339	81340	H45AL-RN-A-20500
	1/2	5/8	4	2-1/4	.475	2	02300	02302	H45AL-RN-M-20500
	1/2	5/8	4-1/2	2-3/4	.475	2	81341	81342	H45AL-RN-ML-20500
	1/2	5/8	6	3-3/8	.475	2	02315	02317	H45AL-RN-L-20500
	1/2	5/8	6	4-1/4	.475	2	02325	02327	H45AL-RN-X-20500
5/8	5/8	3/4	4	1-5/8	.593	2	02345	02347	H45AL-RN-R-20625
3/4	3/4	1	4	2	.712	2	02405	02407	H45AL-RN-R-20750
	3/4	1	6	2-1/2	.712	2	02420	02422	H45AL-RN-M-20750
	3/4	1	6	3-3/8	.712	2	02435	02437	H45AL-RN-L-20750
	3/4	1	6	4-3/8	.712	2	02445	02447	H45AL-RN-X-20750
1	1	1-1/4	5	2-5/8	.950	2	02465	02467	H45AL-RN-R-21000
	1	1-1/4	6	3-3/8	.950	2	02480	02482	H45AL-RN-M-21000
	1	1-1/4	7	4-3/8	.950	2	02485	02487	H45AL-RN-L-21000

* .0003 max TR



Speeds & Feeds on Page 34

H45AL-RN-2

2 FLUTE - BALL
45° Helix - Reduced Neck

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a high helix for improved part finish and shearing action
- Cylindrically ground to maintain edge strength
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Length of Cut L2 ± .012 - .010	Overall Length L1 ± .002 - .002	Resch (LBS) L1	Neck Dia. L3	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	3	1/2	.118	2	18015	18017	H45AL-RN-R-20125-BN
	1/8	5/32	3	3/4	.118	2	18030	18032	H45AL-RN-M-20125-BN
	1/8	5/32	3	1	.118	2	81343	81344	H45AL-RN-L-20125-BN
3/16	3/16	7/32	3	1/2	.178	2	18060	18062	H45AL-RN-R-20187-BN
	3/16	7/32	3	3/4	.178	2	18075	18077	H45AL-RN-M-20187-BN
	3/16	7/32	3	1	.178	2	81345	81346	H45AL-RN-L-20187-BN
1/4	1/4	3/8	4	3/4	.237	2	18105	18107	H45AL-RN-R-20250-BN
	1/4	3/8	4	1-1/8	.237	2	18120	18122	H45AL-RN-M-20250-BN
	1/4	3/8	4	1-5/8	.237	2	81347	81348	H45AL-RN-A-20250-BN
	1/4	3/8	4	2-1/8	.237	2	18135	18137	H45AL-RN-M-20250-BN
	1/4	3/8	4	2-1/2	.237	2	81349	81350	H45AL-RN-L-20250-BN
5/16	5/16	7/16	4	1-1/8	.296	2	18165	18167	H45AL-RN-R-20312-BN
	5/16	7/16	4	2-1/8	.296	2	18180	18182	H45AL-RN-M-20312-BN
	5/16	7/16	6	3-1/8	.296	2	18190	18192	H45AL-RN-L-20312-BN
3/8	3/8	1/2	4	1-1/8	.356	2	18210	18212	H45AL-RN-R-20375-BN
	3/8	1/2	4	1-5/8	.356	2	81351	81352	H45AL-RN-A-20375-BN
	3/8	1/2	4	2-1/8	.356	2	18225	18227	H45AL-RN-M-20375-BN
	3/8	1/2	5	2-1/2	.356	2	81353	81354	H45AL-RN-L-20375-BN
	3/8	1/2	6	3-1/8	.356	2	18235	18237	H45AL-RN-L-20375-BN
	3/8	1/2	6	4	.356	2	18245	18247	H45AL-RN-X-20375-BN
1/2	1/2	5/8	4	1-3/8	.475	2	18285	18287	H45AL-RN-R-20500-BN
	1/2	5/8	4	1-3/4	.475	2	81355	81356	H45AL-RN-A-20500-BN
	1/2	5/8	4	2-1/4	.475	2	18300	18302	H45AL-RN-M-20500-BN
	1/2	5/8	4-1/2	2-3/4	.475	2	81357	81358	H45AL-RN-L-20500-BN
	1/2	5/8	6	3-3/8	.475	2	18315	18317	H45AL-RN-L-20500-BN
	1/2	5/8	6	4-1/4	.475	2	18325	18327	H45AL-RN-X-20500-BN
3/4	3/4	1	4	2	.712	2	18405	18407	H45AL-RN-R-20750-BN
	3/4	1	6	2-1/2	.712	2	18420	18422	H45AL-RN-M-20750-BN
	3/4	1	6	3-3/8	.712	2	18435	18437	H45AL-RN-L-20750-BN
	3/4	1	6	4-3/8	.712	2	18445	18447	H45AL-RN-X-20750-BN
1	1	1-1/4	5	2-5/8	.950	2	18465	18467	H45AL-RN-R-21000-BN
	1	1-1/4	6	3-3/8	.950	2	18480	18482	H45AL-RN-M-21000-BN
	1	1-1/4	7	4-3/8	.950	2	18495	18497	H45AL-RN-L-21000-BN

* .0003 max TIR



SPEEDS & FEEDS

45° Helix

H45AL-RN-2

2 Flute

H45AL-2 / H45AL-RN-2

Material Guide		EFM	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			5/8			1/2			3/4			1		
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
WROUGHT ALUMINUM ALLOY	2014, 5082, 6061, T050, 7075, 7475	2100	.0007	.0014	.0018	.0010	.0021	.0021	.0014	.0028	.0023	.0020	.0042	.0027	.0007	.0055	.0032	.0038	.0078	.0037	.0048	.0106	.0045
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 390.0, 390.0, 390.0, 525.0, 535.0	1400	.0011	.0023	.0023	.0016	.0033	.0028	.0022	.0044	.0029	.0032	.0066	.0034	.0042	.0088	.0039	.0066	.0124	.0047	.0071	.0157	.0067
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	770	.0007	.0015	.0015	.0011	.0022	.0021	.0014	.0029	.0024	.0021	.0044	.0027	.0028	.0057	.0032	.0048	.0082	.0039	.0051	.0104	.0047

MILLING PROCESS	STYLE	ADOC	RDOC
Slot (Full Slotting)	Non-Reached	Up to 200% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rgh (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-50% Diameter
	Reached	Up to Max LOC	30%-50% Diameter
Fin (Finishing)	NA	Up to Max LOC	4%-6% Diameter

NOTES:

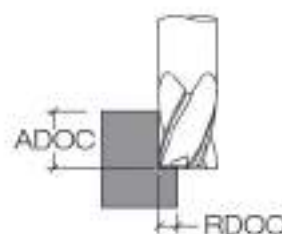
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

HMGC-RN-3



3 FLUTE - SQUARE

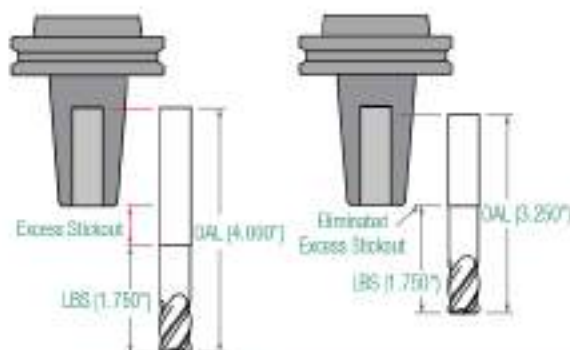
Coolant Through - High Balance - Reduced Neck

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for high performance in Makino MAG machining centers capable of elevated RPMs and feed rates
- Precision balanced for high velocity machining in aluminum (up to 33,000 RPM)
- Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity
- Excellent performance in High Efficiency Milling (HEM)
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased MRR
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- h6 shank tolerance for high precision tool holders
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Length of Cut L2 $\frac{+0.012}{-0.007}$	Overall Length L1 $\frac{+0.012}{-0.007}$	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Tool Description
3/8	3/8	1/2	2-1/4	1-1/8	.360	3	60022	HMGC-RN-030-30075
	3/8	1/2	2-3/4	1-1/2	.360	3	60025	HMGC-RN-040-30075
	3/8	1/2	3-1/4	1-3/4	.360	3	60028	HMGC-RN-048-30075
	3/8	1/2	3-1/4	2	.360	3	60031	HMGC-RN-053-30075
1/2	1/2	5/8	2-3/4	1-3/8	.475	3	60034	HMGC-RN-027-30600
	1/2	5/8	3-1/4	1-3/4	.475	3	60037	HMGC-RN-035-30600
	1/2	5/8	3-3/4	2	.475	3	60040	HMGC-RN-040-30600
	1/2	5/8	3-3/4	2-1/4	.475	3	60043	HMGC-RN-045-30600
	1/2	5/8	4-1/4	2-1/2	.475	3	60046	HMGC-RN-050-30600
	1/2	5/8	4-1/4	2-3/4	.475	3	60049	HMGC-RN-055-30600
	1/2	5/8	4-3/4	3	.475	3	60052	HMGC-RN-060-30600
3/4	3/4	1	4	2	.712	3	60055	HMGC-RN-026-30750
	3/4	1	4-1/2	2-1/2	.712	3	60058	HMGC-RN-033-30750
	3/4	1	5	3	.712	3	60061	HMGC-RN-040-30750
	3/4	1	5	3-3/8	.712	3	60064	HMGC-RN-045-30750
1	1	1-1/4	4-1/4	2-3/8	.950	3	60067	HMGC-RN-023-31000
	1	1-1/4	4-1/4	2-5/8	.950	3	60070	HMGC-RN-026-31000
	1	1-1/4	4-3/4	3	.950	3	60073	HMGC-RN-030-31000

* .0003 max TIR



Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity.



Speeds & Feeds on Page 37

3 FLUTE - CORNER RADIUS

Coolant Through - High Balance - Reduced Neck


HMGC-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for high performance in Makino MAG machining centers capable of elevated RPMs and feed rates
- Precision balanced for high velocity machining in aluminum (up to 33,000 RPM)
- Shank length designed for optimal use in high performance tool holders, providing reduced excess stickout and increased rigidity
- Excellent performance in High Efficiency Milling (HEM)
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased MRR
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Unique "3 teeth-to-center" and geometry for ramping applications
- h6 shank tolerance for high precision tool holders
- Solid carbide
- CNC ground in the USA

See page 35
for shank
length benefits



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ -.002	L0C L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Tool Description
3/8	3/8	.030	1/2	2-1/4	1-1/8	.356	3	60023	HMGC-RN-030-30375-R.030
	3/8	.030	1/2	2-3/4	1-1/2	.356	3	60026	HMGC-RN-040-30375-R.030
	3/8	.030	1/2	3-1/4	1-3/4	.356	3	60029	HMGC-RN-040-30375-R.030
	3/8	.030	1/2	3-1/4	2	.356	3	60032	HMGC-RN-053-30375-R.030
	3/8	.060	1/2	2-1/4	1-1/8	.356	3	60024	HMGC-RN-030-30375-R.060
	3/8	.060	1/2	2-3/4	1-1/2	.356	3	60027	HMGC-RN-040-30375-R.060
	3/8	.060	1/2	3-1/4	1-3/4	.356	3	60030	HMGC-RN-040-30375-R.060
	3/8	.060	1/2	3-1/4	2	.356	3	60033	HMGC-RN-053-30375-R.060
1/2	1/2	.030	5/8	2-3/4	1-3/8	.475	3	60035	HMGC-RN-027-30500-R.030
	1/2	.030	5/8	3-1/4	1-3/4	.475	3	60038	HMGC-RN-030-30500-R.030
	1/2	.030	5/8	3-3/4	2	.475	3	60041	HMGC-RN-040-30500-R.030
	1/2	.030	5/8	2-3/4	2-1/4	.475	3	60044	HMGC-RN-045-30500-R.030
	1/2	.030	5/8	4-1/4	2-1/2	.475	3	60047	HMGC-RN-050-30500-R.030
	1/2	.030	5/8	4-1/4	2-3/4	.475	3	60050	HMGC-RN-055-30500-R.030
	1/2	.030	5/8	4-3/4	3	.475	3	60053	HMGC-RN-060-30500-R.030
	1/2	.060	5/8	2-3/4	1-3/8	.475	3	60036	HMGC-RN-027-30500-R.060
	1/2	.060	5/8	3-1/4	1-3/4	.475	3	60039	HMGC-RN-035-30500-R.060
	1/2	.060	5/8	2-3/4	2	.475	3	60042	HMGC-RN-040-30500-R.060
	1/2	.060	5/8	3-3/4	2-1/4	.475	3	60045	HMGC-RN-045-30500-R.060
	1/2	.060	5/8	4-1/4	2-1/2	.475	3	60048	HMGC-RN-050-30500-R.060
	1/2	.060	5/8	4-1/4	2-3/4	.475	3	60051	HMGC-RN-055-30500-R.060
	1/2	.060	5/8	4-3/4	3	.475	3	60054	HMGC-RN-060-30500-R.060
3/4	3/4	.030	1	4	2	.712	3	60056	HMGC-RN-026-30750-R.030
	3/4	.030	1	4-1/2	2-1/2	.712	3	60059	HMGC-RN-033-30750-R.030
	3/4	.030	1	5	3	.712	3	60062	HMGC-RN-040-30750-R.030
	3/4	.030	1	5	3-3/8	.712	3	60065	HMGC-RN-045-30750-R.030
	3/4	.060	1	4	2	.712	3	60057	HMGC-RN-026-30750-R.060
	3/4	.060	1	4-1/2	2-1/2	.712	3	60060	HMGC-RN-033-30750-R.060
	3/4	.060	1	5	3	.712	3	60063	HMGC-RN-040-30750-R.060
	3/4	.060	1	5	3-3/8	.712	3	60066	HMGC-RN-045-30750-R.060
3/4	3/4	.190	1	4-1/2	3	.712	3	84580	HMGC-RN-040-30750-R.190

* .0003 max. TIR

continued on next page



Speeds & Feeds on Page 37

HMGC-RN-3



3 FLUTE - CORNER RADIUS

Coolant Through - High Balance - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Tool Description
1	1	.030	1-1/4	4-1/4	2-3/8	.950	3	60063	HMGC-RN-023-31000-R.030
	1	.030	1-1/4	4-1/4	2-5/8	.950	3	60071	HMGC-RN-026-31000-R.030
	1	.030	1-1/4	4-3/4	3	.950	3	60074	HMGC-RN-030-31000-R.030
	1	.060	1-1/4	4-1/4	2-3/8	.950	3	60069	HMGC-RN-023-31000-R.060
	1	.060	1-1/4	4-1/4	2-5/8	.950	3	60072	HMGC-RN-026-31000-R.060
	1	.060	1-1/4	4-3/4	3	.950	3	60075	HMGC-RN-030-31000-R.060
	1	.120	1	4-1/4	2	.950	3	84581	HMGC-RN-020-31000-R.120

*.0003 max TIR

HMGC-RN-3

Material Guide		SFM	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			3/8			1/2			3/4			1		
			Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin
WROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	2100	.0007	.0015	.0016	.0011	.0022	.0018	.0014	.0029	.0021	.0021	.0043	.0024	.0029	.0056	.0038	.0040	.0060	.0033	.0061	.0102	.0040
	319.0, 325.0, 355.0, 383.0, 383.0, 383.0, 390.0, 525.0, 535.0	1400	.0011	.0023	.0020	.0017	.0034	.0023	.0022	.0046	.0026	.0039	.0096	.0038	.0043	.0097	.0035	.0062	.0124	.0041	.0079	.0158	.0069
COPPER ALLOY	Cu-ETP, CuB2, CuZn30, CuZn38Pb3, CuZn18, CuSn5	770	.0008	.0015	.0017	.0011	.0023	.0019	.0015	.0030	.0021	.0022	.0044	.0024	.0029	.0059	.0038	.0041	.0063	.0034	.0063	.0106	.0041

MILLING PROCESS	ADOC	RDOC
Slot (Full Slotting)	Up to Max LOC	100% Diameter
Rph (Traditional Roughing)	Up to Max LOC	35%-65% Diameter
Fin (Finish)	Up to Max LOC	4%-6% Diameter

NOTES:

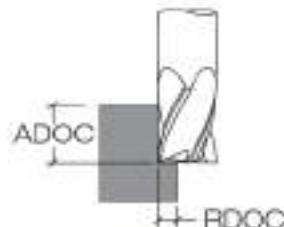
IPT values shown are for 4xD reach tools, and should be adjusted for longer or shorter reaches. For tools with reaches greater than 4xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

3 FLUTE - SQUARE

New Items!



H35AL-3

35° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for tough roughing applications with 3 flutes and 35° helix
- Cylindrically ground to maintain edge strength
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 (in)	Shank Diameter D2 (in)	Length of Cut L2 $\pm \frac{.001}{.001}$	Overall Length L1 $\pm \frac{.001}{.001}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	3	01015	01017	H35AL-S-30125
	1/8	3/8	2	3	01030	01032	H35AL-SR-30125
	1/8	1/2	2-1/2	3	01045	01047	H35AL-R-30125
	1/8	5/8	2-1/2	3	01359	01360	H35AL-M-30125
	1/8	3/4	2-1/2	3	01361	01362	H35AL-L-30125
	1/8	7/8	2-1/2	3	03429	03430	H35AL-LX-30125
	1/8	1	2-1/2	3	03045	03046	H35AL-X-30125
3/16	3/16	5/16	2	3	01090	01092	H35AL-S-30187
	3/16	7/16	2	3	03431	03432	H35AL-SR-30187
	3/16	9/16	2-1/2	3	01105	01107	H35AL-R-30187
	3/16	3/4	2-1/2	3	01363	01364	H35AL-M-30187
	3/16	1	2-1/2	3	01365	01366	H35AL-L-30187
	3/16	1-3/16	3	3	03433	03434	H35AL-LX-30187
	3/16	1-3/8	3	3	03047	03048	H35AL-X-30187
1/4	1/4	3/8	2	3	01150	01152	H35AL-S-30250
	1/4	1/2	2-1/2	3	01155	01157	H35AL-SR-30250
	1/4	5/8	2-1/2	3	01165	01167	H35AL-R-30250
	1/4	1	3	3	01180	01182	H35AL-M-30250
	1/4	1-1/4	3	3	01195	01197	H35AL-L-30250
	1/4	1-1/2	3	3	01307	01308	H35AL-LX-30250
	1/4	1-3/4	4	3	01309	01370	H35AL-X-30250
	1/4	2	4	3	03049	03050	H35AL-Y-30250
5/16	5/16	7/16	2	3	01240	01242	H35AL-S-30312
	5/16	9/8	2-1/2	3	01255	01257	H35AL-R-30312
	5/16	1	2	3	01270	01272	H35AL-M-30312
	5/16	1-1/4	3	3	01285	01287	H35AL-L-30312
	5/16	1-9/16	4	3	03435	03436	H35AL-LX-30312
	5/16	2-1/8	4	3	01300	01302	H35AL-X-30312
	5/16	2-1/2	4	3	03051	03052	H35AL-Y-30312

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 47

H35AL-3



New Items!

3 FLUTE - SQUARE

35° Helix (cont.)

continued from previous page

new

Cutter Diameter* D ₁ h8	Shank Diameter D ₂ h8	Length of Cut L ₂ ^{+0.027} / _{-0.027}	Overall Length L ₁ ^{+0.027} / _{-0.027}	Flutes	Uncosted	Zplus Coated	Tool Description
3/8	3/8	1/2	2	3	01330	01332	H35AL-S-30075
	3/8	3/4	2-1/2	3	01371	01372	H35AL-SR-30075
	3/8	1	3	3	01345	01347	H35AL-R-30075
	3/8	1-1/4	3-1/2	3	01360	01362	H35AL-M-30075
	3/8	1-1/2	4	3	01375	01377	H35AL-L-30075
	3/8	2	4	3	01390	01392	H35AL-LX-30075
	3/8	2-1/2	5	3	01405	01407	H35AL-X-30075
	3/8	3	5	3	00053	00054	H35AL-Y-30075
1/2	1/2	5/8	2-1/2	3	01435	01437	H35AL-S-30500
	1/2	1	3	3	01450	01452	H35AL-SR-30500
	1/2	1-1/4	3	3	01465	01467	H35AL-R-30500
	1/2	1-5/8	4	3	01480	01482	H35AL-M-30500
	1/2	2	4	3	01495	01497	H35AL-L-30500
	1/2	2-1/2	5	3	01510	01512	H35AL-LX-30500
	1/2	3-1/8	6	3	01525	01527	H35AL-X-30500
	1/2	3-5/8	6	3	03437	03438	H35AL-Y-30500
5/8	5/8	3/4	3	3	01555	01557	H35AL-S-30625
	5/8	1-1/4	3-1/2	3	03439	03440	H35AL-SR-30625
	5/8	1-5/8	3-1/2	3	01570	01572	H35AL-R-30625
	5/8	2-1/8	4	3	01585	01587	H35AL-M-30625
	5/8	2-1/2	5	3	01600	01602	H35AL-L-30625
	5/8	3-1/4	6	3	01610	01612	H35AL-LX-30625
	5/8	3-3/4	6	3	01615	01617	H35AL-X-30625
3/4	3/4	1	4	3	01645	01647	H35AL-S-30750
	3/4	1-5/8	4	3	01660	01662	H35AL-R-30750
	3/4	2-1/4	5	3	01675	01677	H35AL-M-30750
	3/4	2-3/4	5	3	01373	01374	H35AL-ML-30750
	3/4	3-1/4	6	3	01690	01692	H35AL-L-30750
	3/4	4	6-1/2	3	01705	01707	H35AL-X-30750
1	1	1-1/4	4	3	01735	01737	H35AL-S-31000
	1	2	5	3	01750	01752	H35AL-R-31000
	1	2-5/8	6	3	01765	01767	H35AL-M-31000
	1	3-1/4	6	3	01780	01782	H35AL-L-31000
	1	4-1/4	7	3	01795	01797	H35AL-X-31000

*.0003 max TIR

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3 FLUTE - SQUARE - METRIC

35° Helix


MH35AL-3
METRIC

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for tough roughing applications with 3 flutes and 35° helix
- Cylindrically ground to maintain edge strength
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D ₁ (H9)	Shank Diameter D ₂ (H8)	Length of Cut L ₂ ^{+0.00 mm -0.00 mm}	Overall Length L ₁ ^{+1.00 mm -1.00 mm}	Flutes	Uncoated	Zplus Coated	Tool Description
6 mm	6.00 mm	9.00 mm	63 mm	3	59690	59691	MH35AL-015-30600
	6.00 mm	12.00 mm	63 mm	3	59726	59727	MH35AL-020-30600
	6.00 mm	18.00 mm	63 mm	3	59794	59795	MH35AL-030-30600
8 mm	8.00 mm	12.00 mm	63 mm	3	59696	59697	MH35AL-015-30800
	8.00 mm	16.00 mm	63 mm	3	59732	59733	MH35AL-020-30800
	8.00 mm	24.00 mm	75 mm	3	59800	59801	MH35AL-030-30800
10 mm	10.00 mm	15.00 mm	63 mm	3	59702	59703	MH35AL-015-31000
	10.00 mm	20.00 mm	63 mm	3	59738	59739	MH35AL-020-31000
	10.00 mm	25.00 mm	75 mm	3	59766	59767	MH35AL-025-31000
12 mm	12.00 mm	18.00 mm	75 mm	3	59708	59709	MH35AL-015-31200
	12.00 mm	24.00 mm	75 mm	3	59744	59745	MH35AL-020-31200
	12.00 mm	30.00 mm	75 mm	3	59772	59773	MH35AL-025-31200
16 mm	16.00 mm	24.00 mm	89 mm	3	59714	59715	MH35AL-015-31600
	16.00 mm	32.00 mm	89 mm	3	59750	59751	MH35AL-020-31600
	16.00 mm	40.00 mm	89 mm	3	59778	59779	MH35AL-025-31600
20 mm	20.00 mm	30.00 mm	89 mm	3	59720	59721	MH35AL-015-32000
	20.00 mm	40.00 mm	100 mm	3	59756	59757	MH35AL-020-32000
	20.00 mm	50.00 mm	125 mm	3	59784	59785	MH35AL-025-32000
25 mm	25.00 mm	50.00 mm	125 mm	3	59762	59763	MH35AL-020-32500
	25.00 mm	64.00 mm	125 mm	3	59790	59791	MH35AL-025-32500

* .008 mm max TIR



Speeds & Feeds on Page 47



H35AL-3

New Items!

3 FLUTE - CORNER RADIUS

35° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for tough roughing applications with 3 flutes and 35° helix
- Cylindrically ground to maintain edge strength
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 (in)	Shank Diameter D2 (in)	Corner Radius R $\frac{+0.002}{-0.000}$	Length of Cut L2 $\frac{+0.002}{-0.000}$	Overall Length L1 $\frac{+0.002}{-0.000}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	1.4	1-1/2	3	59000	59001	H35AL-S-30125-R.010
	1/8	.010	3/8	2	3	59008	59009	H35AL-SR-30125-R.010
	1/8	.010	1/2	2-1/2	3	82759	82760	H35AL-R-30125-R.010
	1/8	.010	5/8	2-1/2	3	87967	87968	H35AL-M-30125-R.010
	1/8	.015	1.4	1-1/2	3	59002	59003	H35AL-S-30125-R.015
	1/8	.015	3/8	2	3	59010	59011	H35AL-SR-30125-R.015
	1/8	.015	1/2	2-1/2	3	82761	82762	H35AL-R-30125-R.015
	1/8	.015	5/8	2-1/2	3	87969	87970	H35AL-M-30125-R.015
	1/8	.020	1.4	1-1/2	3	59004	59005	H35AL-S-30125-R.020
	1/8	.020	3/8	2	3	59012	59013	H35AL-SR-30125-R.020
	1/8	.020	1/2	2-1/2	3	82763	82764	H35AL-R-30125-R.020
	1/8	.020	5/8	2-1/2	3	87971	87972	H35AL-M-30125-R.020
	1/8	.030	1.4	1-1/2	3	59006	59007	H35AL-S-30125-R.030
	1/8	.030	3/8	2	3	59014	59015	H35AL-SR-30125-R.030
	1/8	.030	1/2	2-1/2	3	82765	82766	H35AL-R-30125-R.030
	1/8	.030	5/8	2-1/2	3	87983	87984	H35AL-M-30125-R.030
3/16	3/16	.010	5/16	2	3	59016	59017	H35AL-S-30187-R.010
	3/16	.010	9/16	2-1/2	3	59024	59025	H35AL-R-30187-R.010
	3/16	.010	3/4	2-1/2	3	82767	82768	H35AL-M-30187-R.010
	3/16	.010	1	2-1/2	3	87985	87986	H35AL-L-30187-R.010
	3/16	.015	5/16	2	3	59018	59019	H35AL-S-30187-R.015
	3/16	.015	9/16	2-1/2	3	59026	59027	H35AL-R-30187-R.015
	3/16	.015	3/4	2-1/2	3	82769	82770	H35AL-M-30187-R.015
	3/16	.015	1	2-1/2	3	87987	87988	H35AL-L-30187-R.015
	3/16	.020	5/16	2	3	59020	59021	H35AL-S-30187-R.020
	3/16	.020	9/16	2-1/2	3	59028	59029	H35AL-R-30187-R.020
	3/16	.020	3/4	2-1/2	3	82771	82772	H35AL-M-30187-R.020
	3/16	.020	1	2-1/2	3	87989	88000	H35AL-L-30187-R.020
	3/16	.030	5/16	2	3	59022	59023	H35AL-S-30187-R.030
	3/16	.030	9/16	2-1/2	3	59030	59031	H35AL-R-30187-R.030
	3/16	.030	3/4	2-1/2	3	82773	82774	H35AL-M-30187-R.030
	3/16	.030	1	2-1/2	3	88001	88002	H35AL-L-30187-R.030
1/4	1/4	.010	3/8	2	3	59032	59033	H35AL-S-30250-R.010
	1/4	.010	5/8	2-1/2	3	59042	59043	H35AL-R-30250-R.010
	1/4	.010	1	3	3	59052	59053	H35AL-M-30250-R.010
	1/4	.010	1-1/4	3	3	82775	82776	H35AL-L-30250-R.010
	1/4	.010	1-1/2	3	3	88003	88004	H35AL-LX-30250-R.010

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 47

3 FLUTE - CORNER RADIUS

New Items!



H35AL-3

35° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Corner Radius R $\frac{+.002}{-.002}$	Length of Cut L ₂ $\frac{+.002}{-.002}$	Overall Length L ₁ $\frac{+.002}{-.002}$	Flutes	Uncoated	Zplus Coated	Tool Description
1/4	1/4	.015	3/8	2	3	59034	59035	H35AL-S-30250-R.015
	1/4	.015	5/8	2-1/2	3	59044	59045	H35AL-R-30250-R.015
	1/4	.015	1	3	3	59054	59055	H35AL-M-30250-R.015
	1/4	.015	1-1/4	3	3	82777	82778	H35AL-L-30250-R.015
	1/4	.015	1-1/2	3	3	88005	88006	H35AL-LX-30250-R.015
	1/4	.020	3/8	2	3	59036	59037	H35AL-S-30250-R.020
	1/4	.020	5/8	2-1/2	3	59046	59047	H35AL-R-30250-R.020
	1/4	.020	1	3	3	59056	59057	H35AL-M-30250-R.020
	1/4	.020	1-1/4	3	3	82779	82780	H35AL-L-30250-R.020
	1/4	.020	1-1/2	3	3	88007	88008	H35AL-LX-30250-R.020
	1/4	.030	3/8	2	3	59038	59039	H35AL-S-30250-R.030
	1/4	.030	5/8	2-1/2	3	59048	59049	H35AL-R-30250-R.030
	1/4	.030	1	3	3	59058	59059	H35AL-M-30250-R.030
	1/4	.030	1-1/4	3	3	82781	82782	H35AL-L-30250-R.030
	1/4	.030	1-1/2	3	3	88009	88010	H35AL-LX-30250-R.030
	1/4	.060	3/8	2	3	59040	59041	H35AL-S-30250-R.060
	1/4	.060	5/8	2-1/2	3	59050	59051	H35AL-R-30250-R.060
	1/4	.060	1	3	3	59060	59061	H35AL-M-30250-R.060
	1/4	.060	1-1/4	3	3	82783	82784	H35AL-L-30250-R.060
	1/4	.060	1-1/2	3	3	88011	88012	H35AL-LX-30250-R.060
5/16	5/16	.010	7/16	2	3	59013	59014	H30AL-S-30312-R.010
	5/16	.010	5/8	2-1/2	3	59015	59016	H35AL-R-30312-R.010
	5/16	.010	1	3	3	59017	59018	H35AL-M-30312-R.010
	5/16	.020	7/16	2	3	59062	59063	H35AL-S-30312-R.020
	5/16	.020	5/8	2-1/2	3	59068	59069	H35AL-R-30312-R.020
	5/16	.020	1	3	3	59074	59075	H35AL-M-30312-R.020
	5/16	.030	7/16	2	3	59064	59065	H35AL-S-30312-R.030
	5/16	.030	5/8	2-1/2	3	59070	59071	H35AL-R-30312-R.030
	5/16	.030	1	3	3	59076	59077	H35AL-M-30312-R.030
	5/16	.060	7/16	2	3	59066	59067	H35AL-S-30312-R.060
	5/16	.060	5/8	2-1/2	3	59072	59073	H35AL-R-30312-R.060
	5/16	.060	1	3	3	59078	59079	H35AL-M-30312-R.060
3/8	3/8	.010	1/2	2	3	59080	59081	H35AL-S-30375-R.010
	3/8	.010	1	3	3	59090	59091	H35AL-R-30375-R.010
	3/8	.010	1-1/4	3-1/2	3	59100	59101	H35AL-M-30375-R.010
	3/8	.010	1-1/2	4	3	82785	82786	H35AL-L-30375-R.010
	3/8	.015	1/2	2	3	59082	59083	H35AL-S-30375-R.015
	3/8	.015	1	3	3	59092	59093	H35AL-R-30375-R.015
	3/8	.015	1-1/4	3-1/2	3	59102	59103	H35AL-M-30375-R.015
	3/8	.015	1-1/2	4	3	88019	88020	H35AL-L-30375-R.015
	3/8	.020	1/2	2	3	59084	59085	H35AL-S-30375-R.020
	3/8	.020	1	3	3	59094	59095	H35AL-R-30375-R.020
	3/8	.020	1-1/4	3-1/2	3	59104	59105	H35AL-M-30375-R.020
	3/8	.020	1-1/2	4	3	88021	88022	H35AL-L-30375-R.020
	3/8	.030	1/2	2	3	59086	59087	H35AL-S-30375-R.030
	3/8	.030	1	3	3	59096	59097	H35AL-R-30375-R.030
	3/8	.030	1-1/4	3-1/2	3	59106	59107	H35AL-M-30375-R.030
	3/8	.030	1-1/2	4	3	82787	82788	H35AL-L-30375-R.030
	3/8	.060	1/2	2	3	59088	59089	H35AL-S-30375-R.060
	3/8	.060	1	3	3	59098	59099	H35AL-R-30375-R.060
	3/8	.060	1-1/4	3-1/2	3	59108	59109	H35AL-M-30375-R.060
	3/8	.060	1-1/2	4	3	82789	82790	H35AL-L-30375-R.060

* .0003 max TIR

continued on next page

H35AL-3



New Items!

3 FLUTE - CORNER RADIUS

35° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Corner Radius R $\pm .002$ - .002	Length of Cut L ₂ $\pm .002$ - .002	Overall Length L ₁ $\pm .002$ - .002	Flutes	Uncoated	Zplus Coated	Tool Description
NEW 3/8	3/8	.090	1/2	2	3	88023	88024	H35AL-S-30375-R.090
	3/8	.090	1	3	3	88025	88026	H35AL-R-30375-R.090
	3/8	.090	1-1/4	3-1/2	3	88027	88028	H35AL-M-30375-R.090
	3/8	.090	1-1/2	4	3	88029	88030	H35AL-L-30375-R.090
	3/8	.125	1/2	2	3	88031	88032	H35AL-S-30375-R.125
	3/8	.125	1	3	3	88033	88034	H35AL-R-30375-R.125
	3/8	.125	1-1/4	3-1/2	3	88035	88036	H35AL-M-30375-R.125
	3/8	.125	1-1/2	4	3	88037	88038	H35AL-L-30375-R.125
NEW 1/2	1/2	.010	5/8	2-1/2	3	59110	59111	H35AL-S-30500-R.010
	1/2	.010	1	3	3	59124	59125	H35AL-SR-30500-R.010
	1/2	.010	1-1/4	3	3	59138	59139	H35AL-R-30500-R.010
	1/2	.010	1-5/8	4	3	59152	59153	H35AL-M-30500-R.010
	1/2	.010	2	4	3	88039	88040	H35AL-L-30500-R.010
	1/2	.015	5/8	2-1/2	3	59112	59113	H35AL-S-30500-R.015
	1/2	.015	1	3	3	59126	59127	H35AL-SR-30500-R.015
	1/2	.015	1-1/4	3	3	59140	59141	H35AL-R-30500-R.015
	1/2	.015	1-5/8	4	3	59154	59155	H35AL-M-30500-R.015
	1/2	.015	2	4	3	88041	88042	H35AL-L-30500-R.015
	1/2	.020	5/8	2-1/2	3	59114	59115	H35AL-S-30500-R.020
	1/2	.020	1	3	3	59128	59129	H35AL-SR-30500-R.020
	1/2	.020	1-1/4	3	3	59142	59143	H35AL-R-30500-R.020
	1/2	.020	1-5/8	4	3	59156	59157	H35AL-M-30500-R.020
	1/2	.020	2	4	3	82791	82792	H35AL-L-30500-R.020
	1/2	.030	5/8	2-1/2	3	59116	59117	H35AL-S-30500-R.030
	1/2	.030	1	3	3	59130	59131	H35AL-SR-30500-R.030
	1/2	.030	1-1/4	3	3	59144	59145	H35AL-R-30500-R.030
	1/2	.030	1-5/8	4	3	59158	59159	H35AL-M-30500-R.030
	1/2	.030	2	4	3	82793	82794	H35AL-L-30500-R.030
	1/2	.060	5/8	2-1/2	3	59118	59119	H35AL-S-30500-R.060
	1/2	.060	1	3	3	59132	59133	H35AL-SR-30500-R.060
	1/2	.060	1-1/4	3	3	59146	59147	H35AL-R-30500-R.060
	1/2	.060	1-5/8	4	3	59160	59161	H35AL-M-30500-R.060
	1/2	.060	2	4	3	82795	82796	H35AL-L-30500-R.060
	1/2	.090	5/8	2-1/2	3	59120	59121	H35AL-S-30500-R.090
	1/2	.090	1	3	3	59134	59135	H35AL-SR-30500-R.090
	1/2	.090	1-1/4	3	3	59148	59149	H35AL-R-30500-R.090
	1/2	.090	1-5/8	4	3	59162	59163	H35AL-M-30500-R.090
	1/2	.090	2	4	3	88043	88044	H35AL-L-30500-R.090
	1/2	.125	5/8	2-1/2	3	59122	59123	H35AL-S-30500-R.125
	1/2	.125	1	3	3	59136	59137	H35AL-SR-30500-R.125
	1/2	.125	1-1/4	3	3	59150	59151	H35AL-R-30500-R.125
	1/2	.125	1-5/8	4	3	59164	59165	H35AL-M-30500-R.125
	1/2	.125	2	4	3	82797	82798	H35AL-L-30500-R.125
NEW 5/8	5/8	.020	3/4	3	3	59166	59167	H35AL-S-30625-R.020
	5/8	.020	1-5/8	3-1/2	3	59174	59175	H35AL-R-30625-R.020
	5/8	.020	2-1/8	4	3	59182	59183	H35AL-M-30625-R.020
	5/8	.020	2-1/2	5	3	59190	59191	H35AL-L-30625-R.020
	5/8	.030	3/4	3	3	59168	59169	H35AL-S-30625-R.030
	5/8	.030	1-5/8	3-1/2	3	59176	59177	H35AL-R-30625-R.030
	5/8	.030	2-1/8	4	3	59184	59185	H35AL-M-30625-R.030
	5/8	.030	2-1/2	5	3	59192	59193	H35AL-L-30625-R.030

*.0003 max TIR

continued on next page

3 FLUTE - CORNER RADIUS

New Items!



H35AL-3

35° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Corner Radius R $\frac{+ .002"}{- .002"}$	Length of Cut L ₂ $\frac{+ .002"}{- .002"}$	Overall Length L ₁ $\frac{+ .002"}{- .002"}$	Flutes	Uncoated	Zplus Coated	Tool Description
5/8	5/8	.060	3/4	3	3	59170	59171	H35AL-S-10025-R.060
	5/8	.060	1-5/8	3-1/2	3	59178	59179	H35AL-R-10025-R.060
	5/8	.060	2-1/8	4	3	59186	59187	H35AL-M-10025-R.060
	5/8	.060	2-1/2	5	3	59194	59195	H35AL-L-10025-R.060
	5/8	.125	3/4	3	3	59172	59173	H35AL-S-10025-R.125
	5/8	.125	1-5/8	3-1/2	3	59180	59181	H35AL-R-10025-R.125
	5/8	.125	2-1/8	4	3	59188	59189	H35AL-M-10025-R.125
	5/8	.125	2-1/2	5	3	59196	59197	H35AL-L-10025-R.125
3/4	3/4	.030	1-5/8	4	3	59198	59199	H35AL-R-10750-R.030
	3/4	.030	2-1/4	5	3	59210	59211	H35AL-M-10750-R.030
	3/4	.030	3-1/4	6	3	59222	59223	H35AL-L-10750-R.030
	3/4	.030	4	6-1/2	3	82799	82800	H35AL-X-10750-R.030
	3/4	.060	1-5/8	4	3	59200	59201	H35AL-R-10750-R.060
	3/4	.060	2-1/4	5	3	59212	59213	H35AL-M-10750-R.060
	3/4	.060	3-1/4	6	3	59224	59225	H35AL-L-10750-R.060
	3/4	.060	4	6-1/2	3	82801	82802	H35AL-X-10750-R.060
	3/4	.090	1-5/8	4	3	59202	59203	H35AL-R-10750-R.090
	3/4	.090	2-1/4	5	3	59214	59215	H35AL-M-10750-R.090
	3/4	.090	3-1/4	6	3	59226	59227	H35AL-L-10750-R.090
	3/4	.125	1-5/8	4	3	59204	59205	H35AL-R-10750-R.125
	3/4	.125	2-1/4	5	3	59216	59217	H35AL-M-10750-R.125
	3/4	.125	3-1/4	6	3	59228	59229	H35AL-L-10750-R.125
	3/4	.125	4	6-1/2	3	82803	82804	H35AL-X-10750-R.125
	3/4	.190	1-5/8	4	3	59206	59207	H35AL-R-10750-R.190
	3/4	.190	2-1/4	5	3	59218	59219	H35AL-M-10750-R.190
	3/4	.190	3-1/4	6	3	59230	59231	H35AL-L-10750-R.190
	3/4	.250	1-5/8	4	3	59208	59209	H35AL-R-10750-R.250
	3/4	.250	2-1/4	5	3	59220	59221	H35AL-M-10750-R.250
	3/4	.250	3-1/4	6	3	59232	59233	H35AL-L-10750-R.250
	3/4	.250	4	6-1/2	3	82805	82806	H35AL-X-10750-R.250
1	1	.030	2	5	3	59234	59235	H35AL-R-11000-R.030
	1	.030	3-1/4	6	3	59242	59243	H35AL-L-11000-R.030
	1	.060	2	5	3	59236	59237	H35AL-R-11000-R.060
	1	.060	3-1/4	6	3	59244	59245	H35AL-L-11000-R.060
	1	.125	2	5	3	59238	59239	H35AL-R-11000-R.125
	1	.125	3-1/4	6	3	59246	59247	H35AL-L-11000-R.125
	1	.250	2	5	3	59240	59241	H35AL-R-11000-R.250
	1	.250	3-1/4	6	3	59248	59249	H35AL-L-11000-R.250

* .0003 max TIR

MH35AL-3

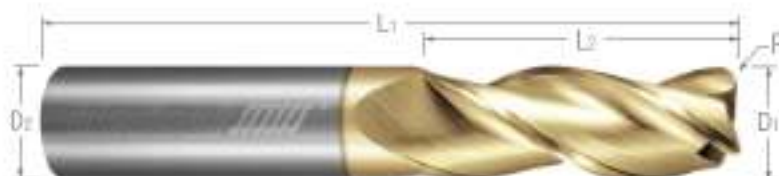
METRIC



3 FLUTE - CORNER RADIUS - METRIC

35° Helix

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for tough roughing applications with 3 flutes and 35° helix
- Cylindrically ground to maintain edge strength
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D ₁ (mm)	Shank Diameter D ₂ (mm)	Corner Radius R + .05 mm - .05 mm	LDC L ₂ + .80 mm - .02 mm	Overall Length L ₁ + 1.50 mm - 1.50 mm	Flutes	Uncoated	Zplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	3	50632	50633	MH35AL-015-30630-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	2	50728	50729	MH35AL-020-30630-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	3	50796	50797	MH35AL-030-30630-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	3	50634	50635	MH35AL-015-30630-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	2	50730	50731	MH35AL-020-30630-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	3	50798	50799	MH35AL-030-30630-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	2	50698	50699	MH35AL-015-30890-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	3	50734	50735	MH35AL-020-30890-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	3	50802	50803	MH35AL-030-30890-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	2	50700	50701	MH35AL-015-30890-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	3	50736	50737	MH35AL-020-30890-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	3	50804	50805	MH35AL-030-30890-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	2	50704	50705	MH35AL-015-31090-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	3	50740	50741	MH35AL-020-31090-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	3	50768	50769	MH35AL-025-31090-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	2	50706	50707	MH35AL-015-31090-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	3	50742	50743	MH35AL-020-31090-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	3	50770	50771	MH35AL-025-31090-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	3	50710	50711	MH35AL-015-31290-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	2	50746	50747	MH35AL-020-31290-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	3	50774	50775	MH35AL-025-31290-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	3	50712	50713	MH35AL-015-31290-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	3	50748	50749	MH35AL-020-31290-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	3	50776	50777	MH35AL-025-31290-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	2	50716	50717	MH35AL-015-31690-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	3	50752	50753	MH35AL-020-31690-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	2	50780	50781	MH35AL-025-31690-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	2	50718	50719	MH35AL-015-31690-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	3	50754	50755	MH35AL-020-31690-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	2	50782	50783	MH35AL-025-31690-R1.00
20 mm	20.00 mm	.50 mm	30.00 mm	89 mm	3	50722	50723	MH35AL-015-32090-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	3	50758	50759	MH35AL-020-32090-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	3	50786	50787	MH35AL-025-32090-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	3	50724	50725	MH35AL-015-32090-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	2	50760	50761	MH35AL-020-32090-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	3	50788	50789	MH35AL-025-32090-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	2	50764	50765	MH35AL-020-32590-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	3	50792	50793	MH35AL-025-32590-R1.00

* .008 mm max TIR



Speeds & Feeds on Page 47

3 FLUTE - SQUARE

35° Helix - Reduced Neck



H35AL-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials.
- Designed for tough roughing applications with 3 flutes and 35° helix.
- Cylindrically ground to maintain edge strength.
- Excellent performance in High Efficiency Milling (HEM).
- Center cutting.
- Reduced neck provides maximum strength in long reach and deep pocketing applications.
- h8 shank tolerance for high precision tool holders.
- Zplus coating offers higher hardness and added lubricity for maximum performance.
- Solid carbide.
- CNC ground in the USA.



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	LOC L2 ±.002 -.001	OAL L1 ±.002 -.001	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	3	1/2	.118	3	04015	04017	H35AL-RN-R-30125
	1/8	5/32	3	5/8	.118	3	81375	81376	H35AL-RN-A-30125
	1/8	5/32	3	3/4	.118	3	04030	04032	H35AL-RN-M-30125
	1/8	5/32	3	1	.118	3	81377	81378	H35AL-RN-L-30125
	1/8	5/32	3	1-1/4	.118	3	83441	83442	H35AL-RN-LX-30125
3/16	3/16	7/32	3	1/2	.178	3	04060	04062	H35AL-RN-R-30167
	3/16	7/32	3	5/8	.178	3	81379	81380	H35AL-RN-A-30167
	3/16	7/32	3	3/4	.178	3	04075	04077	H35AL-RN-M-30167
	3/16	7/32	3	1	.178	3	81381	81382	H35AL-RN-ML-30167
	3/16	7/32	3	1-5/16	.178	3	83443	83444	H35AL-RN-LX-30167
1/4	1/4	3/8	4	3/4	.237	3	04105	04107	H35AL-RN-S-30250
	1/4	3/8	4	1-1/8	.237	3	04120	04122	H35AL-RN-R-30250
	1/4	3/8	4	1-5/8	.237	3	81383	81384	H35AL-RN-A-30250
	1/4	3/8	4	2-1/8	.237	3	04135	04137	H35AL-RN-M-30250
	1/4	3/8	4	2-1/2	.237	3	81385	81386	H35AL-RN-ML-30250
	1/4	3/8	4-1/2	3	.237	3	83445	83446	H35AL-RN-L-30250
5/16	5/16	7/16	4	1-1/8	.296	3	04165	04167	H35AL-RN-R-30312
	5/16	7/16	4	1-3/4	.296	3	83447	83448	H35AL-RN-A-30312
	5/16	7/16	4	2-1/8	.296	3	04180	04182	H35AL-RN-M-30312
	5/16	7/16	6	3-1/8	.296	3	04190	04192	H35AL-RN-L-30312
	5/16	7/16	6	4	.296	3	04200	04202	H35AL-RN-X-30312
3/8	3/8	1/2	4	1-1/8	.356	3	04210	04212	H35AL-RN-R-30375
	3/8	1/2	4	1-5/8	.356	3	81387	81388	H35AL-RN-A-30375
	3/8	1/2	4	2-1/8	.356	3	04225	04227	H35AL-RN-M-30375
	3/8	1/2	5	2-1/2	.356	3	81389	81390	H35AL-RN-ML-30375
	3/8	1/2	6	3-1/8	.356	3	04235	04237	H35AL-RN-L-30375
	3/8	1/2	6	3-1/2	.356	3	83449	83450	H35AL-RN-LX-30375
	3/8	1/2	6	4	.356	3	04245	04247	H35AL-RN-X-30375
1/2	1/2	5/8	4	1-3/8	.475	3	04285	04287	H35AL-RN-R-30500
	1/2	5/8	4	1-3/4	.475	3	81391	81392	H35AL-RN-A-30500
	1/2	5/8	4	2-1/4	.475	3	04300	04302	H35AL-RN-M-30500
	1/2	5/8	4-1/2	2-3/4	.475	3	81393	81394	H35AL-RN-ML-30500
	1/2	5/8	6	3-3/8	.475	3	04315	04317	H35AL-RN-L-30500
	1/2	5/8	6	4-1/4	.475	3	04325	04327	H35AL-RN-X-30500
	1/2	5/8	7	5	.475	3	83451	83452	H35AL-RN-Y-30500

* DCC3 max TIR.

continued on next page

H35AL-RN-3



3 FLUTE - SQUARE

35° Helix - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ (#)	Shank Dia. D ₂ (#)	LOC L ₂ ± .002 - .001	OAL L ₁ ± .002 - .001	Reach (LBS) L _r	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
5/8	5/8	3/4	4	1-5/8	.593	3	04345	04347	H35AL-RN-R-30625
	5/8	3/4	6	2-3/8	.593	3	04360	04362	H35AL-RN-M-30625
	5/8	3/4	8	3-3/8	.593	3	04375	04377	H35AL-RN-L-30625
3/4	3/4	1	4	2	.712	3	04405	04407	H35AL-RN-R-30750
	3/4	1	6	2-1/2	.712	3	04420	04422	H35AL-RN-M-30750
	3/4	1	6	2-7/8	.712	3	01395	01396	H35AL-RN-ML-30750
	3/4	1	6	3-3/8	.712	3	04435	04437	H35AL-RN-L-30750
	3/4	1	6	4-2/8	.712	3	04445	04447	H35AL-RN-X-30750
1	1	1-1/4	5	2-5/8	.950	3	04465		H35AL-RN-R-31000
	1	1-1/4	6	3-3/8	.950	3	04480		H35AL-RN-M-31000
	1	1-1/4	7	4-3/8	.950	3	04495		H35AL-RN-L-31000

*.0003 max TIR

H35AL-3 / H35AL-RN-3

Material Guide		SFM	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			3/8			1/2			3/4			1		
			Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin
BROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	2190	.0007	.0013	.0016	.0011	.0019	.0018	.0014	.0025	.0020	.0021	.0038	.0023	.0027	.0050	.0027	.0039	.0022	.0033	.0050	.0041	.0039
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	1490	.0011	.0020	.0020	.0017	.0030	.0022	.0022	.0040	.0025	.0023	.0058	.0028	.0043	.0078	.0034	.0061	.0111	.0040	.0078	.0142	.0049
COPPER ALLOY	Cu-ETP, CuB2, CuZn30, CuZn36Pb3, CuZn13, CuSn5	770	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0027	.0021	.0022	.0040	.0024	.0029	.0052	.0026	.0041	.0074	.0033	.0052	.0085	.0040

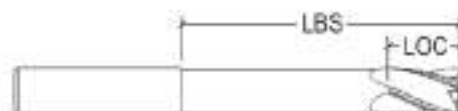
MILLING PROCESS	STYLE	ADOC	RDOC
Slot (Full Slotting)	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to Max LOC	100% Diameter
Rph (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-40% Diameter
	Reached	Up to Max LOC	30%-40% Diameter
Fin (Finishing)	Mill	Up to Max LOC	4%-6% Diameter

NOTES:

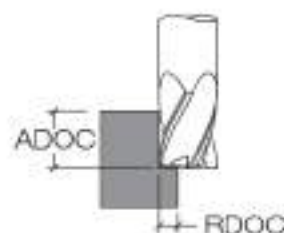
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

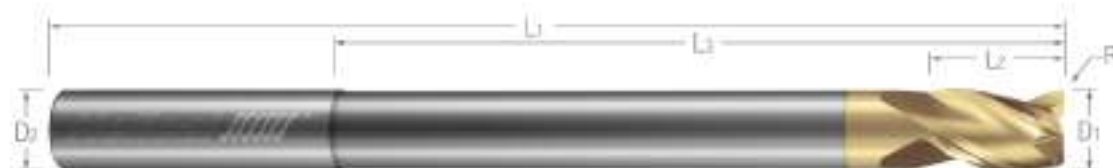
RDOC=Radial Depth of Cut

3 FLUTE - CORNER RADIUS

35° Helix - Reduced Neck


H35AL-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed for tough roughing applications with 3 flutes and 35° helix
- Cylindrically ground to maintain edge strength
- Excellent performance in High Efficiency Milling (HEM)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\frac{.002}{.003}$	Length of Cut L2 $\frac{.002}{.003}$	Overall Length L1 $\frac{.002}{.003}$	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	5/32	3	1/2	118	3	86636	86637	H35AL-RN-R-30125-R.010
	1/8	.010	5/32	3	5/8	118	3	86638	86639	H35AL-RN-A-30125-R.010
	1/8	.010	5/32	3	3/4	118	3	86640	86641	H35AL-RN-M-30125-R.010
	1/8	.010	5/32	3	1	118	3	86642	86643	H35AL-RN-L-30125-R.010
	1/8	.030	5/32	3	1/2	118	3	86644	86645	H35AL-RN-R-30125-R.030
	1/8	.030	5/32	3	5/8	118	3	86646	86647	H35AL-RN-A-30125-R.030
	1/8	.030	5/32	3	3/4	118	3	86648	86649	H35AL-RN-M-30125-R.030
	1/8	.030	5/32	3	1	118	3	86650	86651	H35AL-RN-L-30125-R.030
3/16	3/16	.010	7/32	3	1/2	178	3	86652	86653	H35AL-RN-R-30187-R.010
	3/16	.010	7/32	3	5/8	178	3	86654	86655	H35AL-RN-A-30187-R.010
	3/16	.010	7/32	3	3/4	178	3	86656	86657	H35AL-RN-M-30187-R.010
	3/16	.010	7/32	3	1	178	3	86658	86659	H35AL-RN-L-30187-R.010
	3/16	.030	7/32	3	1/2	178	3	86660	86661	H35AL-RN-R-30187-R.030
	3/16	.030	7/32	3	5/8	178	3	86662	86663	H35AL-RN-A-30187-R.030
	3/16	.030	7/32	3	3/4	178	3	86664	86665	H35AL-RN-M-30187-R.030
	3/16	.030	7/32	3	1	178	3	86666	86667	H35AL-RN-L-30187-R.030
1/4	1/4	.010	1/8	4	3/4	237	3	86668	86669	H35AL-RN-S-30250-R.010
	1/4	.010	1/8	4	1-1/8	237	3	86670	86671	H35AL-RN-R-30250-R.010
	1/4	.010	1/8	4	1-5/8	237	3	86672	86673	H35AL-RN-A-30250-R.010
	1/4	.010	1/8	4	2-1/8	237	3	86674	86675	H35AL-RN-M-30250-R.010
	1/4	.010	1/8	4	2-1/2	237	3	86676	86677	H35AL-RN-L-30250-R.010
	1/4	.030	1/8	4	3/4	237	3	86678	86679	H35AL-RN-S-30250-R.030
	1/4	.030	1/8	4	1-1/8	237	3	86680	86681	H35AL-RN-R-30250-R.030
	1/4	.030	1/8	4	1-5/8	237	3	86682	86683	H35AL-RN-A-30250-R.030
	1/4	.030	1/8	4	2-1/8	237	3	86684	86685	H35AL-RN-M-30250-R.030
	1/4	.030	1/8	4	2-1/2	237	3	86686	86687	H35AL-RN-L-30250-R.030

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 47

H35AL-RN-3



3 FLUTE - CORNER RADIUS

35° Helix - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut L ₂ $\begin{smallmatrix} +.002" \\ -.000" \end{smallmatrix}$	Overall Length L ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Reach (LBS) L ₁	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
3/8	3/8	.010	1/2	4	1-1/8	.356	3	66688	66689	H35AL-RN-R-30375-R.010
	3/8	.010	1/2	4	1-5/8	.356	3	66690	66691	H35AL-RN-A-30375-R.010
	3/8	.010	1/2	4	2-1/8	.356	3	66692	66693	H35AL-RN-M-30375-R.010
	3/8	.010	1/2	5	2-1/2	.356	3	66694	66695	H35AL-RN-ML-30375-R.010
	3/8	.010	1/2	6	3-1/8	.356	3	66696	66697	H35AL-RN-L-30375-R.010
	3/8	.030	1/2	4	1-1/8	.356	3	66698	66699	H35AL-RN-R-30375-R.030
	3/8	.030	1/2	4	1-5/8	.356	3	66700	66701	H35AL-RN-A-30375-R.030
	3/8	.030	1/2	4	2-1/8	.356	3	66702	66703	H35AL-RN-M-30375-R.030
	3/8	.030	1/2	5	2-1/2	.356	3	66704	66705	H35AL-RN-ML-30375-R.030
	3/8	.030	1/2	6	3-1/8	.356	3	66706	66707	H35AL-RN-L-30375-R.030
1/2	1/2	.030	5/8	4	1-3/8	.475	3	66708	66709	H35AL-RN-R-30500-R.030
	1/2	.030	5/8	4	1-3/4	.475	3	66710	66711	H35AL-RN-A-30500-R.030
	1/2	.030	5/8	4	2-1/4	.475	3	66712	66713	H35AL-RN-M-30500-R.030
	1/2	.030	5/8	4-1/2	2-3/4	.475	3	66714	66715	H35AL-RN-ML-30500-R.030
	1/2	.030	5/8	6	3-3/8	.475	3	66716	66717	H35AL-RN-L-30500-R.030
	1/2	.030	5/8	6	4-1/4	.475	3	66718	66719	H35AL-RN-X-30500-R.030
	1/2	.060	5/8	4	1-3/8	.475	3	66720	66721	H35AL-RN-R-30500-R.060
	1/2	.060	5/8	4	1-3/4	.475	3	66722	66723	H35AL-RN-A-30500-R.060
	1/2	.060	5/8	4	2-1/4	.475	3	66724	66725	H35AL-RN-M-30500-R.060
	1/2	.060	5/8	4-1/2	2-3/4	.475	3	66726	66727	H35AL-RN-ML-30500-R.060
	1/2	.060	5/8	6	3-3/8	.475	3	66728	66729	H35AL-RN-L-30500-R.060
	1/2	.060	5/8	6	4-1/4	.475	3	66730	66731	H35AL-RN-X-30500-R.060
3/4	3/4	.030	1	4	2	.712	3	66732	66733	H35AL-RN-R-30750-R.030
	3/4	.030	1	6	2-1/2	.712	3	66734	66735	H35AL-RN-M-30750-R.030
	3/4	.030	1	6	3-3/8	.712	3	66736	66737	H35AL-RN-L-30750-R.030
	3/4	.030	1	6	4-3/8	.712	3	66738	66739	H35AL-RN-X-30750-R.030
	3/4	.060	1	4	2	.712	3	66740	66741	H35AL-RN-R-30750-R.060
	3/4	.060	1	6	2-1/2	.712	3	66742	66743	H35AL-RN-M-30750-R.060
	3/4	.060	1	6	3-3/8	.712	3	66744	66745	H35AL-RN-L-30750-R.060
	3/4	.060	1	6	4-3/8	.712	3	66746	66747	H35AL-RN-X-30750-R.060

* .0003 max. TIR

3 FLUTE - SQUARE

New Items & Coatings!



H40ALV-3 / H40AMV-3

40° Helix - Variable Pitch

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- Wiper flat design leaves superior floor finish
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Dplus coating for superior tool life and edge retention in abrasive non-ferrous materials
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter** D1 ±.0005	Shank Diameter D2 (H8)	LOC L2 ±.002 -.000	Overall Length L1 ±.002 -.001	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
1/32	1/4	4/32	2	3	88865*	88866*		H40AMV-030-30031	new
	1/8	5/32	2	3	88867*	88868*		H40AMV-080-30031	new
3/64	1/4	5/32	2	3	88869*	88870*		H40AMV-030-30047	new
	1/8	1/4	2	3	88871*	88872*		H40AMV-080-30047	new
1/16	1/4	3/16	2	3	88873*	88874*		H40AMV-030-30062	new
	1/8	5/16	2	3	88875*	88876*		H40AMV-080-30062	new
5/64	1/4	1/4	2	3	88877*	88878*		H40AMV-030-30078	new
	1/8	3/8	2	3	88879*	88880*		H40AMV-080-30078	new
3/32	1/4	9/32	2	3	88881*	88882*		H40AMV-030-30083	new
	1/8	1/2	2	3	88883*	88884*		H40AMV-080-30083	new

Cutter Diameter** D1 (H8)	Shank Diameter D2 (H8)	LOC L2 ±.002 -.000	Overall Length L1 ±.002 -.001	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
1/8	1/8	1/4	1-1/2	3	48000	48001	87849	H40ALV-S-30125	new
	1/4	1/4	2	3	88885	88886		H40AMV-020-30125	new
	1/8	3/8	2	3	48010	48011	87850	H40ALV-SR-30125	new
	1/4	3/8	2	3	88887	88888		H40AMV-030-30125	new
	1/8	1/2	2-1/2	3	48020	48021	87851	H40ALV-R-30125	new
	1/4	1/2	2	3	88889	88890		H40AMV-040-30125	new
	1/8	5/8	2-1/2	3	82389	82390	87852	H40ALV-M-30125	new
	1/8	3/4	2-1/2	3	81397	81398		H40ALV-L-30125	
	1/8	7/8	2-1/2	3	83521	83522		H40ALV-LX-30125	
	1/8	1	2-1/2	3	86960	86961		H40ALV-X-30125	
3/16	1/4	5/16	2	3	88891	88892		H40AMV-017-30187	new
	3/16	3/8	2	3	48030	48031	87853	H40ALV-S-30187	new
	1/4	7/16	2	3	88893	88894		H40AMV-023-30187	new
	1/4	9/16	2	3	88895	88896		H40AMV-038-30187	new
	3/16	3/4	2-1/2	3	48045	48046	87854	H40ALV-R-30187	new
	1/4	3/4	2	3	88897	88898		H40AMV-048-30187	new
	3/16	1	3	3	48060	48061	87855	H40ALV-M-30187	new
	3/16	1-3/16	3	3	86962	86963		H40ALV-ML-30187	
	3/16	1-3/8	3	3	82391	82392		H40ALV-L-30187	
	3/16	1-9/16	4	3	86962	86963		H40ALV-LX-30187	

* Wiper flats not included if cutter diameter is below 1/8". ** .0003 max TIR

continued on next page

H40ALV-3 / H40AMV-3



New Items & Coating!

3 FLUTE - SQUARE

40° Helix - Variable Pitch (cont.)

continued from previous page

	Cutter Diameter** D ₁ (in)	Shank Diameter D ₂ (in)	LOC L ₂ ^{+0.03"} / _{-0.02"}	Overall Length L ₁ ^{+0.02"} / _{-0.02"}	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
new	1/4	1/4	3/8	2	3	48075	48076	87856	H40ALV-S-30250
new		1/4	1/2	2	3	81399	81400	87857	H40ALV-SR-30250
new		1/4	3/4	2-1/2	3	48115	48116	87858	H40ALV-R-30250
new		1/4	1	3	3	48125	48136	87859	H40ALV-M-30250
new		1/4	1-1/4	3	3	81401	81402	87860	H40ALV-L-30250
		1/4	1-1/2	3	3	81403	81404		H40ALV-LX-30250
		1/4	1-3/4	4	3	83523	83524		H40ALV-X-30250
		1/4	2	4	3	86064	86065		H40ALV-Y-30250
new	5/16	5/16	7/16	2	3	81405	81406	87861	H40ALV-S-30312
new		5/16	3/4	2-1/2	3	81407	81408	87862	H40ALV-R-30312
new		5/16	1	3	3	81409	81410	87863	H40ALV-M-30312
		5/16	1-1/4	3	3	82393	82394		H40ALV-L-30312
		5/16	1-3/16	4	3	86066	86067		H40ALV-LX-30312
new	3/8	3/8	1/2	2	3	48235	48236	87864	H40ALV-S-30375
new		3/8	3/4	2-1/2	3	81411	81412	87865	H40ALV-SR-30375
new		3/8	1	2-1/2	3	48260	48261	87866	H40ALV-R-30375
new		3/8	1-1/4	3	3	81413	81414	87867	H40ALV-M-30375
new		3/8	1-1/2	3-1/2	3	48310	48311	87868	H40ALV-L-30375
		3/8	2	4	3	82395	82396		H40ALV-LX-30375
		3/8	2-1/2	5	3	86068	86069		H40ALV-X-30375
new	1/2	1/2	5/8	2-1/2	3	48335	48336	87869	H40ALV-S-30500
new		1/2	1	3	3	48345	48346	87870	H40ALV-SR-30500
new		1/2	1-1/4	3	3	48395	48396	87871	H40ALV-R-30500
new		1/2	1-5/8	4	3	48425	48426	87872	H40ALV-M-30500
new		1/2	2	4	3	48455	48456	87873	H40ALV-L-30500
		1/2	2-1/2	5	3	81415	81416		H40ALV-LX-30500
		1/2	3-1/8	6	3	82397	82398		H40ALV-X-30500
		1/2	3-5/8	6	3	86070	86071		H40ALV-Y-30500
new	5/8	5/8	3/4	3	3	48485	48486	87874	H40ALV-S-30625
new		5/8	1-1/4	3-1/2	3	48510	48511	87875	H40ALV-SR-30625
new		5/8	1-5/8	4	3	48535	48536	87876	H40ALV-R-30625
		5/8	2	4	3	82399	82400		H40ALV-M-30625
		5/8	2-1/2	5	3	86064	86065		H40ALV-ML-30625
new	3/4	3/4	1	3	3	48545	48546	87877	H40ALV-S-30750
new		3/4	1-5/8	4	3	48620	48621	87878	H40ALV-R-30750
new		3/4	2-1/4	5	3	48655	48656	87879	H40ALV-M-30750
new		3/4	2-3/4	5	3	81417	81418	87880	H40ALV-ML-30750
		3/4	3-1/4	6	3	83525	83526		H40ALV-L-30750
		3/4	4	6-1/2	3	86066	86067		H40ALV-LX-30750
new	1	1	1-1/4	4	3	48690	48691	87881	H40ALV-S-31000
new		1	2	5	3	48725	48726	87882	H40ALV-R-31000
new		1	3-1/4	6	3	48760	48761	87883	H40ALV-M-31000
		1	4-1/4	7	3	86072	86073		H40ALV-L-31000

* Wiper flats not included if cutter diameter is below 1/8". ** .0003 max TIR

3 FLUTE - BALL

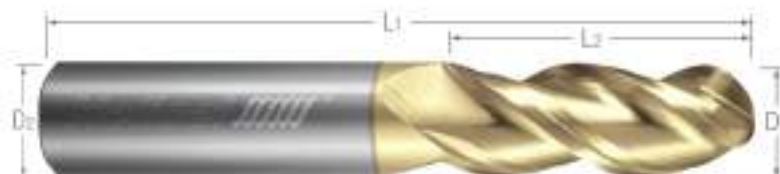
New Items & Coatings!



H40ALV-3

40° Helix - Variable Pitch

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- H6 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Dplus coating for superior tool life and edge retention in abrasive non-ferrous materials
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Diameter** D1 (in)	Shank Diameter D2 (in)	LDC L2 ^{+0.002} / _{-0.001}	Overall Length L1 ^{+0.02} / _{-0.02}	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
1/8	1/8	1/4	1-1/2	3	49030*	49031*	67814*	H40ALV-S-30125-BN	new
	1/8	3/8	2	3	49035*	49036*	67815*	H40ALV-SR-30125-BN	new
	1/8	1/2	2-1/2	3	49040*	49041*	67816*	H40ALV-R-30125-BN	new
	1/8	5/8	2-1/2	3	82453*	82454*	67817*	H40ALV-M-30125-BN	new
	1/8	3/4	2-1/2	3	81455*	81456*		H40ALV-L-30125-BN	
	1/8	7/8	2-1/2	3	86074*	86075*		H40ALV-LX-30125-BN	
	1/8	1	2-1/2	3	86068*	86069*		H40ALV-X-30125-BN	
3/16	3/16	3/8	2	3	49050*	49051*	67818*	H40ALV-S-30187-BN	new
	3/16	3/4	2-1/2	3	49060*	49061*	67819*	H40ALV-R-30187-BN	new
	3/16	1	3	3	49065*	49066*	67820*	H40ALV-M-30187-BN	new
	3/16	1-3/16	3	3	86070*	86071*		H40ALV-ML-30187-BN	
	3/16	1-3/8	3	3	82455*	82456*		H40ALV-L-30187-BN	
	3/16	1-9/16	4	3	86076*	86077*		H40ALV-LX-30187-BN	
1/4	1/4	3/8	2	3	49075	49076	67821	H40ALV-S-30250-BN	new
	1/4	1/2	2	3	81457	81458	67822	H40ALV-SR-30250-BN	new
	1/4	3/4	2-1/2	3	49105	49106	67823	H40ALV-R-30250-BN	new
	1/4	1	3	3	49120	49121	67824	H40ALV-M-30250-BN	new
	1/4	1-1/4	3	3	81459	81460	67825	H40ALV-L-30250-BN	new
	1/4	1-1/2	3	3	82457	82458		H40ALV-LX-30250-BN	
	1/4	1-3/4	4	3	86078	86079		H40ALV-X-30250-BN	
	1/4	2	4	3	86972	86973		H40ALV-Y-30250-BN	
5/16	5/16	7/16	2	3	81461	81462	67826	H40ALV-S-30312-BN	new
	5/16	3/4	2-1/2	3	81463	81464	67827	H40ALV-R-30312-BN	new
	5/16	1	3	3	82459	82460	67828	H40ALV-M-30312-BN	new
	5/16	1-1/4	3	3	86080	86081		H40ALV-L-30312-BN	
	5/16	1-9/16	4	3	86974	86975		H40ALV-LX-30312-BN	

* 1/8 and 3/16 have 1 tooth to center ** .0003 max TR

continued on next page



Speeds & Feeds on Page 65

H40ALV-3



New Items & Coating!

3 FLUTE - BALL

40° Helix - Variable Pitch (cont.)

continued from previous page

Cutter Diameter** D ₁ (in)	Shank Diameter D ₂ (in)	LOC L ₂ + .002" - .000"	Overall Length L ₁ + .300" - .000"	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
3/8	3/8	1/2	2	3	49195	49196	\$7829	H40ALV-S-30375-BN
	3/8	3/4	2-1/2	3	82461	82462	\$7830	H40ALV-SR-30375-BN
	3/8	1	2-1/2	3	49210	49211	\$7831	H40ALV-R-30375-BN
	3/8	1-1/4	3	3	81465	81466	\$7832	H40ALV-M-30375-BN
	3/8	1-1/2	3-1/2	3	49240	49241	\$7833	H40ALV-L-30375-BN
	3/8	2	4	3	82463	82464		H40ALV-LX-30375-BN
	3/8	2-1/2	5	3	86082	86083		H40ALV-X-30375-BN
1/2	1/2	5/8	2-1/2	3	49255	49256	\$7834	H40ALV-S-30500-BN
	1/2	1	3	3	49270	49271	\$7835	H40ALV-SR-30500-BN
	1/2	1-1/4	3	3	49285	49286	\$7836	H40ALV-R-30500-BN
	1/2	1-5/8	4	3	49300	49301	\$7837	H40ALV-M-30500-BN
	1/2	2	4	3	49315	49316	\$7838	H40ALV-L-30500-BN
	1/2	2-1/2	5	3	82465	82466		H40ALV-LX-30500-BN
	1/2	3-1/8	6	3	86076	86077		H40ALV-X-30500-BN
5/8	5/8	3/4	3	3	49330	49331	\$7839	H40ALV-S-30625-BN
	5/8	1-1/4	3-1/2	3	49345	49346	\$7840	H40ALV-SR-30625-BN
	5/8	1-5/8	4	3	49360	49361	\$7841	H40ALV-R-30625-BN
	5/8	2	4	3	86078	86079		H40ALV-M-30625-BN
3/4	3/4	1	3	3	49390	49391	\$7842	H40ALV-S-30750-BN
	3/4	1-5/8	4	3	49405	49406	\$7843	H40ALV-R-30750-BN
	3/4	2-1/4	5	3	49420	49421	\$7844	H40ALV-M-30750-BN
	3/4	2-3/4	5	3	82467	82468	\$7845	H40ALV-ML-30750-BN
	3/4	3-1/4	6	3	86084	86085		H40ALV-L-30750-BN
1	1	1-1/4	4	3	49435	49436	\$7846	H40ALV-S-31000-BN
	1	2	5	3	49450	49451	\$7847	H40ALV-R-31000-BN
	1	3-1/4	6	3	49465	49466	\$7848	H40ALV-M-31000-BN
	1	4-1/4	7	3	86086	86087		H40ALV-L-31000-BN

*1/8 and 3/16 have 1 tooth to center ** .0003 max TIR

Experience the Benefits of Helical's New Dplus Coating!

In The Loupe
RESEARCH & ANALYSIS

Dplus is our newest innovation for superior tool life in non-ferrous alloys. Its tetrahedral amorphous carbon (taC) bond structure represents an advanced leap, delivering remarkable enhancements in tool life compared to conventional DLC coatings.

Featuring an exceptionally low coefficient of friction and extremely high hardness, this coating maintains a sharp cutting edge, while still resisting abrasion, making it outperformed only by CVD diamond itself. Experience outstanding tool life in materials ranging from aerospace aluminum all the way to graphite or abrasive composites, with this new premium coating.



SCAN TO READ

www.harveyprecision.com/in-the-loupe/dplus-coating/

3 FLUTE - CORNER RADIUS

New Items & Coating!



H40ALV-3 / H40AMV-3

40° Helix - Variable Pitch

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- Wiper flat design leaves superior floor finish
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h6 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Dplus coating for superior tool life and edge retention in abrasive non-ferrous materials
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



H40AMV series features enlarged shanks for added strength

Cutter Dia.** D1 (+.0005/-0.0005)	Shank Dia. D2 (h6)	Corner Radius R (+.001/-0.001)	LOC L1 (+.010/-0.000)	OAL L2 (+.062/-0.000)	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
1/32	1/4	.005	4/43	2	3	88817*	88818*		H40AMV-030-30031-R.005	new
	1/4	.005	5/32	2	3	88819*	88820*		H40AMV-050-30031-R.005	new
3/64	1/4	.010	5/32	2	3	88821*	88822*		H40AMV-030-30047-R.010	new
	1/4	.010	1/4	2	3	88823*	88824*		H40AMV-050-30047-R.010	new
1/16	1/4	.010	3/16	2	3	88825*	88826*		H40AMV-030-30052-R.010	new
	1/4	.010	5/16	2	3	88827*	88828*		H40AMV-050-30052-R.010	new
5/64	1/4	.010	1/4	2	3	88829*	88830*		H40AMV-030-30078-R.010	new
	1/4	.010	3/8	2	3	88831*	88832*		H40AMV-040-30078-R.010	new
3/32	1/4	.010	5/32	2	3	88833*	88834*		H40AMV-030-30093-R.010	new
	1/4	.010	1/2	2	3	88835*	88836*		H40AMV-050-30093-R.010	new

Cutter Dia.** D1 (h6)	Shank Dia. D2 (h6)	Corner Radius R (+.002/-0.002)	LOC L1 (+.020/-0.000)	OAL L2 (+.062/-0.000)	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description	
1/8	1/8	.010	1/4	1-1/2	3	82401	82402	87884	H40ALV-S-30125-R.010	new
	1/4	.010	1/4	2	3	88837	88838		H40AMV-020-30125-R.010	new
	1/8	.010	3/8	2	3	82403	82404	87885	H40ALV-SR-30125-R.010	new
	1/4	.010	3/8	2	3	88839	88840		H40AMV-030-30125-R.010	new
	1/8	.010	1/2	2-1/2	3	82405	82406	87886	H40ALV-R-30125-R.010	new
	1/4	.010	1/2	2	3	88841	88842		H40AMV-040-30125-R.010	new
	1/8	.010	5/8	2-1/2	3	86088	86089	87887	H40ALV-M-30125-R.010	new
	1/8	.015	1/4	1-1/2	3	48085	48086	87888	H40ALV-S-30125-R.015	new
	1/8	.015	3/8	2	3	48015	48016	87889	H40ALV-SR-30125-R.015	new
	1/8	.015	1/2	2-1/2	3	48025	48026	87890	H40ALV-R-30125-R.015	new
	1/8	.015	5/8	2-1/2	3	82407	82408	87891	H40ALV-M-30125-R.015	new
	1/8	.015	3/4	2-1/2	3	86090	86091		H40ALV-L-30125-R.015	
	1/8	.020	1/4	1-1/2	3	86090	86091		H40ALV-S-30125-R.020	
	1/8	.020	3/8	2	3	86092	86093		H40ALV-SR-30125-R.020	
	1/8	.020	1/2	2-1/2	3	86094	86095		H40ALV-R-30125-R.020	
	1/8	.030	1/4	1-1/2	3	81419*	81420*	87892*	H40ALV-S-30125-R.030	new
	1/4	.030	1/4	2	3	88843	88844		H40AMV-020-30125-R.030	new
	1/8	.030	3/8	2	3	81421*	81422*	87893*	H40ALV-SR-30125-R.030	new
	1/4	.030	3/8	2	3	88845	88846		H40AMV-030-30125-R.030	new
	1/8	.030	1/2	2-1/2	3	81423*	81424*	87894*	H40ALV-R-30125-R.030	new
	1/4	.030	1/2	2	3	88847	88848		H40AMV-040-30125-R.030	new
	1/8	.030	5/8	2-1/2	3	82409*	82410*	87895*	H40ALV-M-30125-R.030	new
	1/8	.030	3/4	2-1/2	3	86096*	86097*		H40ALV-L-30125-R.030	
	1/8	.030	7/8	2-1/2	3	86082*	86083*		H40ALV-LX-30125-R.030	

* Wiper flats not included if corner radius exceeds 20% of tool diameter or cutter diameter is below 1/8". **.0003 max TIR

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Speeds & Feeds on Page 65

H40ALV-3 / H40AMV-3



New Items & New Coatings!

3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch (cont.)

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Cutter Dia.** D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R $\pm \frac{.001}{.002}$	LOC L ₂ $\pm \frac{.001}{.002}$	OAL L ₁ $\pm \frac{.002}{.002}$	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
new	3/16	1/4 .010	5/16	2	3	88849	88850		H40AMV-017-30187-R.010
		3/16 .010	3/8	2	3	88896	88899		H40ALV-S-30187-R.010
		1/4 .010	7/16	2	3	88851	88852		H40AMV-023-30187-R.010
		1/4 .010	9/16	2	3	88853	88854		H40AMV-030-30187-R.010
		3/16 .010	3/4	2-1/2	3	86100	86101		H40ALV-R-30187-R.010
		1/4 .010	3/4	2	3	88855	88856		H40AMV-040-30187-R.010
		3/16 .010	1	3	3	86102	86103		H40ALV-M-30187-R.010
		3/16 .015	3/8	2	3	48035	48036	87896	H40ALV-S-30187-R.015
		3/16 .015	3/4	2-1/2	3	48050	48051	87897	H40ALV-R-30187-R.015
		3/16 .015	1	3	3	48065	48066	87898	H40ALV-M-30187-R.015
		3/16 .015	1-3/8	3	3	82411	82412		H40ALV-L-30187-R.015
		3/16 .020	3/8	2	3	86104	86105		H40ALV-S-30187-R.020
		3/16 .020	3/4	2-1/2	3	86106	86107		H40ALV-R-30187-R.020
		3/16 .020	1	3	3	86108	86109		H40ALV-M-30187-R.020
		1/4 .030	5/16	2	3	88857	88858		H40AMV-017-30187-R.030
		3/16 .030	3/8	2	3	48040	48041	87900	H40ALV-S-30187-R.030
		1/4 .030	7/16	2	3	88859	88860		H40AMV-023-30187-R.030
		1/4 .030	9/16	2	3	88861	88862		H40AMV-030-30187-R.030
		3/16 .030	3/4	2-1/2	3	48055	48056	87900	H40ALV-R-30187-R.030
		1/4 .030	3/4	2	3	88863	88864		H40AMV-040-30187-R.030
		3/16 .030	1	3	3	48070	48071	87901	H40ALV-M-30187-R.030
		3/16 .030	1-3/8	3	3	82413	82414		H40ALV-L-30187-R.030
new	1/4	1/4 .010	3/8	2	3	82415	82416		H40ALV-S-30250-R.010
		1/4 .010	1/2	2	3	86110	86111		H40ALV-SR-30250-R.010
		1/4 .010	3/4	2-1/2	3	82417	82418		H40ALV-R-30250-R.010
		1/4 .010	1	3	3	82419	82420		H40ALV-M-30250-R.010
		1/4 .010	1-1/4	3	3	86884	86885		H40ALV-L-30250-R.010
		1/4 .010	1-1/2	3	3	86886	86887		H40ALV-LX-30250-R.010
		1/4 .015	3/8	2	3	48080	48081	87902	H40ALV-S-30250-R.015
		1/4 .015	1/2	2	3	81425	81426	87903	H40ALV-SR-30250-R.015
		1/4 .015	3/4	2-1/2	3	48120	48121	87904	H40ALV-R-30250-R.015
		1/4 .015	1	3	3	48140	48141	87905	H40ALV-M-30250-R.015
		1/4 .015	1-1/4	3	3	82421	82422	87906	H40ALV-L-30250-R.015
		1/4 .015	1-1/2	3	3	86888	86889		H40ALV-LX-30250-R.015
		1/4 .020	3/8	2	3	86112	86113		H40ALV-S-30250-R.020
		1/4 .020	1/2	2	3	86114	86115		H40ALV-SR-30250-R.020
		1/4 .020	3/4	2-1/2	3	86116	86117		H40ALV-R-30250-R.020
		1/4 .020	1	3	3	86118	86119		H40ALV-M-30250-R.020
		1/4 .020	1-1/4	3	3	86990	86991		H40ALV-L-30250-R.020
		1/4 .020	1-1/2	3	3	86992	86993		H40ALV-LX-30250-R.020
		1/4 .030	3/8	2	3	48085	48086	87907	H40ALV-S-30250-R.030
		1/4 .030	1/2	2	3	81427	81428	87908	H40ALV-SR-30250-R.030
		1/4 .030	3/4	2-1/2	3	48125	48126	87909	H40ALV-R-30250-R.030
		1/4 .030	1	3	3	48145	48146	87910	H40ALV-M-30250-R.030
		1/4 .030	1-1/4	3	3	82423	82424	87911	H40ALV-L-30250-R.030
		1/4 .030	1-1/2	3	3	86994	86995		H40ALV-LX-30250-R.030
		1/4 .060	3/8	2	3	48090*	48091*	87912*	H40ALV-S-30250-R.060
		1/4 .060	1/2	2	3	81429*	81430*	87913*	H40ALV-SR-30250-R.060
		1/4 .060	3/4	2-1/2	3	48130*	48131*	87914*	H40ALV-R-30250-R.060
		1/4 .060	1	3	3	48150*	48151*	87915*	H40ALV-M-30250-R.060
		1/4 .060	1-1/4	3	3	82425*	82426*	87916*	H40ALV-L-30250-R.060
		1/4 .060	1-1/2	3	3	86996*	86997*		H40ALV-LX-30250-R.060

* Wiper flats not included if corner radius exceeds 20% of tool diameter or cutter diameter is below 1/8". **.0003 max. TIR

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3 FLUTE - CORNER RADIUS

New Items & Coating!



H40ALV-3 / H40AMV-3

40° Helix - Variable Pitch (cont.)

continued from previous page

Cutter Dia.** D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R ^{+0.02"} _{-0.02"}	LOC L ₁ ^{+0.02"} _{-0.02"}	OAL L ₁ ^{+0.02"} _{-0.02"}	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
5/16	5/16	.010	7/16	2	3	86120	86121		H40ALV-S-30312-R.010
	5/16	.010	3/4	2-1/2	3	86122	86123		H40ALV-R-30312-R.010
	5/16	.010	1	3	3	86124	86125		H40ALV-M-30312-R.010
	5/16	.010	1-1/4	3	3	86998	86999		H40ALV-L-30312-R.010
	5/16	.030	7/16	2	3	86126	86127		H40ALV-S-30312-R.030
	5/16	.030	3/4	2-1/2	3	86128	86129		H40ALV-R-30312-R.030
	5/16	.030	1	3	3	86130	86131		H40ALV-M-30312-R.030
	5/16	.030	1-1/4	3	3	87000	87001		H40ALV-L-30312-R.030
	5/16	.060	7/16	2	3	86132	86133		H40ALV-S-30312-R.060
	5/16	.060	3/4	2-1/2	3	86134	86135		H40ALV-R-30312-R.060
	5/16	.060	1	3	3	86136	86137		H40ALV-M-30312-R.060
	5/16	.060	1-1/4	3	3	87002	87003		H40ALV-L-30312-R.060
3/8	3/8	.010	1/2	2	3	81431	81432	87917	H40ALV-S-30375-R.010
	3/8	.010	3/4	2-1/2	3	83527	83528	87918	H40ALV-SR-30375-R.010
	3/8	.010	1	2-1/2	3	81433	81434	87919	H40ALV-R-30375-R.010
	3/8	.010	1-1/4	3	3	87004	87005	87920	H40ALV-M-30375-R.010
	3/8	.010	1-1/2	3-1/2	3	81435	81436	87921	H40ALV-L-30375-R.010
	3/8	.010	2	4	3	87006	87007		H40ALV-LX-30375-R.010
	3/8	.015	1/2	2	3	48240	48241	87922	H40ALV-S-30375-R.015
	3/8	.015	3/4	2-1/2	3	81437	81438	87923	H40ALV-SR-30375-R.015
	3/8	.015	1	2-1/2	3	48265	48266	87924	H40ALV-R-30375-R.015
	3/8	.015	1-1/4	3	3	87008	87009	87925	H40ALV-M-30375-R.015
	3/8	.015	1-1/2	3-1/2	3	48315	48316	87926	H40ALV-L-30375-R.015
	3/8	.015	2	4	3	82427	82428		H40ALV-LX-30375-R.015
	3/8	.020	1/2	2	3	86138	86139		H40ALV-S-30375-R.020
	3/8	.020	3/4	2-1/2	3	87010	87011		H40ALV-SR-30375-R.020
	3/8	.020	1	2-1/2	3	86140	86141		H40ALV-R-30375-R.020
	3/8	.020	1-1/4	3	3	87012	87013		H40ALV-M-30375-R.020
	3/8	.020	1-1/2	3-1/2	3	86142	86143		H40ALV-L-30375-R.020
	3/8	.020	2	4	3	87014	87015		H40ALV-LX-30375-R.020
	3/8	.020	1/2	2	3	48245	48246	87927	H40ALV-S-30375-R.020
	3/8	.020	3/4	2-1/2	3	81439	81440	87928	H40ALV-SR-30375-R.020
	3/8	.020	1	2-1/2	3	48270	48271	87929	H40ALV-R-30375-R.020
	3/8	.020	1-1/4	3	3	87016	87017	87930	H40ALV-M-30375-R.020
	3/8	.020	1-1/2	3-1/2	3	48320	48321	87931	H40ALV-L-30375-R.020
	3/8	.020	2	4	3	82429	82430		H40ALV-LX-30375-R.020
	3/8	.060	1/2	2	3	48250	48251	87932	H40ALV-S-30375-R.060
	3/8	.060	3/4	2-1/2	3	81441	81442	87933	H40ALV-SR-30375-R.060
	3/8	.060	1	2-1/2	3	48275	48276	87934	H40ALV-R-30375-R.060
	3/8	.060	1-1/4	3	3	87018	87019	87935	H40ALV-M-30375-R.060
	3/8	.060	1-1/2	3-1/2	3	48325	48326	87936	H40ALV-L-30375-R.060
	3/8	.060	2	4	3	82431	82432		H40ALV-LX-30375-R.060
	3/8	.090	1/2	2	3	48255*	48256*		H40ALV-S-30375-R.090
	3/8	.090	3/4	2-1/2	3	81443*	81444*		H40ALV-SR-30375-R.090
	3/8	.090	1	2-1/2	3	48280*	48281*		H40ALV-R-30375-R.090
	3/8	.090	1-1/4	3	3	87020*	87021*		H40ALV-M-30375-R.090
	3/8	.090	1-1/2	3-1/2	3	48330*	48331*		H40ALV-L-30375-R.090
	3/8	.090	2	4	3	82433*	82434*		H40ALV-LX-30375-R.090
	3/8	.125	1/2	2	3	83529*	83530*		H40ALV-S-30375-R.125
	3/8	.125	3/4	2-1/2	3	83531*	83532*		H40ALV-SR-30375-R.125
	3/8	.125	1	2-1/2	3	83533*	83534*		H40ALV-R-30375-R.125
	3/8	.125	1-1/4	3	3	87022*	87023*		H40ALV-M-30375-R.125
	3/8	.125	1-1/2	3-1/2	3	83535*	83536*		H40ALV-L-30375-R.125
	3/8	.125	2	4	3	83537*	83538*		H40ALV-LX-30375-R.125

* Wiper flats not included if corner radius exceeds 20% of tool diameter or cutter diameter is below 1/8". ** .0003 max TIR.

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H40ALV-3 / H40AMV-3



New Items & Coating!

3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch (cont.)

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Cutter Dia.** D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R ± .002 / .002	LOC L ₂ ± .002 / .002	OAL L ₁ ± .002 / .002	Flutes	Uncoated	Zplus Coated	New Dplus Coated	Tool Description
1/2	1/2	.010	5/8	2-1/2	3	81445	81446		H40ALV-S-30500-R.010
	1/2	.010	1	3	3	81447	81448		H40ALV-SR-30500-R.010
	1/2	.010	1-1/4	3	3	81449	81450		H40ALV-R-30500-R.010
	1/2	.010	1-5/8	4	3	81451	81452		H40ALV-M-30500-R.010
	1/2	.010	2	4	3	81453	81454		H40ALV-L-30500-R.010
	1/2	.010	2-1/2	5	3	87024	87025		H40ALV-LX-30500-R.010
	1/2	.015	5/8	2-1/2	3	48340	48341	87937	H40ALV-S-30500-R.015
	1/2	.015	1	3	3	48370	48371	87938	H40ALV-SR-30500-R.015
	1/2	.015	1-1/4	3	3	48400	48401	87939	H40ALV-R-30500-R.015
	1/2	.015	1-5/8	4	3	48430	48431	87940	H40ALV-M-30500-R.015
	1/2	.015	2	4	3	48460	48461	87941	H40ALV-L-30500-R.015
	1/2	.015	2-1/2	5	3	82435	82436		H40ALV-LX-30500-R.015
	1/2	.015	3-1/8	6	3	87028	87029		H40ALV-X-30500-R.015
	1/2	.020	5/8	2-1/2	3	83539	83540		H40ALV-S-30500-R.020
	1/2	.020	1	3	3	83541	83542		H40ALV-SR-30500-R.020
	1/2	.020	1-1/4	3	3	83543	83544		H40ALV-R-30500-R.020
	1/2	.020	1-5/8	4	3	83545	83546		H40ALV-M-30500-R.020
	1/2	.020	2	4	3	83547	83548		H40ALV-L-30500-R.020
	1/2	.020	2-1/2	5	3	87026	87027		H40ALV-LX-30500-R.020
	1/2	.030	5/8	2-1/2	3	48345	48346	87942	H40ALV-S-30500-R.030
	1/2	.030	1	3	3	48375	48376	87943	H40ALV-SR-30500-R.030
	1/2	.030	1-1/4	3	3	48405	48406	87944	H40ALV-R-30500-R.030
	1/2	.030	1-5/8	4	3	48435	48436	87945	H40ALV-M-30500-R.030
	1/2	.030	2	4	3	48465	48466	87946	H40ALV-L-30500-R.030
	1/2	.030	2-1/2	5	3	82437	82438		H40ALV-LX-30500-R.030
	1/2	.030	3-1/8	6	3	87030	87031		H40ALV-X-30500-R.030
	1/2	.060	5/8	2-1/2	3	48350	48351	87947	H40ALV-S-30500-R.060
	1/2	.060	1	3	3	48380	48381	87948	H40ALV-SR-30500-R.060
	1/2	.060	1-1/4	3	3	48410	48411	87949	H40ALV-R-30500-R.060
	1/2	.060	1-5/8	4	3	48440	48441	87950	H40ALV-M-30500-R.060
	1/2	.060	2	4	3	48470	48471	87951	H40ALV-L-30500-R.060
	1/2	.060	2-1/2	5	3	82439	82440		H40ALV-LX-30500-R.060
	1/2	.060	3-1/8	6	3	87032	87033		H40ALV-X-30500-R.060
	1/2	.090	5/8	2-1/2	3	48355	48356		H40ALV-S-30500-R.090
	1/2	.090	1	3	3	48385	48386		H40ALV-SR-30500-R.090
	1/2	.090	1-1/4	3	3	48415	48416		H40ALV-R-30500-R.090
	1/2	.090	1-5/8	4	3	48445	48446		H40ALV-M-30500-R.090
	1/2	.090	2	4	3	48475	48476		H40ALV-L-30500-R.090
	1/2	.090	2-1/2	5	3	82441	82442		H40ALV-LX-30500-R.090
	1/2	.125	5/8	2-1/2	3	48360*	48361*	87952*	H40ALV-S-30500-R.125
	1/2	.125	1	3	3	48390*	48391*	87953*	H40ALV-SR-30500-R.125
	1/2	.125	1-1/4	3	3	48420*	48421*	87954*	H40ALV-R-30500-R.125
	1/2	.125	1-5/8	4	3	48450*	48451*	87955*	H40ALV-M-30500-R.125
	1/2	.125	2	4	3	48480*	48481*	87956*	H40ALV-L-30500-R.125
	1/2	.125	2-1/2	5	3	82443*	82444*		H40ALV-LX-30500-R.125
	1/2	.125	3-1/8	6	3	87034	87035		H40ALV-X-30500-R.125
5/8	5/8	.015	3/4	3	3	87036	87037		H40ALV-S-30625-R.015
	5/8	.015	1-1/4	3-1/2	3	87038	87039		H40ALV-SR-30625-R.015
	5/8	.015	1-5/8	4	3	87040	87041		H40ALV-R-30625-R.015
	5/8	.015	2	4	3	87042	87043		H40ALV-M-30625-R.015
	5/8	.030	3/4	3	3	48490	48491	87957	H40ALV-S-30625-R.030
	5/8	.030	1-1/4	3-1/2	3	48515	48516	87958	H40ALV-SR-30625-R.030
	5/8	.030	1-5/8	4	3	48540	48541	87959	H40ALV-R-30625-R.030
	5/8	.030	2	4	3	82445	82446		H40ALV-M-30625-R.030

* Wiper flats not included if corner radius exceeds 20% of tool diameter or outer diameter is below 1/8". **, .0003 max TIR

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3 FLUTE - CORNER RADIUS

New Items & Coating!



H40ALV-3 / H40AMV-3

40° Helix - Variable Pitch (cont.)

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Cutter Dia.** D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\frac{.002}{.002}$	LOC L ₁ $\frac{.002}{.002}$	OAL L ₁ $\frac{.002}{.002}$	Flutes	Uncoated	Zplus Coated	New Optus Coated	Tool Description
5/8	5/8	.060	3/4	3	3	48495	48496		H40ALV-S-30625-R.060
	5/8	.060	1-1/4	3-1/2	3	48520	48521		H40ALV-SR-30625-R.060
	5/8	.060	1-5/8	4	3	48545	48546		H40ALV-R-30625-R.060
	5/8	.060	2	4	3	87044	87045		H40ALV-M-30625-R.060
	5/8	.090	3/4	3	3	48500	48501		H40ALV-S-30625-R.090
	5/8	.090	1-1/4	3-1/2	3	48525	48526		H40ALV-SR-30625-R.090
	5/8	.090	1-5/8	4	3	48550	48551		H40ALV-R-30625-R.090
	5/8	.090	2	4	3	87046	87047		H40ALV-M-30625-R.090
	5/8	.125	3/4	3	3	48505	48506		H40ALV-S-30625-R.125
	5/8	.125	1-1/4	3-1/2	3	48530	48531		H40ALV-SR-30625-R.125
	5/8	.125	1-5/8	4	3	48555	48556		H40ALV-R-30625-R.125
	5/8	.125	2	4	3	82447	82448		H40ALV-M-30625-R.125
3/4	3/4	.015	1	3	3	83549	83550		H40ALV-S-30750-R.015
	3/4	.015	1-5/8	4	3	83551	83552		H40ALV-R-30750-R.015
	3/4	.015	2-1/4	5	3	83553	83554		H40ALV-M-30750-R.015
	3/4	.015	2-3/4	5	3	87048	87049		H40ALV-ML-30750-R.015
	3/4	.020	1	3	3	87050	87051		H40ALV-S-30750-R.020
	3/4	.020	1-5/8	4	3	87052	87053		H40ALV-R-30750-R.020
	3/4	.020	2-1/4	5	3	87054	87055		H40ALV-M-30750-R.020
	3/4	.020	2-3/4	5	3	87056	87057		H40ALV-ML-30750-R.020
	3/4	.030	1	3	3	48590	48591	87960	H40ALV-S-30750-R.030 new
	3/4	.030	1-5/8	4	3	48625	48626	87961	H40ALV-R-30750-R.030 new
	3/4	.030	2-1/4	5	3	48630	48631	87962	H40ALV-M-30750-R.030 new
	3/4	.030	2-3/4	5	3	82449	82450	87963	H40ALV-ML-30750-R.030 new
	3/4	.060	1	3	3	48595	48596	87964	H40ALV-S-30750-R.060 new
	3/4	.060	1-5/8	4	3	48630	48631	87965	H40ALV-R-30750-R.060 new
	3/4	.060	2-1/4	5	3	48635	48636	87966	H40ALV-M-30750-R.060 new
	3/4	.060	2-3/4	5	3	86144	86145	87967	H40ALV-ML-30750-R.060 new
	3/4	.090	1	3	3	48630	48631		H40ALV-S-30750-R.090
	3/4	.090	1-5/8	4	3	48635	48636		H40ALV-R-30750-R.090
	3/4	.090	2-1/4	5	3	48670	48671		H40ALV-M-30750-R.090
	3/4	.125	1	3	3	48605	48606	87968	H40ALV-S-30750-R.125 new
	3/4	.125	1-5/8	4	3	48640	48641	87969	H40ALV-R-30750-R.125 new
	3/4	.125	2-1/4	5	3	48675	48676	87970	H40ALV-M-30750-R.125 new
	3/4	.125	2-3/4	5	3	82451	82452	87971	H40ALV-ML-30750-R.125 new
	3/4	.190	1	3	3	48610*	48611*		H40ALV-S-30750-R.190
	3/4	.190	1-5/8	4	3	48645*	48646*		H40ALV-R-30750-R.190
	3/4	.190	2-1/4	5	3	48680*	48681*		H40ALV-M-30750-R.190
	3/4	.250	1	3	3	48615*	48616*		H40ALV-S-30750-R.250
	3/4	.250	1-5/8	4	3	48650*	48651*		H40ALV-R-30750-R.250
	3/4	.250	2-1/4	5	3	48685*	48686*		H40ALV-M-30750-R.250
	3/4	.250	2-3/4	5	3	87058*	87059*		H40ALV-ML-30750-R.250
1	1	.030	1-1/4	4	3	48695	48696	87972	H40ALV-S-31000-R.030 new
	1	.030	2	5	3	48730	48731	87973	H40ALV-R-31000-R.030 new
	1	.030	3-1/4	6	3	48765	48766	87974	H40ALV-M-31000-R.030 new
	1	.060	1-1/4	4	3	48700	48701		H40ALV-S-31000-R.060
	1	.060	2	5	3	48735	48736		H40ALV-R-31000-R.060
	1	.060	3-1/4	6	3	48770	48771		H40ALV-M-31000-R.060
	1	.125	1-1/4	4	3	48710	48711		H40ALV-S-31000-R.125
	1	.125	2	5	3	48745	48746		H40ALV-R-31000-R.125
	1	.125	3-1/4	6	3	48780	48781		H40ALV-M-31000-R.125
	1	.250	1-1/4	4	3	48720*	48721*		H40ALV-S-31000-R.250
	1	.250	2	5	3	48755*	48756*		H40ALV-R-31000-R.250
	1	.250	3-1/4	6	3	48790*	48791*		H40ALV-M-31000-R.250

* Wiper flats not included if corner radius exceeds 20% of tool diameter or cutter diameter is below 1/8". ** .0003 max TIR

H40ALVC-3



New!

3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch - Coolant Through

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Unique "3 teeth-to-center" end geometry for ramping applications
- Wiper flat design leaves superior floor finish

- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Uncoated tool offers an excellent option for aluminum finishing applications
- Solid carbide
- CNC ground in the USA



Cutter Diameter** D1 (in)	Shank Diameter D2 (in)	Corner Radius R $\pm .002$ / $-.001$	Length of Cut L1 $\pm .002$ / $-.001$	Overall Length L2 $\pm .002$ / $-.001$	Flutes	Uncoated	Nplus Coated	Tool Description
1/4	1/4	.015	3/8	2	3	88097	88098	H40ALVC-015-30250-R.015
	1/4	.015	1/2	2	3	88103	88104	H40ALVC-020-30250-R.015
	1/4	.030	3/8	2	3	88099	88100	H40ALVC-015-30250-R.030
	1/4	.030	1/2	2	3	88105	88106	H40ALVC-020-30250-R.030
	1/4	.060	3/8	2	3	88101*	88102*	H40ALVC-015-30250-R.060
	1/4	.060	1/2	2	3	88107*	88108*	H40ALVC-020-30250-R.060
3/8	3/8	.015	1/2	2	3	88109	88110	H40ALVC-015-30375-R.015
	3/8	.015	3/4	2-1/2	3	88115	88116	H40ALVC-020-30375-R.015
	3/8	.030	1/2	2	3	88111	88112	H40ALVC-015-30375-R.030
	3/8	.030	3/4	2-1/2	3	88117	88118	H40ALVC-020-30375-R.030
	3/8	.060	1/2	2	3	88113	88114	H40ALVC-015-30375-R.060
	3/8	.060	3/4	2-1/2	3	88119	88120	H40ALVC-020-30375-R.060
1/2	1/2	.015	5/8	2-1/2	3	88121	88122	H40ALVC-015-30500-R.015
	1/2	.015	1	3	3	88129	88130	H40ALVC-020-30500-R.015
	1/2	.015	1-1/4	3	3	88137	88138	H40ALVC-025-30500-R.015
	1/2	.030	5/8	2-1/2	3	88123	88124	H40ALVC-015-30500-R.030
	1/2	.030	1	3	3	88131	88132	H40ALVC-020-30500-R.030
	1/2	.030	1-1/4	3	3	88139	88140	H40ALVC-025-30500-R.030
	1/2	.060	5/8	2-1/2	3	88125	88126	H40ALVC-015-30500-R.060
	1/2	.060	1	3	3	88133	88134	H40ALVC-020-30500-R.060
	1/2	.060	1-1/4	3	3	88141	88142	H40ALVC-025-30500-R.060
	1/2	.125	5/8	2-1/2	3	88127*	88128*	H40ALVC-015-30500-R.125
	1/2	.125	1	3	3	88135*	88136*	H40ALVC-020-30500-R.125
	1/2	.125	1-1/4	3	3	88143*	88144*	H40ALVC-025-30500-R.125
3/4	3/4	.030	1	3	3	88145	88146	H40ALVC-015-30750-R.030
	3/4	.030	1-5/8	4	3	88151	88152	H40ALVC-021-30750-R.030
	3/4	.060	1	3	3	88147	88148	H40ALVC-015-30750-R.060
	3/4	.060	1-5/8	4	3	88153	88154	H40ALVC-021-30750-R.060
	3/4	.125	1	3	3	88149	88150	H40ALVC-015-30750-R.125
	3/4	.125	1-5/8	4	3	88155	88156	H40ALVC-021-30750-R.125

* Wiper flats not included if corner radius exceeds 20% of tool diameter, **.0003 max TIR



3 FLUTE - SQUARE

40° Helix - Variable Pitch - Reduced Neck



H40ALV-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" and geometry for ramping applications
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Wiper flat design leaves superior floor finish
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h8 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 (#)	Shank Dia. D2 (#)	LOC L2 ^{+0.002} / _{-0.001}	Overall Length L1 ^{+0.002} / _{-0.001}	Reach (LBS) L3	Neck Dia. L4	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	2-1/2	1/2	.118	3	46010	46011	H40ALV-RN-R-30125
	1/8	5/32	3	3/4	.118	3	46020	46021	H40ALV-RN-M-30125
	1/8	5/32	3	1	.118	3	81467	81468	H40ALV-RN-L-30125
	1/8	5/32	3	1-1/4	.118	3	82469	82470	H40ALV-RN-LX-30125
	1/8	5/32	3	1-1/2	.118	3	83555	83556	H40ALV-RN-X-30125
3/16	3/16	7/32	2-1/2	1/2	.179	3	46045	46046	H40ALV-RN-R-30187
	3/16	7/32	3	3/4	.179	3	46060	46061	H40ALV-RN-M-30187
	3/16	7/32	3	1	.179	3	81469	81470	H40ALV-RN-ML-30187
	3/16	7/32	3	1-5/16	.179	3	82471	82472	H40ALV-RN-LX-30187
	3/16	7/32	3	1-1/2	.179	3	83557	83558	H40ALV-RN-X-30187
1/4	1/4	3/8	2-1/2	3/4	.237	3	46075	46076	H40ALV-RN-S-30250
	1/4	3/8	3	1-1/8	.237	3	46095	46096	H40ALV-RN-R-30250
	1/4	3/8	3	1-3/8	.237	3	82473	82474	H40ALV-RN-RA-30250
	1/4	3/8	3	1-5/8	.237	3	81471	81472	H40ALV-RN-A-30250
	1/4	3/8	4	1-7/8	.237	3	82475	82476	H40ALV-RN-AM-30250
	1/4	3/8	4	2-1/8	.237	3	81473	81474	H40ALV-RN-M-30250
	1/4	3/8	4	2-1/2	.237	3	82477	82478	H40ALV-RN-ML-30250
	1/4	3/8	4-1/2	3	.237	3	83559	83560	H40ALV-RN-L-30250
5/16	5/16	7/16	4	1-1/8	.296	3	86500	86501	H40ALV-RN-S-30312
	5/16	7/16	4	1-3/4	.296	3	86502	86503	H40ALV-RN-R-30312
	5/16	7/16	4	2-1/8	.296	3	86504	86505	H40ALV-RN-M-30312
3/8	3/8	1/2	3	1-1/8	.355	3	46220	46221	H40ALV-RN-R-30375
	3/8	1/2	3	1-5/8	.355	3	81475	81476	H40ALV-RN-A-30375
	3/8	1/2	4	2-1/8	.355	3	46245	46246	H40ALV-RN-M-30375
	3/8	1/2	5	2-1/2	.355	3	81477	81478	H40ALV-RN-ML-30375
	3/8	1/2	6	3-1/8	.355	3	82479	82480	H40ALV-RN-LX-30375
	3/8	1/2	6	4	.355	3	83561	83562	H40ALV-RN-X-30375

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 65

H40ALV-RN-3



3 FLUTE - SQUARE

40° Helix - Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	LOC L ₂ ^{+0.02"} -0.007	Overall Length L ₁ ^{+0.02"} -0.007	Reach (LBS) L ₁	Neck Dia.	Flutes	Uncoated	Zr-Coated	Tool Description
1/2	1/2	5/8	3	1-3/8	.475	3	46300	46301	H40ALV-RN-R-30500
	1/2	5/8	3-1/2	1-3/4	.475	3	81479	81480	H40ALV-RN-A-30500
	1/2	5/8	4	2-1/4	.475	3	46330	46331	H40ALV-RN-M-30500
	1/2	5/8	4-1/2	2-3/4	.475	3	81481	81482	H40ALV-RN-ML-30500
	1/2	5/8	5	3-3/8	.475	3	46360	46361	H40ALV-RN-L-30500
	1/2	5/8	6	3-3/4	.475	3	81483	81484	H40ALV-RN-LX-30500
	1/2	5/8	6	4-1/4	.475	3	46390	46391	H40ALV-RN-X-30500
	1/2	5/8	7	5	.475	3	82481	82482	H40ALV-RN-Y-30500
	1/2	5/8	8	6	.475	3	86506	86507	H40ALV-RN-Z-30500
5/8	5/8	3/4	4	2-3/8	.593	3	46470	46471	H40ALV-RN-M-30625
	5/8	3/4	6	3-3/8	.593	3	46495	46496	H40ALV-RN-L-30625
	5/8	3/4	6	4-1/8	.593	3	83563	83564	H40ALV-RN-X-30625
3/4	3/4	1	4	2	.712	3	46505	46506	H40ALV-RN-R-30750
	3/4	1	5	2-1/2	.712	3	81485	81486	H40ALV-RN-A-30750
	3/4	1	6	3-3/8	.712	3	46590	46591	H40ALV-RN-M-30750
	3/4	1	7	4-1/8	.712	3	81487	81488	H40ALV-RN-ML-30750
	3/4	1	7	5	.712	3	46625	46626	H40ALV-RN-L-30750
	3/4	1	10	6	.712	3	82483	82484	H40ALV-RN-LX-30750
	3/4	1	10	7-1/2	.712	3	86508	86509	H40ALV-RN-X-30750
1	1	1-1/4	5	2-5/8	.950	3	46695	46696	H40ALV-RN-R-31000
	1	1-1/4	6	3-3/8	.950	3	46730	46731	H40ALV-RN-M-31000
	1	1-1/4	7	4-3/8	.950	3	46765	46766	H40ALV-RN-L-31000
	1	1-1/4	9	6	.950	3	46800	46801	H40ALV-RN-LX-31000
	1	1-1/4	12-1/2	9-1/2	.950	3	86510	86511	H40ALV-RN-X-31000

*.0003 max TIR



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3 FLUTE - BALL

40° Helix - Variable Pitch - Reduced Neck



H40ALV-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h6 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.** D1 (in)	Shank Dia. D2 (in)	Length of Cut L2 $\pm .002$ in	Overall Length L1 $\pm .002$ in	Reach (L3) L3	Neck Dia. L4	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	2-1/2	1/2	.118	3	47040*	47041*	H40ALV-RN-R-30125-BN
	1/8	5/32	3	3/4	.118	3	47045*	47046*	H40ALV-RN-M-30125-BN
	1/8	5/32	3	1	.118	3	81533*	81534*	H40ALV-RN-L-30125-BN
	1/8	5/32	3	1-1/4	.118	3	82485*	82486*	H40ALV-RN-LX-30125-BN
	1/8	5/32	3	1-1/2	.118	3	83565*	83566*	H40ALV-RN-X-30125-BN
3/16	3/16	7/32	2-1/2	1/2	.178	3	47060*	47061*	H40ALV-RN-R-30187-BN
	3/16	7/32	3	3/4	.178	3	47065*	47066*	H40ALV-RN-M-30187-BN
	3/16	7/32	3	1	.178	3	81535*	81536*	H40ALV-RN-L-30187-BN
	3/16	7/32	3	1-5/16	.178	3	82487*	82488*	H40ALV-RN-LX-30187-BN
	3/16	7/32	3	1-1/2	.178	3	83567*	83568*	H40ALV-RN-X-30187-BN
1/4	1/4	3/8	2-1/2	3/4	.237	3	47075	47076	H40ALV-RN-S-30250-BN
	1/4	3/8	3	1-1/8	.237	3	47090	47091	H40ALV-RN-R-30250-BN
	1/4	3/8	3	1-3/8	.237	3	82489	82490	H40ALV-RN-SA-30250-BN
	1/4	3/8	3	1-5/8	.237	3	81537	81538	H40ALV-RN-A-30250-BN
	1/4	3/8	4	1-7/8	.237	3	82491	82492	H40ALV-RN-AM-30250-BN
	1/4	3/8	4	2-1/8	.237	3	81539	81540	H40ALV-RN-M-30250-BN
	1/4	3/8	4	2-1/2	.237	3	82493	82494	H40ALV-RN-ML-30250-BN
	1/4	3/8	4-1/2	3	.237	3	83569	83570	H40ALV-RN-L-30250-BN
5/16	5/16	7/16	4	1-1/8	.296	3	86512	86513	H40ALV-RN-S-30312-BN
	5/16	7/16	4	1-3/4	.296	3	86514	86515	H40ALV-RN-R-30312-BN
	5/16	7/16	4	2-1/8	.296	3	86516	86517	H40ALV-RN-M-30312-BN
3/8	3/8	1/2	3	1-1/8	.356	3	47180	47181	H40ALV-RN-R-30375-BN
	3/8	1/2	3	1-5/8	.356	3	81541	81542	H40ALV-RN-A-30375-BN
	3/8	1/2	4	2-1/8	.356	3	47186	47186	H40ALV-RN-M-30375-BN
	3/8	1/2	5	2-1/2	.356	3	81543	81544	H40ALV-RN-ML-30375-BN
	3/8	1/2	6	3-1/8	.356	3	82495	82496	H40ALV-RN-LX-30375-BN
	3/8	1/2	6	4	.356	3	86518	86519	H40ALV-RN-X-30375-BN

* 1/8 & 3/16 have one tooth to center ** .0003 max TR

continued on next page



Speeds & Feeds on Page 65

H40ALV-RN-3**3 FLUTE - BALL****40° Helix - Variable Pitch - Reduced Neck (cont.)**

continued from previous page

Cutter Dia.** D ₁ (in)	Shank Dia. D ₂ (in)	Length of Cut L ₂ = .002" -.000"	Overall Length L ₁ = .002" -.002"	Reach (LBS) L ₃	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/2	1/2	5/8	3	1-3/8	.475	3	47225	47226	H40ALV-RN-R-30500-BN
	1/2	5/8	3-1/2	1-3/4	.475	3	61545	61546	H40ALV-RN-X-30500-BN
	1/2	5/8	4	2-1/4	.475	3	47240	47241	H40ALV-RN-M-30500-BN
	1/2	5/8	4-1/2	2-3/4	.475	3	61547	61548	H40ALV-RN-NL-30500-BN
	1/2	5/8	5	3-3/8	.475	3	47255	47256	H40ALV-RN-L-30500-BN
	1/2	5/8	6	3-3/4	.475	3	61549	61550	H40ALV-RN-LX-30500-BN
	1/2	5/8	8	4-1/4	.475	3	47270	47271	H40ALV-RN-X-30500-BN
	1/2	5/8	7	5	.475	3	62497	62498	H40ALV-RN-Y-30500-BN
5/8	5/8	3/4	4	1-5/8	.593	3	47300	47301	H40ALV-RN-R-30625-BN
	5/8	3/4	4	2-3/8	.593	3	47315	47316	H40ALV-RN-M-30625-BN
	5/8	3/4	6	3-3/8	.593	3	47330	47331	H40ALV-RN-L-30625-BN
3/4	3/4	1	4	2	.712	3	47360	47361	H40ALV-RN-R-30750-BN
	3/4	1	5	2-1/2	.712	3	63571	63572	H40ALV-RN-X-30750-BN
	3/4	1	6	3-3/8	.712	3	47375	47376	H40ALV-RN-M-30750-BN
	3/4	1	7	4-1/8	.712	3	63573	63574	H40ALV-RN-NL-30750-BN
	3/4	1	7	5	.712	3	47390	47391	H40ALV-RN-L-30750-BN
1	1	1-1/4	5	2-5/8	.950	3	47420	47421	H40ALV-RN-R-31000-BN
	1	1-1/4	6	3-3/8	.950	3	47435	47436	H40ALV-RN-M-31000-BN
	1	1-1/4	7	4-3/8	.950	3	47450	47451	H40ALV-RN-L-31000-BN
	1	1-1/4	9	6	.950	3	47465	47466	H40ALV-RN-LX-31000-BN
	1	1-1/4	12-1/2	9-1/2	.950	3	47480	47481	H40ALV-RN-X-31000-BN

* 1/8 & 3/16 have one tooth to center. ** .0003 max TIR

Speeds & Feeds 101

In The Loupe

Every machinist should know the basics when it comes to speeds and feeds, or the cutting variables used in every milling operation, as proper running parameters are critical to the outcome of your part. In our "In the Loupe" post *Speeds and Feeds 101*, learn how to calculate speeds and feeds, determine your tool's efficiency via Material Removal Rate (MRR), and much more.

www.harveyprecision.com/in-the-loupe/speeds-and-feeds-101/


SCAN TO READ

3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch - Reduced Neck


H40ALV-RN-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials
- Designed with a specialized combination of features for excellent performance in roughing and finishing applications
- Unique "3 teeth-to-center" end geometry for ramping applications
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Wiper flat design leaves superior floor finish
- Excellent performance in High Efficiency Milling (HEM)
- Center cutting
- h6 shank tolerance for high precision tool holders
- Uncoated tool offers an excellent option for aluminum finishing applications
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.** D2 (in)	Shank Dia. D1 (in)	Corner Radius R ± .002	LOC L2 ± .002	OAL L1 ± .002	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	5/32	2-1/2	1/2	.118	3	86522	86523	H40ALV-RN-R-30125-R.010
	1/8	.010	5/32	3	3/4	.118	3	86526	86527	H40ALV-RN-M-30125-R.010
	1/8	.010	5/32	3	1	.118	3	86530	86531	H40ALV-RN-L-30125-R.010
	1/8	.015	5/32	2-1/2	1/2	.118	3	46015	46016	H40ALV-RN-R-30125-R.015
	1/8	.015	5/32	3	3/4	.118	3	46025	46026	H40ALV-RN-M-30125-R.015
	1/8	.015	5/32	3	1	.118	3	82807	82808	H40ALV-RN-L-30125-R.015
	1/8	.030	5/32	2-1/2	1/2	.118	3	86524*	86525*	H40ALV-RN-R-30125-R.030
	1/8	.030	5/32	3	3/4	.118	3	86528*	86529*	H40ALV-RN-M-30125-R.030
	1/8	.030	5/32	3	1	.118	3	86532*	86533*	H40ALV-RN-L-30125-R.030
3/16	3/16	.010	7/32	2-1/2	1/2	.178	3	86534	86535	H40ALV-RN-R-30187-R.010
	3/16	.010	7/32	3	3/4	.178	3	86536	86537	H40ALV-RN-M-30187-R.010
	3/16	.010	7/32	3	1	.178	3	86538	86539	H40ALV-RN-L-30187-R.010
	3/16	.015	7/32	2-1/2	1/2	.178	3	46050	46051	H40ALV-RN-R-30187-R.015
	3/16	.015	7/32	3	3/4	.178	3	46065	46066	H40ALV-RN-M-30187-R.015
	3/16	.015	7/32	3	1	.178	3	82809	82810	H40ALV-RN-L-30187-R.015
	3/16	.030	7/32	2-1/2	1/2	.178	3	46055	46056	H40ALV-RN-R-30187-R.030
	3/16	.030	7/32	3	3/4	.178	3	46070	46071	H40ALV-RN-M-30187-R.030
	3/16	.030	7/32	3	1	.178	3	82811	82812	H40ALV-RN-L-30187-R.030
1/4	1/4	.015	3/8	2-1/2	3/4	.237	3	46080	46081	H40ALV-RN-R-30250-R.015
	1/4	.015	3/8	3	1-1/8	.237	3	46100	46101	H40ALV-RN-R-30250-R.015
	1/4	.015	3/8	3	1-3/8	.237	3	82813	82814	H40ALV-RN-PA-30250-R.015
	1/4	.015	3/8	3	1-5/8	.237	3	81489	81490	H40ALV-RN-A-30250-R.015
	1/4	.015	3/8	4	1-7/8	.237	3	82815	82816	H40ALV-RN-AW-30250-R.015
	1/4	.015	3/8	4	2-1/8	.237	3	81491	81492	H40ALV-RN-M-30250-R.015
	1/4	.015	3/8	4	2-1/2	.237	3	82817	82818	H40ALV-RN-ML-30250-R.015
	1/4	.030	3/8	2-1/2	3/4	.237	3	46085	46086	H40ALV-RN-R-30250-R.030
	1/4	.030	3/8	3	1-1/8	.237	3	46105	46106	H40ALV-RN-R-30250-R.030
	1/4	.030	3/8	3	1-3/8	.237	3	82819	82820	H40ALV-RN-PA-30250-R.030
	1/4	.030	3/8	3	1-5/8	.237	3	81493	81494	H40ALV-RN-A-30250-R.030
	1/4	.030	3/8	4	1-7/8	.237	3	82821	82822	H40ALV-RN-AW-30250-R.030
	1/4	.030	3/8	4	2-1/8	.237	3	81495	81496	H40ALV-RN-M-30250-R.030
	1/4	.030	3/8	4	2-1/2	.237	3	82823	82824	H40ALV-RN-ML-30250-R.030

* Wiper flats not included if corner radius exceeds 20% of tool diameter. ** .0003 max TIR

continued on next page



Speeds & Feeds on Page 65

H40ALV-RN-3



3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.** D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\frac{+.002}{-.002}$	LOC L2 $\frac{+.002}{-.002}$	OAL L1 $\frac{+.062}{-.062}$	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/4	1/4	.060	3/8	2-1/2	3/4	.237	3	46090*	46091*	H40ALV-RN-S-30250-R.060
	1/4	.060	3/8	3	1-1/8	.237	3	46110*	46111*	H40ALV-RN-R-30250-R.060
	1/4	.060	3/8	3	1-3/8	.237	3	82825*	82826*	H40ALV-RN-PA-30250-R.060
	1/4	.060	3/8	3	1-5/8	.237	3	81497*	81498*	H40ALV-RN-A-30250-R.060
	1/4	.060	3/8	4	1-7/8	.237	3	82827*	82828*	H40ALV-RN-MM-30250-R.060
	1/4	.060	3/8	4	2-1/8	.237	3	81499*	81500*	H40ALV-RN-M-30250-R.060
	1/4	.060	3/8	4	2-1/2	.237	3	82829*	82830*	H40ALV-RN-ML-30250-R.060
5/16	5/16	.030	7/16	4	1-1/8	.296	3	86540	86541	H40ALV-RN-S-30312-R.030
	5/16	.030	7/16	4	1-3/4	.296	3	86544	86545	H40ALV-RN-R-30312-R.030
	5/16	.030	7/16	4	2-1/8	.296	3	86548	86549	H40ALV-RN-M-30312-R.030
	5/16	.060	7/16	4	1-1/8	.296	3	86542	86543	H40ALV-RN-S-30312-R.060
	5/16	.060	7/16	4	1-3/4	.296	3	86546	86547	H40ALV-RN-R-30312-R.060
	5/16	.060	7/16	4	2-1/8	.296	3	86550	86551	H40ALV-RN-M-30312-R.060
3/8	3/8	.015	1/2	3	1-1/8	.356	3	46225	46226	H40ALV-RN-R-30375-R.015
	3/8	.015	1/2	3	1-5/8	.356	3	81501	81502	H40ALV-RN-A-30375-R.015
	3/8	.015	1/2	4	2-1/8	.356	3	46250	46251	H40ALV-RN-M-30375-R.015
	3/8	.015	1/2	5	2-1/2	.356	3	82831	82832	H40ALV-RN-ML-30375-R.015
	3/8	.030	1/2	3	1-1/8	.356	3	46230	46231	H40ALV-RN-R-30375-R.030
	3/8	.030	1/2	3	1-5/8	.356	3	81503	81504	H40ALV-RN-A-30375-R.030
	3/8	.030	1/2	4	2-1/8	.356	3	46255	46256	H40ALV-RN-M-30375-R.030
	3/8	.030	1/2	5	2-1/2	.356	3	81505	81506	H40ALV-RN-ML-30375-R.030
	3/8	.030	1/2	6	3-1/8	.356	3	86552	86553	H40ALV-RN-LX-30375-R.030
	3/8	.060	1/2	3	1-1/8	.356	3	46235	46236	H40ALV-RN-R-30375-R.060
	3/8	.060	1/2	3	1-5/8	.356	3	81507	81508	H40ALV-RN-A-30375-R.060
	3/8	.060	1/2	4	2-1/8	.356	3	46260	46261	H40ALV-RN-M-30375-R.060
	3/8	.060	1/2	5	2-1/2	.356	3	81509	81510	H40ALV-RN-ML-30375-R.060
	3/8	.060	1/2	6	3-1/8	.356	3	86554	86555	H40ALV-RN-LX-30375-R.060
	3/8	.090	1/2	3	1-1/8	.356	3	46240*	46241*	H40ALV-RN-R-30375-R.090
	3/8	.090	1/2	3	1-5/8	.356	3	82833*	82834*	H40ALV-RN-A-30375-R.090
	3/8	.090	1/2	4	2-1/8	.356	3	46265*	46266*	H40ALV-RN-M-30375-R.090
	3/8	.090	1/2	5	2-1/2	.356	3	82835*	82836*	H40ALV-RN-ML-30375-R.090
1/2	1/2	.015	5/8	3	1-3/8	.475	3	46305	46306	H40ALV-RN-R-30500-R.015
	1/2	.015	5/8	4	2-1/4	.475	3	46335	46336	H40ALV-RN-M-30500-R.015
	1/2	.015	5/8	5	3-3/8	.475	3	46365	46366	H40ALV-RN-L-30500-R.015
	1/2	.015	5/8	6	4-1/4	.475	3	46395	46396	H40ALV-RN-X-30500-R.015
	1/2	.030	5/8	3	1-3/8	.475	3	46310	46311	H40ALV-RN-R-30500-R.030
	1/2	.030	5/8	3-1/2	1-3/4	.475	3	81511	81512	H40ALV-RN-A-30500-R.030
	1/2	.030	5/8	4	2-1/4	.475	3	46340	46341	H40ALV-RN-M-30500-R.030
	1/2	.030	5/8	4-1/2	2-3/4	.475	3	81513	81514	H40ALV-RN-ML-30500-R.030
	1/2	.030	5/8	5	3-3/8	.475	3	46370	46371	H40ALV-RN-L-30500-R.030
	1/2	.030	5/8	6	3-3/4	.475	3	82837	82838	H40ALV-RN-LX-30500-R.030
	1/2	.030	5/8	6	4-1/4	.475	3	46400	46401	H40ALV-RN-X-30500-R.030
	1/2	.030	5/8	7	5	.475	3	82839	82840	H40ALV-RN-Y-30500-R.030

* Wiper flats not included if corner radius exceeds 20% of tool diameter. ** .0003 max TIR

continued on next page

3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch - Reduced Neck (cont.)



H40ALV-RN-3

continued from previous page

Cutter Dia.** D ₁ (in)	Shank Dia. D ₂ (in)	Corner Radius R ^{+0.02"} _{-0.01"}	LOC L ₂ ^{+0.02"} _{-0.01"}	OAL L ₁ ^{+0.02"} _{-0.02"}	Reach (LBS) L ₃	Neck Dia.	Flutes	Uncoated	Zn+ve Coated	Tool Description
1/2	1/2	.060	5/8	3	1-3/8	.475	3	46315	46316	H40ALV-RN-R-30500-R.060
	1/2	.060	5/8	3-1/2	1-3/4	.475	3	81515	81516	H40ALV-RN-A-30500-R.060
	1/2	.060	5/8	4	2-1/4	.475	3	46345	46346	H40ALV-RN-M-30500-R.060
	1/2	.060	5/8	4-1/2	2-3/4	.475	3	81517	81518	H40ALV-RN-ML-30500-R.060
	1/2	.060	5/8	5	3-3/8	.475	3	46375	46376	H40ALV-RN-L-30500-R.060
	1/2	.060	5/8	6	3-3/4	.475	3	82841	82842	H40ALV-RN-LX-30500-R.060
	1/2	.060	5/8	6	4-1/4	.475	3	46405	46406	H40ALV-RN-X-30500-R.060
	1/2	.060	5/8	7	5	.475	3	82843	82844	H40ALV-RN-Y-30500-R.060
	1/2	.090	5/8	3	1-3/8	.475	3	46320	46321	H40ALV-RN-R-30500-R.090
	1/2	.090	5/8	3-1/2	1-3/4	.475	3	86556	86557	H40ALV-RN-A-30500-R.090
	1/2	.090	5/8	4	2-1/4	.475	3	46350	46351	H40ALV-RN-M-30500-R.090
	1/2	.090	5/8	4-1/2	2-3/4	.475	3	86558	86559	H40ALV-RN-ML-30500-R.090
	1/2	.090	5/8	5	3-3/8	.475	3	46380	46381	H40ALV-RN-L-30500-R.090
	1/2	.090	5/8	6	4-1/4	.475	3	46410	46411	H40ALV-RN-X-30500-R.090
	1/2	.125	5/8	3	1-3/8	.475	3	46325*	46326*	H40ALV-RN-R-30500-R.125
	1/2	.125	5/8	3-1/2	1-3/4	.475	3	81519*	81520*	H40ALV-RN-A-30500-R.125
	1/2	.125	5/8	4	2-1/4	.475	3	46355*	46356*	H40ALV-RN-M-30500-R.125
	1/2	.125	5/8	4-1/2	2-3/4	.475	3	81521*	81522*	H40ALV-RN-ML-30500-R.125
	1/2	.125	5/8	5	3-3/8	.475	3	46385*	46386*	H40ALV-RN-L-30500-R.125
	1/2	.125	5/8	6	3-3/4	.475	3	82845*	82846*	H40ALV-RN-LX-30500-R.125
	1/2	.125	5/8	6	4-1/4	.475	3	46415*	46416*	H40ALV-RN-X-30500-R.125
	1/2	.125	5/8	7	5	.475	3	82847*	82848*	H40ALV-RN-Y-30500-R.125
5/8	5/8	.030	3/4	4	2-3/8	.593	3	46475	46476	H40ALV-RN-M-30625-R.030
	5/8	.030	3/4	6	3-3/8	.593	3	46500	46501	H40ALV-RN-L-30625-R.030
	5/8	.060	3/4	4	2-3/8	.593	3	46480	46481	H40ALV-RN-M-30625-R.060
	5/8	.090	3/4	4	2-3/8	.593	3	46485	46486	H40ALV-RN-M-30625-R.090
	5/8	.125	3/4	4	2-3/8	.593	3	46490	46491	H40ALV-RN-M-30625-R.125
3/4	3/4	.030	1	4	2	.712	3	46560	46561	H40ALV-RN-R-30750-R.030
	3/4	.030	1	5	2-1/2	.712	3	81523	81524	H40ALV-RN-A-30750-R.030
	3/4	.030	1	6	3-3/8	.712	3	46595	46596	H40ALV-RN-M-30750-R.030
	3/4	.030	1	7	4-1/8	.712	3	81525	81526	H40ALV-RN-ML-30750-R.030
	3/4	.030	1	7	5	.712	3	46630	46631	H40ALV-RN-L-30750-R.030
	3/4	.030	1	10	6	.712	3	86560	86561	H40ALV-RN-LX-30750-R.030
	3/4	.060	1	4	2	.712	3	46565	46566	H40ALV-RN-R-30750-R.060
	3/4	.060	1	5	2-1/2	.712	3	81527	81528	H40ALV-RN-A-30750-R.060
	3/4	.060	1	6	3-3/8	.712	3	46600	46601	H40ALV-RN-M-30750-R.060
	3/4	.060	1	7	4-1/8	.712	3	81529	81530	H40ALV-RN-ML-30750-R.060
	3/4	.060	1	7	5	.712	3	46635	46636	H40ALV-RN-L-30750-R.060
	3/4	.090	1	4	2	.712	3	46570	46571	H40ALV-RN-R-30750-R.090
	3/4	.090	1	6	3-3/8	.712	3	46605	46606	H40ALV-RN-M-30750-R.090
	3/4	.125	1	4	2	.712	3	46575	46576	H40ALV-RN-R-30750-R.125
	3/4	.125	1	5	2-1/2	.712	3	81531	81532	H40ALV-RN-A-30750-R.125
	3/4	.125	1	6	3-3/8	.712	3	46610	46611	H40ALV-RN-M-30750-R.125
	3/4	.125	1	7	5	.712	3	46645	46646	H40ALV-RN-L-30750-R.125
	3/4	.190	1	4	2	.712	3	46581*	46581*	H40ALV-RN-R-30750-R.190
	3/4	.190	1	6	3-3/8	.712	3	46615*	46616*	H40ALV-RN-M-30750-R.190
	3/4	.250	1	4	2	.712	3	46585*	46586*	H40ALV-RN-R-30750-R.250
	3/4	.250	1	6	3-3/8	.712	3	46620*	46621*	H40ALV-RN-M-30750-R.250
	3/4	.250	1	7	5	.712	3	46655*	46656*	H40ALV-RN-L-30750-R.250

* Wiper flats not included if corner radius exceeds 20% of tool diameter. ** .0003 max TIR

continued on next page

H40ALV-RN-3



3 FLUTE - CORNER RADIUS

40° Helix - Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.** D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ - .002	LOC L2 $\pm .002$ - .002	OAL L1 $\pm .002$ - .002	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1	1	.030	1-1/4	5	2-5/8	.950	3	46700	46701	H40ALV-RN-R-31000-R.030
	1	.030	1-1/4	6	3-3/8	.950	3	46725	46726	H40ALV-RN-M-31000-R.030
	1	.030	1-1/4	7	4-3/8	.950	3	46770	46771	H40ALV-RN-L-31000-R.030
	1	.030	1-1/4	9	6	.950	3	46805	46806	H40ALV-RN-LX-31000-R.030
	1	.060	1-1/4	5	2-5/8	.950	3	46705	46706	H40ALV-RN-R-31000-R.060
	1	.060	1-1/4	6	3-3/8	.950	3	46740	46741	H40ALV-RN-M-31000-R.060
	1	.060	1-1/4	7	4-3/8	.950	3	46775	46776	H40ALV-RN-L-31000-R.060
	1	.125	1-1/4	5	2-5/8	.950	3	46715	46716	H40ALV-RN-R-31000-R.125
	1	.125	1-1/4	6	3-3/8	.950	3	46750	46751	H40ALV-RN-M-31000-R.125
	1	.125	1-1/4	7	4-3/8	.950	3	46785	46786	H40ALV-RN-L-31000-R.125
	1	.125	1-1/4	9	6	.950	3	46820	46821	H40ALV-RN-LX-31000-R.125
	1	.250	1-1/4	5	2-5/8	.950	3	46725*	46726*	H40ALV-RN-R-31000-R.250
	1	.250	1-1/4	6	3-3/8	.950	3	46760*	46761*	H40ALV-RN-M-31000-R.250
	1	.250	1-1/4	7	4-3/8	.950	3	46795*	46796*	H40ALV-RN-L-31000-R.250
	1	.250	1-1/4	9	6	.950	3	46830*	46831*	H40ALV-RN-LX-31000-R.250

* Wiper flats not included if corner radius exceeds 20% of tool diameter. ** .0003 max TIR

H40ALV-3 / H40AMV-3 / H40ALV-RN-3

Material Guide		SFV	Inches per Tooth (IPT)																							
			1/16			1/8			3/16			1/4			5/8			1/2			3/4			1		
			Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
WROUGHT ALUMINUM ALLOY	2014, 6062, 6061, 7050, 7075, 7475	2200- 2800	.0035	.0068	.0064	.0007	.0008	.0005	.0010	.0012	.0008	.0012	.0015	.0010	.0020	.0025	.0015	.0028	.0030	.0025	.0040	.0050	.0038	.0055	.0080	.0040
CAST ALUMINUM ALLOY	319 D, 328 D, 355 D, 360 D, 368 D, 383 D, 390 D, 520 D, 535 D	900- 1200	.0038	.0018	.0068	.0012	.0015	.0008	.0018	.0020	.0015	.0022	.0028	.0018	.0035	.0040	.0028	.0045	.0065	.0035	.0070	.0080	.0058	.0090	.0110	.0070
COPPER ALLOY	CuETP, CuBe2, CuZn30, CuZn39Pb3, CuZn40, Cu8SiE	450- 650	.0030	.0007	.0065	.0006	.0010	.0005	.0010	.0015	.0010	.0015	.0020	.0012	.0022	.0030	.0020	.0030	.0040	.0025	.0045	.0060	.0048	.0080	.0090	.0080

MILLING PROCESS	STYLE	ADOC	RDOC
Stk (Full Skidding)	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to Full LOC	100% Diameter
Rgh (Traditional Roughing)	Non-Reached	120%-200% Diameter	30%-40% Diameter
	Reached	Up to Full LOC	30%-40% Diameter
Fin (Finishing)	N/A	Up to Full LOC	4%-6% Diameter

NOTES:

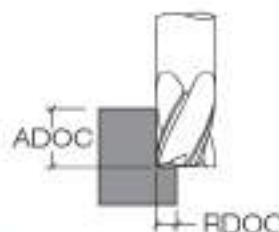
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

3 FLUTE - SQUARE

45° Helix



H45AL-3

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials.
- Designed with a high helix for improved part finish and shearing action.
- Cylindrically ground to maintain edge strength.
- Center cutting.
- Excellent performance in High Efficiency Milling (HEM).
- h8 shank tolerance for high precision tool holders.
- Zplus coating offers higher hardness and added lubricity for maximum performance.
- Solid carbide.
- CNC ground in the USA.



Cutter Diameter* D1 (in)	Shank Diameter D2 (in)	Length of Cut L2 $\pm .002$ in	Overall Length L1 $\pm .002$ in	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	3	03015	03017	H45AL-S-30125
	1/8	3/8	2	3	03030	03032	H45AL-SR-30125
	1/8	1/2	2-1/2	3	03045	03047	H45AL-R-30125
	1/8	5/8	2-1/2	3	81551	81552	H45AL-M-30125
	1/8	3/4	2-1/2	3	03060	03062	H45AL-L-30125
	1/8	7/8	2-1/2	3	82849	82850	H45AL-LX-30125
	1/8	1	2-1/2	3	87060	87061	H45AL-X-30125
3/16	3/16	5/16	2	3	03090	03092	H45AL-S-30187
	3/16	7/16	2	3	87062	87063	H45AL-SR-30187
	3/16	9/16	2-1/2	3	03105	03107	H45AL-R-30187
	3/16	3/4	2-1/2	3	03120	03122	H45AL-M-30187
	3/16	1	2-1/2	3	81553	81554	H45AL-ML-30187
	3/16	1-3/16	3	3	82851	82852	H45AL-L-30187
	3/16	1-3/8	3	3	87064	87065	H45AL-LX-30187
1/4	1/4	3/8	2	3	03150	03152	H45AL-S-30250
	1/4	1/2	2-1/2	3	03155	03157	H45AL-SR-30250
	1/4	3/4	2-1/2	3	03165	03167	H45AL-R-30250
	1/4	1	3	3	03180	03182	H45AL-M-30250
	1/4	1-1/4	3	3	03195	03197	H45AL-L-30250
	1/4	1-1/2	3	3	81555	81556	H45AL-LX-30250
	1/4	1-3/4	4	3	03210	03212	H45AL-X-30250
5/16	5/16	2	4	3	82853	82854	H45AL-Y-30250
	5/16	7/16	2	3	03240	03242	H45AL-S-30312
	5/16	13/16	2-1/2	3	03255	03257	H45AL-R-30312
	5/16	1	3	3	03270	03272	H45AL-M-30312
	5/16	1-1/4	3	3	03285	03287	H45AL-L-30312
	5/16	1-9/16	3	3	81557	81558	H45AL-LX-30312
	5/16	2-1/8	4	3	03300	03302	H45AL-X-30312
5/16	5/16	2-1/2	4	3	87066	87067	H45AL-Y-30312

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 75

H45AL-3



3 FLUTE - SQUARE

45° Helix (cont.)

continued from previous page

Cutter Diameter* D ₁ (in)	Shank Diameter D ₂ (in)	Length of Cut L ₂ ^{+0.02"} _{-0.00"}	Overall Length L ₁ ^{+0.02"} _{-0.00"}	Flutes	Uncoated	Zplus Coated	Tool Description
3/8	3/8	1/2	2	3	03330	03332	H45AL-S-30370
	3/8	3/4	2-1/2	3	01558	01560	H45AL-SR-30375
	3/8	1	3	3	03345	03347	H45AL-R-30375
	3/8	1-1/4	3-1/2	3	03360	03362	H45AL-M-30375
	3/8	1-1/2	4	3	03375	03377	H45AL-L-30375
	3/8	2	4	3	03390	03392	H45AL-LX-30375
	3/8	2-1/2	5	3	03405	03407	H45AL-X-30375
	3/8	3	5	3	03555	03556	H45AL-Y-30375
1/2	1/2	5/8	2-1/2	3	03435	03437	H45AL-S-30500
	1/2	1	3	3	03450	03452	H45AL-SR-30500
	1/2	1-1/4	3	3	03465	03467	H45AL-R-30500
	1/2	1-5/8	4	3	03480	03482	H45AL-M-30500
	1/2	2	4	3	03495	03497	H45AL-L-30500
	1/2	2-1/2	5	3	03510	03512	H45AL-LX-30500
	1/2	3-1/8	6	3	03525	03527	H45AL-X-30500
	1/2	3-5/8	6	3	03557	03558	H45AL-Y-30500
5/8	5/8	3/4	3	3	03555	03557	H45AL-S-30625
	5/8	1-5/8	3-1/2	3	03570	03572	H45AL-R-30625
	5/8	2-1/8	4	3	03585	03587	H45AL-M-30625
	5/8	2-1/2	5	3	03600	03602	H45AL-L-30625
	5/8	3-1/4	6	3	03610	03612	H45AL-LX-30625
	5/8	3-3/4	6	3	03615	03617	H45AL-X-30625
3/4	3/4	1	4	3	03645	03647	H45AL-S-30750
	3/4	1-5/8	4	3	03660	03662	H45AL-R-30750
	3/4	2	4	3	01561	01562	H45AL-A-30750
	3/4	2-1/4	5	3	03675	03677	H45AL-M-30750
	3/4	2-3/4	5	3	01563	01564	H45AL-ML-30750
	3/4	3-1/4	6	3	03690	03692	H45AL-L-30750
	3/4	4	6-1/2	3	03705	03707	H45AL-X-30750
	3/4	4-3/4	7	3	07068	07069	H45AL-Y-30750
1	1	2	5	3	03750	03752	H45AL-R-31000
	1	2-5/8	6	3	03765	03767	H45AL-M-31000
	1	3-1/4	6	3	03780	03782	H45AL-L-31000
	1	4-1/8	7	3	03795	03797	H45AL-X-31000

* .0003 max TIR

3 FLUTE - CORNER RADIUS

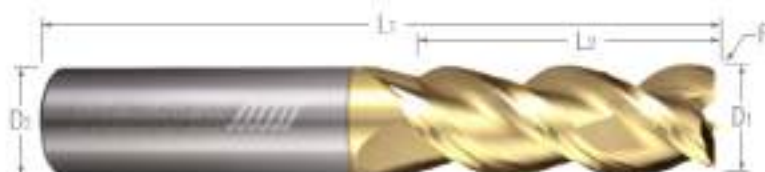
New Items!



H45AL-3

45° Helix

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- Solid carbide.
- CNC ground in the USA.



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ in	Length of Cut L1 $\pm .002$ in	OAL L2 $\pm .002$ in	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	3	83581	83582	H45AL-S-30125-R.010
	1/8	.010	3/8	2	3	83583	83584	H45AL-SR-30125-R.010
	1/8	.010	1/2	2-1/2	3	83585	83586	H45AL-H-30125-R.010
	1/8	.010	5/8	2-1/2	3	83575	83576	H45AL-M-30125-R.010
	1/8	.010	3/4	2-1/2	3	83577	83578	H45AL-L-30125-R.010
	1/8	.020	1/4	1-1/2	3	83579	83580	H45AL-S-30125-R.020
	1/8	.020	3/8	2	3	83581	83582	H45AL-SR-30125-R.020
	1/8	.020	1/2	2-1/2	3	83583	83584	H45AL-H-30125-R.020
	1/8	.020	5/8	2-1/2	3	87070	87071	H45AL-M-30125-R.020
	1/8	.020	3/4	2-1/2	3	87072	87073	H45AL-L-30125-R.020
	1/8	.030	1/4	1-1/2	3	83585	83586	H45AL-S-30125-R.030
	1/8	.030	3/8	2	3	83587	83588	H45AL-SR-30125-R.030
	1/8	.030	1/2	2-1/2	3	83589	83590	H45AL-H-30125-R.030
	1/8	.030	5/8	2-1/2	3	87074	87075	H45AL-M-30125-R.030
	1/8	.030	3/4	2-1/2	3	87076	87077	H45AL-L-30125-R.030
3/16	3/16	.010	5/16	2	3	83591	83592	H45AL-S-30187-R.010
	3/16	.010	9/16	2-1/2	3	83593	83594	H45AL-R-30187-R.010
	3/16	.010	3/4	2-1/2	3	83595	83596	H45AL-M-30187-R.010
	3/16	.010	1	2-1/2	3	87078	87079	H45AL-ML-30187-R.010
	3/16	.020	5/16	2	3	83597	83598	H45AL-S-30187-R.020
	3/16	.020	9/16	2-1/2	3	83599	83600	H45AL-R-30187-R.020
	3/16	.020	3/4	2-1/2	3	83601	83602	H45AL-M-30187-R.020
	3/16	.020	1	2-1/2	3	87080	87081	H45AL-ML-30187-R.020
	3/16	.030	5/16	2	3	83603	83604	H45AL-S-30187-R.030
	3/16	.030	9/16	2-1/2	3	83605	83606	H45AL-R-30187-R.030
	3/16	.030	3/4	2-1/2	3	83607	83608	H45AL-M-30187-R.030
	3/16	.030	1	2-1/2	3	87082	87083	H45AL-ML-30187-R.030

* .0003 max TIR

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Speeds & Feeds on Page 75

3 FLUTE - CORNER RADIUS

New Items!



H45AL-3

45° Helix (cont.)

continued from previous page

Cutter Dia.*	Shank Dia.	Corner Radius	Length of Cut	DAL	Flutes	Uncoated	Zplus Coated	Tool Description	
D1 (in)	D2 (in)	R $\frac{+0.002}{-0.002}$	L $\frac{+0.002}{-0.002}$	L1 $\frac{+0.002}{-0.002}$					
3/8	3/8	.125	1/2	2	3	87096	87097	H45AL-S-30375-R.125	
	3/8	.125	3/4	2-1/2	3	88765	88766	H45AL-SR-30375-R.125	new
	3/8	.125	1	3	3	87098	87099	H45AL-R-30375-R.125	
	3/8	.125	1-1/4	3-1/2	3	87100	87101	H45AL-M-30375-R.125	
1/2	1/2	.010	5/8	2-1/2	3	88767	88768	H45AL-S-30500-R.010	new
	1/2	.010	1	3	3	83653	83654	H45AL-SR-30500-R.010	
	1/2	.010	1-1/4	3	3	83655	83656	H45AL-R-30500-R.010	
	1/2	.010	1-5/8	4	3	83657	83658	H45AL-M-30500-R.010	
	1/2	.010	2	4	3	83659	83660	H45AL-L-30500-R.010	
	1/2	.010	2-1/2	5	3	88773	88774	H45AL-LX-30500-R.010	new
	1/2	.020	5/8	2-1/2	3	88769	88770	H45AL-S-30500-R.020	new
	1/2	.020	1	3	3	83661	83662	H45AL-SR-30500-R.020	
	1/2	.020	1-1/4	3	3	83663	83664	H45AL-R-30500-R.020	
	1/2	.020	1-5/8	4	3	83665	83666	H45AL-M-30500-R.020	
	1/2	.020	2	4	3	83667	83668	H45AL-L-30500-R.020	
	1/2	.020	2-1/2	5	3	88775	88776	H45AL-LX-30500-R.020	new
	1/2	.030	5/8	2-1/2	3	83669	83670	H45AL-S-30500-R.030	
	1/2	.030	1	3	3	81611	81612	H45AL-SR-30500-R.030	
	1/2	.030	1-1/4	3	3	81613	81614	H45AL-R-30500-R.030	
	1/2	.030	1-5/8	4	3	81615	81616	H45AL-M-30500-R.030	
	1/2	.030	2	4	3	81617	81618	H45AL-L-30500-R.030	
	1/2	.030	2-1/2	5	3	83671	83672	H45AL-LX-30500-R.030	
	1/2	.060	5/8	2-1/2	3	83673	83674	H45AL-S-30500-R.060	
	1/2	.060	1	3	3	81619	81620	H45AL-SR-30500-R.060	
	1/2	.060	1-1/4	3	3	81621	81622	H45AL-R-30500-R.060	
	1/2	.060	1-5/8	4	3	81623	81624	H45AL-M-30500-R.060	
	1/2	.060	2	4	3	81625	81626	H45AL-L-30500-R.060	
	1/2	.060	2-1/2	5	3	83675	83676	H45AL-LX-30500-R.060	
	1/2	.125	5/8	2-1/2	3	88771	88772	H45AL-S-30500-R.125	new
	1/2	.125	1	3	3	83677	83678	H45AL-SR-30500-R.125	
	1/2	.125	1-1/4	3	3	83679	83680	H45AL-R-30500-R.125	
	1/2	.125	1-5/8	4	3	83681	83682	H45AL-M-30500-R.125	
	1/2	.125	2	4	3	83683	83684	H45AL-L-30500-R.125	
	1/2	.125	2-1/2	5	3	88777	88778	H45AL-LX-30500-R.125	new
5/8	5/8	.030	1-5/8	2-1/2	3	83685	83686	H45AL-R-30625-R.030	
	5/8	.030	2-1/8	4	3	83687	83688	H45AL-M-30625-R.030	
	5/8	.030	2-1/2	5	3	83689	83690	H45AL-L-30625-R.030	
	5/8	.060	1-5/8	2-1/2	3	83691	83692	H45AL-R-30625-R.060	
	5/8	.060	2-1/8	4	3	83693	83694	H45AL-M-30625-R.060	
	5/8	.060	2-1/2	5	3	83695	83696	H45AL-L-30625-R.060	
	5/8	.125	1-5/8	2-1/2	3	83697	83698	H45AL-R-30625-R.125	
	5/8	.125	2-1/8	4	3	83699	83700	H45AL-M-30625-R.125	
	5/8	.125	2-1/2	5	3	83701	83702	H45AL-L-30625-R.125	

* .0003 max TIR

continued on next page

H45AL-3



New Items!

3 FLUTE - CORNER RADIUS

45° Helix (cont.)

continued from previous page

Cutter Dia.* D ₁ (H)	Shank Dia. D ₂ (H)	Corner Radius R $\pm \frac{.002"}{.002"}$	Length of Cut L ₂ $\pm \frac{.002"}{.002"}$	OAL L ₁ $\pm \frac{.002"}{.002"}$	Flutes	Uncoated	Zplus Coated	Tool Description
3/4	3/4	.030	1-5/8	4	3	81627	81628	H45AL-R-3/8750-R.030
	3/4	.030	2	4	3	86779	86780	H45AL-A-3/8750-R.030
	3/4	.030	2-1/4	5	3	81629	81630	H45AL-M-3/8750-R.030
	3/4	.030	2-3/4	5	3	86785	86786	H45AL-ML-3/8750-R.030
	3/4	.060	1-5/8	4	3	81631	81632	H45AL-R-3/8750-R.060
	3/4	.060	2	4	3	86781	86782	H45AL-A-3/8750-R.060
	3/4	.060	2-1/4	5	3	81633	81634	H45AL-M-3/8750-R.060
	3/4	.060	2-3/4	5	3	86787	86788	H45AL-ML-3/8750-R.060
	3/4	.125	1-5/8	4	3	83703	83704	H45AL-R-3/8750-R.125
	3/4	.125	2	4	3	86783	86784	H45AL-A-3/8750-R.125
	3/4	.125	2-1/4	5	3	83705	83706	H45AL-M-3/8750-R.125
	3/4	.125	2-3/4	5	3	86789	86790	H45AL-ML-3/8750-R.125
1	1	.030	2	5	3	86791	86792	H45AL-R-3/1000-R.030
	1	.030	2-5/8	8	3	86793	86794	H45AL-M-3/1000-R.030
	1	.030	3-1/4	8	3	86795	86796	H45AL-L-3/1000-R.030

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3 FLUTE - SQUARE

New Items!



H45AL-RN-3

45° Helix - Reduced Neck

- Designed for outstanding performance and accelerated material removal rates in aluminum and non-ferrous materials.
- Designed with a high helix for improved part finish and shearing action.
- High helix for increased part finish and shearing action.
- Cylindrically ground to maintain edge strength.
- Reduced neck provides maximum strength in long reach and deep pocketing applications.
- Excellent performance in High Efficiency Milling (HEM).
- Center cutting.
- h8 shank tolerance for high precision tool holders.
- Zplus coating offers higher hardness and added lubricity for maximum performance.
- Solid carbide.
- CNC ground in the USA.



Cutter Dia.* D1 (in)	Shank Dia. D2 (in)	Length of Cut L2 $\pm .002$ - .001	Overall Length L1 $\pm .002$ - .001	Reach (LBS) L3	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/8	1/8	5/32	3	1/2	118	3	19015	19017	H45AL-RN-F-30125
	1/8	5/32	3	3/4	118	3	19030	19032	H45AL-RN-M-30125
	1/8	5/32	3	1	118	3	01565	01566	H45AL-RN-L-30125
	1/8	5/32	3	1-3/4	118	3	03707	03708	H45AL-RN-LX-30125
	1/8	5/32	3	1-1/2	118	3	03797	03798	H45AL-RN-X-30125
3/16	3/16	7/32	3	1/2	178	3	19060	19062	H45AL-RN-F-30187
	3/16	7/32	3	3/4	178	3	19075	19077	H45AL-RN-M-30187
	3/16	7/32	3	1	178	3	01567	01568	H45AL-RN-ML-30187
	3/16	7/32	3	1-5/16	178	3	03709	03710	H45AL-RN-LX-30187
	3/16	7/32	3	1-1/2	178	3	03799	03800	H45AL-RN-X-30187
1/4	1/4	3/8	4	3/4	237	3	19105	19107	H45AL-RN-F-30250
	1/4	3/8	4	1-1/8	237	3	19120	19122	H45AL-RN-M-30250
	1/4	3/8	4	1-5/8	237	3	01569	01570	H45AL-RN-A-30250
	1/4	3/8	4	2-1/8	237	3	19135	19137	H45AL-RN-M-30250
	1/4	3/8	4	2-1/2	237	3	01571	01572	H45AL-RN-ML-30250
	1/4	3/8	4-1/2	3	237	3	03711	03712	H45AL-RN-L-30250
5/16	5/16	7/16	4	1-1/8	296	3	19165	19167	H45AL-RN-F-30312
	5/16	7/16	4	1-3/4	296	3	03713	03714	H45AL-RN-A-30312
	5/16	7/16	4	2-1/8	296	3	19180	19182	H45AL-RN-M-30312
	5/16	7/16	6	2-1/8	296	3	19190	19192	H45AL-RN-L-30312
	5/16	7/16	6	4	296	3	19200	19202	H45AL-RN-X-30312
3/8	3/8	1/2	4	1-1/8	356	3	19210	19212	H45AL-RN-F-30375
	3/8	1/2	4	1-5/8	356	3	01573	01574	H45AL-RN-A-30375
	3/8	1/2	4	2-1/8	356	3	19225	19227	H45AL-RN-M-30375
	3/8	1/2	6	2-1/2	356	3	03715	03716	H45AL-RN-ML-30375
	3/8	1/2	6	2-1/8	356	3	19235	19237	H45AL-RN-L-30375
	3/8	1/2	6	2-1/2	356	3	03801	03802	H45AL-RN-LX-30375
	3/8	1/2	6	4	356	3	19245	19247	H45AL-RN-X-30375
1/2	1/2	5/8	4	1-3/8	475	3	19285	19287	H45AL-RN-F-30500
	1/2	5/8	4	1-3/4	475	3	01575	01576	H45AL-RN-A-30500
	1/2	5/8	4	2-1/4	475	3	19300	19302	H45AL-RN-M-30500
	1/2	5/8	4-1/2	2-3/4	475	3	01577	01578	H45AL-RN-ML-30500

* .0003 max TIR

continued on next page



Speeds & Feeds on Page 75

H45AL-3



New Items!

3 FLUTE - SQUARE

45° Helix - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ (in)	Shank Dia. D ₂ (in)	Length of Cut L ₂ + $\frac{102^\circ}{300}$	Overall Length L ₁ + $\frac{92^\circ}{300}$	Reach (LBS) L ₃	Neck Dia.	Flutes	Uncoated	Zplus Coated	Tool Description
1/2	1/2	5/8	6	3-3/8	.473	3	19315	19317	H45AL-RN-L-30500
	1/2	5/8	6	3-3/4	.473	3	83717	83718	H45AL-RN-LX-30500
	1/2	5/8	6	4-1/4	.473	3	19325	19327	H45AL-RN-X-30500
	1/2	5/8	7	5	.473	3	88803	88804	H45AL-RN-Y-30500
3/4	3/4	1	4	2	.712	3	19405	19407	H45AL-RN-R-30750
	3/4	1	6	2-1/2	.712	3	19420	19422	H45AL-RN-M-30750
	3/4	1	6	2-7/8	.712	3	81579	81580	H45AL-RN-XL-30750
	3/4	1	6	3-3/8	.712	3	19435	19437	H45AL-RN-L-30750
	3/4	1	6	4-3/8	.712	3	19445	19447	H45AL-RN-X-30750
	3/4	1	7	5	.712	3	88805	88806	H45AL-RN-Y-30750
1	1	1-1/4	6	3-3/8	.961	3	19400	19402	H45AL-RN-M-31000
	1	1-1/4	7	4-3/8	.961	3	19495	19497	H45AL-RN-L-31000
	1	1-1/4	8	6	.961	3	88807	88808	H45AL-RN-X-31000

*.0003 max TIR

H45AL-3 / H45AL-RN-3

Material Guide		SPM	Inches per Tooth (IPT)																				
			1/8			3/16			1/4			5/8			1/2			3/4			1		
			Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin	Slot	Rph	Fin
WROUGHT ALUMINUM ALLOY	2014, 5082, 6061, 7050, 7075, 7475	2100	.009	.016	.018	.0012	.023	.021	.016	.031	.023	.0024	.045	.027	.032	.069	.032	.046	.085	.037	.038	.108	.045
CAST ALUMINUM ALLOY	319.0, 325.0, 355.0, 390.0, 390.0, 393.0, 500.0, 520.0, 535.0	1400	.013	.024	.025	.0019	.036	.028	.025	.048	.029	.0038	.071	.034	.049	.092	.039	.071	.132	.047	.096	.169	.067
COPPER ALLOY	Cu-ETP, CuBe2, CuZn36, CuZn38Pb3, CuZn10, CuSi5	775	.009	.016	.019	.0013	.024	.021	.017	.032	.024	.0025	.047	.027	.033	.062	.032	.047	.089	.036	.095	.113	.0647

MILLING PROCESS	STYLE	ADOC	RDOC
Slot (Full Milling)	Non-Reached	75%-125% Diameter	100% Diameter
	Reached	Up to full LOC	100% Diameter
Rph (Traditional Roughing)	Non-Reached	125%-200% Diameter	30%-40% Diameter
	Reached	Up to full LOC	30%-40% Diameter
Fin (Finishing)	N/A	Up to full LOC	4%-8% Diameter

NOTES:

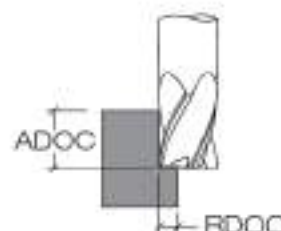
IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.



Regular Style



Reduced Neck Style



Key: LOC=Length of Cut

ADOC=Axial Depth of Cut

RDOC=Radial Depth of Cut

5 FLUTE - SQUARE

New!



HVAL-5

Variable Pitch - For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of aerospace aluminum alloys with excellent performance in other non-ferrous alloys
- Excellent tool life and maximum material removal rates proven through extensive testing
- Engineered with variable pitch for minimized harmonics and reduced tool pressure
- Center cutting
- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Dia. D2 (H4)	Length of Cut L2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Flutes	Uncoated	Nplus Coated	Tool Description	
1/8	1/4	1/4	2-1/2	5	88967	88968	HVAL-020-50125	new
	1/4	3/8	2-1/2	5	88969	88970	HVAL-030-50125	new
	1/4	1/2	2-1/2	5	88971	88972	HVAL-040-50125	new
3/16	1/4	3/8	2-1/2	5	88973	88974	HVAL-020-50187	new
	1/4	3/4	2-1/2	5	88975	88976	HVAL-040-50187	new
	1/4	1	2-1/2	5	88977	88978	HVAL-063-50187	new
1/4	1/4	1/2	2-1/2	5	88979	88980	HVAL-020-50250	new
	1/4	3/4	2-1/2	5	88981	88982	HVAL-030-50250	new
	1/4	1	3	5	88983	88984	HVAL-040-50250	new
3/8	3/8	3/4	2-1/2	5	88985	88986	HVAL-020-50375	new
	3/8	1	3	5	88987	88988	HVAL-026-50375	new
	3/8	1-1/2	3-1/2	5	88989	88990	HVAL-040-50375	new
1/2	1/2	1	3	5	88991	88992	HVAL-020-50500	new
	1/2	1-1/4	3	5	88993	88994	HVAL-025-50500	new
	1/2	1-5/8	4	5	88995	88996	HVAL-032-50500	new
	1/2	2	4	5	88997	88998	HVAL-040-50500	new
3/4	3/4	1-5/8	4	5	89000	89000	HVAL-021-50750	new
	3/4	2-1/4	5	5	89001	89002	HVAL-030-50750	new

*.0003 max TIR



Speeds & Feeds on Page 78

HVAL-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of aerospace aluminum alloys with excellent performance in other non-ferrous alloys
- Excellent tool life and maximum material removal rates proven through extensive testing
- Engineered with variable pitch for minimized harmonics and reduced tool pressure
- Center cutting
- h8 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (h6)	Corner Radius R $\pm \frac{.001}{.002}$	LOC L2 $\pm \frac{.002}{.003}$	Overall Length L1 $\pm \frac{.002}{.003}$	Flutes	Uncoated	Nplus Coated	Tool Description
1/8	1/4	.010	1/4	2-1/2	5	84105	84106	HVAL-C20-50125-R.010
	1/4	.010	3/8	2-1/2	5	84107	84108	HVAL-C30-50125-R.010
	1/4	.010	1/2	2-1/2	5	84109	84110	HVAL-C40-50125-R.010
	1/4	.030	1/4	2-1/2	5	84111	84112	HVAL-C20-50125-R.030
	1/4	.030	3/8	2-1/2	5	84113	84114	HVAL-C30-50125-R.030
	1/4	.030	1/2	2-1/2	5	84115	84116	HVAL-C40-50125-R.030
3/16	1/4	.010	1/4	2-1/2	5	88990	88900	HVAL-C13-50187-R.010
	1/4	.010	3/8	2-1/2	5	84117	84118	HVAL-C20-50187-R.010
	1/4	.010	1/2	2-1/2	5	88901	88902	HVAL-C27-50187-R.010
	1/4	.010	3/4	2-1/2	5	84119	84120	HVAL-C40-50187-R.010
	1/4	.010	1	2-1/2	5	84121	84122	HVAL-C63-50187-R.010
	1/4	.030	3/8	2-1/2	5	84123	84124	HVAL-C20-50187-R.030
1/4	1/4	.030	3/4	2-1/2	5	84125	84126	HVAL-C40-50187-R.030
	1/4	.030	1	2-1/2	5	84127	84128	HVAL-C63-50187-R.030
	3/8	.010	3/8	2-1/2	5	88903	88904	HVAL-C13-50250-R.010
	3/8	.010	1/2	2-1/2	5	84129	84130	HVAL-C20-50250-R.010
	3/8	.010	3/4	2-1/2	5	84131	84132	HVAL-C30-50250-R.010
	3/8	.010	1	3	5	84133	84134	HVAL-C40-50250-R.010
3/8	1/2	.010	1-1/4	3	5	88905	88906	HVAL-C50-50250-R.010
	1/2	.030	1/2	2-1/2	5	84135	84136	HVAL-C20-50250-R.030
	1/2	.030	3/4	2-1/2	5	84137	84138	HVAL-C30-50250-R.030
	1/2	.030	1	3	5	84139	84140	HVAL-C40-50250-R.030
	3/8	.010	1/2	2-1/2	5	88907	88908	HVAL-C13-50375-R.010
	3/8	.010	3/4	2-1/2	5	84141	84142	HVAL-C20-50375-R.010
1/2	3/8	.010	1	3	5	84143	84144	HVAL-C30-50375-R.010
	3/8	.010	1-1/4	3	5	88909	88910	HVAL-C50-50375-R.010
	3/8	.010	1-1/2	3-1/2	5	84145	84146	HVAL-C40-50375-R.010
	3/8	.030	3/4	2-1/2	5	84147	84148	HVAL-C20-50375-R.030
	3/8	.030	1	3	5	84149	84150	HVAL-C30-50375-R.030
	3/8	.030	1-1/2	3-1/2	5	84151	84152	HVAL-C40-50375-R.030

*.0003 max TIR

continued on next page



Speeds & Feeds on Page 78

5 FLUTE - CORNER RADIUS

New Items!



HVAL-5

Variable Pitch - For High Efficiency Milling (cont.)

continued from previous page

Cutter Dia.* D ₁ $\pm .002$ $\pm .002$	Shank Dia. D ₂ (in)	Corner Radius R $\pm .017$ $\pm .007$	LOC L ₂ $\pm .037$ $\pm .007$	Overall Length L ₁ $\pm .037$ $\pm .007$	Flutes	Uncoated	Nplus Coated	Tool Description	
1/2	1/2	.010	5/8	2-1/2	5	88911	88912	HVAL-013-50000-R.010	new
	1/2	.010	1	3	5	84153	84154	HVAL-020-50000-R.010	
	1/2	.010	1-1/4	3	5	84155	84156	HVAL-025-50000-R.010	
	1/2	.010	1-5/8	4	5	84157	84158	HVAL-032-50000-R.010	
	1/2	.010	2	4	5	84159	84160	HVAL-040-50000-R.010	
	1/2	.010	2-1/2	5	5	88913	88914	HVAL-050-50000-R.010	new
	1/2	.030	5/8	2-1/2	5	88915	88916	HVAL-013-50000-R.030	new
	1/2	.030	1	3	5	84161	84162	HVAL-020-50000-R.030	
	1/2	.030	1-1/4	3	5	84163	84164	HVAL-025-50000-R.030	
	1/2	.030	1-5/8	4	5	84165	84166	HVAL-032-50000-R.030	
	1/2	.030	2	4	5	84167	84168	HVAL-040-50000-R.030	
	1/2	.030	2-1/2	5	5	88917	88918	HVAL-050-50000-R.030	new
	1/2	.060	1	3	5	84169	84170	HVAL-020-50000-R.060	
	1/2	.060	1-1/4	3	5	84171	84172	HVAL-025-50000-R.060	
	1/2	.060	1-5/8	4	5	84173	84174	HVAL-032-50000-R.060	
	1/2	.060	2	4	5	84175	84176	HVAL-040-50000-R.060	
	1/2	.125	1	3	5	84177	84178	HVAL-020-50000-R.125	
	1/2	.125	1-1/4	3	5	84179	84180	HVAL-025-50000-R.125	
	1/2	.125	1-5/8	4	5	84181	84182	HVAL-032-50000-R.125	
	1/2	.125	2	4	5	84183	84184	HVAL-040-50000-R.125	
3/4	3/4	.030	1	3	5	88919	88920	HVAL-013-50750-R.030	new
	3/4	.030	1-5/8	4	5	84185	84186	HVAL-021-50750-R.030	
	3/4	.030	2-1/4	5	5	84187	84188	HVAL-030-50750-R.030	
	3/4	.030	2-3/4	5	5	88921	88922	HVAL-037-50750-R.030	new
	3/4	.060	1-5/8	4	5	84189	84190	HVAL-021-50750-R.060	
	3/4	.060	2-1/4	5	5	84191	84192	HVAL-030-50750-R.060	
	3/4	.125	1-5/8	4	5	84193	84194	HVAL-021-50750-R.125	
	3/4	.125	2-1/4	5	5	84195	84196	HVAL-030-50750-R.125	

* DCCG max TIR

HVAL-5

Material/Grade		SPM	Inches per Tooth (IPT)																							
			1/8			3/16			1/4			5/16			3/8			1/2			3/4			1		
			HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin			
WROUGHT ALUMINUM ALLOY	2014, 5082, 6061, 7050, 7075, 7475	2100	.0016	.0013	.0018	.0023	.0020	.0025	.0030	.0028	.0023	.0040	.0039	.0027	.0058	.0051	.0031	.0064	.0073	.0037	.0107	.0094	.0040			
CAST ALUMINUM ALLOY	319.0, 328.0, 335.0, 360.0, 360.0, 383.0, 390.0, 520.0, 535.0	1400	.0023	.0021	.0023	.0035	.0031	.0025	.0047	.0041	.0029	.0070	.0061	.0033	.0071	.0063	.0039	.0131	.0114	.0048	.0167	.0145	.0056			
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn35Pb3, CuZn10, CuSn5	770	.0016	.0014	.0018	.0023	.0021	.0021	.0031	.0028	.0024	.0047	.0041	.0027	.0071	.0063	.0033	.0067	.0076	.0038	.0112	.0097	.0048			

MILLING PROCESS	ADDC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Rgh (Traditional Roughing)	120%-200% Diameter	36%-40% Diameter
Fin (Finishing)	Up to Max LOC	4%-5% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

HMAF-AL

MULTI-AXIS FINISHERS

Multi-Axis Finishers are Helical's solution for operations with extremely high surface finish requirements. When switching from a traditional ball end mill, finish requirements can be dramatically improved, and cycle times can be cut down to a fraction of the time.

Benefits of Multi-Axis Finishing Techniques

The basic principle of a Multi-Axis Finisher comes down to the large radius included in the profile of the tool. With a larger radius, a far greater stepover can be used pass-to-pass while keeping the same cusp height as a ball end mill. This decreases the cycle time by a known value called the Benefit Multiple. A Multi-Axis Finisher with a Benefit Multiple of 8 will reduce the cycle time to 1/8 of the cycle time for a ball end mill of the same shank diameter - an 87.5% time savings! If a Multi-Axis Finisher is used with the same pass-to-pass stepover as a ball end mill, the finish will be drastically improved due to exponentially smaller cusp heights. Most situations allow both reduced cycle time and improved surface finish to be achieved.

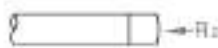


The images above show the comparison of a ball end mill to an oval shape Multi-Axis Finisher with a benefit multiple of 4.

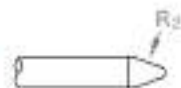


Due to their large radii, Multi-Axis Finishers are best suited for wide open, flowing, and somewhat flat surfaces. Smaller spaces, especially tight corners, will generally not see as much benefit from these tools due to limited use of the major radius.

3 Different Profiles of Multi-Axis Finishers

Lens
pg. 80


The lens form includes 2 tangential radii on the end of the tool and is used for work mostly on the face of a part. Tilt angles of approximately 5 degrees are recommended for these tools to avoid working on-center.

Taper
pg. 81


The taper form includes 3 tangential radii and a taper angle. It allows for the largest radius, and therefore greatest potential improvement of finish and reduction of cycle time. They are best used where a specific approach angle is needed and where maximum performance gain is desired.

Oval
pg. 83


The oval form includes 2 tangential radii and offers the most versatility in smaller spaces where a slightly varied approach angle is required, such as impellers or fan blades.

Helical CAM Resources

Programming Multi-Axis Finishers requires some additional consideration compared to a typical end mill. Luckily, many modern CAM packages offer support for these unique profiles, including many of Helical's CAM partners. Each software has their own name for these toolpaths, so reach out to your CAM or Helical sales rep to find how you can program yours!

MULTI-AXIS FINISHERS - 3 FLUTE

HMAF-AL-3

Lens Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Lens form with two tangential radii for finishing floors
- 3 flute geometry specifically designed for finishing in aluminum and non-ferrous alloys
- Center cutting
- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .002$	Shank Dia. D2 (H9)	Major Radius R1	Corner Radius R2	Length of Cut L2 $\pm .002$	Overall Length L1 $\pm .002$	Flutes	Benefit Multiple	Nplus Coated	Tool Description
3/8	3/8	3/4	.020	3/8	2-1/2	3	2x	86314	HMAF-AL-30375-02-LNS
1/2	1/2	1	.030	1/2	3	3	2x	86315	HMAF-AL-30500-02-LNS
5/8	5/8	1-1/4	.035	5/8	3-1/2	3	2x	86316	HMAF-AL-30625-02-LNS
3/4	3/4	1-1/2	.045	3/4	4	3	2x	86317	HMAF-AL-30750-02-LNS

* .0005 max TIR

HMAF-AL-3

Material Guide		SPM	Inches per Tooth (IPT)						
			1/8	3/16	1/4	5/16	1/2	3/4	1
			F _{in}	F _{in}	F _{in}	F _{in}	F _{in}	F _{in}	F _{in}
WROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	2100	.0016	.0018	.0020	.0023	.0027	.0033	.0039
CAST ALUMINUM ALLOY	319.0, 328.0, 355.0, 390.0, 390.0, 395.0, 390.0, 520.0, 535.0	1400	.0020	.0022	.0025	.0029	.0034	.0040	.0045
COPPER ALLOY	Cu-ETP, Cu-Bi2, Cu-Zn30, Cu-Zn35Pb3, Cu-Zn10, Cu-Sn5	770	.0018	.0018	.0021	.0024	.0028	.0033	.0040

STYLE	TOOLPATH	ADOC (STOCK REMOVAL)	RDOC (STEPOVER PER PASS)
HMAF-AL-3 Lens	Finishing (F _{in})	.005-.010"	.025 x Dia x Benefit Multiple

NOTE:

ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements.

If converting from a ball end mill, the benefit multiple can be used to recalculate stepover pass-to-pass.

HMAF-AL-4

New Items!

MULTI-AXIS FINISHERS - 4 FLUTE

Taper Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Taper form with three tangential radii offered in a variety of angles for maximum performance and optimal clearance angle for any workpiece
- 4 flute geometry specifically designed for finishing in aluminum and non-ferrous alloys
- Center cutting
- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminums and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



Ang. Per Side A1 $\pm \frac{.002}{.002}$	Shank Dia.* D2 (in)	Major Radius R1	Tip Radius R2	Corner Radius R3	Length of Cut L2	OAL L1 $\pm \frac{.002}{.002}$	Flutes	Benefit Multiple	Nplus Coated	Tool Description
new new 15°	1/4	8	1/16	1/8	.3040	2	4	8x	96271	HMAF-AL-40375-08-T15
	1/4	18	1/16	1/8	.3040	2	4	12x	96276	HMAF-AL-40375-12-T15
	3/8	12	3/64	3/16	.5801	2-1/2	4	8x	96279	HMAF-AL-40375-08-T15
	3/8	27	3/64	3/16	.5802	2-1/2	4	12x	96284	HMAF-AL-40375-12-T15
	1/2	16	1/16	1/4	.7888	3	4	8x	96287	HMAF-AL-40500-08-T15
	1/2	36	1/16	1/4	.7889	3	4	12x	96292	HMAF-AL-40500-12-T15
	5/8	20	5/64	5/16	.9634	3	4	8x	96295	HMAF-AL-40625-08-T15
	5/8	45	5/64	5/16	.9635	3	4	12x	96300	HMAF-AL-40625-12-T15
	3/4	24	3/32	3/8	1.1801	4	4	8x	96303	HMAF-AL-40750-08-T15
	3/4	54	3/32	3/8	1.1803	4	4	12x	96308	HMAF-AL-40750-12-T15
new new 30°	1/4	8	1/16	1/8	.1875	2	4	8x	96272	HMAF-AL-40250-08-T30
	1/4	18	1/16	1/8	.1875	2	4	12x	96277	HMAF-AL-40250-12-T30
	3/8	12	3/64	3/16	.3281	2-1/2	4	8x	96280	HMAF-AL-40375-08-T30
	3/8	27	3/64	3/16	.3281	2-1/2	4	12x	96285	HMAF-AL-40375-12-T30
	1/2	16	1/16	1/4	.4375	3	4	8x	96288	HMAF-AL-40500-08-T30
	1/2	36	1/16	1/4	.4375	3	4	12x	96293	HMAF-AL-40500-12-T30
	5/8	20	5/64	5/16	.5489	3	4	8x	96296	HMAF-AL-40625-08-T30
	5/8	45	5/64	5/16	.5489	3	4	12x	96301	HMAF-AL-40625-12-T30
	3/4	24	3/32	3/8	.6862	4	4	8x	96304	HMAF-AL-40750-08-T30
	3/4	54	3/32	3/8	.6862	4	4	12x	96309	HMAF-AL-40750-12-T30
new new 45°	1/4	8	1/16	1/32	.1121	2	4	8x	96273	HMAF-AL-40250-08-T45
	1/4	18	1/16	1/32	.1121	2	4	12x	96278	HMAF-AL-40250-12-T45
	3/8	12	3/64	3/64	.1875	2-1/2	4	8x	96281	HMAF-AL-40375-08-T45
	3/8	27	3/64	3/64	.1875	2-1/2	4	12x	96286	HMAF-AL-40375-12-T45
	1/2	16	1/16	1/16	.2500	3	4	8x	96289	HMAF-AL-40500-08-T45
	1/2	36	1/16	1/16	.2500	3	4	12x	96294	HMAF-AL-40500-12-T45
	5/8	20	5/64	5/64	.3125	3	4	8x	96297	HMAF-AL-40625-08-T45
	5/8	45	5/64	5/64	.3125	3	4	12x	96302	HMAF-AL-40625-12-T45
	3/4	24	3/32	3/32	.3750	4	4	8x	96305	HMAF-AL-40750-08-T45
	3/4	54	3/32	3/32	.3750	4	4	12x	96310	HMAF-AL-40750-12-T45

*.0005 max TR

continued on next page



Speeds & Feeds on Page 83

MULTI-AXIS FINISHERS - 4 FLUTE

New Items!

HMAF-AL-4

Taper Form (cont.)

continued from previous page

Ang. Per Side A ₁ ^{+0.30} / _{-0.30}	Shank Dia.* D ₂ (R)	Major Radius R ₁	Tip Radius R ₂	Corner Radius R ₃	Length of Cut L ₁	QAL L ₁ ^{+0.02} / _{-0.02}	Flutes	Benefit Multiple	Nplus Coated	Tool Description	
60°	1/4	8	1/16	1/64	.0715	2	4	8x	86274	HMAF-AL-40250-08-T60	new
	3/8	12	3/32	3/128	.1073	2-1/2	4	8x	86282	HMAF-AL-40375-08-T60	new
	1/2	16	1/8	1/32	.1430	3	4	8x	86290	HMAF-AL-40500-08-T60	new
	5/8	20	5/32	5/128	.1788	3	4	8x	86296	HMAF-AL-40625-08-T60	new
	3/4	24	3/16	3/64	.2146	4	4	8x	86306	HMAF-AL-40750-08-T60	new
75°	1/4	8	1/16	1/64	.0433	2	4	8x	86275	HMAF-AL-40250-08-T75	new
	3/8	12	3/32	3/128	.0649	2-1/2	4	8x	86283	HMAF-AL-40375-08-T75	new
	1/2	16	1/8	1/32	.0900	3	4	8x	86291	HMAF-AL-40500-08-T75	new
	5/8	20	5/32	5/128	.1062	3	4	8x	86299	HMAF-AL-40625-08-T75	new
	3/4	24	3/16	3/64	.1298	4	4	8x	86307	HMAF-AL-40750-08-T75	new

* .0005 max TIR

The Advantageous Qualities of Helical Solutions' Nplus Coating

In The Loupe
ANALYTICAL BLOG

Is Nplus coating the right option for you, and your next project? Let us answer that question for you in our "In the Loupe" blog post: *The Advantageous Qualities of Helical Solutions' Nplus Coating.* There, we bring you through the many benefits of this unique coating option, but also tell you when Nplus may not be your best option.

www.harveyprecision.com/in-the-loupe/nplus-coating/


SCAN TO READ

HMAF-AL-4**New Items!****MULTI-AXIS FINISHERS - 4 FLUTE****Oval Form**

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Oval form with two tangential radii for versatility in angle of approach and clearance in tight spaces
- 4 flute geometry specifically designed for finishing in aluminum and non-ferrous alloys
- Center cutting
- h6 shank tolerance for high precision tool holders
- Nplus coating for maximum performance in abrasive aluminum and extended tool life in a wide variety of non-ferrous alloys
- Solid carbide
- CNC ground in the USA



NEW

NEW

NEW

NEW

Cutter Dia.* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (H6)	Major Radius R1	Tip Radius R2	LOC L2	OAL L1 $\pm \frac{.002}{.002}$	Flutes	Benefit Multiple	Nplus Coated	Tool Description
3/8	3/8	3	3/32	.8260	2-1/2	4	4x	86267	HMAF-AL-40375-04-DVL
	3/8	3	3/32	.8260	4	4	4x	87973	HMAF-AL-40375-04-DVL
1/2	1/2	4	1/8	1.1013	3	4	4x	86269	HMAF-AL-40500-04-DVL
	1/2	4	1/8	1.1013	4	4	4x	87976	HMAF-AL-40500-04-DVL
5/8	5/8	5	5/32	1.3766	3-1/2	4	4x	86269	HMAF-AL-40625-04-DVL
	5/8	5	5/32	1.3766	6	4	4x	87977	HMAF-AL-40625-04-DVL
3/4	3/4	6	3/16	1.6519	4	4	4x	86279	HMAF-AL-40750-04-DVL
	3/4	6	3/16	1.6519	6	4	4x	87973	HMAF-AL-40750-04-DVL

*.0005 max TIP

HMAF-AL-4

Material Guide		SFM	Inches per Tooth (IPT)						
			18	3/10	1/4	3/8	1/2	3/4	1
			F _{in}	F _{in}	F _{in}	F _{in}	F _{in}	F _{in}	F _{in}
WROUGHT ALUMINUM ALLOY	2014, 6062, 6061, 7050, 7075, 7475	2100	.0024	.0027	.0030	.0035	.0041	.0050	.0059
CAST ALUMINUM ALLOY	318.0, 328.0, 355.0, 360.0, 380.0, 390.0, 396.0, 520.0, 535.0	1800	.0030	.0033	.0038	.0044	.0051	.0060	.0070
COPPER ALLOY	Cu-ETR, CuB42, CuZn02, CuZn36Pb3, CuZn40, CuSn5	770	.0024	.0027	.0032	.0038	.0042	.0050	.0060

STYLE	TOOLPATH	ADOC (STOCK REMOVAL)	RDOC (STROVER PER PASS)
HMAF-AL-4 Oval	Finishing (Fin)	.005"-.010"	.025 x Dia x Benefit Multiple
HMAF-AL-4 Taper	Finishing (Fin)	.005"-.010"	.025 x Dia x Benefit Multiple

NOTE

ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements. If converting from a ball end mill, the benefit multiple can be used to recalculate stepover pass-to-pass.

4 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch

HSVR-C-4

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Eccentric relief for maximum edge strength
- Redesigned end geometry for optimal ramping, slotting, and plunging
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter*	Shank Dia.	Corner Radius	LDC	Overall Length	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
$D_1 \pm .002$	$D_2 \pm .001$	$R \pm .002$	$L_2 \pm .002$	$L_1 \pm .002$				
1/8	1/8	.010	1/4	1-1/2	4	33017		HSVR-C-S-40125-R.010
	1/8	.010	3/8	2	4	82499		HSVR-C-SR-40125-R.010
	1/8	.010	1/2	2-1/2	4	33032		HSVR-C-R-40125-R.010
	1/8	.010	5/8	2-1/2	4	82500		HSVR-C-A-40125-R.010
	1/8	.030	1/4	1-1/2	4	83453		HSVR-C-S-40125-R.030
	1/8	.030	1/2	2-1/2	4	83454		HSVR-C-R-40125-R.030
3/16	3/16	.010	5/16	2	4	33077		HSVR-C-S-40187-R.010
	3/16	.010	7/16	2	4	82501		HSVR-C-SR-40187-R.010
	3/16	.010	5/8	2-1/2	4	33092		HSVR-C-R-40187-R.010
	3/16	.010	1	2-1/2	4	82502		HSVR-C-M-40187-R.010
	3/16	.030	5/16	2	4	83455		HSVR-C-S-40187-R.030
	3/16	.030	5/8	2-1/2	4	83456		HSVR-C-R-40187-R.030
1/4	1/4	.010	3/8	2	4	83457		HSVR-C-S-40250-R.010
	1/4	.010	1/2	2-1/2	4	83458		HSVR-C-SR-40250-R.010
	1/4	.010	3/4	2-1/2	4	83459		HSVR-C-R-40250-R.010
	1/4	.020	5/8	2	4	33137	33137W	HSVR-C-S-40250-R.020
	1/4	.020	1/2	2-1/2	4	33142	33142W	HSVR-C-SR-40250-R.020
	1/4	.020	3/4	2-1/2	4	33152	33152W	HSVR-C-R-40250-R.020
	1/4	.020	1	3	4	33167		HSVR-C-M-40250-R.020
	1/4	.020	1-1/4	3	4	82503		HSVR-C-L-40250-R.020
	1/4	.030	3/8	2	4	83460		HSVR-C-S-40250-R.030
	1/4	.030	1/2	2-1/2	4	83461		HSVR-C-SR-40250-R.030
	1/4	.030	3/4	2-1/2	4	83462		HSVR-C-R-40250-R.030
5/16	5/16	.020	1/2	2	4	33227		HSVR-C-S-40312-R.020
	5/16	.020	3/4	2-1/2	4	33242		HSVR-C-R-40312-R.020
	5/16	.020	1	2-1/2	4	82504		HSVR-C-A-40312-R.020
	5/16	.020	1-1/4	3	4	33257		HSVR-C-M-40312-R.020

* .0005 max TIR

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HSVR-C-4

4 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\frac{+0.007}{-0.007}$	Shank Dia. D2 (in)	Corner Radius R $\frac{+0.007}{-0.007}$	LOC L2 $\frac{+0.007}{-0.007}$	Overall Length L1 $\frac{+0.007}{-0.007}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
3/8	3/8	.010	1/2	2	4	83463		HSVR-C-S-40375-R.010
	3/8	.010	7/8	3	4	83464		HSVR-C-SR-40375-R.010
	3/8	.010	1	3	4	83465		HSVR-C-R-40375-R.010
	3/8	.020	1/2	2	4	33317	33317W	HSVR-C-S-40375-R.020
	3/8	.020	7/8	3	4	33332	33332W	HSVR-C-SR-40375-R.020
	3/8	.020	1	3	4	33337	33337W	HSVR-C-R-40375-R.020
	3/8	.020	1-1/4	3	4	33347	33347W	HSVR-C-M-40375-R.020
	3/8	.020	1-1/2	3	4	82506		HSVR-C-L-40375-R.020
	3/8	.030	1/2	2	4	83466		HSVR-C-S-40375-R.030
	3/8	.030	7/8	3	4	83467		HSVR-C-SR-40375-R.030
	3/8	.030	1	3	4	83468		HSVR-C-R-40375-R.030
7/16	7/16	.020	5/8	2-3/4	4	33407		HSVR-C-S-40437-R.020
	7/16	.020	7/8	2-3/4	4	33422		HSVR-C-R-40437-R.020
1/2	1/2	.010	5/8	2-1/2	4	83469		HSVR-C-S-40500-R.010
	1/2	.010	1	3	4	83470		HSVR-C-SR-40500-R.010
	1/2	.010	1-1/4	3	4	83471		HSVR-C-R-40500-R.010
	1/2	.010	1-5/8	4	4	83472		HSVR-C-M-40500-R.010
	1/2	.030	5/8	2-1/2	4	33487	33487W	HSVR-C-S-40500-R.030
	1/2	.030	1	3	4	33512	33512W	HSVR-C-SR-40500-R.030
	1/2	.030	1-1/4	3	4	33527	33527W	HSVR-C-R-40500-R.030
	1/2	.030	1-5/8	4	4	33542	33542W	HSVR-C-M-40500-R.030
	1/2	.030	2	4	4	82506		HSVR-C-L-40500-R.030
	1/2	.030	2-1/2	4	4	82507		HSVR-C-LX-40500-R.030
	1/2	.060	5/8	2-1/2	4	83473		HSVR-C-S-40500-R.060
	1/2	.060	1	3	4	83474		HSVR-C-SR-40500-R.060
	1/2	.060	1-1/4	3	4	83475		HSVR-C-R-40500-R.060
	1/2	.060	1-5/8	4	4	83476		HSVR-C-M-40500-R.060
5/8	5/8	.030	3/4	3	4	33557	33557W	HSVR-C-S-40625-R.030
	5/8	.030	1-1/4	3-1/2	4	33572	33572W	HSVR-C-SR-40625-R.030
	5/8	.030	1-5/8	3-1/2	4	33587	33587W	HSVR-C-R-40625-R.030
	5/8	.030	2	4	4	33602	33602W	HSVR-C-M-40625-R.030
	5/8	.030	2-1/2	5	4	82508		HSVR-C-ML-40625-R.030
	5/8	.030	3-1/4	6	4	33617		HSVR-C-L-40625-R.030
	5/8	.060	1-1/4	3-1/2	4	83477		HSVR-C-SR-40625-R.060
	5/8	.060	1-5/8	3-1/2	4	83478		HSVR-C-R-40625-R.060
3/4	3/4	.030	2	4	4	83479		HSVR-C-M-40625-R.060
	3/4	.030	7/8	3	4	33632	33632W	HSVR-C-S-40750-R.030
	3/4	.030	1-1/4	4	4	33647	33647W	HSVR-C-SR-40750-R.030
	3/4	.030	1-5/8	4	4	33662	33662W	HSVR-C-R-40750-R.030
	3/4	.030	2-1/4	5	4	33677	33677W	HSVR-C-M-40750-R.030
	3/4	.030	2-3/4	5	4	82509		HSVR-C-ML-40750-R.030
	3/4	.030	3-1/4	6	4	33692	33692W	HSVR-C-L-40750-R.030
	3/4	.060	1-5/8	4	4	83480		HSVR-C-R-40750-R.060
1	1	.030	2-1/4	5	4	83481		HSVR-C-M-40750-R.060
	1	.030	1-1/2	4	4	33707		HSVR-C-S-41000-R.030
	1	.030	2	4-1/2	4	33722		HSVR-C-R-41000-R.030
	1	.030	2-5/8	5	4	33737	33737W	HSVR-C-M-41000-R.030
	1	.030	3	6	4	33742	33742W	HSVR-C-ML-41000-R.030
1	1	.030	4-1/4	7	4	33752		HSVR-C-L-41000-R.030

* .0005 max TR

4 FLUTE - CORNER RADIUS

HSVR-C-RN-4

Chipbreaker Rougher - Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Eccentric relief for maximum edge strength
- Redesigned end geometry for optimal ramping, slotting, and plunging
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .0005$ -.002	Shank Dia. D2 H6	Corner Radius R $\pm .002$ -.002	Length of Cut L2 $\pm .002$ -.002	OAL L1 $\pm .001$ -.001	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/4	1/4	.020	3/8	4	3/4	.217	4	82876	HSVR-C-RN-S-40250-R.020
	1/4	.020	3/8	4	1-1/8	.217	4	82877	HSVR-C-RN-R-40250-R.020
	1/4	.020	3/8	4	2-1/8	.217	4	82878	HSVR-C-RN-M-40250-R.020
3/8	3/8	.020	1/2	4	1-1/8	.356	4	82879	HSVR-C-RN-S-40375-R.020
	3/8	.020	1/2	4	2-1/8	.356	4	82880	HSVR-C-RN-R-40375-R.020
	3/8	.020	1/2	6	3-1/8	.356	4	82881	HSVR-C-RN-M-40375-R.020
1/2	1/2	.030	5/8	4	1-1/2	.475	4	82882	HSVR-C-RN-S-40500-R.030
	1/2	.030	5/8	4	2-1/4	.475	4	82883	HSVR-C-RN-R-40500-R.030
	1/2	.030	5/8	6	3-3/8	.475	4	82884	HSVR-C-RN-M-40500-R.030
	1/2	.030	5/8	6	4-1/8	.475	4	82885	HSVR-C-RN-L-40500-R.030
3/4	3/4	.030	1	4	2	.712	4	82886	HSVR-C-RN-S-40750-R.030
	3/4	.030	1	6	2-1/2	.712	4	82887	HSVR-C-RN-R-40750-R.030
	3/4	.030	1	6	3-3/8	.712	4	82888	HSVR-C-RN-M-40750-R.030

* .0005 max TR



HSVR-C-4

SPEEDS & FEEDS

4 Flute - Chipbreaker Rougher - Variable Pitch

HSVR-C-4 / HSVR-C-RN-4

Material Guide		Hardness	SPM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		5/16		3/8		7/8		1	
				Sot	Rgn	Sot	Rgn	Sot	Rgn	Sot	Rgn	Sot	Rgn	Sot	Rgn	Sot	Rgn
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	435	.008	.013	.012	.019	.015	.025	.023	.037	.038	.046	.042	.069	.064	.088
		75 - 99 HRB	440	.008	.009	.008	.014	.011	.016	.017	.027	.022	.035	.031	.051	.046	.065
		21 - 36 HRC	435	.004	.006	.005	.006	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 95XX	75 - 99 HRB	390	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	340	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		36 - 50 HRC	290	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	155	.003	.004	.004	.006	.005	.008	.007	.012	.011	.016	.014	.023	.017	.029
		75 - 99 HRB	340	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	290	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
SPECIALTY STEEL	300M, Inconel 600, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	75 - 99 HRB	390	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	175	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	150	.004	.006	.005	.009	.007	.011	.010	.017	.014	.022	.019	.032	.025	.040
AUSTENITIC STAINLESS STEEL	304, 316, 321, 304L, 316L, 321L, 307, 309, 310, 314, 315, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 996, 997, 998, 999, 1000	75 - 99 HRB	295	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	225	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 430, 440, 430, 440	75 - 99 HRB	330	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	280	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	200	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 455	75 - 99 HRB	410	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		21 - 36 HRC	370	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
GRAY CAST IRON	SAE J131, ASTM A48	75 - 99 HRB	410	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		21 - 36 HRC	370	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
MALLEABLE CAST IRON	ASTM A47, ASTM A225, ASTM A502	75 - 99 HRB	345	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	330	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 657	75 - 99 HRB	310	.005	.008	.007	.012	.010	.016	.014	.025	.019	.031	.027	.044	.034	.056
		21 - 36 HRC	280	.004	.007	.006	.010	.008	.013	.012	.019	.016	.025	.022	.033	.028	.042
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.007	.011	.010	.016	.013	.022	.020	.032	.026	.042	.037	.050	.047	.077
		75 - 99 HRB	230	.006	.009	.008	.014	.011	.016	.017	.027	.022	.035	.031	.051	.046	.065
		21 - 36 HRC	75	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Inconel 20	75 - 99 HRB	65	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
		21 - 36 HRC	75	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
		36 - 50 HRC	75	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		75 - 99 HRB	275	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		21 - 36 HRC	250	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 12V-2Fe-3Al	75 - 99 HRB	180	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		21 - 36 HRC	160	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		36 - 50 HRC	160	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
COBALT ALLOY	ASTM F902, ASTM F906, ASTM F75, ASTM F756	75 - 99 HRB	210	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		21 - 36 HRC	170	.004	.006	.005	.009	.007	.012	.011	.017	.014	.023	.022	.033	.028	.042
		36 - 50 HRC	65	.003	.005	.004	.006	.006	.010	.009	.015	.012	.020	.018	.029	.022	.036

MILLING PROCESS	HARDNESS	ADOC	ROOC
Sot (Full Stepping)	< 35 HRC	75%-125% Diameter	100% Diameter
	≥ 35 HRC	60%-75% Diameter	100% Diameter
Rgn (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	20%-40% Diameter

5 FLUTE - CORNER RADIUS

New Items!



HEV-C-5

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 188 for Tplus coating



Cutter Diameter* D1 $^{+0.005}$ -0.005	Shank Diameter D2 (H6)	Corner Radius R $^{+0.005}$ -0.005	Length of Cut L2 $^{+0.012}$ -0.007	Overall Length L1 $^{+0.012}$ -0.007	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	59391	HEV-C-S-50125-R.010
	1/8	.010	3/8	2	5	82213	HEV-C-SR-50125-R.010
	1/8	.010	1/2	2-1/2	5	59392	HEV-C-R-50125-R.010
	1/8	.010	5/8	2-1/2	5	82214	HEV-C-A-50125-R.010
	1/8	.010	3/4	2-1/2	5	83068	HEV-C-M-50125-R.010
	1/8	.020	1/4	1-1/2	5	87343	HEV-C-S-50125-R.020
	1/8	.020	3/8	2	5	87344	HEV-C-SR-50125-R.020
	1/8	.020	1/2	2-1/2	5	87345	HEV-C-R-50125-R.020
	1/8	.020	5/8	2-1/2	5	87346	HEV-C-A-50125-R.020
	1/8	.020	3/4	2-1/2	5	87347	HEV-C-M-50125-R.020
	1/8	.030	1/4	1-1/2	5	87348	HEV-C-S-50125-R.030
	1/8	.030	3/8	2	5	87349	HEV-C-SR-50125-R.030
	1/8	.030	1/2	2-1/2	5	87350	HEV-C-R-50125-R.030
	1/8	.030	5/8	2-1/2	5	87351	HEV-C-A-50125-R.030
	1/8	.030	3/4	2-1/2	5	87352	HEV-C-M-50125-R.030
3/16	3/16	.010	5/16	2	5	59393	HEV-C-S-50187-R.010
	3/16	.010	7/16	2	5	81956	HEV-C-SR-50187-R.010
	3/16	.010	9/16	2-1/2	5	59394	HEV-C-R-50187-R.010
	3/16	.010	3/4	2-1/2	5	81957	HEV-C-M-50187-R.010
	3/16	.010	1	2-1/2	5	83069	HEV-C-ML-50187-R.010
	3/16	.020	5/16	2	5	87353	HEV-C-S-50187-R.020
	3/16	.020	7/16	2	5	87354	HEV-C-SR-50187-R.020
	3/16	.020	9/16	2-1/2	5	87355	HEV-C-R-50187-R.020
	3/16	.020	3/4	2-1/2	5	87356	HEV-C-M-50187-R.020
	3/16	.020	1	2-1/2	5	87357	HEV-C-ML-50187-R.020
	3/16	.030	5/16	2	5	83070	HEV-C-S-50187-R.030
	3/16	.030	7/16	2	5	83071	HEV-C-SR-50187-R.030
	3/16	.030	9/16	2-1/2	5	83072	HEV-C-R-50187-R.030
	3/16	.030	3/4	2-1/2	5	83073	HEV-C-M-50187-R.030
	3/16	.030	1	2-1/2	5	87358	HEV-C-ML-50187-R.030

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Speeds & Feeds on Page 92

HEV-C-5



New Items!

5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H8)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Flutes	Aplics Control	Tool Description
1/4	1/4	.020	3/8	2	5	56395	HEV-C-S-50250-R.020
	1/4	.020	1/2	2-1/2	5	56396	HEV-C-SR-50250-R.020
	1/4	.020	3/4	2-1/2	5	56397	HEV-C-R-50250-R.020
	1/4	.020	1	3	5	56398	HEV-C-M-50250-R.020
	1/4	.020	1-1/4	3	5	82215	HEV-C-L-50250-R.020
	1/4	.020	1-1/2	3	5	83074	HEV-C-LX-50250-R.020
	1/4	.030	3/8	2	5	83075	HEV-C-S-50250-R.030
	1/4	.030	1/2	2-1/2	5	83076	HEV-C-SR-50250-R.030
	1/4	.030	3/4	2-1/2	5	83077	HEV-C-R-50250-R.030
	1/4	.030	1	3	5	83078	HEV-C-M-50250-R.030
	1/4	.030	1-1/4	3	5	86493	HEV-C-L-50250-R.030
	1/4	.060	3/8	2	5	87350	HEV-C-S-50250-R.060
	1/4	.060	1/2	2-1/2	5	87351	HEV-C-SR-50250-R.060
	1/4	.060	3/4	2-1/2	5	87352	HEV-C-R-50250-R.060
5/16	5/16	.020	7/16	2	5	56399	HEV-C-S-50312-R.020
	5/16	.020	13/16	2-1/2	5	56400	HEV-C-SR-50312-R.020
	5/16	.020	1-1/4	3	5	82216	HEV-C-L-50312-R.020
	5/16	.030	7/16	2	5	86494	HEV-C-S-50312-R.030
	5/16	.030	13/16	2-1/2	5	86495	HEV-C-SR-50312-R.030
	5/16	.030	1-1/4	3	5	86496	HEV-C-L-50312-R.030
3/8	3/8	.020	1/2	2	5	56401	HEV-C-S-50375-R.020
	3/8	.020	3/4	2-1/2	5	81958	HEV-C-SR-50375-R.020
	3/8	.020	1	3	5	56402	HEV-C-R-50375-R.020
	3/8	.020	1-1/4	3	5	56403	HEV-C-M-50375-R.020
	3/8	.020	1-1/2	3-1/2	5	82217	HEV-C-L-50375-R.020
	3/8	.020	2	4	5	83079	HEV-C-LX-50375-R.020
	3/8	.030	1/2	2	5	83080	HEV-C-S-50375-R.030
	3/8	.030	3/4	2-1/2	5	83081	HEV-C-SR-50375-R.030
	3/8	.030	1	3	5	83082	HEV-C-R-50375-R.030
	3/8	.030	1-1/4	3	5	83083	HEV-C-M-50375-R.030
	3/8	.030	1-1/2	3-1/2	5	86497	HEV-C-L-50375-R.030
	3/8	.060	1/2	2	5	87353	HEV-C-S-50375-R.060
	3/8	.060	3/4	2-1/2	5	87354	HEV-C-SR-50375-R.060
	3/8	.060	1	3	5	87355	HEV-C-R-50375-R.060
	3/8	.060	1-1/4	3	5	87356	HEV-C-M-50375-R.060
1/2	1/2	.010	5/8	2-1/2	5	83084	HEV-C-S-50500-R.010
	1/2	.010	1	3	5	83085	HEV-C-SR-50500-R.010
	1/2	.010	1-1/4	3	5	83086	HEV-C-R-50500-R.010
	1/2	.010	1-5/8	4	5	83087	HEV-C-M-50500-R.010
	1/2	.010	2	4	5	83088	HEV-C-L-50500-R.010
	1/2	.010	2-1/2	5	5	86503	HEV-C-LX-50500-R.010
	1/2	.020	5/8	2-1/2	5	86498	HEV-C-S-50500-R.020
	1/2	.020	1	3	5	86499	HEV-C-SR-50500-R.020
	1/2	.020	1-1/4	3	5	86500	HEV-C-R-50500-R.020
	1/2	.020	1-5/8	4	5	86501	HEV-C-M-50500-R.020
	1/2	.020	2	4	5	86502	HEV-C-L-50500-R.020
	1/2	.030	5/8	2-1/2	5	56404	HEV-C-S-50500-R.030
	1/2	.030	1	3	5	56405	HEV-C-SR-50500-R.030

*.0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-C-5

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ ± .002"	Shank Diameter D ₂ (in)	Corner Radius R ± .002"	Length of Cut L ₂ ± .002"	Overall Length L ₁ ± .002"	Flutes	Aplus Coated	Tool Description
1/2	1/2	.030	1-1/4	3	5	59406	HEV-C-R-50500-R.030
	1/2	.030	1-5/8	4	5	59407	HEV-C-M-50500-R.030
	1/2	.030	2	4	5	59408	HEV-C-L-50500-R.030
	1/2	.030	2-1/2	5	5	81959	HEV-C-LX-50500-R.030
	1/2	.030	3-1/8	6	5	82218	HEV-C-X-50500-R.030
	1/2	.030	3-5/8	6	5	82219	HEV-C-Y-50500-R.030
	1/2	.060	5/8	2-1/2	5	81960	HEV-C-S-50500-R.060
	1/2	.060	1	3	5	81961	HEV-C-SR-50500-R.060
	1/2	.060	1-1/4	3	5	81962	HEV-C-R-50500-R.060
	1/2	.060	1-5/8	4	5	81963	HEV-C-M-50500-R.060
	1/2	.060	2	4	5	81964	HEV-C-L-50500-R.060
	1/2	.060	2-1/2	5	5	81965	HEV-C-LX-50500-R.060
	1/2	.060	3-1/8	6	5	83089	HEV-C-X-50500-R.060
	1/2	.125	5/8	2-1/2	5	87367	HEV-C-S-50500-R.125
	1/2	.125	1	3	5	87368	HEV-C-SR-50500-R.125
	1/2	.125	1-1/4	3	5	87369	HEV-C-R-50500-R.125
	1/2	.125	1-5/8	4	5	87370	HEV-C-M-50500-R.125
5/8	5/8	.030	3/4	3	5	59409	HEV-C-S-50625-R.030
	5/8	.030	1-1/4	3-1/2	5	59410	HEV-C-SR-50625-R.030
	5/8	.030	1-5/8	3-1/2	5	59411	HEV-C-R-50625-R.030
	5/8	.030	2-1/8	4	5	59412	HEV-C-M-50625-R.030
	5/8	.030	2-1/2	5	5	82220	HEV-C-L-50625-R.030
	5/8	.030	3-1/4	6	5	82221	HEV-C-LX-50625-R.030
	5/8	.060	3/4	3	5	81966	HEV-C-S-50625-R.060
	5/8	.060	1-1/4	3-1/2	5	81967	HEV-C-SR-50625-R.060
	5/8	.060	1-5/8	3-1/2	5	81968	HEV-C-R-50625-R.060
	5/8	.060	2-1/8	4	5	81969	HEV-C-M-50625-R.060
3/4	3/4	.030	1	3	5	59413	HEV-C-S-50750-R.030
	3/4	.030	1-5/8	4	5	59414	HEV-C-R-50750-R.030
	3/4	.030	2-1/4	5	5	59415	HEV-C-M-50750-R.030
	3/4	.030	2-3/4	5	5	59416	HEV-C-L-50750-R.030
	3/4	.030	3-1/4	6	5	59417	HEV-C-LX-50750-R.030
	3/4	.030	4	6-1/2	5	82222	HEV-C-X-50750-R.030
	3/4	.060	1	3	5	81970	HEV-C-S-50750-R.060
	3/4	.060	1-5/8	4	5	81971	HEV-C-R-50750-R.060
	3/4	.060	2-1/4	5	5	81972	HEV-C-M-50750-R.060
	3/4	.060	2-3/4	5	5	81973	HEV-C-L-50750-R.060
	3/4	.060	3-1/4	6	5	81974	HEV-C-LX-50750-R.060
	3/4	.060	4	6-1/2	5	88506	HEV-C-X-50750-R.060
	3/4	.125	1-5/8	4	5	87371	HEV-C-R-50750-R.125
	3/4	.125	2-1/4	5	5	87372	HEV-C-M-50750-R.125
	3/4	.125	2-3/4	5	5	87373	HEV-C-L-50750-R.125
	3/4	.125	3-1/4	6	5	87374	HEV-C-LX-50750-R.125
1	1	.030	1-1/4	4	5	59418	HEV-C-S-51000-R.030
	1	.030	2	4-1/2	5	59419	HEV-C-R-51000-R.030
	1	.030	2-5/8	5	5	88507	HEV-C-M-51000-R.030
	1	.030	3-1/4	6	5	88508	HEV-C-L-51000-R.030

* .0005 max TIR

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HEV-C-RN-5



5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .001$ -.002	Shank Dia. D2 (H6)	Corner Radius R $\pm .002$ -.002	Length of Cut L2 $\pm .001$	OAL L1 $\pm .002$ -.002	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	5/32	2	2/8	.118	5	87305	HEV-C-RN-S-50125-S.010
	1/8	.010	5/32	2	1/2	.118	5	87306	HEV-C-RN-SB-50125-R.010
	1/8	.010	5/32	2-1/2	2/4	.118	5	87307	HEV-C-RN-R-50125-S.010
	1/8	.010	5/32	2-1/2	1	.118	5	87308	HEV-C-RN-M-50125-R.010
3/16	3/16	.010	7/32	2	1/2	.178	5	87309	HEV-C-RN-S-50187-S.010
	3/16	.010	7/32	2-1/2	2/4	.178	5	87400	HEV-C-RN-SB-50187-R.010
	3/16	.010	7/32	2-1/2	1-1/8	.178	5	87401	HEV-C-RN-R-50187-S.010
	3/16	.010	7/32	2-1/2	1-5/16	.178	5	87402	HEV-C-RN-M-50187-R.010
1/4	1/4	.020	2/8	4	2/4	.237	5	82889	HEV-C-RN-S-50250-S.020
	1/4	.020	2/8	4	1-1/8	.237	5	82890	HEV-C-RN-R-50250-R.020
	1/4	.020	2/4	4	1-1/8	.237	5	82891	HEV-C-RNR-R-50250-R.020
	1/4	.020	2/8	4	2-1/8	.237	5	82892	HEV-C-RN-M-50250-R.020
	1/4	.020	2/4	4	2-1/8	.237	5	82893	HEV-C-RNR-M-50250-R.020
3/8	3/8	.020	1/2	4	1-1/8	.256	5	82894	HEV-C-RN-S-50275-S.020
	3/8	.020	1/2	4	2-1/8	.256	5	82895	HEV-C-RN-R-50275-S.020
	3/8	.020	1	4	2-1/8	.256	5	82896	HEV-C-RNR-R-50275-R.020
	3/8	.020	1/2	6	2-1/8	.256	5	82897	HEV-C-RN-M-50275-R.020
	3/8	.020	1	6	2-1/8	.256	5	82898	HEV-C-RNR-M-50275-R.020
1/2	1/2	.030	5/8	4	1-1/2	.475	5	82899	HEV-C-RN-S-50500-S.030
	1/2	.030	5/8	4	2-1/4	.475	5	82900	HEV-C-RN-R-50500-R.030
	1/2	.030	1-1/4	4	2-1/4	.475	5	82901	HEV-C-RNR-R-50500-R.030
	1/2	.030	5/8	6	3-3/8	.475	5	82902	HEV-C-RN-M-50500-R.030
	1/2	.030	1-1/4	6	3-3/8	.475	5	82903	HEV-C-RNR-M-50500-R.030
	1/2	.030	5/8	6	4-1/8	.475	5	82904	HEV-C-RN-L-50500-R.030
	1/2	.030	1-1/4	6	4-1/8	.475	5	82905	HEV-C-RNR-L-50500-R.030
3/4	3/4	.030	1	4	2	.712	5	82906	HEV-C-RN-S-50750-R.030
	3/4	.030	1	6	2-1/2	.712	5	82907	HEV-C-RN-R-50750-R.030
	3/4	.030	1-5/8	6	2-1/2	.712	5	82908	HEV-C-RNR-R-50750-R.030
	3/4	.030	1	6	3-3/8	.712	5	82909	HEV-C-RN-M-50750-R.030
	3/4	.030	1-5/8	6	3-3/8	.712	5	82910	HEV-C-RNR-M-50750-R.030

* .0005 max TIR



SPEEDS & FEEDS

5 Flute - Chipbreaker Rougher - Variable Pitch



HEV-C-5

HEV-C-5 / HEV-C-RN-5

Material Guide		Hardness	SPM	Inches per Tooth (IPT)													
				.08		.110		.14		.16		.12		.09		.1	
				Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	493	.0009	.0010	.0014	.0021	.0016	.0029	.0027	.0043	.0035	.0056	.0051	.0090	.0065	.0102
		75 - 98 HRB	445	.0007	.0011	.0010	.0015	.0013	.0021	.0020	.0031	.0026	.0041	.0037	.0050	.0047	.0075
		21 - 36 HRC	480	.0004	.0007	.0007	.0010	.0009	.0014	.0013	.0020	.0017	.0026	.0024	.0038	.0031	.0048
LOW ALLOY STEEL	13XX, 41XX, 43XX, 5XX, 60XX, 60XX	75 - 98 HRB	390	.0006	.0009	.0009	.0013	.0012	.0018	.0017	.0027	.0022	.0035	.0032	.0051	.0041	.0065
		21 - 36 HRC	340	.0004	.0007	.0007	.0010	.0009	.0013	.0013	.0020	.0017	.0026	.0024	.0038	.0030	.0048
		36 - 50 HRC	290	.0004	.0006	.0006	.0009	.0008	.0012	.0011	.0017	.0015	.0023	.0021	.0033	.0027	.0042
TOOL STEEL	A2, H13, L1, P20, S7	> 50 HRC	155	.0003	.0005	.0005	.0007	.0006	.0009	.0008	.0014	.0011	.0018	.0017	.0026	.0021	.0033
		75 - 98 HRB	340	.0006	.0009	.0009	.0013	.0012	.0018	.0017	.0027	.0022	.0035	.0032	.0051	.0041	.0065
		21 - 36 HRC	290	.0005	.0007	.0007	.0011	.0009	.0015	.0014	.0022	.0018	.0028	.0026	.0040	.0033	.0051
SPECIALTY STEEL	300M, Inver 38, Kovar, Managing 280, Managing 280, Managing 380, Managing 380	36 - 50 HRC	143	.0004	.0006	.0006	.0008	.0007	.0011	.0011	.0017	.0014	.0022	.0020	.0031	.0026	.0040
		> 50 HRC	85	.0003	.0005	.0005	.0007	.0006	.0009	.0009	.0014	.0011	.0018	.0016	.0026	.0021	.0033
		< 75 HRB	290	.0008	.0012	.0011	.0018	.0015	.0024	.0023	.0035	.0029	.0046	.0042	.0066	.0054	.0085
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347, Inconel 27-TMO, 316, 316L, 321, 347	75 - 98 HRB	285	.0006	.0009	.0009	.0013	.0011	.0018	.0017	.0027	.0022	.0035	.0032	.0051	.0041	.0065
		21 - 36 HRC	225	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0044	.0036	.0057
		36 - 50 HRC	180	.0004	.0007	.0007	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 415, 416, 420, 440, 438, 445	75 - 98 HRB	380	.0006	.0009	.0009	.0013	.0012	.0018	.0017	.0027	.0022	.0035	.0032	.0051	.0041	.0065
		21 - 36 HRC	280	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0044	.0036	.0056
		36 - 50 HRC	230	.0004	.0007	.0007	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 405	75 - 98 HRB	410	.0010	.0015	.0014	.0022	.0019	.0029	.0028	.0044	.0036	.0057	.0052	.0082	.0066	.0104
		21 - 36 HRC	370	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0045	.0038	.0057
		36 - 50 HRC	325	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0045	.0038	.0057
GRAY CAST IRON	SAE J431, ASTM A48	75 - 98 HRB	410	.0010	.0015	.0014	.0022	.0019	.0029	.0028	.0044	.0036	.0057	.0052	.0082	.0066	.0104
		21 - 36 HRC	370	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0045	.0038	.0057
		36 - 50 HRC	325	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0045	.0038	.0057
MALLEABLE CAST IRON	ASTM A47, ASTM A216, ASTM A902	75 - 98 HRB	345	.0006	.0010	.0009	.0014	.0012	.0019	.0018	.0028	.0023	.0036	.0033	.0052	.0042	.0066
		21 - 36 HRC	305	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0024	.0020	.0031	.0028	.0045	.0038	.0057
		36 - 50 HRC	260	.0004	.0007	.0007	.0010	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 897	75 - 98 HRB	310	.0006	.0010	.0009	.0014	.0012	.0019	.0018	.0028	.0023	.0036	.0033	.0052	.0044	.0066
		21 - 36 HRC	280	.0004	.0007	.0007	.0010	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
		36 - 50 HRC	135	.0003	.0004	.0004	.0006	.0005	.0008	.0008	.0012	.0010	.0016	.0014	.0023	.0018	.0029
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0008	.0013	.0012	.0018	.0016	.0025	.0024	.0037	.0031	.0049	.0044	.0070	.0056	.0089
		75 - 98 HRB	250	.0007	.0011	.0010	.0015	.0013	.0021	.0020	.0031	.0026	.0041	.0037	.0050	.0047	.0074
		21 - 36 HRC	80	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Inconel 20	75 - 98 HRB	80	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
		21 - 36 HRC	70	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0045
		36 - 50 HRC	70	.0005	.0005	.0005	.0008	.0007	.0010	.0010	.0015	.0013	.0020	.0016	.0029	.0023	.0037
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	380	.0011	.0017	.0017	.0025	.0022	.0035	.0033	.0051	.0043	.0067	.0061	.0095	.0078	.0122
		75 - 98 HRB	275	.0009	.0015	.0014	.0021	.0018	.0029	.0027	.0043	.0036	.0056	.0051	.0081	.0066	.0103
		21 - 36 HRC	230	.0007	.0011	.0010	.0016	.0014	.0022	.0021	.0032	.0027	.0042	.0036	.0050	.0049	.0077
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 98 HRB	180	.0006	.0009	.0008	.0013	.0011	.0017	.0016	.0025	.0021	.0033	.0030	.0048	.0039	.0061
		21 - 36 HRC	160	.0005	.0008	.0008	.0012	.0010	.0016	.0015	.0023	.0019	.0030	.0026	.0040	.0035	.0055
		36 - 50 HRC	120	.0005	.0007	.0007	.0011	.0009	.0015	.0014	.0021	.0018	.0028	.0026	.0040	.0032	.0051
COBALT ALLOY	ASTM F902, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0005	.0007	.0007	.0011	.0009	.0015	.0014	.0021	.0018	.0028	.0026	.0040	.0032	.0051
		21 - 36 HRC	170	.0005	.0007	.0007	.0010	.0009	.0014	.0013	.0021	.0017	.0027	.0025	.0039	.0031	.0050
		36 - 50 HRC	85	.0003	.0005	.0005	.0007	.0006	.0010	.0009	.0014	.0012	.0018	.0017	.0026	.0021	.0034

MILLING PROCESS	HARDNESS	ADDC	ADDC
Slot (Full Slotting)	< 35 HRC	30%-75% Diameter	100% Diameter
	≥ 35 HRC	25%-90% Diameter	100% Diameter
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	10%-30% Diameter
	≥ 35 HRC	Up to Max LOC	10%-30% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B

HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

HEV-C-6



New Items!

6 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure

- Center cutting
- H9 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 190 for Tplus coating



Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 (in)	Corner Radius R $\pm .001$ -.002	Length of Cut L2 $\pm .001$	Overall Length L1 $\pm .001$	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	6	84374	HEV-C-S-60125-R.010
	1/8	.010	3/8	2	6	84375	HEV-C-SR-60125-R.010
	1/8	.010	1/2	2-1/2	6	84376	HEV-C-R-60125-R.010
	1/8	.010	5/8	2-1/2	6	84377	HEV-C-A-60125-R.010
3/16	3/16	.010	5/16	2	6	84378	HEV-C-S-60167-R.010
	3/16	.010	7/16	2	6	84379	HEV-C-SR-60167-R.010
	3/16	.010	9/16	2-1/2	6	84380	HEV-C-R-60167-R.010
	3/16	.010	3/4	2-1/2	6	84381	HEV-C-M-60167-R.010
	3/16	.010	1	3	6	88518	HEV-C-ML-60167-R.010
1/4	1/4	.010	3/8	2	6	83125	HEV-C-S-60250-R.010
	1/4	.010	1/2	2-1/2	6	83126	HEV-C-SR-60250-R.010
	1/4	.010	3/4	2-1/2	6	83127	HEV-C-R-60250-R.010
	1/4	.010	1	3	6	83128	HEV-C-M-60250-R.010
	1/4	.020	3/8	2	6	82223	HEV-C-S-60250-R.020
	1/4	.020	1/2	2-1/2	6	82224	HEV-C-SR-60250-R.020
	1/4	.020	3/4	2-1/2	6	82225	HEV-C-R-60250-R.020
	1/4	.020	1	3	6	82226	HEV-C-M-60250-R.020
	1/4	.020	1-1/4	3	6	88519	HEV-C-L-60250-R.020
	1/4	.030	3/8	2	6	87403	HEV-C-S-60250-R.030
	1/4	.030	1/2	2-1/2	6	87404	HEV-C-SR-60250-R.030
	1/4	.030	3/4	2-1/2	6	87405	HEV-C-R-60250-R.030
	1/4	.030	1	3	6	87406	HEV-C-M-60250-R.030
	1/4	.060	3/8	2	6	87407	HEV-C-S-60250-R.060
	1/4	.060	1/2	2-1/2	6	87408	HEV-C-SR-60250-R.060
	1/4	.060	3/4	2-1/2	6	87409	HEV-C-R-60250-R.060
	1/4	.060	1	3	6	87410	HEV-C-M-60250-R.060
3/8	3/8	.010	1/2	2	6	83129	HEV-C-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	83130	HEV-C-SR-60375-R.010
	3/8	.010	1	3	6	83131	HEV-C-R-60375-R.010
	3/8	.010	1-1/4	3	6	83132	HEV-C-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	88520	HEV-C-L-60375-R.010
	3/8	.020	1/2	2	6	87411	HEV-C-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	87412	HEV-C-SR-60375-R.020

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 95

6 FLUTE - CORNER RADIUS

New Items!



HEV-C-6

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1: $\frac{1927}{1000}$	Shank Diameter D2: H8	Corner Radius R: $\frac{1927}{1000}$	Length of Cut L2: $\frac{1927}{1000}$	Overall Length L1: $\frac{1927}{1000}$	Flutes	Aplus Coated	Tool Description
3/8	3/8	.020	1	3	6	87413	HEV-C-R-60375-R.020
	3/8	.020	1-1/4	3	6	87414	HEV-C-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	88521	HEV-C-L-60375-R.020
	3/8	.030	1/2	2	6	82227	HEV-C-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	82228	HEV-C-SR-60375-R.030
	3/8	.030	1	3	6	82229	HEV-C-R-60375-R.030
	3/8	.030	1-1/4	3	6	82230	HEV-C-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	88522	HEV-C-L-60375-R.030
	3/8	.060	1/2	2	6	87415	HEV-C-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	87416	HEV-C-SR-60375-R.060
	3/8	.060	1	3	6	87417	HEV-C-R-60375-R.060
	3/8	.060	1-1/4	3	6	87418	HEV-C-M-60375-R.060
	3/8	.060	1-1/2	3-1/2	6	88523	HEV-C-L-60375-R.060
1/2	1/2	.010	5/8	2-1/2	6	83133	HEV-C-S-60500-R.010
	1/2	.010	1	3	6	83134	HEV-C-SR-60500-R.010
	1/2	.010	1-1/4	3	6	83135	HEV-C-R-60500-R.010
	1/2	.010	1-5/8	4	6	83136	HEV-C-M-60500-R.010
	1/2	.010	2	4	6	83137	HEV-C-L-60500-R.010
	1/2	.010	2-1/2	5	6	83138	HEV-C-LX-60500-R.010
	1/2	.030	5/8	2-1/2	6	82231	HEV-C-S-60500-R.030
	1/2	.030	1	3	6	82232	HEV-C-SR-60500-R.030
	1/2	.030	1-1/4	3	6	82233	HEV-C-R-60500-R.030
	1/2	.030	1-5/8	4	6	82234	HEV-C-M-60500-R.030
	1/2	.030	2	4	6	82235	HEV-C-L-60500-R.030
	1/2	.030	2-1/2	5	6	82236	HEV-C-LX-60500-R.030
	1/2	.060	5/8	2-1/2	6	82237	HEV-C-S-60500-R.060
	1/2	.060	1	3	6	82238	HEV-C-SR-60500-R.060
	1/2	.060	1-1/4	3	6	82239	HEV-C-R-60500-R.060
	1/2	.060	1-5/8	4	6	82240	HEV-C-M-60500-R.060
	1/2	.060	2	4	6	82241	HEV-C-L-60500-R.060
	1/2	.060	2-1/2	5	6	82242	HEV-C-LX-60500-R.060
	1/2	.125	5/8	2-1/2	6	87419	HEV-C-S-60500-R.125
	1/2	.125	1	3	6	87420	HEV-C-SR-60500-R.125
	1/2	.125	1-1/4	3	6	87421	HEV-C-R-60500-R.125
	1/2	.125	1-5/8	4	6	87422	HEV-C-M-60500-R.125
5/8	5/8	.030	1-1/4	3-1/2	6	83139	HEV-C-SR-60625-R.030
	5/8	.030	1-5/8	3-1/2	6	83140	HEV-C-R-60625-R.030
	5/8	.030	2	4	6	83141	HEV-C-M-60625-R.030
	5/8	.060	3/4	3	6	88524	HEV-C-S-60625-R.060
	5/8	.060	1-1/4	3-1/2	6	82243	HEV-C-SR-60625-R.060
	5/8	.060	1-5/8	3-1/2	6	82244	HEV-C-R-60625-R.060
	5/8	.060	2	4	6	82245	HEV-C-M-60625-R.060
	5/8	.060	2-1/2	5	6	88525	HEV-C-L-60625-R.060
3/4	3/4	.030	1-5/8	4	6	83142	HEV-C-R-60750-R.030
	3/4	.030	2-1/4	5	6	83143	HEV-C-M-60750-R.030
	3/4	.030	2-3/4	5	6	83144	HEV-C-L-60750-R.030
	3/4	.030	3-1/4	6	6	88526	HEV-C-LX-60750-R.030
	3/4	.060	1-5/8	4	6	82246	HEV-C-R-60750-R.060
	3/4	.060	2-1/4	5	6	82247	HEV-C-M-60750-R.060
	3/4	.060	2-3/4	5	6	82248	HEV-C-L-60750-R.060
	3/4	.060	3-1/4	6	6	88527	HEV-C-LX-60750-R.060
	3/4	.125	1-5/8	4	6	87423	HEV-C-R-60750-R.125
	3/4	.125	2-1/4	5	6	87424	HEV-C-M-60750-R.125
	3/4	.125	2-3/4	5	6	87425	HEV-C-L-60750-R.125

*.0005 max TIR

HEV-C-6



SPEEDS & FEEDS

6 Flute - Chipbreaker Rougher - Variable Pitch

HEV-C-6										
Material Grade		Hardness	SPM	Inches per Tooth (IPT)						
				1/8	3/16	1/4	5/8	1/2	3/4	1
				Rph	Rph	Rph	Rph	Rph	Rph	Rph
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	400	.0014	.0020	.0028	.0041	.0054	.0077	.0099
		75 - 98 HRC	345	.0016	.0015	.0030	.0038	.0040	.0057	.0073
		21 - 38 HRC	400	.0007	.0010	.0013	.0028	.0026	.0037	.0047
LOW ALLOY STEEL	15XX, 41XX, 43XX, 51XX, 80XX, 93XX	75 - 98 HRC	390	.0008	.0013	.0018	.0028	.0034	.0049	.0063
		21 - 38 HRC	340	.0007	.0010	.0013	.0028	.0026	.0037	.0047
		34 - 50 HRC	360	.0008	.0008	.0011	.0017	.0022	.0032	.0041
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	155	.0005	.0007	.0009	.0014	.0018	.0025	.0033
		75 - 98 HRC	340	.0008	.0013	.0018	.0028	.0034	.0049	.0063
		21 - 38 HRC	290	.0007	.0010	.0014	.0021	.0027	.0039	.0050
SPECIALTY STEEL	300M, Inver 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	38 - 50 HRC	145	.0008	.0008	.0011	.0016	.0021	.0031	.0043
		> 50 HRC	85	.0005	.0007	.0009	.0013	.0017	.0025	.0032
		< 75 HRB	250	.0012	.0017	.0023	.0034	.0045	.0064	.0082
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347	75 - 98 HRC	285	.0008	.0013	.0017	.0025	.0033	.0048	.0061
		21 - 38 HRC	225	.0008	.0011	.0015	.0023	.0030	.0043	.0055
		38 - 50 HRC	160	.0008	.0009	.0012	.0018	.0024	.0034	.0044
MARTENSITIC & FERRITIC STAINLESS STEEL	405, 410, 416, 435, 445, 430, 444	75 - 98 HRC	300	.0008	.0013	.0018	.0028	.0034	.0049	.0064
		21 - 38 HRC	260	.0008	.0011	.0015	.0023	.0030	.0043	.0055
		38 - 50 HRC	160	.0008	.0009	.0012	.0018	.0024	.0034	.0044
PM STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 495	21 - 38 HRC	200	.0007	.0010	.0013	.0019	.0025	.0036	.0047
		38 - 50 HRC	145	.0008	.0008	.0011	.0017	.0022	.0031	.0040
		75 - 98 HRC	410	.0014	.0021	.0029	.0042	.0056	.0080	.0103
GRAY CAST IRON	SAC J40, ASTM A49	21 - 38 HRC	370	.0008	.0011	.0016	.0023	.0030	.0043	.0055
		75 - 98 HRC	410	.0014	.0021	.0029	.0042	.0056	.0080	.0103
		38 - 50 HRC	370	.0008	.0011	.0016	.0023	.0030	.0043	.0055
MALLEABLE CAST IRON	ASTM A47, ASTM A225, ASTM A802	75 - 98 HRC	345	.0009	.0013	.0018	.0027	.0035	.0051	.0065
		21 - 38 HRC	305	.0008	.0012	.0016	.0023	.0030	.0043	.0055
		38 - 50 HRC	310	.0010	.0014	.0019	.0028	.0037	.0052	.0068
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM 687	21 - 38 HRC	260	.0008	.0009	.0012	.0018	.0024	.0035	.0045
		38 - 50 HRC	135	.0004	.0006	.0008	.0012	.0015	.0022	.0029
		75 - 98 HRC	310	.0010	.0014	.0019	.0028	.0037	.0052	.0068
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	385	.0012	.0018	.0024	.0036	.0047	.0067	.0087
		75 - 98 HRC	250	.0010	.0015	.0020	.0030	.0039	.0057	.0073
		21 - 38 HRC	80	.0008	.0009	.0012	.0018	.0024	.0034	.0044
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Hastelloy, Rene 41, Inconel 718, Inconel 20	21 - 38 HRC	75	.0008	.0009	.0012	.0017	.0023	.0035	.0045
		38 - 50 HRC	70	.0005	.0007	.0010	.0015	.0020	.0028	.0038
		75 - 98 HRC	300	.0017	.0025	.0033	.0050	.0066	.0093	.0129
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	21 - 38 HRC	275	.0014	.0021	.0028	.0042	.0055	.0078	.0101
		38 - 50 HRC	250	.0011	.0015	.0021	.0031	.0041	.0059	.0079
		75 - 98 HRC	180	.0008	.0012	.0017	.0025	.0032	.0046	.0060
TITANIUM ALLOY	Ti 5Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 38 HRC	160	.0008	.0011	.0015	.0022	.0029	.0042	.0054
		38 - 50 HRC	100	.0008	.0011	.0015	.0022	.0029	.0042	.0054
		75 - 98 HRC	210	.0007	.0010	.0014	.0021	.0027	.0039	.0051
COBALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	21 - 38 HRC	170	.0007	.0010	.0014	.0021	.0026	.0038	.0049
		38 - 50 HRC	85	.0005	.0007	.0009	.0014	.0018	.0026	.0033
		75 - 98 HRC	310	.0010	.0014	.0019	.0028	.0037	.0052	.0068

MILLING PROCESS	HARDNESS	ADCC	ROCC
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	15%-25% Diameter
	≥ 35 HRC	Up to Max LOC	10%-20% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B

HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch


HEV-C-7

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 7 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 194 for Tplus coating



Cutter Diameter* D1 $\pm \frac{0.001}{0.002}$	Shank Diameter D2 (M)	Corner Radius R $\pm \frac{0.001}{0.002}$	Length of Cut L2 $\pm \frac{0.001}{0.002}$	Overall Length L1 $\pm \frac{0.001}{0.002}$	Flutes	Aplus Coated	Tool Description
1/4	1/4	.020	3/8	2	7	59420	HEV-C-S-70250-R.020
	1/4	.020	1/2	2	7	59421	HEV-C-SR-70250-R.020
	1/4	.020	3/4	2-1/2	7	59422	HEV-C-R-70250-R.020
	1/4	.020	1	3	7	82249	HEV-C-M-70250-R.020
	1/4	.020	1-1/4	3	7	83163	HEV-C-L-70250-R.020
	1/4	.030	3/8	2	7	87174	HEV-C-S-70250-R.030
	1/4	.030	1/2	2	7	87175	HEV-C-SR-70250-R.030
	1/4	.030	3/4	2-1/2	7	87176	HEV-C-R-70250-R.030
3/8	3/8	.020	1/2	2	7	59423	HEV-C-S-70375-R.020
	3/8	.020	3/4	2-1/2	7	59424	HEV-C-SR-70375-R.020
	3/8	.020	1	2-1/2	7	59425	HEV-C-R-70375-R.020
	3/8	.020	1-1/2	3-1/2	7	82250	HEV-C-M-70375-R.020
	3/8	.030	1/2	2	7	87177	HEV-C-S-70375-R.030
	3/8	.030	3/4	2-1/2	7	87178	HEV-C-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87179	HEV-C-R-70375-R.030
	3/8	.060	1/2	2	7	83164	HEV-C-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	83165	HEV-C-SR-70375-R.060
	3/8	.060	1	2-1/2	7	83166	HEV-C-R-70375-R.060
1/2	1/2	.010	5/8	2-1/2	7	87180	HEV-C-S-70500-R.010
	1/2	.010	1	3	7	87181	HEV-C-SR-70500-R.010
	1/2	.010	1-1/4	3	7	87182	HEV-C-R-70500-R.010
	1/2	.010	1-5/8	4	7	87183	HEV-C-M-70500-R.010
	1/2	.010	2	4	7	87184	HEV-C-L-70500-R.010
	1/2	.020	5/8	2-1/2	7	83167	HEV-C-S-70500-R.020
	1/2	.020	1	3	7	83168	HEV-C-SR-70500-R.020
	1/2	.020	1-1/4	3	7	83169	HEV-C-R-70500-R.020
	1/2	.020	1-5/8	4	7	83170	HEV-C-M-70500-R.020
	1/2	.020	2	4	7	83171	HEV-C-L-70500-R.020
	1/2	.030	5/8	2-1/2	7	59426	HEV-C-S-70500-R.030
	1/2	.030	1	3	7	59427	HEV-C-SR-70500-R.030
	1/2	.030	1-1/4	3	7	59428	HEV-C-R-70500-R.030
	1/2	.030	1-5/8	4	7	59429	HEV-C-M-70500-R.030
	1/2	.030	2	4	7	81075	HEV-C-L-70500-R.030
	1/2	.030	3-1/2	5	7	82251	HEV-C-X-70500-R.030
	1/2	.030	3-1/8	6	7	82252	HEV-C-X-70500-R.030

* .0005 max TR

continued on next page



Speeds & Feeds on Page 99

HEV-C-7



7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.002}{.002}$	Shank Diameter D2 $\pm .001$	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L1 $\pm \frac{.002}{.002}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Aplus-Coated	Tool Description
1/2	1/2	.060	5/8	2-1/2	7	81978	HEV-C-S-70500-R.060
	1/2	.060	1	3	7	81979	HEV-C-SR-70600-R.060
	1/2	.060	1-1/4	3	7	81980	HEV-C-R-70500-R.060
	1/2	.060	1-5/8	4	7	81981	HEV-C-M-70600-R.060
	1/2	.060	2	4	7	81982	HEV-C-L-70500-R.060
	1/2	.060	2-1/2	5	7	83172	HEV-C-LX-70600-R.060
5/8	5/8	.030	3/4	3	7	83173	HEV-C-S-70625-R.030
	5/8	.030	1-1/4	3-1/2	7	59430	HEV-C-SR-70625-R.030
	5/8	.030	1-5/8	4	7	59431	HEV-C-R-70625-R.030
	5/8	.030	2-1/8	4	7	81976	HEV-C-M-70625-R.030
	5/8	.060	1-1/4	3-1/2	7	81983	HEV-C-SR-70625-R.060
	5/8	.060	1-5/8	4	7	81984	HEV-C-R-70625-R.060
3/4	3/4	.030	1-1/4	3-1/2	7	83174	HEV-C-SR-70750-R.030
	3/4	.030	1-5/8	4	7	59432	HEV-C-R-70750-R.030
	3/4	.030	2-1/4	5	7	59433	HEV-C-M-70750-R.030
	3/4	.030	2-3/4	5	7	81977	HEV-C-L-70750-R.030
	3/4	.030	3-1/4	6	7	83175	HEV-C-LX-70750-R.030
	3/4	.030	4	6-1/2	7	87185	HEV-C-X-70750-R.030
	3/4	.060	1-1/4	3-1/2	7	83176	HEV-C-SR-70750-R.060
	3/4	.060	1-5/8	4	7	81986	HEV-C-R-70750-R.060
	3/4	.060	2-1/4	5	7	81987	HEV-C-M-70750-R.060
	3/4	.060	2-3/4	5	7	81988	HEV-C-L-70750-R.060
	3/4	.060	3-1/4	6	7	87186	HEV-C-LX-70750-R.060
	3/4	.060	4	6-1/2	7	87187	HEV-C-X-70750-R.060
1	1	.030	2-5/8	5	7	87188	HEV-C-M-71000-R.030
	1	.030	3-1/4	6	7	87189	HEV-C-L-71000-R.030
	1	.030	4-1/8	7	7	87190	HEV-C-X-71000-R.030

* .0005 max TIR

08000119



SKU: 55257
Coating: Aplus
Cutter Dia: 5/8"
Length of Cut: 1-5/8"
Radius: .060"

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7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch- Reduced Neck


HEV-C-RN-7

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 7 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- End cutting geometry (non-center cutting)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\begin{smallmatrix} +.001 \\ -.002 \end{smallmatrix}$	Shank Dia. D2 H6	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.001 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.001 \\ -.001 \end{smallmatrix}$	Reach (LBS) L3	Neck Dia. L4	Flutes	Aplus Coated	Tool Description
1/4	1/4	.020	3/4	4	1-1/8	.237	7	82927	HEV-C-RNR-R-70250-R.020
	1/4	.020	3/4	4	2-1/8	.237	7	82928	HEV-C-RNR-M-70250-R.020
3/8	3/8	.020	1	4	2-1/8	.396	7	82929	HEV-C-RNR-R-70375-R.020
	3/8	.020	1	6	3-1/8	.396	7	82930	HEV-C-RNR-M-70375-R.020
1/2	1/2	.030	1-1/4	4	2-1/4	.475	7	82931	HEV-C-RNR-R-70500-R.030
	1/2	.030	1-1/4	6	3-3/8	.475	7	82932	HEV-C-RNR-M-70500-R.030
	1/2	.030	1-1/4	6	4-1/8	.475	7	82933	HEV-C-RNR-L-70500-R.030
	1/2	.060	1-1/4	4	2-1/4	.475	7	82934	HEV-C-RNR-R-70500-R.060
	1/2	.060	1-1/4	6	3-3/8	.475	7	82935	HEV-C-RNR-M-70500-R.060
	1/2	.060	1-1/4	6	4-1/8	.475	7	82936	HEV-C-RNR-L-70500-R.060
3/4	3/4	.030	1-5/8	6	2-1/2	.712	7	82937	HEV-C-RNR-R-70750-R.030
	3/4	.030	1-5/8	6	3-3/8	.712	7	82938	HEV-C-RNR-M-70750-R.030
	3/4	.060	1-5/8	6	2-1/2	.712	7	82939	HEV-C-RNR-R-70750-R.060
	3/4	.060	1-5/8	6	3-3/8	.712	7	82940	HEV-C-RNR-M-70750-R.060

* .0005 max. TR



HEV-C-7



SPEEDS & FEEDS

7 Flute - Chipbreaker Rougher - Variable Pitch

HEV-C-7 / HEV-C-RN-7

Material Grade		Hardness	SFM	Inches per Tooth (IPT)						
				1/8	3/16	1/4	5/8	1/2	3/4	1
				Rph	Rph	Rph	Rph	Rph	Rph	Rph
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	400	.0018	.0023	.0030	.0043	.0056	.0065	.0109
		75 - 98 HRC	440	.0011	.0017	.0023	.0033	.0042	.0052	.0079
		21 - 38 HRC	400	.0007	.0011	.0014	.0021	.0026	.0040	.0057
LOW ALLOY STEEL	15XX, 41XX, 43XX, 51XX, 80XX, 93XX	75 - 98 HRB	350	.0018	.0014	.0019	.0029	.0037	.0054	.0068
		21 - 38 HRC	340	.0007	.0011	.0014	.0021	.0027	.0040	.0051
		38 - 50 HRC	340	.0008	.0009	.0012	.0019	.0024	.0035	.0041
		> 50 HRC	155	.0005	.0007	.0010	.0015	.0019	.0028	.0035
TOOL STEEL	A2, H13, L8, P20, S7	75 - 98 HRB	340	.0018	.0014	.0019	.0029	.0037	.0054	.0068
		21 - 38 HRC	290	.0008	.0011	.0015	.0023	.0029	.0043	.0054
		38 - 50 HRC	145	.0008	.0009	.0012	.0018	.0023	.0033	.0047
		> 50 HRC	85	.0005	.0007	.0010	.0014	.0019	.0027	.0034
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRB	250	.0013	.0019	.0025	.0037	.0048	.0070	.0089
		75 - 98 HRB	225	.0008	.0013	.0017	.0028	.0033	.0048	.0061
		21 - 38 HRC	175	.0008	.0012	.0015	.0023	.0030	.0043	.0055
		38 - 50 HRC	150	.0007	.0011	.0014	.0021	.0027	.0039	.0049
		> 50 HRC	55	.0004	.0006	.0008	.0013	.0016	.0024	.0033
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 305, 304, 304L, Inconel 27-TMO, 316, 316L, 321, 347	75 - 98 HRB	260	.0009	.0014	.0019	.0028	.0036	.0052	.0068
		21 - 38 HRC	225	.0008	.0013	.0017	.0025	.0032	.0047	.0060
		38 - 50 HRC	180	.0007	.0010	.0013	.0020	.0026	.0038	.0049
MARTENSITIC & FERRITIC STAINLESS STEEL	405, 410, 416, 435, 445, 430, 444	75 - 98 HRB	300	.0018	.0015	.0019	.0029	.0037	.0054	.0068
		21 - 38 HRC	280	.0008	.0013	.0017	.0025	.0032	.0047	.0059
PM STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 495	21 - 38 HRC	200	.0007	.0011	.0014	.0021	.0027	.0039	.0050
		38 - 50 HRC	145	.0008	.0009	.0012	.0018	.0024	.0034	.0044
GRAY CAST IRON	SAC J401, ASTM A48	75 - 98 HRB	410	.0018	.0024	.0031	.0046	.0060	.0087	.0111
		21 - 38 HRC	370	.0008	.0013	.0017	.0025	.0032	.0047	.0060
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A802	75 - 98 HRB	340	.0018	.0015	.0019	.0029	.0036	.0055	.0070
		21 - 38 HRC	305	.0008	.0013	.0017	.0025	.0033	.0047	.0060
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM 687	75 - 98 HRB	310	.0018	.0015	.0020	.0031	.0039	.0057	.0077
		21 - 38 HRC	280	.0007	.0010	.0013	.0020	.0026	.0038	.0048
		38 - 50 HRC	178	.0004	.0007	.0009	.0013	.0017	.0024	.0031
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	385	.0013	.0020	.0026	.0038	.0051	.0074	.0094
		75 - 98 HRB	250	.0011	.0017	.0022	.0033	.0042	.0062	.0079
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Inconel 718, Inconel 719, Inconel 738, Inconel 739	75 - 98 HRB	80	.0007	.0010	.0013	.0020	.0026	.0037	.0048
		21 - 38 HRC	75	.0007	.0010	.0013	.0019	.0025	.0036	.0048
		38 - 50 HRC	70	.0008	.0008	.0011	.0018	.0021	.0031	.0039
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0018	.0028	.0036	.0054	.0070	.0102	.0129
		75 - 98 HRB	275	.0018	.0023	.0030	.0045	.0059	.0085	.0109
		21 - 38 HRC	250	.0011	.0017	.0023	.0034	.0044	.0064	.0081
TITANIUM ALLOY	Ti 5Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 38 HRC	180	.0008	.0014	.0019	.0027	.0035	.0050	.0064
		38 - 50 HRC	160	.0008	.0012	.0016	.0023	.0032	.0046	.0058
COBALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0008	.0012	.0015	.0023	.0029	.0043	.0054
		21 - 38 HRC	170	.0007	.0011	.0015	.0022	.0028	.0041	.0052
		38 - 50 HRC	80	.0005	.0008	.0010	.0015	.0019	.0028	.0038

MILLING PROCESS	HARDNESS	ADOC	RDOC
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	10%-20% Diameter
	> 35 HRC	Up to Max LOC	10%-20% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

MULTI-FLUTE - CORNER RADIUS

Knuckle Rougher - Variable Pitch

HXVR

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with staggered "low profile" edge geometry for chip control and minimized cutting forces
- Available in 4 flute and 5 flute options
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 196 for Tplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (6)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/4	1/4	.030	3/8	2	4	54017	54017W	HVR-S-40250-R.030
	1/4	.030	1/2	2-1/2	4	82859		HVR-SR-40250-R.030
	1/4	.030	3/4	2-1/2	4	54047	54047W	HVR-R-40250-R.030
	1/4	.030	1	3	4	82860		HVR-M-40250-R.030
3/8	3/8	.040	1/2	2	4	54092	54092W	HVR-S-40375-R.040
	3/8	.040	1/2	2	5	55092	55092W	HVR-S-50375-R.040
	3/8	.040	3/4	2-1/2	4	82861		HVR-SR-40375-R.040
	3/8	.040	3/4	2-1/2	5	82862		HVR-SR-50375-R.040
	3/8	.040	1	3	4	54107	54107W	HVR-R-40375-R.040
	3/8	.040	1	3	5	55107	55107W	HVR-R-50375-R.040
	3/8	.040	1-1/4	3	4	82863		HVR-M-40375-R.040
	3/8	.040	1-1/4	3	5	82864		HVR-M-50375-R.040
1/2	1/2	.040	5/8	2-1/2	4	54152	54152W	HVR-S-40500-R.040
	1/2	.040	5/8	2-1/2	5	55152	55152W	HVR-S-50500-R.040
	1/2	.040	1	3	4	82865		HVR-SR-40500-R.040
	1/2	.040	1	3	5	82866		HVR-SR-50500-R.040
	1/2	.040	1-1/4	3	4	54182	54182W	HVR-R-40500-R.040
	1/2	.040	1-1/4	3	5	55182	55182W	HVR-R-50500-R.040
	1/2	.040	1-5/8	4	4	82867		HVR-M-40500-R.040
	1/2	.040	1-5/8	4	5	82868		HVR-M-50500-R.040
5/8	5/8	.060	3/4	3	4	54227		HVR-S-40625-R.060
	5/8	.060	3/4	3	5	55227		HVR-S-50625-R.060
	5/8	.060	1-5/8	3-1/2	4	54257		HVR-R-40625-R.060
	5/8	.060	1-5/8	3-1/2	5	55257		HVR-R-50625-R.060
	5/8	.060	2	4	5	82869		HVR-M-50625-R.060
3/4	3/4	.060	1	3	4	54302		HVR-S-40750-R.060
	3/4	.060	1	3	5	55302		HVR-S-50750-R.060
	3/4	.060	1-5/8	4	4	54317	54317W	HVR-R-40750-R.060
	3/4	.060	1-5/8	4	5	55317	55317W	HVR-R-50750-R.060
	3/4	.060	2-1/4	5	5	82870		HVR-M-50750-R.060
1	1	.060	1-1/4	4	4	54377		HVR-S-41000-R.060
	1	.060	1-1/4	4	5	55377		HVR-S-51000-R.060
	1	.060	2	4-1/2	4	54392		HVR-R-41000-R.060
	1	.060	2	4-1/2	5	55392		HVR-R-51000-R.060

* .0005 max TIR

HXVR-RN

MULTI-FLUTE - CORNER RADIUS Knuckle Rougher - Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with staggered "low profile" edge geometry for chip control and minimized cutting forces
- Available in 4 flute and 5 flute options
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .002$	Shank Dia. D2 (H6)	Corner Radius R $\pm .002$	Length of Cut L1 $\pm .002$	Overall Length L2 $\pm .002$	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/4	1/4	.030	3/8	2-1/2	1-1/8	.237	4	64032	HXVR RN A-40250-R.030
	1/4	.030	3/8	3	1-3/8	.237	4	82071	HXVR RN A-40250-R.030
3/8	3/8	.040	1/2	2-1/2	1-1/8	.354	4	64077	HXVR RN A-40375-R.040
	3/8	.040	1/2	2-1/2	1-1/8	.354	5	65077	HXVR RN A-50375-R.040
	3/8	.040	1/2	4	1-5/8	.354	5	82072	HXVR RN A-50375-R.040
1/2	1/2	.040	5/8	3	1-3/8	.475	4	64152	HXVR RN A-40500-R.040
	1/2	.040	5/8	3	1-3/8	.475	5	65152	HXVR RN A-50500-R.040
	1/2	.040	5/8	4	2-1/4	.475	4	82073	HXVR RN A-40500-R.040
	1/2	.040	5/8	4	2-1/4	.475	5	82074	HXVR RN A-50500-R.040
5/8	5/8	.050	3/4	3-1/2	1-5/8	.593	5	65227	HXVR RN A-50625-R.050
3/4	3/4	.050	1	4	2	.712	5	65302	HXVR RN A-50750-R.050
	3/4	.050	1	6	2-1/2	.712	5	82075	HXVR RN A-50750-R.050
1	1	.050	1-1/4	5	2-5/8	.963	5	65377	HXVR RN A-51000-R.050

* .0005 max TIR

Climb Milling vs. Conventional Milling

In The Loupe
ANALYZE YOUR TOOL

There are two distinct ways to cut materials when milling: Conventional Milling (Up) and Climb Milling (Down). The difference between these two techniques is the relationship of the rotation of the cutter to the direction of feed. Using the right approach may prolong your tool's life. Learn which way of machining is right for you by reading our "In the Loupe" post *Climb Milling vs. Conventional Milling*.

www.harveyprecision.com/in-the-loupe/conventional-vs-climb-milling/



SCAN TO READ

SPEEDS & FEEDS

4 Flute - Knuckle Rougher - Variable Pitch

HXVR-4

HXVR / HXVR-RN (4 Flute)

Material Grade		Hardness	SPM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		5/8		3/2		3/4		1	
				Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	465	.0007	.0018	.0010	.0015	.0015	.0023	.0022	.0034	.0028	.0044	.0040	.0063	.0051	.0081
		75 - 99 HRB	445	.0005	.0008	.0006	.0013	.0012	.0010	.0018	.0028	.0024	.0037	.0034	.0053	.0043	.0067
		21 - 36 HRC	400	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0034	.0028	.0043
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 68XX, 93XX	75 - 99 HRB	390	.0005	.0007	.0007	.0011	.0011	.0016	.0016	.0024	.0020	.0032	.0029	.0045	.0037	.0058
		21 - 36 HRC	340	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0034	.0028	.0043
		36 - 50 HRC	260	.0003	.0005	.0005	.0007	.0007	.0011	.0010	.0016	.0013	.0021	.0019	.0030	.0024	.0036
TOOL STEEL	A2, H13, L6, P20, S7	75 - 99 HRB	340	.0005	.0007	.0007	.0011	.0011	.0016	.0016	.0024	.0020	.0032	.0029	.0045	.0037	.0058
		21 - 36 HRC	290	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0046
		36 - 50 HRC	145	.0003	.0005	.0004	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0018	.0028	.0023	.0036
SPECIALTY STEEL	30M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRB	200	.0003	.0005	.0005	.0008	.0008	.0012	.0011	.0018	.0015	.0023	.0021	.0034	.0027	.0043
		75 - 99 HRB	205	.0005	.0008	.0006	.0012	.0011	.0018	.0017	.0026	.0022	.0035	.0032	.0050	.0040	.0063
		21 - 36 HRC	175	.0003	.0004	.0004	.0006	.0006	.0009	.0009	.0014	.0011	.0018	.0016	.0025	.0021	.0032
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347	< 75 HRB	255	.0005	.0008	.0006	.0012	.0012	.0010	.0018	.0027	.0023	.0036	.0033	.0051	.0042	.0065
		21 - 36 HRC	225	.0004	.0006	.0006	.0009	.0009	.0014	.0013	.0020	.0017	.0026	.0024	.0038	.0031	.0048
		36 - 50 HRC	160	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 440, 445	75 - 99 HRB	300	.0005	.0007	.0007	.0011	.0011	.0016	.0016	.0024	.0020	.0032	.0029	.0046	.0037	.0058
		21 - 36 HRC	280	.0004	.0006	.0006	.0009	.0009	.0014	.0014	.0021	.0018	.0028	.0025	.0040	.0032	.0051
		36 - 50 HRC	145	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0019	.0028	.0023	.0036
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	75 - 99 HRB	410	.0008	.0012	.0011	.0018	.0017	.0026	.0025	.0039	.0033	.0052	.0047	.0074	.0060	.0094
		21 - 36 HRC	370	.0004	.0007	.0006	.0010	.0009	.0014	.0014	.0021	.0018	.0029	.0026	.0040	.0033	.0051
		36 - 50 HRC	320	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
GRAY CAST IRON	SAE 1431, ASTM A48	75 - 99 HRB	410	.0008	.0012	.0011	.0018	.0017	.0026	.0025	.0039	.0033	.0052	.0047	.0074	.0060	.0094
		21 - 36 HRC	370	.0004	.0007	.0006	.0010	.0009	.0014	.0014	.0021	.0018	.0029	.0026	.0040	.0033	.0051
		36 - 50 HRC	320	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A662	75 - 99 HRB	345	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0033	.0030	.0047	.0038	.0060
		21 - 36 HRC	328	.0004	.0007	.0006	.0010	.0009	.0015	.0014	.0022	.0019	.0029	.0026	.0040	.0033	.0051
		36 - 50 HRC	135	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
MODULAR (DUCTILE) CAST IRON	ASTM A538, ASTM 687	75 - 99 HRB	310	.0005	.0008	.0008	.0012	.0011	.0017	.0017	.0026	.0022	.0034	.0031	.0049	.0040	.0062
		21 - 36 HRC	260	.0003	.0005	.0005	.0008	.0007	.0012	.0011	.0017	.0014	.0023	.0021	.0032	.0026	.0041
		36 - 50 HRC	135	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	265	.0007	.0010	.0010	.0015	.0014	.0022	.0021	.0033	.0028	.0044	.0040	.0063	.0051	.0080
		75 - 99 HRB	250	.0005	.0008	.0008	.0013	.0012	.0019	.0018	.0028	.0023	.0037	.0033	.0052	.0043	.0067
		21 - 36 HRC	190	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Hastelloy 41, Inconel 718, Inconel 720	75 - 99 HRB	80	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0022	.0035	.0028	.0046
		21 - 36 HRC	75	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029	.0046
		36 - 50 HRC	70	.0003	.0005	.0004	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0018	.0028	.0023	.0036
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0009	.0014	.0013	.0021	.0020	.0031	.0030	.0046	.0039	.0060	.0055	.0086	.0070	.1110
		75 - 99 HRB	275	.0008	.0012	.0011	.0017	.0017	.0026	.0025	.0039	.0032	.0051	.0046	.0072	.0059	.0092
		21 - 36 HRC	250	.0006	.0009	.0008	.0013	.0012	.0020	.0019	.0029	.0024	.0038	.0035	.0054	.0044	.0069
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 99 HRB	180	.0004	.0007	.0007	.0010	.0010	.0015	.0015	.0023	.0019	.0030	.0027	.0043	.0036	.0054
		21 - 36 HRC	160	.0004	.0006	.0006	.0009	.0009	.0014	.0013	.0021	.0017	.0027	.0025	.0039	.0032	.0050
		36 - 50 HRC	85	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037
COBALT ALLOY	ASTM F902, ASTM F903, ASTM F905, ASTM F909	75 - 99 HRB	210	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0030	.0046
		21 - 36 HRC	170	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0022	.0036	.0030	.0046
		36 - 50 HRC	85	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0020	.0019	.0029	.0024	.0037

MILLING PROCESS	HARDNESS	ADOC	IDOC
Slot (Full Slotting)	< 30 HRC	75%-125% Diameter	100% Diameter
	> 30 HRC	60%-75% Diameter	100% Diameter
Rph (Traditional Roughing)	< 30 HRC	Up to Max LOC	20%-40% Diameter
	> 30 HRC	Up to Max LOC	20%-40% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

HXVR-5

SPEEDS & FEEDS

5 Flute - Knuckle Rougher - Variable Pitch

HXVR / HXVR-RN (5 Flute)

Material Grade	Hardness	SFM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		3/8		1/2		3/4		1	
			Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh	Slot	Rgh
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	400	.0007	.0010	.0010	.0010	.0013	.0022	.0034	.0029	.0040	.0041	.0044	.0052	.0062
		75 - 99 HRB	445	.0006	.0008	.0008	.0013	.0012	.0019	.0018	.0028	.0024	.0037	.0034	.0053	.0043
		21 - 35 HRC	400	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0035	.0028
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 99 HRB	360	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0032	.0029	.0046	.0038
		21 - 35 HRC	340	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0034	.0028
		36 - 50 HRC	260	.0003	.0005	.0005	.0007	.0007	.0011	.0010	.0016	.0013	.0021	.0019	.0030	.0024
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	155	.0002	.0004	.0004	.0006	.0005	.0009	.0008	.0013	.0011	.0017	.0015	.0024	.0019
		75 - 99 HRB	340	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0032	.0029	.0046	.0038
		21 - 35 HRC	250	.0004	.0006	.0006	.0009	.0008	.0013	.0013	.0020	.0016	.0026	.0023	.0037	.0030
SPECIALTY STEEL	300M, Inver 36, Kovarc, Maraging 200, Maraging 250, Maraging 300, Maraging 350	36 - 50 HRC	145	.0003	.0005	.0004	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0018	.0029	.0023
		> 50 HRC	85	.0002	.0004	.0004	.0006	.0005	.0009	.0008	.0013	.0011	.0017	.0015	.0024	.0019
		< 75 HRB	250	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0034	.0028
AUSTENITIC (STAINLESS) STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-TMO, 316, 316L, 321, 347	75 - 99 HRB	205	.0005	.0008	.0008	.0012	.0012	.0019	.0018	.0028	.0023	.0036	.0033	.0052	.0042
		21 - 35 HRC	225	.0004	.0006	.0006	.0009	.0008	.0014	.0013	.0021	.0017	.0027	.0025	.0036	.0031
		36 - 50 HRC	180	.0003	.0005	.0005	.0007	.0007	.0011	.0010	.0016	.0013	.0021	.0019	.0030	.0024
MARTENSITIC & FERRITIC (STAINLESS) STEEL	403, 410, 416, 420, 440, 440, 446	75 - 99 HRB	300	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0032	.0029	.0046	.0038
		21 - 35 HRC	260	.0004	.0006	.0006	.0010	.0009	.0014	.0014	.0021	.0018	.0028	.0026	.0040	.0033
		36 - 50 HRC	145	.0003	.0005	.0004	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0018	.0028	.0023
PH STAINLESS STEEL	15-7, 17-4, Carpenter 450, Carpenter 465	21 - 35 HRC	200	.0004	.0006	.0005	.0009	.0008	.0012	.0012	.0018	.0015	.0024	.0022	.0034	.0028
		36 - 50 HRC	145	.0003	.0005	.0004	.0007	.0007	.0010	.0010	.0015	.0013	.0020	.0018	.0028	.0023
		75 - 99 HRB	410	.0008	.0012	.0012	.0018	.0017	.0027	.0025	.0040	.0033	.0052	.0046	.0075	.0061
GRAY CAST IRON	SAE J431, ASTM A48	21 - 35 HRC	370	.0004	.0007	.0006	.0010	.0009	.0015	.0014	.0022	.0018	.0028	.0026	.0041	.0033
		75 - 99 HRB	345	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0033	.0030	.0047	.0039
		21 - 35 HRC	330	.0004	.0007	.0006	.0010	.0009	.0015	.0014	.0022	.0018	.0028	.0026	.0041	.0033
MALLEABLE CAST IRON	ASTM A47, ASTM A226, ASTM A802	75 - 99 HRB	345	.0005	.0008	.0007	.0011	.0011	.0017	.0016	.0025	.0021	.0033	.0030	.0047	.0039
		21 - 35 HRC	330	.0004	.0007	.0006	.0010	.0009	.0015	.0014	.0022	.0018	.0028	.0026	.0041	.0033
		36 - 50 HRC	130	.0003	.0005	.0005	.0007	.0007	.0011	.0010	.0016	.0013	.0021	.0019	.0030	.0024
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM 897	75 - 99 HRB	310	.0005	.0008	.0008	.0012	.0011	.0018	.0017	.0026	.0022	.0034	.0032	.0049	.0040
		21 - 35 HRC	260	.0003	.0005	.0005	.0008	.0008	.0012	.0011	.0017	.0015	.0023	.0021	.0033	.0027
		36 - 50 HRC	130	.0003	.0005	.0005	.0007	.0007	.0011	.0010	.0016	.0013	.0021	.0019	.0030	.0024
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	280	.0007	.0010	.0010	.0015	.0015	.0023	.0022	.0034	.0028	.0044	.0041	.0063	.0052
		75 - 99 HRB	250	.0005	.0008	.0008	.0012	.0012	.0019	.0018	.0028	.0024	.0037	.0034	.0053	.0043
		21 - 35 HRC	80	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Rene 41, Inconel 718, Incoloy 20	75 - 99 HRB	75	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0019	.0016	.0025	.0023	.0036	.0029
		21 - 35 HRC	70	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0021	.0019	.0030	.0024
		36 - 50 HRC	70	.0003	.0005	.0005	.0007	.0007	.0010	.0010	.0016	.0013	.0021	.0019	.0030	.0024
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0008	.0014	.0014	.0021	.0020	.0032	.0030	.0047	.0039	.0061	.0056	.0088	.0071
		75 - 99 HRB	270	.0006	.0012	.0011	.0018	.0017	.0026	.0025	.0039	.0033	.0051	.0047	.0073	.0060
		21 - 35 HRC	250	.0006	.0009	.0008	.0013	.0013	.0020	.0019	.0029	.0025	.0038	.0035	.0055	.0045
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 15V-2Fe-3Al	75 - 99 HRB	180	.0005	.0007	.0007	.0010	.0010	.0016	.0015	.0023	.0019	.0028	.0026	.0043	.0035
		21 - 35 HRC	160	.0004	.0007	.0006	.0009	.0009	.0014	.0013	.0021	.0018	.0028	.0025	.0039	.0032
		36 - 50 HRC	160	.0004	.0007	.0006	.0009	.0009	.0014	.0013	.0021	.0018	.0028	.0025	.0039	.0032
COBALT ALLOY	ASTM F562, ASTM F566, ASTM F575, ASTM F576	75 - 99 HRB	210	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0020	.0016	.0026	.0023	.0037	.0030
		21 - 35 HRC	170	.0004	.0006	.0006	.0009	.0008	.0013	.0012	.0020	.0016	.0026	.0023	.0037	.0030
		36 - 50 HRC	95	.0003	.0004	.0004	.0006	.0006	.0009	.0008	.0013	.0011	.0017	.0015	.0024	.0020

MILLING PROCESS	HARDNESS	ADDC	RDOC
Std Full Striding	< 35 HRC	30%-90% Diameter	100% Diameter
	≥ 35 HRC	30%-90% Diameter	100% Diameter
Rgh (Fractional Roughing)	< 35 HRC	Up to Max LOC	10%-30% Diameter
	≥ 35 HRC	Up to Max LOC	10%-30% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

3 FLUTE - SQUARE

Variable Pitch

HSV-3

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed with variable pitch and 3 flutes for reduced harmonics, increased chip clearance, and higher quality parts in full slotting and heavy roughing applications
- Eccentric relief for maximum edge strength
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H6)	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	3	23010	HSV-S-30125
	1/8	1/2	2-1/2	3	23020	HSV-R-30125
3/16	3/16	5/16	2	3	23040	HSV-S-30187
	3/16	3/8	2-1/2	3	23050	HSV-R-30187
1/4	1/4	3/8	2	3	23070	HSV-S-30250
	1/4	1/2	2-1/2	3	23080	HSV-GR-30250
	1/4	3/4	2-1/2	3	23090	HSV-R-30250
	1/4	1	3	3	23100	HSV-M-30250
5/16	5/16	7/16	2	3	23120	HSV-S-30312
	5/16	13/16	2-1/2	3	23130	HSV-R-30312
	5/16	1-1/4	3	3	23140	HSV-M-30312
3/8	3/8	1/2	2	3	23150	HSV-S-30375
	3/8	1	3	3	23160	HSV-R-30375
	3/8	1-1/4	3	3	23170	HSV-M-30375
1/2	1/2	5/8	2-1/2	3	23190	HSV-S-30500
	1/2	1	3	3	23200	HSV-GR-30500
	1/2	1-1/4	3	3	23210	HSV-R-30500
	1/2	1-5/8	4	3	23220	HSV-M-30500
5/8	5/8	3/4	3	3	23240	HSV-S-30625
	5/8	1-1/8	3-1/2	3	23250	HSV-GR-30625
	5/8	1-5/8	4	3	23260	HSV-R-30625
	5/8	2-1/8	4	3	23270	HSV-M-30625
3/4	3/4	1	3	3	23290	HSV-S-30750
	3/4	1-5/8	4	3	23300	HSV-R-30750
	3/4	2-1/4	5	3	23310	HSV-M-30750
1	1	1-1/4	4	3	23330	HSV-S-31000
	1	2	4-1/2	3	23340	HSV-R-31000
	1	2-5/8	6	3	23350	HSV-M-31000

* .0005 max TIR



HSV-3

3 FLUTE - CORNER RADIUS

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed with variable pitch and 3 flutes for reduced harmonics, increased chip clearance, and higher quality parts in full slotting and heavy roughing applications
- Eccentric relief for maximum edge strength
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 (h6)	Corner Radius R $\pm .002$ -.002	Length of Cut L2 $\pm .002$ -.002	Overall Length L1 $\pm .002$ -.002	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	3	23011	HSV-S-30125-R.010
	1/8	.010	1/2	2-1/2	3	23021	HSV-R-30125-R.010
3/16	3/16	.010	5/16	2	3	23041	HSV-S-30187-R.010
	3/16	.010	9/16	2-1/2	3	23051	HSV-R-30187-R.010
1/4	1/4	.020	3/8	2	3	23072	HSV-S-30250-R.020
	1/4	.020	1/2	2-1/2	3	23082	HSV-SR-30250-R.020
	1/4	.020	3/4	2-1/2	3	23092	HSV-R-30250-R.020
	1/4	.020	1	3	3	23102	HSV-M-30250-R.020
5/16	5/16	.020	7/16	2	3	23122	HSV-S-30312-R.020
	5/16	.020	13/16	2-1/2	3	23132	HSV-R-30312-R.020
	5/16	.020	1-1/4	3	3	23142	HSV-M-30312-R.020
3/8	3/8	.020	1/2	2	3	23152	HSV-S-30375-R.020
	3/8	.020	1	3	3	23162	HSV-R-30375-R.020
	3/8	.020	1-1/4	3	3	23172	HSV-M-30375-R.020
1/2	1/2	.030	5/8	2-1/2	3	23193	HSV-S-30500-R.030
	1/2	.030	1	3	3	23203	HSV-SR-30500-R.030
	1/2	.030	1-1/4	3	3	23213	HSV-R-30500-R.030
	1/2	.030	1-5/8	4	3	23223	HSV-M-30500-R.030
5/8	5/8	.030	3/4	3	3	23243	HSV-S-30625-R.030
	5/8	.030	1-1/8	3-1/2	3	23253	HSV-SR-30625-R.030
	5/8	.030	1-5/8	4	3	23263	HSV-R-30625-R.030
	5/8	.030	2-1/8	4	3	23273	HSV-M-30625-R.030
3/4	3/4	.030	1	3	3	23293	HSV-S-30750-R.030
	3/4	.030	1-5/8	4	3	23303	HSV-R-30750-R.030
	3/4	.030	2-1/4	5	3	23313	HSV-M-30750-R.030
1	1	.030	1-1/4	4	3	23333	HSV-S-31000-R.030
	1	.030	2	4-1/2	3	23343	HSV-R-31000-R.030
	1	.030	2-5/8	6	3	23353	HSV-M-31000-R.030

* .0005 max.TIR



SPEEDS & FEEDS

3 Flute - Variable Pitch

HSV-3

HSV-3

Material Guide		Hardness	SPM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		3/8		1/2		3/4		1	
				Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	400	.007	.012	.010	.016	.013	.023	.022	.035	.028	.045	.037	.056	.047	.084
		75 - 99 HRB	445	.008	.009	.007	.013	.010	.017	.014	.026	.019	.033	.027	.048	.034	.062
		≥ 100 HRB	500	.009	.008	.006	.008	.006	.011	.009	.017	.013	.021	.017	.031	.023	.040
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 56XX, 63XX	75 - 99 HRB	390	.004	.006	.006	.011	.008	.015	.012	.022	.016	.029	.023	.042	.036	.053
		21 - 36 HRC	340	.003	.006	.005	.009	.006	.011	.009	.017	.012	.021	.017	.031	.022	.040
		36 - 50 HRC	260	.003	.005	.004	.007	.005	.010	.008	.014	.011	.019	.016	.027	.019	.033
TOOL STEEL	A2, H13, L4, P20, S7	> 50 HRC	195	.003	.004	.003	.006	.004	.008	.006	.011	.008	.015	.012	.021	.016	.027
		75 - 99 HRB	340	.004	.006	.006	.011	.008	.015	.012	.022	.016	.029	.023	.042	.036	.053
		21 - 36 HRC	290	.003	.006	.005	.009	.007	.012	.010	.019	.013	.023	.019	.033	.023	.042
SPECIALTY STEEL	300M, Invar 36, Koro-M, Maraging 250, Maraging 300, Maraging 350	36 - 50 HRC	145	.003	.005	.004	.007	.005	.009	.008	.014	.010	.016	.014	.026	.018	.033
		> 50 HRC	85	.003	.004	.003	.006	.004	.008	.006	.011	.008	.015	.012	.021	.016	.027
		< 75 HRB	290	.004	.010	.008	.015	.011	.019	.016	.029	.021	.038	.031	.055	.038	.070
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, Incoloy 27-7MO, 216, 216L, 321, 347	75 - 99 HRB	295	.004	.007	.006	.011	.008	.014	.012	.022	.016	.028	.023	.041	.036	.052
		21 - 36 HRC	225	.004	.007	.006	.010	.007	.013	.011	.020	.014	.025	.020	.037	.028	.047
		36 - 50 HRC	180	.003	.005	.004	.006	.006	.011	.009	.016	.011	.020	.016	.030	.021	.036
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 438, 448	75 - 99 HRB	300	.004	.006	.006	.011	.008	.015	.013	.022	.016	.029	.023	.042	.036	.054
		21 - 36 HRC	280	.004	.007	.006	.010	.007	.013	.011	.020	.014	.025	.020	.036	.028	.047
		36 - 50 HRC	200	.003	.005	.004	.006	.006	.011	.009	.016	.011	.020	.016	.030	.021	.036
PH STAINLESS STEEL	15-7, 17-4, Carpenter 420, Carpenter 405	21 - 36 HRC	200	.003	.006	.005	.008	.006	.011	.009	.016	.012	.021	.017	.031	.022	.039
		36 - 50 HRC	145	.003	.005	.004	.007	.005	.010	.008	.014	.010	.018	.015	.027	.019	.034
		75 - 99 HRB	410	.007	.012	.010	.016	.013	.024	.020	.036	.028	.047	.038	.066	.048	.087
GRAY CAST IRON	SAE 431, ASTM A48	21 - 36 HRC	370	.004	.007	.006	.010	.007	.013	.011	.020	.014	.025	.021	.037	.028	.047
		75 - 99 HRB	345	.004	.008	.007	.012	.009	.015	.013	.023	.017	.030	.024	.043	.036	.055
		21 - 36 HRC	335	.004	.007	.006	.010	.007	.013	.011	.020	.014	.025	.021	.037	.028	.047
MALLEABLE CAST IRON	ASTM A47, ASTM A202, ASTM A602	75 - 99 HRB	310	.005	.008	.007	.012	.009	.016	.013	.024	.017	.031	.025	.045	.032	.057
		21 - 36 HRC	260	.003	.005	.005	.006	.006	.011	.009	.016	.012	.020	.016	.030	.021	.036
		36 - 50 HRC	135	.002	.003	.003	.005	.004	.007	.006	.010	.007	.013	.010	.019	.013	.024
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 687	< 75 HRB	265	.004	.010	.009	.016	.012	.020	.017	.031	.022	.039	.032	.057	.041	.073
		75 - 99 HRB	250	.005	.009	.007	.013	.010	.017	.014	.028	.019	.033	.027	.048	.034	.061
		21 - 36 HRC	80	.003	.005	.004	.006	.006	.010	.009	.016	.011	.020	.016	.030	.021	.036
PURE NICKEL	Hastelloy C-22, Inconel 625, Waspalloy, Rask 41, Inconel 718, Incoloy 20	21 - 36 HRC	75	.003	.005	.004	.006	.006	.010	.009	.016	.011	.020	.016	.030	.021	.036
		36 - 50 HRC	70	.003	.004	.004	.007	.005	.009	.008	.013	.009	.016	.013	.024	.017	.031
		75 - 99 HRB	80	.003	.005	.004	.006	.006	.010	.009	.016	.011	.020	.016	.030	.021	.036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Rask 41, Inconel 718, Incoloy 20	21 - 36 HRC	75	.003	.005	.004	.006	.006	.010	.009	.016	.011	.020	.016	.030	.021	.036
		36 - 50 HRC	70	.003	.004	.004	.007	.005	.009	.008	.013	.009	.016	.013	.024	.017	.031
		75 - 99 HRB	80	.003	.005	.004	.006	.006	.010	.009	.016	.011	.020	.016	.030	.021	.036
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.004	.014	.012	.022	.018	.028	.024	.042	.031	.055	.044	.079	.056	.101
		75 - 99 HRB	275	.007	.012	.010	.016	.013	.024	.020	.035	.026	.046	.037	.066	.047	.085
		21 - 36 HRC	250	.008	.009	.008	.014	.010	.018	.015	.027	.019	.034	.028	.050	.038	.064
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.004	.007	.006	.011	.008	.014	.012	.021	.015	.027	.022	.039	.028	.050
		36 - 50 HRC	160	.004	.006	.005	.010	.007	.013	.011	.019	.014	.025	.020	.036	.028	.046
		75 - 99 HRB	210	.003	.006	.005	.009	.007	.012	.010	.018	.013	.023	.019	.033	.024	.042
COBALT ALLOY	ASTM F902, ASTM F90, ASTM F75, ASTM F799	21 - 36 HRC	170	.003	.006	.005	.009	.006	.011	.010	.017	.012	.022	.018	.032	.023	.041
		36 - 50 HRC	85	.003	.004	.003	.006	.004	.008	.007	.012	.008	.015	.012	.022	.016	.028
		< 75 HRB	290	.004	.010	.008	.015	.011	.019	.016	.029	.021	.038	.031	.055	.038	.070

MILLING PROCESS	HARDNESS	ADOC	TOOC
Slot (Full Slotting)	< 35 HRC	100%-100% Diameter	100% Diameter
	≥ 35 HRC	100%-125% Diameter	100% Diameter
Rgn (Traditional Roughing)	< 35 HRC	Up to Max LOC	Up to 58% Diameter
	≥ 35 HRC	Up to Max LOC	Up to 58% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

HST-3

3 FLUTE - BALL

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed for excellent chip evacuation in slotting, pocketing, and roughing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .002$ -.002	Shank Diameter D2 H9	Length of Cut L2 $\pm .032$ -.001	Overall Length L1 $\pm .002$ -.002	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	3	12017	HST-S-30125-BN
	1/8	1/2	2-1/2	3	12032	HST-R-30125-BN
3/16	3/16	5/16	2	3	12042	HST-S-30187-BN
	3/16	8/16	2-1/2	3	12077	HST-R-30187-BN
1/4	1/4	3/8	2	3	12107	HST-S-30250-BN
	1/4	1/2	2-1/2	3	12112	HST-SR-30250-BN
	1/4	3/4	2-1/2	3	12122	HST-R-30250-BN
5/16	5/16	7/16	2	3	12167	HST-S-30312-BN
	5/16	13/16	2-1/2	3	12182	HST-R-30312-BN
3/8	3/8	1/2	2	3	12212	HST-S-30375-BN
	3/8	1	3	3	12227	HST-R-30375-BN
1/2	1/2	5/8	2-1/2	3	12317	HST-S-30500-BN
	1/2	1	3	3	12332	HST-SR-30500-BN
	1/2	1-1/4	3	3	12347	HST-R-30500-BN
5/8	5/8	1-1/8	3-1/2	3	12407	HST-SR-30625-BN
3/4	3/4	1	3	3	12467	HST-S-30750-BN
	3/4	1-5/8	4	3	12482	HST-R-30750-BN
1	1	1-1/4	4	3	12527	HST-S-31900-BN
	1	2	4-1/2	3	12542	HST-R-31900-BN

* .0005 max TIR

3 FLUTE - CORNER RADIUS

HST-3

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed for excellent chip evacuation in slotting, pocketing, and roughing applications
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* $D_1 \pm \frac{.007}{.002}$	Shank Diameter $D_2 \text{ (in)}$	Corner Radius $R \pm \frac{.002}{.001}$	Length of Cut $L_1 \pm \frac{.007}{.002}$	Overall Length $L_2 \pm \frac{.007}{.002}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	3	08017	HST-S-30125-R.010
	1/8	.010	1/2	2-1/2	3	08032	HST-R-30125-R.010
3/16	3/16	.010	5/16	2	3	08062	HST-S-30187-R.010
	3/16	.010	9/16	2-1/2	3	08077	HST-R-30187-R.010
1/4	1/4	.020	3/8	2	3	08107	HST-S-30250-R.020
	1/4	.020	1/2	2-1/2	3	08112	HST-SR-30250-R.020
	1/4	.020	3/4	2-1/2	3	08122	HST-R-30250-R.020
	1/4	.020	1	3	3	08137	HST-M-30250-R.020
5/16	5/16	.020	7/16	2	3	08167	HST-S-30312-R.020
	5/16	.020	13/16	2-1/2	3	08182	HST-R-30312-R.020
	5/16	.020	1-1/4	3	3	08192	HST-M-30312-R.020
3/8	3/8	.020	1/2	2	3	08212	HST-S-30375-R.020
	3/8	.020	1	3	3	08227	HST-R-30375-R.020
	3/8	.020	1-1/4	3	3	08242	HST-M-30375-R.020
1/2	1/2	.030	5/8	2-1/2	3	08317	HST-S-30500-R.030
	1/2	.030	1	3	3	08332	HST-SR-30500-R.030
	1/2	.030	1-1/4	3	3	08347	HST-R-30500-R.030
	1/2	.030	1-5/8	4	3	08362	HST-M-30500-R.030
5/8	5/8	.030	3/4	3	3	08392	HST-S-30625-R.030
	5/8	.030	1-1/8	2-1/2	3	08407	HST-SR-30625-R.030
	5/8	.030	1-5/8	4	3	08422	HST-R-30625-R.030
	5/8	.030	2-1/8	4	3	08437	HST-M-30625-R.030
3/4	3/4	.030	1	3	3	08467	HST-S-30750-R.030
	3/4	.030	1-5/8	4	3	08482	HST-R-30750-R.030
	3/4	.030	2-1/4	5	3	08497	HST-M-30750-R.030
1	1	.030	1-1/4	4	3	08527	HST-S-31000-R.030
	1	.030	2	4-1/2	3	08542	HST-R-31000-R.030
	1	.030	2-5/8	6	3	08557	HST-M-31000-R.030

* .0005 max TIR



HST-RN-3

3 FLUTE - BALL
Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed for excellent chip evacuation in slotting, pocketing, and roughing applications
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Reach (LBS) L3	Neck Diameter	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	3	3/8	.118	3	13017	HST-RN-S-30125-BN
	1/8	5/32	3	1/2	.118	3	13032	HST-RN-R-30125-BN
	1/8	5/32	3	5/8	.118	3	13047	HST-RN-M-30125-BN
3/16	3/16	7/32	3	1/2	.178	3	13077	HST-RN-S-30187-BN
	3/16	7/32	3	3/4	.178	3	13082	HST-RN-M-30187-BN
1/4	1/4	3/8	4	3/4	.237	3	13112	HST-RN-S-30250-BN
	1/4	3/8	4	1-1/8	.237	3	13122	HST-RN-R-30250-BN
	1/4	3/8	4	2-1/8	.237	3	13137	HST-RN-M-30250-BN
5/16	5/16	7/16	4	1-1/8	.296	3	13157	HST-RN-R-30312-BN
	5/16	7/16	4	2-1/8	.296	3	13167	HST-RN-M-30312-BN
3/8	3/8	1/2	4	1-1/8	.356	3	13187	HST-RN-R-30375-BN
	3/8	1/2	6	2-3/8	.356	3	13212	HST-RN-M-30375-BN
	3/8	1/2	6	3-3/8	.356	3	13227	HST-RN-L-30375-BN
	3/8	1/2	6	4	.356	3	13232	HST-RN-X-30375-BN
1/2	1/2	5/8	4	1-3/8	.475	3	13302	HST-RN-R-30500-BN
	1/2	5/8	6	2-3/8	.475	3	13317	HST-RN-M-30500-BN
	1/2	5/8	6	3-3/8	.475	3	13332	HST-RN-L-30500-BN
	1/2	5/8	6	4-1/8	.475	3	13347	HST-RN-X-30500-BN

* .0005 max TIR

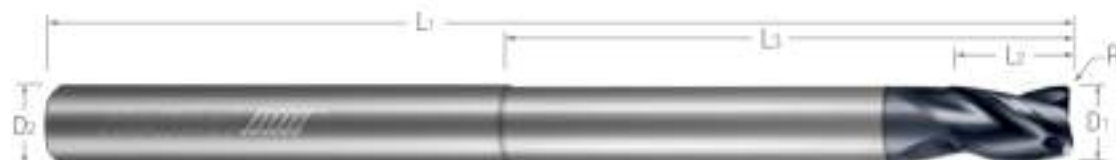


3 FLUTE - CORNER RADIUS

HST-RN-3

Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed for excellent chip evacuation in slotting, pocketing, and roughing applications
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.002 \end{smallmatrix}$ "	Shank Dia. D2 (H6)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$ "	Length of Cut L2 $\begin{smallmatrix} +.032 \\ -.000 \end{smallmatrix}$ "	DAL L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$ "	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	5/32	3	3/8	.118	3	10017	HST-RN-S-30125-R.010
	1/8	.010	5/32	3	5/8	.118	3	10047	HST-RN-M-30125-R.010
3/16	3/16	.010	7/32	3	3/4	.179	3	10082	HST-RN-M-30147-R.010
1/4	1/4	.020	3/8	4	3/4	.237	3	10112	HST-RN-S-30250-R.020
	1/4	.020	3/8	4	1-1/8	.237	3	10122	HST-RN-R-30250-R.020
	1/4	.020	3/8	4	2-1/8	.237	3	10137	HST-RN-M-30250-R.020
5/16	5/16	.020	7/16	4	1-1/8	.296	3	10157	HST-RN-R-30312-R.020
	5/16	.020	7/16	4	2-1/8	.296	3	10167	HST-RN-M-30312-R.020
3/8	3/8	.020	1/2	4	1-1/8	.356	3	10187	HST-RN-R-30375-R.020
	3/8	.020	1/2	6	2-3/8	.356	3	10212	HST-RN-M-30375-R.020
1/2	1/2	.030	5/8	4	1-3/8	.475	3	10382	HST-RN-R-30500-R.030
	1/2	.030	5/8	6	2-3/8	.475	3	10317	HST-RN-M-30500-R.030
	1/2	.030	5/8	6	3-3/8	.475	3	10332	HST-RN-L-30500-R.030
	1/2	.030	5/8	6	4-1/8	.475	3	10347	HST-RN-X-30500-R.030

* .0005 max TIR



HST-3

SPEEDS & FEEDS

3 Flute

HST-3 / HST-RN-3

Material Grade		Hardness	SFM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		5/8		1/2		3/4		1	
				Spl.	Rph.	Spl.	Rph.	Spl.	Rph.	Spl.	Rph.	Spl.	Rph.	Spl.	Rph.	Spl.	Rph.
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	405	.0007	.0011	.0010	.0017	.0013	.0023	.0019	.0034	.0025	.0044	.0038	.0064	.0045	.0082
		75 - 98 HRB	445	.0005	.0009	.0007	.0013	.0009	.0017	.0014	.0025	.0018	.0032	.0028	.0047	.0033	.0060
		21 - 36 HRC	400	.0003	.0006	.0005	.0008	.0006	.0011	.0009	.0016	.0012	.0021	.0017	.0030	.0021	.0039
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB	360	.0004	.0007	.0006	.0011	.0008	.0015	.0012	.0022	.0016	.0028	.0023	.0041	.0029	.0052
		21 - 36 HRC	340	.0003	.0005	.0005	.0008	.0006	.0011	.0009	.0016	.0012	.0021	.0017	.0030	.0021	.0039
		36 - 50 HRC	260	.0003	.0005	.0004	.0007	.0005	.0009	.0006	.0014	.0010	.0019	.0015	.0026	.0019	.0034
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	155	.0002	.0004	.0003	.0006	.0004	.0007	.0006	.0011	.0008	.0014	.0013	.0021	.0015	.0027
		75 - 98 HRB	340	.0004	.0007	.0006	.0011	.0008	.0015	.0012	.0022	.0016	.0028	.0023	.0041	.0029	.0052
		21 - 36 HRC	250	.0003	.0006	.0005	.0008	.0007	.0011	.0010	.0017	.0013	.0022	.0018	.0032	.0023	.0041
SPECIALTY STEEL	300M, Invar 36, Kovar, Managing 250, Managing 250, Managing 300, Managing 350	75 - 98 HRB	145	.0003	.0005	.0004	.0007	.0005	.0009	.0006	.0014	.0010	.0017	.0014	.0025	.0019	.0032
		36 - 50 HRC	85	.0002	.0004	.0003	.0006	.0004	.0007	.0006	.0011	.0008	.0014	.0013	.0021	.0015	.0026
		< 75 HRB	250	.0006	.0010	.0008	.0015	.0011	.0019	.0016	.0029	.0021	.0037	.0038	.0053	.0039	.0068
AUSTENITIC STAINLESS STEEL	A192, Invar 36, Kovar, Managing 250, Managing 250, Managing 300, Managing 350	15 - 98 HRB	265	.0004	.0007	.0006	.0010	.0007	.0013	.0011	.0020	.0014	.0025	.0028	.0037	.0028	.0047
		21 - 36 HRC	175	.0003	.0006	.0005	.0009	.0007	.0012	.0010	.0017	.0013	.0023	.0019	.0033	.0023	.0042
		36 - 50 HRC	150	.0003	.0005	.0004	.0008	.0006	.0011	.0009	.0016	.0011	.0020	.0016	.0029	.0021	.0036
MARTENSITIC & FERRITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347	> 50 HRC	85	.0002	.0003	.0003	.0005	.0004	.0007	.0006	.0010	.0007	.0012	.0010	.0019	.0013	.0023
		75 - 98 HRB	225	.0004	.0007	.0006	.0011	.0008	.0014	.0012	.0021	.0015	.0027	.0022	.0040	.0029	.0051
		21 - 36 HRC	225	.0004	.0006	.0006	.0010	.0007	.0013	.0011	.0019	.0014	.0025	.0028	.0036	.0028	.0046
RH STAINLESS STEEL	15-5, 17-4, Carpenter 490, Carpenter 495	36 - 50 HRC	180	.0003	.0005	.0004	.0008	.0006	.0010	.0009	.0015	.0011	.0020	.0016	.0029	.0020	.0037
		21 - 36 HRC	200	.0003	.0005	.0005	.0008	.0006	.0011	.0009	.0016	.0012	.0021	.0017	.0030	.0021	.0039
		75 - 98 HRB	300	.0004	.0007	.0006	.0011	.0008	.0015	.0012	.0022	.0016	.0028	.0023	.0041	.0029	.0052
GRAY CAST IRON	SAE J431, ASTM A48	21 - 36 HRC	260	.0004	.0006	.0006	.0010	.0007	.0013	.0011	.0019	.0014	.0024	.0028	.0035	.0028	.0046
		75 - 98 HRB	410	.0007	.0012	.0010	.0018	.0013	.0023	.0020	.0035	.0028	.0046	.0037	.0064	.0045	.0084
		21 - 36 HRC	370	.0004	.0006	.0005	.0010	.0007	.0013	.0011	.0019	.0014	.0025	.0028	.0036	.0025	.0046
WALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A502	75 - 98 HRB	345	.0004	.0008	.0006	.0011	.0008	.0015	.0012	.0022	.0016	.0029	.0023	.0042	.0030	.0054
		21 - 36 HRC	335	.0004	.0007	.0006	.0010	.0007	.0013	.0011	.0019	.0014	.0025	.0028	.0036	.0025	.0046
		36 - 50 HRC	290	.0003	.0005	.0004	.0008	.0006	.0010	.0009	.0015	.0011	.0020	.0016	.0029	.0020	.0037
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM A67	75 - 98 HRB	310	.0005	.0008	.0007	.0012	.0009	.0015	.0013	.0023	.0017	.0030	.0024	.0043	.0031	.0056
		21 - 36 HRC	260	.0003	.0005	.0004	.0008	.0006	.0010	.0009	.0015	.0011	.0020	.0016	.0029	.0020	.0037
		36 - 50 HRC	135	.0002	.0003	.0003	.0005	.0004	.0007	.0005	.0010	.0007	.0013	.0011	.0019	.0013	.0023
PURE NICKEL	Nickel 201, Nickel 201	< 75 HRB	285	.0006	.0010	.0008	.0015	.0011	.0020	.0017	.0030	.0022	.0038	.0031	.0056	.0048	.0072
		75 - 98 HRB	250	.0005	.0008	.0007	.0013	.0009	.0017	.0014	.0025	.0018	.0032	.0028	.0047	.0033	.0060
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Inconel 601, Inconel 718, Inconel 70	75 - 98 HRB	80	.0003	.0005	.0004	.0008	.0006	.0010	.0008	.0015	.0011	.0020	.0016	.0029	.0023	.0039
		21 - 36 HRC	75	.0003	.0005	.0004	.0007	.0006	.0010	.0008	.0015	.0011	.0019	.0015	.0027	.0019	.0035
		36 - 50 HRC	70	.0002	.0004	.0004	.0006	.0005	.0009	.0007	.0013	.0009	.0016	.0013	.0023	.0017	.0030
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0008	.0014	.0012	.0021	.0015	.0027	.0023	.0041	.0030	.0053	.0043	.0077	.0055	.0099
		75 - 98 HRB	275	.0007	.0012	.0010	.0018	.0013	.0023	.0019	.0034	.0025	.0046	.0038	.0065	.0048	.0083
		21 - 36 HRC	250	.0005	.0009	.0007	.0013	.0010	.0017	.0014	.0026	.0019	.0033	.0027	.0049	.0034	.0062
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 15V-3Fe-3Al	21 - 36 HRC	180	.0004	.0007	.0006	.0010	.0008	.0014	.0011	.0020	.0015	.0026	.0021	.0038	.0027	.0049
		36 - 50 HRC	160	.0004	.0006	.0005	.0009	.0007	.0012	.0010	.0019	.0014	.0024	.0019	.0035	.0025	.0045
		75 - 98 HRB	210	.0003	.0006	.0005	.0009	.0007	.0012	.0010	.0017	.0013	.0022	.0018	.0032	.0023	.0041
COBALT ALLOY	ASTM F902, ASTM F90, ASTM F75, ASTM F759	21 - 36 HRC	170	.0003	.0006	.0006	.0009	.0006	.0011	.0009	.0017	.0012	.0022	.0017	.0031	.0022	.0040
		36 - 50 HRC	85	.0002	.0004	.0003	.0006	.0004	.0009	.0006	.0011	.0008	.0015	.0013	.0021	.0015	.0027
		75 - 98 HRB	210	.0003	.0006	.0005	.0009	.0007	.0012	.0010	.0017	.0013	.0022	.0018	.0032	.0023	.0041

MILLING PROCESS	HARDNESS	ADOC	RDOC
Set (Full Setting)	< 35 HRC	100% - 100% Diameter	100% Diameter
	> 35 HRC	100% - 125% Diameter	100% Diameter
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	Up to 50% Diameter
	> 35 HRC	Up to Max LOC	Up to 50% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

4 FLUTE - SQUARE

New Items!

HSV-4

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 197 for Tplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 H6	Length of Cut L2 $\begin{smallmatrix} +.0027 \\ -.007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0031 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/8	1/8	1/4	1-1/2	4	30017		HSV-S-40125
	1/8	3/8	2	4	81635		HSV-SR-40125
	1/8	1/2	2-1/2	4	30032		HSV-R-40125
	1/8	5/8	2-1/2	4	81636		HSV-A-40125
	1/8	3/4	2-1/2	4	81637		HSV-M-40125
	1/8	7/8	2-1/2	4	82253		HSV-L-40125
	1/8	1	2-1/2	4	84685		HSV-LX-40125
5/32	3/16	3/16	2	4	30047		HSV-S-40156
	3/16	5/16	2	4	84686		HSV-SR-40156
	3/16	7/16	2-1/2	4	30062		HSV-R-40156
	3/16	9/16	2-1/2	4	81638		HSV-M-40156
	3/16	3/4	2-1/2	4	82254		HSV-L-40156
	3/16	1	3	4	88157		HSV-L-40156 new
3/16	3/16	5/16	2	4	30077		HSV-S-40187
	3/16	7/16	2	4	81639		HSV-SR-40187
	3/16	9/16	2-1/2	4	30092		HSV-R-40187
	3/16	3/4	2-1/2	4	88158		HSV-A-40187 new
	3/16	1	2-1/2	4	81640		HSV-M-40187
	3/16	1-3/16	3	4	82255		HSV-L-40187
	3/16	1-3/8	3	4	84687		HSV-LX-40187
7/32	1/4	1/4	2	4	30107		HSV-S-40218
	1/4	7/16	2-1/2	4	30122		HSV-R-40218
	1/4	5/8	2-1/2	4	82256		HSV-A-40218
1/4	1/4	3/8	2	4	30137	30137W	HSV-S-40250
	1/4	1/2	2-1/2	4	30142	30142W	HSV-SR-40250
	1/4	3/4	2-1/2	4	30152	30152W	HSV-R-40250
	1/4	1	3	4	30167	30167W	HSV-M-40250
	1/4	1-1/4	3	4	81641		HSV-L-40250
	1/4	1-1/2	3	4	81642		HSV-LX-40250
	1/4	1-3/4	4	4	83182		HSV-X-40250

* .0005 max TR

continued on next page



Speeds & Feeds on Page 132

HSV-4

New Items!

4 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.007}{.002}$	Shank Diameter D2 IN	Length of Cut L2 $\pm \frac{.007}{.002}$	Overall Length L1 $\pm \frac{.007}{.002}$	Flutes	Applus Coated	Applus Coated + Weiden Flat	Tool Description
9/32	5/16	7/16	2	4	30182		HSV-S-40281
	5/16	5/8	2-1/2	4	30197		HSV-R-40281
	5/16	1	3	4	30212		HSV-M-40281
	5/16	1-1/2	3	4	84688		HSV-L-40281
5/16	5/16	1/2	2	4	30227	30227W	HSV-S-40312
	5/16	3/4	2-1/2	4	30242	30242W	HSV-R-40312
	5/16	1	2-1/2	4	81643		HSV-A-40312
	5/16	1-1/4	3	4	30257	30257W	HSV-M-40312
	5/16	1-9/16	4	4	82257		HSV-L-40312
	5/16	2-1/8	4	4	88159		HSV-LX-40312
3/8	3/8	1/2	2	4	30317	30317W	HSV-S-40375
	3/8	7/8	3	4	30332	30332W	HSV-SR-40375
	3/8	1	3	4	30337	30337W	HSV-R-40375
	3/8	1-1/4	3	4	30347	30347W	HSV-M-40375
	3/8	1-1/2	3	4	81644		HSV-L-40375
	3/8	2	4	4	82258		HSV-LX-40375
	3/8	2-1/2	5	4	84689		HSV-X-40375
13/32	7/16	1/2	2-3/4	4	30362		HSV-S-40406
	7/16	15/16	2-3/4	4	30377		HSV-R-40406
7/16	7/16	5/8	2-3/4	4	30407		HSV-S-40437
	7/16	7/8	2-3/4	4	30422		HSV-R-40437
	7/16	1-1/8	3-1/2	4	30437		HSV-M-40437
	7/16	1-5/8	3-1/2	4	84690		HSV-L-40437
1/2	1/2	5/8	2-1/2	4	30407	30407W	HSV-S-40500
	1/2	1	3	4	30512	30512W	HSV-SR-40500
	1/2	1-1/4	3	4	30527	30527W	HSV-R-40500
	1/2	1-5/8	4	4	30542	30542W	HSV-M-40500
	1/2	2	4	4	81645	81645W	HSV-L-40500
	1/2	2-1/2	5	4	81646		HSV-LX-40500
	1/2	3-1/8	6	4	82259		HSV-X-40500
5/8	5/8	3/4	3	4	30557		HSV-S-40625
	5/8	1-1/4	3-1/2	4	30572	30572W	HSV-SR-40625
	5/8	1-5/8	3-1/2	4	30587	30587W	HSV-R-40625
	5/8	2	4	4	30602	30602W	HSV-M-40625
	5/8	2-1/2	5	4	82260		HSV-L-40625
	5/8	3-1/4	6	4	30617		HSV-LX-40625
	5/8	3-3/4	8	4	84691		HSV-X-40625
3/4	3/4	7/8	3	4	30632		HSV-S-40750
	3/4	1-1/4	4	4	30647	30647W	HSV-SR-40750
	3/4	1-5/8	4	4	30662	30662W	HSV-R-40750
	3/4	2-1/4	5	4	30677	30677W	HSV-M-40750
	3/4	2-3/4	5	4	81647		HSV-L-40750
	3/4	3-1/4	6	4	30692	30692W	HSV-LX-40750
	3/4	4	6-1/2	4	82261		HSV-X-40750
	3/4	4-3/4	7	4	84692		HSV-X-40750
1	1	1-1/2	4	4	30707		HSV-S-41000
	1	2	4-1/2	4	30722	30722W	HSV-R-41000
	1	2-5/8	5	4	30737	30737W	HSV-M-41000
	1	3	6	4	30742		HSV-L-41000
	1	4-1/4	7	4	30752		HSV-L-41000

*.0005 max TIR

4 FLUTE - SQUARE - METRIC

Variable Pitch

MHSV-4
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 +0.0 mm -0.0 mm	Shank Diameter D2 (H6)	Length of Cut L2 +0.0 mm -0.0 mm	Overall Length L1 +1.68 mm -1.68 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	9.00 mm	63 mm	4	59458	MHSV-015-40600
	6.00 mm	12.00 mm	63 mm	4	59476	MHSV-020-40600
	6.00 mm	18.00 mm	63 mm	4	59510	MHSV-030-40600
8 mm	8.00 mm	12.00 mm	63 mm	4	59461	MHSV-015-40800
	8.00 mm	16.00 mm	63 mm	4	59479	MHSV-020-40800
	8.00 mm	24.00 mm	75 mm	4	59513	MHSV-030-40800
10 mm	10.00 mm	15.00 mm	63 mm	4	59464	MHSV-015-41000
	10.00 mm	20.00 mm	63 mm	4	59482	MHSV-020-41000
	10.00 mm	25.00 mm	75 mm	4	59496	MHSV-025-41000
12 mm	12.00 mm	18.00 mm	75 mm	4	59467	MHSV-015-41200
	12.00 mm	24.00 mm	75 mm	4	59485	MHSV-020-41200
	12.00 mm	30.00 mm	75 mm	4	59499	MHSV-025-41200
16 mm	16.00 mm	24.00 mm	89 mm	4	59470	MHSV-015-41600
	16.00 mm	32.00 mm	89 mm	4	59488	MHSV-020-41600
	16.00 mm	40.00 mm	89 mm	4	59502	MHSV-025-41600
20 mm	20.00 mm	30.00 mm	89 mm	4	59473	MHSV-015-42000
	20.00 mm	40.00 mm	100 mm	4	59491	MHSV-020-42000
	20.00 mm	50.00 mm	125 mm	4	59505	MHSV-025-42000
25 mm	25.00 mm	50.00 mm	125 mm	4	59494	MHSV-020-42500
	25.00 mm	64.00 mm	125 mm	4	59508	MHSV-025-42500

* .013 mm max TIR



HSV-4

New Items!

4 FLUTE - BALL
Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics

- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 200 for T_{plus} coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 H6	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	4	56017	HSV-S-40125-BN
	1/8	3/8	.2	4	81674	HSV-SR-40125-BN
	1/8	1/2	2-1/2	4	56032	HSV-R-40125-BN
	1/8	5/8	2-1/2	4	81675	HSV-A-40125-BN
	1/8	3/4	2-1/2	4	82510	HSV-M-40125-BN
	1/8	7/8	2-1/2	4	84742	HSV-L-40125-BN
	1/8	1	2-1/2	4	88174	HSV-LX-40125-BN
5/32	3/16	3/16	.2	4	83941	HSV-S-40156-BN
	3/16	5/16	.2	4	88175	HSV-SR-40156-BN
	3/16	7/16	2-1/2	4	83942	HSV-R-40156-BN
	3/16	9/16	2-1/2	4	83943	HSV-M-40156-BN
	3/16	3/4	2-1/2	4	84743	HSV-L-40156-BN
3/16	3/16	5/16	.2	4	56077	HSV-S-40187-BN
	3/16	7/16	.2	4	82511	HSV-SR-40187-BN
	3/16	5/8	2-1/2	4	56082	HSV-R-40187-BN
	3/16	3/4	2-1/2	4	88176	HSV-A-40187-BN
	3/16	1	2-1/2	4	81676	HSV-M-40187-BN
	3/16	1-3/16	.3	4	83273	HSV-L-40187-BN
	3/16	1-3/8	.3	4	88177	HSV-LX-40187-BN
7/32	1/4	1/4	.2	4	83944	HSV-S-40218-BN
	1/4	7/16	2-1/2	4	83945	HSV-R-40218-BN
	1/4	5/8	2-1/2	4	88178	HSV-A-40218-BN
1/4	1/4	3/8	.2	4	56137	HSV-S-40250-BN
	1/4	1/2	2-1/2	4	56142	HSV-SR-40250-BN
	1/4	3/4	2-1/2	4	56152	HSV-R-40250-BN
	1/4	1	.3	4	56167	HSV-M-40250-BN
	1/4	1-1/4	.3	4	81677	HSV-L-40250-BN
	1/4	1-1/2	.3	4	82512	HSV-LX-40250-BN
	1/4	1-3/4	.4	4	84744	HSV-X-40250-BN
9/32	5/16	7/16	.2	4	83946	HSV-S-40281-BN
	5/16	5/8	2-1/2	4	83947	HSV-R-40281-BN
	5/16	1	.3	4	84745	HSV-M-40281-BN

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 132

4 FLUTE - BALL

New Items!

HSV-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (in)	Length of Cut L2 $\pm \frac{.002}{.001}$	Overall Length L1 $\pm \frac{.002}{.001}$	Flutes	Aplus Coated	Tool Description
5/16	5/16	1/2	2	4	56227	HSV-S-40312-BN
	5/16	3/4	2-1/2	4	56242	HSV-R-40312-BN
	5/16	1	2-1/2	4	81678	HSV-A-40312-BN
	5/16	1-1/4	3	4	56257	HSV-M-40312-BN
	5/16	1-9/16	4	4	82513	HSV-L-40312-BN
	5/16	2-1/8	4	4	88179	HSV-DX-40312-BN
3/8	3/8	1/2	2	4	56317	HSV-S-40375-BN
	3/8	7/8	3	4	56332	HSV-SR-40375-BN
	3/8	1	3	4	56337	HSV-R-40375-BN
	3/8	1-1/4	3	4	56347	HSV-M-40375-BN
	3/8	1-1/2	3	4	82514	HSV-L-40375-BN
	3/8	2	4	4	84746	HSV-DX-40375-BN
	3/8	2-1/2	5	4	88180	HSV-X-40375-BN
7/16	7/16	5/8	2-3/4	4	56407	HSV-S-40437-BN
	7/16	7/8	2-3/4	4	56422	HSV-R-40437-BN
	7/16	1-1/8	3-1/2	4	56437	HSV-M-40437-BN
1/2	1/2	5/8	2-1/2	4	56487	HSV-S-40500-BN
	1/2	1	3	4	56512	HSV-SR-40500-BN
	1/2	1-1/4	3	4	56527	HSV-R-40500-BN
	1/2	1-5/8	4	4	56542	HSV-M-40500-BN
	1/2	2	4	4	81679	HSV-L-40500-BN
	1/2	2-1/2	5	4	83274	HSV-DX-40500-BN
	1/2	3-1/8	6	4	88181	HSV-X-40500-BN
5/8	5/8	3/4	3	4	56557	HSV-S-40625-BN
	5/8	1-1/4	3-1/2	4	56572	HSV-SR-40625-BN
	5/8	1-5/8	3-1/2	4	56587	HSV-R-40625-BN
	5/8	2	4	4	56602	HSV-M-40625-BN
	5/8	2-1/2	5	4	84747	HSV-ML-40625-BN
	5/8	3-1/4	6	4	56617	HSV-L-40625-BN
3/4	3/4	7/8	3	4	56632	HSV-S-40750-BN
	3/4	1-1/4	4	4	56647	HSV-SR-40750-BN
	3/4	1-5/8	4	4	56662	HSV-R-40750-BN
	3/4	2-1/4	5	4	56677	HSV-M-40750-BN
	3/4	2-3/4	5	4	84748	HSV-ML-40750-BN
	3/4	3-1/4	6	4	56692	HSV-L-40750-BN
	3/4	4	6-1/2	4	84749	HSV-DX-40750-BN
1	1	1-1/2	4	4	56707	HSV-S-41000-BN
	1	2	4-1/2	4	56722	HSV-R-41000-BN
	1	2-5/8	5	4	56737	HSV-M-41000-BN
	1	3	6	4	56742	HSV-ML-41000-BN
	1	4-1/4	7	4	56752	HSV-L-41000-BN

* .0005 max TIR

MHSV-4

METRIC

4 FLUTE - BALL - METRIC

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.00 \text{ mm} \\ -.00 \text{ mm} \end{smallmatrix}$	Shank Diameter D2 (H9)	Length of Cut L2 $\begin{smallmatrix} +.00 \text{ mm} \\ -.00 \text{ mm} \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.00 \text{ mm} \\ -.00 \text{ mm} \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	9.00 mm	63 mm	4	84960	MHSV-015-40600-BN
	6.00 mm	12.00 mm	63 mm	4	84961	MHSV-020-40600-BN
	6.00 mm	18.00 mm	63 mm	4	84962	MHSV-030-40600-BN
8 mm	8.00 mm	12.00 mm	63 mm	4	84963	MHSV-015-40800-BN
	8.00 mm	18.00 mm	63 mm	4	84964	MHSV-020-40800-BN
	8.00 mm	24.00 mm	75 mm	4	84965	MHSV-030-40800-BN
10 mm	10.00 mm	15.00 mm	63 mm	4	84966	MHSV-015-41000-BN
	10.00 mm	20.00 mm	63 mm	4	84967	MHSV-020-41000-BN
	10.00 mm	25.00 mm	75 mm	4	84968	MHSV-025-41000-BN
12 mm	12.00 mm	18.00 mm	75 mm	4	84969	MHSV-015-41200-BN
	12.00 mm	24.00 mm	75 mm	4	84970	MHSV-020-41200-BN
	12.00 mm	30.00 mm	75 mm	4	84971	MHSV-025-41200-BN
16 mm	16.00 mm	24.00 mm	89 mm	4	84972	MHSV-015-41600-BN
	16.00 mm	32.00 mm	89 mm	4	84973	MHSV-020-41600-BN
	16.00 mm	40.00 mm	89 mm	4	84974	MHSV-025-41600-BN
20 mm	20.00 mm	30.00 mm	89 mm	4	84975	MHSV-015-42000-BN
	20.00 mm	40.00 mm	100 mm	4	84976	MHSV-020-42000-BN
	20.00 mm	50.00 mm	125 mm	4	84977	MHSV-025-42000-BN
25 mm	25.00 mm	50.00 mm	125 mm	4	84978	MHSV-020-42500-BN
	25.00 mm	64.00 mm	125 mm	4	84979	MHSV-026-42500-BN

*.013 mm max TIR



4 FLUTE - CORNER RADIUS

New Items!

HSV-4

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 202 for Tplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0008 \\ -.0008 \end{smallmatrix}$	Shank Diameter D2 $\pm .000$	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/8	1/8	.010	1/4	1-1/2	4	31017		HSV-S-40125-R.010
	1/8	.010	3/8	2	4	81648		HSV-SR-40125-R.010
	1/8	.010	1/2	2-1/2	4	31032		HSV-R-40125-R.010
	1/8	.010	5/8	2-1/2	4	81649		HSV-A-40125-R.010
	1/8	.010	3/4	2-1/2	4	81650		HSV-M-40125-R.010
	1/8	.010	7/8	2-1/2	4	83212		HSV-L-40125-R.010
	1/8	.015	1/4	1-1/2	4	81651		HSV-S-40125-R.015
	1/8	.015	3/8	2	4	82276		HSV-SR-40125-R.015
	1/8	.015	1/2	2-1/2	4	81652		HSV-R-40125-R.015
	1/8	.015	5/8	2-1/2	4	83213		HSV-A-40125-R.015
	1/8	.020	1/4	1-1/2	4	83214		HSV-S-40125-R.020
	1/8	.020	3/8	2	4	83215		HSV-SR-40125-R.020
	1/8	.020	1/2	2-1/2	4	83216		HSV-R-40125-R.020
	1/8	.020	5/8	2-1/2	4	88187		HSV-A-40125-R.020 new
	1/8	.030	1/4	1-1/2	4	43017		HSV-S-40125-R.030
	1/8	.030	3/8	2	4	82277		HSV-SR-40125-R.030
5/32	3/16	.010	3/16	2	4	31047		HSV-S-40156-R.010
	3/16	.010	5/16	2	4	84598		HSV-SR-40156-R.010
	3/16	.010	7/16	2-1/2	4	31062		HSV-R-40156-R.010
	3/16	.010	9/16	2-1/2	4	81653		HSV-M-40156-R.010
	3/16	.010	3/4	2-1/2	4	88188		HSV-ML-40156-R.010 new
	3/16	.030	3/16	2	4	82279		HSV-S-40156-R.030
	3/16	.030	5/16	2	4	84599		HSV-SR-40156-R.030
	3/16	.030	7/16	2-1/2	4	82280		HSV-R-40156-R.030
	3/16	.030	9/16	2-1/2	4	84700		HSV-M-40156-R.030
3/16	3/16	.030	3/4	2-1/2	4	88189		HSV-ML-40156-R.030 new
	3/16	.010	5/16	2	4	31077		HSV-S-40187-R.010
	3/16	.010	7/16	2	4	81654		HSV-SR-40187-R.010
	3/16	.010	5/8	2-1/2	4	31092		HSV-R-40187-R.010
	3/16	.010	1	2-1/2	4	81655		HSV-M-40187-R.010
	3/16	.010	1-3/16	3	4	83217		HSV-L-40187-R.010
	3/16	.015	5/16	2	4	83218		HSV-S-40187-R.015
	3/16	.015	7/16	2	4	83219		HSV-SR-40187-R.015
	3/16	.015	5/8	2-1/2	4	83220		HSV-R-40187-R.015
	3/16	.015	1	2-1/2	4	88190		HSV-M-40187-R.015 new

*.0005 max TIR

HSV-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H6)	Corner Radius R $\pm \frac{.002}{.003}$	Length of Cut L2 $\pm \frac{.002}{.003}$	Overall Length L1 $\pm \frac{.002}{.003}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
3/16	3/16	.020	5/16	2	4	83221		HSV-S-40187-R.020
	3/16	.020	7/16	2	4	83222		HSV-SR-40187-R.020
	3/16	.020	5/8	2-1/2	4	83223		HSV-R-40187-R.020
	3/16	.020	1	2-1/2	4	88191		HSV-M-40187-R.020
	3/16	.030	5/16	2	4	43077		HSV-S-40187-R.030
	3/16	.030	7/16	2	4	82281		HSV-SR-40187-R.030
	3/16	.030	5/8	2-1/2	4	43082		HSV-R-40187-R.030
	3/16	.030	1	2-1/2	4	82282		HSV-M-40187-R.030
7/32	1/4	.010	1/4	2	4	31107		HSV-S-40218-R.010
	1/4	.010	7/16	2-1/2	4	31122		HSV-R-40218-R.010
	1/4	.010	5/8	2-1/2	4	82283		HSV-A-40218-R.010
1/4	1/4	.010	3/8	2	4	81656		HSV-S-40250-R.010
	1/4	.010	1/2	2-1/2	4	81657		HSV-SR-40250-R.010
	1/4	.010	3/4	2-1/2	4	81658		HSV-R-40250-R.010
	1/4	.010	1	3	4	82284		HSV-M-40250-R.010
	1/4	.010	1-1/4	3	4	82285		HSV-L-40250-R.010
	1/4	.015	3/8	2	4	82286		HSV-S-40250-R.015
	1/4	.015	1/2	2-1/2	4	82287		HSV-SR-40250-R.015
	1/4	.015	3/4	2-1/2	4	82288		HSV-R-40250-R.015
	1/4	.015	1	3	4	82289		HSV-M-40250-R.015
	1/4	.015	1-1/4	3	4	82290		HSV-L-40250-R.015
	1/4	.020	3/8	2	4	31137	31137W	HSV-S-40250-R.020
	1/4	.020	1/2	2-1/2	4	31142	31142W	HSV-SR-40250-R.020
	1/4	.020	3/4	2-1/2	4	31152	31152W	HSV-R-40250-R.020
	1/4	.020	1	3	4	31167	31167W	HSV-M-40250-R.020
	1/4	.020	1-1/4	3	4	81659		HSV-L-40250-R.020
	1/4	.020	1-1/2	3	4	83224		HSV-LX-40250-R.020
	1/4	.030	3/8	2	4	43137		HSV-S-40250-R.030
	1/4	.030	1/2	2-1/2	4	43142	43142W	HSV-SR-40250-R.030
	1/4	.030	3/4	2-1/2	4	43152	43152W	HSV-R-40250-R.030
	1/4	.030	1	3	4	43167		HSV-M-40250-R.030
	1/4	.030	1-1/4	3	4	82291		HSV-L-40250-R.030
	1/4	.060	3/8	2	4	43138		HSV-S-40250-R.060
	1/4	.060	1/2	2-1/2	4	43143		HSV-SR-40250-R.060
	1/4	.060	3/4	2-1/2	4	43153		HSV-R-40250-R.060
	1/4	.060	1	3	4	43168		HSV-M-40250-R.060
	1/4	.060	1-1/4	3	4	82292		HSV-L-40250-R.060
9/32	5/16	.020	7/16	2	4	31182		HSV-S-40281-R.020
	5/16	.020	5/8	2-1/2	4	31197		HSV-R-40281-R.020
	5/16	.020	1	3	4	31212		HSV-M-40281-R.020
5/16	5/16	.010	1/2	2	4	82293		HSV-S-40312-R.010
	5/16	.010	3/4	2-1/2	4	82294		HSV-R-40312-R.010
	5/16	.010	1	2-1/2	4	84701		HSV-A-40312-R.010
	5/16	.010	1-1/4	3	4	82295		HSV-M-40312-R.010
	5/16	.020	1/2	2	4	31227	31227W	HSV-S-40312-R.020
	5/16	.020	3/4	2-1/2	4	31242	31242W	HSV-R-40312-R.020
	5/16	.020	1	2-1/2	4	81660		HSV-A-40312-R.020
	5/16	.020	1-1/4	3	4	31257	31257W	HSV-M-40312-R.020
	5/16	.020	1-9/16	4	4	82296		HSV-ML-40312-R.020

*.0005 max TIR

continued on next page

4 FLUTE - CORNER RADIUS

New Items!

HSV-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 .005	Corner Radius R $\pm .002$ -.002	Length of Cut L2 $\pm .002$ -.002	Overall Length L1 $\pm .002$ -.002	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
5/16	5/16	.030	1/2	2	4	43227	43227W	HSV-S-40312-R.030
	5/16	.030	3/4	2-1/2	4	43242		HSV-R-40312-R.030
	5/16	.030	1	2-1/2	4	44702		HSV-A-40312-R.030
	5/16	.030	1-1/4	3	4	43257		HSV-M-40312-R.030
	5/16	.030	1-5/16	4	4	44703		HSV-ML-40312-R.030
	5/16	.060	1/2	2	4	43228		HSV-S-40312-R.060
	5/16	.060	3/4	2-1/2	4	43243		HSV-R-40312-R.060
	5/16	.060	1	2-1/2	4	44704		HSV-A-40312-R.060
	5/16	.060	1-1/4	3	4	43258		HSV-M-40312-R.060
	5/16	.060	1-5/16	4	4	44705		HSV-ML-40312-R.060
3/8	3/8	.010	1/2	2	4	41661		HSV-S-40375-R.010
	3/8	.010	7/8	3	4	41662		HSV-SR-40375-R.010
	3/8	.010	1	3	4	48102		HSV-R-40375-R.010
	3/8	.010	1-1/4	3	4	41663		HSV-M-40375-R.010
	3/8	.010	1-1/2	3	4	43225		HSV-L-40375-R.010
	3/8	.015	1/2	2	4	43226		HSV-S-40375-R.015
	3/8	.015	7/8	3	4	43227		HSV-SR-40375-R.015
	3/8	.015	1	3	4	48103		HSV-R-40375-R.015
	3/8	.015	1-1/4	3	4	43228		HSV-M-40375-R.015
	3/8	.020	1/2	2	4	41317	41317W	HSV-S-40375-R.020
	3/8	.020	7/8	3	4	41332	41332W	HSV-SR-40375-R.020
	3/8	.020	1	3	4	41337	41337W	HSV-R-40375-R.020
	3/8	.020	1-1/4	3	4	41347	41347W	HSV-M-40375-R.020
	3/8	.020	1-1/2	3	4	41664		HSV-L-40375-R.020
	3/8	.030	1/2	2	4	43317	43317W	HSV-S-40375-R.030
	3/8	.030	7/8	3	4	43332	43332W	HSV-SR-40375-R.030
	3/8	.030	1	3	4	43337	43337W	HSV-R-40375-R.030
	3/8	.030	1-1/4	3	4	43347	43347W	HSV-M-40375-R.030
	3/8	.030	1-1/2	3	4	43229		HSV-L-40375-R.030
	3/8	.060	1/2	2	4	43318	43318W	HSV-S-40375-R.060
	3/8	.060	7/8	3	4	43333	43333W	HSV-SR-40375-R.060
	3/8	.060	1	3	4	43338	43338W	HSV-R-40375-R.060
	3/8	.060	1-1/4	3	4	43348	43348W	HSV-M-40375-R.060
	3/8	.060	1-1/2	3	4	43230		HSV-L-40375-R.060
	3/8	.090	1/2	2	4	43319		HSV-S-40375-R.090
	3/8	.090	7/8	3	4	43334		HSV-SR-40375-R.090
	3/8	.090	1	3	4	43339		HSV-R-40375-R.090
	3/8	.090	1-1/4	3	4	43349		HSV-M-40375-R.090
13/32	7/16	.020	1/2	2-3/4	4	41362		HSV-S-40406-R.020
	7/16	.020	15/16	2-3/4	4	41377		HSV-R-40406-R.020
7/16	7/16	.020	5/8	2-3/4	4	41407		HSV-S-40437-R.020
	7/16	.020	7/8	2-3/4	4	41422		HSV-R-40437-R.020
	7/16	.020	1-1/8	3-1/2	4	41437		HSV-M-40437-R.020
	7/16	.030	5/8	2-3/4	4	43407		HSV-S-40437-R.030
	7/16	.030	7/8	2-3/4	4	43422		HSV-R-40437-R.030
	7/16	.030	1-1/8	3-1/2	4	43437		HSV-M-40437-R.030
	7/16	.060	5/8	2-3/4	4	43408		HSV-S-40437-R.060
	7/16	.060	7/8	2-3/4	4	43423		HSV-R-40437-R.060
	7/16	.060	1-1/8	3-1/2	4	43438		HSV-M-40437-R.060
	7/16	.090	5/8	2-3/4	4	43409		HSV-S-40437-R.090
	7/16	.090	7/8	2-3/4	4	43424		HSV-R-40437-R.090
	7/16	.090	1-1/8	3-1/2	4	43439		HSV-M-40437-R.090

* .0005 max TIR

continued on next page

HSV-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ $\frac{+0.007}{-0.007}$	Shank Diameter D ₂ (in)	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L ₂ $\frac{+0.027}{-0.007}$	Overall Length L ₁ $\frac{+0.027}{-0.007}$	Flutes	Apix Coated	Apix Coated + Weldon Flat	Tool Description
15/32	1/2	.030	5/8	2-1/2	4	31452		HSV-S-40468-R.030
	1/2	.030	1	3	4	31467		HSV-R-40468-R.030
	1/2	.030	1-1/4	3	4	31482		HSV-M-40468-R.030
1/2	1/2	.010	5/8	2-1/2	4	82297		HSV-S-40500-R.010
	1/2	.010	1	3	4	82298		HSV-SR-40500-R.010
	1/2	.010	1-1/4	3	4	82299		HSV-R-40500-R.010
	1/2	.010	1-5/8	4	4	83231		HSV-M-40500-R.010
	1/2	.010	2	4	4	84706		HSV-L-40500-R.010
	1/2	.015	5/8	2-1/2	4	81665		HSV-S-40600-R.015
	1/2	.015	1	3	4	81666		HSV-SR-40600-R.015
	1/2	.015	1-1/4	3	4	81667		HSV-R-40600-R.015
	1/2	.015	1-5/8	4	4	83232		HSV-M-40600-R.015
	1/2	.015	2	4	4	83233		HSV-L-40600-R.015
	1/2	.020	5/8	2-1/2	4	43496	43496W	HSV-S-40600-R.020
	1/2	.020	1	3	4	43511	43511W	HSV-SR-40600-R.020
	1/2	.020	1-1/4	3	4	43526	43526W	HSV-R-40600-R.020
	1/2	.020	1-5/8	4	4	43541		HSV-M-40600-R.020
	1/2	.020	2	4	4	83234		HSV-L-40600-R.020
	1/2	.030	5/8	2-1/2	4	31497	31497W	HSV-S-40600-R.030
	1/2	.030	1	3	4	31512	31512W	HSV-SR-40600-R.030
	1/2	.030	1-1/4	3	4	31527	31527W	HSV-R-40600-R.030
	1/2	.030	1-5/8	4	4	31542	31542W	HSV-M-40600-R.030
	1/2	.030	2	4	4	81668	81668W	HSV-L-40600-R.030
	1/2	.030	2-1/2	5	4	83235		HSV-LX-40600-R.030
	1/2	.060	5/8	2-1/2	4	43497	43497W	HSV-S-40600-R.060
	1/2	.060	1	3	4	43512	43512W	HSV-SR-40600-R.060
	1/2	.060	1-1/4	3	4	43527	43527W	HSV-R-40600-R.060
	1/2	.060	1-5/8	4	4	43542	43542W	HSV-M-40600-R.060
	1/2	.060	2	4	4	81669		HSV-L-40600-R.060
	1/2	.060	2-1/2	5	4	83236		HSV-LX-40600-R.060
	1/2	.090	5/8	2-1/2	4	43498		HSV-S-40600-R.090
	1/2	.090	1	3	4	43513		HSV-SR-40600-R.090
	1/2	.090	1-1/4	3	4	43528		HSV-R-40600-R.090
	1/2	.090	1-5/8	4	4	43543		HSV-M-40600-R.090
	1/2	.120	5/8	2-1/2	4	88194		HSV-S-40600-R.120
	1/2	.120	1	3	4	88195		HSV-SR-40600-R.120
	1/2	.120	1-1/4	3	4	88196		HSV-R-40600-R.120
	1/2	.120	1-5/8	4	4	88197		HSV-M-40600-R.120
	1/2	.120	2	4	4	88198		HSV-L-40600-R.120
	1/2	.125	5/8	2-1/2	4	43499		HSV-S-40600-R.125
	1/2	.125	1	3	4	43514	43514W	HSV-SR-40600-R.125
	1/2	.125	1-1/4	3	4	43529	43529W	HSV-R-40600-R.125
	1/2	.125	1-5/8	4	4	43544	43544W	HSV-M-40600-R.125
	1/2	.125	2	4	4	83237		HSV-L-40600-R.125
5/8	5/8	.015	3/4	3	4	88199		HSV-S-40625-R.015
	5/8	.015	1-1/4	3-1/2	4	84707		HSV-SR-40625-R.015
	5/8	.015	1-5/8	3-1/2	4	84708		HSV-R-40625-R.015
	5/8	.015	2	4	4	84709		HSV-M-40625-R.015
	5/8	.020	3/4	3	4	88200		HSV-S-40625-R.020
	5/8	.020	1-1/4	3-1/2	4	84710		HSV-SR-40625-R.020
	5/8	.020	1-5/8	3-1/2	4	84711		HSV-R-40625-R.020
	5/8	.020	2	4	4	84712		HSV-M-40625-R.020

*.0005 max TIR

continued on next page

4 FLUTE - CORNER RADIUS

New Items!

HSV-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 .001	Corner Radius R $\pm .002$ -.002	Length of Cut L1 $\pm .002$ -.002	Overall Length L1 $\pm .002$ -.002	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
5/8	5/8	.030	3/4	3	4	31557		HSV-S-40625-R.030
	5/8	.030	1-1/4	3-1/2	4	31572	31572W	HSV-SR-40625-R.030
	5/8	.030	1-5/8	3-1/2	4	31587	31587W	HSV-R-40625-R.030
	5/8	.030	2	4	4	31602	31602W	HSV-M-40625-R.030
	5/8	.030	2-1/2	5	4	31670		HSV-ML-40625-R.030
	5/8	.030	3-1/4	6	4	31617		HSV-L-40625-R.030
	5/8	.030	3-3/4	6	4	32300		HSV-LX-40625-R.030
	5/8	.060	3/4	3	4	43557		HSV-S-40625-R.060
	5/8	.060	1-1/4	3-1/2	4	43572		HSV-SR-40625-R.060
	5/8	.060	1-5/8	3-1/2	4	43587		HSV-R-40625-R.060
	5/8	.060	2	4	4	43602		HSV-M-40625-R.060
	5/8	.060	3-1/4	6	4	43617		HSV-L-40625-R.060
	5/8	.090	3/4	3	4	43558		HSV-S-40625-R.090
	5/8	.090	1-1/4	3-1/2	4	43573		HSV-SR-40625-R.090
	5/8	.090	1-5/8	3-1/2	4	43588		HSV-R-40625-R.090
	5/8	.090	2	4	4	43603		HSV-M-40625-R.090
	5/8	.090	3-1/4	6	4	43618		HSV-L-40625-R.090
	5/8	.125	3/4	3	4	43559		HSV-S-40625-R.125
	5/8	.125	1-1/4	3-1/2	4	43574		HSV-SR-40625-R.125
	5/8	.125	1-5/8	3-1/2	4	43589		HSV-R-40625-R.125
	5/8	.125	2	4	4	43604		HSV-M-40625-R.125
	5/8	.125	3-1/4	6	4	43619		HSV-L-40625-R.125
3/4	3/4	.015	7/8	3	4	33201		HSV-S-40750-R.015
	3/4	.015	1-1/4	4	4	31671		HSV-SR-40750-R.015
	3/4	.015	1-5/8	4	4	31672		HSV-R-40750-R.015
	3/4	.015	2-1/4	5	4	34713		HSV-M-40750-R.015
	3/4	.020	1-1/4	4	4	34714		HSV-SR-40750-R.020
	3/4	.020	1-5/8	4	4	34715		HSV-R-40750-R.020
	3/4	.020	2-1/4	5	4	34716		HSV-M-40750-R.020
	3/4	.030	7/8	3	4	31632	31632W	HSV-S-40750-R.030
	3/4	.030	1-1/4	4	4	31647	31647W	HSV-SR-40750-R.030
	3/4	.030	1-5/8	4	4	31662	31662W	HSV-R-40750-R.030
	3/4	.030	2-1/4	5	4	31677	31677W	HSV-M-40750-R.030
	3/4	.030	2-3/4	5	4	31673		HSV-ML-40750-R.030
	3/4	.030	3-1/4	6	4	31692	31692W	HSV-L-40750-R.030
	3/4	.030	4	6-1/2	4	32301		HSV-LX-40750-R.030
	3/4	.030	4-3/4	7	4	34717		HSV-X-40750-R.030
	3/4	.060	7/8	3	4	43632		HSV-S-40750-R.060
	3/4	.060	1-1/4	4	4	43647		HSV-SR-40750-R.060
	3/4	.060	1-5/8	4	4	43662		HSV-R-40750-R.060
	3/4	.060	2-1/4	5	4	43677		HSV-M-40750-R.060
	3/4	.060	2-3/4	5	4	33202		HSV-ML-40750-R.060
	3/4	.060	3-1/4	6	4	43692		HSV-L-40750-R.060
	3/4	.090	7/8	3	4	43633		HSV-S-40750-R.090
	3/4	.090	1-1/4	4	4	43648		HSV-SR-40750-R.090
	3/4	.090	1-5/8	4	4	43663		HSV-R-40750-R.090
	3/4	.090	2-1/4	5	4	43678		HSV-M-40750-R.090
	3/4	.090	3-1/4	6	4	43693		HSV-L-40750-R.090

* .0005 max. TIR

continued on next page

HSV-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.007 \\ -.007 \end{smallmatrix}$	Shank Diameter D2 (in)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Applus Coated	Applus Coated + Weldon Flat	Tool Description
3/4	3/4	.125	7/8	3	4	43634		HSV-S-40750-R.125
	3/4	.125	1-1/4	4	4	43640		HSV-SR-40750-R.125
	3/4	.125	1-5/8	4	4	43664		HSV-R-40750-R.125
	3/4	.125	2-1/4	5	4	43679		HSV-M-40750-R.125
	3/4	.125	2-1/4	6	4	43694		HSV-L-40750-R.125
	3/4	.190	7/8	3	4	43625		HSV-S-40750-R.190
	3/4	.190	1-1/4	4	4	43650		HSV-SR-40750-R.190
	3/4	.190	1-5/8	4	4	43665		HSV-R-40750-R.190
	3/4	.190	2-1/4	5	4	43680		HSV-M-40750-R.190
	3/4	.190	2-1/4	6	4	43695		HSV-L-40750-R.190
	3/4	.250	7/8	3	4	43636		HSV-S-40750-R.250
	3/4	.250	1-1/4	4	4	43651		HSV-SR-40750-R.250
	3/4	.250	1-5/8	4	4	43666		HSV-R-40750-R.250
	3/4	.250	2-1/4	5	4	43681		HSV-M-40750-R.250
	3/4	.250	2-1/4	6	4	43696		HSV-L-40750-R.250
1	1	.000	1-1/2	4	4	31707		HSV-M-41000-R.000
	1	.000	2	4-1/2	4	31722	31722W	HSV-M-41000-R.000
	1	.000	2-5/8	5	4	31737		HSV-L-41000-R.000
	1	.000	3	6	4	31742		HSV-S-41000-R.000
	1	.000	4-1/4	7	4	31752		HSV-R-41000-R.000
	1	.000	5-1/4	8	4	82302		HSV-M-41000-R.000
	1	.060	1-1/2	4	4	43707		HSV-M-41000-R.060
	1	.060	2	4-1/2	4	43722	43722W	HSV-L-41000-R.060
	1	.060	2-5/8	5	4	43737		HSV-M-41000-R.060
	1	.060	3	6	4	43742		HSV-M-41000-R.060
	1	.060	4-1/4	7	4	43752		HSV-L-41000-R.060
	1	.000	1-1/2	4	4	43708		HSV-S-41000-R.000
	1	.000	2	4-1/2	4	43723		HSV-R-41000-R.000
	1	.000	2-5/8	5	4	43738		HSV-M-41000-R.000
	1	.000	3	6	4	43743		HSV-M-41000-R.000
	1	.000	4-1/4	7	4	43753		HSV-L-41000-R.000
	1	.125	1-1/2	4	4	43709		HSV-S-41000-R.125
	1	.125	2	4-1/2	4	43724		HSV-R-41000-R.125
	1	.125	2-5/8	5	4	43739		HSV-M-41000-R.125
	1	.125	3	6	4	43744		HSV-M-41000-R.125
	1	.125	4-1/4	7	4	43754		HSV-L-41000-R.125
	1	.190	1-1/2	4	4	43710		HSV-S-41000-R.190
	1	.190	2	4-1/2	4	43725		HSV-R-41000-R.190
	1	.190	2-5/8	5	4	43740		HSV-M-41000-R.190
	1	.190	3	6	4	43745		HSV-M-41000-R.190
	1	.190	4-1/4	7	4	43755		HSV-L-41000-R.190
	1	.250	1-1/2	4	4	43711		HSV-S-41000-R.250
	1	.250	2	4-1/2	4	43726		HSV-R-41000-R.250
	1	.250	2-5/8	5	4	43741		HSV-M-41000-R.250
	1	.250	3	6	4	43746		HSV-M-41000-R.250
	1	.250	4-1/4	7	4	43756		HSV-L-41000-R.250

*.0005 max. TIR

4 FLUTE - CORNER RADIUS - METRIC

Variable Pitch

MHSV-4
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 +0.0 mm -0.05 mm	Shank Diameter D2 Ø	Corner Radius R +0.0 mm -0.05 mm	Length of Cut L2 +0.0 mm -0.05 mm	Overall Length L1 +1.00 mm -1.00 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	8.00 mm	63 mm	4	59450	MHSV-015-40600-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	4	59477	MHSV-020-40600-R0.50
	6.00 mm	.50 mm	16.00 mm	63 mm	4	59511	MHSV-030-40600-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	4	59460	MHSV-015-40800-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	4	59478	MHSV-020-40800-R1.00
	6.00 mm	1.00 mm	16.00 mm	63 mm	4	59512	MHSV-030-40800-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	4	59462	MHSV-015-40900-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	4	59480	MHSV-020-40900-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	4	59514	MHSV-030-40900-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	4	59463	MHSV-015-40800-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	4	59481	MHSV-020-40800-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	4	59515	MHSV-030-40800-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	4	59465	MHSV-015-41000-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	4	59483	MHSV-020-41000-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	4	59497	MHSV-025-41000-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	4	59466	MHSV-015-41000-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	4	59484	MHSV-020-41000-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	4	59498	MHSV-025-41000-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	4	59468	MHSV-015-41200-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	4	59486	MHSV-020-41200-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	4	59500	MHSV-025-41200-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	4	59469	MHSV-015-41200-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	4	59487	MHSV-020-41200-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	4	59501	MHSV-025-41200-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	4	59471	MHSV-015-41600-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	4	59489	MHSV-020-41600-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	4	59503	MHSV-025-41600-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	4	59472	MHSV-015-41800-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	4	59490	MHSV-020-41800-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	4	59504	MHSV-025-41800-R1.00
20 mm	20.00 mm	.50 mm	30.00 mm	89 mm	4	59474	MHSV-015-42000-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	4	59492	MHSV-020-42000-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	4	59506	MHSV-025-42000-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	4	59475	MHSV-015-42000-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	4	59493	MHSV-020-42000-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	4	59507	MHSV-025-42000-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	4	59495	MHSV-020-42500-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	4	59509	MHSV-025-42500-R1.00

* .013 mm max TIR



Speeds & Feeds on Page 132

HSV-RN-4

New Items!

4 FLUTE - SQUARE

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 207 for Tplus coating



Cutter Dia.* D1 $\pm .002$	Shank Diameter D2 (h6)	Length of Cut L2 $\pm .002$	Overall Length L1 $\pm .002$	Reach (LBS) L3	Neck Diameter	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	3	3/8	.118	4	52017	HSV-RN-S-40125
	1/8	5/32	3	1/2	.118	4	52032	HSV-RN-R-40125
	1/8	5/32	3	5/8	.118	4	52047	HSV-RN-M-40125
	1/8	5/32	3	3/4	.118	4	83496	HSV-RN-ML-40125
	1/8	5/32	3	1	.118	4	83497	HSV-RN-LX-40125
3/16	3/16	7/32	3	1-1/4	.118	4	80560	HSV-RN-X-40125
	3/16	7/32	3	1/2	.178	4	52062	HSV-RN-S-40187
	3/16	7/32	3	3/4	.178	4	52077	HSV-RN-R-40187
	3/16	7/32	3	1	.178	4	52092	HSV-RN-M-40187
	3/16	7/32	3	1-5/16	.178	4	83498	HSV-RN-ML-40187
1/4	3/16	7/32	3	1-1/2	.178	4	80561	HSV-RN-LX-40187
	1/4	3/8	4	3/4	.237	4	52107	HSV-RN-S-40250
	1/4	3/8	4	1-1/8	.237	4	52122	HSV-RN-R-40250
	1/4	3/8	4	1-5/8	.237	4	81680	HSV-RN-A-40250
	1/4	3/8	4	2-1/8	.237	4	52137	HSV-RN-M-40250
3/8	1/4	3/8	4	2-1/2	.237	4	83499	HSV-RN-ML-40250
	3/8	1/2	4	1-1/8	.356	4	52152	HSV-RN-S-40375
	3/8	1/2	4	1-5/8	.356	4	81681	HSV-RN-A-40375
	3/8	1/2	4	2-1/8	.356	4	52167	HSV-RN-R-40375
	3/8	1/2	6	2-1/2	.356	4	81682	HSV-RN-M-40375
1/2	3/8	1/2	6	3-1/8	.356	4	52182	HSV-RN-L-40375
	3/8	1/2	6	4-1/8	.356	4	52197	HSV-RN-ML-40375
	1/2	5/8	4	1-1/2	.475	4	52212	HSV-RN-S-40500
	1/2	5/8	4	1-3/4	.475	4	81683	HSV-RN-A-40500
	1/2	5/8	4	2-1/4	.475	4	52227	HSV-RN-R-40500
5/8	1/2	5/8	5	2-3/4	.475	4	81684	HSV-RN-M-40500
	1/2	5/8	6	3-3/8	.475	4	52242	HSV-RN-L-40500
	1/2	5/8	6	3-3/4	.475	4	83500	HSV-RN-ML-40500
	1/2	5/8	6	4-1/8	.475	4	52257	HSV-RN-X-40500
	1/2	5/8	7	5	.475	4	80562	HSV-RN-LX-40500
3/4	5/8	3/4	4	1-5/8	.593	4	52272	HSV-RN-S-40625
	5/8	3/4	6	2-3/8	.593	4	52287	HSV-RN-R-40625
	5/8	3/4	6	3-3/8	.593	4	52302	HSV-RN-M-40625
	5/8	3/4	6	4-1/8	.593	4	52317	HSV-RN-L-40625
	3/4	1	4	2	.712	4	52332	HSV-RN-S-40750
1	3/4	1	6	2-1/2	.712	4	52347	HSV-RN-R-40750
	3/4	1	6	3-3/8	.712	4	52362	HSV-RN-M-40750
	3/4	1	6	4-1/8	.712	4	52377	HSV-RN-L-40750
	3/4	1	7	4-3/4	.712	4	80563	HSV-RN-X-40750
	1	1-1/4	4	2-1/4	.960	4	52392	HSV-RN-S-41000
1	1	1-1/4	6	2-5/8	.960	4	52407	HSV-RN-R-41000
	1	1-1/4	6	3-3/8	.960	4	52422	HSV-RN-M-41000
	1	1-1/4	6	4-1/8	.960	4	52437	HSV-RN-L-41000
	1	1-1/4	6	4-1/8	.960	4	52452	HSV-RN-ML-41000

*.0005 max TIR



Speeds & Feeds on Page 132

4 FLUTE - BALL

HSV-RN-4

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 208 for Tplus coating



Cutter Dia.* D1 $\pm .0007$ -.0007	Shank Diameter D2 (H6)	Length of Cut L2 $\pm .002$ -.002	Overall Length L1 $\pm .002$ -.002	Reach (LBS) L3	Neck Diameter L4	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	3	3/8	11.8	4	57017	HSV-RN-S-40125-BN
	1/8	5/32	3	1/2	11.8	4	57032	HSV-RN-R-40125-BN
	1/8	5/32	3	5/8	11.8	4	57047	HSV-RN-M-40125-BN
	1/8	5/32	3	3/4	11.8	4	82515	HSV-RN-ML-40125-BN
	1/8	5/32	3	1	11.8	4	83512	HSV-RN-LX-40125-BN
3/16	3/16	7/32	3	1/2	17.8	4	57062	HSV-RN-S-40187-BN
	3/16	7/32	3	3/4	17.8	4	57077	HSV-RN-R-40187-BN
	3/16	7/32	3	1	17.8	4	57092	HSV-RN-M-40187-BN
	3/16	7/32	3	1-5/16	17.8	4	82516	HSV-RN-L-40187-BN
	3/16	7/32	3	1-1/2	17.8	4	83513	HSV-RN-LX-40187-BN
1/4	1/4	3/8	3	3/4	23.7	4	57107	HSV-RN-S-40250-BN
	1/4	3/8	4	1-1/8	23.7	4	57122	HSV-RN-R-40250-BN
	1/4	3/8	4	1-5/8	23.7	4	81694	HSV-RN-A-40250-BN
	1/4	3/8	4	2-1/8	23.7	4	57137	HSV-RN-M-40250-BN
	1/4	3/8	4	2-1/2	23.7	4	81695	HSV-RN-ML-40250-BN
	1/4	3/8	4-1/2	3	23.7	4	82517	HSV-RN-L-40250-BN
3/8	3/8	1/2	4	1-1/8	35.6	4	57152	HSV-RN-S-40375-BN
	3/8	1/2	4	1-5/8	35.6	4	81696	HSV-RN-SR-40375-BN
	3/8	1/2	4	2-1/8	35.6	4	57167	HSV-RN-R-40375-BN
	3/8	1/2	6	2-1/2	35.6	4	81697	HSV-RN-A-40375-BN
	3/8	1/2	6	3-1/8	35.6	4	57182	HSV-RN-M-40375-BN
	3/8	1/2	6	3-5/8	35.6	4	83514	HSV-RN-ML-40375-BN
	3/8	1/2	6	4-1/8	35.6	4	57197	HSV-RN-L-40375-BN
1/2	1/2	5/8	4	1-1/2	47.5	4	57212	HSV-RN-S-40500-BN
	1/2	5/8	4	1-3/4	47.5	4	81698	HSV-RN-SR-40500-BN
	1/2	5/8	4	2-1/4	47.5	4	57227	HSV-RN-R-40500-BN
	1/2	5/8	5	2-3/4	47.5	4	81699	HSV-RN-A-40500-BN
	1/2	5/8	6	3-3/8	47.5	4	57242	HSV-RN-M-40500-BN
	1/2	5/8	6	3-3/4	47.5	4	81700	HSV-RN-ML-40500-BN
	1/2	5/8	6	4-1/8	47.5	4	57257	HSV-RN-L-40500-BN
	1/2	5/8	7	5	47.5	4	83515	HSV-RN-LX-40500-BN

* .0005 max TPI

continued on next page



Speeds & Feeds on Page 132

HSV-RN-4

4 FLUTE - BALL

Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ $\pm .001$ -.002	Shank Diameter D ₂ (in)	Length of Cut L ₁ $\pm .001$ -.002	Overall Length L ₂ $\pm .001$ -.002	Reach (LBS) L ₃	Neck Diameter	Flutes	Aptus Coated	Tool Description
5/8	5/8	3/4	4	1-5/8	.393	4	57272	HSV-RN-S-40625-BN
	5/8	3/4	6	2-3/8	.393	4	57287	HSV-RN-R-40625-BN
	5/8	3/4	6	3-3/8	.393	4	57302	HSV-RN-M-40625-BN
	5/8	3/4	6	4-1/8	.393	4	57317	HSV-RN-L-40625-BN
3/4	3/4	1	4	2	.712	4	57332	HSV-RN-S-40750-BN
	3/4	1	6	2-1/2	.712	4	57347	HSV-RN-R-40750-BN
	3/4	1	6	3-3/8	.712	4	57362	HSV-RN-M-40750-BN
	3/4	1	6	3-3/4	.712	4	83516	HSV-RN-ML-40750-BN
	3/4	1	6	4-1/8	.712	4	57377	HSV-RN-L-40750-BN
1	1	1-1/4	4	2-1/4	.950	4	57392	HSV-RN-S-41000-BN
	1	1-1/4	6	3-5/8	.950	4	57407	HSV-RN-R-41000-BN
	1	1-1/4	6	3-3/8	.950	4	57422	HSV-RN-M-41000-BN
	1	1-1/4	6	4-1/8	.950	4	57437	HSV-RN-L-41000-BN

*.0005 max TIR

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Run Faster. Push Harder. and Machine Smarter.

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SKU: 50007
Coating: Aptus
Included Angle: 60°
Length of Cut: .095"
Tip Diameter: .050"

Tag us and share what you are working on @helicaltools

4 FLUTE - CORNER RADIUS

New Items!

HSV-RN-4

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 209 for Tplus coating



Cutter Dia. [*] D1 ± .002"	Shank Dia. D2 (H6)	Corner Radius R ± .002"	LOC L2 ± .002"	OAL L1 ± .002"	Reach (LBS) L3	Neck Dia. L4	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	5/32	3	3/8	.118	4	32017	HSV-RN-S-40125-R.010
	1/8	.010	5/32	3	1/2	.118	4	32032	HSV-RN-R-40125-R.010
	1/8	.010	5/32	3	5/8	.118	4	32047	HSV-RN-M-40125-R.010
	1/8	.010	5/32	3	3/4	.118	4	81685	HSV-RN-L-40125-R.010
	1/8	.010	5/32	3	1	.118	4	83501	HSV-RN-LX-40125-R.010
	1/8	.010	5/32	3	1-1/4	.118	4	88504	HSV-RN-X-40125-R.010
	1/8	.030	5/32	3	3/8	.118	4	53017	HSV-RN-R-40125-R.030
	1/8	.030	5/32	3	1/2	.118	4	53032	HSV-RN-M-40125-R.030
	1/8	.030	5/32	3	5/8	.118	4	53047	HSV-RN-L-40125-R.030
	1/8	.030	5/32	3	3/4	.118	4	83502	HSV-RN-X-40125-R.010
3/16	3/16	.010	7/32	3	1/2	.178	4	32062	HSV-RN-S-40187-R.010
	3/16	.010	7/32	3	3/4	.178	4	32077	HSV-RN-R-40187-R.010
	3/16	.010	7/32	3	1	.178	4	32092	HSV-RN-M-40187-R.010
	3/16	.010	7/32	3	1-5/16	.178	4	81686	HSV-RN-L-40187-R.010
	3/16	.010	7/32	3	1-1/2	.178	4	83503	HSV-RN-LX-40187-R.010
	3/16	.030	7/32	3	1/2	.178	4	53062	HSV-RN-S-40187-R.030
	3/16	.030	7/32	3	3/4	.178	4	53077	HSV-RN-R-40187-R.030
	3/16	.030	7/32	3	1	.178	4	53092	HSV-RN-M-40187-R.030
	3/16	.030	7/32	3	1-5/16	.178	4	83504	HSV-RN-L-40187-R.030
	3/16	.030	7/32	3	1-1/2	.178	4	88505	HSV-RN-X-40187-R.030
1/4	1/4	.020	1/8	3	3/4	.237	4	32107	HSV-RN-S-40250-R.020
	1/4	.020	1/8	4	1-1/8	.237	4	32122	HSV-RN-R-40250-R.020
	1/4	.020	1/8	4	1-5/8	.237	4	81687	HSV-RN-M-40250-R.020
	1/4	.020	1/8	4	2-1/8	.237	4	32137	HSV-RN-L-40250-R.020
	1/4	.020	1/8	4	2-1/2	.237	4	83505	HSV-RN-LX-40250-R.020
	1/4	.030	1/8	3	3/4	.237	4	53107	HSV-RN-S-40250-R.030
	1/4	.030	1/8	4	1-1/8	.237	4	53122	HSV-RN-R-40250-R.030
	1/4	.030	1/8	4	1-5/8	.237	4	83506	HSV-RN-M-40250-R.030
	1/4	.030	1/8	4	2-1/8	.237	4	53137	HSV-RN-L-40250-R.030
	1/4	.030	1/8	4	2-1/2	.237	4	83507	HSV-RN-LX-40250-R.030
	1/4	.060	1/8	3	3/4	.237	4	53108	HSV-RN-S-40250-R.060
	1/4	.060	1/8	4	1-1/8	.237	4	53123	HSV-RN-R-40250-R.060
	1/4	.060	1/8	4	1-5/8	.237	4	88506	HSV-RN-M-40250-R.060
	1/4	.060	1/8	4	2-1/8	.237	4	53138	HSV-RN-L-40250-R.060
	1/4	.060	1/8	4	2-1/2	.237	4	88507	HSV-RN-X-40250-R.060

* .0000 max TIP

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Speeds & Feeds on Page 132

HSV-RN-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D1 $\frac{+0.007}{-0.007}$	Shank Dia. D2 (in)	Corner Radius R $\frac{+0.007}{-0.007}$	LOC L2 $\frac{+0.007}{-0.007}$	OAL L1 $\frac{+0.007}{-0.007}$	Reach (LBS) L3	Neck Dia.	Flutes	Applus Coated	Tool Description
3/8	3/8	.020	1/2	4	1-1/8	.356	4	32152	HSV-RN-S-40375-R.020
	3/8	.020	1/2	4	1-5/8	.356	4	81688	HSV-RN-SR-40375-R.020
	3/8	.020	1/2	4	2-1/8	.356	4	32167	HSV-RN-R-40375-R.020
	3/8	.020	1/2	6	2-1/2	.356	4	81689	HSV-RN-A-40375-R.020
	3/8	.020	1/2	6	3-1/8	.356	4	32182	HSV-RN-M-40375-R.020
	3/8	.020	1/2	6	4-1/8	.356	4	32197	HSV-RN-L-40375-R.020
	3/8	.030	1/2	4	1-1/8	.356	4	53152	HSV-RN-S-40375-R.030
	3/8	.030	1/2	4	1-5/8	.356	4	88568	HSV-RN-SR-40375-R.030
	3/8	.030	1/2	4	2-1/8	.356	4	53167	HSV-RN-R-40375-R.030
	3/8	.030	1/2	6	2-1/2	.356	4	53182	HSV-RN-M-40375-R.030
	3/8	.030	1/2	6	3-1/8	.356	4	53197	HSV-RN-L-40375-R.030
	3/8	.060	1/2	4	1-1/8	.356	4	53153	HSV-RN-S-40375-R.060
	3/8	.060	1/2	4	1-5/8	.356	4	88569	HSV-RN-SR-40375-R.060
	3/8	.060	1/2	4	2-1/8	.356	4	53168	HSV-RN-R-40375-R.060
	3/8	.060	1/2	6	2-1/2	.356	4	53183	HSV-RN-M-40375-R.060
	3/8	.060	1/2	6	3-1/8	.356	4	53198	HSV-RN-L-40375-R.060
	3/8	.090	1/2	4	1-1/8	.356	4	53154	HSV-RN-S-40375-R.090
	3/8	.090	1/2	4	1-5/8	.356	4	88570	HSV-RN-SR-40375-R.090
	3/8	.090	1/2	4	2-1/8	.356	4	53169	HSV-RN-R-40375-R.090
	3/8	.090	1/2	6	2-1/2	.356	4	53184	HSV-RN-M-40375-R.090
	3/8	.090	1/2	6	3-1/8	.356	4	53199	HSV-RN-L-40375-R.090
1/2	1/2	.010	5/8	4	1-1/2	.475	4	83508	HSV-RN-S-40500-R.010
	1/2	.010	5/8	4	2-1/4	.475	4	83509	HSV-RN-R-40500-R.010
	1/2	.010	5/8	6	2-3/8	.475	4	83510	HSV-RN-M-40500-R.010
	1/2	.010	5/8	6	3-1/8	.475	4	83511	HSV-RN-L-40500-R.010
	1/2	.020	5/8	4	1-1/2	.475	4	53211	HSV-RN-S-40500-R.020
	1/2	.020	5/8	4	1-3/4	.475	4	88571	HSV-RN-SR-40500-R.020
	1/2	.020	5/8	4	2-1/4	.475	4	53226	HSV-RN-R-40500-R.020
	1/2	.020	5/8	6	2-3/8	.475	4	53241	HSV-RN-M-40500-R.020
	1/2	.020	5/8	6	3-1/4	.475	4	88572	HSV-RN-ML-40500-R.020
	1/2	.020	5/8	6	4-1/8	.475	4	53256	HSV-RN-L-40500-R.020
	1/2	.030	5/8	4	1-1/2	.475	4	32212	HSV-RN-S-40500-R.030
	1/2	.030	5/8	4	1-3/4	.475	4	81690	HSV-RN-SR-40500-R.030
	1/2	.030	5/8	4	2-1/4	.475	4	32227	HSV-RN-R-40500-R.030
	1/2	.030	5/8	6	2-3/4	.475	4	81691	HSV-RN-M-40500-R.030
	1/2	.030	5/8	6	3-3/8	.475	4	32242	HSV-RN-L-40500-R.030
	1/2	.030	5/8	6	3-3/4	.475	4	81692	HSV-RN-ML-40500-R.030
	1/2	.030	5/8	6	4-1/8	.475	4	32257	HSV-RN-L-40500-R.030
	1/2	.060	5/8	4	1-1/2	.475	4	53212	HSV-RN-S-40500-R.060
	1/2	.060	5/8	4	1-3/4	.475	4	88573	HSV-RN-SR-40500-R.060
	1/2	.060	5/8	4	2-1/4	.475	4	53227	HSV-RN-R-40500-R.060
	1/2	.060	5/8	6	2-3/8	.475	4	53242	HSV-RN-M-40500-R.060
	1/2	.060	5/8	6	3-3/4	.475	4	88574	HSV-RN-ML-40500-R.060
	1/2	.060	5/8	6	4-1/8	.475	4	53257	HSV-RN-L-40500-R.060
	1/2	.090	5/8	4	1-1/2	.475	4	53213	HSV-RN-S-40500-R.090
	1/2	.090	5/8	4	2-1/4	.475	4	53228	HSV-RN-R-40500-R.090
	1/2	.090	5/8	6	2-3/8	.475	4	53243	HSV-RN-M-40500-R.090
	1/2	.090	5/8	6	3-3/4	.475	4	53258	HSV-RN-L-40500-R.090
	1/2	.125	5/8	4	1-1/2	.475	4	53214	HSV-RN-S-40500-R.125
	1/2	.125	5/8	4	2-1/4	.475	4	53229	HSV-RN-R-40500-R.125
	1/2	.125	5/8	6	2-3/8	.475	4	53244	HSV-RN-M-40500-R.125
	1/2	.125	5/8	6	3-3/4	.475	4	53259	HSV-RN-L-40500-R.125

*.0005 max TIR

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4 FLUTE - CORNER RADIUS

New Items!

HSV-RN-4

Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D1 $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Dia. D2 (H9)	Corner Radius R $\begin{smallmatrix} +.001" \\ -.001" \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Reach (LBS) L3	Neck Dia.	Flutes	Applus Coated	Tool Description
5/8	5/8	.030	3/4	4	1-5/8	5/8	4	32272	HSV-RN-S-40625-R.030
	5/8	.030	3/4	6	2-3/8	5/8	4	32297	HSV-RN-R-40625-R.030
	5/8	.030	3/4	6	3-3/8	5/8	4	32302	HSV-RN-M-40625-R.030
	5/8	.030	3/4	6	4-1/8	5/8	4	32317	HSV-RN-L-40625-R.030
	5/8	.060	3/4	4	1-5/8	5/8	4	53272	HSV-RN-S-40625-R.060
	5/8	.060	3/4	6	2-3/8	5/8	4	53297	HSV-RN-R-40625-R.060
	5/8	.060	3/4	6	3-3/8	5/8	4	53302	HSV-RN-M-40625-R.060
	5/8	.060	3/4	6	4-1/8	5/8	4	53317	HSV-RN-L-40625-R.060
	5/8	.090	3/4	4	1-5/8	5/8	4	53273	HSV-RN-S-40625-R.090
	5/8	.090	3/4	6	2-3/8	5/8	4	53298	HSV-RN-R-40625-R.090
	5/8	.090	3/4	6	3-3/8	5/8	4	53303	HSV-RN-M-40625-R.090
	5/8	.090	3/4	6	4-1/8	5/8	4	53318	HSV-RN-L-40625-R.090
	5/8	.125	3/4	4	1-5/8	5/8	4	53274	HSV-RN-S-40625-R.125
	5/8	.125	3/4	6	2-3/8	5/8	4	53299	HSV-RN-R-40625-R.125
	5/8	.125	3/4	6	3-3/8	5/8	4	53304	HSV-RN-M-40625-R.125
	5/8	.125	3/4	6	4-1/8	5/8	4	53319	HSV-RN-L-40625-R.125
3/4	3/4	.030	1	4	2	7/12	4	32332	HSV-RN-S-40750-R.030
	3/4	.030	1	6	2-1/2	7/12	4	32347	HSV-RN-R-40750-R.030
	3/4	.030	1	6	2-7/8	7/12	4	81693	HSV-RN-A-40750-R.030
	3/4	.030	1	6	3-2/8	7/12	4	32362	HSV-RN-M-40750-R.030
	3/4	.030	1	6	4-1/8	7/12	4	32377	HSV-RN-L-40750-R.030
	3/4	.030	1	7	4-3/4	7/12	4	88575	HSV-RN-LX-40750-R.030
	3/4	.060	1	4	2	7/12	4	53332	HSV-RN-S-40750-R.060
	3/4	.060	1	6	2-1/2	7/12	4	53347	HSV-RN-R-40750-R.060
	3/4	.060	1	6	3-3/8	7/12	4	53362	HSV-RN-M-40750-R.060
	3/4	.060	1	6	4-1/8	7/12	4	53377	HSV-RN-L-40750-R.060
	3/4	.090	1	4	2	7/12	4	53333	HSV-RN-S-40750-R.090
	3/4	.090	1	6	2-1/2	7/12	4	53348	HSV-RN-R-40750-R.090
	3/4	.090	1	6	3-3/8	7/12	4	53363	HSV-RN-M-40750-R.090
	3/4	.090	1	6	4-1/8	7/12	4	53378	HSV-RN-L-40750-R.090
	3/4	.125	1	4	2	7/12	4	53334	HSV-RN-S-40750-R.125
	3/4	.125	1	6	2-1/2	7/12	4	53349	HSV-RN-R-40750-R.125
	3/4	.125	1	6	3-3/8	7/12	4	53364	HSV-RN-M-40750-R.125
	3/4	.125	1	6	4-1/8	7/12	4	53379	HSV-RN-L-40750-R.125
	3/4	.190	1	4	2	7/12	4	53335	HSV-RN-S-40750-R.190
	3/4	.190	1	6	2-1/2	7/12	4	53350	HSV-RN-R-40750-R.190
	3/4	.190	1	6	3-3/8	7/12	4	53365	HSV-RN-M-40750-R.190
	3/4	.190	1	6	4-1/8	7/12	4	53380	HSV-RN-L-40750-R.190
	3/4	.250	1	4	2	7/12	4	53336	HSV-RN-S-40750-R.250
	3/4	.250	1	6	2-1/2	7/12	4	53351	HSV-RN-R-40750-R.250
	3/4	.250	1	6	3-3/8	7/12	4	53366	HSV-RN-M-40750-R.250
	3/4	.250	1	6	4-1/8	7/12	4	53381	HSV-RN-L-40750-R.250

* .0005 max TIR

continued on next page

HSV-RN-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Dia. D2 (in)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	LDC L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Reach (LBS) L3	Neck Dia.	Flutes	Applus Coated	Tool Description
1	1	.030	1-1/4	4	2-1/4	.950	4	53382	HSV-RN-S-41000-R.030
	1	.030	1-1/4	6	2-5/8	.950	4	53407	HSV-RN-R-41000-R.030
	1	.030	1-1/4	6	3-3/8	.950	4	53422	HSV-RN-M-41000-R.030
	1	.030	1-1/4	6	4-1/8	.950	4	53437	HSV-RN-L-41000-R.030
	1	.060	1-1/4	4	2-1/4	.950	4	53392	HSV-RN-S-41000-R.060
	1	.060	1-1/4	6	2-5/8	.950	4	53407	HSV-RN-R-41000-R.060
	1	.060	1-1/4	6	3-3/8	.950	4	53422	HSV-RN-M-41000-R.060
	1	.060	1-1/4	6	4-1/8	.950	4	53437	HSV-RN-L-41000-R.060
	1	.090	1-1/4	4	2-1/4	.950	4	53393	HSV-RN-S-41000-R.090
	1	.090	1-1/4	6	2-5/8	.950	4	53408	HSV-RN-R-41000-R.090
	1	.090	1-1/4	6	3-3/8	.950	4	53423	HSV-RN-M-41000-R.090
	1	.090	1-1/4	6	4-1/8	.950	4	53438	HSV-RN-L-41000-R.090
	1	.125	1-1/4	4	2-1/4	.950	4	53394	HSV-RN-S-41000-R.125
	1	.125	1-1/4	6	2-5/8	.950	4	53409	HSV-RN-R-41000-R.125
	1	.125	1-1/4	6	3-3/8	.950	4	53424	HSV-RN-M-41000-R.125
	1	.125	1-1/4	6	4-1/8	.950	4	53439	HSV-RN-L-41000-R.125
	1	.190	1-1/4	4	2-1/4	.950	4	53395	HSV-RN-S-41000-R.190
	1	.190	1-1/4	6	2-5/8	.950	4	53410	HSV-RN-R-41000-R.190
	1	.190	1-1/4	6	3-3/8	.950	4	53425	HSV-RN-M-41000-R.190
	1	.190	1-1/4	6	4-1/8	.950	4	53440	HSV-RN-L-41000-R.190
	1	.250	1-1/4	4	2-1/4	.950	4	53396	HSV-RN-S-41000-R.250
	1	.250	1-1/4	6	2-5/8	.950	4	53411	HSV-RN-R-41000-R.250
	1	.250	1-1/4	6	3-3/8	.950	4	53426	HSV-RN-M-41000-R.250
	1	.250	1-1/4	6	4-1/8	.950	4	53441	HSV-RN-L-41000-R.250

*.0005 max TR

SPEEDS & FEEDS

4 Flute - Variable Pitch

HSV-4

HSV-4 / HSV-RN-4

Material Guide		Hardness	SPM	Inches per Tooth (IPT)																								
				1/16			1/8			3/16			1/4			3/8			1/2			3/4			1			
				Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	Start	Rpt	Fin	
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A37, ASTM A36	< 75 HRS 75 - 88 HRS 21 - 38 HRC	455 415 400	0004 0003 0002	0006 0005 0003	0008 0007 0006	0007 0005 0003	0012 0009 0006	0016 0014 0011	0010 0008 0005	0018 0013 0009	0019 0014 0010	0014 0010 0006	0024 0018 0012	0021 0015 0010	0020 0014 0009	0036 0028 0020	0034 0024 0017	0027 0019 0013	0047 0030 0022	0026 0018 0013	0038 0029 0022	0067 0049 0032	0034 0023 0017	0049 0036 0023	0060 0043 0028	0041 0028 0019	
	LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC > 50 HRC	390 340 300 255	0003 0002 0002 0001	0004 0003 0003 0002	0007 0006 0006 0005	0005 0003 0003 0002	0008 0006 0006 0004	0010 0008 0008 0006	0013 0009 0009 0005	0007 0005 0005 0003	0011 0007 0007 0005	0015 0010 0010 0006	0009 0006 0006 0004	0015 0010 0010 0007	0017 0012 0012 0009	0019 0014 0014 0010	0017 0011 0011 0008	0030 0022 0022 0016	0023 0017 0017 0013	0030 0020 0020 0015	0023 0018 0018 0014	0034 0024 0024 0019	0027 0019 0019 0015	0031 0022 0022 0018	0054 0040 0030 0019	0033 0024 0024 0016
		TOOL STEEL	A2, H13, L6, P20, S7	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC > 50 HRC	340 290 140 85	0003 0002 0002 0001	0004 0003 0003 0002	0007 0006 0006 0005	0005 0004 0004 0002	0008 0006 0006 0004	0010 0008 0008 0006	0013 0009 0009 0005	0007 0005 0005 0003	0011 0007 0007 0005	0015 0010 0010 0006	0009 0006 0006 0004	0015 0010 0010 0007	0017 0012 0012 0009	0019 0014 0014 0010	0017 0011 0011 0008	0030 0022 0022 0016	0023 0017 0017 0013	0030 0020 0020 0015	0023 0018 0018 0014	0034 0024 0024 0019	0027 0019 0019 0015	0031 0022 0022 0018	0054 0040 0030 0019
SPECIALTY STEEL			300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	< 75 HRS 75 - 88 HRS 21 - 38 HRC 36 - 50 HRC > 50 HRC	290 250 170 150 95	0003 0002 0002 0002 0001	0005 0004 0004 0003 0002	0008 0006 0006 0005 0002	0006 0004 0004 0003 0002	0010 0008 0008 0006 0004	0015 0012 0012 0009 0006	0009 0005 0005 0003 0002	0015 0010 0010 0007 0005	0017 0013 0013 0009 0006	0011 0007 0007 0005 0004	0020 0014 0014 0010 0007	0019 0013 0013 0009 0006	0017 0012 0012 0008 0005	0036 0028 0028 0020 0015	0032 0022 0022 0016 0012	0022 0016 0016 0012 0009	0039 0026 0026 0019 0015	0036 0025 0025 0018 0014	0032 0022 0022 0016 0012	0056 0039 0039 0031 0019	0031 0021 0021 0016 0012	0040 0028 0028 0020 0014	0071 0049 0049 0039 0023
	AUSTENITIC STAINLESS STEEL		Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Inconel 27-TMO, 316, 316L, 321, 347	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC	265 225 160	0002 0002 0002	0004 0004 0003	0007 0006 0006	0004 0004 0003	0008 0007 0006	0010 0008 0008	0013 0009 0009	0011 0007 0007	0015 0010 0010	0009 0006 0006	0015 0010 0010	0017 0012 0012	0019 0014 0014	0017 0012 0012	0029 0020 0020	0022 0016 0016	0024 0018 0018	0032 0022 0022	0026 0019 0019	0042 0030 0030	0038 0025 0025	0030 0019 0019	0063 0040 0040
		MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 88 HRS 21 - 38 HRC	300 280	0003 0002	0004 0003	0007 0006	0005 0004	0008 0007	0010 0008	0013 0009	0011 0007	0015 0010	0009 0006	0015 0010	0017 0012	0019 0014	0017 0012	0030 0020	0023 0016	0024 0018	0034 0022	0027 0019	0031 0021	0055 0036	0033 0023	0043 0027
PH STAINLESS STEEL			15-5, 17-4, Carpenter 450, Carpenter 465	21 - 38 HRC 36 - 50 HRC	200 145	0002 0002	0003 0003	0006 0006	0003 0003	0006 0005	0008 0006	0011 0007	0005 0003	0009 0007	0012 0008	0011 0006	0014 0010	0010 0006	0017 0012	0019 0014	0016 0011	0032 0020	0022 0016	0023 0018	0031 0021	0023 0016	0023 0016	0040 0026
	GRAY CAST IRON		SAE J431, ASTM A48	75 - 88 HRS 21 - 38 HRC	410 370	0004 0002	0007 0004	0009 0008	0007 0004	0015 0007	0017 0012	0011 0006	0018 0013	0019 0014	0014 0009	0025 0015	0021 0016	0021 0016	0037 0026	0035 0026	0027 0019	0048 0030	0039 0029	0036 0026	0069 0049	0034 0025	0050 0037	0068 0048
		MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A802	75 - 88 HRS 21 - 38 HRC	340 335	0003 0002	0004 0004	0007 0006	0005 0004	0008 0007	0010 0008	0013 0009	0011 0007	0015 0010	0009 0006	0015 0010	0017 0012	0019 0014	0017 0012	0030 0020	0023 0016	0024 0018	0034 0022	0027 0019	0031 0021	0054 0036	0033 0023	0043 0027
MODULAR (DUCTILE) CAST IRON			ASTM A336, ASTM 907	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC	310 260 195	0003 0002 0001	0005 0003 0002	0008 0006 0005	0006 0004 0004	0010 0008 0008	0013 0009 0009	0011 0007 0007	0015 0010 0010	0009 0006 0006	0015 0010 0010	0017 0012 0012	0019 0014 0014	0017 0012 0012	0030 0020 0020	0023 0016 0016	0024 0018 0018	0034 0022 0022	0027 0019 0019	0031 0021 0021	0054 0036 0036	0033 0023 0023	0043 0027 0027	0035 0023 0023
	PURE NICKEL		Nickel 200, Nickel 201	< 75 HRS 75 - 88 HRS	280 260	0003 0002	0005 0003	0008 0007	0006 0004	0010 0008	0013 0009	0011 0007	0015 0010	0009 0006	0015 0010	0017 0012	0019 0014	0017 0012	0030 0020	0023 0016	0024 0018	0034 0022	0027 0019	0031 0021	0054 0036	0033 0023	0043 0027	0035 0023
		NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Inconel 20	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC	300 275 210	0003 0002 0002	0005 0003 0003	0008 0006 0006	0006 0004 0004	0010 0008 0008	0013 0009 0009	0011 0007 0007	0015 0010 0010	0009 0006 0006	0015 0010 0010	0017 0012 0012	0019 0014 0014	0017 0012 0012	0030 0020 0020	0023 0016 0016	0024 0018 0018	0034 0022 0022	0027 0019 0019	0031 0021 0021	0054 0036 0036	0033 0023 0023	0043 0027 0027	0035 0023 0023
PURE TITANIUM			Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRS 75 - 88 HRS 21 - 38 HRC	300 275 250	0004 0004 0003	0006 0005 0005	0009 0007 0007	0008 0007 0006	0015 0012 0012	0018 0010 0010	0022 0018 0018	0020 0014 0014	0017 0010 0010	0029 0014 0014	0023 0016 0016	0023 0016 0016	0043 0022 0022	0037 0020 0020	0032 0016 0016	0047 0028 0028	0034 0023 0023	0047 0028 0028	0031 0023 0023	0046 0030 0030	0037 0024 0024	0059 0040 0040	0103 0067 0067
	TITANIUM ALLOY		Ti 3Al-2.5V, Ti 6Al-4V, Ti 12V-2Fe-3Al	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC	300 275 160	0002 0002 0002	0004 0004 0004	0007 0006 0006	0006 0004 0004	0010 0008 0008	0013 0009 0009	0011 0007 0007	0015 0010 0010	0009 0006 0006	0015 0010 0010	0017 0012 0012	0019 0014 0014	0017 0012 0012	0030 0020 0020	0023 0016 0016	0024 0018 0018	0034 0022 0022	0027 0019 0019	0031 0021 0021	0054 0036 0036	0033 0023 0023	0043 0027 0027	0035 0023 0023
		COBALT ALLOY	ASTM F902, ASTM F903, ASTM F75, ASTM F799	75 - 88 HRS 21 - 38 HRC 36 - 50 HRC	210 170 85	0002 0002 0001	0003 0003 0002	0006 0006 0005	0004 0004 0002	0008 0007 0006	0010 0008 0008	0013 0009 0009	0011 0007 0007	0015 0010 0010	0009 0006 0006	0015 0010 0010	0017 0012 0012	0019 0014 0014	0017 0012 0012	0030 0020 0020	0023 0016 0016	0024 0018 0018	0034 0022 0022	0027 0019 0019	0031 0021 0021	0054 0036 0036	0033 0023 0023	0043 0027 0027

HEV-5



New Items!

5 FLUTE - SQUARE
Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates

- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 212 for Tplus coating



Cutter Diameter* D1 $\pm \frac{0.001}{-0.002}$	Shank Diameter D2 h6	Length of Cut L2 $\pm \frac{0.02}{-0.03}$	Overall Length L1 $\pm \frac{0.02}{-0.03}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/8	1/8	1/4	1-1/2	5	44017		HEV-S-50125
	1/8	3/8	2	5	81701		HEV-SR-50125
	1/8	1/2	2-1/2	5	44032		HEV-R-50125
	1/8	5/8	2-1/2	5	81702		HEV-A-50125
	1/8	3/4	2-1/2	5	44047		HEV-M-50125
	1/8	7/8	2-1/2	5	82518		HEV-L-50125
	1/8	1	2-1/2	5	84626		HEV-LX-50125
5/32	3/16	3/16	2	5	81703		HEV-S-50156
	3/16	5/16	2	5	84627		HEV-SR-50156
	3/16	7/16	2-1/2	5	81704		HEV-R-50156
	3/16	9/16	2-1/2	5	81705		HEV-M-50156
	3/16	3/4	2-1/2	5	84628		HEV-ML-50156
	3/16	1	3	5	86242		HEV-L-50156
3/16	3/16	5/16	2	5	44062		HEV-S-50187
	3/16	7/16	2	5	81706		HEV-SR-50187
	3/16	9/16	2-1/2	5	44077		HEV-R-50187
	3/16	3/4	2-1/2	5	44082		HEV-M-50187
	3/16	1	2-1/2	5	81707		HEV-ML-50187
	3/16	1-3/16	3	5	82519		HEV-L-50187
	3/16	1-3/8	3	5	84629		HEV-LX-50187
7/32	1/4	5/16	2	5	81708		HEV-S-50218
	1/4	7/16	2-1/2	5	81709		HEV-R-50218
	1/4	5/8	2-1/2	5	84630		HEV-M-50218
1/4	1/4	3/8	2	5	44107	44107W	HEV-S-50250
	1/4	3/8	4	5	82941		HEV-S-50250
	1/4	1/2	2-1/2	5	44122	44122W	HEV-SR-50250
	1/4	3/4	2-1/2	5	44137	44137W	HEV-R-50250
	1/4	3/4	4	5	82942		HEV-R-50250
	1/4	1	3	5	44152	44152W	HEV-M-50250
	1/4	1-1/4	3	5	44157	44157W	HEV-L-50250
	1/4	1-1/2	3	5	81710		HEV-LX-50250

* .0005 max TIP

continued on next page



Speeds & Feeds on Page 151

5 FLUTE - SQUARE

New Items!



HEV-5

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ $\frac{+0.007}{-0.002}$	Shank Diameter D ₂ (in)	Length of Cut L ₂ $\frac{+0.007}{-0.007}$	Overall Length L ₁ $\frac{+0.002}{-0.002}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
9/32	5/16	3/4	2-1/2	5	81711		HEV-R-50381
	5/16	1	3	5	81712		HEV-M-50381
5/16	5/16	7/16	2	5	44167	44167W	HEV-S-50312
	5/16	5/8	2-1/2	5	84631		HEV-SR-50312
	5/16	11/16	2-1/2	5	44182	44182W	HEV-R-50312
	5/16	1	3	5	44197	44197W	HEV-M-50312
	5/16	1-1/4	3	5	81713		HEV-L-50312
	5/16	1-9/16	4	5	82520		HEV-LX-50312
	5/16	2-1/8	4	5	83243		HEV-X-50312
							new
3/8	3/8	1/2	2	5	44212	44212W	HEV-S-50375
	3/8	1/2	4	5	82943		HEV-S-50375
	3/8	3/4	2-1/2	5	81714	81714W	HEV-SR-50375
	3/8	1	3	5	44227	44227W	HEV-R-50375
	3/8	1	6	5	82944		HEV-R-50375
	3/8	1-1/4	3	5	44242	44242W	HEV-M-50375
	3/8	1-1/2	3-1/2	5	44247	44247W	HEV-L-50375
	3/8	2	4	5	82521		HEV-LX-50375
7/16	7/16	2-1/2	5	5	84632		HEV-X-50375
							new
	7/16	5/8	2-3/4	5	83244		HEV-S-50437
	7/16	7/8	2-3/4	5	83245		HEV-R-50437
1/2	7/16	1-1/8	3-1/2	5	83246		HEV-M-50437
							new
	1/2	5/8	2-1/2	5	44257	44257W	HEV-S-50500
	1/2	5/8	4	5	82945		HEV-S-50500
	1/2	1	3	5	44272	44272W	HEV-SR-50500
	1/2	1-1/4	3	5	44287	44287W	HEV-R-50500
	1/2	1-1/4	6	5	82946		HEV-R-50500
	1/2	1-5/8	4	5	44302	44302W	HEV-M-50500
	1/2	2	4	5	44307	44307W	HEV-L-50500
	1/2	2-1/2	5	5	81715	81715W	HEV-LX-50500
5/8	1/2	3-1/8	6	5	82522		HEV-X-50500
	1/2	3-5/8	6	5	82523		HEV-Y-50500
	5/8	3/4	3	5	44317	44317W	HEV-S-50625
	5/8	1-1/4	3-1/2	5	44322	44322W	HEV-SR-50625
	5/8	1-5/8	3-1/2	5	44332	44332W	HEV-R-50625
	5/8	2-1/8	4	5	44347	44347W	HEV-M-50625
	5/8	2-1/2	5	5	44352	44352W	HEV-L-50625
	5/8	3-1/4	6	5	82524		HEV-LX-50625

* .0005 max TIR

continued on next page

HEV-5



New Items!

5 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.000" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 ϕ (6)	Length of Cut L2 $\begin{smallmatrix} +.02" \\ -.00" \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.02" \\ -.02" \end{smallmatrix}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
3/4	3/4	1	3	5	44362	44362W	HEV-S-50750
	3/4	1	6	5	82947		HEV-S-50750
	3/4	1-1/4	4	5	81716		HEV-SR-50750
	3/4	1-5/8	4	5	44377	44377W	HEV-R-50750
	3/4	1-5/8	6	5	82948		HEV-R-50750
	3/4	2-1/4	5	5	44382	44382W	HEV-M-50750
	3/4	2-3/4	5	5	44387	44387W	HEV-L-50750
	3/4	3-1/4	6	5	44402	44402W	HEV-LX-50750
	3/4	4	6-1/2	5	81717		HEV-L-50750
1	1	1-1/4	4	5	44407		HEV-S-51000
	1	2	4-1/2	5	44422	44422W	HEV-R-51000
	1	2-5/8	5	5	44437	44437W	HEV-M-51000
	1	3-1/4	6	5	44442	44442W	HEV-L-51000
	1	4-1/4	7	5	44447	44447W	HEV-L-51000
	1	5-1/4	8	5	85247		HEV-F-51000
1-1/4	1-1/4	2	4-1/2	5	44467		HEV-R-51250
	1-1/4	2-5/8	5-1/2	5	44482		HEV-M-51250
	1-1/4	3-1/4	6	5	44497		HEV-L-51250
	1-1/4	4-1/2	7	5	44512		HEV-LX-51250

* .0005 max TIR

Speeds & Feeds 101

In The Loupe

Mastering the Basics

Every machinist should know the basics when it comes to speeds and feeds, or the cutting variables used in every milling operation, as proper running parameters are critical to the outcome of your part. In our "In the Loupe" post *Speeds and Feeds 101*, learn how to calculate speeds and feeds, determine your tool's efficiency via Material Removal Rate (MRR), and much more.

www.harveyperformance.com/in-the-loupe/speeds-and-feeds-101/


SCAN TO READ

5 FLUTE - SQUARE - METRIC

Variable Pitch


MHEV-5
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +0.00 \text{ mm} \\ -0.00 \text{ mm} \end{smallmatrix}$	Shank Diameter D2 (H8)	Length of Cut L2 $\begin{smallmatrix} +0.00 \text{ mm} \\ -0.00 \text{ mm} \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +1.0 \text{ mm} \\ -1.0 \text{ mm} \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	9.00 mm	63 mm	5	59516	MHEV-015-50600
	6.00 mm	12.00 mm	63 mm	5	59534	MHEV-020-50600
	6.00 mm	18.00 mm	63 mm	5	59568	MHEV-030-50600
8 mm	8.00 mm	12.00 mm	63 mm	5	59519	MHEV-015-50800
	8.00 mm	16.00 mm	63 mm	5	59537	MHEV-020-50800
	8.00 mm	24.00 mm	75 mm	5	59571	MHEV-030-50800
10 mm	10.00 mm	15.00 mm	63 mm	5	59522	MHEV-015-51000
	10.00 mm	20.00 mm	63 mm	5	59540	MHEV-020-51000
	10.00 mm	25.00 mm	75 mm	5	59554	MHEV-025-51000
12 mm	12.00 mm	18.00 mm	75 mm	5	59525	MHEV-015-51200
	12.00 mm	24.00 mm	75 mm	5	59543	MHEV-020-51200
	12.00 mm	30.00 mm	75 mm	5	59557	MHEV-025-51200
16 mm	16.00 mm	24.00 mm	89 mm	5	59528	MHEV-015-51600
	16.00 mm	32.00 mm	89 mm	5	59546	MHEV-020-51600
	16.00 mm	40.00 mm	89 mm	5	59560	MHEV-025-51600
20 mm	20.00 mm	30.00 mm	89 mm	5	59531	MHEV-015-52000
	20.00 mm	40.00 mm	100 mm	5	59549	MHEV-020-52000
	20.00 mm	50.00 mm	125 mm	5	59563	MHEV-025-52000
25 mm	25.00 mm	60.00 mm	125 mm	5	59552	MHEV-020-52500
	25.00 mm	64.00 mm	125 mm	5	59566	MHEV-025-52500

* D13 mm max. TIR



HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates

- Center cutting
- h/8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 214 for Tplus coating



Cutter Dia.* D1 $^{+0.007}_{-0.007}$	Shank Dia. D2 (in)	Corner Radius R $^{+0.001}_{-0.001}$	LOC L2 $^{+0.002}_{-0.002}$	OAL L1 $^{+0.002}_{-0.002}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	34017		HEV-S-50125-R.010
	1/8	.010	3/8	2	5	81718		HEV-SR-50125-R.010
	1/8	.010	1/2	2-1/2	5	34032		HEV-R-50125-R.010
	1/8	.010	5/8	2-1/2	5	81719		HEV-A-50125-R.010
	1/8	.010	3/4	2-1/2	5	34047		HEV-M-50125-R.010
	1/8	.010	7/8	2-1/2	5	84636		HEV-L-50125-R.010
	1/8	.015	1/4	1-1/2	5	81720		HEV-S-50125-R.015
	1/8	.015	3/8	2	5	82530		HEV-SR-50125-R.015
	1/8	.015	1/2	2-1/2	5	81721		HEV-R-50125-R.015
	1/8	.015	5/8	2-1/2	5	84637		HEV-A-50125-R.015
	1/8	.020	1/4	1-1/2	5	84638		HEV-S-50125-R.020
	1/8	.020	3/8	2	5	84639		HEV-SR-50125-R.020
	1/8	.020	1/2	2-1/2	5	84640		HEV-R-50125-R.020
	1/8	.030	1/4	1-1/2	5	45017		HEV-S-50125-R.030
	1/8	.030	3/8	2	5	82531		HEV-SR-50125-R.030
	1/8	.030	1/2	2-1/2	5	45032		HEV-R-50125-R.030
	1/8	.030	5/8	2-1/2	5	82532		HEV-A-50125-R.030
	1/8	.030	3/4	2-1/2	5	45047		HEV-M-50125-R.030
	1/8	.030	7/8	2-1/2	5	84641		HEV-L-50125-R.030
5/32	3/16	.010	3/16	2	5	81722		HEV-S-50156-R.010
	3/16	.010	5/16	2	5	84642		HEV-SR-50156-R.010
	3/16	.010	7/16	2-1/2	5	81723		HEV-R-50156-R.010
	3/16	.010	9/16	2-1/2	5	81724		HEV-M-50156-R.010
	3/16	.010	3/4	2-1/2	5	84643		HEV-L-50156-R.010
	3/16	.030	3/16	2	5	88259		HEV-S-50156-R.030
	3/16	.030	5/16	2	5	88260		HEV-SR-50156-R.030
	3/16	.030	7/16	2-1/2	5	88261		HEV-R-50156-R.030
	3/16	.030	9/16	2-1/2	5	88262		HEV-M-50156-R.030
3/16	3/16	.030	3/4	2-1/2	5	88263		HEV-L-50156-R.030
	3/16	.010	5/16	2	5	34062		HEV-S-50187-R.010
	3/16	.010	7/16	2	5	81725		HEV-SR-50187-R.010
	3/16	.010	9/16	2-1/2	5	34077		HEV-R-50187-R.010
	3/16	.010	3/4	2-1/2	5	34092		HEV-M-50187-R.010
	3/16	.010	1	2-1/2	5	81726		HEV-L-50187-R.010
	3/16	.010	1-3/16	3	5	84644		HEV-S-50187-R.010
	3/16	.015	5/16	2	5	81727		HEV-S-50187-R.015

*0.0005 max TIR

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Speeds & Feeds on Page 151

5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D ₁ $\pm \frac{.001}{.002}$	Shank Dia. D ₂ (in)	Corner Radius R $\pm \frac{.002}{.002}$	LOC L ₂ $\pm \frac{.002}{.002}$	OAL L ₁ $\pm \frac{.002}{.002}$	Flutes	Applus Coated	Applus Coated + Weldon Flat	Tool Description
3/16	3/16	.015	7/16	2	5	82523		HEV-SR-50187-R.015
	3/16	.015	9/16	2-1/2	5	81728		HEV-R-50187-R.015
	3/16	.015	3/4	2-1/2	5	82534		HEV-M-50187-R.015
	3/16	.015	1	2-1/2	5	82535		HEV-ML-50187-R.015
	3/16	.020	5/16	2	5	84645		HEV-S-50187-R.020
	3/16	.020	7/16	2	5	84646		HEV-SR-50187-R.020
	3/16	.020	9/16	2-1/2	5	84647		HEV-R-50187-R.020
	3/16	.030	5/16	2	5	45062		HEV-S-50187-R.030
	3/16	.030	7/16	2	5	81729		HEV-SR-50187-R.030
	3/16	.030	9/16	2-1/2	5	45077		HEV-R-50187-R.030
	3/16	.030	3/4	2-1/2	5	45092		HEV-M-50187-R.030
	3/16	.030	1	2-1/2	5	82536		HEV-ML-50187-R.030
7/32	1/4	.010	5/16	2	5	81730		HEV-S-50218-R.010
	1/4	.010	7/16	2-1/2	5	81731		HEV-R-50218-R.010
1/4	1/4	.010	3/8	2	5	81732		HEV-S-50250-R.010
	1/4	.010	1/2	2-1/2	5	81733		HEV-SR-50250-R.010
	1/4	.010	3/4	2-1/2	5	81734		HEV-R-50250-R.010
	1/4	.010	1	3	5	82537		HEV-M-50250-R.010
	1/4	.010	1-1/4	3	5	82538		HEV-L-50250-R.010
	1/4	.015	3/8	2	5	81735		HEV-S-50250-R.015
	1/4	.015	1/2	2-1/2	5	81736		HEV-SR-50250-R.015
	1/4	.015	3/4	2-1/2	5	81737		HEV-R-50250-R.015
	1/4	.015	1	3	5	82539		HEV-M-50250-R.015
	1/4	.015	1-1/4	3	5	82540		HEV-L-50250-R.015
	1/4	.020	3/8	2	5	34107	34107W	HEV-S-50250-R.020
	1/4	.020	3/8	4	5	82958		HEV-S-50250-R.020
	1/4	.020	1/2	2-1/2	5	34122	34122W	HEV-SR-50250-R.020
	1/4	.020	3/4	2-1/2	5	34137	34137W	HEV-R-50250-R.020
	1/4	.020	3/4	4	5	82959		HEV-R-50250-R.020
	1/4	.020	1	3	5	34152	34152W	HEV-M-50250-R.020
	1/4	.020	1-1/4	3	5	34157		HEV-L-50250-R.020
	1/4	.020	1-1/2	3	5	82541		HEV-LX-50250-R.020
	1/4	.030	3/8	2	5	45107	45107W	HEV-S-50250-R.030
	1/4	.030	1/2	2-1/2	5	45122	45122W	HEV-SR-50250-R.030
	1/4	.030	3/4	2-1/2	5	45137	45137W	HEV-R-50250-R.030
	1/4	.030	1	3	5	45152	45152W	HEV-M-50250-R.030
	1/4	.030	1-1/4	3	5	45157		HEV-L-50250-R.030
	1/4	.030	1-1/2	3	5	82542		HEV-LX-50250-R.030
	1/4	.040	3/8	2	5	88264		HEV-S-50250-R.040
	1/4	.040	1/2	2-1/2	5	88265		HEV-SR-50250-R.040
	1/4	.040	3/4	2-1/2	5	88266		HEV-R-50250-R.040
	1/4	.040	1	3	5	88267		HEV-M-50250-R.040
	1/4	.060	3/8	2	5	45108	45108W	HEV-S-50250-R.060
	1/4	.060	1/2	2-1/2	5	45123	45123W	HEV-SR-50250-R.060
	1/4	.060	3/4	2-1/2	5	45138	45138W	HEV-R-50250-R.060
	1/4	.060	1	3	5	45153	45153W	HEV-M-50250-R.060
	1/4	.060	1-1/4	3	5	45158		HEV-L-50250-R.060
	1/4	.060	1-1/2	3	5	82543		HEV-LX-50250-R.060

* .0005 max TIR

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new
new
new
new

HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

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Cutter Dia.* D1 $\begin{smallmatrix} +.001 \\ -.001 \end{smallmatrix}$	Shank Dia. D2 (in)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	L/C L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Applus Coated	Applus Coated + Weldon Flat	Tool Description
9/32	5/16	.020	7/16	2	5	81738		HEV-S-50281-R.020
	5/16	.020	3/4	2-1/2	5	81739		HEV-R-50281-R.020
	5/16	.020	1	3	5	81740		HEV-M-50281-R.020
new	5/16	.010	7/16	2	5	81741		HEV-S-50312-R.010
	5/16	.010	13/16	2-1/2	5	81742		HEV-R-50312-R.010
	5/16	.010	1	3	5	84649		HEV-M-50312-R.010
	5/16	.010	1-1/4	3	5	88258		HEV-L-50312-R.010
	5/16	.015	7/16	2	5	84650		HEV-S-50312-R.015
	5/16	.015	13/16	2-1/2	5	84651		HEV-R-50312-R.015
	5/16	.015	1	3	5	84652		HEV-M-50312-R.015
	5/16	.015	1-1/4	3	5	88259		HEV-L-50312-R.015
	5/16	.020	7/16	2	5	34187	34167W	HEV-S-50312-R.020
	5/16	.020	5/8	2-1/2	5	84653		HEV-SR-50312-R.020
	5/16	.020	13/16	2-1/2	5	34182	34182W	HEV-R-50312-R.020
	5/16	.020	1	3	5	34197	34197W	HEV-M-50312-R.020
	5/16	.020	1-1/4	3	5	81743		HEV-L-50312-R.020
	5/16	.020	1-9/16	4	5	82544		HEV-LX-50312-R.020
	5/16	.030	7/16	2	5	45167	45167W	HEV-S-50312-R.030
	5/16	.030	5/8	2-1/2	5	84654		HEV-SR-50312-R.030
	5/16	.030	13/16	2-1/2	5	45182	45182W	HEV-R-50312-R.030
	5/16	.030	1	3	5	45197	45197W	HEV-M-50312-R.030
new	5/16	.030	1-1/4	3	5	82545		HEV-L-50312-R.030
	5/16	.060	7/16	2	5	45188		HEV-S-50312-R.060
	5/16	.060	13/16	2-1/2	5	45183		HEV-R-50312-R.060
	5/16	.060	1	3	5	45198		HEV-M-50312-R.060
	5/16	.060	1-1/4	3	5	88270		HEV-L-50312-R.060
new	3/8	.010	1/2	2	5	81744		HEV-S-50375-R.010
	3/8	.010	3/4	2-1/2	5	82546		HEV-SR-50375-R.010
	3/8	.010	1	3	5	81745		HEV-R-50375-R.010
	3/8	.010	1-1/4	3	5	81746		HEV-M-50375-R.010
	3/8	.010	1-1/2	3-1/2	5	81747		HEV-L-50375-R.010
	3/8	.015	1/2	2	5	81748		HEV-S-50375-R.015
	3/8	.015	3/4	2-1/2	5	82547		HEV-SR-50375-R.015
	3/8	.015	1	3	5	81749		HEV-R-50375-R.015
	3/8	.015	1-1/4	3	5	82548		HEV-M-50375-R.015
	3/8	.015	1-1/2	3-1/2	5	88271		HEV-L-50375-R.015
	3/8	.020	1/2	2	5	34212	34212W	HEV-S-50375-R.020
	3/8	.020	1/2	4	5	82960		HEV-S-50375-R.020
	3/8	.020	3/4	2-1/2	5	81750		HEV-SR-50375-R.020
	3/8	.020	1	3	5	34227	34227W	HEV-R-50375-R.020
	3/8	.020	1	6	5	82961		HEV-R-50375-R.020
	3/8	.020	1-1/4	3	5	34242	34242W	HEV-M-50375-R.020
	3/8	.020	1-1/2	3-1/2	5	34247		HEV-L-50375-R.020
	3/8	.020	2	4	5	84655		HEV-LX-50375-R.020
	3/8	.030	1/2	2	5	45212	45212W	HEV-S-50375-R.030
	3/8	.030	3/4	2-1/2	5	81751		HEV-SR-50375-R.030
	3/8	.030	1	3	5	45227	45227W	HEV-R-50375-R.030
	3/8	.030	1-1/4	3	5	45242	45242W	HEV-M-50375-R.030
	3/8	.030	1-1/2	3-1/2	5	45247	45247W	HEV-L-50375-R.030
	3/8	.030	2	4	5	84656		HEV-LX-50375-R.030

*.0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

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Cutter Dia.* D1 $\pm .002$ "	Shank Dia. D2 H9	Corner Radius R $\pm .002$ "	LOC L2 $\pm .002$ "	OAL L1 $\pm .002$ "	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description	
3/8	3/8	.040	1/2	2	5	88272		HEV-S-50375-R.040	new
	3/8	.040	3/4	2-1/2	5	88273		HEV-SR-50375-R.040	new
	3/8	.040	1	3	5	88274		HEV-R-50375-R.040	new
	3/8	.040	1-1/4	3	5	88275		HEV-M-50375-R.040	new
	3/8	.060	1/2	2	5	45213	45213W	HEV-S-50375-R.060	
	3/8	.060	3/4	2-1/2	5	81752		HEV-SR-50375-R.060	
	3/8	.060	1	3	5	45228	45228W	HEV-R-50375-R.060	
	3/8	.060	1-1/4	3	5	45243	45243W	HEV-M-50375-R.060	
	3/8	.060	1-1/2	3-1/2	5	45248		HEV-L-50375-R.060	
	3/8	.060	2	4	5	84657		HEV-LX-50375-R.060	
	3/8	.090	1/2	2	5	45214		HEV-S-50375-R.090	
	3/8	.090	3/4	2-1/2	5	84658		HEV-SR-50375-R.090	
	3/8	.090	1	3	5	45229		HEV-R-50375-R.090	
	3/8	.090	1-1/4	3	5	45244		HEV-M-50375-R.090	
	3/8	.090	1-1/2	3-1/2	5	45249		HEV-L-50375-R.090	
	3/8	.120	1/2	2	5	88276		HEV-S-50375-R.120	new
	3/8	.120	3/4	2-1/2	5	88277		HEV-SR-50375-R.120	new
	3/8	.120	1	3	5	88278		HEV-R-50375-R.120	new
	3/8	.120	1-1/4	3	5	88279		HEV-M-50375-R.120	new
	3/8	.120	1-1/2	3-1/2	5	88280		HEV-L-50375-R.120	new
	3/8	.125	1/2	2	5	82548		HEV-S-50375-R.125	
	3/8	.125	3/4	2-1/2	5	84659		HEV-SR-50375-R.125	
	3/8	.125	1	3	5	82558		HEV-R-50375-R.125	
	3/8	.125	1-1/4	3	5	82551		HEV-M-50375-R.125	
	3/8	.125	1-1/2	3-1/2	5	84660		HEV-L-50375-R.125	
7/16	7/16	.010	5/8	2-3/4	5	88281		HEV-S-50437-R.010	new
	7/16	.010	7/8	2-3/4	5	88282		HEV-R-50437-R.010	new
	7/16	.010	1-1/8	3-1/2	5	88283		HEV-M-50437-R.010	new
	7/16	.030	5/8	2-3/4	5	88284		HEV-S-50437-R.030	new
	7/16	.030	7/8	2-3/4	5	88285		HEV-R-50437-R.030	new
	7/16	.030	1-1/8	3-1/2	5	88286		HEV-M-50437-R.030	new
	7/16	.060	5/8	2-3/4	5	88287		HEV-S-50437-R.060	new
	7/16	.060	7/8	2-3/4	5	88288		HEV-R-50437-R.060	new
1/2	1/2	.010	5/8	2-1/2	5	81753	81753W	HEV-S-50500-R.010	
	1/2	.010	1	3	5	81754	81754W	HEV-SR-50500-R.010	
	1/2	.010	1-1/4	3	5	81755	81755W	HEV-R-50500-R.010	
	1/2	.010	1-5/8	4	5	81756		HEV-M-50500-R.010	
	1/2	.010	2	4	5	81757		HEV-L-50500-R.010	
	1/2	.010	2-1/2	5	5	84661		HEV-LX-50500-R.010	
	1/2	.015	5/8	2-1/2	5	81758	81758W	HEV-S-50500-R.015	
	1/2	.015	1	3	5	81759	81759W	HEV-SR-50500-R.015	
	1/2	.015	1-1/4	3	5	81760	81760W	HEV-R-50500-R.015	
	1/2	.015	1-5/8	4	5	82552		HEV-M-50500-R.015	
	1/2	.015	2	4	5	82553		HEV-L-50500-R.015	
	1/2	.015	2-1/2	5	5	88290		HEV-LX-50500-R.015	new
	1/2	.020	5/8	2-1/2	5	81761	81761W	HEV-S-50500-R.020	
	1/2	.020	1	3	5	81762	81762W	HEV-SR-50500-R.020	
	1/2	.020	1-1/4	3	5	81763	81763W	HEV-R-50500-R.020	
	1/2	.020	1-5/8	4	5	82554		HEV-M-50500-R.020	
	1/2	.020	2	4	5	82555		HEV-L-50500-R.020	
	1/2	.020	2-1/2	5	5	88291		HEV-LX-50500-R.020	new

*.0005 max TIR

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HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

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Cutter Dia.* D1 $\pm .002$ -.002	Shank Dia. D2 $\pm .001$	Corner Radius R $\pm .002$ -.002	L/C L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/2	1/2	.030	5/8	2-1/2	5	34257	34257W	HEV-S-50500-R.030
	1/2	.030	5/8	4	5	82962		HEV-S-50500-R.030
	1/2	.030	1	3	5	34272	34272W	HEV-SR-50500-R.030
	1/2	.030	1-1/4	3	5	34287	34287W	HEV-R-50500-R.030
	1/2	.030	1-1/4	5	5	82963		HEV-R-50500-R.030
	1/2	.030	1-5/8	4	5	34302	34302W	HEV-M-50500-R.030
	1/2	.030	2	4	5	34307	34307W	HEV-L-50500-R.030
	1/2	.030	2-1/2	5	5	81764		HEV-LX-50500-R.030
	1/2	.030	3-1/8	5	5	82556		HEV-X-50500-R.030
	1/2	.030	3-5/8	5	5	82957		HEV-Y-50500-R.030
	1/2	.040	5/8	2-1/2	5	88292		HEV-S-50500-R.040
	1/2	.040	1	3	5	88293		HEV-SR-50500-R.040
	1/2	.040	1-1/4	3	5	88294		HEV-R-50500-R.040
	1/2	.040	1-5/8	4	5	88295		HEV-M-50500-R.040
	1/2	.040	2	4	5	88296		HEV-L-50500-R.040
	1/2	.060	5/8	2-1/2	5	45257	45257W	HEV-S-50500-R.060
	1/2	.060	5/8	4	5	82964		HEV-S-50500-R.060
	1/2	.060	1	3	5	45272	45272W	HEV-SR-50500-R.060
	1/2	.060	1-1/4	3	5	45287	45287W	HEV-R-50500-R.060
	1/2	.060	1-1/4	5	5	82965		HEV-R-50500-R.060
	1/2	.060	1-5/8	4	5	45302	45302W	HEV-M-50500-R.060
	1/2	.060	2	4	5	45307	45307W	HEV-L-50500-R.060
	1/2	.060	2-1/2	5	5	81765		HEV-LX-50500-R.060
	1/2	.090	5/8	2-1/2	5	45258	45258W	HEV-S-50500-R.090
	1/2	.090	1	3	5	45273	45273W	HEV-SR-50500-R.090
	1/2	.090	1-1/4	3	5	45288	45288W	HEV-R-50500-R.090
	1/2	.090	1-5/8	4	5	45303		HEV-M-50500-R.090
	1/2	.090	2	4	5	45308		HEV-L-50500-R.090
	1/2	.090	2-1/2	5	5	82558		HEV-LX-50500-R.090
	1/2	.120	5/8	2-1/2	5	45259	45259W	HEV-S-50500-R.120
	1/2	.120	1	3	5	45274	45274W	HEV-SR-50500-R.120
	1/2	.120	1-1/4	3	5	45289	45289W	HEV-R-50500-R.120
	1/2	.120	1-5/8	4	5	45304	45304W	HEV-M-50500-R.120
	1/2	.120	2	4	5	45309	45309W	HEV-L-50500-R.120
	1/2	.120	2-1/2	5	5	82559		HEV-LX-50500-R.120
	1/2	.125	5/8	2-1/2	5	81766		HEV-S-50500-R.125
	1/2	.125	1	3	5	81767		HEV-SR-50500-R.125
	1/2	.125	1-1/4	3	5	81768		HEV-R-50500-R.125
	1/2	.125	1-5/8	4	5	82560		HEV-M-50500-R.125
	1/2	.125	2	4	5	88297		HEV-L-50500-R.125
	1/2	.125	2-1/2	5	5	88298		HEV-LX-50500-R.125
5/8	5/8	.015	3/4	3	5	88299		HEV-S-50625-R.015
	5/8	.015	1-1/4	3-1/2	5	84002		HEV-SR-50625-R.015
	5/8	.015	1-5/8	3-1/2	5	84003		HEV-R-50625-R.015
	5/8	.015	2-1/8	4	5	84004		HEV-M-50625-R.015
	5/8	.015	2-1/2	5	5	88300		HEV-L-50625-R.015
	5/8	.030	3/4	3	5	34317		HEV-S-50625-R.030
	5/8	.030	1-1/4	3-1/2	5	34322	34322W	HEV-SR-50625-R.030

*.0005 max TIR

continued on next page

5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D1 $\pm \frac{.007}{.002}$	Shank Dia. D2 (in)	Corner Radius R $\pm \frac{.007}{.002}$	LOC L2 $\pm \frac{.007}{.002}$	OAL L1 $\pm \frac{.007}{.002}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
5/8	5/8	.030	1-5/8	3-1/2	5	34332	34332W	HEV-R-50625-R.030
	5/8	.030	2-1/8	4	5	34347	34347W	HEV-M-50625-R.030
	5/8	.030	2-1/2	5	5	34352		HEV-L-50625-R.030
	5/8	.030	3-1/4	6	5	32561		HEV-LX-50625-R.030
	5/8	.060	3/4	3	5	45317		HEV-S-50625-R.060
	5/8	.060	1-1/4	3-1/2	5	45322		HEV-SR-50625-R.060
	5/8	.060	1-5/8	3-1/2	5	45332		HEV-R-50625-R.060
	5/8	.060	2-1/8	4	5	45347		HEV-M-50625-R.060
	5/8	.060	2-1/2	5	5	45352		HEV-L-50625-R.060
	5/8	.090	3/4	3	5	45318		HEV-S-50625-R.090
	5/8	.090	1-1/4	3-1/2	5	45323		HEV-SR-50625-R.090
	5/8	.090	1-5/8	3-1/2	5	45333		HEV-R-50625-R.090
	5/8	.090	2-1/8	4	5	45348		HEV-M-50625-R.090
	5/8	.090	2-1/2	5	5	45353		HEV-L-50625-R.090
	5/8	.120	3/4	3	5	45319		HEV-S-50625-R.120
	5/8	.120	1-1/4	3-1/2	5	45324		HEV-SR-50625-R.120
	5/8	.120	1-5/8	3-1/2	5	45334		HEV-R-50625-R.120
	5/8	.120	2-1/8	4	5	45349		HEV-M-50625-R.120
	5/8	.120	2-1/2	5	5	45354		HEV-L-50625-R.120
	5/8	.120	3-1/4	6	5	32562		HEV-LX-50625-R.120
3/4	3/4	.010	1	3	5	31769		HEV-S-50750-R.010
	3/4	.010	1-5/8	4	5	31770		HEV-R-50750-R.010
	3/4	.010	2-1/4	5	5	31771		HEV-M-50750-R.010
	3/4	.010	2-3/4	5	5	38301		HEV-L-50750-R.010
	3/4	.015	1	3	5	31772		HEV-S-50750-R.015
	3/4	.015	1-5/8	4	5	31773		HEV-R-50750-R.015
	3/4	.015	2-1/4	5	5	31774		HEV-M-50750-R.015
	3/4	.015	2-3/4	5	5	38302		HEV-L-50750-R.015
	3/4	.020	1	3	5	31775		HEV-S-50750-R.020
	3/4	.020	1-5/8	4	5	31776		HEV-R-50750-R.020
	3/4	.020	2-1/4	5	5	31777		HEV-M-50750-R.020
	3/4	.020	2-3/4	5	5	38303		HEV-L-50750-R.020
	3/4	.030	1	3	5	34362	34362W	HEV-S-50750-R.030
	3/4	.030	1	6	5	32966		HEV-S-50750-R.030
	3/4	.030	1-1/4	4	5	31778	31778W	HEV-SR-50750-R.030
	3/4	.030	1-5/8	4	5	34377	34377W	HEV-R-50750-R.030
	3/4	.030	1-5/8	6	5	32967		HEV-R-50750-R.030
	3/4	.030	2-1/4	5	5	34392	34392W	HEV-M-50750-R.030
	3/4	.030	2-3/4	5	5	34397	34397W	HEV-L-50750-R.030
	3/4	.030	3-1/4	6	5	34402	34402W	HEV-LX-50750-R.030
	3/4	.030	4	6-1/2	5	32563		HEV-X-50750-R.030
	3/4	.060	1	3	5	45362	45362W	HEV-S-50750-R.060
	3/4	.060	1	6	5	32968		HEV-S-50750-R.060
	3/4	.060	1-1/4	4	5	31779		HEV-SR-50750-R.060
	3/4	.060	1-5/8	4	5	45377	45377W	HEV-R-50750-R.060
	3/4	.060	1-5/8	6	5	32969		HEV-R-50750-R.060
	3/4	.060	2-1/4	5	5	45392	45392W	HEV-M-50750-R.060
	3/4	.060	2-3/4	5	5	45397		HEV-L-50750-R.060
	3/4	.060	3-1/4	6	5	45402		HEV-LX-50750-R.060
	3/4	.060	4	6-1/2	5	32564		HEV-X-50750-R.060
	3/4	.090	1	3	5	45363		HEV-S-50750-R.090
	3/4	.090	1-1/4	4	5	34665		HEV-SR-50750-R.090
	3/4	.090	1-5/8	4	5	45378	45378W	HEV-R-50750-R.090

*.0005 max TIR

continued on next page

HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D1: $\frac{.007}{.002}$	Shank Dia. D2 (#6)	Corner Radius R: $\frac{.007}{.002}$	LOC L2: $\frac{.007}{.002}$	OAL L1: $\frac{.007}{.002}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
3/4	3/4	.090	2-1/4	5	5	45383		HEV-M-50750-R.090
	3/4	.090	2-3/4	5	5	45388		HEV-L-50750-R.090
	3/4	.090	3-1/4	6	6	45403		HEV-LX-50750-R.090
	3/4	.120	1	3	5	45364		HEV-S-50750-R.120
	3/4	.120	1-1/4	4	5	81780		HEV-SR-50750-R.120
	3/4	.120	1-5/8	4	5	45379	45379W	HEV-R-50750-R.120
	3/4	.120	2-1/4	5	5	45394	45394W	HEV-M-50750-R.120
	3/4	.120	2-3/4	5	5	45399		HEV-L-50750-R.120
	3/4	.120	3-1/4	6	6	45404		HEV-LX-50750-R.120
	3/4	.190	1	3	5	45365		HEV-S-50750-R.190
	3/4	.190	1-1/4	4	5	84666		HEV-SR-50750-R.190
	3/4	.190	1-5/8	4	5	45380	45380W	HEV-R-50750-R.190
	3/4	.190	2-1/4	5	5	45385		HEV-M-50750-R.190
	3/4	.190	2-3/4	5	5	45400		HEV-L-50750-R.190
	3/4	.190	3-1/4	6	6	45405		HEV-LX-50750-R.190
	3/4	.250	1	3	5	45366		HEV-S-50750-R.250
	3/4	.250	1-1/4	4	5	84667		HEV-SR-50750-R.250
	3/4	.250	1-5/8	4	5	45381	45381W	HEV-R-50750-R.250
	3/4	.250	2-1/4	5	5	45386		HEV-M-50750-R.250
	3/4	.250	2-3/4	5	5	45401	45401W	HEV-L-50750-R.250
	3/4	.250	3-1/4	6	6	45406		HEV-LX-50750-R.250
1	1	.030	1-1/4	4	5	34407	34407W	HEV-S-51000-R.030
	1	.030	2	4-1/2	5	34422	34422W	HEV-R-51000-R.030
	1	.030	2-5/8	5	5	34437	34437W	HEV-M-51000-R.030
	1	.030	3-1/4	6	6	34442	34442W	HEV-L-51000-R.030
	1	.030	4-1/4	7	6	34447	34447W	HEV-X-51000-R.030
	1	.030	5-1/4	9	5	84668		HEV-Y-51000-R.030
	1	.060	1-1/4	4	5	45407		HEV-S-51000-R.060
	1	.060	2	4-1/2	5	45422		HEV-R-51000-R.060
	1	.060	2-5/8	5	5	45437		HEV-M-51000-R.060
	1	.060	3-1/4	6	6	45442		HEV-L-51000-R.060
	1	.060	4-1/4	7	6	45447		HEV-X-51000-R.060
	1	.090	1-1/4	4	5	45408		HEV-S-51000-R.090
	1	.090	2	4-1/2	5	45423		HEV-R-51000-R.090
	1	.090	2-5/8	5	5	45438		HEV-M-51000-R.090
	1	.120	1-1/4	4	5	45409		HEV-S-51000-R.120
	1	.120	2	4-1/2	5	45424		HEV-R-51000-R.120
	1	.120	2-5/8	5	5	45439		HEV-M-51000-R.120
	1	.120	3-1/4	6	6	45444		HEV-L-51000-R.120
	1	.120	4-1/4	7	6	45449		HEV-X-51000-R.120
	1	.190	2	4-1/2	5	45425		HEV-R-51000-R.190
	1	.190	3-1/4	6	6	45445		HEV-L-51000-R.190
	1	.190	4-1/4	7	6	45450		HEV-X-51000-R.190
	1	.250	1-1/4	4	5	45411		HEV-S-51000-R.250
	1	.250	2	4-1/2	5	45426		HEV-R-51000-R.250
	1	.250	2-5/8	5	5	45441		HEV-M-51000-R.250
	1	.250	3-1/4	6	6	45446		HEV-L-51000-R.250
	1	.250	4-1/4	7	6	45451		HEV-X-51000-R.250
1-1/4	1-1/4	.060	2	4-1/2	5	34467		HEV-R-51250-R.060
	1-1/4	.060	2-5/8	5-1/2	5	34482		HEV-M-51250-R.060
	1-1/4	.060	3-1/4	6	5	34497		HEV-L-51250-R.060
	1-1/4	.060	4-1/2	7	5	34512		HEV-LX-51250-R.060

*.0005 max TIR

5 FLUTE - CORNER RADIUS - METRIC

Variable Pitch


MHEV-5
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 ±.01 mm	Shank Dia. D2 H6	Corner Radius R ±.01 mm	Length of Cut L2 ±.01 mm	Overall Length L1 ±.01 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	5	59517	MHEV-015-6060-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	5	59535	MHEV-020-6060-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	5	59569	MHEV-030-6060-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	5	59514	MHEV-015-6060-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	5	59536	MHEV-020-6060-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	5	59579	MHEV-030-6060-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	5	59529	MHEV-015-8080-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	5	59538	MHEV-020-8080-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	5	59572	MHEV-030-8080-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	5	59521	MHEV-015-8080-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	5	59539	MHEV-020-8080-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	5	59573	MHEV-030-8080-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	5	59523	MHEV-015-10100-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	5	59541	MHEV-020-10100-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	5	59565	MHEV-025-10100-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	5	59524	MHEV-015-10100-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	5	59542	MHEV-020-10100-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	5	59566	MHEV-025-10100-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	5	59526	MHEV-015-12120-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	5	59544	MHEV-020-12120-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	5	59568	MHEV-025-12120-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	5	59527	MHEV-015-12120-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	5	59545	MHEV-020-12120-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	5	59569	MHEV-025-12120-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	5	59529	MHEV-015-16160-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	5	59547	MHEV-020-16160-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	5	59561	MHEV-025-16160-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	5	59530	MHEV-015-16160-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	5	59548	MHEV-020-16160-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	5	59562	MHEV-025-16160-R1.00
	20.00 mm	.50 mm	30.00 mm	89 mm	5	59532	MHEV-015-20200-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	5	59559	MHEV-020-20200-R0.50
20 mm	20.00 mm	.50 mm	60.00 mm	125 mm	5	59564	MHEV-025-20200-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	5	59533	MHEV-015-20200-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	5	59561	MHEV-020-20200-R1.00
	20.00 mm	1.00 mm	60.00 mm	125 mm	5	59565	MHEV-025-20200-R1.00
25 mm	25.00 mm	1.00 mm	60.00 mm	125 mm	5	59563	MHEV-020-25250-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	5	59567	MHEV-025-25250-R1.00

* .013 mm Max TIR



Speeds & Feeds on Page 151

HEV-RN-5



5 FLUTE - SQUARE

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Longer lengths of cut available for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 220 for Tplus coating



Cutter Dia.* D1 $\frac{.001}{.002}$	Shank Dia. D2 (in)	Length of Cut L2 $\frac{.001}{.002}$	Overall Length L1 $\frac{.001}{.002}$	Reach (LBS) L3	Neck Diameter	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	2	3/8	.118	5	50017	HEV-RN-S-50125
	1/8	5/32	2	1/2	.118	5	50032	HEV-RN-R-50125
	1/8	5/32	2-1/2	3/4	.118	5	50047	HEV-RN-M-50125
	1/8	5/32	2-1/2	1	.118	5	81781	HEV-RN-L-50125
	1/8	5/32	2-1/2	1-1/4	.118	5	83014	HEV-RN-LX-50125
	1/8	5/32	3	1-1/2	.118	5	86372	HEV-RN-X-50125
3/16	3/16	7/32	2	1/2	.178	5	50062	HEV-RN-S-50187
	3/16	7/32	2-1/2	3/4	.178	5	50077	HEV-RN-M-50187
	3/16	7/32	2-1/2	1-1/8	.178	5	50092	HEV-RN-L-50187
	3/16	7/32	2-1/2	1-5/8	.178	5	83015	HEV-RN-LX-50187
	3/16	7/32	3	1-1/2	.178	5	86373	HEV-RN-X-50187
1/4	1/4	3/8	4	3/4	.237	5	50107	HEV-RN-S-50250
	1/4	3/8	4	1-1/8	.237	5	50122	HEV-RN-R-50250
	1/4	3/4	4	1-1/8	.237	5	83016	HEV-RN-R-50250
	1/4	3/8	4	1-5/8	.237	5	81782	HEV-RN-A-50250
	1/4	3/8	4	2-1/8	.237	5	50137	HEV-RN-M-50250
	1/4	3/4	4	2-1/8	.237	5	83017	HEV-RN-R-50250
	1/4	3/8	4	2-1/2	.237	5	81783	HEV-RN-ML-50250
	1/4	3/4	4	2-1/2	.237	5	87533	HEV-RN-ML-50250
	1/4	3/8	4-1/2	3	.237	5	83018	HEV-RN-L-50250
	1/4	3/4	4-1/2	3	.237	5	87534	HEV-RN-L-50250
5/16	5/16	7/16	4	1-1/8	.296	5	86374	HEV-RN-R-50312
	5/16	7/16	4	1-3/4	.296	5	86375	HEV-RN-M-50312
	5/16	7/16	4	2-1/8	.296	5	86376	HEV-RN-ML-50312

* .0005 max IR

continued on next page



5 FLUTE - SQUARE

Variable Pitch - Reduced Neck (cont.)



HEV-RN-5

continued from previous page

Cutter Dia.* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (in)	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.002}{.002}$	Reach (LBS) L3	Neck Diameter	Flutes	Aptus Coated	Tool Description
3/8	3/8	1/2	4	1-1/8	.356	5	50152	HEV-RN-S-50375
	3/8	1/2	4	1-5/8	.356	5	81784	HEV-RN-SR-50375
	3/8	1	4	1-5/8	.356	5	87535	HEV-RNR-SR-50375
	3/8	1/2	4	2-1/8	.356	5	50167	HEV-RN-R-50375
	3/8	1	4	2-1/8	.356	5	83019	HEV-RNR-R-50375
	3/8	1/2	6	2-1/2	.356	5	81785	HEV-RN-A-50375
	3/8	1	6	2-1/2	.356	5	87536	HEV-RNR-A-50375
	3/8	1/2	6	3-1/8	.356	5	50197	HEV-RN-M-50375
	3/8	1	6	3-1/8	.356	5	83020	HEV-RNR-M-50375
	3/8	1/2	6	3-5/8	.356	5	86377	HEV-RN-ML-50375
	3/8	1/2	6	4-1/8	.356	5	50212	HEV-RN-L-50375
	3/8	1	6	4-1/8	.356	5	87537	HEV-RNR-L-50375
1/2	1/2	5/8	4	1-1/2	.475	5	50227	HEV-RN-S-50590
	1/2	5/8	4	1-3/4	.475	5	81786	HEV-RN-SR-50590
	1/2	5/8	4	2-1/4	.475	5	50242	HEV-RN-R-50590
	1/2	1-1/4	4	2-1/4	.475	5	83021	HEV-RNR-R-50590
	1/2	5/8	5	2-3/4	.475	5	81787	HEV-RN-A-50590
	1/2	1-1/4	5	2-3/4	.475	5	86378	HEV-RNR-A-50590
	1/2	5/8	6	3-3/8	.475	5	50272	HEV-RN-M-50590
	1/2	1-1/4	6	3-3/8	.475	5	83022	HEV-RNR-M-50590
	1/2	5/8	6	4-1/8	.475	5	50287	HEV-RN-L-50590
	1/2	1-1/4	6	4-1/8	.475	5	83023	HEV-RNR-L-50590
5/8	5/8	3/4	4	1-5/8	.593	5	50302	HEV-RN-S-50625
	5/8	3/4	6	2-3/8	.593	5	50317	HEV-RN-R-50625
	5/8	3/4	6	3-3/8	.593	5	50332	HEV-RN-M-50625
	5/8	3/4	6	4-1/8	.593	5	50347	HEV-RN-L-50625
3/4	3/4	1	4	2	.712	5	50362	HEV-RN-S-50750
	3/4	1-5/8	4	2	.712	5	86379	HEV-RNR-S-50750
	3/4	1	6	2-1/2	.712	5	50377	HEV-RN-R-50750
	3/4	1-5/8	6	2-1/2	.712	5	83025	HEV-RNR-R-50750
	3/4	1	6	2-7/8	.712	5	81788	HEV-RN-A-50750
	3/4	1	6	3-3/8	.712	5	50392	HEV-RN-M-50750
	3/4	1-5/8	6	3-3/8	.712	5	83026	HEV-RNR-M-50750
	3/4	1	6	4-1/8	.712	5	50407	HEV-RN-L-50750
	3/4	1-5/8	6	4-1/8	.712	5	86380	HEV-RNR-L-50750
1	1	1-1/4	6	2-5/8	.950	5	50437	HEV-RN-R-51000
	1	1-1/4	6	3-3/8	.950	5	50452	HEV-RN-M-51000
	1	1-1/4	6	4-1/8	.950	5	50467	HEV-RN-L-51000

*.0005 max TIR

HEV-RN-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- Reduced neck provides maximum strength in long reach and deep pocketing applications

- Longer lengths of cut available for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 221 for Tplus coating



new

1/8

new

3/16

new

1/4

new

1/4

Cutter Dia.* D1 $\pm .001$ -.002	Shank Dia. D2 (H6)	Corner Radius R $\pm .001$ -.002	LOC L1 $\pm .001$ -.002	OAL L2 $\pm .001$ -.002	Resch (LBS) L3	Neck Dia. L4	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	5/32	2	3/8	.118	5	35017	HEV-RN-S-50125-R.010
	1/8	.010	5/32	2	1/2	.118	5	35032	HEV-RN-R-50125-R.010
	1/8	.010	5/32	2-1/2	3/4	.118	5	35047	HEV-RN-M-50125-R.010
	1/8	.010	5/32	2-1/2	1	.118	5	81789	HEV-RN-L-50125-R.010
	1/8	.010	5/32	2-1/2	1-1/4	.118	5	83027	HEV-RN-X-50125-R.010
	1/8	.010	5/32	3	1-1/2	.118	5	88576	HEV-RN-Y-50125-R.010
	1/8	.030	5/32	2	3/8	.118	5	51017	HEV-RN-S-50125-R.030
	1/8	.030	5/32	2	1/2	.118	5	51032	HEV-RN-R-50125-R.030
	1/8	.030	5/32	2-1/2	3/4	.118	5	51047	HEV-RN-M-50125-R.030
	1/8	.030	5/32	2-1/2	1	.118	5	83028	HEV-RN-L-50125-R.030
3/16	3/16	.010	7/32	2	1/2	.178	5	35062	HEV-RN-S-50187-R.010
	3/16	.010	7/32	2-1/2	3/4	.178	5	35077	HEV-RN-R-50187-R.010
	3/16	.010	7/32	2-1/2	1-1/8	.178	5	35092	HEV-RN-M-50187-R.010
	3/16	.010	7/32	2-1/2	1-5/16	.178	5	81790	HEV-RN-L-50187-R.010
	3/16	.010	7/32	3	1-1/2	.178	5	83029	HEV-RN-X-50187-R.010
	3/16	.010	7/32	4	1-7/8	.178	5	86383	HEV-RN-Y-50187-R.010
	3/16	.010	7/32	4	2-1/4	.178	5	88578	HEV-RN-Z-50187-R.010
	3/16	.030	7/32	2	1/2	.178	5	51062	HEV-RN-S-50187-R.030
	3/16	.030	7/32	2-1/2	3/4	.178	5	51077	HEV-RN-R-50187-R.030
	3/16	.030	7/32	2-1/2	1-1/8	.178	5	51092	HEV-RN-M-50187-R.030
1/4	1/4	.020	5/8	4	3/4	.237	5	35107	HEV-RN-S-50250-R.020
	1/4	.020	5/8	4	1-1/8	.237	5	35122	HEV-RN-R-50250-R.020
	1/4	.020	5/4	4	1-1/8	.237	5	83031	HEV-RN-M-50250-R.020
	1/4	.020	5/8	4	1-5/8	.237	5	81792	HEV-RN-L-50250-R.020
	1/4	.020	5/4	4	1-5/8	.237	5	86386	HEV-RN-Y-50250-R.020
	1/4	.020	5/8	4	2-1/8	.237	5	35137	HEV-RN-Z-50250-R.020
	1/4	.020	5/4	4	2-1/8	.237	5	83032	HEV-RN-M-50250-R.020
	1/4	.020	5/8	4	2-1/2	.237	5	81793	HEV-RN-L-50250-R.020
	1/4	.020	5/8	4-1/2	3	.237	5	83033	HEV-RN-X-50250-R.020
	1/4	.020	5/8	4-1/2	3	.237	5	83033	HEV-RN-Y-50250-R.020

* .0005 max TIR

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Speeds & Feeds on Page 151

5 FLUTE - CORNER RADIUS

New Items!



HEV-RN-5

Variable Pitch - Reduced Neck (cont.)

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Cutter Dia.* D1 $\pm .002$	Shank Dia. D2 (H6)	Corner Radius R $\pm .002$ -.002	LOC L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Reach (LBS) L3	Neck Dia.	Flutes	Aptus Coated	Tool Description
1/4	1/4	.030	3/8	4	3/4	.237	5	51107	HEV-RN-S-50250-R.030
	1/4	.030	3/8	4	1-1/8	.237	5	51122	HEV-RN-R-50250-R.030
	1/4	.030	3/4	4	1-1/8	.237	5	86387	HEV-RNR-R-50250-R.030
	1/4	.030	3/8	4	1-5/8	.237	5	88588	HEV-RN-A-50250-R.030
	1/4	.030	3/8	4	2-1/8	.237	5	51137	HEV-RN-M-50250-R.030
	1/4	.030	3/4	4	2-1/8	.237	5	86388	HEV-RNR-M-50250-R.030
	1/4	.030	3/8	4	2-1/2	.237	5	83034	HEV-RN-ML-50250-R.030
	1/4	.060	3/8	4	3/4	.237	5	51108	HEV-RN-S-50250-R.060
	1/4	.060	3/8	4	1-1/8	.237	5	51123	HEV-RN-R-50250-R.060
	1/4	.060	3/4	4	1-1/8	.237	5	88582	HEV-RNR-R-50250-R.060
	1/4	.060	3/8	4	1-5/8	.237	5	88581	HEV-RN-A-50250-R.060
	1/4	.060	3/8	4	2-1/8	.237	5	51138	HEV-RN-M-50250-R.060
	1/4	.060	3/4	4	2-1/8	.237	5	88583	HEV-RNR-M-50250-R.060
	1/4	.060	3/8	4	2-1/2	.237	5	86389	HEV-RN-ML-50250-R.060
5/16	5/16	.020	7/16	4	1-1/8	.296	5	88584	HEV-RN-R-50312-R.020
	5/16	.020	7/16	4	1-3/4	.296	5	88585	HEV-RN-M-50312-R.020
	5/16	.020	7/16	4	2-1/8	.296	5	88586	HEV-RN-ML-50312-R.020
	5/16	.030	7/16	4	1-1/8	.296	5	86390	HEV-RN-R-50312-R.030
	5/16	.030	7/16	4	1-3/4	.296	5	86391	HEV-RN-M-50312-R.030
	5/16	.030	7/16	4	2-1/8	.296	5	86392	HEV-RN-ML-50312-R.030
3/8	3/8	.020	1/2	4	1-1/8	.356	5	35152	HEV-RN-S-50375-R.020
	3/8	.020	1/2	4	1-5/8	.356	5	81794	HEV-RN-SR-50375-R.020
	3/8	.020	1/2	4	2-1/8	.356	5	35167	HEV-RN-R-50375-R.020
	3/8	.020	1	4	2-1/8	.356	5	83035	HEV-RNR-R-50375-R.020
	3/8	.020	1/2	6	2-1/2	.356	5	81795	HEV-RN-A-50375-R.020
	3/8	.020	1/2	6	3-1/8	.356	5	35197	HEV-RN-M-50375-R.020
	3/8	.020	1	6	3-1/8	.356	5	83036	HEV-RNR-M-50375-R.020
	3/8	.020	1/2	6	3-5/8	.356	5	86394	HEV-RN-ML-50375-R.020
	3/8	.030	1/2	4	1-1/8	.356	5	51152	HEV-RN-S-50375-R.030
	3/8	.030	1/2	4	1-5/8	.356	5	81796	HEV-RN-SR-50375-R.030
	3/8	.030	1/2	4	2-1/8	.356	5	51167	HEV-RN-R-50375-R.030
	3/8	.030	1/2	6	2-1/2	.356	5	81797	HEV-RN-A-50375-R.030
	3/8	.030	1/2	6	3-1/8	.356	5	51197	HEV-RN-M-50375-R.030
	3/8	.030	1/2	6	3-5/8	.356	5	86395	HEV-RN-ML-50375-R.030
	3/8	.030	1/2	6	4-1/8	.356	5	81212	HEV-RN-L-50375-R.030
	3/8	.060	1/2	4	1-1/8	.356	5	51153	HEV-RN-S-50375-R.060
	3/8	.060	1/2	4	1-5/8	.356	5	86396	HEV-RN-SR-50375-R.060
	3/8	.060	1/2	4	2-1/8	.356	5	51168	HEV-RN-R-50375-R.060
	3/8	.060	1/2	6	2-1/2	.356	5	86397	HEV-RN-A-50375-R.060
	3/8	.060	1/2	6	3-1/8	.356	5	51198	HEV-RN-M-50375-R.060
	3/8	.060	1/2	6	3-5/8	.356	5	88587	HEV-RN-ML-50375-R.060
	3/8	.090	1/2	4	1-1/8	.356	5	51154	HEV-RN-S-50375-R.090
	3/8	.090	1/2	4	2-1/8	.356	5	51169	HEV-RN-R-50375-R.090
	3/8	.090	1/2	6	2-1/8	.356	5	51199	HEV-RN-M-50375-R.090

*.0005 TIR MAX TIR

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HEV-RN-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck (cont.)

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Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Dia. D2 (Ø)	Corner Radius R $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.0027 \\ -.0007 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.0027 \\ -.0027 \end{smallmatrix}$	Reach (LBS) L3	Neck Dia.	Flutes	Aplis Coated	Tool Description
1/2	1/2	.030	5/8	4	1-1/2	475	5	35227	HEV-RN-S-50690-R.030
	1/2	.030	5/8	4	1-3/4	475	5	81798	HEV-RN-SR-50600-R.030
	1/2	.030	1-1/4	4	1-3/4	475	5	86388	HEV-RNR-SR-50300-R.030
	1/2	.030	5/8	4	2-1/4	475	5	35242	HEV-RN-R-50690-R.030
	1/2	.030	1-1/4	4	2-1/4	475	5	83037	HEV-RNR-R-50600-R.030
	1/2	.030	5/8	5	2-3/4	475	5	81799	HEV-RN-A-50690-R.030
	1/2	.030	1-1/4	5	2-3/4	475	5	86399	HEV-RNR-A-50600-R.030
	1/2	.030	5/8	6	3-3/8	475	5	35272	HEV-RN-M-50690-R.030
	1/2	.030	1-1/4	6	3-3/8	475	5	83038	HEV-RNR-M-50300-R.030
	1/2	.030	5/8	6	4-1/8	475	5	35287	HEV-RN-L-50690-R.030
	1/2	.030	1-1/4	6	4-1/8	475	5	83039	HEV-RNR-L-50300-R.030
	1/2	.030	5/8	7	5	475	5	83040	HEV-RN-X-50690-R.030
	1/2	.060	5/8	4	1-1/2	475	5	51227	HEV-RN-S-50690-R.060
	1/2	.060	5/8	4	1-3/4	475	5	86400	HEV-RN-SR-50300-R.060
	1/2	.060	1-1/4	4	1-3/4	475	5	88588	HEV-RNR-SR-50300-R.060
	1/2	.060	5/8	4	2-1/4	475	5	51242	HEV-RN-R-50690-R.060
	1/2	.060	1-1/4	4	2-1/4	475	5	88589	HEV-RNR-R-50300-R.060
	1/2	.060	5/8	5	2-3/4	475	5	86401	HEV-RN-A-50690-R.060
	1/2	.060	1-1/4	5	2-3/4	475	5	88590	HEV-RNR-A-50300-R.060
	1/2	.060	5/8	6	3-3/8	475	5	51272	HEV-RN-M-50690-R.060
	1/2	.060	1-1/4	6	3-3/8	475	5	88591	HEV-RNR-M-50300-R.060
	1/2	.060	5/8	6	4-1/8	475	5	51287	HEV-RN-L-50690-R.060
	1/2	.090	5/8	4	1-1/2	475	5	51228	HEV-RN-S-50690-R.090
	1/2	.090	5/8	4	2-1/4	475	5	51243	HEV-RN-R-50690-R.090
	1/2	.090	5/8	6	3-3/8	475	5	51273	HEV-RN-M-50690-R.090
	1/2	.120	5/8	4	1-1/2	475	5	51229	HEV-RN-S-50690-R.120
	1/2	.120	5/8	4	1-3/4	475	5	86402	HEV-RN-SR-50300-R.120
	1/2	.120	5/8	4	2-1/4	475	5	51244	HEV-RN-R-50690-R.120
	1/2	.120	5/8	5	2-3/4	475	5	86403	HEV-RN-A-50690-R.120
	1/2	.120	5/8	6	3-3/8	475	5	51274	HEV-RN-M-50690-R.120
	1/2	.120	5/8	6	4-1/8	475	5	51289	HEV-RN-L-50690-R.120
5/8	5/8	.030	3/4	4	1-5/8	593	5	35302	HEV-RN-S-50625-R.030
	5/8	.030	3/4	4	2	593	5	86404	HEV-RN-SR-50625-R.030
	5/8	.030	3/4	6	2-3/8	593	5	35317	HEV-RN-R-50625-R.030
	5/8	.030	3/4	6	3-3/8	593	5	35332	HEV-RN-M-50625-R.030
	5/8	.030	3/4	6	3-3/4	593	5	86405	HEV-RN-ML-50625-R.030
	5/8	.030	3/4	6	4-1/8	593	5	35347	HEV-RN-L-50625-R.030
	5/8	.060	3/4	4	1-5/8	593	5	51302	HEV-RN-S-50625-R.060
	5/8	.060	3/4	6	2-3/8	593	5	51317	HEV-RN-R-50625-R.060
	5/8	.060	3/4	6	3-3/8	593	5	51332	HEV-RN-M-50625-R.060
	5/8	.060	3/4	6	4-1/8	593	5	51347	HEV-RN-L-50625-R.060
	5/8	.120	3/4	4	1-5/8	593	5	51304	HEV-RN-S-50625-R.120
	5/8	.120	3/4	6	2-3/8	593	5	51319	HEV-RN-R-50625-R.120
	5/8	.120	3/4	6	3-3/8	593	5	86406	HEV-RN-M-50625-R.120

*.0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-RN-5

Variable Pitch - Reduced Neck (cont.)

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Cutter Dia.* D ₁ $\pm \frac{.001}{.002}$	Shank Dia. D ₂ H6	Corner Radius R $\pm \frac{.001}{.002}$	LOC L ₂ $\pm \frac{.032}{.001}$	OAL L ₁ $\pm \frac{.062}{.002}$	Reach (LBS) L ₃	Neck Dia.	Flutes	Applus Coated	Tool Description
3/4	3/4	.030	1	4	2	.712	5	35362	HEV-RN-S-50750-R.030
	3/4	.030	1-5/8	4	2	.712	5	86407	HEV-RN-R-50750-R.030
	3/4	.030	1	6	2-1/2	.712	5	35377	HEV-RN-R-50750-R.030
	3/4	.030	1-5/8	6	2-1/2	.712	5	83043	HEV-RN-R-50750-R.030
	3/4	.030	1	6	2-7/8	.712	5	81809	HEV-RN-A-50750-R.030
	3/4	.030	1	6	3-3/8	.712	5	35392	HEV-RN-M-50750-R.030
	3/4	.030	1-5/8	6	3-3/8	.712	5	83044	HEV-RN-M-50750-R.030
	3/4	.030	1	6	4-1/8	.712	5	35407	HEV-RN-L-50750-R.030
	3/4	.030	1-5/8	6	4-1/8	.712	5	86408	HEV-RN-L-50750-R.030
	3/4	.030	1	7	4-3/4	.712	5	86409	HEV-RN-LX-50750-R.030
	3/4	.060	1	4	2	.712	5	51362	HEV-RN-S-50750-R.060
	3/4	.060	1	6	2-1/2	.712	5	51377	HEV-RN-R-50750-R.060
	3/4	.060	1	6	2-7/8	.712	5	86418	HEV-RN-A-50750-R.060
	3/4	.060	1	6	3-3/8	.712	5	51392	HEV-RN-M-50750-R.060
	3/4	.060	1	6	4-1/8	.712	5	51407	HEV-RN-L-50750-R.060
	3/4	.060	1	7	4-3/4	.712	5	88592	HEV-RN-LX-50750-R.060
	3/4	.090	1	4	2	.712	5	51363	HEV-RN-S-50750-R.090
	3/4	.090	1	6	4-1/8	.712	5	51408	HEV-RN-L-50750-R.090
	3/4	.120	1	4	2	.712	5	51364	HEV-RN-S-50750-R.120
	3/4	.120	1	6	2-1/2	.712	5	51379	HEV-RN-R-50750-R.120
	3/4	.120	1	6	2-7/8	.712	5	86411	HEV-RN-A-50750-R.120
	3/4	.120	1	6	3-3/8	.712	5	51394	HEV-RN-M-50750-R.120
	3/4	.120	1	6	4-1/8	.712	5	51409	HEV-RN-L-50750-R.120
	3/4	.120	1	7	4-3/4	.712	5	88593	HEV-RN-LX-50750-R.120
	3/4	.190	1	4	2	.712	5	51365	HEV-RN-S-50750-R.190
	3/4	.190	1	6	4-1/8	.712	5	51419	HEV-RN-L-50750-R.190
	3/4	.250	1	4	2	.712	5	51366	HEV-RN-S-50750-R.250
	3/4	.250	1	6	2-1/2	.712	5	51381	HEV-RN-R-50750-R.250
	3/4	.250	1	6	2-7/8	.712	5	81801	HEV-RN-A-50750-R.250
	3/4	.250	1	6	3-3/8	.712	5	51396	HEV-RN-M-50750-R.250
	3/4	.250	1	6	4-1/8	.712	5	51411	HEV-RN-L-50750-R.250
1	1	.030	1-1/4	4	2-1/4	.950	5	35422	HEV-RN-S-51000-R.030
	1	.030	1-1/4	6	2-5/8	.950	5	35437	HEV-RN-R-51000-R.030
	1	.030	1-1/4	6	3-3/8	.950	5	35452	HEV-RN-M-51000-R.030
	1	.030	1-1/4	6	4-1/8	.950	5	35467	HEV-RN-L-51000-R.030
	1	.120	1-1/4	4	2-1/4	.950	5	51403	HEV-RN-S-51000-R.120
	1	.120	1-1/4	6	2-5/8	.950	5	51454	HEV-RN-R-51000-R.120
	1	.120	1-1/4	6	3-3/8	.950	5	51439	HEV-RN-M-51000-R.120
	1	.120	1-1/4	6	4-1/8	.950	5	51424	HEV-RN-L-51000-R.120

* .0005 max TIR

HEV-5 / HSM-5


SPEEDS & FEEDS
 5 Flute - Variable Pitch

HEV-5 / HEV-RN-5 / HSM-5

Material Guide		Hardness	SFM	Inches per Tooth (IPT)																								
				Inches per Tooth (IPT)																								
				1/16			1/8			3/16			1/4			3/8			1/2			3/4			1			
Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin	Slot	Rgn	Fin		
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	455	0005	0008	0009	0006	0010	0015	0018	0014	0021	0020	0018	0029	0022	0027	0043	0026	0035	0058	0030	0051	0080	0036	0065	0100	0044
		75 - 89 HRB	440	0004	0006	0006	0007	0011	0015	0010	0015	0017	0013	0021	0019	0020	0031	0022	0026	0041	0030	0037	0059	0031	0047	0075	0037	
		21 - 36 HRC	400	0002	0004	0006	0004	0007	0012	0007	0010	0014	0006	0014	0015	0013	0020	0016	0017	0026	0021	0024	0038	0025	0031	0048	0030	
LOW ALLOY STEEL	13XX, 41XX, 50XX, 51XX, 86XX, 95XX	75 - 89 HRB	390	0003	0005	0007	0006	0009	0014	0009	0013	0016	0012	0018	0018	0017	0021	0022	0035	0024	0032	0051	0029	0041	0065	0035		
		21 - 36 HRC	340	0002	0004	0006	0004	0007	0012	0007	0010	0013	0006	0013	0015	0013	0020	0016	0017	0026	0021	0024	0038	0025	0030	0048	0030	
		36 - 50 HRC	300	0002	0003	0006	0004	0006	0011	0006	0009	0013	0006	0012	0014	0011	0017	0017	0015	0023	0019	0021	0033	0023	0027	0042	0028	
	> 50 HRC	195	0002	0003	0005	0003	0005	0010	0005	0007	0011	0006	0008	0013	0009	0014	0015	0011	0018	0017	0017	0026	0020	0021	0033	0025		
TOOL STEEL		75 - 89 HRB	340	0003	0005	0007	0006	0009	0014	0009	0013	0016	0012	0018	0018	0017	0021	0022	0035	0024	0032	0051	0029	0041	0065	0035		
		21 - 36 HRC	290	0003	0004	0006	0005	0007	0012	0007	0011	0014	0008	0015	0016	0014	0022	0016	0018	0028	0021	0026	0040	0025	0033	0051	0031	
		36 - 50 HRC	145	0002	0003	0006	0004	0006	0011	0006	0009	0013	0007	0012	0014	0011	0017	0016	0014	0023	0019	0021	0032	0023	0026	0041	0028	
	> 50 HRC	85	0002	0003	0005	0003	0005	0010	0005	0007	0011	0006	0008	0013	0009	0014	0015	0011	0018	0017	0017	0026	0020	0021	0033	0025		
SPECIALTY STEEL	308M, Invar 36, Kovar, Monel 200, Monel 250, Monel 300, Monel 350	< 75 HRB	290	0004	0006	0008	0006	0012	0016	0011	0016	0018	0015	0024	0020	0023	0035	0024	0029	0046	0028	0042	0045	0033	0054	0065	0040	
		75 - 89 HRB	255	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0032	0033	0029	0045	0027	0037	0058	0033	
		21 - 36 HRC	175	0003	0004	0007	0005	0008	0013	0007	0011	0014	0006	0015	0016	0014	0022	0016	0018	0028	0021	0026	0041	0026	0033	0052	0031	
	36 - 50 HRC	150	0002	0004	0006	0004	0007	0012	0006	0010	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030		
	> 50 HRC	55	0002	0002	0005	0003	0004	0009	0004	0006	0010	0006	0008	0012	0008	0013	0014	0015	0015	0016	0014	0022	0019	0018	0029	0023		
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 302, 304, 304L, Incoloy 27-TM3, 316, 316L, 321, 347	75 - 89 HRB	365	0003	0005	0007	0006	0009	0014	0009	0013	0016	0011	0018	0018	0017	0026	0020	0022	0034	0024	0031	0049	0028	0040	0065	0034	
		21 - 36 HRC	325	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0031	0023	0028	0044	0027	0036	0057	0033	
		36 - 50 HRC	260	0002	0004	0006	0004	0007	0012	0006	0009	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030	
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 89 HRB	300	0003	0005	0007	0006	0009	0014	0009	0013	0016	0012	0018	0018	0017	0026	0020	0022	0034	0024	0031	0049	0028	0040	0065	0034	
		21 - 36 HRC	280	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0031	0022	0028	0044	0027	0036	0056	0033	
		36 - 50 HRC	145	0002	0003	0006	0004	0006	0011	0006	0009	0013	0007	0012	0014	0011	0017	0016	0014	0023	0019	0021	0032	0023	0026	0041	0028	
IN STAINLESS STEEL	15-5, T7-4, Carpenter 402, Carpenter 403	75 - 89 HRB	410	0005	0008	0009	0010	0015	0018	0014	0022	0025	0019	0029	0023	0028	0044	0026	0036	0057	0030	0052	0082	0037	0066	0104	0044	
		21 - 36 HRC	370	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0031	0022	0028	0045	0027	0036	0057	0033	
		36 - 50 HRC	145	0002	0003	0006	0004	0006	0011	0006	0009	0013	0007	0012	0014	0011	0017	0016	0014	0023	0019	0021	0032	0023	0026	0041	0028	
GRAY CAST IRON	SAE J431, ASTM A18	75 - 89 HRB	410	0005	0008	0009	0010	0015	0018	0014	0022	0025	0019	0029	0023	0028	0044	0026	0036	0057	0030	0052	0082	0037	0066	0104	0044	
		21 - 36 HRC	370	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0031	0022	0028	0045	0027	0036	0057	0033	
		36 - 50 HRC	145	0002	0003	0006	0004	0006	0011	0006	0009	0013	0007	0012	0014	0011	0017	0016	0014	0023	0019	0021	0032	0023	0026	0041	0028	
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A532	75 - 89 HRB	345	0003	0005	0007	0006	0010	0014	0009	0014	0016	0012	0018	0018	0017	0026	0020	0022	0034	0024	0031	0049	0028	0040	0065	0034	
		21 - 36 HRC	325	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0024	0019	0025	0031	0022	0028	0045	0027	0036	0057	0033	
		36 - 50 HRC	125	0002	0003	0006	0004	0006	0011	0006	0009	0013	0007	0012	0014	0011	0017	0016	0014	0023	0019	0021	0032	0023	0026	0041	0028	
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM A572	75 - 89 HRB	310	0003	0005	0008	0006	0010	0015	0009	0014	0016	0012	0020	0018	0018	0026	0020	0022	0034	0024	0031	0049	0028	0040	0065	0034	
		21 - 36 HRC	360	0002	0004	0006	0004	0007	0012	0006	0010	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030	
		36 - 50 HRC	125	0002	0003	0005	0003	0004	0009	0004	0006	0010	0005	0008	0012	0008	0013	0014	0015	0015	0016	0014	0023	0019	0018	0029	0023	
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	385	0004	0007	0009	0008	0013	0017	0012	0018	0019	0015	0025	0021	0024	0037	0024	0031	0048	0028	0044	0027	0036	0056	0034		
		75 - 89 HRB	290	0004	0006	0008	0007	0011	0015	0010	0015	0017	0013	0021	0019	0020	0031	0022	0026	0041	0028	0042	0037	0058	0031	0047	0037	
		21 - 36 HRC	80	0002	0003	0006	0004	0006	0012	0006	0009	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030	
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Incoloy 20	75 - 89 HRB	80	0002	0003	0006	0004	0006	0012	0006	0009	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030	
		21 - 36 HRC	75	0002	0003	0006	0004	0006	0012	0006	0009	0013	0006	0013	0015	0012	0019	0017	0016	0026	0020	0023	0037	0024	0030	0046	0030	
		36 - 50 HRC	70	0002	0003	0005	0003	0005	0010	0005	0008	0012	0007	0013	0014	0010	0015	0015	0013	0022	0018	0019	0029	0022	0023	0037	0028	
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 5, Ti Grade 12	< 75 HRB	300	0006	0009	0010	0011	0017	0019	0017	0025	0022	0022	0035	0025	0033	0051	0028	0043	0067	0033	0061	0096	0038	0078	0122	0048	
		75 - 89 HRB	275	0005	0008	0009	0008	0015	0018	0014	0021	0020	0018	0029	0023	0027	0043	0026	0036	0056	0030	0051	0081	0036	0065	0100	0044	
		21 - 36 HRC	260	0004	0006	0008	0007	0011	0015	0010	0016	0017	0014	0022	0020	0021	0030	0022	0027	0042	0029	0036	0060	0031	0049	0077	0039	
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 89 HRB	180	0003	0005	0007	0006	0009	0014	0009	0013	0015	0011	0017	0017	0016	0026	0020	0021	0033	0023	0030	0048	0028	0036	0061	0034	
		21 - 36 HRC	160	0003	0004	0007	0005	0008	0013	0008	0012	0015	0010	0016	0017	0015	0023	0019	0018	0029	0022	0028	0043	0027	0035	0055	0032	

6 FLUTE - SQUARE

Variable Pitch


HEV-6

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 223 for Tplus coating



Cutter Diameter* D1 $\pm .001$ $\pm .002$	Shank Diameter D2 (H6)	Length of Cut L2 $\pm .002$ $\pm .004$	Overall Length L1 $\pm .002$ $\pm .004$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	6	84382	HEV-S-60125
	1/8	3/8	2	6	84383	HEV-SR-60125
	1/8	1/2	2-1/2	6	84384	HEV-R-60125
	1/8	5/8	2-1/2	6	84385	HEV-A-60125
3/16	3/16	5/16	2	6	84386	HEV-S-60187
	3/16	7/16	2	6	84387	HEV-SR-60187
	3/16	9/16	2-1/2	6	84388	HEV-R-60187
	3/16	3/4	2-1/2	6	84389	HEV-M-60187
1/4	1/4	3/8	2	6	59250	HEV-S-60250
	1/4	1/2	2-1/2	6	59251	HEV-SR-60250
	1/4	3/4	2-1/2	6	59252	HEV-R-60250
	1/4	1	3	6	59253	HEV-M-60250
	1/4	1-1/4	3	6	59254	HEV-L-60250
	1/4	1-1/2	3	6	82565	HEV-LX-60250
5/16	5/16	7/16	2	6	59255	HEV-S-60312
	5/16	3/4	2-1/2	6	59256	HEV-R-60312
	5/16	1	3	6	59257	HEV-M-60312
3/8	3/8	1/2	2	6	59258	HEV-S-60375
	3/8	3/4	2-1/2	6	82566	HEV-SR-60375
	3/8	1	3	6	59259	HEV-R-60375
	3/8	1-1/4	3	6	59260	HEV-M-60375
	3/8	1-1/2	3-1/2	6	59261	HEV-L-60375
	3/8	2	4	6	82567	HEV-LX-60375
1/2	1/2	5/8	2-1/2	6	59262	HEV-S-60500
	1/2	1	3	6	59263	HEV-SR-60500
	1/2	1-1/4	3	6	59264	HEV-R-60500
	1/2	1-5/8	4	6	59265	HEV-M-60500
	1/2	2	4	6	59266	HEV-L-60500
	1/2	2-1/2	5	6	82568	HEV-LX-60500
	1/2	3-1/8	6	6	84586	HEV-X-60500

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 167

HEV-6



6 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.0017 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (in)	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
5/8	5/8	3/4	3	6	59267	HEV-S-60625
	5/8	1-1/4	3-1/2	6	59268	HEV-SR-60625
	5/8	1-5/8	3-1/2	6	59269	HEV-R-60625
	5/8	2	4	6	59270	HEV-M-60625
	5/8	2-1/2	5	6	59271	HEV-L-60625
	5/8	3-1/4	6	6	84987	HEV-LX-60625
3/4	3/4	1	3	6	59272	HEV-S-60750
	3/4	1-5/8	4	6	59273	HEV-R-60750
	3/4	2-1/4	5	6	59274	HEV-M-60750
	3/4	2-3/4	5	6	59275	HEV-L-60750
	3/4	3-1/4	6	6	59276	HEV-LX-60750
	3/4	4	6-1/2	6	84988	HEV-X-60750
1	1	1-1/4	4	6	84989	HEV-S-61000
	1	2	4-1/2	6	59277	HEV-R-61000
	1	2-5/8	5	6	59278	HEV-M-61000
	1	3-1/4	6	6	59279	HEV-L-61000
	1	4-1/4	7	6	84990	HEV-X-61000

*.0005 max TIR



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6 FLUTE - SQUARE - METRIC

Variable Pitch


MHEV-6
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 +0.00 mm -0.00 mm	Shank Diameter D2 (H6)	Length of Cut L2 +0.00 mm -0.00 mm	Overall Length L1 +1.50 mm -1.50 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	9.00 mm	62 mm	6	59574	MHEV-015-60600
	6.00 mm	12.00 mm	62 mm	6	59592	MHEV-020-60600
	6.00 mm	18.00 mm	63 mm	6	59626	MHEV-030-60600
8 mm	8.00 mm	12.00 mm	62 mm	6	59577	MHEV-015-80800
	8.00 mm	16.00 mm	62 mm	6	59595	MHEV-020-80800
	8.00 mm	24.00 mm	75 mm	6	59629	MHEV-030-80800
10 mm	10.00 mm	15.00 mm	62 mm	6	59580	MHEV-015-61000
	10.00 mm	20.00 mm	62 mm	6	59598	MHEV-020-61000
	10.00 mm	25.00 mm	75 mm	6	59612	MHEV-025-61000
12 mm	12.00 mm	18.00 mm	75 mm	6	59583	MHEV-015-61200
	12.00 mm	24.00 mm	75 mm	6	59601	MHEV-020-61200
	12.00 mm	30.00 mm	75 mm	6	59615	MHEV-025-61200
16 mm	16.00 mm	24.00 mm	80 mm	6	59586	MHEV-015-61600
	16.00 mm	32.00 mm	80 mm	6	59604	MHEV-020-61600
	16.00 mm	40.00 mm	89 mm	6	59618	MHEV-025-61600
20 mm	20.00 mm	30.00 mm	80 mm	6	59589	MHEV-015-62000
	20.00 mm	40.00 mm	100 mm	6	59607	MHEV-020-62000
	20.00 mm	50.00 mm	125 mm	6	59621	MHEV-025-62000
25 mm	25.00 mm	50.00 mm	125 mm	6	59610	MHEV-020-62500
	25.00 mm	64.00 mm	125 mm	6	59624	MHEV-025-62500

* .013 mm max TIR



HEV-6



New Items!

6 FLUTE - BALL
Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates

- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 226 for Tplus coating



Outer Diameter* $D_1 \begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter $D_2 (h6)$	Length of Cut $L_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length $L_2 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	6	84406	HEV-S-60125-BN
	1/8	3/8	2	6	84407	HEV-SR-60125-BN
	1/8	1/2	2-1/2	6	84408	HEV-R-60125-BN
	1/8	5/8	2-1/2	6	84409	HEV-A-60125-BN
	1/8	3/4	2-1/2	6	88353	HEV-M-60125-BN
3/16	3/16	5/16	2	6	84410	HEV-S-60187-BN
	3/16	7/16	2	6	84411	HEV-SR-60187-BN
	3/16	9/16	2-1/2	6	84412	HEV-R-60187-BN
	3/16	3/4	2-1/2	6	84413	HEV-M-60187-BN
	3/16	1	3	6	88354	HEV-ML-60187-BN
1/4	1/4	3/8	2	6	59434	HEV-S-60250-BN
	1/4	1/2	2-1/2	6	59435	HEV-SR-60250-BN
	1/4	3/4	2-1/2	6	59436	HEV-R-60250-BN
	1/4	1	3	6	59437	HEV-M-60250-BN
	1/4	1-1/4	3	6	59438	HEV-L-60250-BN
	1/4	1-1/2	3	6	83361	HEV-LX-60250-BN
5/16	5/16	7/16	2	6	59439	HEV-S-60312-BN
	5/16	3/4	2-1/2	6	59440	HEV-R-60312-BN
	5/16	1	3	6	59441	HEV-M-60312-BN
	5/16	1-1/4	3	6	88355	HEV-ML-60312-BN
3/8	3/8	1/2	2	6	59442	HEV-S-60375-BN
	3/8	3/4	2-1/2	6	82592	HEV-SR-60375-BN
	3/8	1	3	6	59443	HEV-R-60375-BN
	3/8	1-1/4	3	6	59444	HEV-M-60375-BN
	3/8	1-1/2	3-1/2	6	59445	HEV-L-60375-BN
	3/8	2	4	6	83362	HEV-LX-60375-BN
	3/8	2-1/2	5	6	88356	HEV-X-60375-BN

*.0005 max TIR

continued on next page



Speeds & Feeds on Page 167

6 FLUTE - BALL

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* $D_1 \pm .002$	Shank Diameter $D_2 \pm .001$	Length of Cut $L_2 \pm .002$	Overall Length $L_1 \pm .002$	Flutes	Apex Coated	Tool Description
1/2	1/2	5/8	2-1/2	6	50446	HEV-S-60500-BN
	1/2	1	3	6	50447	HEV-SR-60500-BN
	1/2	1-1/4	3	6	50448	HEV-R-60500-BN
	1/2	1-5/8	4	6	50449	HEV-M-60500-BN
	1/2	2	4	6	50450	HEV-L-60500-BN
	1/2	2-1/2	5	6	82593	HEV-LX-60500-BN
5/8	5/8	3/4	3	6	50451	HEV-S-60625-BN
	5/8	1-1/4	3-1/2	6	50452	HEV-SR-60625-BN
	5/8	1-5/8	3-1/2	6	50453	HEV-R-60625-BN
3/4	3/4	1	3	6	50454	HEV-S-60750-BN
	3/4	1-5/8	4	6	50455	HEV-R-60750-BN
	3/4	2-1/4	5	6	50456	HEV-M-60750-BN
	3/4	2-3/4	5	6	83363	HEV-L-60750-BN
	3/4	3-1/4	6	6	88358	HEV-LX-60750-BN
1	1	2	4-1/2	6	50457	HEV-R-61000-BN
	1	2-5/8	5	6	82594	HEV-M-61000-BN
	1	3-1/4	6	6	88359	HEV-L-61000-BN

*.0005 max TIR

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HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates

- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 228 for Tplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.007 \\ -.007 \end{smallmatrix}$	Shank Diameter D2 h6	Corner Radius R $\begin{smallmatrix} +.010 \\ -.010 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.012 \\ -.007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	6	84390	HEV-S-80125-R.010
	1/8	.010	3/8	2	6	84391	HEV-SR-80125-R.010
	1/8	.010	1/2	2-1/2	6	84392	HEV-R-80125-R.010
	1/8	.010	5/8	2-1/2	6	84393	HEV-A-80125-R.010
	1/8	.030	1/4	1-1/2	6	84394	HEV-S-80125-R.030
	1/8	.030	3/8	2	6	84395	HEV-SR-80125-R.030
	1/8	.030	1/2	2-1/2	6	84396	HEV-R-80125-R.030
	1/8	.030	5/8	2-1/2	6	84397	HEV-A-80125-R.030
3/16	3/16	.010	5/16	2	6	84398	HEV-S-80187-R.010
	3/16	.010	7/16	2	6	84399	HEV-SR-80187-R.010
	3/16	.010	9/16	2-1/2	6	84400	HEV-R-80187-R.010
	3/16	.010	3/4	2-1/2	6	84401	HEV-M-80187-R.010
	3/16	.030	5/16	2	6	84402	HEV-S-80187-R.030
	3/16	.030	7/16	2	6	84403	HEV-SR-80187-R.030
	3/16	.030	9/16	2-1/2	6	84404	HEV-R-80187-R.030
	3/16	.030	3/4	2-1/2	6	84405	HEV-M-80187-R.030
1/4	1/4	.010	3/8	2	6	84995	HEV-S-80250-R.010
	1/4	.010	1/2	2-1/2	6	84996	HEV-SR-80250-R.010
	1/4	.010	3/4	2-1/2	6	84997	HEV-R-80250-R.010
	1/4	.010	1	3	6	87550	HEV-M-80250-R.010
	1/4	.010	1-1/4	3	6	87551	HEV-L-80250-R.010
	1/4	.010	1-1/2	3	6	87552	HEV-LX-80250-R.010
	1/4	.020	3/8	2	6	58290	HEV-S-80250-R.020
	1/4	.020	1/2	2-1/2	6	58293	HEV-SR-80250-R.020
	1/4	.020	3/4	2-1/2	6	58296	HEV-R-80250-R.020
	1/4	.020	1	3	6	58299	HEV-M-80250-R.020
	1/4	.020	1-1/4	3	6	58302	HEV-L-80250-R.020
	1/4	.020	1-1/2	3	6	82508	HEV-LX-80250-R.020
	1/4	.030	3/8	2	6	58291	HEV-S-80250-R.030
	1/4	.030	1/2	2-1/2	6	58294	HEV-SR-80250-R.030
	1/4	.030	3/4	2-1/2	6	58297	HEV-R-80250-R.030
	1/4	.030	1	3	6	58299	HEV-M-80250-R.030
	1/4	.030	1-1/4	3	6	58293	HEV-L-80250-R.030
	1/4	.030	1-1/2	3	6	87553	HEV-LX-80250-R.030

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 167

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Outer Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H6)	Corner Radius R $\pm \frac{.002}{.001}$	Length of Cut L2 $\pm \frac{.002}{.001}$	Overall Length L1 $\pm \frac{.002}{.001}$	Flutes	Aphs Coated	Tool Description
1/4	1/4	.060	3/8	2	6	59282	HEV-S-60250-R.060
	1/4	.060	1/2	2-1/2	6	59285	HEV-SR-60250-R.060
	1/4	.060	3/4	2-1/2	6	59288	HEV-R-60250-R.060
	1/4	.060	1	3	6	59291	HEV-M-60250-R.060
	1/4	.060	1-1/4	3	6	59294	HEV-L-60250-R.060
	1/4	.060	1-1/2	3	6	82570	HEV-LX-60250-R.060
	5/16	.010	7/16	2	6	87554	HEV-S-60312-R.010
5/16	5/16	.010	3/4	2-1/2	6	87555	HEV-SR-60312-R.010
	5/16	.010	1	3	6	87556	HEV-M-60312-R.010
	5/16	.020	7/16	2	6	59295	HEV-S-60312-R.020
	5/16	.020	3/4	2-1/2	6	59298	HEV-R-60312-R.020
	5/16	.020	1	3	6	59301	HEV-M-60312-R.020
	5/16	.020	1-1/4	3	6	88371	HEV-L-60312-R.020
	5/16	.030	7/16	2	6	59296	HEV-S-60312-R.030
	5/16	.030	3/4	2-1/2	6	59299	HEV-R-60312-R.030
	5/16	.030	1	3	6	59302	HEV-M-60312-R.030
	5/16	.030	1-1/4	3	6	88372	HEV-L-60312-R.030
	5/16	.060	7/16	2	6	59297	HEV-S-60312-R.060
	5/16	.060	3/4	2-1/2	6	59300	HEV-R-60312-R.060
	5/16	.060	1	3	6	59303	HEV-M-60312-R.060
	5/16	.060	1-1/4	3	6	88373	HEV-L-60312-R.060
3/8	3/8	.010	1/2	2	6	84998	HEV-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	84999	HEV-SR-60375-R.010
	3/8	.010	1	3	6	86000	HEV-R-60375-R.010
	3/8	.010	1-1/4	3	6	86001	HEV-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	87557	HEV-L-60375-R.010
	3/8	.010	2	4	6	87558	HEV-LX-60375-R.010
	3/8	.015	1/2	2	6	88374	HEV-S-60375-R.015
	3/8	.015	3/4	2-1/2	6	88375	HEV-SR-60375-R.015
	3/8	.015	1	3	6	88376	HEV-R-60375-R.015
	3/8	.015	1-1/4	3	6	88377	HEV-M-60375-R.015
	3/8	.020	1/2	2	6	59304	HEV-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	82571	HEV-SR-60375-R.020
	3/8	.020	1	3	6	59308	HEV-R-60375-R.020
	3/8	.020	1-1/4	3	6	59312	HEV-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	59316	HEV-L-60375-R.020
	3/8	.020	2	4	6	83318	HEV-LX-60375-R.020
	3/8	.030	1/2	2	6	59305	HEV-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	82572	HEV-SR-60375-R.030
	3/8	.030	1	3	6	59309	HEV-R-60375-R.030
	3/8	.030	1-1/4	3	6	59313	HEV-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	59317	HEV-L-60375-R.030
	3/8	.030	2	4	6	82573	HEV-LX-60375-R.030

* .0005 max TIR

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HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $^{+0.001}_{-0.002}$	Shank Diameter D2 (in)	Corner Radius R $^{+0.002}_{-0.002}$	Length of Cut L2 $^{+0.002}_{-0.002}$	Overall Length L1 $^{+0.002}_{-0.002}$	Flutes	Aplus Coated	Tool Description
3/8	3/8	.060	1/2	2	6	59306	HEV-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	82574	HEV-SR-60375-R.060
	3/8	.060	1	3	6	59310	HEV-R-60375-R.060
	3/8	.060	1-1/4	3	6	59314	HEV-M-60375-R.060
	3/8	.060	1-1/2	3-1/2	6	59318	HEV-L-60375-R.060
	3/8	.060	2	4	6	82575	HEV-LX-60375-R.060
	3/8	.090	1/2	2	6	59307	HEV-S-60375-R.090
	3/8	.090	3/4	2-1/2	6	82576	HEV-SR-60375-R.090
	3/8	.090	1	3	6	59311	HEV-R-60375-R.090
	3/8	.090	1-1/4	3	6	59315	HEV-M-60375-R.090
	3/8	.090	1-1/2	3-1/2	6	59319	HEV-L-60375-R.090
	3/8	.090	2	4	6	82577	HEV-LX-60375-R.090
	3/8	.125	1/2	2	6	87559	HEV-S-60375-R.125
	3/8	.125	3/4	2-1/2	6	87560	HEV-SR-60375-R.125
	3/8	.125	1	3	6	87561	HEV-R-60375-R.125
	3/8	.125	1-1/4	3	6	87562	HEV-M-60375-R.125
1/2	1/2	.010	5/8	2-1/2	6	83319	HEV-S-60500-R.010
	1/2	.010	1	3	6	82578	HEV-SR-60500-R.010
	1/2	.010	1-1/4	3	6	82579	HEV-R-60500-R.010
	1/2	.010	1-5/8	4	6	86002	HEV-M-60500-R.010
	1/2	.010	2	4	6	87563	HEV-L-60500-R.010
	1/2	.010	2-1/2	5	6	87564	HEV-LX-60500-R.010
	1/2	.015	5/8	2-1/2	6	83320	HEV-S-60500-R.015
	1/2	.015	1	3	6	82580	HEV-SR-60500-R.015
	1/2	.015	1-1/4	3	6	82581	HEV-R-60500-R.015
	1/2	.015	1-5/8	4	6	86003	HEV-M-60500-R.015
	1/2	.015	2	4	6	87565	HEV-L-60500-R.015
	1/2	.015	2-1/2	5	6	87566	HEV-LX-60500-R.015
	1/2	.020	5/8	2-1/2	6	87567	HEV-S-60500-R.020
	1/2	.020	1	3	6	82582	HEV-SR-60500-R.020
	1/2	.020	1-1/4	3	6	82583	HEV-R-60500-R.020
	1/2	.020	1-5/8	4	6	86004	HEV-M-60500-R.020
	1/2	.020	2	4	6	87568	HEV-L-60500-R.020
	1/2	.020	2-1/2	5	6	87569	HEV-LX-60500-R.020
	1/2	.030	5/8	2-1/2	6	59320	HEV-S-60500-R.030
	1/2	.030	1	3	6	59324	HEV-SR-60500-R.030
	1/2	.030	1-1/4	3	6	59328	HEV-R-60500-R.030
	1/2	.030	1-5/8	4	6	59332	HEV-M-60500-R.030
	1/2	.030	2	4	6	59336	HEV-L-60500-R.030
	1/2	.030	2-1/2	5	6	82584	HEV-LX-60500-R.030
	1/2	.030	3-1/8	6	6	86004	HEV-X-60500-R.030
	1/2	.060	5/8	2-1/2	6	59321	HEV-S-60500-R.060
	1/2	.060	1	3	6	59325	HEV-SR-60500-R.060
	1/2	.060	1-1/4	3	6	59329	HEV-R-60500-R.060
	1/2	.060	1-5/8	4	6	59333	HEV-M-60500-R.060
	1/2	.060	2	4	6	59337	HEV-L-60500-R.060
	1/2	.060	2-1/2	5	6	82585	HEV-LX-60500-R.060

*.0000 max TIR

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6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\frac{+0.001}{-0.002}$ "	Shank Diameter D2 H9	Corner Radius R $\frac{+0.002}{-0.002}$ "	Length of Cut L2 $\frac{+0.002}{-0.002}$ "	Overall Length L1 $\frac{+0.002}{-0.002}$ "	Flutes	Aplus-Coated	Tool Description
1/2	1/2	.090	5/8	2-1/2	6	59322	HEV-S-60600-R.090
	1/2	.090	1	3	6	59326	HEV-SR-60600-R.090
	1/2	.090	1-1/4	3	6	59330	HEV-R-60600-R.090
	1/2	.090	1-5/8	4	6	59334	HEV-M-60600-R.090
	1/2	.090	2	4	6	59338	HEV-L-60600-R.090
	1/2	.090	2-1/2	5	6	82586	HEV-LX-60600-R.090
	1/2	.120	5/8	2-1/2	6	87570	HEV-S-60600-R.120
	1/2	.120	1	3	6	87571	HEV-SR-60600-R.120
	1/2	.120	1-1/4	3	6	87572	HEV-R-60600-R.120
	1/2	.120	1-5/8	4	6	87573	HEV-M-60600-R.120
	1/2	.125	5/8	2-1/2	6	59323	HEV-S-60600-R.125
	1/2	.125	1	3	6	59327	HEV-SR-60600-R.125
	1/2	.125	1-1/4	3	6	59331	HEV-R-60600-R.125
	1/2	.125	1-5/8	4	6	59335	HEV-M-60600-R.125
	1/2	.125	2	4	6	59339	HEV-L-60600-R.125
	1/2	.125	2-1/2	5	6	83321	HEV-LX-60600-R.125
5/8	5/8	.030	3/4	3	6	59340	HEV-S-60625-R.030
	5/8	.030	1-1/4	3-1/2	6	59341	HEV-SR-60625-R.030
	5/8	.030	1-5/8	3-1/2	6	59345	HEV-R-60625-R.030
	5/8	.030	2	4	6	59349	HEV-M-60625-R.030
	5/8	.030	2-1/2	5	6	59353	HEV-L-60625-R.030
	5/8	.030	3-1/4	6	6	88379	HEV-LX-60625-R.030
	5/8	.060	3/4	3	6	87574	HEV-S-60625-R.060
	5/8	.060	1-1/4	3-1/2	6	59342	HEV-SR-60625-R.060
	5/8	.060	1-5/8	3-1/2	6	59346	HEV-R-60625-R.060
	5/8	.060	2	4	6	59350	HEV-M-60625-R.060
	5/8	.060	2-1/2	5	6	87575	HEV-L-60625-R.060
	5/8	.090	1-1/4	3-1/2	6	59343	HEV-SR-60625-R.090
	5/8	.090	1-5/8	3-1/2	6	59347	HEV-R-60625-R.090
	5/8	.090	2	4	6	59351	HEV-M-60625-R.090
	5/8	.125	3/4	3	6	87576	HEV-S-60625-R.125
	5/8	.125	1-1/4	3-1/2	6	59344	HEV-SR-60625-R.125
	5/8	.125	1-5/8	3-1/2	6	59348	HEV-R-60625-R.125
	5/8	.125	2	4	6	59352	HEV-M-60625-R.125
	5/8	.125	2-1/2	5	6	86005	HEV-L-60625-R.125
3/4	3/4	.010	1	3	6	88380	HEV-S-60750-R.010
	3/4	.010	1-5/8	4	6	88381	HEV-R-60750-R.010
	3/4	.010	2-1/4	5	6	88382	HEV-M-60750-R.010
	3/4	.010	2-3/4	5	6	88383	HEV-L-60750-R.010
	3/4	.010	3-1/4	6	6	88384	HEV-LX-60750-R.010
	3/4	.030	1	3	6	59354	HEV-S-60750-R.030
	3/4	.030	1-5/8	4	6	59360	HEV-R-60750-R.030
	3/4	.030	2-1/4	5	6	59366	HEV-M-60750-R.030
	3/4	.030	2-3/4	5	6	59372	HEV-L-60750-R.030
	3/4	.030	3-1/4	6	6	59378	HEV-LX-60750-R.030
	3/4	.030	4	6-1/2	6	86006	HEV-X-60750-R.030
	3/4	.060	1	3	6	59355	HEV-S-60750-R.060
	3/4	.060	1-5/8	4	6	59361	HEV-R-60750-R.060
	3/4	.060	2-1/4	5	6	59367	HEV-M-60750-R.060
	3/4	.060	2-3/4	5	6	59373	HEV-L-60750-R.060
	3/4	.060	3-1/4	6	6	83322	HEV-LX-60750-R.060

* .0005 max TIR

continued on next page

HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.002}{.001}$	Shank Diameter D2 (in)	Corner Radius R $\pm \frac{.002}{.001}$	Length of Cut L2 $\pm \frac{.002}{.001}$	Overall Length L1 $\pm \frac{.002}{.001}$	Flutes	Applus Coated	Tool Description
3/4	3/4	.090	1	3	6	59356	HEV-S-60750-R.090
	3/4	.090	1-5/8	4	6	59362	HEV-R-60750-R.090
	3/4	.090	2-1/4	5	6	59368	HEV-M-60750-R.090
	3/4	.090	2-3/4	5	6	59374	HEV-L-60750-R.090
	3/4	.120	1	3	6	87577	HEV-S-60750-R.120
	3/4	.120	1-5/8	4	6	87578	HEV-R-60750-R.120
	3/4	.120	2-1/4	5	6	87579	HEV-M-60750-R.120
	3/4	.125	1	3	6	59357	HEV-S-60750-R.125
	3/4	.125	1-5/8	4	6	59363	HEV-R-60750-R.125
	3/4	.125	2-1/4	5	6	59369	HEV-M-60750-R.125
	3/4	.125	2-3/4	5	6	59375	HEV-L-60750-R.125
	3/4	.125	3-1/4	6	6	83385	HEV-LX-60750-R.125
	3/4	.190	1	3	6	59358	HEV-S-60750-R.190
	3/4	.190	1-5/8	4	6	59364	HEV-R-60750-R.190
	3/4	.190	2-1/4	5	6	59370	HEV-M-60750-R.190
	3/4	.190	2-3/4	5	6	59376	HEV-L-60750-R.190
	3/4	.250	1	3	6	59359	HEV-S-60750-R.250
	3/4	.250	1-5/8	4	6	59365	HEV-R-60750-R.250
	3/4	.250	2-1/4	5	6	59371	HEV-M-60750-R.250
	3/4	.250	2-3/4	5	6	59377	HEV-L-60750-R.250
	3/4	.250	3-1/4	6	6	83323	HEV-LX-60750-R.250
1	1	.030	2	4-1/2	6	59379	HEV-R-61000-R.030
	1	.030	2-5/8	5	6	59383	HEV-M-61000-R.030
	1	.030	3-1/4	6	6	59387	HEV-L-61000-R.030
	1	.060	2	4-1/2	6	59380	HEV-R-61000-R.060
	1	.060	2-5/8	5	6	59384	HEV-M-61000-R.060
	1	.060	3-1/4	6	6	59388	HEV-L-61000-R.060
	1	.125	2	4-1/2	6	59381	HEV-R-61000-R.125
	1	.125	2-5/8	5	6	59385	HEV-M-61000-R.125
	1	.125	3-1/4	6	6	59389	HEV-L-61000-R.125
	1	.250	2	4-1/2	6	59382	HEV-R-61000-R.250
	1	.250	2-5/8	5	6	59386	HEV-M-61000-R.250
	1	.250	3-1/4	6	6	59390	HEV-L-61000-R.250

*.0005 max TIR

6 FLUTE - CORNER RADIUS - METRIC

Variable Pitch


MHEV-6
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 ±.01 mm ±.005 mm	Shank Diameter D2 H8	Corner Radius R +.05 mm -.05 mm	Length of Cut L2 +.30 mm -.30 mm	Overall Length L1 +1.5 mm -1.5 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	6	59575	MHEV-015-60600-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	6	59593	MHEV-020-60600-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	6	59627	MHEV-030-60600-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	6	59576	MHEV-015-60600-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	6	59594	MHEV-020-60600-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	6	59628	MHEV-030-60600-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	6	59578	MHEV-015-60800-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	6	59596	MHEV-020-60800-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	6	59630	MHEV-030-60800-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	6	59579	MHEV-015-60800-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	6	59597	MHEV-020-60800-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	6	59631	MHEV-030-60800-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	6	59581	MHEV-015-61000-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	6	59599	MHEV-020-61000-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	6	59613	MHEV-025-61000-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	6	59582	MHEV-015-61000-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	6	59600	MHEV-020-61000-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	6	59614	MHEV-025-61000-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	6	59584	MHEV-015-61200-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	6	59602	MHEV-020-61200-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	6	59616	MHEV-025-61200-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	6	59585	MHEV-015-61200-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	6	59603	MHEV-020-61200-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	6	59617	MHEV-025-61200-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	6	59587	MHEV-015-61600-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	6	59605	MHEV-020-61600-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	6	59619	MHEV-025-61600-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	6	59588	MHEV-015-61600-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	6	59606	MHEV-020-61600-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	6	59620	MHEV-025-61600-R1.00
20 mm	20.00 mm	.50 mm	30.00 mm	89 mm	6	59590	MHEV-015-62000-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	6	59608	MHEV-020-62000-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	6	59622	MHEV-025-62000-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	6	59591	MHEV-015-62000-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	6	59609	MHEV-020-62000-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	6	59623	MHEV-025-62000-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	6	59611	MHEV-020-62500-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	6	59625	MHEV-025-62500-R1.00

* .013 mm max TIR



Speeds & Feeds on Page 167

HEV-RN-6



New Items!

6 FLUTE - SQUARE

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 233 for Tplus coating



Cutter Dia.* D1 $\pm .001$ D2 $\pm .001$	Shank Dia. D2 in/in	Length of Cut L2 $\pm .001$ D2 $\pm .001$	Overall Length L1 $\pm .001$ D2 $\pm .001$	Reach (LBS) L3	Neck Diameter L3	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	2	3/8	118	6	87506	HEV-RN-S-60125
	1/8	5/32	2	5/8	118	6	87507	HEV-RN-F-60125
	1/8	5/32	2-1/2	1	118	6	87508	HEV-RN-M-60125
3/16	3/16	7/32	2	1/2	178	6	87599	HEV-RN-S-60187
	3/16	7/32	2-1/2	1	178	6	87600	HEV-RN-F-60187
	3/16	7/32	3	1-1/2	178	6	87601	HEV-RN-M-60187
1/4	1/4	3/8	4	3/4	237	6	82597	HEV-RN-S-60250
	1/4	3/8	4	1-1/8	237	6	82598	HEV-RN-F-60250
	1/4	3/8	4	1-5/8	237	6	88594	HEV-RN-A-60250
	1/4	3/8	4	2-1/8	237	6	82599	HEV-RN-M-60250
3/8	3/8	1/2	4	1-1/8	356	6	82600	HEV-RN-S-60375
	3/8	1/2	4	1-5/8	356	6	88595	HEV-RN-SR-60375
	3/8	1/2	4	2-1/8	356	6	82601	HEV-RN-F-60375
	3/8	1/2	6	2-1/2	356	6	88596	HEV-RN-A-60375
	3/8	1/2	6	3-1/8	356	6	82602	HEV-RN-M-60375
1/2	1/2	5/8	4	1-1/2	475	6	82603	HEV-RN-S-60500
	1/2	5/8	4	2-1/4	475	6	82604	HEV-RN-F-60500
	1/2	5/8	6	2-3/4	475	6	88597	HEV-RN-A-60500
	1/2	5/8	6	3-3/8	475	6	82605	HEV-RN-M-60500
	1/2	5/8	6	4-1/8	475	6	82606	HEV-RN-L-60500
5/8	5/8	3/4	4	1-5/8	593	6	88598	HEV-RN-S-60625
	5/8	3/4	6	2-3/8	593	6	88599	HEV-RN-F-60625
	5/8	3/4	6	3-3/8	593	6	88600	HEV-RN-M-60625
3/4	3/4	1	4	2	712	6	82607	HEV-RN-S-60750
	3/4	1	6	2-1/2	712	6	82608	HEV-RN-F-60750
	3/4	1	6	3-3/8	712	6	82609	HEV-RN-M-60750

* .0005 max.TIR



Speeds & Feeds on Page 167

6 FLUTE - BALL

New Items!



HEV-RN-6

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 234 for Tplus coating



Cutter Dia.* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (H6)	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Reach (LBS) L3	Neck Diameter L4	Flutes	Aplus Coated	Tool Description
1/8	1/8	5/32	2	3/8	.118	6	87602	HEV-RN-S-60125-BN
	1/8	5/32	2	5/8	.118	6	87603	HEV-RN-R-60125-BN
	1/8	5/32	2-1/2	1	.118	6	87604	HEV-RN-M-60125-BN
3/16	3/16	7/32	2	1/2	.178	6	87605	HEV-RN-S-60187-BN
	3/16	7/32	2-1/2	1	.178	6	87606	HEV-RN-R-60187-BN
	3/16	7/32	3	1-1/2	.178	6	87607	HEV-RN-M-60187-BN
1/4	1/4	3/8	4	3/4	.237	6	82634	HEV-RN-S-60250-BN
	1/4	3/8	4	1-1/8	.237	6	82635	HEV-RN-R-60250-BN
	1/4	3/8	4	1-5/8	.237	6	88601	HEV-RN-A-60250-BN
	1/4	3/8	4	2-1/8	.237	6	82636	HEV-RN-M-60250-BN
	1/4	3/8	4	2-1/2	.237	6	88602	HEV-RN-L-60250-BN
3/8	3/8	1/2	4	1-1/8	.356	6	82637	HEV-RN-S-60375-BN
	3/8	1/2	4	1-5/8	.356	6	88603	HEV-RN-SR-60375-BN
	3/8	1/2	4	2-1/8	.356	6	82638	HEV-RN-R-60375-BN
	3/8	1/2	6	2-1/2	.356	6	88604	HEV-RN-A-60375-BN
	3/8	1/2	6	3-1/8	.356	6	82639	HEV-RN-M-60375-BN
1/2	1/2	5/8	4	1-1/2	.475	6	82640	HEV-RN-S-60500-BN
	1/2	5/8	4	2-1/4	.475	6	82641	HEV-RN-R-60500-BN
	1/2	5/8	6	2-3/4	.475	6	88605	HEV-RN-A-60500-BN
	1/2	5/8	6	3-3/8	.475	6	82642	HEV-RN-M-60500-BN
	1/2	5/8	6	4-1/8	.475	6	82643	HEV-RN-L-60500-BN
5/8	5/8	3/4	4	1-5/8	.593	6	88606	HEV-RN-S-60625-BN
	5/8	3/4	6	2-3/8	.593	6	88607	HEV-RN-R-60625-BN
	5/8	3/4	6	3-3/8	.593	6	88608	HEV-RN-M-60625-BN
3/4	3/4	1	4	2	.712	6	82644	HEV-RN-S-60750-BN
	3/4	1	6	2-1/2	.712	6	82645	HEV-RN-R-60750-BN
	3/4	1	6	3-3/8	.712	6	82646	HEV-RN-M-60750-BN

* .0005 max TIR



Speeds & Feeds on Page 167

HEV-RN-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 235 for Tplus coating



	Cutter Dia.* D1 $\pm .001$ -.002	Shank Dia. D2 H9	Corner Radius R $\pm .001$ -.002	LOC L2 $\pm .001$ -.002	OAL L1 $\pm .001$ -.002	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
new	1/8	1/8	.010	5/32	2	3/8	.118	6	88609	HEV-RN-S-60125-R.010
new		1/8	.010	5/32	2	5/8	.118	6	88610	HEV-RN-R-60125-R.010
new		1/8	.010	5/32	2-1/2	1	.118	6	88611	HEV-RN-M-60125-R.010
new	3/16	3/16	.010	7/32	2	1/2	.178	6	88612	HEV-RN-S-60187-R.010
new		3/16	.010	7/32	2-1/2	1	.178	6	88613	HEV-RN-R-60187-R.010
new		3/16	.010	7/32	3	1-1/2	.178	6	88614	HEV-RN-L-60187-R.010
new	1/4	1/4	.020	3/8	4	3/4	.237	6	82610	HEV-RN-S-60250-R.020
new		1/4	.020	3/8	4	1-1/8	.237	6	82611	HEV-RN-R-60250-R.020
new		1/4	.020	3/8	4	1-5/8	.237	6	88615	HEV-RN-A-60250-R.020
new		1/4	.020	3/8	4	2-1/8	.237	6	82612	HEV-RN-M-60250-R.020
new		1/4	.030	3/8	4	3/4	.237	6	88616	HEV-RN-S-60250-R.030
new		1/4	.030	3/8	4	1-1/8	.237	6	88617	HEV-RN-R-60250-R.030
new		1/4	.030	3/8	4	1-5/8	.237	6	88618	HEV-RN-A-60250-R.030
new		1/4	.030	3/8	4	2-1/8	.237	6	88619	HEV-RN-M-60250-R.030
new	3/8	3/8	.020	1/2	4	1-1/8	.356	6	82613	HEV-RN-S-60375-R.020
new		3/8	.020	1/2	4	1-5/8	.356	6	88620	HEV-RN-SR-60375-R.020
new		3/8	.020	1/2	4	2-1/8	.356	6	82614	HEV-RN-R-60375-R.020
new		3/8	.020	1/2	6	3-1/8	.356	6	82615	HEV-RN-M-60375-R.020
new		3/8	.030	1/2	4	1-1/8	.356	6	88621	HEV-RN-S-60375-R.030
new		3/8	.030	1/2	4	1-5/8	.356	6	88622	HEV-RN-SR-60375-R.030
new		3/8	.030	1/2	4	2-1/8	.356	6	88623	HEV-RN-R-60375-R.030
new		3/8	.030	1/2	6	3-1/8	.356	6	88624	HEV-RN-M-60375-R.030

*.0005 max TIR

continued on next page



Speeds & Feeds on Page 167

6 FLUTE - CORNER RADIUS

New Items!



HEV-RN-6

Variable Pitch - Reduced Neck (cont.)

continued from previous page

Cutter Dia.* D ₁ ^{+0.01"} -0.02"	Shank Dia. D ₂ H9	Corner Radius R ^{+0.02"} -0.02"	LOC L ₂ ^{+0.02"} -0.00"	OAL L ₁ ^{+0.02"} -0.00"	Reach (LBS) L ₃	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/2	1/2	.030	5/8	4	1-1/2	.475	0	32616	HEV-RN-S-60500-R.030
	1/2	.030	5/8	4	2-1/4	.475	0	32617	HEV-RN-R-60500-R.030
	1/2	.030	5/8	6	2-3/4	.475	0	32625	HEV-RN-A-60500-R.030
	1/2	.030	5/8	6	3-3/8	.475	0	32618	HEV-RN-M-60500-R.030
	1/2	.030	5/8	6	4-1/8	.475	0	32619	HEV-RN-L-60500-R.030
	1/2	.060	5/8	4	1-1/2	.475	0	32620	HEV-RN-S-60500-R.060
	1/2	.060	5/8	4	2-1/4	.475	0	32621	HEV-RN-R-60500-R.060
	1/2	.060	5/8	6	2-3/4	.475	0	32626	HEV-RN-A-60500-R.060
	1/2	.060	5/8	6	3-3/8	.475	0	32622	HEV-RN-M-60500-R.060
	1/2	.060	5/8	6	4-1/8	.475	0	32623	HEV-RN-L-60500-R.060
	1/2	.125	5/8	4	1-1/2	.475	0	32624	HEV-RN-S-60500-R.125
	1/2	.125	5/8	4	2-1/4	.475	0	32625	HEV-RN-R-60500-R.125
	1/2	.125	5/8	6	2-3/4	.475	0	32627	HEV-RN-A-60500-R.125
	1/2	.125	5/8	6	3-3/8	.475	0	32628	HEV-RN-M-60500-R.125
	1/2	.125	5/8	6	4-1/8	.475	0	32627	HEV-RN-L-60500-R.125
5/8	5/8	.030	3/4	4	1-5/8	.503	0	32628	HEV-RN-S-60625-R.030
	5/8	.030	3/4	6	2-3/8	.503	0	32629	HEV-RN-R-60625-R.030
	5/8	.030	3/4	6	3-3/8	.503	0	32630	HEV-RN-M-60625-R.030
3/4	3/4	.030	1	4	2	.712	0	32628	HEV-RN-S-60750-R.030
	3/4	.030	1	6	2-1/2	.712	0	32629	HEV-RN-R-60750-R.030
	3/4	.030	1	6	3-3/8	.712	0	32630	HEV-RN-M-60750-R.030
	3/4	.030	1	6	4-1/8	.712	0	32631	HEV-RN-L-60750-R.030
	3/4	.060	1	4	2	.712	0	32631	HEV-RN-S-60750-R.060
	3/4	.060	1	6	2-1/2	.712	0	32632	HEV-RN-R-60750-R.060
	3/4	.060	1	6	3-3/8	.712	0	32633	HEV-RN-M-60750-R.060
	3/4	.060	1	6	4-1/8	.712	0	32632	HEV-RN-L-60750-R.060

*.0005 max TIR

HEV-6



SPEEDS & FEEDS

6 Flute - Variable Pitch

HEV-6 / HEV-RN-6

Material Guide		Hardness	SPM	Inches per Tooth (IPT)															
				1/8		3/16		1/4		5/16		3/8		1/2		3/4		1	
				Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A105	< 75 HRB 75 - 95 HRB 21 - 38 HRC	455 445 400	.0014 .0010 .0007	.0017 .0014 .0012	.0020 .0015 .0010	.0019 .0016 .0013	.0028 .0020 .0013	.0022 .0018 .0015	.0041 .0030 .0020	.0025 .0021 .0017	.0054 .0039 .0025	.0029 .0025 .0020	.0077 .0058 .0036	.0034 .0026 .0024	.0099 .0072 .0047	.0042 .0036 .0029		
	LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 65XX, 93XX	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC > 50 HRC	390 340 360 155	.0009 .0007 .0006 .0005	.0013 .0011 .0011 .0010	.0013 .0010 .0008 .0007	.0015 .0013 .0012 .0011	.0018 .0013 .0011 .0009	.0017 .0015 .0014 .0012	.0026 .0020 .0017 .0013	.0020 .0017 .0016 .0014	.0034 .0025 .0018 .0016	.0023 .0020 .0018 .0015	.0049 .0036 .0032 .0025	.0027 .0023 .0022 .0018	.0063 .0047 .0041 .0032	.0033 .0028 .0027 .0024	
		TOOL STEEL	A2, H13, L6, P30, S7	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC > 50 HRC	340 290 145 85	.0009 .0007 .0006 .0005	.0013 .0012 .0011 .0010	.0013 .0010 .0008 .0007	.0015 .0013 .0012 .0011	.0018 .0014 .0011 .0009	.0017 .0015 .0014 .0012	.0026 .0021 .0018 .0013	.0020 .0017 .0015 .0013	.0034 .0027 .0018 .0014	.0023 .0020 .0018 .0015	.0049 .0038 .0030 .0025	.0027 .0024 .0022 .0018	.0063 .0050 .0039 .0032	.0033 .0029 .0026 .0023
SPECIALTY STEEL			508M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRB 75 - 95 HRB 21 - 38 HRC 36 - 50 HRC > 50 HRC	290 255 175 150 55	.0012 .0009 .0007 .0006 .0004	.0015 .0013 .0012 .0011 .0009	.0017 .0012 .0010 .0009 .0008	.0017 .0014 .0013 .0013 .0010	.0023 .0016 .0015 .0014 .0009	.0020 .0016 .0015 .0014 .0011	.0034 .0023 .0021 .0018 .0012	.0022 .0019 .0018 .0017 .0013	.0045 .0031 .0027 .0025 .0015	.0026 .0022 .0020 .0019 .0015	.0064 .0044 .0039 .0035 .0022	.0031 .0026 .0025 .0023 .0018	.0082 .0056 .0051 .0045 .0028	.0038 .0031 .0030 .0028 .0022
	AUSTENITIC STAINLESS STEEL		Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 20-7MO, 316, 316L, 321, 347	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC	285 225 180	.0009 .0008 .0008	.0013 .0013 .0011	.0013 .0011 .0009	.0015 .0014 .0012	.0017 .0016 .0012	.0017 .0016 .0014	.0025 .0023 .0018	.0019 .0018 .0016	.0033 .0030 .0024	.0023 .0021 .0019	.0048 .0043 .0034	.0027 .0026 .0023	.0061 .0055 .0044	.0033 .0031 .0028
		MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 442, 446	75 - 95 HRB 21 - 38 HRC	300 280	.0009 .0008	.0013 .0013	.0013 .0011	.0015 .0014	.0018 .0016	.0017 .0016	.0026 .0023	.0020 .0018	.0034 .0030	.0023 .0021	.0049 .0043	.0027 .0025	.0063 .0055	.0033 .0031
PH STAINLESS STEEL			15-5, 17-4, Carpenter 450, Carpenter 465	21 - 38 HRC 36 - 50 HRC	290 145	.0007 .0005	.0011 .0011	.0010 .0008	.0013 .0012	.0013 .0011	.0015 .0014	.0018 .0017	.0017 .0016	.0025 .0022	.0020 .0018	.0036 .0031	.0023 .0022	.0046 .0040	.0028 .0027
	GRAY CAST IRON		SAE J431, ASTM A48	75 - 95 HRB 21 - 38 HRC	410 270	.0014 .0009	.0017 .0013	.0021 .0011	.0019 .0014	.0029 .0016	.0022 .0016	.0042 .0023	.0025 .0018	.0055 .0030	.0029 .0021	.0079 .0043	.0038 .0025	.0102 .0055	.0042 .0031
		MALLEABLE CAST IRON	ASTM A47, ASTM A229, ASTM A602	75 - 95 HRB 21 - 38 HRC	345 335	.0009 .0008	.0014 .0013	.0013 .0011	.0015 .0014	.0018 .0016	.0017 .0016	.0027 .0023	.0020 .0018	.0035 .0030	.0023 .0021	.0050 .0043	.0028 .0026	.0065 .0056	.0034 .0031
NODULAR (DUCTILE) CAST IRON			ASTM A536, ASTM A577	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC	310 290 135	.0009 .0009 .0004	.0014 .0011 .0009	.0014 .0009 .0006	.0015 .0013 .0010	.0019 .0012 .0009	.0018 .0014 .0011	.0028 .0019 .0012	.0020 .0017 .0013	.0036 .0024 .0015	.0024 .0019 .0015	.0052 .0035 .0022	.0028 .0025 .0018	.0067 .0044 .0028	.0034 .0029 .0022
	PURE NICKEL		Nickel 200, Nickel 301	< 75 HRB 75 - 95 HRB	285 250	.0012 .0010	.0016 .0014	.0018 .0015	.0018 .0016	.0024 .0020	.0020 .0018	.0036 .0030	.0023 .0021	.0047 .0039	.0027 .0025	.0067 .0056	.0032 .0029	.0066 .0055	.0039 .0036
		NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy Rat-41, Inconel 718, Incoloy 28	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC	80 75 70	.0008 .0006 .0005	.0011 .0011 .0010	.0008 .0008 .0007	.0013 .0012 .0010	.0013 .0012 .0010	.0014 .0014 .0013	.0018 .0017 .0015	.0018 .0016 .0015	.0024 .0023 .0020	.0019 .0019 .0017	.0034 .0033 .0028	.0023 .0023 .0021	.0044 .0042 .0036	.0028 .0027 .0025
PURE TITANIUM			Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB 75 - 95 HRB 21 - 38 HRC	300 275 290	.0017 .0014 .0011	.0019 .0017 .0015	.0024 .0021 .0015	.0021 .0019 .0017	.0033 .0028 .0021	.0024 .0022 .0019	.0048 .0041 .0031	.0027 .0025 .0022	.0065 .0054 .0041	.0032 .0029 .0025	.0081 .0079 .0068	.0038 .0038 .0030	.0119 .0100 .0075	.0048 .0042 .0036
	TITANIUM ALLOY		Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 38 HRC 36 - 50 HRC	180 160	.0009 .0008	.0013 .0012	.0013 .0011	.0015 .0014	.0017 .0016	.0017 .0016	.0024 .0022	.0019 .0018	.0032 .0029	.0022 .0021	.0046 .0042	.0027 .0025	.0059 .0054	.0032 .0031
		COBALT ALLOY	ASTM F902, ASTM F903, ASTM F75, ASTM F799	75 - 95 HRB 21 - 38 HRC 36 - 50 HRC	210 170 95	.0007 .0007 .0005	.0012 .0012 .0010	.0010 .0010 .0007	.0013 .0013 .0011	.0014 .0014 .0009	.0015 .0015 .0012	.0021 .0020 .0014	.0018 .0017 .0014	.0027 .0026 .0019	.0021 .0020 .0017	.0039 .0038 .0028	.0024 .0024 .0020	.0050 .0048 .0033	.0030 .0029 .0023

MILLING PROCESS	HARDNESS	DOC	DOC
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	15%-25% Diameter
	≥ 35 HRC	Up to Max LOC	15%-25% Diameter
Fin (Finishing)	NA	Up to Max LOC	4%-6% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

7 FLUTE - SQUARE

New Items!



HEV-7

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 236 for Tplus coating



Cutter Diameter* $D_1 \begin{smallmatrix} +.0005 \\ -.0005 \end{smallmatrix}$	Shank Diameter $D_2 \text{ (H6)}$	Length of Cut $L_2 \begin{smallmatrix} +.001 \\ -.001 \end{smallmatrix}$	Overall Length $L_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	7	94414	HEV-S-70125
	1/8	3/8	2	7	94415	HEV-S8-70125
	1/8	1/2	2-1/2	7	94416	HEV-R-70125
	1/8	5/8	2-1/2	7	94417	HEV-A-70125
	1/8	3/4	2-1/2	7	99652	HEV-M-70125
3/16	3/16	5/16	2	7	94418	HEV-S-70187
	3/16	7/16	2	7	94419	HEV-S8-70187
	3/16	9/16	2-1/2	7	94420	HEV-R-70187
	3/16	3/4	2-1/2	7	94421	HEV-M-70187
	3/16	1	3	7	99653	HEV-L-70187
1/4	1/4	3/8	2	7	26107	HEV-S-70250
	1/4	1/2	2	7	26122	HEV-S8-70250
	1/4	3/4	2-1/2	7	26137	HEV-R-70250
	1/4	1	3	7	26152	HEV-M-70250
	1/4	1-1/4	3	7	92647	HEV-L-70250
5/16	5/16	7/16	2	7	92648	HEV-S-70312
	5/16	3/4	2-1/2	7	92649	HEV-R-70312
	5/16	1	3	7	92650	HEV-M-70312
	5/16	1-1/4	3	7	99654	HEV-L-70312
3/8	3/8	1/2	2	7	26212	HEV-S-70375
	3/8	3/4	2-1/2	7	26227	HEV-S8-70375
	3/8	1	2-1/2	7	26242	HEV-R-70375
	3/8	1-1/4	3	7	99655	HEV-M-70375
	3/8	1-1/2	3-1/2	7	26247	HEV-L-70375
	3/8	2	4	7	92651	HEV-LX-70375
1/2	1/2	5/8	2-1/2	7	26257	HEV-S-70500
	1/2	1	3	7	26272	HEV-S8-70500
	1/2	1-1/4	3	7	26287	HEV-R-70500
	1/2	1-5/8	4	7	26302	HEV-M-70500
	1/2	2	4	7	26307	HEV-L-70500
	1/2	2-1/2	5	7	92652	HEV-LX-70500
	1/2	3-1/8	6	7	92653	HEV-X-70500

* .0005 max TIR

continued on next page



HEV-7



New Items!

7 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ - .002	Shank Diameter D2 (in)	Length of Cut L2 $\pm .032$ - .002	Overall Length L1 $\pm .063$ - .002	Flutes	Applus Coated	Tool Description
5/8	5/8	3/4	3	7	26317	HEV-S-70625
	5/8	1-1/4	3-1/2	7	26322	HEV-SR-70625
	5/8	1-5/8	4	7	26332	HEV-R-70625
	5/8	2-1/8	4	7	26347	HEV-M-70625
	5/8	2-1/2	5	7	83373	HEV-L-70625
3/4	3/4	1	3	7	26362	HEV-S-70750
	3/4	1-1/4	3-1/2	7	26367	HEV-SR-70750
	3/4	1-5/8	4	7	26377	HEV-R-70750
	3/4	2-1/4	5	7	26382	HEV-M-70750
	3/4	2-3/4	5	7	83374	HEV-L-70750
	3/4	3-1/4	6	7	82654	HEV-LX-70750
1	1	1-1/4	4	7	26407	HEV-S-71000
	1	2	5	7	26422	HEV-R-71000
	1	2-5/8	5	7	83465	HEV-M-71000
	1	3-1/4	6	7	26442	HEV-L-71000

* .0005 max TIR



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7 FLUTE - SQUARE - METRIC

Variable Pitch


MHEV-7
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{0.01}{0.005}$ mm	Shank Diameter D2 H6	Length of Cut L2 $\pm \frac{0.01}{0.005}$ mm	Overall Length L1 $\pm \frac{0.01}{0.005}$ mm	Flutes	Aplus Coated	Tool Description
6 mm	8.00 mm	9.00 mm	65 mm	7	59632	MHEV-015-70600
	8.00 mm	12.00 mm	65 mm	7	59650	MHEV-020-70600
	8.00 mm	18.00 mm	65 mm	7	59684	MHEV-030-70600
8 mm	8.00 mm	12.00 mm	65 mm	7	59635	MHEV-015-70800
	8.00 mm	16.00 mm	65 mm	7	59653	MHEV-020-70800
	8.00 mm	24.00 mm	75 mm	7	59687	MHEV-030-70800
10 mm	10.00 mm	15.00 mm	65 mm	7	59638	MHEV-015-71000
	10.00 mm	20.00 mm	65 mm	7	59656	MHEV-020-71000
	10.00 mm	25.00 mm	75 mm	7	59670	MHEV-025-71000
12 mm	12.00 mm	18.00 mm	75 mm	7	59641	MHEV-015-71200
	12.00 mm	24.00 mm	75 mm	7	59659	MHEV-020-71200
	12.00 mm	30.00 mm	75 mm	7	59673	MHEV-025-71200
16 mm	16.00 mm	24.00 mm	88 mm	7	59644	MHEV-015-71600
	16.00 mm	32.00 mm	89 mm	7	59662	MHEV-020-71600
	16.00 mm	40.00 mm	88 mm	7	59676	MHEV-025-71600
20 mm	20.00 mm	30.00 mm	89 mm	7	59647	MHEV-015-72000
	20.00 mm	40.00 mm	100 mm	7	59665	MHEV-020-72000
	20.00 mm	60.00 mm	125 mm	7	59679	MHEV-025-72000
25 mm	25.00 mm	50.00 mm	125 mm	7	59668	MHEV-020-72500
	25.00 mm	84.00 mm	125 mm	7	59682	MHEV-025-72500

* D13 mm max TIR



HEV-7



7 FLUTE - CORNER RADIUS

Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates

- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 238 for Tplus coating



Cutter Diameter* D1 $\pm \frac{.001}{.002}$ "	Shank Diameter D2 $\pm .001$ "	Corner Radius R $\pm \frac{.001}{.002}$ "	Length of Cut L2 $\pm \frac{.001}{.002}$ "	Overall Length L1 $\pm \frac{.001}{.002}$ "	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	7	84422	HEV-S-70125-R.010
	1/8	.010	3/8	2	7	84423	HEV-SR-70125-R.010
	1/8	.010	1/2	2-1/2	7	84424	HEV-R-70125-R.010
	1/8	.010	5/8	2-1/2	7	84425	HEV-A-70125-R.010
	1/8	.030	1/4	1-1/2	7	84426	HEV-S-70125-R.030
	1/8	.030	3/8	2	7	84427	HEV-SR-70125-R.030
	1/8	.030	1/2	2-1/2	7	84428	HEV-R-70125-R.030
	1/8	.030	5/8	2-1/2	7	84429	HEV-A-70125-R.030
3/16	3/16	.010	5/16	2	7	84430	HEV-S-70187-R.010
	3/16	.010	7/16	2	7	84431	HEV-SR-70187-R.010
	3/16	.010	9/16	2-1/2	7	84432	HEV-R-70187-R.010
	3/16	.010	3/4	2-1/2	7	84433	HEV-M-70187-R.010
	3/16	.030	5/16	2	7	84434	HEV-S-70187-R.030
	3/16	.030	7/16	2	7	84435	HEV-SR-70187-R.030
	3/16	.030	9/16	2-1/2	7	84436	HEV-R-70187-R.030
	3/16	.030	3/4	2-1/2	7	84437	HEV-M-70187-R.030
1/4	1/4	.010	3/8	2	7	83376	HEV-S-70250-R.010
	1/4	.010	1/2	2	7	83377	HEV-SR-70250-R.010
	1/4	.010	3/4	2-1/2	7	83378	HEV-R-70250-R.010
	1/4	.010	1	3	7	83379	HEV-M-70250-R.010
	1/4	.010	1-1/4	3	7	86040	HEV-L-70250-R.010
	1/4	.020	3/8	2	7	27107	HEV-S-70250-R.020
	1/4	.020	1/2	2	7	27122	HEV-SR-70250-R.020
	1/4	.020	3/4	2-1/2	7	27137	HEV-R-70250-R.020
	1/4	.020	1	3	7	27152	HEV-M-70250-R.020
	1/4	.020	1-1/4	3	7	82655	HEV-L-70250-R.020
	1/4	.020	1-1/2	3	7	86041	HEV-LX-70250-R.020
	1/4	.030	3/8	2	7	87106	HEV-S-70250-R.030
	1/4	.030	1/2	2	7	87107	HEV-SR-70250-R.030
	1/4	.030	3/4	2-1/2	7	87108	HEV-R-70250-R.030
	1/4	.030	1	3	7	87109	HEV-M-70250-R.030
	1/4	.030	1-1/4	3	7	87110	HEV-L-70250-R.030
	1/4	.060	3/8	2	7	81807	HEV-S-70250-R.060
	1/4	.060	1/2	2	7	81808	HEV-SR-70250-R.060
	1/4	.060	3/4	2-1/2	7	81809	HEV-R-70250-R.060
	1/4	.060	1	3	7	81810	HEV-M-70250-R.060
	1/4	.060	1-1/4	3	7	87111	HEV-L-70250-R.060

* .0005 max TIR

continued on next page

7 FLUTE - CORNER RADIUS

Variable Pitch (cont.)



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continued from previous page

Outer Diameter* D1 $^{+0.005}_{-0.005}$	Shank Diameter D2 (in)	Corner Radius R $^{+0.005}_{-0.005}$	Length of Cut L1 $^{+0.025}_{-0.005}$	Overall Length L1 $^{+0.025}_{-0.025}$	Flutes	Apex Coated	Tool Description
3/8	3/8	.010	1/2	2	7	83380	HEV-S-70375-R.010
	3/8	.010	3/4	2-1/2	7	83381	HEV-SR-70375-R.010
	3/8	.010	1	2-1/2	7	83382	HEV-R-70375-R.010
	3/8	.010	1-1/4	3	7	86042	HEV-M-70375-R.010
	3/8	.010	1-1/2	3-1/2	7	83383	HEV-L-70375-R.010
	3/8	.020	1/2	2	7	27212	HEV-S-70375-R.020
	3/8	.020	3/4	2-1/2	7	27227	HEV-SR-70375-R.020
	3/8	.020	1	2-1/2	7	27242	HEV-R-70375-R.020
	3/8	.020	1-1/4	3	7	87112	HEV-M-70375-R.020
	3/8	.020	1-1/2	3-1/2	7	27247	HEV-L-70375-R.020
	3/8	.030	2	4	7	82656	HEV-LX-70375-R.030
	3/8	.030	1/2	2	7	87113	HEV-S-70375-R.030
	3/8	.030	3/4	2-1/2	7	87114	HEV-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87115	HEV-R-70375-R.030
	3/8	.030	1-1/4	3	7	87116	HEV-M-70375-R.030
	3/8	.030	1-1/2	3-1/2	7	87117	HEV-L-70375-R.030
	3/8	.060	1/2	2	7	81811	HEV-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	81812	HEV-SR-70375-R.060
	3/8	.060	1	2-1/2	7	81813	HEV-R-70375-R.060
	3/8	.060	1-1/4	3	7	87118	HEV-M-70375-R.060
	3/8	.060	1-1/2	3-1/2	7	87119	HEV-L-70375-R.060
	3/8	.125	1/2	2	7	87120	HEV-S-70375-R.125
	3/8	.125	3/4	2-1/2	7	87121	HEV-SR-70375-R.125
	3/8	.125	1	2-1/2	7	87122	HEV-R-70375-R.125
	3/8	.125	1-1/4	3	7	87123	HEV-M-70375-R.125
	3/8	.125	1-1/2	3-1/2	7	87124	HEV-L-70375-R.125
1/2	1/2	.010	5/8	2-1/2	7	83384	HEV-S-70500-R.010
	1/2	.010	1	3	7	83385	HEV-SR-70500-R.010
	1/2	.010	1-1/4	3	7	83386	HEV-R-70500-R.010
	1/2	.010	1-5/8	4	7	83387	HEV-M-70500-R.010
	1/2	.010	2	4	7	83388	HEV-L-70500-R.010
	1/2	.010	2-1/2	5	7	87125	HEV-LX-70500-R.010
	1/2	.020	5/8	2-1/2	7	81814	HEV-S-70500-R.020
	1/2	.020	1	3	7	81815	HEV-SR-70500-R.020
	1/2	.020	1-1/4	3	7	81816	HEV-R-70500-R.020
	1/2	.020	1-5/8	4	7	81817	HEV-M-70500-R.020
	1/2	.020	2	4	7	81818	HEV-L-70500-R.020
	1/2	.020	2-1/2	5	7	87126	HEV-LX-70500-R.020
	1/2	.030	5/8	2-1/2	7	27257	HEV-S-70500-R.030
	1/2	.030	1	3	7	27272	HEV-SR-70500-R.030
	1/2	.030	1-1/4	3	7	27287	HEV-R-70500-R.030
	1/2	.030	1-5/8	4	7	27302	HEV-M-70500-R.030
	1/2	.030	2	4	7	27307	HEV-L-70500-R.030
	1/2	.030	2-1/2	5	7	82657	HEV-LX-70500-R.030
	1/2	.030	3-1/8	6	7	82658	HEV-X-70500-R.030

* .0005 max. TR

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7 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H6)	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L2 $\pm \frac{.002}{.002}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Apex Coated	Tool Description
1/2	1/2	.060	5/8	2-1/2	7	81819	HEV-S-70500-R.060
	1/2	.060	1	3	7	81820	HEV-SR-70500-R.060
	1/2	.060	1-1/4	3	7	81821	HEV-R-70500-R.060
	1/2	.060	1-5/8	4	7	81822	HEV-M-70500-R.060
	1/2	.060	2	4	7	81823	HEV-L-70500-R.060
	1/2	.060	2-1/2	5	7	87127	HEV-LX-70500-R.060
	1/2	.125	5/8	2-1/2	7	87128	HEV-S-70500-R.125
	1/2	.125	1	3	7	87129	HEV-SR-70500-R.125
	1/2	.125	1-1/4	3	7	87130	HEV-R-70500-R.125
	1/2	.125	1-5/8	4	7	87131	HEV-M-70500-R.125
	1/2	.125	2	4	7	87132	HEV-L-70500-R.125
5/8	5/8	.010	3/4	3	7	87133	HEV-S-70625-R.010
	5/8	.010	1-1/4	3-1/2	7	87134	HEV-SR-70625-R.010
	5/8	.010	1-5/8	4	7	87135	HEV-R-70625-R.010
	5/8	.010	2-1/8	4	7	87136	HEV-M-70625-R.010
	5/8	.030	3/4	3	7	27317	HEV-S-70625-R.030
	5/8	.030	1-1/4	3-1/2	7	27322	HEV-SR-70625-R.030
	5/8	.030	1-5/8	4	7	27332	HEV-R-70625-R.030
	5/8	.030	2-1/8	4	7	27347	HEV-M-70625-R.030
	5/8	.030	2-1/2	5	7	82659	HEV-L-70625-R.030
	5/8	.060	3/4	3	7	86043	HEV-S-70625-R.060
	5/8	.060	1-1/4	3-1/2	7	81824	HEV-SR-70625-R.060
3/4	3/4	.030	1	3	7	27362	HEV-S-70750-R.030
	3/4	.030	1-1/4	3-1/2	7	27367	HEV-SR-70750-R.030
	3/4	.030	1-5/8	4	7	27377	HEV-R-70750-R.030
	3/4	.030	2-1/4	5	7	27382	HEV-M-70750-R.030
	3/4	.030	2-3/4	5	7	82660	HEV-L-70750-R.030
	3/4	.030	3-1/4	6	7	82661	HEV-LX-70750-R.030
	3/4	.060	1	3	7	81826	HEV-S-70750-R.060
	3/4	.060	1-5/8	4	7	81827	HEV-R-70750-R.060
	3/4	.060	2-1/4	5	7	81828	HEV-M-70750-R.060
	3/4	.060	2-3/4	5	7	86045	HEV-L-70750-R.060
	3/4	.060	3-1/4	6	7	87137	HEV-LX-70750-R.060
	3/4	.125	1	3	7	87138	HEV-S-70750-R.125
	3/4	.125	1-5/8	4	7	87139	HEV-R-70750-R.125
	3/4	.125	2-1/4	5	7	87140	HEV-M-70750-R.125
	3/4	.250	1	3	7	87141	HEV-S-70750-R.250
	3/4	.250	1-5/8	4	7	87142	HEV-R-70750-R.250
	3/4	.250	2-1/4	5	7	87143	HEV-M-70750-R.250
1	1	.030	1-1/4	4	7	27407	HEV-S-71000-R.030
	1	.030	2	5	7	27422	HEV-R-71000-R.030
	1	.030	2-5/8	5	7	86046	HEV-M-71000-R.030
	1	.030	3-1/4	6	7	27442	HEV-L-71000-R.030
	1	.030	4-1/4	7	7	86047	HEV-LX-71000-R.030

* .0005 max TR

7 FLUTE - CORNER RADIUS - METRIC

Variable Pitch


MHEV-7
METRIC

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- h8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +0.05 \text{ mm} \\ -0.05 \text{ mm} \end{smallmatrix}$	Shank Diameter D2 h8	Corner Radius R $\begin{smallmatrix} +0.05 \text{ mm} \\ -0.05 \text{ mm} \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +0.05 \text{ mm} \\ -0.05 \text{ mm} \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +1.00 \text{ mm} \\ -1.00 \text{ mm} \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	7	50633	MHEV-015-70600-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	7	50651	MHEV-020-70600-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	7	50685	MHEV-030-70600-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	7	50634	MHEV-015-70600-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	7	50652	MHEV-020-70600-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	7	50686	MHEV-030-70600-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	7	50636	MHEV-015-70800-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	7	50654	MHEV-020-70800-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	7	50688	MHEV-030-70800-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	7	50637	MHEV-015-70800-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	7	50655	MHEV-020-70800-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	7	50689	MHEV-030-70800-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	7	50639	MHEV-015-71000-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	7	50657	MHEV-020-71000-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	7	50671	MHEV-025-71000-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	7	50640	MHEV-015-71000-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	7	50658	MHEV-020-71000-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	7	50672	MHEV-025-71000-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	7	50642	MHEV-015-71200-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	7	50660	MHEV-020-71200-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	7	50674	MHEV-025-71200-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	7	50643	MHEV-015-71200-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	7	50661	MHEV-020-71200-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	7	50675	MHEV-025-71200-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	7	50645	MHEV-015-71600-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	7	50663	MHEV-020-71600-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	7	50677	MHEV-025-71600-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	7	50646	MHEV-015-71600-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	7	50664	MHEV-020-71600-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	7	50678	MHEV-025-71600-R1.00

*.013 mm max TIR

continued on next page



MHEV-7
 METRIC

7 FLUTE - CORNER RADIUS - METRIC

Variable Pitch (cont.)

continued from previous page

Cutter Diameter [*] D1 $\begin{smallmatrix} +.00 \text{ mm} \\ -.05 \text{ mm} \end{smallmatrix}$	Shank Diameter D2 #6	Corner Radius R $\begin{smallmatrix} +.05 \text{ mm} \\ -.05 \text{ mm} \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.80 \text{ mm} \\ -.30 \text{ mm} \end{smallmatrix}$	Overall Length L3 $\begin{smallmatrix} +1.60 \text{ mm} \\ -.1.00 \text{ mm} \end{smallmatrix}$	Flutes	Applus Coated	Tool Description
20 mm	20.00 mm	.50 mm	50.00 mm	89 mm	7	59648	MHEV-015-72000-R0.50
	20.00 mm	.50 mm	40.00 mm	108 mm	7	59666	MHEV-020-72000-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	7	59680	MHEV-025-72000-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	7	59649	MHEV-015-72000-R1.00
	20.00 mm	1.00 mm	40.00 mm	108 mm	7	59667	MHEV-020-72000-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	7	59681	MHEV-025-72000-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	7	59669	MHEV-020-72500-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	7	59683	MHEV-025-72500-R1.00

^{*} .013 mm max TIR

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7 FLUTE - SQUARE

Variable Pitch – Reduced Neck


HEV-RN-7

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .001$ $\pm .002$	Shank Dia. D2 H6	Length of Cut L2 $\pm .001$ $\pm .002$	Overall Length L1 $\pm .001$ $\pm .002$	Reach (L3) L3	Neck Diameter	Flutes	Aplus Coated	Tool Description
1/4	1/4	3/4	4	1-1/8	.237	7	83045	HEV-RNR-R-70250
	1/4	3/4	4	2-1/8	.237	7	83046	HEV-RNR-M-70250
3/8	3/8	1	4	2-1/8	.356	7	83047	HEV-RNR-R-70375
	3/8	1	6	3-1/8	.356	7	83048	HEV-RNR-M-70375
1/2	1/2	1-1/4	4	2-1/4	.475	7	83049	HEV-RNR-R-70500
	1/2	1-1/4	6	3-3/8	.475	7	83050	HEV-RNR-M-70500
	1/2	1-1/4	6	4-1/8	.475	7	83051	HEV-RNR-L-70500
3/4	3/4	1-5/8	6	2-1/2	.712	7	83052	HEV-RNR-R-70750
	3/4	1-5/8	6	3-3/8	.712	7	83053	HEV-RNR-M-70750

* .0005 max TR



HEV-RN-7



7 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in deep pocket High Efficiency Milling (HEM) applications
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- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.0012 \end{smallmatrix}$	Shank Dia. D2 $\begin{smallmatrix} +.0000 \\ 0 \end{smallmatrix}$	Corner Radius R $\begin{smallmatrix} +.0020 \\ -.0020 \end{smallmatrix}$	LDC L2 $\begin{smallmatrix} +.0020 \\ -.0020 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.0020 \\ -.0020 \end{smallmatrix}$	Reach (LBS) L3	Neck Dia.	Flutes	Aplus Coated	Tool Description
1/4	1/4	.020	3/4	4	1-1/8	.237	7	83054	HEV-RN-R-70250-R.020
	1/4	.020	3/4	4	2-1/8	.237	7	83055	HEV-RN-M-70250-R.020
3/8	3/8	.020	1	4	2-1/8	.356	7	83056	HEV-RN-R-70375-R.020
	3/8	.020	1	6	3-1/8	.356	7	83057	HEV-RN-M-70375-R.020
1/2	1/2	.030	1-1/4	4	2-1/4	.475	7	83058	HEV-RN-R-70500-R.030
	1/2	.030	1-1/4	6	3-3/8	.475	7	83059	HEV-RN-M-70500-R.030
	1/2	.030	1-1/4	6	4-1/8	.475	7	83060	HEV-RN-L-70500-R.030
	1/2	.060	1-1/4	4	2-1/4	.475	7	83061	HEV-RN-R-70500-R.060
	1/2	.060	1-1/4	6	3-3/8	.475	7	83062	HEV-RN-M-70500-R.060
	1/2	.060	1-1/4	6	4-1/8	.475	7	83063	HEV-RN-L-70500-R.060
3/4	3/4	.030	1-5/8	6	2-1/2	.712	7	83064	HEV-RN-R-70750-R.030
	3/4	.030	1-5/8	6	3-3/8	.712	7	83065	HEV-RN-M-70750-R.030
	3/4	.060	1-5/8	6	2-1/2	.712	7	83066	HEV-RN-R-70750-R.060
	3/4	.060	1-5/8	6	3-3/8	.712	7	83067	HEV-RN-M-70750-R.060

* .0005 max TIR



SPEEDS & FEEDS

7 Flute - Variable Pitch



HEV-7

HEV-7 / HEV-RN-7

Material Guide		Hardness	IPM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		5/8		1/2		3/4		1	
				Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	455	.0018	.0017	.0024	.0019	.0031	.0022	.0047	.0025	.0060	.0029	.0087	.0035	.0111	.0043
		75 - 98 HRB	445	.0011	.0015	.0017	.0016	.0023	.0019	.0034	.0022	.0044	.0025	.0064	.0030	.0081	.0036
		21 - 35 HRC	400	.0007	.0012	.0011	.0013	.0015	.0015	.0022	.0017	.0028	.0020	.0041	.0024	.0053	.0029
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 80XX, 93XX	75 - 98 HRB	390	.0013	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 35 HRC	340	.0007	.0012	.0011	.0013	.0015	.0015	.0022	.0017	.0028	.0020	.0041	.0024	.0052	.0029
		36 - 50 HRC	350	.0006	.0011	.0010	.0012	.0013	.0014	.0019	.0016	.0025	.0019	.0036	.0023	.0046	.0027
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	155	.0005	.0010	.0008	.0011	.0010	.0013	.0015	.0014	.0020	.0017	.0028	.0020	.0036	.0024
		75 - 98 HRB	340	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 35 HRC	290	.0008	.0012	.0012	.0013	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
SPECIALTY STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	75 - 98 HRB	290	.0013	.0016	.0020	.0018	.0026	.0020	.0039	.0023	.0050	.0027	.0072	.0032	.0092	.0039
		15 - 98 HRB	255	.0009	.0013	.0014	.0014	.0016	.0017	.0027	.0019	.0034	.0022	.0050	.0027	.0069	.0032
		21 - 35 HRC	175	.0008	.0012	.0012	.0014	.0016	.0016	.0024	.0018	.0031	.0021	.0045	.0025	.0057	.0030
AUSTENITIC STAINLESS STEEL	Nitoron 50, Nitoron 80, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	< 75 HRB	290	.0013	.0016	.0020	.0018	.0026	.0020	.0039	.0023	.0050	.0027	.0072	.0032	.0092	.0039
		15 - 98 HRB	255	.0009	.0013	.0014	.0014	.0016	.0017	.0027	.0019	.0034	.0022	.0050	.0027	.0069	.0032
		21 - 35 HRC	225	.0009	.0013	.0013	.0015	.0017	.0016	.0026	.0019	.0033	.0022	.0048	.0026	.0062	.0032
FERRITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB	300	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 35 HRC	250	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0033	.0022	.0048	.0026	.0061	.0032
		36 - 50 HRC	180	.0007	.0012	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0049	.0028
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 480	75 - 98 HRB	300	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 35 HRC	250	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0033	.0022	.0048	.0026	.0061	.0032
		36 - 50 HRC	145	.0006	.0011	.0010	.0012	.0013	.0014	.0019	.0016	.0024	.0019	.0035	.0022	.0045	.0027
GRAY CAST IRON	SAE J431, ASTM A48	75 - 98 HRB	410	.0016	.0017	.0024	.0020	.0032	.0022	.0048	.0026	.0062	.0030	.0090	.0036	.0114	.0043
		21 - 35 HRC	270	.0008	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0033	.0022	.0049	.0026	.0062	.0032
		36 - 50 HRC	145	.0006	.0011	.0010	.0012	.0013	.0014	.0019	.0016	.0024	.0019	.0035	.0022	.0045	.0027
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A302	75 - 98 HRB	345	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0039	.0024	.0057	.0028	.0072	.0034
		21 - 35 HRC	325	.0006	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0034	.0022	.0049	.0026	.0062	.0032
		36 - 50 HRC	110	.0011	.0014	.0016	.0016	.0021	.0018	.0032	.0021	.0041	.0024	.0059	.0029	.0075	.0035
MODULAR (DUCTILE) CAST IRON	ASTM A236, ASTM A507	75 - 98 HRB	310	.0011	.0014	.0016	.0016	.0021	.0018	.0032	.0021	.0041	.0024	.0059	.0029	.0075	.0035
		21 - 35 HRC	250	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0050	.0028
		36 - 50 HRC	135	.0005	.0009	.0007	.0010	.0009	.0012	.0013	.0014	.0017	.0016	.0025	.0019	.0032	.0023
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0014	.0016	.0021	.0018	.0027	.0020	.0041	.0023	.0052	.0027	.0076	.0033	.0097	.0040
		75 - 98 HRB	250	.0011	.0015	.0017	.0016	.0023	.0019	.0034	.0021	.0044	.0025	.0064	.0030	.0081	.0036
		21 - 35 HRC	80	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0049	.0028
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0049	.0028
		21 - 35 HRC	75	.0007	.0011	.0010	.0012	.0013	.0014	.0020	.0016	.0025	.0019	.0037	.0023	.0047	.0026
		36 - 50 HRC	70	.0006	.0010	.0008	.0011	.0011	.0013	.0017	.0015	.0022	.0018	.0032	.0021	.0040	.0026
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		75 - 98 HRB	275	.0010	.0017	.0024	.0019	.0031	.0022	.0047	.0025	.0060	.0030	.0088	.0035	.0112	.0043
		21 - 35 HRC	250	.0012	.0015	.0018	.0017	.0023	.0019	.0035	.0022	.0046	.0028	.0066	.0031	.0084	.0037
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 11V-2Fe-3Al	75 - 98 HRB	180	.0009	.0013	.0014	.0016	.0018	.0017	.0026	.0020	.0036	.0023	.0052	.0027	.0066	.0033
		21 - 35 HRC	160	.0009	.0013	.0013	.0014	.0017	.0016	.0025	.0019	.0033	.0022	.0047	.0026	.0060	.0031
		36 - 50 HRC	210	.0008	.0012	.0012	.0014	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
COBALT ALLOY	ASTM F802, ASTM F90, ASTM F75, ASTM F700	75 - 98 HRB	170	.0008	.0012	.0012	.0014	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
		21 - 35 HRC	170	.0008	.0012	.0012	.0014	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
		36 - 50 HRC	88	.0006	.0010	.0008	.0011	.0010	.0013	.0015	.0014	.0020	.0017	.0029	.0020	.0037	.0024

MILING PROCESS	HARDNESS	ADDC	RDOC
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	10%-15% Diameter
	≥ 35 HRC	Up to Max LOC	10%-15% Diameter
Fin (Finishing)	NA	Up to Max LOC	4%-6% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B

HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.

HEF-5

5 FLUTE - SQUARE
Finisher

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed with 5 flutes for excellent performance in roughing, High Efficiency Milling (HEM), and finishing (including thin wall applications)
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* $D1 \begin{smallmatrix} +.001 \\ -.002 \end{smallmatrix}$	Shank Diameter $D2 \text{ (H8)}$	Length of Cut $L2 \begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length $L1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	5	05807	HEF-S-50125
	1/8	3/8	2	5	81802	HEF-SR-50125
	1/8	1/2	2-1/2	5	05822	HEF-R-50125
	1/8	5/8	2-1/2	5	81803	HEF-M-50125
	1/8	3/4	2-1/2	5	05837	HEF-L-50125
3/16	3/16	5/16	2	5	05867	HEF-S-50187
	3/16	7/16	2	5	81804	HEF-SR-50187
	3/16	9/16	2-1/2	5	05882	HEF-R-50187
	3/16	3/4	2-1/2	5	05887	HEF-M-50187
	3/16	1	2-1/2	5	81805	HEF-L-50187
1/4	1/4	3/8	2	5	05127	HEF-S-50250
	1/4	1/2	2-1/2	5	05132	HEF-SR-50250
	1/4	3/4	2-1/2	5	05142	HEF-R-50250
	1/4	1	3	5	05157	HEF-M-50250
	1/4	1-1/4	3	5	05172	HEF-L-50250
	1/4	1-3/4	4	5	05182	HEF-X-50250
5/16	5/16	7/16	2	5	05202	HEF-S-50312
	5/16	13/16	2-1/2	5	05217	HEF-R-50312
	5/16	1	3	5	05232	HEF-M-50312
	5/16	1-1/4	3	5	05247	HEF-L-50312
	5/16	2-1/8	4	5	05262	HEF-X-50312
3/8	3/8	1/2	2	5	05282	HEF-S-50375
	3/8	3/4	2-1/2	5	81806	HEF-SR-50375
	3/8	1	3	5	05307	HEF-R-50375
	3/8	1-1/4	3	5	05322	HEF-M-50375
	3/8	1-1/2	3-1/2	5	05337	HEF-L-50375
	3/8	2	4	5	05352	HEF-LX-50375
	3/8	2-1/2	5	5	05367	HEF-X-50375
7/16	7/16	9/16	2-3/4	5	05387	HEF-S-50437
	7/16	1	2-3/4	5	05412	HEF-R-50437
	7/16	2	4	5	05427	HEF-L-50437

* .0005 max. TIR

continued on next page



5 FLUTE - SQUARE

Finisher (cont.)



HEF-5

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L2 $\begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Applus Coated	Tool Description
1/2	1/2	5/8	2-1/2	5	05457	HEF-S-50500
	1/2	1	3	5	05472	HEF-SR-50500
	1/2	1-1/4	3	5	05487	HEF-R-50500
	1/2	1-5/8	4	5	05502	HEF-M-50500
	1/2	2	4	5	05517	HEF-L-50500
	1/2	2-1/2	5	5	05532	HEF-LX-50500
	1/2	3-1/8	6	5	05547	HEF-X-50500
5/8	5/8	3/4	3	5	05607	HEF-S-50625
	5/8	1-5/8	3-1/2	5	05622	HEF-R-50625
	5/8	2-1/8	4	5	05637	HEF-M-50625
	5/8	2-1/2	5	5	05652	HEF-L-50625
	5/8	3-1/4	6	5	05667	HEF-LX-50625
	5/8	4	6	5	05682	HEF-X-50625
3/4	3/4	1	3	5	05697	HEF-S-50750
	3/4	1-5/8	4	5	05712	HEF-R-50750
	3/4	2-1/4	5	5	05727	HEF-M-50750
	3/4	2-3/4	5	5	05742	HEF-ML-50750
	3/4	3-1/2	6	5	05757	HEF-L-50750
	3/4	4	6	5	05772	HEF-X-50750
1	1	1-1/4	4	5	05882	HEF-S-51000
	1	2	4-1/2	5	05877	HEF-R-51000
	1	2-5/8	5	5	05892	HEF-M-51000
	1	3-1/4	6	5	05907	HEF-L-51000
	1	4-1/8	7	5	05922	HEF-X-51000

* .0005 max TIR

HEF-5



SPEEDS & FEEDS

5 Flute - Finisher

HEF-5																	
Material Guide		Hardness	DPM	Inches Per Tooth (IPT)													
				1/8		3/16		1/4		3/8		1/2		3/4		1	
				Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12XXL, ASTM A27, ASTM A58	< 75 HRB	455	.0010	.0019	.0023	.0022	.0031	.0024	.0040	.0028	.0061	.0035	.0087	.0039	.0111	.0047
		75 - 98 HRB	445	.0012	.0018	.0017	.0018	.0023	.0021	.0034	.0024	.0044	.0028	.0064	.0033	.0081	.0040
		21 - 38 HRC	430	.0008	.0013	.0011	.0015	.0015	.0017	.0022	.0019	.0029	.0022	.0041	.0027	.0053	.0025
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB	390	.0010	.0015	.0015	.0017	.0020	.0019	.0029	.0022	.0038	.0026	.0055	.0031	.0070	.0036
		21 - 38 HRC	340	.0008	.0012	.0011	.0014	.0015	.0017	.0022	.0019	.0029	.0023	.0041	.0027	.0052	.0023
		36 - 52 HRC	280	.0007	.0012	.0009	.0014	.0013	.0016	.0019	.0018	.0025	.0021	.0036	.0025	.0048	.0020
TOOL STEEL	A2, H13, L6, P20, S7	75 - 98 HRB	340	.0010	.0015	.0015	.0017	.0020	.0019	.0029	.0022	.0038	.0026	.0055	.0031	.0070	.0036
		21 - 38 HRC	290	.0008	.0014	.0012	.0015	.0016	.0017	.0023	.0020	.0031	.0023	.0044	.0028	.0056	.0024
		36 - 52 HRC	145	.0006	.0012	.0009	.0013	.0012	.0015	.0018	.0017	.0024	.0020	.0034	.0024	.0044	.0025
SPECIALTY STEEL	303M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	< 75 HRB	290	.0013	.0017	.0019	.0020	.0026	.0022	.0038	.0026	.0060	.0030	.0072	.0035	.0092	.0043
		75 - 98 HRB	285	.0009	.0014	.0013	.0016	.0018	.0018	.0026	.0021	.0038	.0026	.0050	.0029	.0063	.0026
		21 - 38 HRC	175	.0008	.0014	.0012	.0015	.0016	.0018	.0024	.0020	.0031	.0023	.0044	.0028	.0067	.0024
AUSTENITIC STAINLESS STEEL	303M, 304, 304L, Inconel 20-7MO, 316, 316L, 321, 347	75 - 98 HRB	285	.0010	.0015	.0014	.0017	.0019	.0019	.0029	.0022	.0037	.0026	.0054	.0031	.0069	.0037
		21 - 38 HRC	225	.0009	.0014	.0013	.0016	.0017	.0018	.0026	.0021	.0034	.0024	.0040	.0029	.0062	.0026
		36 - 52 HRC	180	.0007	.0013	.0010	.0014	.0014	.0016	.0021	.0019	.0027	.0022	.0039	.0026	.0060	.0022
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 440, 440	75 - 98 HRB	330	.0010	.0015	.0015	.0017	.0020	.0019	.0029	.0022	.0038	.0026	.0055	.0031	.0070	.0036
		21 - 38 HRC	290	.0009	.0014	.0013	.0016	.0017	.0018	.0026	.0021	.0034	.0024	.0040	.0029	.0062	.0026
		36 - 52 HRC	145	.0006	.0012	.0009	.0013	.0012	.0015	.0018	.0017	.0024	.0020	.0034	.0024	.0044	.0025
RH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 38 HRC	200	.0007	.0013	.0011	.0014	.0015	.0017	.0022	.0019	.0028	.0022	.0041	.0028	.0052	.0022
		36 - 52 HRC	145	.0006	.0012	.0009	.0014	.0013	.0016	.0019	.0018	.0024	.0021	.0035	.0025	.0045	.0020
		75 - 98 HRB	410	.0016	.0019	.0024	.0022	.0032	.0024	.0048	.0028	.0062	.0033	.0089	.0039	.0114	.0048
GRAY CAST IRON	SAE J431, ASTM A48	21 - 38 HRC	370	.0009	.0014	.0013	.0016	.0017	.0018	.0026	.0021	.0034	.0025	.0049	.0029	.0062	.0026
		75 - 98 HRB	345	.0010	.0015	.0015	.0017	.0020	.0019	.0029	.0022	.0038	.0026	.0055	.0031	.0070	.0036
		21 - 38 HRC	335	.0009	.0014	.0013	.0016	.0017	.0018	.0026	.0021	.0034	.0025	.0049	.0029	.0062	.0026
MALLEABLE CAST IRON	ASTM A27, ASTM A220, ASTM A602	75 - 98 HRB	310	.0011	.0016	.0016	.0017	.0021	.0020	.0031	.0023	.0041	.0027	.0059	.0032	.0075	.0036
		21 - 38 HRC	280	.0007	.0013	.0010	.0014	.0014	.0016	.0021	.0019	.0027	.0022	.0039	.0026	.0060	.0022
		36 - 52 HRC	135	.0005	.0010	.0007	.0011	.0009	.0013	.0015	.0015	.0017	.0017	.0025	.0021	.0052	.0025
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 80T	75 - 98 HRB	310	.0011	.0016	.0016	.0017	.0021	.0020	.0031	.0023	.0041	.0027	.0059	.0032	.0075	.0036
		21 - 38 HRC	280	.0007	.0013	.0010	.0014	.0014	.0016	.0021	.0019	.0027	.0022	.0039	.0026	.0060	.0022
		36 - 52 HRC	135	.0005	.0010	.0007	.0011	.0009	.0013	.0015	.0015	.0017	.0017	.0025	.0021	.0052	.0025
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0014	.0018	.0020	.0020	.0027	.0023	.0040	.0026	.0063	.0030	.0076	.0038	.0097	.0044
		75 - 98 HRB	250	.0012	.0016	.0017	.0018	.0023	.0021	.0034	.0024	.0044	.0028	.0063	.0033	.0081	.0040
		21 - 38 HRC	80	.0007	.0013	.0010	.0014	.0014	.0016	.0021	.0019	.0027	.0022	.0039	.0026	.0060	.0022
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Rene 41, Inconel 718, Inconel 29	21 - 38 HRC	75	.0007	.0012	.0010	.0014	.0014	.0016	.0020	.0018	.0026	.0021	.0037	.0025	.0047	.0021
		36 - 52 HRC	70	.0006	.0011	.0009	.0013	.0011	.0015	.0017	.0017	.0023	.0020	.0032	.0023	.0041	.0020
		75 - 98 HRB	390	.0016	.0021	.0028	.0024	.0037	.0027	.0056	.0031	.0073	.0036	.0104	.0043	.0134	.0052
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	75 - 98 HRB	275	.0016	.0019	.0023	.0022	.0032	.0024	.0047	.0028	.0061	.0033	.0087	.0039	.0112	.0048
		21 - 38 HRC	250	.0012	.0017	.0017	.0019	.0024	.0021	.0035	.0024	.0046	.0028	.0060	.0034	.0084	.0041
		36 - 52 HRC	180	.0009	.0016	.0014	.0017	.0019	.0019	.0028	.0023	.0038	.0026	.0052	.0030	.0068	.0027
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 38 HRC	180	.0009	.0016	.0014	.0017	.0019	.0019	.0028	.0023	.0038	.0026	.0052	.0030	.0068	.0027
		36 - 52 HRC	180	.0009	.0014	.0012	.0016	.0017	.0018	.0025	.0021	.0033	.0024	.0047	.0029	.0060	.0025
		75 - 98 HRB	210	.0008	.0013	.0012	.0015	.0016	.0017	.0023	.0020	.0031	.0023	.0044	.0028	.0056	.0024
COPALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	21 - 38 HRC	170	.0008	.0013	.0011	.0015	.0015	.0017	.0023	.0020	.0031	.0023	.0044	.0028	.0054	.0023
		36 - 52 HRC	65	.0005	.0011	.0008	.0012	.0010	.0014	.0015	.0016	.0020	.0019	.0029	.0023	.0057	.0027
		< 75 HRB	210	.0008	.0013	.0012	.0015	.0016	.0017	.0023	.0020	.0031	.0023	.0044	.0028	.0056	.0024

MILLING PROCESS	HARDNESS	ADOC	IDOC
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	5%-25% Diameter
	≥ 35 HRC	Up to Max LOC	10%-25% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B

HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

7 FLUTE - SQUARE

Finisher



HSF-7

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/4	1/4	3/8	2	7	24017	HSF-S-70250
	1/4	1/2	2-1/2	7	24022	HSF-SA-70250
	1/4	3/4	2-1/2	7	24032	HSF-R-70250
	1/4	1-1/4	3	7	24047	HSF-L-70250
	1/4	1-3/4	4	7	24062	HSF-X-70250
5/16	5/16	7/16	2	7	24062	HSF-S-70312
	5/16	13/16	2-1/2	7	24107	HSF-R-70312
	5/16	1-5/8	3-1/2	7	24122	HSF-L-70312
	5/16	2	4	7	24137	HSF-X-70312
	5/16	2-1/2	5	7	24212	HSF-X-70312
3/8	3/8	1/2	2	7	24167	HSF-S-70375
	3/8	7/8	2-1/2	7	24182	HSF-SA-70375
	3/8	1	3	7	24187	HSF-R-70375
	3/8	1-1/2	3-1/2	7	24197	HSF-L-70375
	3/8	2-1/2	5	7	24212	HSF-X-70375
7/16	7/16	9/16	2-3/4	7	24242	HSF-S-70437
	7/16	1	2-3/4	7	24257	HSF-R-70437
	7/16	1-1/2	3-1/2	7	24272	HSF-M-70437
1/2	1/2	3/4	2-1/2	7	24317	HSF-S-70500
	1/2	1	2-1/2	7	81829	HSF-SA-70500
	1/2	1-1/4	3	7	24332	HSF-R-70500
	1/2	1-5/8	3-1/2	7	81830	HSF-M-70500
	1/2	2	4	7	24347	HSF-L-70500
	1/2	2-1/2	5	7	81831	HSF-LX-70500
	1/2	3-1/4	6	7	24362	HSF-X-70500
5/8	5/8	3/4	3	7	24382	HSF-S-70625
	5/8	1-5/8	4	7	24407	HSF-R-70625
	5/8	2	4	7	24422	HSF-M-70625
3/4	3/4	1	3	7	24467	HSF-S-70750
	3/4	1-5/8	4	7	24482	HSF-R-70750
	3/4	2-1/4	5	7	24497	HSF-M-70750
	3/4	3-1/4	6	7	24512	HSF-L-70750
1	1	1-1/4	4	7	24542	HSF-S-71000
	1	2	4-1/2	7	24557	HSF-R-71000
	1	3-1/4	6	7	24572	HSF-M-71000
	1	4-1/8	7	7	24587	HSF-X-71000
1-1/4	1-1/4	2	4-1/2	7	24617	HSF-R-71250
	1-1/4	2-5/8	5-1/2	7	24632	HSF-M-71250
	1-1/4	3-1/4	6	7	24647	HSF-L-71250
	1-1/4	5	7-1/2	7	24662	HSF-X-71250

* .0005 max TIR



Speeds & Feeds on Page 183

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SPEEDS & FEEDS

7 Flute - Finisher

HSF-7

Material Grade	Hardness	SPM	Feet Per Tooth (IPT)													
			1/8		3/16		1/4		3/8		1/2		3/4		1	
			Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A28	< 70 HRB	450	.0017	.0019	.0020	.0022	.0024	.0024	.0025	.0028	.0027	.0030	.0029	.0033	.0047
	75 - 90 HRB	445	.0013	.0016	.0019	.0018	.0020	.0021	.0020	.0024	.0024	.0026	.0027	.0030	.0030	.0040
	21 - 36 HRC	400	.0008	.0013	.0013	.0015	.0016	.0017	.0024	.0019	.0021	.0022	.0045	.0027	.0036	.0033
LOW ALLOY STEEL	11XX, 41XX, 43XX, 51XX, 60XX, 93XX	75 - 90 HRB	380	.0011	.0015	.0017	.0017	.0022	.0019	.0023	.0022	.0042	.0026	.0041	.0031	.0078
	21 - 36 HRC	340	.0008	.0013	.0012	.0014	.0016	.0017	.0024	.0019	.0021	.0023	.0046	.0027	.0038	.0033
	36 - 50 HRC	360	.0007	.0012	.0011	.0014	.0014	.0016	.0021	.0019	.0027	.0021	.0040	.0026	.0051	.0030
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	155	.0006	.0011	.0009	.0012	.0011	.0014	.0017	.0016	.0022	.0019	.0032	.0022	.0040
	75 - 90 HRB	340	.0011	.0015	.0017	.0017	.0022	.0019	.0023	.0022	.0042	.0026	.0041	.0031	.0078	.0038
	21 - 36 HRC	290	.0009	.0014	.0013	.0015	.0017	.0017	.0026	.0020	.0030	.0023	.0049	.0028	.0062	.0034
SPECIALTY STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	36 - 50 HRC	145	.0007	.0012	.0010	.0013	.0014	.0015	.0020	.0017	.0026	.0020	.0038	.0034	.0029
	> 50 HRC	85	.0006	.0011	.0008	.0012	.0011	.0014	.0017	.0016	.0022	.0019	.0031	.0022	.0040	.0027
	< 75 HRB	280	.0014	.0017	.0022	.0020	.0028	.0022	.0043	.0028	.0055	.0030	.0080	.0035	.0102	.0043
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 20-7MO, 316, 316L, 321, 347	75 - 90 HRB	280	.0011	.0015	.0018	.0017	.0021	.0019	.0022	.0022	.0041	.0026	.0040	.0031	.0078
	21 - 36 HRC	225	.0010	.0014	.0015	.0016	.0019	.0018	.0029	.0021	.0037	.0024	.0054	.0029	.0069	.0030
	36 - 50 HRC	180	.0008	.0013	.0012	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055	.0032
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 444	75 - 90 HRB	300	.0011	.0015	.0017	.0017	.0022	.0019	.0023	.0022	.0042	.0026	.0041	.0031	.0078
	21 - 36 HRC	280	.0010	.0014	.0015	.0016	.0019	.0018	.0029	.0021	.0037	.0024	.0054	.0029	.0069	.0030
	36 - 50 HRC	180	.0008	.0013	.0012	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055	.0032
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	200	.0008	.0013	.0012	.0014	.0016	.0017	.0024	.0019	.0031	.0022	.0043	.0028	.0057
	36 - 50 HRC	145	.0007	.0012	.0011	.0014	.0014	.0016	.0021	.0019	.0027	.0021	.0039	.0025	.0050	.0030
	75 - 90 HRB	410	.0018	.0019	.0027	.0022	.0035	.0024	.0053	.0028	.0068	.0033	.0099	.0039	.0127	.0048
GRAY CAST IRON	SAE J431, ASTM A46	21 - 36 HRC	370	.0010	.0014	.0015	.0016	.0018	.0029	.0021	.0037	.0025	.0054	.0029	.0069	.0030
	75 - 90 HRB	345	.0011	.0015	.0017	.0017	.0022	.0020	.0034	.0023	.0043	.0026	.0043	.0031	.0080	.0038
	21 - 36 HRC	335	.0010	.0014	.0015	.0016	.0019	.0018	.0029	.0021	.0037	.0025	.0054	.0029	.0069	.0030
MALLEABLE CAST IRON	ASTM A47, ASTM A229, ASTM A302	75 - 90 HRB	310	.0012	.0016	.0018	.0017	.0023	.0025	.0023	.0045	.0027	.0065	.0032	.0083	.0039
	21 - 36 HRC	280	.0008	.0013	.0012	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055	.0032
	36 - 50 HRC	135	.0005	.0010	.0008	.0011	.0010	.0013	.0015	.0015	.0019	.0017	.0028	.0021	.0035	.0025
NODULAR (DUCTILE) CAST IRON	ASTM A236, ASTM 607	< 75 HRB	285	.0015	.0018	.0023	.0020	.0030	.0023	.0045	.0025	.0068	.0030	.0084	.0038	.0107
	75 - 90 HRB	250	.0013	.0016	.0019	.0018	.0025	.0021	.0038	.0024	.0048	.0026	.0071	.0033	.0090	.0040
	21 - 36 HRC	200	.0008	.0013	.0012	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055	.0032
PURE NICKEL	Nickel 200, Nickel 201	75 - 90 HRB	80	.0008	.0013	.0012	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055
	21 - 36 HRC	70	.0007	.0012	.0011	.0014	.0015	.0016	.0023	.0019	.0030	.0023	.0043	.0028	.0055	.0032
	36 - 50 HRC	70	.0006	.0011	.0009	.0013	.0013	.0015	.0019	.0017	.0024	.0020	.0035	.0023	.0045	.0028
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 28	< 75 HRB	300	.0021	.0021	.0032	.0024	.0041	.0027	.0062	.0031	.0080	.0036	.0116	.0043	.0148
	75 - 90 HRB	275	.0018	.0019	.0027	.0022	.0035	.0024	.0053	.0028	.0067	.0033	.0097	.0039	.0124	.0048
	21 - 36 HRC	250	.0013	.0017	.0020	.0019	.0028	.0021	.0039	.0024	.0050	.0026	.0073	.0034	.0093	.0041
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	75 - 90 HRB	180	.0010	.0015	.0016	.0017	.0020	.0019	.0021	.0022	.0040	.0025	.0058	.0036	.0073
	21 - 36 HRC	160	.0010	.0014	.0014	.0016	.0019	.0018	.0026	.0021	.0036	.0024	.0053	.0029	.0067	.0035
	36 - 50 HRC	160	.0010	.0014	.0014	.0016	.0019	.0018	.0026	.0021	.0036	.0024	.0053	.0029	.0067	.0035
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 50Al-2Fe-3Al	75 - 90 HRB	210	.0009	.0013	.0013	.0015	.0017	.0017	.0025	.0020	.0033	.0023	.0048	.0028	.0062
	21 - 36 HRC	170	.0009	.0013	.0013	.0015	.0017	.0017	.0025	.0020	.0033	.0023	.0047	.0027	.0060	.0033
	36 - 50 HRC	85	.0006	.0011	.0009	.0012	.0011	.0014	.0017	.0016	.0022	.0019	.0032	.0023	.0041	.0027
COBALT ALLOY	ASTM F962, ASTM F93, ASTM F75, ASTM F139	< 75 HRB	300	.0021	.0021	.0032	.0024	.0041	.0027	.0062	.0031	.0080	.0036	.0116	.0043	.0148
	75 - 90 HRB	275	.0018	.0019	.0027	.0022	.0035	.0024	.0053	.0028	.0067	.0033	.0097	.0039	.0124	.0048
	21 - 36 HRC	250	.0013	.0017	.0020	.0019	.0028	.0021	.0039	.0024	.0050	.0026	.0073	.0034	.0093	.0041

MILLING PROCESS	HARDNESS	ADOC	ADOC
Rph (Traditional Roughing)	< 35 HRB	Up to Max LOC	10%-15% Diameter
	≥ 35 HRB	Up to Max LOC	10%-15% Diameter
Fin (Finishing)	NA	Up to Max LOC	4%-8% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

MULTI-FLUTE - CORNER RADIUS

New Items!



HXF

Finisher

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed with high flute count for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA

For increased wear resistance, see page 251 for Tplus coating



Cutter Diameter* D1 $\pm .002$ -.002"	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ -.002"	Length of Cut L2 $\pm .002$ -.002"	Overall Length L1 $\pm .002$ -.002"	Flutes	Aplus Coated	Tool Description	
1/4	1/4	.020	3/8	2	7	36016	HXF-S-070250-R.020	
	1/4	.020	1/2	2	7	31832	HXF-SR-070250-R.020	
	1/4	.020	3/4	2-1/2	7	36021	HXF-R-070250-R.020	
	1/4	.020	1	3	7	37752	HXF-M-070250-R.020	new
3/8	3/8	.020	1/2	2	7	36046	HXF-S-070275-R.020	
	3/8	.020	3/4	2-1/2	7	31833	HXF-SR-070275-R.020	
	3/8	.020	1	2	7	36061	HXF-R-070275-R.020	
	3/8	.020	1-1/4	3	7	31834	HXF-M-070275-R.020	
	3/8	.020	1-1/2	3-1/2	7	37754	HXF-L-070275-R.020	new
1/2	1/2	.010	5/8	2-1/2	8	37756	HXF-S-080500-R.010	new
	1/2	.010	1	2	8	37757	HXF-SR-080500-R.010	new
	1/2	.010	1-1/4	3	8	37758	HXF-R-080500-R.010	new
	1/2	.010	1-5/8	3-1/2	8	37759	HXF-M-080500-R.010	new
	1/2	.030	5/8	2-1/2	8	36076	HXF-S-080500-R.030	
	1/2	.030	1	2	8	36091	HXF-SR-080500-R.030	
	1/2	.030	1-1/4	3	8	36106	HXF-R-080500-R.030	
	1/2	.030	1-5/8	3-1/2	8	31835	HXF-M-080500-R.030	
	1/2	.030	2	3-1/2	8	31836	HXF-L-080500-R.030	
	1/2	.030	2	3-1/2	8	31836	HXF-L-080500-R.030	
5/8	5/8	.060	3/4	2	10	36121	HXF-S-100625-R.060	
	5/8	.060	1-5/8	3-1/2	10	36136	HXF-R-100625-R.060	
3/4	3/4	.060	1	2	12	36151	HXF-S-120750-R.060	
	3/4	.060	1-5/8	4	12	36166	HXF-R-120750-R.060	
	3/4	.060	2	4	12	31837	HXF-M-120750-R.060	
1	1	.060	1-1/4	4	14	36181	HXF-S-141000-R.060	
	1	.060	2	4-1/2	14	36196	HXF-R-141000-R.060	

* .0005 max TIR



HXF



SPEEDS & FEEDS

Multi-Flute - Corner Radius - Finisher

HXF																	
Material Data		Hardness	SPM	Inches Per Tooth (IPT)													
				1/8		3/16		1/4		5/16		3/8		1/2		3/4	
				Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	450	.0017	.0018	.0026	.0020	.0034	.0022	.0051	.0026	.0066	.0030	.0087	.0036	.0123	.0044
		75 - 95 HRC	445	.0012	.0015	.0019	.0017	.0025	.0019	.0038	.0022	.0048	.0026	.0071	.0031	.0090	.0037
		21 - 35 HRC	430	.0008	.0012	.0012	.0014	.0016	.0015	.0024	.0018	.0031	.0021	.0045	.0025	.0056	.0030
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 65XX, 69XX	75 - 95 HRC	380	.0011	.0014	.0017	.0016	.0021	.0018	.0033	.0021	.0041	.0024	.0061	.0029	.0078	.0035
		21 - 35 HRC	340	.0008	.0012	.0012	.0013	.0016	.0015	.0024	.0018	.0031	.0021	.0045	.0025	.0056	.0030
		96 - 99 HRC	260	.0007	.0011	.0011	.0013	.0014	.0014	.0021	.0017	.0027	.0019	.0040	.0023	.0050	.0028
TOOL STEEL	A2, H13, U5, P18, S7	> 95 HRC	155	.0006	.0010	.0009	.0011	.0011	.0013	.0017	.0015	.0021	.0017	.0031	.0020	.0040	.0025
		75 - 95 HRC	340	.0011	.0014	.0017	.0016	.0021	.0018	.0033	.0021	.0041	.0024	.0061	.0029	.0078	.0035
		21 - 35 HRC	290	.0009	.0012	.0013	.0014	.0017	.0016	.0026	.0018	.0033	.0021	.0049	.0025	.0062	.0031
SPECIALTY STEEL	309M, Invar 36, Kovar, Manganing 250, Manganing 250, Manganing 350, Manganing 350	96 - 99 HRC	145	.0007	.0011	.0011	.0012	.0013	.0014	.0020	.0016	.0026	.0019	.0038	.0023	.0048	.0027
		> 95 HRC	85	.0006	.0010	.0008	.0011	.0011	.0013	.0017	.0015	.0021	.0017	.0031	.0020	.0039	.0025
		75 - 95 HRC	290	.0011	.0014	.0017	.0016	.0021	.0018	.0033	.0021	.0041	.0024	.0061	.0029	.0078	.0035
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347	< 75 HRB	250	.0014	.0016	.0022	.0018	.0028	.0020	.0043	.0024	.0054	.0028	.0080	.0033	.0102	.0040
		75 - 95 HRC	255	.0010	.0013	.0015	.0015	.0019	.0017	.0029	.0019	.0037	.0023	.0055	.0027	.0070	.0033
		21 - 35 HRC	175	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0034	.0021	.0049	.0026	.0063	.0031
MARTENSITIC & FERRITIC STAINLESS STEEL	401, 410, 416, 420, 440, 438, 448	96 - 99 HRC	150	.0009	.0012	.0012	.0013	.0015	.0015	.0023	.0017	.0030	.0020	.0044	.0024	.0056	.0030
		> 95 HRC	95	.0005	.0009	.0007	.0010	.0009	.0012	.0014	.0014	.0018	.0016	.0027	.0019	.0034	.0023
		75 - 95 HRC	300	.0011	.0014	.0017	.0016	.0021	.0018	.0033	.0021	.0042	.0024	.0061	.0029	.0078	.0035
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 35 HRC	290	.0009	.0012	.0012	.0013	.0016	.0015	.0024	.0018	.0031	.0021	.0045	.0025	.0057	.0030
		96 - 99 HRC	145	.0007	.0011	.0011	.0013	.0014	.0014	.0021	.0016	.0027	.0019	.0038	.0023	.0049	.0028
		75 - 95 HRC	410	.0016	.0018	.0027	.0020	.0035	.0023	.0063	.0026	.0067	.0030	.0089	.0037	.0126	.0044
GRAY CAST IRON	SAE J431, ASTM A48	21 - 35 HRC	320	.0009	.0013	.0015	.0015	.0019	.0017	.0029	.0019	.0037	.0023	.0055	.0027	.0068	.0033
		75 - 95 HRC	345	.0011	.0014	.0017	.0016	.0022	.0018	.0034	.0021	.0043	.0024	.0063	.0029	.0080	.0036
		21 - 35 HRC	335	.0010	.0013	.0015	.0015	.0019	.0017	.0029	.0019	.0037	.0023	.0055	.0027	.0068	.0033
MALLEABLE CAST IRON	ASTM A47, ASTM A223, ASTM A229	75 - 95 HRC	310	.0012	.0015	.0018	.0016	.0023	.0018	.0035	.0021	.0044	.0025	.0065	.0029	.0083	.0036
		21 - 35 HRC	260	.0008	.0012	.0012	.0013	.0016	.0015	.0023	.0017	.0029	.0020	.0043	.0024	.0055	.0029
		96 - 99 HRC	125	.0005	.0009	.0008	.0010	.0010	.0012	.0015	.0014	.0019	.0016	.0027	.0019	.0035	.0023
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 697	< 75 HRB	285	.0015	.0017	.0023	.0019	.0029	.0021	.0045	.0024	.0057	.0028	.0084	.0034	.0107	.0041
		75 - 95 HRC	250	.0013	.0015	.0019	.0017	.0025	.0019	.0037	.0022	.0048	.0026	.0070	.0031	.0089	.0037
		21 - 35 HRC	90	.0008	.0012	.0012	.0013	.0016	.0015	.0023	.0017	.0029	.0020	.0043	.0024	.0054	.0029
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, René 41, Inconel 718, Inconel 281	75 - 95 HRC	75	.0007	.0012	.0011	.0013	.0014	.0015	.0022	.0017	.0028	.0020	.0041	.0025	.0052	.0028
		21 - 35 HRC	70	.0006	.0010	.0010	.0012	.0012	.0014	.0019	.0015	.0024	.0016	.0035	.0022	.0044	.0026
		96 - 99 HRC	70	.0006	.0010	.0010	.0012	.0012	.0014	.0019	.0015	.0024	.0016	.0035	.0022	.0044	.0026
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	360	.0020	.0019	.0031	.0022	.0041	.0025	.0062	.0028	.0079	.0033	.0116	.0038	.0147	.0048
		75 - 95 HRC	275	.0017	.0018	.0026	.0020	.0034	.0023	.0052	.0026	.0066	.0030	.0087	.0036	.0123	.0044
		21 - 35 HRC	250	.0013	.0015	.0020	.0017	.0025	.0020	.0038	.0022	.0050	.0026	.0073	.0031	.0093	.0038
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 95 HRC	180	.0010	.0014	.0016	.0015	.0020	.0017	.0031	.0020	.0039	.0023	.0057	.0028	.0073	.0034
		96 - 99 HRC	160	.0009	.0013	.0014	.0015	.0018	.0017	.0028	.0019	.0036	.0023	.0052	.0027	.0067	.0032
		21 - 35 HRC	210	.0009	.0012	.0013	.0014	.0017	.0016	.0026	.0018	.0033	.0022	.0049	.0026	.0062	.0031
COBALT ALLOY	ASTM F962, ASTM F963, ASTM F75, ASTM F799	75 - 95 HRC	170	.0008	.0012	.0013	.0014	.0017	.0016	.0025	.0018	.0032	.0021	.0047	.0025	.0060	.0030
		21 - 35 HRC	65	.0006	.0010	.0009	.0011	.0011	.0013	.0017	.0015	.0022	.0017	.0032	.0021	.0040	.0025
		96 - 99 HRC	65	.0006	.0010	.0009	.0011	.0011	.0013	.0017	.0015	.0022	.0017	.0032	.0021	.0040	.0025

MILLING PROCESS	HARDNESS	ADDC	RDOC
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	8%-15% Diameter
	≥ 35 HRC	Up to Max LOC	8%-15% Diameter
Fin (Finishing)	NA	Up to Max LOC	4%-5% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B

HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

4 FLUTE - CORNER RADIUS

HEVC-C-4

Coolant Through - Chipbreaker Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- 4 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tiplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.001 \\ -.012 \end{smallmatrix}$	Shank Diameter D2 (H6)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tiplus Coated	Tool Description
1/4	1/4	.020	1/2	2-1/2	4	84328	HEVC-C-020-40250-R.020
	1/4	.020	3/4	2-1/2	4	84329	HEVC-C-030-40250-R.020
	1/4	.030	1/2	2-1/2	4	84330	HEVC-C-020-40250-R.030
	1/4	.030	3/4	2-1/2	4	84331	HEVC-C-030-40250-R.030
3/8	3/8	.020	1/2	2	4	84332	HEVC-C-013-40375-R.020
	3/8	.020	1	3	4	84333	HEVC-C-026-40375-R.020
	3/8	.030	1/2	2	4	84334	HEVC-C-013-40375-R.030
	3/8	.030	1	3	4	84335	HEVC-C-026-40375-R.030
1/2	1/2	.030	1	3	4	84336	HEVC-C-020-40500-R.030
	1/2	.030	1-1/4	3	4	84337	HEVC-C-026-40500-R.030
	1/2	.030	1-5/8	4	4	84338	HEVC-C-032-40500-R.030
	1/2	.060	1	3	4	84339	HEVC-C-020-40500-R.060
	1/2	.060	1-1/4	3	4	84340	HEVC-C-026-40500-R.060
	1/2	.060	1-5/8	4	4	84341	HEVC-C-032-40500-R.060
3/4	3/4	.030	1-5/8	4	4	84342	HEVC-C-021-40750-R.030
	3/4	.030	2-1/4	5	4	84343	HEVC-C-030-40750-R.030

* .0005 max TIR



HEVC-C-4

SPEEDS & FEEDS

4 Flute - Corner Radius Coolant Through -
Chipbreaker Rougher - Variable Pitch

HEVC-C-4																	
Material Guide		Hardness	SFM	Inches per Tooth (IPT)													
				1/8		3/16		1/4		3/8		1/2		3/4		1	
				Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	455	.0007	.0013	.0011	.0019	.0014	.0025	.0021	.0037	.0028	.0049	.0040	.0070	.0058	.0099
		75 - 88 HRB	445	.0005	.0009	.0008	.0014	.0010	.0018	.0016	.0027	.0020	.0036	.0028	.0051	.0037	.0065
		21 - 36 HRC	400	.0005	.0006	.0006	.0009	.0007	.0012	.0010	.0016	.0013	.0023	.0019	.0033	.0024	.0042
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 68XX, 93XX	75 - 88 HRB	390	.0005	.0008	.0007	.0012	.0008	.0016	.0013	.0024	.0017	.0031	.0025	.0044	.0032	.0056
		21 - 36 HRC	340	.0005	.0006	.0006	.0009	.0007	.0012	.0010	.0016	.0013	.0023	.0019	.0033	.0024	.0042
		36 - 50 HRC	280	.0003	.0005	.0005	.0008	.0006	.0010	.0009	.0015	.0011	.0020	.0016	.0028	.0021	.0038
TOOL STEEL	A2, H13, L6, P20, S7	75 - 88 HRB	340	.0005	.0008	.0007	.0012	.0008	.0016	.0013	.0024	.0017	.0031	.0025	.0044	.0032	.0056
		21 - 36 HRC	250	.0004	.0006	.0005	.0009	.0007	.0013	.0011	.0019	.0014	.0025	.0020	.0035	.0025	.0045
		36 - 50 HRC	145	.0003	.0005	.0004	.0007	.0006	.0010	.0008	.0015	.0011	.0019	.0016	.0028	.0020	.0035
SPECIALTY STEEL	308M, Invar 36, Kovar, Managing 280, Managing 250, Managing 300, Managing 350	< 75 HRB	290	.0006	.0011	.0008	.0015	.0012	.0021	.0018	.0031	.0023	.0040	.0033	.0056	.0042	.0074
		75 - 88 HRB	255	.0004	.0007	.0006	.0011	.0008	.0014	.0012	.0021	.0016	.0028	.0023	.0040	.0028	.0051
		21 - 36 HRC	175	.0004	.0007	.0006	.0010	.0007	.0013	.0011	.0019	.0014	.0025	.0020	.0035	.0026	.0040
AUSTENITIC STAINLESS STEEL	Nitinol 50, Nitinol 60, 901, 304, 304L, Inconel 21-7MO, 316, 316L, 321, 347	75 - 88 HRB	305	.0004	.0008	.0007	.0012	.0008	.0016	.0013	.0023	.0017	.0030	.0024	.0043	.0031	.0055
		21 - 36 HRC	225	.0004	.0007	.0006	.0010	.0008	.0014	.0012	.0021	.0015	.0027	.0022	.0039	.0028	.0048
		36 - 50 HRC	180	.0003	.0005	.0005	.0008	.0006	.0011	.0009	.0017	.0012	.0022	.0018	.0031	.0023	.0040
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 442, 444	75 - 88 HRB	300	.0005	.0008	.0007	.0012	.0008	.0016	.0013	.0024	.0018	.0031	.0025	.0044	.0032	.0057
		21 - 36 HRC	280	.0004	.0007	.0006	.0010	.0008	.0014	.0012	.0021	.0015	.0027	.0022	.0039	.0028	.0048
		36 - 50 HRC	200	.0003	.0005	.0005	.0008	.0007	.0012	.0010	.0017	.0013	.0023	.0018	.0033	.0024	.0041
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	200	.0003	.0005	.0005	.0008	.0007	.0012	.0010	.0017	.0013	.0023	.0018	.0033	.0024	.0041
		36 - 50 HRC	145	.0003	.0005	.0004	.0008	.0006	.0010	.0009	.0015	.0011	.0020	.0016	.0028	.0020	.0036
GRAY CAST IRON	SAE J431, ASTM A48	75 - 88 HRB	410	.0007	.0013	.0011	.0019	.0015	.0026	.0022	.0038	.0028	.0050	.0041	.0072	.0062	.0091
		21 - 36 HRC	370	.0004	.0007	.0006	.0010	.0009	.0014	.0012	.0021	.0015	.0027	.0022	.0039	.0028	.0050
MALLEABLE CAST IRON	ASTM A47, ASTM A228, ASTM A602	75 - 88 HRB	345	.0005	.0008	.0007	.0012	.0008	.0016	.0013	.0024	.0018	.0032	.0026	.0045	.0033	.0058
		21 - 36 HRC	335	.0004	.0007	.0006	.0010	.0008	.0014	.0012	.0021	.0016	.0027	.0022	.0039	.0028	.0050
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM A572	75 - 88 HRB	310	.0005	.0009	.0007	.0013	.0010	.0017	.0014	.0025	.0019	.0033	.0027	.0047	.0034	.0060
		21 - 36 HRC	260	.0003	.0006	.0005	.0009	.0008	.0011	.0010	.0017	.0012	.0022	.0018	.0031	.0023	.0040
		36 - 50 HRC	135	.0002	.0004	.0003	.0006	.0004	.0007	.0006	.0011	.0008	.0014	.0011	.0020	.0014	.0025
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0006	.0011	.0008	.0016	.0012	.0022	.0018	.0032	.0024	.0042	.0035	.0061	.0044	.0077
		75 - 88 HRB	250	.0005	.0009	.0008	.0014	.0010	.0016	.0015	.0027	.0020	.0036	.0028	.0051	.0037	.0065
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Rene-41, Inconel 718, Inconel 26	75 - 88 HRB	85	.0003	.0006	.0005	.0008	.0006	.0011	.0009	.0017	.0012	.0022	.0018	.0031	.0023	.0040
		21 - 36 HRC	75	.0003	.0005	.0005	.0008	.0006	.0011	.0009	.0016	.0012	.0021	.0017	.0030	.0021	.0038
		36 - 50 HRC	70	.0003	.0005	.0004	.0007	.0005	.0009	.0008	.0014	.0010	.0019	.0014	.0025	.0018	.0032
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0006	.0013	.0011	.0022	.0017	.0030	.0025	.0045	.0033	.0060	.0048	.0084	.0061	.0107
		75 - 88 HRB	275	.0007	.0013	.0011	.0019	.0014	.0025	.0021	.0036	.0028	.0049	.0040	.0070	.0051	.0090
		21 - 36 HRC	250	.0006	.0010	.0008	.0014	.0011	.0019	.0016	.0026	.0021	.0037	.0030	.0053	.0038	.0067
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.0004	.0008	.0006	.0011	.0008	.0015	.0013	.0022	.0018	.0029	.0024	.0042	.0030	.0053
		36 - 50 HRC	160	.0004	.0007	.0006	.0010	.0008	.0014	.0011	.0020	.0015	.0026	.0022	.0038	.0027	.0048
COBALT ALLOY	ASTM F962, ASTM F969, ASTM F75, ASTM F798	75 - 88 HRB	210	.0004	.0008	.0006	.0011	.0008	.0015	.0013	.0022	.0018	.0029	.0024	.0042	.0030	.0053
		21 - 36 HRC	170	.0004	.0006	.0006	.0009	.0007	.0012	.0010	.0018	.0013	.0024	.0019	.0034	.0025	.0043
		36 - 50 HRC	85	.0002	.0004	.0004	.0006	.0005	.0009	.0007	.0012	.0009	.0016	.0013	.0023	.0017	.0029

MILLING PROCESS	HARDNESS	ADOC	RDOC
Slot (Full Slotting)	< 35 HRC	75%-125% Diameter	100% Diameter
	≥ 35 HRC	60%-100% Diameter	100% Diameter
Rough (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-35% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

5 FLUTE - CORNER RADIUS

New Items!



HEV-C-5

Chipbreaker Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 88 for Aplus coating



Cutter Diameter* D1 $\frac{+0.007}{-0.007}$	Shank Diameter D2 (H6)	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L2 $\frac{+0.002}{-0.002}$	Overall Length L1 $\frac{+0.002}{-0.002}$	Flutes	Tplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	83092	HEV-C-S-50125-R.010
	1/8	.010	3/8	2	5	86146	HEV-C-SR-50125-R.010
	1/8	.010	1/2	2-1/2	5	83091	HEV-C-R-50125-R.010
	1/8	.010	5/8	2-1/2	5	86147	HEV-C-A-50125-R.010
	1/8	.010	3/4	2-1/2	5	89509	HEV-C-M-50125-R.010
3/16	3/16	.010	5/16	2	5	83092	HEV-C-S-50187-R.010
	3/16	.010	7/16	2	5	83091	HEV-C-SR-50187-R.010
	3/16	.010	9/16	2-1/2	5	83094	HEV-C-R-50187-R.010
	3/16	.010	3/4	2-1/2	5	83095	HEV-C-M-50187-R.010
	3/16	.010	1	2-1/2	5	86148	HEV-C-ML-50187-R.010
	3/16	.010	1-3/16	3	5	89510	HEV-C-L-50187-R.010
1/4	1/4	.020	3/8	2	5	83096	HEV-C-S-50250-R.020
	1/4	.020	1/2	2-1/2	5	83097	HEV-C-SR-50250-R.020
	1/4	.020	3/4	2-1/2	5	83098	HEV-C-R-50250-R.020
	1/4	.020	1	3	5	83099	HEV-C-M-50250-R.020
	1/4	.020	1-1/4	3	5	86149	HEV-C-L-50250-R.020
	1/4	.020	1-1/2	3	5	89511	HEV-C-LX-50250-R.020
	1/4	.030	3/4	2	5	87375	HEV-C-S-50250-R.030
	1/4	.030	1/2	2-1/2	5	87376	HEV-C-SR-50250-R.030
	1/4	.030	3/4	2-1/2	5	87377	HEV-C-R-50250-R.030
5/16	5/16	.020	7/16	2	5	86150	HEV-C-S-50312-R.020
	5/16	.020	13/16	2-1/2	5	86151	HEV-C-R-50312-R.020
	5/16	.020	1-1/4	3	5	86152	HEV-C-L-50312-R.020
	5/16	.020	1-1/2	3	5	83109	HEV-C-S-50375-R.020
3/8	3/8	.020	1/2	2	5	83109	HEV-C-S-50375-R.020
	3/8	.020	3/4	2-1/2	5	83101	HEV-C-SR-50375-R.020
	3/8	.020	1	3	5	83102	HEV-C-R-50375-R.020
	3/8	.020	1-1/4	3	5	89103	HEV-C-M-50375-R.020
	3/8	.020	1-1/2	3-1/2	5	86160	HEV-C-L-50375-R.020
	3/8	.020	2	4	5	89512	HEV-C-LX-50375-R.020
	3/8	.030	1/2	2	5	87379	HEV-C-S-50375-R.030
	3/8	.030	3/4	2-1/2	5	87380	HEV-C-SR-50375-R.030
	3/8	.030	1	3	5	87381	HEV-C-R-50375-R.030
	3/8	.030	1-1/4	3	5	87382	HEV-C-M-50375-R.030

* .0005 max TIR

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New Items!

5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .0007$ $\pm .002$	Shank Diameter D2 H9	Corner Radius R $\pm .002$ $\pm .003$	Length of Cut L2 $\pm .032$ $\pm .007$	Overall Length L1 $\pm .007$ $\pm .007$	Flutes	TiAlN Coated	Tool Description
1/2	1/2	.030	5/8	2 1/2	5	83104	HEV-C-S-50500-R.030
	1/2	.030	1	3	5	83105	HEV-C-SR-50500-R.030
	1/2	.030	1-1/4	3	5	83106	HEV-C-R-50500-R.030
	1/2	.030	1-5/8	4	5	83107	HEV-C-M-50500-R.030
	1/2	.030	2	4	5	83108	HEV-C-L-50500-R.030
	1/2	.030	2-1/2	5	5	83109	HEV-C-LX-50500-R.030
	1/2	.030	3-1/8	5	5	86154	HEV-C-X-50500-R.030
	1/2	.060	5/8	2 1/2	5	83110	HEV-C-S-50500-R.060
	1/2	.060	1	3	5	83111	HEV-C-SR-50500-R.060
	1/2	.060	1-1/4	3	5	83112	HEV-C-R-50500-R.060
	1/2	.060	1-5/8	4	5	83113	HEV-C-M-50500-R.060
	1/2	.060	2	4	5	83114	HEV-C-L-50500-R.060
	1/2	.060	2-1/2	5	5	83115	HEV-C-LX-50500-R.060
	1/2	.060	3-1/8	5	5	88513	HEV-C-X-50500-R.060
	1/2	.125	5/8	2 1/2	5	87383	HEV-C-S-50500-R.125
	1/2	.125	1	3	5	87384	HEV-C-SR-50500-R.125
5/8	5/8	.030	3/4	3	5	83116	HEV-C-S-50625-R.030
	5/8	.030	1-1/4	3 1/2	5	83117	HEV-C-SR-50625-R.030
	5/8	.030	1-5/8	3 1/2	5	83118	HEV-C-R-50625-R.030
	5/8	.030	2-1/8	4	5	83119	HEV-C-M-50625-R.030
	5/8	.030	2-1/2	5	5	86155	HEV-C-L-50625-R.030
	5/8	.060	1-1/4	3 1/2	5	87388	HEV-C-SR-50625-R.060
	5/8	.060	1-5/8	3 1/2	5	87389	HEV-C-R-50625-R.060
3/4	3/4	.030	1	3	5	83120	HEV-C-S-50750-R.030
	3/4	.030	1-3/8	4	5	83121	HEV-C-R-50750-R.030
	3/4	.030	2-1/4	5	5	83122	HEV-C-M-50750-R.030
	3/4	.030	2-3/4	5	5	83123	HEV-C-L-50750-R.030
	3/4	.030	2-1/4	6	5	83124	HEV-C-LX-50750-R.030
	3/4	.030	4	6 1/2	5	86156	HEV-C-X-50750-R.030
	3/4	.060	1	3	5	87391	HEV-C-S-50750-R.060
	3/4	.060	1-5/8	4	5	87392	HEV-C-R-50750-R.060
	3/4	.060	2-1/4	5	5	87393	HEV-C-M-50750-R.060
	3/4	.060	2-3/4	5	5	87394	HEV-C-L-50750-R.060
1	1	.030	1-1/4	4	5	88514	HEV-C-S-51000-R.030
	1	.030	2	4 1/2	5	88515	HEV-C-R-51000-R.030
	1	.030	2-5/8	5	5	88516	HEV-C-M-51000-R.030
	1	.030	3-1/4	5	5	88517	HEV-C-L-51000-R.030

*.0005 max.TIR

6 FLUTE - CORNER RADIUS

New Items!



HEV-C-6

Chipbreaker Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 93 for Aplus coating



Cutter Diameter* D1 $\frac{+0.007}{-0.002}$	Shank Diameter D2 (H6)	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L2 $\frac{+0.02}{-0.001}$	Overall Length L1 $\frac{+0.02}{-0.002}$	Flutes	Tplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	6	87426	HEV-C-S-60125-R.010
	1/8	.010	3/8	2	6	87427	HEV-C-SR-60125-R.010
	1/8	.010	1/2	2-1/2	6	87428	HEV-C-R-60125-R.010
	1/8	.010	5/8	2-1/2	6	87429	HEV-C-A-60125-R.010
3/16	3/16	.010	5/16	2	6	87430	HEV-C-S-60187-R.010
	3/16	.010	7/16	2	6	87431	HEV-C-SR-60187-R.010
	3/16	.010	9/16	2-1/2	6	87432	HEV-C-R-60187-R.010
	3/16	.010	3/4	2-1/2	6	87433	HEV-C-M-60187-R.010
	3/16	.010	1	3	6	88529	HEV-C-L-60187-R.010
1/4	1/4	.010	3/8	2	6	87434	HEV-C-S-60250-R.010
	1/4	.010	1/2	2-1/2	6	87435	HEV-C-SR-60250-R.010
	1/4	.010	3/4	2-1/2	6	87436	HEV-C-R-60250-R.010
	1/4	.010	1	3	6	87437	HEV-C-M-60250-R.010
	1/4	.020	3/8	2	6	83145	HEV-C-S-60250-R.020
	1/4	.020	1/2	2-1/2	6	83146	HEV-C-SR-60250-R.020
	1/4	.020	3/4	2-1/2	6	83147	HEV-C-R-60250-R.020
	1/4	.020	1	3	6	83148	HEV-C-M-60250-R.020
	1/4	.020	1-1/4	3	6	88529	HEV-C-L-60250-R.020
	1/4	.030	3/8	2	6	87438	HEV-C-S-60250-R.030
	1/4	.030	1/2	2-1/2	6	87439	HEV-C-SR-60250-R.030
	1/4	.030	3/4	2-1/2	6	87440	HEV-C-R-60250-R.030
	1/4	.030	1	3	6	87441	HEV-C-M-60250-R.030
	1/4	.060	3/8	2	6	87442	HEV-C-S-60250-R.060
	1/4	.060	1/2	2-1/2	6	87443	HEV-C-SR-60250-R.060
	1/4	.060	3/4	2-1/2	6	87444	HEV-C-R-60250-R.060
	1/4	.060	1	3	6	87445	HEV-C-M-60250-R.060

* .0005 max TIR

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New Items!

6 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

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Cutter Diameter* D1 $\pm \frac{.002}{.002}$ "	Shank Diameter D2 (#)	Corner Radius R $\pm \frac{.002}{.002}$ "	Length of Cut L2 $\pm \frac{.002}{.002}$ "	Overall Length L1 $\pm \frac{.002}{.002}$ "	Flutes	Type Coated	Tool Description
3/8	3/8	.010	1/2	2	6	87446	HEV-C-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	87447	HEV-C-SR-60375-R.010
	3/8	.010	1	3	6	87448	HEV-C-R-60375-R.010
	3/8	.010	1-1/4	3	6	87449	HEV-C-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	87450	HEV-C-L-60375-R.010
	3/8	.020	1/2	2	6	87451	HEV-C-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	87452	HEV-C-SR-60375-R.020
	3/8	.020	1	3	6	87453	HEV-C-R-60375-R.020
	3/8	.020	1-1/4	3	6	87454	HEV-C-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	87455	HEV-C-L-60375-R.020
	3/8	.030	1/2	2	6	83149	HEV-C-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	83150	HEV-C-SR-60375-R.030
	3/8	.030	1	3	6	83151	HEV-C-R-60375-R.030
	3/8	.030	1-1/4	3	6	83152	HEV-C-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	86157	HEV-C-L-60375-R.030
	3/8	.060	1/2	2	6	87456	HEV-C-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	87457	HEV-C-SR-60375-R.060
	3/8	.060	1	3	6	87458	HEV-C-R-60375-R.060
	3/8	.060	1-1/4	3	6	87459	HEV-C-M-60375-R.060
	3/8	.060	1-1/2	3-1/2	6	87460	HEV-C-L-60375-R.060
1/2	1/2	.010	5/8	2-1/2	6	88530	HEV-C-S-60500-R.010
	1/2	.010	1	3	6	88531	HEV-C-SR-60500-R.010
	1/2	.010	1-1/4	3	6	88532	HEV-C-R-60500-R.010
	1/2	.010	1-5/8	4	6	88533	HEV-C-M-60500-R.010
	1/2	.010	2	4	6	88534	HEV-C-L-60500-R.010
	1/2	.010	2-1/2	5	6	88535	HEV-C-LX-60500-R.010
	1/2	.030	5/8	2-1/2	6	83153	HEV-C-S-60500-R.030
	1/2	.030	1	3	6	83154	HEV-C-SR-60500-R.030
	1/2	.030	1-1/4	3	6	83155	HEV-C-R-60500-R.030
	1/2	.030	1-5/8	4	6	83156	HEV-C-M-60500-R.030
	1/2	.030	2	4	6	83157	HEV-C-L-60500-R.030
	1/2	.030	2-1/2	5	6	88536	HEV-C-LX-60500-R.030
	1/2	.060	5/8	2-1/2	6	83158	HEV-C-S-60500-R.060
	1/2	.060	1	3	6	83159	HEV-C-SR-60500-R.060
	1/2	.060	1-1/4	3	6	83160	HEV-C-R-60500-R.060
	1/2	.060	1-5/8	4	6	83161	HEV-C-M-60500-R.060
	1/2	.060	2	4	6	83162	HEV-C-L-60500-R.060
	1/2	.060	2-1/2	5	6	88537	HEV-C-LX-60500-R.060
	1/2	.125	5/8	2-1/2	6	87461	HEV-C-S-60500-R.125
	1/2	.125	1	3	6	87462	HEV-C-SR-60500-R.125
	1/2	.125	1-1/4	3	6	87463	HEV-C-R-60500-R.125
	1/2	.125	1-5/8	4	6	87464	HEV-C-M-60500-R.125
	1/2	.125	2	4	6	87465	HEV-C-L-60500-R.125

* .0005 max TIR

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6 FLUTE - CORNER RADIUS

New Items!



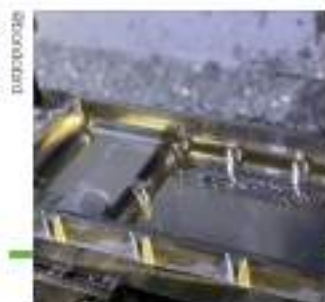
HEV-C-6

Chipbreaker Rougher - Variable Pitch (cont.)

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Outer Diameter* D1 $\pm .002$	Shank Diameter D2 (in)	Corner Radius R $\pm .002$	Length of Cut L2 $\pm .002$	Overall Length L1 $\pm .002$	Flutes	Tool Coated	Tool Description	
5/8	5/8	.030	1-1/4	3-1/2	6	88538	HEV-C-SR-60625-R.030	new
	5/8	.030	1-5/8	3-1/2	6	88539	HEV-C-R-60625-R.030	new
	5/8	.030	2	4	6	88540	HEV-C-M-60625-R.030	new
	5/8	.060	3/4	3	6	88541	HEV-C-S-60625-R.060	new
	5/8	.060	1-1/4	3-1/2	6	86162	HEV-C-SR-60025-R.060	
	5/8	.060	1-5/8	3-1/2	6	86163	HEV-C-R-60625-R.060	
	5/8	.060	2	4	6	86164	HEV-C-M-60025-R.060	
	5/8	.060	2-1/2	3	6	88542	HEV-C-L-60625-R.060	new
3/4	3/4	.030	1-5/8	4	6	87466	HEV-C-R-60750-R.030	
	3/4	.030	2-1/4	5	6	87467	HEV-C-M-60750-R.030	
	3/4	.030	2-3/4	5	6	87468	HEV-C-L-60750-R.030	
	3/4	.030	3-1/4	6	6	88543	HEV-C-LX-60750-R.030	new
	3/4	.060	1-5/8	4	6	86165	HEV-C-R-60750-R.060	
	3/4	.060	2-1/4	5	6	86166	HEV-C-M-60750-R.060	
	3/4	.060	2-3/4	5	6	86167	HEV-C-L-60750-R.060	
	3/4	.060	3-1/4	6	6	88544	HEV-C-LX-60750-R.060	new
	3/4	.250	1-5/8	4	6	87469	HEV-C-R-60750-R.250	
	3/4	.250	2-1/4	5	6	87470	HEV-C-M-60750-R.250	
	3/4	.250	2-3/4	5	6	87471	HEV-C-L-60750-R.250	

* .0005 max TIR



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HEVC-C-6



6 FLUTE - CORNER RADIUS

Coolant Through - Chipbreaker Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $+0.002$ -0.002	Shank Diameter D2 (mm)	Corner Radius R $+0.02$ -0.02	Length of Cut L2 $+0.02$ -0.00	Overall Length L1 $+0.02$ -0.00	Flutes	Tplus Coated	Tool Description
1/4	1/4	.020	3/8	2	6	84344	HEVC-C-015-60250-R.020
	1/4	.020	1/2	2-1/2	6	84345	HEVC-C-021-60250-R.020
3/8	3/8	.020	1/2	2	6	84346	HEVC-C-013-60375-R.020
	3/8	.020	1	3	6	84347	HEVC-C-026-60375-R.020
	3/8	.030	1/2	2	6	84348	HEVC-C-013-60375-R.030
	3/8	.030	1	3	6	84349	HEVC-C-026-60375-R.030
1/2	1/2	.030	1	3	6	84350	HEVC-C-021-60500-R.030
	1/2	.030	1-1/4	3	6	84351	HEVC-C-025-60500-R.030
	1/2	.030	1-5/8	4	6	84352	HEVC-C-033-60500-R.030
	1/2	.060	1	3	6	84353	HEVC-C-025-60500-R.060
	1/2	.060	1-1/4	3	6	84354	HEVC-C-025-60500-R.060
	1/2	.060	1-5/8	4	6	84355	HEVC-C-033-60500-R.060
3/4	3/4	.060	1-5/8	4	6	84356	HEVC-C-021-60750-R.060
	3/4	.060	2-1/4	5	6	84357	HEVC-C-033-60750-R.060

* .0005 max TIR



7 FLUTE - CORNER RADIUS

New Items!



HEV-C-7

Chipbreaker Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 96 for Aplus coating



Cutter Diameter* D1 $^{+0.012}_{-0.012}$	Shank Diameter D2 (in)	Corner Radius R $^{+0.02}_{-0.02}$	Length of Cut L2 $^{+0.02}_{-0.001}$	Overall Length L1 $^{+0.02}_{-0.002}$	Flutes	Tplus Coated	Tool Description
1/4	1/4	.020	3/8	2	7	86166	HEV-C-S-70250-R.020
	1/4	.020	1/2	2	7	82911	HEV-C-SR-70250-R.020
	1/4	.020	3/4	2-1/2	7	82912	HEV-C-R-70250-R.020
	1/4	.020	1	3	7	86168	HEV-C-M-70250-R.020
	1/4	.020	1-1/4	3	7	88545	HEV-C-L-70250-R.020
	1/4	.030	3/8	2	7	87191	HEV-C-S-70250-R.030
	1/4	.030	1/2	2	7	87192	HEV-C-SR-70250-R.030
	1/4	.030	3/4	2-1/2	7	87193	HEV-C-R-70250-R.030
5/16	5/16	.020	7/16	2	7	86170	HEV-C-S-70312-R.020
	5/16	.020	3/4	2-1/2	7	86171	HEV-C-R-70312-R.020
	5/16	.020	1	3	7	86172	HEV-C-M-70312-R.020
3/8	3/8	.020	1/2	2	7	82913	HEV-C-S-70375-R.020
	3/8	.020	3/4	2-1/2	7	82914	HEV-C-SR-70375-R.020
	3/8	.020	1	2-1/2	7	82915	HEV-C-R-70375-R.020
	3/8	.020	1-1/2	3-1/2	7	86173	HEV-C-L-70375-R.020
	3/8	.030	1/2	2	7	87194	HEV-C-S-70375-R.030
	3/8	.030	3/4	2-1/2	7	87195	HEV-C-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87196	HEV-C-R-70375-R.030
	3/8	.060	1/2	2	7	88546	HEV-C-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	88547	HEV-C-SR-70375-R.060
	3/8	.060	1	2-1/2	7	88548	HEV-C-R-70375-R.060

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 99

HEV-C-7



New Items!

7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 (H6)	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Flutes	Tplus-Coated	Tool Description
1/2	1/2	.010	5/8	2-1/2	7	87197	HEV-C-S-70500-R.010
	1/2	.010	1	3	7	87198	HEV-C-SR-70500-R.010
	1/2	.010	1-1/4	3	7	87199	HEV-C-R-70500-R.010
	1/2	.010	1-5/8	4	7	87290	HEV-C-M-70500-R.010
	1/2	.010	2	4	7	87291	HEV-C-L-70500-R.010
	1/2	.020	5/8	2-1/2	7	86549	HEV-C-S-70500-R.020
	1/2	.020	1	3	7	86550	HEV-C-SR-70500-R.020
	1/2	.020	1-1/4	3	7	86551	HEV-C-R-70500-R.020
	1/2	.020	1-5/8	4	7	86552	HEV-C-M-70500-R.020
	1/2	.020	2	4	7	86553	HEV-C-L-70500-R.020
	1/2	.030	5/8	2-1/2	7	82916	HEV-C-S-70500-R.030
	1/2	.030	1	3	7	82917	HEV-C-SR-70500-R.030
	1/2	.030	1-1/4	3	7	82918	HEV-C-R-70500-R.030
	1/2	.030	1-5/8	4	7	82919	HEV-C-M-70500-R.030
	1/2	.030	2	4	7	82920	HEV-C-L-70500-R.030
	1/2	.030	2-1/2	5	7	86174	HEV-C-LX-70500-R.030
	1/2	.030	3-1/8	6	7	86554	HEV-C-X-70500-R.030
	1/2	.060	5/8	2-1/2	7	83177	HEV-C-S-70500-R.060
	1/2	.060	1	3	7	83178	HEV-C-SR-70500-R.060
	1/2	.060	1-1/4	3	7	83179	HEV-C-R-70500-R.060
	1/2	.060	1-5/8	4	7	83180	HEV-C-M-70500-R.060
	1/2	.060	2	4	7	83181	HEV-C-L-70500-R.060
5/8	5/8	.030	1-1/4	3-1/2	7	82921	HEV-C-SR-70625-R.030
	5/8	.030	1-5/8	4	7	82922	HEV-C-R-70625-R.030
	5/8	.030	2-1/8	4	7	86175	HEV-C-M-70625-R.030
	5/8	.060	1-1/4	3-1/2	7	86555	HEV-C-SR-70625-R.060
	5/8	.060	1-5/8	4	7	86556	HEV-C-R-70625-R.060
	5/8	.060	2-1/8	4	7	86557	HEV-C-M-70625-R.060
3/4	3/4	.030	1-1/4	3-1/2	7	86558	HEV-C-SR-70750-R.030
	3/4	.030	1-5/8	4	7	82923	HEV-C-R-70750-R.030
	3/4	.030	2-1/4	5	7	82924	HEV-C-M-70750-R.030
	3/4	.030	2-3/4	5	7	86176	HEV-C-L-70750-R.030
	3/4	.030	3-1/4	6	7	87292	HEV-C-LX-70750-R.030
	3/4	.030	4	6-1/2	7	87293	HEV-C-X-70750-R.030
	3/4	.060	1-1/4	3-1/2	7	86559	HEV-C-SR-70750-R.060
	3/4	.060	1-5/8	4	7	82925	HEV-C-R-70750-R.060
	3/4	.060	2-1/4	5	7	82926	HEV-C-M-70750-R.060
	3/4	.060	2-3/4	5	7	86177	HEV-C-L-70750-R.060
	3/4	.060	3-1/4	6	7	87294	HEV-C-LX-70750-R.060
	3/4	.060	4	6-1/2	7	87295	HEV-C-X-70750-R.060
1	1	.030	2-5/8	5	7	87296	HEV-C-M-71000-R.030
	1	.030	3-1/4	6	7	87297	HEV-C-L-71000-R.030
	1	.030	4-1/8	7	7	87298	HEV-C-X-71000-R.030

*.0005 max TIR

MULTI-FLUTE - CORNER RADIUS

New Items!

HXVR

Knuckle Rougher - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with staggered "low profile" edge geometry for chip control and minimized cutting forces

- Available in 4 flute and 5 flute options
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 100 for Aplus coating



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H9)	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L2 $\pm \frac{.002}{.002}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Tplus Coated	Tool Description	
1/4	1/4	.030	3/8	2	4	83482	HVR-S-40250-R.030	
	1/4	.030	1/2	2-1/2	4	88947	HVR-SR-40250-R.030	new
	1/4	.030	3/4	2-1/2	4	83483	HVR-R-40250-R.030	
	1/4	.030	1	3	4	88948	HVR-M-40250-R.030	new
3/8	3/8	.040	1/2	2	4	83484	HVR-S-40375-R.040	
	3/8	.040	1/2	2	5	83485	HVR-S-50375-R.040	
	3/8	.040	3/4	2-1/2	4	88949	HVR-SR-40375-R.040	new
	3/8	.040	3/4	2-1/2	5	88950	HVR-SR-50375-R.040	new
	3/8	.040	1	3	4	83486	HVR-R-40375-R.040	
	3/8	.040	1	3	5	83487	HVR-R-50375-R.040	
	3/8	.040	1-1/4	3	4	88951	HVR-M-40375-R.040	new
	3/8	.040	1-1/4	3	5	88952	HVR-M-50375-R.040	new
1/2	1/2	.040	5/8	2-1/2	4	83488	HVR-S-40500-R.040	
	1/2	.040	5/8	2-1/2	5	83489	HVR-S-50500-R.040	
	1/2	.040	1	3	4	88953	HVR-SR-40500-R.040	new
	1/2	.040	1	3	5	88954	HVR-SR-50500-R.040	new
	1/2	.040	1-1/4	3	4	83490	HVR-R-40500-R.040	
	1/2	.040	1-1/4	3	5	83491	HVR-R-50500-R.040	
	1/2	.040	1-5/8	4	4	88955	HVR-M-40500-R.040	new
	1/2	.040	1-5/8	4	5	88956	HVR-M-50500-R.040	new
5/8	5/8	.060	3/4	3	4	88957	HVR-S-40625-R.060	new
	5/8	.060	3/4	3	5	88958	HVR-S-50625-R.060	new
	5/8	.060	1-5/8	3-1/2	4	88959	HVR-R-40625-R.060	new
	5/8	.060	1-5/8	3-1/2	5	88960	HVR-R-50625-R.060	new
	5/8	.060	2	4	5	88961	HVR-M-50625-R.060	new
3/4	3/4	.060	1	3	4	83492	HVR-S-40750-R.060	
	3/4	.060	1	3	5	83493	HVR-S-50750-R.060	
	3/4	.060	1-5/8	4	4	83494	HVR-R-40750-R.060	
	3/4	.060	1-5/8	4	5	83495	HVR-R-50750-R.060	
	3/4	.060	2-1/4	5	5	88962	HVR-M-50750-R.060	new
1	1	.060	1-1/4	4	4	88963	HVR-S-41000-R.060	new
	1	.060	1-1/4	4	5	88964	HVR-S-51000-R.060	new
	1	.060	2	4-1/2	4	88965	HVR-R-41000-R.060	new
	1	.060	2	4-1/2	5	88966	HVR-R-51000-R.060	new

* .0005 max TIR

Speeds & Feeds on Page 102

HSV-4 / HSM-4

New Items!

4 FLUTE - SQUARE
Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications

- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- CNC ground in the USA

For steel applications, see page 112 for Aplus coating



Cutter Diameter* D1 $\pm \frac{.0005}{.001}$	Shank Diameter D2 h6	Length of Cut L2 $\pm \frac{.010}{.005}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	T _{plus} Coated	T _{plus} Coated + Weldon Flat	Tool Description
1/32	1/4	3/32	2-1/2	4	84040		HSM-030-40031
	1/4	5/32	2-1/2	4	84041		HSM-050-40031
3/64	1/4	5/32	2-1/2	4	84042		HSM-033-40047
	1/4	1/4	2-1/2	4	84043		HSM-053-40047
1/16	1/4	5/16	2-1/2	4	84044		HSM-030-40062
	1/4	5/16	2-1/2	4	84045		HSM-050-40062
5/64	1/4	1/4	2-1/2	4	84046		HSM-032-40071
	1/4	3/8	2-1/2	4	84047		HSM-048-40071
3/32	1/4	9/32	2-1/2	4	84048		HSM-030-40091
	1/4	1/2	2-1/2	4	84049		HSM-053-40091

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 h6	Length of Cut L2 $\pm \frac{.010}{.005}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	T _{plus} Coated	T _{plus} Coated + Weldon Flat	Tool Description
1/8	1/8	1/4	1-1/2	4	83183		HSV-S-40125
	1/4	1/4	2-1/2	4	84050		HSM-020-40125
	1/8	3/8	2	4	83184		HSV-SR-40125
	1/4	3/8	2-1/2	4	84051		HSM-030-40125
	1/8	1/2	2-1/2	4	83185		HSV-R-40125
	1/4	1/2	2-1/2	4	84052		HSM-040-40125
	1/8	5/8	2-1/2	4	83186		HSV-A-40125
	1/8	3/4	2-1/2	4	83187		HSV-M-40125
	1/8	7/8	2-1/2	4	84093		HSV-L-40125
5/32	1/8	1	2-1/2	4	87472		HSV-LX-40125
	3/16	3/16	2	4	83188		HSV-S-40156
	3/16	5/16	2	4	84094		HSV-SR-40156
	3/16	7/16	2-1/2	4	83189		HSV-R-40156
	3/16	9/16	2-1/2	4	83190		HSV-M-40156
	3/16	3/4	2-1/2	4	84095		HSV-ML-40156
new	3/16	1	3	4	88160		HSV-L-40156

* .0005 max TIP

continued on next page



Speeds & Feeds on Page 132

4 FLUTE - SQUARE

New Items!

HSV-4 / HSM-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\frac{+0.007}{-0.007}$	Shank Diameter D2 (H8)	Length of Cut L2 $\frac{+0.02}{-0.007}$	Overall Length L1 $\frac{+0.02}{-0.02}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description	
3/16	3/16	5/16	2	4	83191		HSV-S-40187	
	1/4	5/16	2-1/2	4	84053		HSM-O16-40187	
	3/16	7/16	2	4	83192		HSV-SR-40187	
	1/4	7/16	2-1/2	4	84054		HSM-C23-40187	
	1/4	9/16	2-1/2	4	84055		HSM-C09-40187	
	3/16	5/8	2-1/2	4	83193		HSV-R-40187	
	3/16	3/4	2-1/2	4	87473		HSV-A-40187	
	1/4	3/4	2-1/2	4	84056		HSM-O40-40187	
	3/16	1	2-1/2	4	83194		HSV-M-40187	
	3/16	1-3/16	3	4	87474		HSV-L-40187	
	3/16	1-3/8	3	4	88161		HSV-LX-40187	new
7/32	1/4	1/4	2	4	87475		HSV-S-40218	
	1/4	7/16	2-1/2	4	87476		HSV-R-40218	
	1/4	5/8	2-1/2	4	87477		HSV-A-40218	
1/4	1/4	3/8	2	4	82262	82262W	HSV-S-40250	
	1/4	1/2	2-1/2	4	82263	82263W	HSV-SR-40250	
	1/4	3/4	2-1/2	4	82264	82264W	HSV-R-40250	
	1/4	1	3	4	82265	82265W	HSV-M-40250	
	1/4	1-1/4	3	4	83195		HSV-L-40250	
	1/4	1-1/2	3	4	83196		HSV-LX-40250	
	1/4	1-3/4	4	4	87478		HSV-X-40250	
9/32	5/16	7/16	2	4	88162		HSV-S-40281	new
	5/16	5/8	2-1/2	4	88163		HSV-R-40281	new
	5/16	1	3	4	88164		HSV-M-40281	new
	5/16	1-1/2	3	4	88165		HSV-L-40281	new
5/16	5/16	1/2	2	4	83197		HSV-S-40312	
	5/16	3/4	2-1/2	4	83198		HSV-R-40312	
	5/16	1	2-1/2	4	83199		HSV-A-40312	
	5/16	1-1/4	3	4	83200		HSV-M-40312	
	5/16	1-3/16	4	4	87479		HSV-L-40312	
	5/16	2-1/8	4	4	88166		HSV-LX-40312	new
3/8	3/8	1/2	2	4	82266	82266W	HSV-S-40375	
	3/8	7/8	3	4	82267	82267W	HSV-SR-40375	
	3/8	1	3	4	82268	82268W	HSV-R-40375	
	3/8	1-1/4	3	4	82269	82269W	HSV-M-40375	
	3/8	1-1/2	3	4	83201		HSV-L-40375	
	3/8	2	4	4	87480		HSV-LX-40375	
	3/8	2-1/2	5	4	88167		HSV-X-40375	new
7/16	7/16	5/8	2-3/4	4	88168		HSV-S-40437	new
	7/16	7/8	2-3/4	4	88169		HSV-R-40437	new
	7/16	1-1/8	3-1/2	4	88170		HSV-M-40437	new
	7/16	1-5/8	3-1/2	4	88171		HSV-L-40437	new

* .0005 max TIR

continued on next page

HSV-4 / HSM-4

New Items!

4 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ $\frac{+0.001}{-0.002}$	Shank Diameter D ₂ H6	Length of Cut L ₂ $\frac{+0.01}{-0.02}$	Overall Length L ₁ $\frac{+0.02}{-0.02}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/2	1/2	5/8	2-1/2	4	82270	82270W	HSV-S-40500
	1/2	1	3	4	82271	82271W	HSV-SR-40500
	1/2	1-1/4	3	4	82272	82272W	HSV-R-40500
	1/2	1-5/8	4	4	82273	82273W	HSV-M-40500
	1/2	2	4	4	83202		HSV-L-40500
	1/2	2-1/2	5	4	83203		HSV-LX-40500
	1/2	3-1/8	6	4	84896		HSV-X-40500
5/8	5/8	3/4	3	4	83204		HSV-S-40625
	5/8	1-1/4	3-1/2	4	83205		HSV-SR-40625
	5/8	1-5/8	3-1/2	4	83206		HSV-R-40625
	5/8	2	4	4	83207		HSV-M-40625
	5/8	2-1/2	5	4	87481		HSV-ML-40625
	5/8	3-1/4	6	4	87482		HSV-L-40625
	5/8	3-3/4	6	4	88173		HSV-LX-40625
3/4	3/4	7/8	3	4	83208		HSV-S-40750
	3/4	1-1/4	4	4	83209		HSV-SR-40750
	3/4	1-5/8	4	4	82274		HSV-R-40750
	3/4	2-1/4	5	4	82275		HSV-M-40750
	3/4	2-3/4	5	4	83210		HSV-ML-40750
	3/4	3-1/4	6	4	83211		HSV-L-40750
	3/4	4	6-1/2	4	87483		HSV-LX-40750
	3/4	4-3/4	7	4	88172		HSV-X-40750

* .0005 max TIR

4 FLUTE - BALL

New Items!

HSV-4

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 115 for Aplus coating



Cutter Diameter* $D1 \begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter $D2 \begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Length of Cut $L2 \begin{smallmatrix} +.0127 \\ -.0007 \end{smallmatrix}$	Overall Length $L1 \begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	4	83275	HSV-S-40125-BN
	1/8	3/8	2	4	83276	HSV-SR-40125-BN
	1/8	1/2	2-1/2	4	83277	HSV-R-40125-BN
	1/8	5/8	2-1/2	4	83278	HSV-A-40125-BN
	1/8	3/4	2-1/2	4	84750	HSV-M-40125-BN
	1/8	7/8	2-1/2	4	84751	HSV-L-40125-BN
	1/8	1	2-1/2	4	87484	HSV-LX-40125-BN
5/32	3/16	3/16	2	4	84752	HSV-S-40156-BN
	3/16	5/16	2	4	83182	HSV-SR-40156-BN
	3/16	7/16	2-1/2	4	84753	HSV-R-40156-BN
	3/16	9/16	2-1/2	4	84754	HSV-M-40156-BN
	3/16	3/4	2-1/2	4	84755	HSV-L-40156-BN
3/16	3/16	5/16	2	4	83279	HSV-S-40187-BN
	3/16	7/16	2	4	84756	HSV-SR-40187-BN
	3/16	5/8	2-1/2	4	83280	HSV-R-40187-BN
	3/16	3/4	2-1/2	4	83183	HSV-A-40187-BN
	3/16	1	2-1/2	4	83281	HSV-M-40187-BN
	3/16	1-3/16	3	4	84757	HSV-L-40187-BN
	3/16	1-3/8	3	4	87485	HSV-LX-40187-BN
7/32	1/4	1/4	2	4	87486	HSV-S-40218-BN
	1/4	7/16	2-1/2	4	87487	HSV-R-40218-BN
	1/4	5/8	2-1/2	4	87488	HSV-A-40218-BN
1/4	1/4	3/8	2	4	83282	HSV-S-40250-BN
	1/4	1/2	2-1/2	4	83283	HSV-SR-40250-BN
	1/4	3/4	2-1/2	4	83284	HSV-R-40250-BN
	1/4	1	3	4	83285	HSV-M-40250-BN
	1/4	1-1/4	3	4	83286	HSV-L-40250-BN
	1/4	1-1/2	3	4	84758	HSV-LX-40250-BN
	1/4	1-3/4	4	4	84759	HSV-X-40250-BN

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 132

HSV-4

New Items!

4 FLUTE - BALL

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* $D_1 \pm .001$ $.002$	Shank Diameter $D_2 (H6)$	Length of Cut $L_2 \pm .02$ $.001$	Overall Length $L_1 \pm .02$ $.002$	Flutes	Tplus Coated	Tool Description
5/16	5/16	1/2	2	4	13287	HSV-S-40312-BN
	5/16	3/4	2-1/2	4	13288	HSV-R-40312-BN
	5/16	1	2-1/2	4	13289	HSV-A-40312-BN
	5/16	1-1/4	3	4	13290	HSV-M-40312-BN
	5/16	1-9/16	4	4	14760	HSV-L-40312-BN
	5/16	2-1/8	4	4	18184	HSV-LX-40312-BN
3/8	3/8	1/2	2	4	13291	HSV-S-40375-BN
	3/8	7/8	3	4	13292	HSV-SR-40375-BN
	3/8	1	3	4	13293	HSV-R-40375-BN
	3/8	1-1/4	3	4	13294	HSV-M-40375-BN
	3/8	1-1/2	3	4	14761	HSV-L-40375-BN
	3/8	2	4	4	14762	HSV-LX-40375-BN
7/16	7/16	5/8	2-3/4	4	14763	HSV-S-40437-BN
	7/16	7/8	2-3/4	4	14764	HSV-R-40437-BN
	7/16	1-1/8	2-1/2	4	14765	HSV-M-40437-BN
1/2	1/2	5/8	2-1/2	4	13295	HSV-S-40500-BN
	1/2	1	3	4	13296	HSV-SR-40500-BN
	1/2	1-1/4	3	4	13297	HSV-R-40500-BN
	1/2	1-5/8	4	4	13298	HSV-M-40500-BN
	1/2	2	4	4	13299	HSV-L-40500-BN
	1/2	2-1/2	5	4	14766	HSV-LX-40500-BN
5/8	5/8	3/4	3	4	18185	HSV-S-40625-BN
	5/8	1-1/4	2-1/2	4	14767	HSV-SR-40625-BN
	5/8	1-5/8	2-1/2	4	14768	HSV-R-40625-BN
	5/8	2	4	4	14769	HSV-M-40625-BN
	5/8	2-1/2	5	4	17481	HSV-L-40625-BN
	5/8	3-1/4	6	4	17482	HSV-LX-40625-BN
3/4	3/4	7/8	3	4	13300	HSV-S-40750-BN
	3/4	1-1/4	4	4	13301	HSV-SR-40750-BN
	3/4	1-5/8	4	4	13302	HSV-R-40750-BN
	3/4	2-1/4	5	4	17483	HSV-M-40750-BN
	3/4	2-3/4	5	4	17484	HSV-L-40750-BN
	3/4	3-1/4	6	4	18186	HSV-LX-40750-BN
1	1	1-1/2	4	4	14770	HSV-S-41000-BN
	1	2	4-1/2	4	14771	HSV-R-41000-BN
	1	2-5/8	5	4	17485	HSV-M-41000-BN

*.0005 max TIR

4 FLUTE - CORNER RADIUS

New Items!

HSV-4 / HSM-4

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 118 for Aplus coating



Cutter Diameter* D1 $\pm \frac{.000}{.002}$	Shank Diameter D2 (h6)	Corner Radius R $\pm \frac{.001}{.001}$	Length of Cut L2 $\pm \frac{.010}{.006}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/32	1/4	.005	3/32	2-1/2	4	84016		HSM-030-40031-R.005
	1/4	.005	5/32	2-1/2	4	84017		HSM-050-40021-R.005
3/64	1/4	.010	1/2	2-1/2	4	84018		HSM-032-40047-R.010
	1/4	.010	1/4	2-1/2	4	84019		HSM-052-40047-R.010
1/16	1/4	.010	3/16	2-1/2	4	84020		HSM-030-40062-R.010
	1/4	.010	5/16	2-1/2	4	84021		HSM-050-40062-R.010
5/64	1/4	.010	1/4	2-1/2	4	84022		HSM-032-40079-R.010
	1/4	.010	3/8	2-1/2	4	84023		HSM-048-40079-R.010
3/32	1/4	.010	9/32	2-1/2	4	84024		HSM-030-40093-R.010
	1/4	.010	1/2	2-1/2	4	84025		HSM-053-40093-R.010

Cutter Diameter* D1 $\pm \frac{.000}{.002}$	Shank Diameter D2 (h6)	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L2 $\pm \frac{.002}{.000}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description	
1/8	1/8	.010	1/4	1-1/2	4	83238		HSV-S-40125-R.010	
	1/4	.010	1/4	2-1/2	4	84026		HSM-020-40125-R.010	
	1/8	.010	3/8	2	4	84718		HSV-SR-40125-R.010	
	1/4	.010	3/8	2-1/2	4	84027		HSM-030-40125-R.010	
	1/8	.010	1/2	2-1/2	4	83239		HSV-R-40125-R.010	
	1/4	.010	1/2	2-1/2	4	84028		HSM-040-40125-R.010	
	1/8	.010	5/8	2-1/2	4	84719		HSV-A-40125-R.010	
	1/4	.010	3/4	2-1/2	4	83204		HSV-M-40125-R.010	new
	1/8	.015	1/4	1-1/2	4	84720		HSV-S-40125-R.015	
	1/8	.015	3/8	2	4	87683		HSV-SR-40125-R.015	
	1/8	.015	1/2	2-1/2	4	84721		HSV-R-40125-R.015	
	1/8	.015	5/8	2-1/2	4	83205		HSV-A-40125-R.015	new
	1/8	.020	1/4	1-1/2	4	87684		HSV-S-40125-R.020	
	1/8	.020	3/8	2	4	87685		HSV-SR-40125-R.020	
	1/8	.020	1/2	2-1/2	4	87686		HSV-R-40125-R.020	
	1/8	.020	5/8	2-1/2	4	83203		HSV-A-40125-R.020	new
	1/8	.030	1/4	1-1/2	4	83240		HSV-S-40125-R.030	
	1/4	.030	1/4	2-1/2	4	84033		HSM-020-40125-R.030	
	1/8	.030	3/8	2	4	84722		HSV-SR-40125-R.030	

* .0005 max TIR

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Speeds & Feeds on Page 132

HSV-4 / HSM-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .002$ "	Shank Diameter D2/h6	Corner Radius R $\pm .002$ "	Length of Cut L2 $\pm .002$ "	Overall Length L1 $\pm .002$ "	Flutes	T-plus Coated	T-plus Coated + Weldon Flat	Tool Description
1/8	1/4	.030	3/8	2-1/2	4	84034		HSM-030-40125-R.030
	1/8	.030	1/2	2-1/2	4	83241		HSV-R-40125-R.030
	1/4	.030	1/2	2-1/2	4	84035		HSM-040-40125-R.030
	1/8	.030	5/8	2-1/2	4	84723		HSV-A-40125-R.030
5/32	3/16	.010	3/16	2	4	87687		HSV-S-40156-R.010
	3/16	.010	5/16	2	4	87688		HSV-SR-40156-R.010
	3/16	.010	7/16	2-1/2	4	87689		HSV-R-40156-R.010
	3/16	.010	9/16	2-1/2	4	87690		HSV-M-40156-R.010
	3/16	.010	3/4	2-1/2	4	88206		HSV-ML-40156-R.010
	3/16	.030	3/16	2	4	87691		HSV-S-40156-R.030
	3/16	.030	5/16	2	4	87692		HSV-SR-40156-R.030
	3/16	.030	7/16	2-1/2	4	87693		HSV-R-40156-R.030
	3/16	.030	9/16	2-1/2	4	87694		HSV-M-40156-R.030
	3/16	.030	3/4	2-1/2	4	88207		HSV-ML-40156-R.030
3/16	3/16	.010	5/16	2	4	83242		HSV-S-40187-R.010
	1/4	.010	5/16	2-1/2	4	84029		HSM-016-40187-R.010
	3/16	.010	7/16	2	4	88218		HSV-SR-40187-R.010
	1/4	.010	7/16	2-1/2	4	84030		HSM-023-40187-R.010
	1/4	.010	9/16	2-1/2	4	84031		HSM-029-40187-R.010
	3/16	.010	5/8	2-1/2	4	83243		HSV-R-40187-R.010
	1/4	.010	3/4	2-1/2	4	84032		HSM-040-40187-R.010
	3/16	.010	1	2-1/2	4	88209		HSV-M-40187-R.010
	3/16	.010	1-3/16	3	4	88219		HSV-L-40187-R.010
	3/16	.015	5/16	2	4	87695		HSV-S-40187-R.015
	3/16	.015	7/16	2	4	87696		HSV-SR-40187-R.015
	3/16	.015	5/8	2-1/2	4	87697		HSV-R-40187-R.015
	3/16	.015	1	2-1/2	4	88211		HSV-M-40187-R.015
	3/16	.020	5/16	2	4	87698		HSV-S-40187-R.020
	3/16	.020	7/16	2	4	87699		HSV-SR-40187-R.020
	3/16	.020	5/8	2-1/2	4	87700		HSV-R-40187-R.020
	3/16	.020	1	2-1/2	4	88212		HSV-M-40187-R.020
	3/16	.030	5/16	2	4	83244		HSV-S-40187-R.030
	1/4	.030	5/16	2-1/2	4	84036		HSM-016-40187-R.030
	3/16	.030	7/16	2	4	88213		HSV-SR-40187-R.030
	1/4	.030	7/16	2-1/2	4	84037		HSM-023-40187-R.030
	1/4	.030	9/16	2-1/2	4	84038		HSM-029-40187-R.030
	3/16	.030	5/8	2-1/2	4	83245		HSV-R-40187-R.030
	1/4	.030	3/4	2-1/2	4	84039		HSM-040-40187-R.030
	3/16	.030	1	2-1/2	4	84724		HSV-M-40187-R.030
7/32	1/4	.010	1/4	2	4	88214		HSV-S-40218-R.010
	1/4	.010	7/16	2-1/2	4	88215		HSV-R-40218-R.010
	1/4	.010	5/8	2-1/2	4	88216		HSV-A-40218-R.010
1/4	1/4	.010	3/8	2	4	83246		HSV-S-40250-R.010
	1/4	.010	1/2	2-1/2	4	83247		HSV-SR-40250-R.010
	1/4	.010	3/4	2-1/2	4	83248		HSV-R-40250-R.010
	1/4	.010	1	3	4	84725		HSV-M-40250-R.010
	1/4	.010	1-1/4	3	4	88217		HSV-L-40250-R.010
	1/4	.015	3/8	2	4	87701		HSV-S-40250-R.015
	1/4	.015	1/2	2-1/2	4	87702		HSV-SR-40250-R.015
	1/4	.015	3/4	2-1/2	4	87703		HSV-R-40250-R.015
	1/4	.015	1	3	4	87704		HSV-M-40250-R.015
	1/4	.015	1-1/4	3	4	88218		HSV-L-40250-R.015

*.0005 max TIP

continued on next page

4 FLUTE - CORNER RADIUS

New Items!

HSV-4 / HSM-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\frac{+0.007}{-0.002}$	Shank Diameter D2 H6	Corner Radius R $\frac{+0.002}{-0.002}$	Length of Cut L2 $\frac{+0.002}{-0.000}$	Overall Length L1 $\frac{+0.002}{-0.002}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/4	1/4	.020	3/8	2	4	82303	82303W	HSV-S-40250-R.020
	1/4	.020	1/2	2-1/2	4	82304	82304W	HSV-SR-40250-R.020
	1/4	.020	3/4	2-1/2	4	82305	82305W	HSV-R-40250-R.020
	1/4	.020	1	3	4	82306		HSV-M-40250-R.020
	1/4	.020	1-1/4	3	4	84726		HSV-L-40250-R.020
	1/4	.030	3/8	2	4	83249		HSV-S-40250-R.030
	1/4	.030	1/2	2-1/2	4	83250		HSV-SR-40250-R.030
	1/4	.030	3/4	2-1/2	4	83251		HSV-R-40250-R.030
	1/4	.030	1	3	4	83252		HSV-M-40250-R.030
	1/4	.030	1-1/4	3	4	84727		HSV-L-40250-R.030
	1/4	.060	3/8	2	4	83253		HSV-S-40250-R.060
	1/4	.060	1/2	2-1/2	4	83254		HSV-SR-40250-R.060
	1/4	.060	3/4	2-1/2	4	83255		HSV-R-40250-R.060
	1/4	.060	1	3	4	83256		HSV-M-40250-R.060
	1/4	.060	1-1/4	3	4	84728		HSV-L-40250-R.060
5/16	5/16	.010	1/2	2	4	87705		HSV-S-40312-R.010
	5/16	.010	3/4	2-1/2	4	87706		HSV-SR-40312-R.010
	5/16	.010	1	2-1/2	4	87707		HSV-R-40312-R.010
	5/16	.010	1-1/4	3	4	87708		HSV-M-40312-R.010
	5/16	.020	1/2	2	4	84729		HSV-S-40312-R.020
	5/16	.020	3/4	2-1/2	4	84730		HSV-SR-40312-R.020
	5/16	.020	1	2-1/2	4	84731		HSV-R-40312-R.020
	5/16	.020	1-1/4	3	4	84732		HSV-M-40312-R.020
	5/16	.030	1/2	2	4	87709		HSV-S-40312-R.030
	5/16	.030	3/4	2-1/2	4	87710		HSV-SR-40312-R.030
	5/16	.030	1	2-1/2	4	87711		HSV-R-40312-R.030
	5/16	.030	1-1/4	3	4	87712		HSV-M-40312-R.030
	5/16	.060	1/2	2	4	88219		HSV-S-40312-R.060
	5/16	.060	3/4	2-1/2	4	88220		HSV-SR-40312-R.060
	5/16	.060	1	2-1/2	4	88221		HSV-R-40312-R.060
	5/16	.060	1-1/4	3	4	88222		HSV-M-40312-R.060
3/8	3/8	.010	1/2	2	4	87713		HSV-S-40375-R.010
	3/8	.010	7/8	3	4	87714		HSV-SR-40375-R.010
	3/8	.010	1	3	4	87715		HSV-R-40375-R.010
	3/8	.010	1-1/4	3	4	87716		HSV-M-40375-R.010
	3/8	.020	1/2	2	4	82307	82307W	HSV-S-40375-R.020
	3/8	.020	7/8	3	4	82308	82308W	HSV-SR-40375-R.020
	3/8	.020	1	3	4	82309		HSV-R-40375-R.020
	3/8	.020	1-1/4	3	4	82310		HSV-M-40375-R.020
	3/8	.030	1/2	2	4	82311		HSV-S-40375-R.030
	3/8	.030	7/8	3	4	82312		HSV-SR-40375-R.030
	3/8	.030	1	3	4	82313		HSV-R-40375-R.030
	3/8	.030	1-1/4	3	4	82314		HSV-M-40375-R.030
	3/8	.060	1/2	2	4	83257		HSV-S-40375-R.060
	3/8	.060	7/8	3	4	83258		HSV-SR-40375-R.060
	3/8	.060	1	3	4	83259		HSV-R-40375-R.060
	3/8	.060	1-1/4	3	4	87717		HSV-M-40375-R.060

* .0005 max TR

continued on next page

HSV-4 / HSM-4

New Items!

4 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Outer Diameter* D1 $^{+0.002}_{-0.002}$	Shank Diameter D2 (H6)	Corner Radius R $^{+0.002}_{-0.002}$	Length of Cut L2 $^{+0.002}_{-0.002}$	Overall Length L1 $^{+0.002}_{-0.002}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/2	1/2	.010	5/8	2-1/2	4	84733		HSV-S-40500-R.010
	1/2	.010	1	3	4	84734		HSV-SR-40500-R.010
	1/2	.010	1-1/4	3	4	84735		HSV-R-40500-R.010
	1/2	.010	1-5/8	4	4	88223		HSV-M-40500-R.010
	1/2	.010	2	4	4	88224		HSV-L-40500-R.010
	1/2	.015	5/8	2-1/2	4	83260		HSV-S-40500-R.015
	1/2	.015	1	3	4	83261		HSV-SR-40500-R.015
	1/2	.015	1-1/4	3	4	83262		HSV-R-40500-R.015
	1/2	.015	1-5/8	4	4	88225		HSV-M-40500-R.015
	1/2	.015	2	4	4	88226		HSV-L-40500-R.015
	1/2	.020	5/8	2-1/2	4	82315		HSV-S-40500-R.020
	1/2	.020	1	3	4	82316		HSV-SR-40500-R.020
	1/2	.020	1-1/4	3	4	82317		HSV-R-40500-R.020
	1/2	.020	1-5/8	4	4	82318		HSV-M-40500-R.020
	1/2	.020	2	4	4	88227		HSV-L-40500-R.020
	1/2	.030	5/8	2-1/2	4	82319	82319W	HSV-S-40500-R.030
	1/2	.030	1	3	4	82320	82320W	HSV-SR-40500-R.030
	1/2	.030	1-1/4	3	4	82321	82321W	HSV-R-40500-R.030
	1/2	.030	1-5/8	4	4	82322	82322W	HSV-M-40500-R.030
	1/2	.030	2	4	4	84736		HSV-L-40500-R.030
	1/2	.060	5/8	2-1/2	4	82323		HSV-S-40500-R.060
	1/2	.060	1	3	4	82324		HSV-SR-40500-R.060
	1/2	.060	1-1/4	3	4	82325		HSV-R-40500-R.060
	1/2	.060	1-5/8	4	4	82326		HSV-M-40500-R.060
	1/2	.060	2	4	4	84737		HSV-L-40500-R.060
	1/2	.090	5/8	2-1/2	4	84738		HSV-S-40500-R.090
	1/2	.090	1	3	4	84739		HSV-SR-40500-R.090
	1/2	.090	1-1/4	3	4	84740		HSV-R-40500-R.090
	1/2	.120	5/8	2-1/2	4	88228		HSV-S-40500-R.120
	1/2	.120	1	3	4	88229		HSV-SR-40500-R.120
	1/2	.120	1-1/4	3	4	88230		HSV-R-40500-R.120
	1/2	.120	1-5/8	4	4	88231		HSV-M-40500-R.120
	1/2	.120	2	4	4	88232		HSV-L-40500-R.120
	1/2	.125	5/8	2-1/2	4	83263		HSV-S-40500-R.125
	1/2	.125	1	3	4	83264		HSV-SR-40500-R.125
	1/2	.125	1-1/4	3	4	83265		HSV-R-40500-R.125
	1/2	.125	1-5/8	4	4	83266		HSV-M-40500-R.125
	1/2	.125	2	4	4	84741		HSV-L-40500-R.125
5/8	5/8	.030	3/4	3	4	88233		HSV-S-40625-R.030
	5/8	.030	1-1/4	3-1/2	4	83267		HSV-SR-40625-R.030
	5/8	.030	1-5/8	3-1/2	4	83268		HSV-R-40625-R.030
	5/8	.030	2	4	4	83269		HSV-M-40625-R.030
	5/8	.125	3/4	3	4	88234		HSV-S-40625-R.125
	5/8	.125	1-1/4	3-1/2	4	88235		HSV-SR-40625-R.125
	5/8	.125	1-5/8	3-1/2	4	88236		HSV-R-40625-R.125
	5/8	.125	2	4	4	88237		HSV-M-40625-R.125

* .0005 max TIR

continued on next page

4 FLUTE - CORNER RADIUS

New Items!

HSV-4 / HSM-4

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .002$	Shank Diameter D2 (R)	Corner Radius R $\pm .002$	Length of Cut L2 $\pm .002$	Overall Length L1 $\pm .002$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
3/4	3/4	.030	7/8	3	4	83270		HSV-S-40750-R.030
	3/4	.030	1-1/4	4	4	83271		HSV-SR-40750-R.030
	3/4	.030	1-5/8	4	4	83272		HSV-R-40750-R.030
	3/4	.030	2-1/4	5	4	83273		HSV-M-40750-R.030
	3/4	.030	3-1/4	6	4	83272		HSV-L-40750-R.030
	3/4	.060	7/8	3	4	87718		HSV-S-40750-R.060
	3/4	.060	1-1/4	4	4	87719		HSV-SR-40750-R.060
	3/4	.060	1-5/8	4	4	87720		HSV-R-40750-R.060
	3/4	.060	2-1/4	5	4	87721		HSV-M-40750-R.060
	3/4	.060	3-1/4	6	4	87722		HSV-L-40750-R.060
	3/4	.125	7/8	3	4	87723		HSV-S-40750-R.125
	3/4	.125	1-1/4	4	4	87724		HSV-SR-40750-R.125
	3/4	.125	1-5/8	4	4	87725		HSV-R-40750-R.125
	3/4	.125	2-1/4	5	4	87726		HSV-M-40750-R.125
	3/4	.125	3-1/4	6	4	87727		HSV-L-40750-R.125
1	1	.030	2	4-1/2	4	88238		HSV-S-41000-R.030
	1	.030	2-5/8	5	4	88239		HSV-M-41000-R.030
	1	.030	3	6	4	88240		HSV-ML-41000-R.030
	1	.030	4-1/4	7	4	88241		HSV-L-41000-R.030

new

new

new

new

* .0005 max TIR

HSV-RN-4

4 FLUTE - SQUARE
Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h5 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 125 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (H8)	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Reach (LBS) L3	Neck Diameter	Flutes	Tplus Coated	Tool Description
1/8	1/8	5/32	3	3/8	.118	4	86935	HSV-RN-S-40125
	1/8	5/32	3	1/2	.118	4	86936	HSV-RN-R-40125
	1/8	5/32	3	5/8	.118	4	86937	HSV-RN-V-40125
	1/8	5/32	3	3/4	.118	4	86938	HSV-RN-M-40125
	1/8	5/32	3	1	.118	4	86939	HSV-RN-L-40125
3/16	3/16	7/32	3	1/2	.178	4	86940	HSV-RN-S-40187
	3/16	7/32	3	3/4	.178	4	86941	HSV-RN-R-40187
	3/16	7/32	3	1	.178	4	86942	HSV-RN-V-40187
	3/16	7/32	3	1-5/16	.178	4	86943	HSV-RN-M-40187
1/4	1/4	3/8	4	3/4	.237	4	86944	HSV-RN-S-40250
	1/4	3/8	4	1-1/8	.237	4	86945	HSV-RN-R-40250
	1/4	3/8	4	1-5/8	.237	4	86946	HSV-RN-V-40250
	1/4	3/8	4	2-1/8	.237	4	86947	HSV-RN-M-40250
3/8	3/8	1/2	4	1-1/8	.356	4	86948	HSV-RN-S-40375
	3/8	1/2	4	1-5/8	.356	4	86949	HSV-RN-R-40375
	3/8	1/2	4	2-1/8	.356	4	86950	HSV-RN-V-40375
	3/8	1/2	6	2-1/2	.356	4	86951	HSV-RN-M-40375
1/2	1/2	5/8	4	1-1/2	.475	4	86952	HSV-RN-S-40500
	1/2	5/8	4	1-3/4	.475	4	86953	HSV-RN-R-40500
	1/2	5/8	4	2-1/4	.475	4	86954	HSV-RN-V-40500
	1/2	5/8	5	2-3/4	.475	4	86955	HSV-RN-M-40500
	1/2	5/8	8	3-3/8	.475	4	86956	HSV-RN-L-40500
3/4	3/4	1	6	2-1/2	.712	4	86957	HSV-RN-S-40750
	3/4	1	8	3-3/8	.712	4	86958	HSV-RN-R-40750
	3/4	1	6	4-1/8	.712	4	86959	HSV-RN-M-40750

* .0005 max TIP



4 FLUTE - BALL

Variable Pitch - Reduced Neck

HSV-RN-4

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 126 for Aplus coating



Outer Diameter* D1 $\begin{smallmatrix} +.0008 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 h6	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Reach (LBS) L3	Neck Diameter	Flutes	T _{plus} Coated	Tool Description
1/8	1/8	5/32	3	3/8	118	4	95875	HSV-RN-S-40125-BN
	1/8	5/32	3	1/2	118	4	95876	HSV-RN-R-40125-BN
	1/8	5/32	3	5/8	118	4	95877	HSV-RN-M-40125-BN
	1/8	5/32	3	3/4	118	4	95878	HSV-RN-ML-40125-BN
	1/8	5/32	3	1	118	4	95879	HSV-RN-LX-40125-BN
	1/8	5/32	3	1	118	4	95880	HSV-RN-S-40187-BN
3/16	3/16	7/32	3	1/2	178	4	95881	HSV-RN-R-40187-BN
	3/16	7/32	3	3/4	178	4	95882	HSV-RN-M-40187-BN
	3/16	7/32	3	1	178	4	95883	HSV-RN-L-40187-BN
	3/16	7/32	3	1 5/16	178	4	95884	HSV-RN-S-40250-BN
	3/16	7/32	3	1 5/16	178	4	95885	HSV-RN-R-40250-BN
1/4	1/4	3/8	4	1-1/8	237	4	95886	HSV-RN-A-40250-BN
	1/4	3/8	4	1-5/8	237	4	95887	HSV-RN-M-40250-BN
	1/4	3/8	4	2-1/8	237	4	95888	HSV-RN-S-40375-BN
	1/4	3/8	4	1-1/8	356	4	95889	HSV-RN-SR-40375-BN
	1/4	3/8	4	1-5/8	356	4	95890	HSV-RN-R-40375-BN
3/8	3/8	1/2	6	2-1/2	356	4	95891	HSV-RN-A-40375-BN
	1/2	5/8	4	1-1/2	475	4	95892	HSV-RN-S-40500-BN
	1/2	5/8	4	1-3/4	475	4	95893	HSV-RN-SR-40500-BN
	1/2	5/8	4	2-1/4	475	4	95894	HSV-RN-R-40500-BN
1/2	1/2	5/8	5	2-3/4	475	4	95895	HSV-RN-A-40500-BN
	1/2	5/8	6	3-3/8	475	4	95896	HSV-RN-M-40500-BN
3/4	3/4	1	6	2-1/2	712	4	95897	HSV-RN-R-40750-BN
	3/4	1	6	3-3/8	712	4	95898	HSV-RN-M-40750-BN
	3/4	1	6	4-1/8	712	4	95899	HSV-RN-L-40750-BN

* .0005 max TIR



Speeds & Feeds on Page 132

HSV-RN-4

4 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered with eccentric relief for maximum edge strength in both roughing and finishing applications
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics

- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 128 for Aplus coating



Cutter Dia. * D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (H8)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L1 $\pm \frac{.001}{.002}$	Overall Length L2 $\pm \frac{.001}{.002}$	Reach (LBS) L3	Neck Diameter D3	Flutes	Tplus Coated	Tool Description
1/8	1/8	.010	5/32	5	3/8	.118	4	88900	HSV-RN-S-40125-R.010
	1/8	.010	5/32	5	1/2	.118	4	88901	HSV-RN-R-40125-R.010
	1/8	.010	5/32	5	5/8	.118	4	88902	HSV-RN-M-40125-R.010
	1/8	.010	5/32	5	3/4	.118	4	88903	HSV-RN-L-40125-R.010
3/16	3/16	.010	7/32	5	1/2	.178	4	88904	HSV-RN-S-40187-R.010
	3/16	.010	7/32	5	3/4	.178	4	88905	HSV-RN-R-40187-R.010
	3/16	.010	7/32	5	1	.178	4	88906	HSV-RN-M-40187-R.010
	3/16	.010	7/32	5	1-5/16	.178	4	88907	HSV-RN-L-40187-R.010
1/4	1/4	.020	3/8	5	3/4	.237	4	88908	HSV-RN-S-40250-R.020
	1/4	.020	3/8	4	1-1/8	.237	4	88909	HSV-RN-R-40250-R.020
	1/4	.020	3/8	4	1-5/8	.237	4	88910	HSV-RN-M-40250-R.020
	1/4	.020	3/8	4	2-1/8	.237	4	88911	HSV-RN-L-40250-R.020
	1/4	.030	3/8	5	3/4	.237	4	88912	HSV-RN-S-40250-R.030
	1/4	.030	3/8	4	1-1/8	.237	4	88913	HSV-RN-R-40250-R.030
	1/4	.030	3/8	4	1-5/8	.237	4	88914	HSV-RN-M-40250-R.030
	1/4	.030	3/8	4	2-1/8	.237	4	88915	HSV-RN-L-40250-R.030
3/8	3/8	.020	1/2	4	1-1/8	.356	4	88916	HSV-RN-S-40375-R.020
	3/8	.020	1/2	4	2-1/8	.356	4	88917	HSV-RN-R-40375-R.020
	3/8	.020	1/2	6	3-1/8	.356	4	88918	HSV-RN-M-40375-R.020
	3/8	.020	1/2	6	4-1/8	.356	4	88919	HSV-RN-L-40375-R.020
	3/8	.030	1/2	4	1-1/8	.356	4	88920	HSV-RN-S-40375-R.030
	3/8	.030	1/2	4	2-1/8	.356	4	88921	HSV-RN-R-40375-R.030
	3/8	.030	1/2	6	3-1/8	.356	4	88922	HSV-RN-M-40375-R.030
	3/8	.030	1/2	6	4-1/8	.356	4	88923	HSV-RN-L-40375-R.030
1/2	1/2	.030	5/8	4	1-1/2	.475	4	88924	HSV-RN-S-40500-R.030
	1/2	.030	5/8	4	2-1/4	.475	4	88925	HSV-RN-R-40500-R.030
	1/2	.030	5/8	6	3-3/8	.475	4	88926	HSV-RN-M-40500-R.030
	1/2	.030	5/8	6	4-1/8	.475	4	88927	HSV-RN-L-40500-R.030
	1/2	.060	5/8	4	1-1/2	.475	4	88928	HSV-RN-S-40500-R.060
	1/2	.060	5/8	4	2-1/4	.475	4	88929	HSV-RN-R-40500-R.060
	1/2	.060	5/8	6	3-3/8	.475	4	88930	HSV-RN-M-40500-R.060
	1/2	.060	5/8	6	4-1/8	.475	4	88931	HSV-RN-L-40500-R.060
3/4	3/4	.030	1	6	2-1/2	.712	4	88932	HSV-RN-S-40750-R.030
	3/4	.030	1	6	3-3/8	.712	4	88933	HSV-RN-R-40750-R.030
	3/4	.030	1	6	4-1/8	.712	4	88934	HSV-RN-L-40750-R.030

* .0005 max. TIR

4 FLUTE - CORNER RADIUS

HEVC-4

Coolant Through - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- 4 flute variable pitch design for reduced harmonics and increased feed rates
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .002$ $-.002$	Shank Diameter D2 (H6)	Corner Radius R $\pm .002$ $-.002$	Length of Cut L2 $\pm .002$ $-.002$	Overall Length L1 $\pm .002$ $-.002$	Flutes	Tplus Coated	Tool Description
1/4	1/4	.020	1/2	2-1/2	4	\$4289	HEVC-020-40250-R.020
	1/4	.020	3/4	2-1/2	4	\$4290	HEVC-030-40250-R.020
	1/4	.030	1/2	2-1/2	4	\$4291	HEVC-020-40250-R.030
	1/4	.030	3/4	2-1/2	4	\$4292	HEVC-030-40250-R.030
3/8	3/8	.020	1/2	2	4	\$4293	HEVC-013-40375-R.020
	3/8	.020	1	3	4	\$4294	HEVC-026-40375-R.020
	3/8	.030	1/2	2	4	\$4295	HEVC-013-40375-R.030
	3/8	.030	1	3	4	\$4296	HEVC-026-40375-R.030
1/2	1/2	.030	1	3	4	\$4297	HEVC-020-40500-R.030
	1/2	.030	1-1/4	3	4	\$4298	HEVC-025-40500-R.030
	1/2	.030	1-5/8	4	4	\$4299	HEVC-032-40500-R.030
	1/2	.060	1	3	4	\$4300	HEVC-020-40500-R.060
	1/2	.060	1-1/4	3	4	\$4301	HEVC-025-40500-R.060
	1/2	.060	1-5/8	4	4	\$4302	HEVC-032-40500-R.060
3/4	3/4	.030	1-5/8	4	4	\$4303	HEVC-021-40750-R.030
	3/4	.030	2-1/4	5	4	\$4304	HEVC-030-40750-R.030

* .0005 max TIR



HEVC-4

SPEEDS & FEEDS

4 Flute - Corner Radius - Coolant Through - Variable Pitch

HEVC-4

HEVC-4																											
Material Guide		Hardness	SPM	Inches per Tooth (IPT)																							
				1/8			3/16			1/4			5/8			1/2			3/4			1					
				Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin			
CARBON STEEL	1008, 1108, 1208, 12LXX, ASTM A27, ASTM A36	< 75 HRB	455	.0007	.0013	.0017	.0011	.0019	.0019	.0014	.0025	.0022	.0021	.0037	.0025	.0028	.0048	.0029	.0048	.0070	.0054	.0050	.0089	.0042			
		75- 88 HRB	445	.0005	.0009	.0014	.0008	.0014	.0016	.0010	.0018	.0018	.0027	.0021	.0020	.0038	.0025	.0025	.0051	.0025	.0027	.0085	.0036				
		21- 36 HRC	400	.0003	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0019	.0018	.0017	.0013	.0023	.0020	.0019	.0033	.0024	.0024	.0042	.0029			
LOW ALLOY STEEL	1300, 4100, 4300, 5100, 8500, 9300	75- 88 HRB	380	.0005	.0009	.0014	.0007	.0012	.0015	.0009	.0019	.0017	.0013	.0024	.0029	.0017	.0031	.0023	.0025	.0044	.0027	.0032	.0058	.0033			
		21- 36 HRC	340	.0003	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0019	.0018	.0017	.0013	.0023	.0020	.0019	.0033	.0024	.0024	.0042	.0029			
		36- 50 HRC	280	.0003	.0005	.0011	.0005	.0008	.0012	.0006	.0013	.0014	.0009	.0015	.0015	.0011	.0021	.0019	.0018	.0029	.0022	.0021	.0038	.0027			
		> 50 HRC	155	.0002	.0004	.0010	.0004	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0017	.0013	.0023	.0026	.0019	.0025	.0034			
TOOL STEEL	A2, H13, L8, P20, S7	75- 88 HRB	340	.0005	.0009	.0014	.0007	.0012	.0015	.0009	.0019	.0017	.0013	.0024	.0029	.0017	.0031	.0023	.0025	.0044	.0027	.0032	.0058	.0033			
		21- 36 HRC	250	.0004	.0006	.0012	.0005	.0009	.0013	.0007	.0013	.0015	.0011	.0019	.0017	.0014	.0023	.0020	.0021	.0035	.0024	.0025	.0041	.0029			
		36- 50 HRC	145	.0003	.0005	.0011	.0004	.0007	.0012	.0006	.0013	.0014	.0008	.0015	.0015	.0011	.0019	.0018	.0016	.0028	.0022	.0020	.0035	.0026			
		> 50 HRC	65	.0002	.0004	.0010	.0003	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0016	.0013	.0022	.0019	.0016	.0025	.0023			
SPECIALTY STEEL	303M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	< 75 HRB	290	.0006	.0011	.0015	.0009	.0015	.0017	.0012	.0021	.0020	.0019	.0031	.0023	.0023	.0041	.0026	.0030	.0059	.0032	.0042	.0074	.0038			
		75- 88 HRB	250	.0004	.0007	.0013	.0008	.0011	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0016	.0028	.0022	.0023	.0040	.0026	.0029	.0051	.0031			
		21- 36 HRC	170	.0004	.0007	.0012	.0006	.0010	.0013	.0007	.0013	.0015	.0011	.0019	.0019	.0014	.0028	.0021	.0025	.0036	.0028	.0026	.0046	.0030			
		36- 50 HRC	150	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0012	.0015	.0019	.0017	.0017	.0013	.0022	.0019	.0018	.0032	.0023	.0023	.0041	.0028			
		> 50 HRC	58	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0010	.0013	.0008	.0014	.0015	.0011	.0020	.0018	.0014	.0025	.0022			
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MOL 316, 316L, 321, 347	75- 88 HRB	285	.0004	.0008	.0013	.0007	.0012	.0015	.0008	.0019	.0017	.0013	.0023	.0019	.0017	.0036	.0023	.0024	.0043	.0027	.0031	.0058	.0033			
		21- 36 HRC	225	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0015	.0027	.0021	.0022	.0039	.0028	.0028	.0048	.0031			
		36- 50 HRC	180	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0043	.0028			
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 440	75- 88 HRB	300	.0005	.0009	.0013	.0007	.0012	.0015	.0009	.0018	.0017	.0013	.0024	.0029	.0018	.0031	.0023	.0025	.0044	.0027	.0032	.0057	.0033			
		21- 36 HRC	280	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0015	.0027	.0021	.0022	.0039	.0028	.0028	.0048	.0031			
		36- 50 HRC	145	.0003	.0005	.0011	.0004	.0008	.0012	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0043	.0028			
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 480	21- 36 HRC	200	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0012	.0015	.0019	.0017	.0017	.0013	.0023	.0020	.0018	.0033	.0023	.0024	.0041	.0028			
		36- 50 HRC	145	.0003	.0005	.0011	.0004	.0008	.0012	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0043	.0028			
GRAY CAST IRON	SAE 4031, ASTM A48	75- 88 HRB	410	.0007	.0013	.0017	.0011	.0019	.0019	.0015	.0028	.0022	.0022	.0038	.0025	.0028	.0051	.0029	.0041	.0072	.0035	.0052	.0091	.0043			
		21- 36 HRC	370	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0015	.0027	.0022	.0022	.0039	.0028	.0028	.0050	.0031			
MALLEABLE CAST IRON	ASTM A47, ASTM A230, ASTM A462	75- 88 HRB	345	.0005	.0009	.0014	.0007	.0012	.0015	.0009	.0019	.0017	.0014	.0024	.0029	.0018	.0032	.0023	.0028	.0045	.0028	.0033	.0058	.0034			
		21- 36 HRC	330	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0016	.0027	.0022	.0022	.0039	.0028	.0028	.0050	.0031			
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM B81	75- 88 HRB	310	.0005	.0009	.0014	.0007	.0013	.0015	.0010	.0017	.0018	.0014	.0025	.0020	.0019	.0033	.0024	.0027	.0047	.0028	.0034	.0062	.0034			
		21- 36 HRC	280	.0003	.0006	.0011	.0005	.0008	.0013	.0008	.0011	.0014	.0019	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0046	.0028			
		36- 50 HRC	135	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0011	.0013	.0008	.0014	.0015	.0011	.0020	.0019	.0014	.0025	.0022			
PURE NICKEL	Nical 200, Nical 201	< 75 HRB	285	.0006	.0011	.0016	.0009	.0016	.0018	.0012	.0022	.0020	.0018	.0032	.0023	.0024	.0042	.0027	.0035	.0061	.0032	.0044	.0077	.0039			
		75- 88 HRB	250	.0005	.0009	.0014	.0008	.0014	.0016	.0010	.0018	.0018	.0015	.0027	.0021	.0020	.0038	.0025	.0029	.0051	.0025	.0037	.0065	.0036			
NICKEL ALLOY	Hastelloy C-22, Inconel 605, Waspaloy, Rene 41, Inconel 718, Inconel 720	75- 88 HRB	30	.0003	.0006	.0011	.0005	.0008	.0013	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0022	.0039	.0028			
		21- 36 HRC	70	.0003	.0005	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0008	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0021	.0038	.0027			
		36- 50 HRC	70	.0003	.0005	.0010	.0004	.0007	.0011	.0005	.0009	.0013	.0008	.0014	.0015	.0010	.0018	.0017	.0014	.0025	.0021	.0018	.0032	.0025			
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 5, Ti Grade 12	< 75 HRB	300	.0009	.0015	.0019	.0013	.0022	.0021	.0017	.0030	.0024	.0025	.0045	.0027	.0033	.0058	.0032	.0048	.0084	.0038	.0061	.0107	.0046			
		75- 88 HRB	275	.0007	.0013	.0017	.0011	.0019	.0019	.0014	.0025	.0022	.0021	.0038	.0025	.0028	.0048	.0029	.0040	.0070	.0038	.0051	.0090	.0042			
		21- 36 HRC	250	.0006	.0013	.0015	.0006	.0014	.0017	.0011	.0019	.0018	.0025	.0022	.0021	.0037	.0025	.0036	.0053	.0036	.0038	.0067	.0036				
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21- 36 HRC	180	.0004	.0008	.0013	.0006	.0011	.0015	.0009	.0015	.0017	.0013	.0022	.0019	.0016	.0025	.0022	.0024	.0042	.0027	.0030	.0053	.0032			
		36- 50 HRC	180	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0028	.0021	.0022	.0038	.0025	.0027	.0046	.0031			
COBALT ALLOY	ASTM F602, ASTM F603, ASTM F75, ASTM F799	75- 88 HRB	210	.0004	.0008	.0012	.0008	.0009	.0014	.0007	.0013	.0015	.0011	.0019	.0018	.0014	.0025	.0021	.0026	.0035	.0024	.0025	.0045	.0030			
		21- 36 HRC	170	.0004	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0019	.0018	.0017	.0013	.0024	.0020	.0019	.0034	.0024	.0025	.0042	.0029			
		36- 50 HRC	65	.0002	.0004	.0010	.0004	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0017	.0013	.0023	.0021	.0017	.0029	.0024			

MILLING PROCESS	HARDNESS	DOC	RDOC
Slot (Full Slotting)	< 35 HRC	75%-125% Diameter	100% Diameter
	≥ 35 HRC	80%-100% Diameter	100% Diameter
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-35% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

5 FLUTE - SQUARE

New Items!

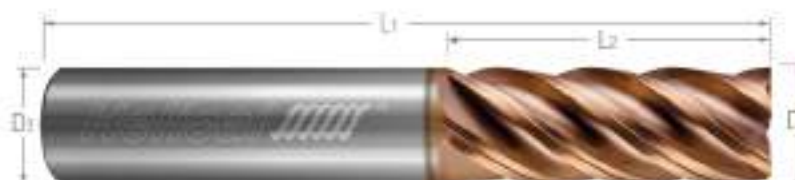


HEV-5 / HSM-5

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 133 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0005 \\ -.0005 \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L2 $\begin{smallmatrix} +.010 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/32	1/4	3/32	2-1/2	5	84081		HSM-C30-50031
	1/4	5/32	2-1/2	5	84082		HSM-C50-50031
3/64	1/4	5/32	2-1/2	5	84083		HSM-C30-50047
	1/4	1/4	2-1/2	5	84084		HSM-C50-50047
1/16	1/4	3/16	2-1/2	5	84085		HSM-C30-50062
	1/4	5/16	2-1/2	5	84086		HSM-C50-50062
5/64	1/4	1/4	2-1/2	5	84087		HSM-C30-50078
	1/4	3/8	2-1/2	5	84088		HSM-C48-50078
3/32	1/4	9/32	2-1/2	5	84089		HSM-C30-50093
	1/4	1/2	2-1/2	5	84090		HSM-C50-50093

Cutter Diameter* D1 $\begin{smallmatrix} +.0005 \\ -.0005 \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/8	1/8	1/4	1-1/2	5	80633		HEV-S-50125
	1/4	1/4	2-1/2	5	84091		HSM-C20-50125
	1/8	3/8	2	5	82525		HEV-SR-50125
	1/4	3/8	2-1/2	5	84092		HSM-C30-50125
	1/8	1/2	2-1/2	5	81640		HEV-S-50125
	1/4	1/2	2-1/2	5	84093		HSM-C40-50125
	1/8	5/8	2-1/2	5	82526		HEV-A-50125
	1/8	3/4	2-1/2	5	82949		HEV-M-50125
	1/8	7/8	2-1/2	5	88248		HEV-L-50125
5/32	1/8	1	2-1/2	5	87496		HEV-LX-50125
	3/16	3/16	2	5	82950		HEV-S-50156
	3/16	5/16	2	5	84633		HEV-SR-50156
	3/16	7/16	2-1/2	5	82951		HEV-R-50156
	3/16	9/16	2-1/2	5	82952		HEV-M-50156
	3/16	3/4	2-1/2	5	88249		HEV-ML-50156
3/16	3/16	1	3	5	88250		HEV-L-50156
	3/16	5/16	2	5	89834		HEV-S-50187
	1/4	5/16	2-1/2	5	84094		HSM-C16-50187
	3/16	7/16	2	5	82527		HEV-SR-50187
	1/4	7/16	2-1/2	5	84095		HSM-C20-50187
	3/16	9/16	2-1/2	5	89835		HEV-R-50187
	1/4	3/16	2-1/2	5	84096		HSM-C28-50187

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 151

HEV-5 / HSM-5



New Items!

5 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

	Cutter Diameter* D1 $^{+0.001}_{-0.002}$ "	Shank Diameter D2 (in)	Length of Cut L1 $^{+0.020}_{-0.005}$ "	Overall Length L1 $^{+0.020}_{-0.010}$ "	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
new	3/16	3/16	3/4	2-1/2	5	81841		HEV-M-50187
		1/4	3/4	2-1/2	5	84007		HSM-040-50187
		3/16	1	2-1/2	5	82863		HEV-ML-50187
		3/16	1-3/16	3	5	88251		HEV-L-50187
	7/32	1/4	5/16	2	5	82954		HEV-S-50216
		1/4	7/16	2-1/2	5	82955		HEV-R-50216
	1/4	1/4	3/8	2	5	59836		HEV-S-50250
		1/4	1/2	2-1/2	5	59837		HEV-SR-50250
		1/4	3/4	2-1/2	5	59838		HEV-R-50250
		1/4	1	3	5	81842		HEV-M-50250
		1/4	1-1/4	3	5	82528		HEV-L-50250
		1/4	1-1/2	3	5	82956		HEV-LX-50250
		1/4	1-3/4	4	5	87497		HEV-X-50250
new	5/16	5/16	7/16	2	5	59839		HEV-S-50312
		5/16	3/8	2-1/2	5	88252		HEV-SR-50312
		5/16	13/16	2-1/2	5	59840		HEV-R-50312
		5/16	1	3	5	59841		HEV-M-50312
		5/16	1-1/4	3	5	87498		HEV-L-50312
	3/8	3/8	1/2	2	5	59842	59842W	HEV-S-50375
		3/8	3/4	2-1/2	5	82529		HEV-SR-50375
		3/8	1	3	5	59843	59843W	HEV-R-50375
		3/8	1-1/4	3	5	59844		HEV-M-50375
		3/8	1-1/2	3-1/2	5	81843		HEV-L-50375
		3/8	2	4	5	87499		HEV-LX-50375
new new new	7/16	7/16	5/8	2-3/4	5	88253		HEV-S-50437
		7/16	7/8	2-3/4	5	88254		HEV-R-50437
		7/16	1-1/8	3-1/2	5	88255		HEV-M-50437
	1/2	1/2	3/8	2-1/2	5	59845	59845W	HEV-S-50500
		1/2	1	3	5	59846	59846W	HEV-SR-50500
		1/2	1-1/4	3	5	59847	59847W	HEV-R-50500
		1/2	1-5/8	4	5	59848		HEV-M-50500
		1/2	2	4	5	81844		HEV-L-50500
		1/2	2-1/2	5	5	84634		HEV-LX-50500
		1/2	3-1/8	6	5	84635		HEV-X-50500
new	5/8	5/8	3/4	3	5	59849	59849W	HEV-S-50625
		5/8	1-1/4	3-1/2	5	59850		HEV-SR-50625
		5/8	1-5/8	3-1/2	5	59851	59851W	HEV-R-50625
		5/8	2-1/8	4	5	81845		HEV-M-50625
		5/8	2-1/2	5	5	81846		HEV-L-50625
	3/4	3/4	1	3	5	59852		HEV-S-50750
		3/4	1-5/8	4	5	59853	59853W	HEV-R-50750
		3/4	2-1/4	5	5	59854	59854W	HEV-M-50750
		3/4	2-3/4	5	5	81847		HEV-L-50750
		3/4	3-1/4	6	5	82957		HEV-LX-50750
		3/4	4	6-1/2	5	88257		HEV-X-50750
new	1	1	2	4-1/2	5	81848		HEV-R-51000
		1	2-5/8	5	5	81849		HEV-M-51000
		1	3-1/4	6	5	88258		HEV-L-51000

* .0005 max TIP

5 FLUTE - CORNER RADIUS

New Items!



HEV-5 / HSM-5

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 137 for Aplus coating



Cutter Dia.* D1 $\pm .005$ $\pm .005$	Shank Dia. D2 (H6)	Corner Radius R $\pm .01$ $\pm .01$	LOC L2 $\pm .010$ $\pm .010$	OAL L1 $\pm .002$ $\pm .002$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/32	1/4	.005	3/32	2-1/2	5	84057		HSM-030-50031-R.005
	1/4	.005	5/32	2-1/2	5	84058		HSM-050-50031-R.005
3/64	1/4	.010	5/32	2-1/2	5	84059		HSM-030-50047-R.010
	1/4	.010	1/4	2-1/2	5	84060		HSM-050-50047-R.010
1/16	1/4	.010	3/16	2-1/2	5	84061		HSM-030-50062-R.010
	1/4	.010	5/16	2-1/2	5	84062		HSM-050-50062-R.010
5/64	1/4	.010	1/4	2-1/2	5	84063		HSM-032-50078-R.010
	1/4	.010	3/8	2-1/2	5	84064		HSM-048-50078-R.010
3/32	1/4	.010	9/32	2-1/2	5	84065		HSM-030-50093-R.010
	1/4	.010	1/2	2-1/2	5	84066		HSM-050-50093-R.010

Cutter Dia.* D1 $\pm .007$ $\pm .007$	Shank Dia. D2 (H6)	Corner Radius R $\pm .002$ $\pm .002$	LOC L2 $\pm .002$ $\pm .002$	OAL L1 $\pm .002$ $\pm .002$	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	58855		HEV-S-50125-R.010
	1/4	.010	1/4	2-1/2	5	84067		HSM-020-50125-R.010
	1/8	.010	3/8	2	5	82970		HEV-SR-50125-R.010
	1/4	.010	3/8	2-1/2	5	84068		HSM-030-50125-R.010
	1/8	.010	1/2	2-1/2	5	81850		HEV-R-50125-R.010
	1/4	.010	1/2	2-1/2	5	84069		HSM-040-50125-R.010
	1/8	.010	5/8	2-1/2	5	84669		HEV-A-50125-R.010
	1/8	.010	3/4	3-1/2	5	82971		HEV-M-50125-R.010
	1/8	.010	7/8	2-1/2	5	88394		HEV-L-50125-R.010
	1/8	.015	1/4	1-1/2	5	82972		HEV-S-50125-R.015
	1/8	.015	3/8	2	5	84670		HEV-SR-50125-R.015
	1/8	.015	1/2	2-1/2	5	82973		HEV-R-50125-R.015
	1/8	.015	5/8	2-1/2	5	87590		HEV-A-50125-R.015
	1/8	.015	3/4	2-1/2	5	87501		HEV-M-50125-R.015
	1/8	.020	1/4	1-1/2	5	87502		HEV-S-50125-R.020
	1/8	.020	3/8	2	5	87503		HEV-SR-50125-R.020
	1/8	.020	1/2	2-1/2	5	87504		HEV-R-50125-R.020
	1/8	.020	5/8	2-1/2	5	87505		HEV-A-50125-R.020
	1/8	.020	3/4	1-1/2	5	81851		HEV-S-50125-R.020
	1/4	.020	1/4	2-1/2	5	84074		HSM-020-50125-R.020
	1/8	.020	3/8	2	5	84671		HEV-SR-50125-R.020

*.0005 max TIR

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HEV-5 / HSM-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

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Cutter Dia.* D ₁ $\pm .0007$ -.002	Shank Dia. D ₂ h8	Corner Radius R $\pm .002$ -.002	LOC L ₂ $\pm .012$ -.007	OAL L ₁ $\pm .002$ -.002	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
1/8	1/4	.030	3/8	2-1/2	5	84975		HSM-030-50125-R.030
	1/8	.030	1/2	2-1/2	5	81852		HEV-R-50125-R.030
	1/4	.030	1/2	2-1/2	5	84076		HSM-040-50125-R.030
	1/8	.030	5/8	2-1/2	5	84572		HEV-A-50125-R.030
	1/8	.030	3/4	2-1/2	5	82974		HEV-M-50125-R.030
	1/8	.030	7/8	2-1/2	5	88305		HEV-L-50125-R.030
5/32	3/16	.010	3/16	2	5	88306		HEV-S-50156-R.010
	3/16	.010	5/16	2	5	88307		HEV-SR-50156-R.010
	3/16	.010	7/16	2-1/2	5	88308		HEV-R-50156-R.010
	3/16	.010	9/16	2-1/2	5	88309		HEV-M-50156-R.010
	3/16	.010	3/4	2-1/2	5	88310		HEV-ML-50156-R.010
	3/16	.030	3/16	2	5	88311		HEV-S-50156-R.030
	3/16	.030	5/16	2	5	88312		HEV-SR-50156-R.030
	3/16	.030	7/16	2-1/2	5	88313		HEV-R-50156-R.030
	3/16	.030	9/16	2-1/2	5	88314		HEV-M-50156-R.030
	3/16	.030	3/4	2-1/2	5	88315		HEV-ML-50156-R.030
	3/16	.010	5/16	2	5	59356		HEV-S-50187-R.010
	1/4	.010	5/16	2-1/2	5	84070		HSM-016-50187-R.010
3/16	3/16	.010	7/16	2	5	82975		HEV-SR-50187-R.010
	1/4	.010	7/16	2-1/2	5	84071		HSM-023-50187-R.010
	3/16	.010	9/16	2-1/2	5	59357		HEV-R-50187-R.010
	1/4	.010	9/16	2-1/2	5	84072		HSM-029-50187-R.010
	3/16	.010	3/4	2-1/2	5	81853		HEV-M-50187-R.010
	1/4	.010	3/4	2-1/2	5	84073		HSM-040-50187-R.010
	3/16	.010	1	2-1/2	5	84573		HEV-ML-50187-R.010
	3/16	.015	5/16	2	5	82976		HEV-S-50187-R.015
	3/16	.015	7/16	2	5	88316		HEV-SR-50187-R.015
	3/16	.015	9/16	2-1/2	5	82977		HEV-R-50187-R.015
	3/16	.015	3/4	2-1/2	5	88317		HEV-M-50187-R.015
	3/16	.015	1	2-1/2	5	88318		HEV-ML-50187-R.015
	3/16	.030	5/16	2	5	81854		HEV-S-50187-R.030
	1/4	.030	5/16	2-1/2	5	84077		HSM-016-50187-R.030
	3/16	.030	7/16	2	5	84674		HEV-SR-50187-R.030
	1/4	.030	7/16	2-1/2	5	84078		HSM-023-50187-R.030
	3/16	.030	9/16	2-1/2	5	81855		HEV-R-50187-R.030
	1/4	.030	9/16	2-1/2	5	84079		HSM-029-50187-R.030
	3/16	.030	3/4	2-1/2	5	81856		HEV-M-50187-R.030
	1/4	.030	3/4	2-1/2	5	84080		HSM-040-50187-R.030
	3/16	.030	1	2-1/2	5	84575		HEV-ML-50187-R.030
1/4	1/4	.010	3/8	2	5	82978		HEV-S-50250-R.010
	1/4	.010	1/2	2-1/2	5	82979		HEV-SR-50250-R.010
	1/4	.010	3/4	2-1/2	5	82980		HEV-R-50250-R.010
	1/4	.010	1	3	5	87506		HEV-M-50250-R.010
	1/4	.010	1-1/4	3	5	87507		HEV-L-50250-R.010
	1/4	.015	3/8	2	5	82981		HEV-S-50250-R.015
	1/4	.015	1/2	2-1/2	5	82982		HEV-SR-50250-R.015
	1/4	.015	3/4	2-1/2	5	82983		HEV-R-50250-R.015
	1/4	.015	1	3	5	87508		HEV-M-50250-R.015
	1/4	.015	1-1/4	3	5	87509		HEV-L-50250-R.015
	1/4	.020	3/8	2	5	59358		HEV-S-50250-R.020
	1/4	.020	1/2	2-1/2	5	59359		HEV-SR-50250-R.020
	1/4	.020	3/4	2-1/2	5	59360		HEV-R-50250-R.020
	1/4	.020	1	3	5	81857		HEV-M-50250-R.020
	1/4	.020	1-1/4	3	5	82984		HEV-L-50250-R.020

*.0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-5 / HSM-5

Variable Pitch (cont.)

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Cutter Dia.* D1 $\pm .002$ "	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ " $\pm .002$ "	L0C L1 $\pm .002$ " $\pm .002$ "	OAL L1 $\pm .002$ " $\pm .002$ "	Flutes	T plus Coated	T plus Coated + Weldon Flat	Tool Description	
1/4	1/4	.030	3/8	2	5	59861		HEV-S-50250-R.030	
	1/4	.030	1/2	2-1/2	5	59862		HEV-SR-50250-R.030	
	1/4	.030	3/4	2-1/2	5	59863		HEV-R-50250-R.030	
	1/4	.030	1	3	5	81858		HEV-M-50250-R.030	
	1/4	.030	1-1/4	3	5	82985		HEV-L-50250-R.030	
	1/4	.040	3/8	2	5	88319		HEV-S-50250-R.040	new
	1/4	.040	1/2	2-1/2	5	88320		HEV-SR-50250-R.040	new
	1/4	.040	3/4	2-1/2	5	88321		HEV-R-50250-R.040	new
	1/4	.040	1	3	5	88322		HEV-M-50250-R.040	new
	1/4	.060	3/8	2	5	81859		HEV-S-50250-R.060	
	1/4	.060	1/2	2-1/2	5	81860		HEV-SR-50250-R.060	
	1/4	.060	3/4	2-1/2	5	81861		HEV-R-50250-R.060	
5/16	5/16	.010	7/16	2	5	84676		HEV-S-50312-R.010	
	5/16	.010	13/16	2-1/2	5	84677		HEV-SR-50312-R.010	
	5/16	.010	1-1/4	3	5	87510		HEV-M-50312-R.010	
	5/16	.015	7/16	2	5	88323		HEV-S-50312-R.015	new
	5/16	.015	13/16	2-1/2	5	88324		HEV-SR-50312-R.015	new
	5/16	.015	1	3	5	88325		HEV-M-50312-R.015	new
	5/16	.020	7/16	2	5	59864		HEV-S-50312-R.020	
	5/16	.020	13/16	2-1/2	5	59865		HEV-SR-50312-R.020	
	5/16	.020	1	3	5	81863		HEV-M-50312-R.020	
	5/16	.030	7/16	2	5	82987		HEV-S-50312-R.030	
	5/16	.030	13/16	2-1/2	5	82988		HEV-SR-50312-R.030	
	5/16	.030	1	3	5	82989		HEV-M-50312-R.030	
	5/16	.060	7/16	2	5	88326		HEV-S-50312-R.060	new
	5/16	.060	13/16	2-1/2	5	88327		HEV-SR-50312-R.060	new
3/8	3/8	.010	1/2	2	5	82990		HEV-S-50375-R.010	
	3/8	.010	3/4	2-1/2	5	84678		HEV-SR-50375-R.010	
	3/8	.010	1	3	5	82991		HEV-R-50375-R.010	
	3/8	.010	1-1/4	3	5	87511		HEV-M-50375-R.010	new
	3/8	.010	1-1/2	3-1/2	5	88328		HEV-L-50375-R.010	new
	3/8	.015	1/2	2	5	88330		HEV-S-50375-R.015	new
	3/8	.015	3/4	2-1/2	5	88331		HEV-SR-50375-R.015	new
	3/8	.015	1	3	5	82992		HEV-R-50375-R.015	
	3/8	.015	1-1/4	3	5	87512		HEV-M-50375-R.015	
	3/8	.020	1/2	2	5	59866	59866W	HEV-S-50375-R.020	
	3/8	.020	3/4	2-1/2	5	84679		HEV-SR-50375-R.020	
	3/8	.020	1	3	5	59867	59867W	HEV-R-50375-R.020	
	3/8	.020	1-1/4	3	5	59868		HEV-M-50375-R.020	
	3/8	.020	1-1/2	3-1/2	5	81864		HEV-L-50375-R.020	
	3/8	.030	1/2	2	5	59869	59869W	HEV-S-50375-R.030	
	3/8	.030	3/4	2-1/2	5	82993		HEV-SR-50375-R.030	
	3/8	.030	1	3	5	59870	59870W	HEV-R-50375-R.030	
	3/8	.030	1-1/4	3	5	59871		HEV-M-50375-R.030	
	3/8	.030	1-1/2	3-1/2	5	81865	81865W	HEV-L-50375-R.030	
	3/8	.030	2	4	5	84690		HEV-LX-50375-R.030	
	3/8	.040	1/2	2	5	88332		HEV-S-50375-R.040	new
	3/8	.040	3/4	2-1/2	5	88333		HEV-SR-50375-R.040	new
	3/8	.040	1	3	5	88334		HEV-R-50375-R.040	new
	3/8	.040	1-1/4	3	5	88335		HEV-M-50375-R.040	new

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HEV-5 / HSM-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

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Cutter Dia.* D1 $\pm .007$ -.007	Shank Dia. D2 $\pm .006$	Corner Radius R $\pm .002$ -.002	LOC L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Flutes	Tplus Coated	Tplus Coated + Weldon Flat	Tool Description
new 3/8	3/8	.060	1/2	2	5	59872		HEV-S-50375-R.060
	3/8	.060	3/4	2-1/2	5	82994		HEV-SR-50375-R.060
	3/8	.060	1	3	5	59873		HEV-R-50375-R.060
	3/8	.060	1-1/4	3	5	59874		HEV-M-50375-R.060
	3/8	.060	1-1/2	3-1/2	5	61866		HEV-L-50375-R.060
	3/8	.090	1/2	2	5	82995		HEV-S-50375-R.090
	3/8	.090	3/4	2-1/2	5	88336		HEV-SR-50375-R.090
	3/8	.090	1	3	5	82996		HEV-R-50375-R.090
	3/8	.090	1-1/4	3	5	87513		HEV-M-50375-R.090
	3/8	.120	1/2	2	5	88337		HEV-S-50375-R.120
	3/8	.120	3/4	2-1/2	5	88338		HEV-SR-50375-R.120
	3/8	.120	1	3	5	88339		HEV-R-50375-R.120
	3/8	.120	1-1/4	3	5	88340		HEV-M-50375-R.120
new 1/2	1/2	.010	5/8	2-1/2	5	82997		HEV-S-50500-R.010
	1/2	.010	1	3	5	82998		HEV-SR-50500-R.010
	1/2	.010	1-1/4	3	5	82999		HEV-R-50500-R.010
	1/2	.010	1-5/8	4	5	87514		HEV-M-50500-R.010
	1/2	.010	2	4	5	87515		HEV-L-50500-R.010
	1/2	.015	5/8	2-1/2	5	83000		HEV-S-50500-R.015
	1/2	.015	1	3	5	83001		HEV-SR-50500-R.015
	1/2	.015	1-1/4	3	5	83002		HEV-R-50500-R.015
	1/2	.015	1-5/8	4	5	87516		HEV-M-50500-R.015
	1/2	.015	2	4	5	87517		HEV-L-50500-R.015
	1/2	.020	5/8	2-1/2	5	83003		HEV-S-50500-R.020
	1/2	.020	1	3	5	83004		HEV-SR-50500-R.020
	1/2	.020	1-1/4	3	5	83005		HEV-R-50500-R.020
	1/2	.020	1-5/8	4	5	87518		HEV-M-50500-R.020
	1/2	.020	2	4	5	87519		HEV-L-50500-R.020
	1/2	.030	5/8	2-1/2	5	59875	59875W	HEV-S-50500-R.030
	1/2	.030	1	3	5	59876	59876W	HEV-SR-50500-R.030
	1/2	.030	1-1/4	3	5	59877	59877W	HEV-R-50500-R.030
	1/2	.030	1-5/8	4	5	59878	59878W	HEV-M-50500-R.030
	1/2	.030	2	4	5	81867		HEV-L-50500-R.030
	1/2	.030	2-1/2	5	5	83006		HEV-LX-50500-R.030
	1/2	.040	5/8	2-1/2	5	88341		HEV-S-50500-R.040
	1/2	.040	1	3	5	88342		HEV-SR-50500-R.040
	1/2	.040	1-1/4	3	5	88343		HEV-R-50500-R.040
	1/2	.040	1-5/8	4	5	88344		HEV-M-50500-R.040
	1/2	.040	2	4	5	88345		HEV-L-50500-R.040
	1/2	.060	5/8	2-1/2	5	59879	59879W	HEV-S-50500-R.060
	1/2	.060	1	3	5	59880	59880W	HEV-SR-50500-R.060
	1/2	.060	1-1/4	3	5	59881	59881W	HEV-R-50500-R.060
	1/2	.060	1-5/8	4	5	59882	59882W	HEV-M-50500-R.060
	1/2	.060	2	4	5	81868		HEV-L-50500-R.060
	1/2	.090	5/8	2-1/2	5	81869		HEV-S-50500-R.090
	1/2	.090	1	3	5	81870		HEV-SR-50500-R.090
	1/2	.090	1-1/4	3	5	81871		HEV-R-50500-R.090
	1/2	.090	1-5/8	4	5	81872		HEV-M-50500-R.090
	1/2	.090	2	4	5	81873		HEV-L-50500-R.090
	1/2	.120	5/8	2-1/2	5	59883		HEV-S-50500-R.120
	1/2	.120	1	3	5	59884		HEV-SR-50500-R.120
	1/2	.120	1-1/4	3	5	59885		HEV-R-50500-R.120
	1/2	.120	1-5/8	4	5	59886		HEV-M-50500-R.120
	1/2	.120	2	4	5	81874		HEV-L-50500-R.120
	1/2	.120	2-1/2	5	5	84681		HEV-LX-50500-R.120

*.0005 max TIP

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5 FLUTE - CORNER RADIUS

New Items!



HEV-5 / HSM-5

Variable Pitch (cont.)

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Cutter Dia.* D1 $\pm .002$ -.002	Shank Dia. D2 (mm)	Corner Radius R $\pm .002$ -.002	LOC L1 $\pm .002$ -.002	OAL L2 $\pm .002$ -.002	Flutes	T-plus Coated	T-plus Coated + Weldon Flat	Tool Description
1/2	1/2	.125	5/8	2-1/2	5	87520		HEV-S-50500-R.125
	1/2	.125	1	3	5	87521		HEV-SR-50500-R.125
	1/2	.125	1-1/4	3	5	87522		HEV-R-50500-R.125
	1/2	.125	1-5/8	4	5	87523		HEV-M-50500-R.125
	1/2	.125	2	4	5	87524		HEV-L-50500-R.125
5/8	5/8	.015	3/4	3	5	87525		HEV-S-50625-R.015
	5/8	.015	1-1/4	3-1/2	5	87526		HEV-SR-50625-R.015
	5/8	.015	1-5/8	3-1/2	5	87527		HEV-R-50625-R.015
	5/8	.015	2-1/8	4	5	87528		HEV-M-50625-R.015
	5/8	.030	3/4	3	5	59887	59887W	HEV-S-50625-R.030
	5/8	.030	1-1/4	3-1/2	5	59888		HEV-SR-50625-R.030
	5/8	.030	1-5/8	3-1/2	5	59889	59889W	HEV-R-50625-R.030
	5/8	.030	2-1/8	4	5	81875		HEV-M-50625-R.030
	5/8	.030	2-1/2	5	5	81876		HEV-L-50625-R.030
	5/8	.060	3/4	3	5	88346		HEV-S-50625-R.060
	5/8	.060	1-1/4	3-1/2	5	81877		HEV-SR-50625-R.060
	5/8	.060	1-5/8	3-1/2	5	81878		HEV-R-50625-R.060
	5/8	.060	2-1/8	4	5	81879		HEV-M-50625-R.060
	5/8	.060	2-1/2	5	5	88347		HEV-L-50625-R.060
	5/8	.120	3/4	3	5	88348		HEV-S-50625-R.120
	5/8	.120	1-1/4	3-1/2	5	88349		HEV-SR-50625-R.120
	5/8	.120	1-5/8	3-1/2	5	83007		HEV-R-50625-R.120
	5/8	.120	2-1/8	4	5	83008		HEV-M-50625-R.120
3/4	3/4	.015	1	3	5	87529		HEV-S-50750-R.015
	3/4	.015	1-1/4	4	5	87530		HEV-SR-50750-R.015
	3/4	.015	1-5/8	4	5	87531		HEV-R-50750-R.015
	3/4	.015	2-1/4	5	5	87532		HEV-M-50750-R.015
	3/4	.030	1	3	5	59890	59890W	HEV-S-50750-R.030
	3/4	.030	1-1/4	4	5	83009		HEV-SR-50750-R.030
	3/4	.030	1-5/8	4	5	59891	59891W	HEV-R-50750-R.030
	3/4	.030	2-1/4	5	5	59892	59892W	HEV-M-50750-R.030
	3/4	.030	2-3/4	5	5	81880		HEV-L-50750-R.030
	3/4	.030	3-1/4	6	5	83010		HEV-LX-50750-R.030
	3/4	.060	1	3	5	59893		HEV-S-50750-R.060
	3/4	.060	1-1/4	4	5	83011		HEV-SR-50750-R.060
	3/4	.060	1-5/8	4	5	59894		HEV-R-50750-R.060
	3/4	.060	2-1/4	5	5	59895		HEV-M-50750-R.060
	3/4	.060	2-3/4	5	5	83012		HEV-L-50750-R.060
	3/4	.060	3-1/4	6	5	83013		HEV-LX-50750-R.060
	3/4	.090	1-5/8	4	5	81881		HEV-R-50750-R.090
	3/4	.090	2-1/4	5	5	84682		HEV-M-50750-R.090
	3/4	.120	1	3	5	59896		HEV-S-50750-R.120
	3/4	.120	1-1/4	4	5	88350		HEV-SR-50750-R.120
	3/4	.120	1-5/8	4	5	59897		HEV-R-50750-R.120
	3/4	.120	2-1/4	5	5	59898		HEV-M-50750-R.120
	3/4	.120	2-3/4	5	5	88351		HEV-L-50750-R.120
	3/4	.120	3-1/4	6	5	88352		HEV-LX-50750-R.120
	3/4	.190	1-5/8	4	5	81882		HEV-R-50750-R.190
	3/4	.190	2-1/4	5	5	84683		HEV-M-50750-R.190
	3/4	.250	1-5/8	4	5	81883		HEV-R-50750-R.250
	3/4	.250	2-1/4	5	5	84684		HEV-M-50750-R.250

*.0005 max TIR

continued on next page

HEV-5 / HSM-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Dia. D2 (in)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	T-plus Coated	T-plus Coated + Weldon Flat	Tool Description
1	1	.030	1-1/4	4	5	59989		HEV-S-51000-R.030
	1	.030	2	4-1/2	5	59990		HEV-R-51000-R.030
	1	.030	2-5/8	5	5	59991		HEV-M-51000-R.030
	1	.030	3-1/4	6	5	51384		HEV-L-51000-R.030
	1	.060	1-1/4	4	5	51385		HEV-S-51000-R.060
	1	.060	2	4-1/2	5	51386		HEV-R-51000-R.060
	1	.060	2-5/8	5	5	51387		HEV-M-51000-R.060
	1	.120	1-1/4	4	5	51388		HEV-S-51000-R.120
	1	.120	2	4-1/2	5	51389		HEV-R-51000-R.120
	1	.120	2-5/8	5	5	51390		HEV-M-51000-R.120
	1	.250	1-1/4	4	5	51391		HEV-S-51000-R.250
	1	.250	2	4-1/2	5	51392		HEV-R-51000-R.250
	1	.250	2-5/8	5	5	51393		HEV-M-51000-R.250

*.0005 max TIR

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5 FLUTE - SQUARE

Variable Pitch - Reduced Neck



HEV-RN-5

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 145 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.000 \\ -.000 \end{smallmatrix}$	Shank Diameter D2 h6	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Reach (LBS) L3	Neck Diameter	Flutes	Tplus Coated	Tool Description
1/8	1/8	5/32	1	3/8	118	5	86790	HEV-RN-S-50125
	1/8	5/32	1	1/2	118	5	86790	HEV-RN-R-50125
	1/8	5/32	2-1/2	3/4	118	5	86800	HEV-RN-M-50125
	1/8	5/32	2-1/2	1	118	5	86801	HEV-RN-L-50125
3/16	3/16	7/32	1	1/2	178	5	86802	HEV-RN-R-50187
	3/16	7/32	2-1/2	3/4	178	5	86803	HEV-RN-M-50187
	3/16	7/32	2-1/2	1-1/8	178	5	86804	HEV-RN-L-50187
1/4	1/4	3/8	1	3/4	237	5	86805	HEV-RN-S-50250
	1/4	3/8	1	1-1/8	237	5	86806	HEV-RN-R-50250
	1/4	3/8	1	1-5/8	237	5	86807	HEV-RN-A-50250
	1/4	3/8	1	2-1/8	237	5	86808	HEV-RN-M-50250
	1/4	3/8	1	2-1/2	237	5	86809	HEV-RN-L-50250
3/8	3/8	1/2	1	1-1/8	356	5	86810	HEV-RN-S-50375
	3/8	1/2	1	1-5/8	356	5	86811	HEV-RN-R-50375
	3/8	1/2	1	2-1/8	356	5	86812	HEV-RN-M-50375
	3/8	1/2	1	2-1/2	356	5	86813	HEV-RN-A-50375
	3/8	1/2	1	3-1/8	356	5	86814	HEV-RN-L-50375
1/2	1/2	5/8	1	1-1/2	475	5	86815	HEV-RN-S-50500
	1/2	5/8	1	1-3/4	475	5	86816	HEV-RN-R-50500
	1/2	5/8	1	2-1/4	475	5	86817	HEV-RN-M-50500
	1/2	5/8	1	2-3/4	475	5	86818	HEV-RN-A-50500
	1/2	5/8	1	3-3/8	475	5	86819	HEV-RN-L-50500
3/4	3/4	1	1	2	712	5	86820	HEV-RN-S-50750
	3/4	1	1	2-1/2	712	5	86821	HEV-RN-R-50750
	3/4	1	1	2-7/8	712	5	86822	HEV-RN-M-50750
	3/4	1	1	3-3/8	712	5	86823	HEV-RN-A-50750
	3/4	1	1	4-1/8	712	5	86824	HEV-RN-L-50750

* .0005 max TIR



Speeds & Feeds on Page 151

HEV-RN-5



5 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications

- Center cutting
- h8 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 147 for Aplus coating



Cutter Dia.* D1 $\pm \frac{.0005}{.0010}$	Shank Dia. D2 (H7)	Corner Radius R $\pm \frac{.002}{.003}$	Length of Cut L2 $\pm \frac{.002}{.003}$	OAL L1 $\pm \frac{.002}{.003}$	Reach (LBS) L3	Neck Diameter	Flutes	Tplus Coated	Tool Description
1/8	1/8	.010	5/32	2	3/8	.118	5	86748	HEV-RN-S-50125-R.010
	1/8	.010	5/32	2	1/2	.118	5	86749	HEV-RN-R-50125-R.010
	1/8	.010	5/32	2-1/2	3/4	.118	5	86750	HEV-RN-M-50125-R.010
	1/8	.010	5/32	2-1/2	1	.118	5	86751	HEV-RN-L-50125-R.010
3/16	3/16	.010	7/32	2-1/2	1/2	.178	5	86752	HEV-RN-R-50187-R.010
	3/16	.010	7/32	2-1/2	3/4	.178	5	86753	HEV-RN-M-50187-R.010
	3/16	.010	7/32	2-1/2	1-1/8	.178	5	86754	HEV-RN-L-50187-R.010
	3/16	.010	7/32	2-1/2	1-5/16	.178	5	86755	HEV-RN-LX-50187-R.010
	3/16	.030	7/32	2	1/2	.178	5	86756	HEV-RN-R-50187-R.030
	3/16	.030	7/32	2-1/2	3/4	.178	5	86757	HEV-RN-M-50187-R.030
	3/16	.030	7/32	2-1/2	1-1/8	.178	5	86758	HEV-RN-L-50187-R.030
	3/16	.030	7/32	2-1/2	1-5/16	.178	5	86759	HEV-RN-LX-50187-R.030
1/4	1/4	.020	3/8	4	3/4	.237	5	86760	HEV-RN-S-50250-R.020
	1/4	.020	3/8	4	1-1/8	.237	5	86761	HEV-RN-R-50250-R.020
	1/4	.020	3/8	4	1-5/8	.237	5	86762	HEV-RN-A-50250-R.020
	1/4	.020	3/8	4	2-1/8	.237	5	86763	HEV-RN-M-50250-R.020
	1/4	.030	3/8	4	3/4	.237	5	86764	HEV-RN-S-50250-R.030
	1/4	.030	3/8	4	1-1/8	.237	5	86765	HEV-RN-R-50250-R.030
	1/4	.030	3/8	4	1-5/8	.237	5	86766	HEV-RN-A-50250-R.030
	1/4	.030	3/8	4	2-1/8	.237	5	86767	HEV-RN-M-50250-R.030
3/8	3/8	.020	1/2	4	1-1/8	.356	5	86768	HEV-RN-S-50375-R.020
	3/8	.020	1/2	4	1-5/8	.356	5	86769	HEV-RN-R-50375-R.020
	3/8	.020	1/2	4	2-1/8	.356	5	86770	HEV-RN-M-50375-R.020
	3/8	.030	1/2	4	1-1/8	.356	5	86771	HEV-RN-S-50375-R.030
	3/8	.030	1/2	4	1-5/8	.356	5	86772	HEV-RN-R-50375-R.030
	3/8	.030	1/2	4	2-1/8	.356	5	86773	HEV-RN-M-50375-R.030

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 161

5 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck (cont.)

continued from previous page



HEV-RN-5

Cutter Dia.* D ₁ $\begin{smallmatrix} +.001" \\ -.001" \end{smallmatrix}$	Shank Dia. D ₂ $\pm .001$	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut L ₂ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	OAL L ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Reach (LBS) L ₃	Neck Diameter	Flutes	Tplus Coated	Tool Description
1/2	1/2	.030	5/8	4	1-1/2	.475	5	86774	HEV-RN-S-50500-R.030
	1/2	.030	5/8	4	1-3/4	.475	5	86775	HEV-RN-SR-50500-R.030
	1/2	.030	5/8	4	2-1/4	.475	5	86776	HEV-RN-R-50500-R.030
	1/2	.030	5/8	5	2-3/4	.475	5	86777	HEV-RN-A-50500-R.030
	1/2	.030	5/8	6	3-3/8	.475	5	86778	HEV-RN-M-50500-R.030
	1/2	.060	5/8	4	1-1/2	.475	5	86779	HEV-RN-S-50500-R.060
	1/2	.060	5/8	4	1-3/4	.475	5	86780	HEV-RN-SR-50500-R.060
	1/2	.060	5/8	4	2-1/4	.475	5	86781	HEV-RN-R-50500-R.060
	1/2	.060	5/8	5	2-3/4	.475	5	86782	HEV-RN-A-50500-R.060
	1/2	.060	5/8	6	3-3/8	.475	5	86783	HEV-RN-M-50500-R.060
5/8	5/8	.030	3/4	4	1-5/8	.590	5	86784	HEV-RN-S-50625-R.030
	5/8	.030	3/4	5	2-3/8	.590	5	86785	HEV-RN-R-50625-R.030
	5/8	.030	3/4	6	3-3/8	.590	5	86786	HEV-RN-M-50625-R.030
	5/8	.030	3/4	6	4-1/8	.590	5	86787	HEV-RN-L-50625-R.030
3/4	3/4	.030	1	4	2	.712	5	86788	HEV-RN-S-50750-R.030
	3/4	.030	1	5	2-1/2	.712	5	86789	HEV-RN-R-50750-R.030
	3/4	.030	1	6	2-7/8	.712	5	86790	HEV-RN-A-50750-R.030
	3/4	.030	1	6	3-3/8	.712	5	86791	HEV-RN-M-50750-R.030
	3/4	.030	1	6	4-1/8	.712	5	86792	HEV-RN-L-50750-R.030
	3/4	.120	1	4	2	.712	5	86793	HEV-RN-S-50750-R.120
	3/4	.120	1	5	2-1/2	.712	5	86794	HEV-RN-R-50750-R.120
	3/4	.120	1	6	2-7/8	.712	5	86795	HEV-RN-A-50750-R.120
	3/4	.120	1	6	3-3/8	.712	5	86796	HEV-RN-M-50750-R.120
	3/4	.120	1	6	4-1/8	.712	5	86797	HEV-RN-L-50750-R.120

* .0005 max TIR

HEV-6



6 FLUTE - SQUARE

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 152 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	6	87538	HEV-S-60125
	1/8	3/8	2	6	87539	HEV-SR-60125
	1/8	1/2	2-1/2	6	87540	HEV-R-60125
	1/8	5/8	2-1/2	6	87541	HEV-A-60125
3/16	3/16	5/16	2	6	87542	HEV-S-60187
	3/16	7/16	2	6	87543	HEV-SR-60187
	3/16	9/16	2-1/2	6	87544	HEV-R-60187
	3/16	3/4	2-1/2	6	87545	HEV-M-60187
1/4	1/4	3/8	2	6	89902	HEV-S-60250
	1/4	1/2	2-1/2	6	89903	HEV-SR-60250
	1/4	3/4	2-1/2	6	89904	HEV-R-60250
	1/4	1	3	6	81894	HEV-M-60250
	1/4	1-1/4	3	6	83303	HEV-L-60250
	1/4	1-1/2	3	6	83304	HEV-LX-60250
5/16	5/16	7/16	2	6	83305	HEV-S-60312
	5/16	3/4	2-1/2	6	83306	HEV-R-60312
	5/16	1	3	6	83307	HEV-M-60312
	5/16	1-1/4	3	6	84991	HEV-MC-60312
3/8	3/8	1/2	2	6	89905	HEV-S-60375
	3/8	3/4	2-1/2	6	83308	HEV-SR-60375
	3/8	1	3	6	89906	HEV-R-60375
	3/8	1-1/4	3	6	89907	HEV-M-60375
	3/8	1-1/2	3-1/2	6	81895	HEV-L-60375
	3/8	2	4	6	83309	HEV-LX-60375
1/2	1/2	5/8	2-1/2	6	89908	HEV-S-60500
	1/2	1	3	6	89909	HEV-SR-60500
	1/2	1-1/4	3	6	89910	HEV-R-60500
	1/2	1-5/8	4	6	89911	HEV-M-60500
	1/2	2	4	6	81896	HEV-L-60500
	1/2	2-1/2	5	6	83310	HEV-LX-60500

continued on next page



Speeds & Feeds on Page 167

6 FLUTE - SQUARE

Variable Pitch (cont.)

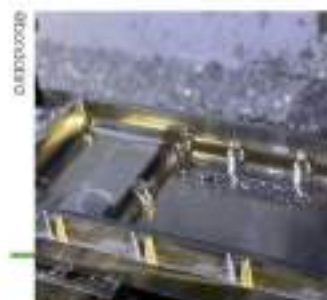
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HEV-6

Cutter Diameter* D1 $\frac{+0.005}{-0.002}$	Shank Diameter D2 #6	Length of Cut L2 $\frac{+0.02}{-0.005}$	Overall Length L1 $\frac{+0.02}{-0.002}$	Flutes	T plus Coated	Tool Description
5/8	5/8	3/4	3	6	83311	HEV-S-00025
	5/8	1-1/4	3-1/2	6	83312	HEV-SR-00025
	5/8	1-5/8	3-1/2	6	83313	HEV-R-00025
	5/8	2	4	6	83314	HEV-M-00025
	5/8	2-1/2	5	6	83315	HEV-L-00025
3/4	3/4	1	3	6	83316	HEV-S-00750
	3/4	1-5/8	4	6	81887	HEV-R-00750
	3/4	2-1/4	5	6	81888	HEV-M-00750
	3/4	2-3/4	5	6	81889	HEV-L-00750
	3/4	3-1/4	6	6	83317	HEV-LX-00750
1	1	2	4-1/2	6	84992	HEV-R-61000
	1	2-5/8	5	6	84993	HEV-M-61000
	1	3-1/4	6	6	84994	HEV-L-61000

* .0005 max TIR



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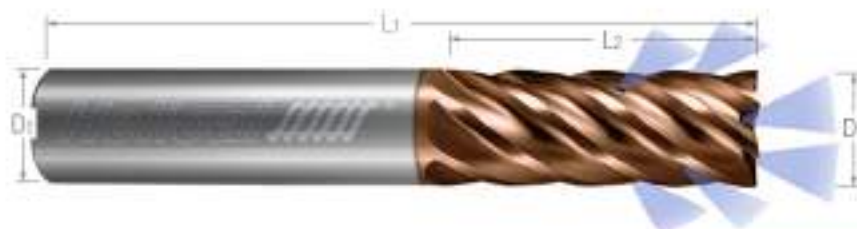
HEVC-6



6 FLUTE - SQUARE

Coolant Through - Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* $D1 \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Shank Diameter $D2 \pm .000$	Length of Cut $L2 \begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Overall Length $L1 \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description
1/4	1/4	3/8	2	6	84305	HEVC-010-60250
	1/4	1/2	2-1/2	6	84306	HEVC-020-60250
3/8	3/8	1/2	2	6	84307	HEVC-010-60375
	3/8	1	3	6	84308	HEVC-020-60375
1/2	1/2	1	3	6	84309	HEVC-020-60500
	1/2	1-1/4	3	6	84310	HEVC-020-60500
	1/2	1-5/8	4	6	84311	HEVC-032-60500
3/4	3/4	1-5/8	4	6	84312	HEVC-021-60750
	3/4	2-1/4	5	6	84313	HEVC-030-60750

* .0005 max TIR



6 FLUTE - BALL

New Items!



HEV-6

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 155 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 (R)	Length of Cut L2 $\begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description	
1/8	1/8	1/4	1-1/2	6	88360	HEV-S-60125-BN	new
	1/8	3/8	2	6	88361	HEV-SR-60125-BN	new
	1/8	1/2	2-1/2	6	88362	HEV-R-60125-BN	new
	1/8	5/8	2-1/2	6	88363	HEV-A-60125-BN	new
	1/8	3/4	2-1/2	6	88364	HEV-M-60125-BN	new
3/16	3/16	5/16	2	6	88365	HEV-S-60187-BN	new
	3/16	7/16	2	6	88366	HEV-SR-60187-BN	new
	3/16	9/16	2-1/2	6	88367	HEV-R-60187-BN	new
	3/16	3/4	2-1/2	6	88368	HEV-M-60187-BN	new
	3/16	1	3	6	88369	HEV-ML-60187-BN	new
1/4	1/4	3/8	2	6	81924	HEV-S-60250-BN	
	1/4	1/2	2-1/2	6	81925	HEV-SR-60250-BN	
	1/4	3/4	2-1/2	6	81926	HEV-R-60250-BN	
	1/4	1	3	6	81927	HEV-M-60250-BN	
	1/4	1-1/4	3	6	82595	HEV-L-60250-BN	
	1/4	1-1/2	3	6	86024	HEV-LX-60250-BN	
5/16	5/16	7/16	2	6	83364	HEV-S-60312-BN	
	5/16	3/4	2-1/2	6	83365	HEV-R-60312-BN	
	5/16	1	3	6	83366	HEV-M-60312-BN	
	5/16	1-1/4	3	6	86025	HEV-ML-60312-BN	
3/8	3/8	1/2	2	6	81928	HEV-S-60375-BN	
	3/8	3/4	2-1/2	6	82067	HEV-SR-60375-BN	
	3/8	1	3	6	81929	HEV-R-60375-BN	
	3/8	1-1/4	3	6	81930	HEV-M-60375-BN	
	3/8	1-1/2	3-1/2	6	82596	HEV-L-60375-BN	
	3/8	2	4	6	86026	HEV-LX-60375-BN	
	3/8	2-1/2	5	6	88370	HEV-X-60375-BN	new

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 167

HEV-6



New Items!

6 FLUTE - BALL

Variable Pitch (cont.)

continued from previous page

Outer Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 (H9)	Length of Cut L2 $\begin{smallmatrix} +.032 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.032 \\ -.032 \end{smallmatrix}$	Flutes	T-plus Coated	Tool Description
1/2	1/2	5/8	2-1/2	6	81931	HEV-S-60500-BN
	1/2	1	3	6	81932	HEV-SR-60500-BN
	1/2	1-1/4	3	6	81933	HEV-R-60500-BN
	1/2	1-5/8	4	6	81934	HEV-M-60500-BN
	1/2	2	4	6	81935	HEV-L-60500-BN
	1/2	2-1/2	5	6	83368	HEV-LX-60500-BN
	1/2	3-1/8	6	6	86027	HEV-X-60500-BN
5/8	5/8	3/4	3	6	83369	HEV-S-60625-BN
	5/8	1-1/4	3-1/2	6	83370	HEV-SR-60625-BN
	5/8	1-5/8	3-1/2	6	83371	HEV-R-60625-BN
	5/8	2	4	6	87546	HEV-M-60625-BN
3/4	3/4	1	3	6	81936	HEV-S-60750-BN
	3/4	1-5/8	4	6	81937	HEV-R-60750-BN
	3/4	2-1/4	5	6	83372	HEV-M-60750-BN
	3/4	2-3/4	5	6	87547	HEV-L-60750-BN
	3/4	3-1/4	6	6	87548	HEV-LX-60750-BN
	3/4	3-1/2	6	6	87549	HEV-X-60750-BN
1	1	1-1/4	4	6	86028	HEV-S-61000-BN
	1	2	4-1/2	6	81938	HEV-R-61000-BN
	1	2-5/8	5	6	86029	HEV-M-61000-BN
	1	3-1/4	6	6	87549	HEV-L-61000-BN

* .0005 max TIR

6 Flute

8 Ways You're Killing Your End Mill

In The Loupe

Are you making these end mill killing mistakes? You could be getting much more use from your tooling! Learn these 8 common ways machinists break their end mills prematurely in our "In the Loupe" blog post *8 Ways You're Killing Your End Mill*.


www.harveyprecision.com/in-the-loupe/8-ways-youre-killing-your-end-mill/

SCAN TO READ

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 157 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 (H6)	Corner Radius R $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.0027 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0627 \\ -.0627 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description	
1/8	1/8	.010	1/4	1-1/2	6	80386	HEV-S-60125-R.010	new
	1/8	.010	3/8	2	6	80387	HEV-SR-60125-R.010	new
	1/8	.010	1/2	2-1/2	6	80388	HEV-A-60125-R.010	new
	1/8	.010	5/8	2-1/2	6	80389	HEV-M-60125-R.010	new
	1/8	.030	1/4	1-1/2	6	80390	HEV-S-60125-R.030	new
	1/8	.030	3/8	2	6	80391	HEV-SR-60125-R.030	new
	1/8	.030	1/2	2-1/2	6	80392	HEV-A-60125-R.030	new
	1/8	.030	5/8	2-1/2	6	80393	HEV-M-60125-R.030	new
3/16	3/16	.010	5/16	2	6	80394	HEV-S-60187-R.010	new
	3/16	.010	7/16	2	6	80395	HEV-SR-60187-R.010	new
	3/16	.010	9/16	2-1/2	6	80396	HEV-A-60187-R.010	new
	3/16	.010	3/4	2-1/2	6	80397	HEV-M-60187-R.010	new
	3/16	.030	5/16	2	6	80398	HEV-S-60187-R.030	new
	3/16	.030	7/16	2	6	80399	HEV-SR-60187-R.030	new
	3/16	.030	9/16	2-1/2	6	80400	HEV-A-60187-R.030	new
	3/16	.030	3/4	2-1/2	6	80401	HEV-M-60187-R.030	new
1/4	1/4	.010	3/8	2	6	86007	HEV-S-60250-R.010	
	1/4	.010	1/2	2-1/2	6	86008	HEV-SR-60250-R.010	
	1/4	.010	3/4	2-1/2	6	86009	HEV-A-60250-R.010	
	1/4	.010	1	3	6	87580	HEV-M-60250-R.010	
	1/4	.010	1-1/4	3	6	87581	HEV-L-60250-R.010	
	1/4	.020	3/8	2	6	59912	HEV-S-60250-R.020	
	1/4	.020	1/2	2-1/2	6	59913	HEV-SR-60250-R.020	
	1/4	.020	3/4	2-1/2	6	59914	HEV-A-60250-R.020	
	1/4	.020	1	3	6	81900	HEV-M-60250-R.020	
	1/4	.020	1-1/4	3	6	83324	HEV-L-60250-R.020	
	1/4	.030	3/8	2	6	59915	HEV-S-60250-R.030	
	1/4	.030	1/2	2-1/2	6	59916	HEV-SR-60250-R.030	
	1/4	.030	3/4	2-1/2	6	59917	HEV-A-60250-R.030	
	1/4	.030	1	3	6	81901	HEV-M-60250-R.030	
	1/4	.030	1-1/4	3	6	83325	HEV-L-60250-R.030	

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 167

HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 (in)	Corner Radius R $\pm .001$ -.001	Length of Cut L2 $\pm .001$ -.001	Overall Length L1 $\pm .001$ -.002	Flutes	Tiplus Coated	Tool Description
1/4	5/4	.060	3/8	2	6	81902	HEV-S-60250-R.060
	5/4	.060	1/2	2-1/2	6	81903	HEV-SR-60250-R.060
	5/4	.060	3/4	2-1/2	6	81904	HEV-R-60250-R.060
	5/4	.060	1	3	6	81905	HEV-M-60250-R.060
	5/4	.060	1-1/4	3	6	83326	HEV-L-60250-R.060
5/16	5/16	.020	7/16	2	6	82587	HEV-S-60312-R.020
	5/16	.020	3/4	2-1/2	6	83327	HEV-R-60312-R.020
	5/16	.020	1	3	6	86010	HEV-M-60312-R.020
	5/16	.030	7/16	2	6	82588	HEV-S-60312-R.030
	5/16	.030	3/4	2-1/2	6	83328	HEV-R-60312-R.030
	5/16	.030	1	3	6	87582	HEV-M-60312-R.030
	5/16	.060	7/16	2	6	83329	HEV-S-60312-R.060
	5/16	.060	3/4	2-1/2	6	83330	HEV-R-60312-R.060
	5/16	.060	1	3	6	87583	HEV-M-60312-R.060
3/8	3/8	.010	1/2	2	6	86011	HEV-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	86012	HEV-SR-60375-R.010
	3/8	.010	1	3	6	86013	HEV-R-60375-R.010
	3/8	.010	1-1/4	3	6	86014	HEV-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	87584	HEV-L-60375-R.010
	3/8	.020	1/2	2	6	59918	HEV-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	86015	HEV-SR-60375-R.020
	3/8	.020	1	3	6	59919	HEV-R-60375-R.020
	3/8	.020	1-1/4	3	6	59920	HEV-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	83331	HEV-L-60375-R.020
	3/8	.030	1/2	2	6	59921	HEV-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	86016	HEV-SR-60375-R.030
	3/8	.030	1	3	6	59922	HEV-R-60375-R.030
	3/8	.030	1-1/4	3	6	59923	HEV-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	83332	HEV-L-60375-R.030
	3/8	.060	1/2	2	6	59924	HEV-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	86017	HEV-SR-60375-R.060
	3/8	.060	1	3	6	59925	HEV-R-60375-R.060
	3/8	.060	1-1/4	3	6	59926	HEV-M-60375-R.060
	3/8	.060	1-1/2	3-1/2	6	83333	HEV-L-60375-R.060
	3/8	.090	1/2	2	6	81906	HEV-S-60375-R.090
	3/8	.090	3/4	2-1/2	6	86019	HEV-SR-60375-R.090
	3/8	.090	1	3	6	81907	HEV-R-60375-R.090
	3/8	.090	1-1/4	3	6	83334	HEV-M-60375-R.090
	3/8	.090	1-1/2	3-1/2	6	83335	HEV-L-60375-R.090
	3/8	.125	1/2	2	6	88402	HEV-S-60375-R.125
	3/8	.125	3/4	2-1/2	6	88403	HEV-SR-60375-R.125
	3/8	.125	1	3	6	88404	HEV-R-60375-R.125
	3/8	.125	1-1/4	3	6	88405	HEV-M-60375-R.125

* .0005 max TIP

continued on next page

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (in)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description	
1/2	1/2	.010	5/8	2-1/2	6	83406	HEV-S-60500-R.010	new
	1/2	.010	1	2	6	83236	HEV-SR-60500-R.010	
	1/2	.010	1-1/4	2	6	83237	HEV-R-60500-R.010	
	1/2	.010	1-5/8	4	6	86020	HEV-M-60500-R.010	
	1/2	.010	2	4	6	87585	HEV-L-60500-R.010	
	1/2	.010	2-1/2	5	6	87586	HEV-LX-60500-R.010	
	1/2	.015	5/8	2-1/2	6	83407	HEV-S-60500-R.015	new
	1/2	.015	1	2	6	83238	HEV-SR-60500-R.015	
	1/2	.015	1-1/4	2	6	83339	HEV-R-60500-R.015	
	1/2	.015	1-5/8	4	6	86021	HEV-M-60500-R.015	
	1/2	.015	2	4	6	87587	HEV-L-60500-R.015	
	1/2	.015	2-1/2	5	6	87588	HEV-LX-60500-R.015	
	1/2	.020	5/8	2-1/2	6	83408	HEV-S-60500-R.020	new
	1/2	.020	1	2	6	83340	HEV-SR-60500-R.020	
	1/2	.020	1-1/4	2	6	83341	HEV-R-60500-R.020	
	1/2	.020	1-5/8	4	6	86022	HEV-M-60500-R.020	
	1/2	.020	2	4	6	87589	HEV-L-60500-R.020	
	1/2	.020	2-1/2	5	6	87590	HEV-LX-60500-R.020	
	1/2	.030	5/8	2-1/2	6	59927	HEV-S-60500-R.030	
	1/2	.030	1	2	6	59928	HEV-SR-60500-R.030	
	1/2	.030	1-1/4	2	6	59929	HEV-R-60500-R.030	
	1/2	.030	1-5/8	4	6	59930	HEV-M-60500-R.030	
	1/2	.030	2	4	6	81908	HEV-L-60500-R.030	
	1/2	.030	2-1/2	5	6	86023	HEV-LX-60500-R.030	
	1/2	.060	5/8	2-1/2	6	59931	HEV-S-60500-R.060	
	1/2	.060	1	2	6	59932	HEV-SR-60500-R.060	
	1/2	.060	1-1/4	2	6	59933	HEV-R-60500-R.060	
	1/2	.060	1-5/8	4	6	59934	HEV-M-60500-R.060	
	1/2	.060	2	4	6	81909	HEV-L-60500-R.060	
	1/2	.060	2-1/2	5	6	87591	HEV-LX-60500-R.060	
	1/2	.090	5/8	2-1/2	6	83342	HEV-S-60500-R.090	
	1/2	.090	1	2	6	83343	HEV-SR-60500-R.090	
	1/2	.090	1-1/4	2	6	82599	HEV-R-60500-R.090	
	1/2	.090	1-5/8	4	6	82599	HEV-M-60500-R.090	
	1/2	.090	2	4	6	82591	HEV-L-60500-R.090	
	1/2	.125	5/8	2-1/2	6	59925	HEV-S-60500-R.125	
	1/2	.125	1	2	6	59926	HEV-SR-60500-R.125	
	1/2	.125	1-1/4	2	6	59937	HEV-R-60500-R.125	
	1/2	.125	1-5/8	4	6	59938	HEV-M-60500-R.125	
	1/2	.125	2	4	6	81910	HEV-L-60500-R.125	
	1/2	.125	2-1/2	5	6	87592	HEV-LX-60500-R.125	
5/8	5/8	.030	1-1/4	3-1/2	6	83344	HEV-SR-60625-R.030	
	5/8	.030	1-5/8	3-1/2	6	83345	HEV-R-60625-R.030	
	5/8	.060	1-1/4	3-1/2	6	83346	HEV-SR-60625-R.060	
	5/8	.060	1-5/8	3-1/2	6	83347	HEV-R-60625-R.060	
	5/8	.090	1-1/4	3-1/2	6	83348	HEV-SR-60625-R.090	
	5/8	.090	1-5/8	3-1/2	6	83349	HEV-R-60625-R.090	
	5/8	.125	1-1/4	3-1/2	6	83350	HEV-SR-60625-R.125	
	5/8	.125	1-5/8	3-1/2	6	83351	HEV-R-60625-R.125	

* .0005 max TIR

continued on next page

HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 (in)	Corner Radius R $\pm .001$ -.002	Length of Cut L2 $\pm .001$ -.002	Overall Length L1 $\pm .001$ -.002	Flutes	Plus Coated	Tool Description
3/4	3/4	.030	1	3	6	83352	HEV-S-60750-R.030
	3/4	.030	1-5/8	4	6	81911	HEV-R-60750-R.030
	3/4	.030	2-1/4	5	6	81912	HEV-M-60750-R.030
	3/4	.030	2-3/4	5	6	81913	HEV-L-60750-R.030
	3/4	.030	3-1/4	6	6	83353	HEV-LX-60750-R.030
	3/4	.060	1-5/8	4	6	81914	HEV-R-60750-R.060
	3/4	.060	2-1/4	5	6	81915	HEV-M-60750-R.060
	3/4	.060	2-3/4	5	6	81916	HEV-L-60750-R.060
	3/4	.060	2-1/4	6	6	86409	HEV-LX-60750-R.060
	3/4	.090	1	3	6	81989	HEV-S-60750-R.090
	3/4	.090	1-5/8	4	6	81917	HEV-R-60750-R.090
	3/4	.090	2-1/4	5	6	81918	HEV-M-60750-R.090
	3/4	.090	2-3/4	5	6	81919	HEV-L-60750-R.090
	3/4	.120	1	3	6	87593	HEV-S-60750-R.120
	3/4	.120	1-5/8	4	6	87594	HEV-R-60750-R.120
	3/4	.120	2-1/4	5	6	87595	HEV-M-60750-R.120
	3/4	.125	1	3	6	83354	HEV-S-60750-R.125
	3/4	.125	1-5/8	4	6	83355	HEV-R-60750-R.125
	3/4	.125	2-1/4	5	6	83356	HEV-M-60750-R.125
	3/4	.125	2-3/4	5	6	86410	HEV-LX-60750-R.125
	3/4	.190	1	3	6	81990	HEV-S-60750-R.190
	3/4	.250	1	3	6	83357	HEV-S-60750-R.250
	3/4	.250	1-5/8	4	6	83358	HEV-R-60750-R.250
	3/4	.250	2-1/4	5	6	83359	HEV-M-60750-R.250
	3/4	.250	2-3/4	5	6	83360	HEV-L-60750-R.250
	3/4	.260	3-1/4	6	6	86411	HEV-LX-60750-R.250
1	1	.030	2	4-1/2	6	81920	HEV-R-61000-R.030
	1	.030	2-5/8	5	6	81921	HEV-M-61000-R.030
	1	.060	2	4-1/2	6	81922	HEV-R-61000-R.060
	1	.060	2-5/8	5	6	81923	HEV-M-61000-R.060

* .0005 max TIR

6 FLUTE - CORNER RADIUS

Coolant Through - Variable Pitch


HEVC-6

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.0017 \\ -.0027 \end{smallmatrix}$	Shank Diameter D2 (in)	Corner Radius R $\begin{smallmatrix} +.007 \\ -.007 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0027 \\ -.0027 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description
1/4	1/4	.020	3/8	2	6	84314	HEVC-015-60250-R.020
	1/4	.020	1/2	2-1/2	6	84315	HEVC-020-60250-R.020
3/8	3/8	.020	1/2	2	6	84316	HEVC-013-60375-R.020
	3/8	.020	1	3	6	84317	HEVC-026-60375-R.020
	3/8	.030	1/2	2	6	84318	HEVC-013-60375-R.030
	3/8	.030	1	3	6	84319	HEVC-026-60375-R.030
	3/8	.060	1-5/8	4	6	84322	HEVC-032-60600-R.060
1/2	1/2	.030	1	3	6	84320	HEVC-020-60600-R.030
	1/2	.030	1-1/4	3	6	84321	HEVC-025-60600-R.030
	1/2	.030	1-5/8	4	6	84322	HEVC-032-60600-R.030
	1/2	.060	1	3	6	84323	HEVC-020-60600-R.060
	1/2	.060	1-1/4	3	6	84324	HEVC-025-60600-R.060
	1/2	.060	1-5/8	4	6	84325	HEVC-032-60600-R.060
3/4	3/4	.060	1-5/8	4	6	84326	HEVC-021-60750-R.060
	3/4	.060	2-1/4	5	6	84327	HEVC-030-60750-R.060

* .0005 max TIR



Speeds & Feeds on Page 167

HEV-RN-6



New Items!

6 FLUTE - SQUARE

Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates

- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 163 for Aplus coating



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (H6)	Length of Cut L2 $\pm \frac{.002}{.003}$	Overall Length L1 $\pm \frac{.002}{.003}$	Reach (LBS) L3	Neck Diameter	Flutes	Tplus Coated	Tool Description
1/8	1/8	0/32	2	3/8	.118	6	88933	HEV-RN-S-00125
	1/8	0/32	2	5/8	.118	6	88934	HEV-RN-R-00125
	1/8	5/32	2-1/2	1	.118	6	88935	HEV-RN-M-00125
3/16	3/16	7/32	2	1/2	.178	6	88936	HEV-RN-S-00187
	3/16	7/32	2-1/2	1	.178	6	88937	HEV-RN-R-00187
	3/16	7/32	3	1-1/2	.178	6	88938	HEV-RN-M-00187
1/4	1/4	3/8	4	3/4	.237	6	88962	HEV-RN-S-00250
	1/4	3/8	4	1-1/8	.237	6	88963	HEV-RN-R-00250
	1/4	3/8	4-1/2	2-1/8	.237	6	88964	HEV-RN-M-00250
3/8	3/8	1/2	4	1-1/8	.306	6	88965	HEV-RN-S-00375
	3/8	1/2	4	2-1/8	.306	6	88966	HEV-RN-R-00375
	3/8	1/2	6	3-1/8	.306	6	88967	HEV-RN-M-00375
1/2	1/2	5/8	4	1-1/2	.473	6	88968	HEV-RN-S-00500
	1/2	5/8	4	2-1/4	.473	6	88969	HEV-RN-R-00500
	1/2	5/8	6	3-3/8	.473	6	88970	HEV-RN-M-00500
	1/2	5/8	6 1/2	4-1/8	.473	6	88971	HEV-RN-L-00500
5/8	5/8	3/4	4	1-5/8	.593	6	88939	HEV-RN-S-00625
	5/8	3/4	6	2-3/8	.593	6	88940	HEV-RN-R-00625
	5/8	3/4	6	3-3/8	.593	6	88941	HEV-RN-M-00625
3/4	3/4	1	4	2	.712	6	88972	HEV-RN-S-00750
	3/4	1	6	2-1/2	.712	6	88973	HEV-RN-R-00750
	3/4	1	6	3-3/8	.712	6	88974	HEV-RN-M-00750

* .0005 max TIR



Speeds & Feeds on Page 167

6 FLUTE - BALL

New Items!



HEV-RN-6

Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 164 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.000" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 (H6)	Length of Cut L1 $\begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Overall Length L2 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Reach (LBS) L3	Neck Diameter	Flutes	T _{plus} Coated	Tool Description	
1/8	1/8	5/32	2	3/8	.118	6	08642	HEV-RN-S-80125-BN	new
	1/8	5/32	2	5/8	.118	6	08643	HEV-RN-R-80125-BN	new
	1/8	5/32	2-1/2	1	.118	6	08644	HEV-RN-M-80125-BN	new
3/16	3/16	7/32	2	1/2	.178	6	08645	HEV-RN-S-80187-BN	new
	3/16	7/32	2-1/2	1	.178	6	08646	HEV-RN-R-80187-BN	new
	3/16	7/32	3	1-1/2	.178	6	08647	HEV-RN-M-80187-BN	new
1/4	1/4	3/8	4	3/4	.237	6	08625	HEV-RN-S-80250-BN	
	1/4	3/8	4	1-1/8	.237	6	08626	HEV-RN-R-80250-BN	
	1/4	3/8	4	1-5/8	.237	6	08648	HEV-RN-A-80250-BN	new
	1/4	3/8	4	2-1/8	.237	6	08627	HEV-RN-M-80250-BN	
3/8	3/8	1/2	4	1-1/8	.358	6	08628	HEV-RN-S-80375-BN	
	3/8	1/2	4	1-5/8	.358	6	08649	HEV-RN-SR-80375-BN	new
	3/8	1/2	4	2-1/8	.358	6	08629	HEV-RN-R-80375-BN	
	3/8	1/2	6	3-1/8	.358	6	08630	HEV-RN-M-80375-BN	
1/2	1/2	5/8	4	1-1/2	.475	6	08631	HEV-RN-S-80500-BN	
	1/2	5/8	4	2-1/4	.475	6	08632	HEV-RN-R-80500-BN	
	1/2	5/8	6	3-3/8	.475	6	08633	HEV-RN-M-80500-BN	
	1/2	5/8	6	4-1/8	.475	6	08634	HEV-RN-L-80500-BN	
5/8	5/8	3/4	4	1-5/8	.591	6	08650	HEV-RN-S-80625-BN	new
	5/8	3/4	6	3-3/8	.591	6	08651	HEV-RN-R-80625-BN	new
	5/8	3/4	6	3-3/8	.591	6	08652	HEV-RN-M-80625-BN	new
3/4	3/4	1	4	2	.712	6	08635	HEV-RN-S-80750-BN	
	3/4	1	6	2-1/2	.712	6	08636	HEV-RN-R-80750-BN	
	3/4	1	6	3-3/8	.712	6	08637	HEV-RN-M-80750-BN	

* .0005 max TIR



Speeds & Feeds on Page 167

HEV-RN-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch - Reduced Neck

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates

- Reduced neck provides maximum strength in long reach and deep pocketing applications
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 165 for Aplus coating



Cutter Dia.* D1 $\pm .001$ -.002	Shank Dia. D2 (IN)	Corner Radius R $\pm .002$ -.002	Length of Cut L1 $\pm .001$ -.001	OAL L2 $\pm .002$ -.002	Reach (LBS) L3	Neck Diameter L4	Flutes	Tplus Coated	Tool Description
1/8	1/8	.010	5/32	2	3/8	.118	6	8863	HEV-RN-S-60125-R.010
	1/8	.010	5/32	2	5/8	.118	6	8864	HEV-RN-R-60125-R.010
	1/8	.010	5/32	2-1/2	1	.118	6	8865	HEV-RN-M-60125-R.010
3/16	3/16	.010	7/32	2	1/2	.178	6	8866	HEV-RN-S-60187-R.010
	3/16	.010	7/32	2-1/2	1	.178	6	8867	HEV-RN-R-60187-R.010
	3/16	.010	7/32	3	1-1/2	.178	6	8868	HEV-RN-L-60187-R.010
1/4	1/4	.020	3/8	4	3/4	.237	6	8869	HEV-RN-S-60250-R.020
	1/4	.020	3/8	4	1-1/8	.237	6	8869	HEV-RN-R-60250-R.020
	1/4	.020	3/8	4	2-1/8	.237	6	8869	HEV-RN-M-60250-R.020
3/8	3/8	.020	1/2	4	1-1/8	.396	6	8881	HEV-RN-S-60375-R.020
	3/8	.020	1/2	4	2-1/8	.396	6	8882	HEV-RN-R-60375-R.020
	3/8	.020	1/2	6	3-1/8	.396	6	8883	HEV-RN-M-60375-R.020
1/2	1/2	.030	5/8	4	1-1/2	.475	6	8884	HEV-RN-S-60500-R.030
	1/2	.030	5/8	4	2-1/4	.475	6	8885	HEV-RN-R-60500-R.030
	1/2	.030	5/8	6	3-3/8	.475	6	8886	HEV-RN-M-60500-R.030
	1/2	.030	5/8	6	4-1/8	.475	6	8887	HEV-RN-L-60500-R.030
	1/2	.060	5/8	4	1-1/2	.475	6	8888	HEV-RN-S-60500-R.060
	1/2	.060	5/8	4	2-1/4	.475	6	8889	HEV-RN-R-60500-R.060
	1/2	.060	5/8	6	3-3/8	.475	6	8890	HEV-RN-M-60500-R.060
	1/2	.060	5/8	6	4-1/8	.475	6	8891	HEV-RN-L-60500-R.060
	1/2	.125	5/8	4	1-1/2	.475	6	8892	HEV-RN-S-60500-R.125
	1/2	.125	5/8	4	2-1/4	.475	6	8893	HEV-RN-R-60500-R.125
	1/2	.125	5/8	6	3-3/8	.475	6	8894	HEV-RN-M-60500-R.125
	1/2	.125	5/8	6	4-1/8	.475	6	8895	HEV-RN-L-60500-R.125
5/8	5/8	.030	3/4	4	1-5/8	.593	6	8899	HEV-RN-S-60625-R.030
	5/8	.030	3/4	6	2-3/8	.593	6	8899	HEV-RN-R-60625-R.030
	5/8	.030	3/4	6	3-3/8	.593	6	8899	HEV-RN-M-60625-R.030
3/4	3/4	.030	1	4	2	.712	6	8896	HEV-RN-S-60750-R.030
	3/4	.030	1	6	2-1/2	.712	6	8897	HEV-RN-R-60750-R.030
	3/4	.030	1	6	3-3/8	.712	6	8898	HEV-RN-M-60750-R.030
	3/4	.060	1	4	2	.712	6	8899	HEV-RN-S-60750-R.060
	3/4	.060	1	6	2-1/2	.712	6	8899	HEV-RN-R-60750-R.060
	3/4	.060	1	6	3-3/8	.712	6	8899	HEV-RN-M-60750-R.060

*.0005 max TIR



Speeds & Feeds on Page 167

7 FLUTE - SQUARE

New Items!



HEV-7

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 168 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 H6	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description	
1/8	1/8	1/4	1-1/2	7	88667	HEV-S-70125	new
	1/8	3/8	2	7	88668	HEV-SR-70125	new
	1/8	1/2	2-1/2	7	88669	HEV-R-70125	new
	1/8	5/8	2-1/2	7	88670	HEV-A-70125	new
3/16	3/16	5/16	2	7	88671	HEV-S-70187	new
	3/16	7/16	2	7	88672	HEV-SR-70187	new
	3/16	9/16	2-1/2	7	88673	HEV-R-70187	new
	3/16	3/4	2-1/2	7	88674	HEV-M-70187	new
1/4	1/4	3/8	2	7	88699	HEV-S-70250	
	1/4	1/2	2	7	88940	HEV-SR-70250	
	1/4	3/4	2-1/2	7	88941	HEV-R-70250	
	1/4	1	3	7	88375	HEV-M-70250	
	1/4	1-1/4	3	7	88030	HEV-L-70250	
5/16	5/16	7/16	2	7	88031	HEV-S-70312	
	5/16	3/4	2-1/2	7	88032	HEV-R-70312	
	5/16	1	3	7	88033	HEV-M-70312	
	5/16	1-1/4	3	7	88675	HEV-L-70312	new
3/8	3/8	1/2	2	7	58042	HEV-S-70375	
	3/8	3/4	2-1/2	7	58043	HEV-SR-70375	
	3/8	1	2-1/2	7	58044	HEV-R-70375	
	3/8	1-1/4	3	7	88034	HEV-M-70375	
	3/8	1-1/2	3-1/2	7	81809	HEV-L-70375	
	3/8	2	4	7	87102	HEV-LX-70375	
1/2	1/2	5/8	2-1/2	7	58045	HEV-S-70500	
	1/2	1	3	7	58046	HEV-SR-70500	
	1/2	1-1/4	3	7	58047	HEV-R-70500	
	1/2	1-5/8	4	7	58048	HEV-M-70500	
	1/2	2	4	7	81840	HEV-L-70500	
	1/2	2-1/2	5	7	88035	HEV-LX-70500	
	1/2	3-1/8	6	7	88036	HEV-X-70500	

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 178

HEV-7



New Items!

7 FLUTE - SQUARE

Variable Pitch (cont.)

continued from previous page

Cutter Diameter*	Shank Diameter	Length of Cut	Overall Length	Flutes	T-plus Coated	Tool Description
$D_1 \pm .002$	$D_2 \text{ (in)}$	$L_2 \pm .002$	$L_1 \pm .002$			
5/8	5/8	3/8	3	7	61941	HEV-S-70625
	5/8	1-1/4	3-1/2	7	61942	HEV-SR-70625
	5/8	1-5/8	4	7	61943	HEV-R-70625
	5/8	2-1/8	4	7	67103	HEV-M-70625
3/4	3/4	1-1/4	3-1/2	7	67104	HEV-SR-70750
	3/4	1-5/8	4	7	61944	HEV-R-70750
	3/4	2-1/4	5	7	61945	HEV-M-70750
	3/4	2-3/4	5	7	66937	HEV-L-70750
	3/4	3-1/4	6	7	67105	HEV-LX-70750
1	1	1-1/4	4	7	66938	HEV-S-71000
	1	2	5	7	61946	HEV-R-71000
	1	2-5/8	5	7	66939	HEV-M-71000
	1	3-1/4	6	7	68576	HEV-L-71000

NEW

*.0005 max TIR



Access customized running parameters for your specific setup and material at
www.machiningadvisorpro.com



7 FLUTE - CORNER RADIUS

New Items!



HEV-7

Variable Pitch

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 171 for Aplus coating



Cutter Diameter* D1 $\begin{smallmatrix} +.001 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 .005	Corner Radius R $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.000 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description	
1/8	1/8	.010	1/4	1-1/2	7	83677	HEV-S-70125-R.010	new
	1/8	.010	3/8	2	7	83678	HEV-SR-70125-R.010	new
	1/8	.010	1/2	2-1/2	7	83679	HEV-R-70125-R.010	new
	1/8	.010	5/8	2-1/2	7	83680	HEV-A-70125-R.010	new
3/16	3/16	.010	5/16	2	7	83681	HEV-S-70187-R.010	new
	3/16	.010	7/16	2	7	83682	HEV-SR-70187-R.010	new
	3/16	.010	9/16	2-1/2	7	83683	HEV-R-70187-R.010	new
	3/16	.010	3/4	2-1/2	7	83684	HEV-M-70187-R.010	new
1/4	1/4	.010	3/8	2	7	87144	HEV-S-70250-R.010	
	1/4	.010	1/2	2	7	87145	HEV-SR-70250-R.010	
	1/4	.010	3/4	2-1/2	7	87146	HEV-R-70250-R.010	
	1/4	.010	1	3	7	87147	HEV-M-70250-R.010	
	1/4	.010	1-1/4	3	7	87148	HEV-L-70250-R.010	
	1/4	.020	3/8	2	7	59949	HEV-S-70250-R.020	
	1/4	.020	1/2	2	7	59950	HEV-SR-70250-R.020	
	1/4	.020	3/4	2-1/2	7	59951	HEV-R-70250-R.020	
	1/4	.020	1	3	7	83389	HEV-M-70250-R.020	
	1/4	.020	1-1/4	3	7	89048	HEV-L-70250-R.020	
	1/4	.030	3/8	2	7	87149	HEV-S-70250-R.030	
	1/4	.030	1/2	2	7	87150	HEV-SR-70250-R.030	
	1/4	.030	3/4	2-1/2	7	87151	HEV-R-70250-R.030	
	1/4	.030	1	3	7	87152	HEV-M-70250-R.030	
	1/4	.030	1-1/4	3	7	87153	HEV-L-70250-R.030	
3/8	3/8	.010	1/2	2	7	87154	HEV-S-70375-R.010	
	3/8	.010	3/4	2-1/2	7	87155	HEV-SR-70375-R.010	
	3/8	.010	1	2-1/2	7	87156	HEV-R-70375-R.010	
	3/8	.010	1-1/4	3	7	83685	HEV-M-70375-R.010	new
	3/8	.010	1-1/2	3-1/2	7	83686	HEV-L-70375-R.010	new
	3/8	.020	1/2	2	7	59952	HEV-S-70375-R.020	
	3/8	.020	3/4	2-1/2	7	59953	HEV-SR-70375-R.020	
	3/8	.020	1	2-1/2	7	59954	HEV-R-70375-R.020	
	3/8	.020	1-1/4	3	7	89049	HEV-M-70375-R.020	
	3/8	.020	1-1/2	3-1/2	7	81947	HEV-L-70375-R.020	
	3/8	.030	2	4	7	89050	HEV-LX-70375-R.030	
	3/8	.030	1/2	2	7	87157	HEV-S-70375-R.030	

* .0005 max TR

continued on next page

HEV-7



New Items!

7 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .001$ -.002	Shank Diameter D2 (in)	Corner Radius R $\pm .017$ -.027	Length of Cut L2 $\pm .037$ -.007	Overall Length L1 $\pm .037$ -.007	Flutes	Typos Coated	Tool Description
3/8	3/8	.030	3/4	2-1/2	7	87158	HEV-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87159	HEV-R-70375-R.030
	3/8	.030	1-1/4	3	7	88687	HEV-M-70375-R.030
	3/8	.030	1-1/2	3-1/2	7	88688	HEV-L-70375-R.030
	3/8	.060	1/2	2	7	83390	HEV-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	83391	HEV-SR-70375-R.060
	3/8	.060	1	2-1/2	7	83392	HEV-R-70375-R.060
	3/8	.060	1-1/4	3	7	88689	HEV-M-70375-R.060
	3/8	.060	1-1/2	3-1/2	7	88690	HEV-L-70375-R.060
	3/8	.125	1/2	2	7	87160	HEV-S-70375-R.125
	3/8	.125	3/4	2-1/2	7	87161	HEV-SR-70375-R.125
	3/8	.125	1	2-1/2	7	87162	HEV-R-70375-R.125
	3/8	.125	1-1/4	3	7	88691	HEV-M-70375-R.125
	3/8	.125	1-1/2	3-1/2	7	88692	HEV-L-70375-R.125
1/2	1/2	.010	5/8	2-1/2	7	88651	HEV-S-70500-R.010
	1/2	.010	1	3	7	88652	HEV-SR-70500-R.010
	1/2	.010	1-1/4	3	7	88653	HEV-R-70500-R.010
	1/2	.010	1-5/8	4	7	88654	HEV-M-70500-R.010
	1/2	.010	2	4	7	87163	HEV-L-70500-R.010
	1/2	.020	5/8	2-1/2	7	83393	HEV-S-70500-R.020
	1/2	.020	1	3	7	83394	HEV-SR-70500-R.020
	1/2	.020	1-1/4	3	7	83395	HEV-R-70500-R.020
	1/2	.020	1-5/8	4	7	83396	HEV-M-70500-R.020
	1/2	.020	2	4	7	88655	HEV-L-70500-R.020
	1/2	.030	5/8	2-1/2	7	88656	HEV-S-70500-R.030
	1/2	.030	1	3	7	88657	HEV-SR-70500-R.030
	1/2	.030	1-1/4	3	7	88658	HEV-R-70500-R.030
	1/2	.030	1-5/8	4	7	88659	HEV-M-70500-R.030
	1/2	.030	2	4	7	81948	HEV-L-70500-R.030
	1/2	.030	2-1/2	5	7	88660	HEV-LX-70500-R.030
	1/2	.060	5/8	2-1/2	7	83397	HEV-S-70500-R.060
	1/2	.060	1	3	7	83398	HEV-SR-70500-R.060
	1/2	.060	1-1/4	3	7	83399	HEV-R-70500-R.060
	1/2	.060	1-5/8	4	7	87169	HEV-M-70500-R.060
	1/2	.060	2	4	7	87170	HEV-L-70500-R.060
	1/2	.125	5/8	2-1/2	7	87164	HEV-S-70500-R.125
	1/2	.125	1	3	7	87165	HEV-SR-70500-R.125
	1/2	.125	1-1/4	3	7	87166	HEV-R-70500-R.125
	1/2	.125	1-5/8	4	7	87167	HEV-M-70500-R.125
	1/2	.125	2	4	7	87168	HEV-L-70500-R.125
5/8	5/8	.030	3/4	3	7	81949	HEV-S-70625-R.030
	5/8	.030	1-1/4	3-1/2	7	81950	HEV-SR-70625-R.030
	5/8	.030	1-5/8	4	7	81951	HEV-R-70625-R.030
	5/8	.030	2-1/8	4	7	88657	HEV-M-70625-R.030
	5/8	.030	2-1/2	5	7	88658	HEV-L-70625-R.030
	5/8	.060	3/4	3	7	88659	HEV-S-70625-R.060
	5/8	.060	1-1/4	3-1/2	7	83400	HEV-SR-70625-R.060
	5/8	.060	1-5/8	4	7	83401	HEV-R-70625-R.060
5/8	5/8	.060	2-1/8	4	7	88655	HEV-M-70625-R.060

* .0005 max TIR

continued on next page

7 FLUTE - CORNER RADIUS

New Items!



HEV-7

Variable Pitch (cont.)

continued from previous page

Cutter Diameter*	Shank Diameter	Corner Radius	Length of Cut	Overall Length	Flutes	Typical Costed	Tool Description
D1 $\pm .001$ -.002	D2 ØR	R $\pm .001$ -.002	L2 $\pm .001$ -.002	L1 $\pm .001$ -.002			
3/4	3/4	.000	1	3	7	81952	HEV-S-70750-R.030
	3/4	.000	1-1/4	3-1/2	7	81953	HEV-SR-70750-R.030
	3/4	.000	1-5/8	4	7	81954	HEV-R-70750-R.030
	3/4	.000	2-1/4	5	7	81955	HEV-M-70750-R.030
	3/4	.000	2-3/4	5	7	87171	HEV-L-70750-R.030
	3/4	.000	3-1/4	6	7	87172	HEV-LX-70750-R.030
	3/4	.060	1	3	7	83402	HEV-S-70750-R.060
	3/4	.060	1-5/8	4	7	83403	HEV-R-70750-R.060
	3/4	.060	2-1/4	5	7	83404	HEV-M-70750-R.060
	3/4	.060	2-3/4	5	7	86058	HEV-L-70750-R.060
	3/4	.060	3-1/4	6	7	87173	HEV-LX-70750-R.060
	3/4	.125	1-5/8	4	7	88636	HEV-R-70750-R.125
	3/4	.125	2-1/4	5	7	88637	HEV-M-70750-R.125
	3/4	.125	2-3/4	5	7	88638	HEV-L-70750-R.125
1	1	.000	1-1/4	4	7	86059	HEV-S-71000-R.030
	1	.000	2	5	7	86060	HEV-R-71000-R.030
	1	.000	2-5/8	5	7	86061	HEV-M-71000-R.030
	1	.000	3-1/4	6	7	88639	HEV-L-71000-R.030
	1	.000	4-1/4	7	7	88700	HEV-X-71000-R.030

* .0005 max TIR

new

new

new

new

new



Machine With Confidence

Customized Running Parameters For
Optimized Machining**MACHINING**
ADVISOR PRO

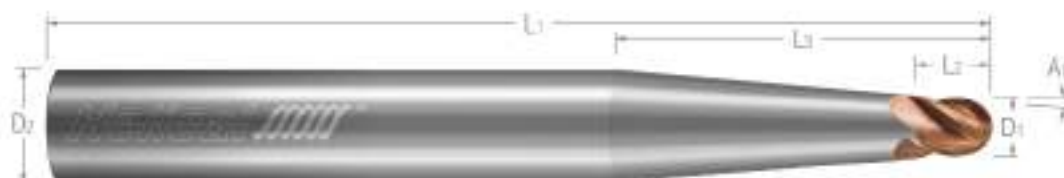
machiningadvisorpro.com



HCF-TN-4

CONTOUR FINISHERS - 4 FLUTE - BALL
Tapered Neck

- Engineered for optimal performance in 3D contouring, profiling and tapered wall applications
- Tapered length of cut and tapered neck for maximum rigidity and clearance in tight spaces
- Reach taper matches LOC taper and is relieved for clearance along entire reach length
- 4 flute variable pitch geometry designed for minimized harmonics and reduced tool pressure
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Angle Per Side A1 $\pm 0.01^\circ$ $\pm 0.01^\circ$	Cutter Dia* D1 ± 0.001 ± 0.001	Shank Dia D2 (H6)	Length of Cut L2 ± 0.02 ± 0.001	Overall Length L1 ± 0.02 ± 0.001	Reach (LBS) L3	Flutes	Tplus Coated	Tool Description
2°	1/8	3/16	3/16	2-1/2	1.0329	4	86442	HCF020-TN-082-40125-BN
	1/8	1/4	3/16	4	1.8278	4	86443	HCF020-TN-154-40125-BN
	3/16	1/4	1/4	2-1/2	1.1007	4	86444	HCF020-TN-038-40167-BN
	3/16	5/16	1/4	4	1.8956	4	86445	HCF020-TN-106-40167-BN
	1/4	5/16	5/16	2-1/2	1.1688	4	86446	HCF020-TN-046-40250-BN
	1/4	3/8	5/16	4	2.0634	4	86447	HCF020-TN-082-40250-BN
	5/16	3/8	3/8	2-1/2	1.2362	4	86448	HCF020-TN-039-40312-BN
	5/16	7/16	3/8	4	2.1311	4	86449	HCF020-TN-068-40312-BN
	3/8	7/16	1/2	2-3/4	1.3060	4	86450	HCF020-TN-034-40375-BN
3°	3/8	1/2	1/2	4	2.2014	4	86451	HCF020-TN-058-40375-BN
	1/8	1/4	3/16	2-1/2	1.3062	4	86452	HCF030-TN-104-40125-BN
	1/8	3/8	3/16	4	2.4088	4	86453	HCF030-TN-198-40125-BN
	3/16	1/4	1/4	2	1.7503	4	86454	HCF030-TN-040-40167-BN
	3/16	3/8	1/4	2-1/2	1.8581	4	86455	HCF030-TN-104-40167-BN
	1/4	3/8	5/16	3	1.4173	4	86456	HCF030-TN-056-40250-BN
	1/4	1/2	5/16	5	2.6090	4	86457	HCF030-TN-104-40250-BN
	5/16	3/8	3/8	2-1/2	1.7766	4	86458	HCF030-TN-028-40312-BN
	5/16	1/2	3/8	4	2.0692	4	86459	HCF030-TN-066-40312-BN
5°	3/8	1/2	1/2	3	1.5310	4	86460	HCF030-TN-040-40375-BN
	3/8	5/8	1/2	5	2.7236	4	86461	HCF030-TN-072-40375-BN
	1/8	1/4	3/16	2	1.8578	4	86462	HCF050-TN-084-40125-BN
	1/8	3/8	3/16	2-1/2	1.9222	4	86463	HCF050-TN-121-40125-BN
	3/16	5/16	1/4	2-1/2	1.8503	4	86464	HCF050-TN-045-40167-BN
	3/16	1/2	1/4	4	1.9249	4	86465	HCF050-TN-102-40167-BN
	1/4	3/8	5/16	2-1/2	1.8668	4	86466	HCF050-TN-035-40250-BN
	1/4	1/2	5/16	2-1/2	1.6132	4	86467	HCF050-TN-064-40250-BN
	5/16	1/2	3/8	3	1.3015	4	86468	HCF050-TN-041-40312-BN
	5/16	5/8	3/8	4	2.0158	4	86469	HCF050-TN-064-40312-BN
	3/8	1/2	1/2	2-1/2	1.9922	4	86470	HCF050-TN-026-40375-BN
	3/8	5/8	1/2	2-1/2	1.7066	4	86471	HCF050-TN-045-40375-BN

*0.0005 max TIR



Speeds & Feeds on Page 242

SPEEDS & FEEDS

HCF-TN-4

Contour Finishers - 4 Flute - Ball - Tapered Neck

HCF-TN-4								
Material Grade		Hardness	SFM	Feeds per Tooth (FPT)				
				1/8	3/16	1/4	5/16	3/8
				F _{max}	F _{max}	F _{max}	F _{max}	F _{max}
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	800	.0014	.0017	.0019	.0020	.0022
		75 - 90 HRB	750	.0013	.0014	.0016	.0016	.0019
		21 - 35 HRC	700	.0010	.0010	.0013	.0014	.0015
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 90 HRB	600	.0012	.0014	.0015	.0016	.0017
		21 - 35 HRC	600	.0010	.0010	.0013	.0014	.0015
		38 - 50 HRC	400	.0010	.0011	.0012	.0013	.0014
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	350	.0008	.0009	.0011	.0012	.0013
		75 - 90 HRB	600	.0012	.0014	.0015	.0016	.0017
		21 - 35 HRC	600	.0011	.0012	.0014	.0014	.0015
SPECIALTY STEEL	300M, Invar 36, Kovar, Meninger 200, Meninger 250, Meninger 300, Meninger 350	38 - 50 HRC	450	.0009	.0011	.0012	.0013	.0014
		> 50 HRC	400	.0008	.0009	.0011	.0012	.0013
		< 75 HRB	450	.0014	.0015	.0017	.0018	.0020
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347, 303, 304, 304L, Inconel 27-TMO, 316, 316L, 321, 347	75 - 90 HRB	500	.0011	.0013	.0014	.0015	.0016
		21 - 35 HRC	450	.0011	.0013	.0014	.0015	.0016
		38 - 50 HRC	400	.0010	.0011	.0013	.0014	.0014
FERRITIC & MARTENSITIC STAINLESS STEEL	403, 405, 409, 410, 416, 430, 440, 430, 440	75 - 90 HRB	750	.0012	.0014	.0015	.0016	.0017
		21 - 35 HRC	650	.0011	.0013	.0014	.0015	.0016
		38 - 50 HRC	400	.0010	.0011	.0013	.0014	.0014
PH STAINLESS STEEL	15-5, 17-4, Carpenter 600, Carpenter 465	21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
		38 - 50 HRC	400	.0010	.0011	.0013	.0013	.0014
		75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
GRAY CAST IRON	SAE 1431, ASTM A48	21 - 35 HRC	550	.0011	.0013	.0014	.0015	.0016
		75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
		21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
		21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
		75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
MODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 65T	21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
		38 - 50 HRC	400	.0008	.0009	.0011	.0012	.0013
		75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	600	.0014	.0015	.0017	.0018	.0021
		75 - 90 HRB	600	.0013	.0014	.0016	.0016	.0019
		21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Inconel 20	21 - 35 HRC	450	.0010	.0011	.0013	.0014	.0014
		38 - 50 HRC	350	.0009	.0010	.0012	.0013	.0014
		75 - 90 HRB	600	.0010	.0012	.0013	.0015	.0016
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	550	.0016	.0018	.0021	.0023	.0024
		75 - 90 HRB	400	.0015	.0017	.0019	.0020	.0022
		21 - 35 HRC	325	.0013	.0014	.0016	.0018	.0019
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 35 HRC	300	.0012	.0013	.0014	.0016	.0017
		38 - 50 HRC	250	.0011	.0013	.0014	.0015	.0016
		75 - 90 HRB	225	.0011	.0012	.0014	.0014	.0015
COBALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	21 - 35 HRC	150	.0010	.0012	.0014	.0014	.0015
		38 - 50 HRC	90	.0008	.0010	.0011	.0012	.0013
		75 - 90 HRB	225	.0011	.0012	.0014	.0014	.0015

MILLING PROCESS	ADOC	RDOC
Fin (Finishing)	Up to Max LOC	45-65 Diameter
	Up to Max LOC	45-65 Diameter

NOTES:

ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements.

HMAF-FE-4

MULTI-AXIS FINISHERS - 4 FLUTE

Lens Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Lens form with two tangential radii for finishing floors
- 4 flute geometry specifically designed for finishing in stainless steel, high temperature alloys, and other ferrous materials
- Center cutting
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 ± .002"/.05"	Shank Dia. D2 H6	Major Radius R1	Corner Radius R2	Length of Cut L2 ± .002"/.05"	Overall Length L1 ± .002"/.05"	Flutes	Benefit Multiple	T _{plus} Coated	Tool Description
3/8	3/8	3/4	.020	3/8	2-1/2	4	2x	86368	HMAF-FE-40375-02-LNS
1/2	1/2	1	.030	1/2	3	4	2x	86369	HMAF-FE-40590-02-LNS
5/8	5/8	1-1/4	.035	5/8	3-1/2	4	2x	86370	HMAF-FE-40825-02-LNS
3/4	3/4	1-1/2	.040	3/4	4	4	2x	86371	HMAF-FE-40730-02-LNS

* .0005 max TIR

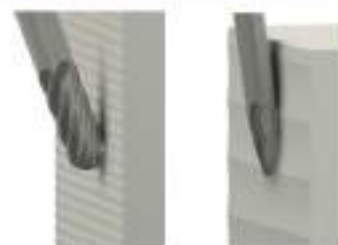


Speeds & Feeds on Page 247

Multi-Axis Finishers: Benefits & Stocked Profiles

Multi-Axis Finishers can significantly reduce cycle times and dramatically improve surface finish when used in place of a ball end mill, and are best used in wide open, flowing, and somewhat flat surfaces due to their large radii. Because of its larger radius, a far greater stepover can be used pass-to-pass while keeping the same cusp height as a ball end mill. This decreases the cycle time by a known value called the Benefit Multiple.

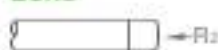
Pro Tip: Multi-Axis Finisher with a Benefit Multiple of 8 will reduce the cycle time to 1/8 of the cycle time for a ball end mill of the same shank diameter – an 87.5% time savings!



The images above show the comparison of a ball end mill to an oval shape Multi-Axis Finisher with a benefit multiple of 8.

3 Different Profiles of Multi-Axis Finishers

Lens



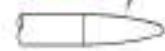
Geometry: 2 tangential radii on the end of the tool
Main Use: Primarily on the face of a part
Tip: Tilt angles of approximately 5 degrees are recommended for these tools to avoid working on-center

Taper



Geometry: 3 tangential radii and a taper angle
Main Use: When a specific approach angle is needed, and where maximum performance gain is desired
Tip: This form allows for the largest radius, and therefore the greatest potential improvement in finish and cycle time

Oval



Geometry: 2 tangential radii
Main Use: In smaller spaces where a slightly varied approach angle is required
Tip: This form offers the most versatility and is a common choice for machinists machining impellers or fan blades



MULTI-AXIS FINISHERS - 4 FLUTE

New Items!

HMAF-FE-4

Taper Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Taper form with three tangential radii and offered in a variety of angles for maximum performance and optimal clearance angle for any workpiece
- 4 flute geometry specifically designed for semi-finishing and finishing in stainless steel, high temperature alloys, and other ferrous materials
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tiplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Ang. Per Side At $\pm .001^\circ$	Shank Dia.* D1 (in)	Major Radius R1	Tip Radius R2	Corner Radius R3	Length of Cut L1	OAL L1 $\pm .002^\circ$	Flutes	Benefit Multiple	Tiplus Coated	Tool Description	
15°	1/4	8	1/16	1/8	.3040	2	4	8x	EC325	HMAF-FE-40250-08-T15	new
	1/4	10	1/16	1/8	.3040	2	4	12x	EC330	HMAF-FE-40250-12-T15	new
	3/8	12	3/64	3/16	.5011	2-1/2	4	8x	EC476	HMAF-FE-40375-08-T15	
	3/8	27	3/64	3/16	.5012	2-1/2	4	12x	EC479	HMAF-FE-40375-12-T15	
	1/2	16	1/16	1/4	.7068	3	4	8x	EC482	HMAF-FE-40500-08-T15	
	1/2	36	1/16	1/4	.7069	3	4	12x	EC485	HMAF-FE-40500-12-T15	
	5/8	20	5/64	5/16	.9034	3	4	8x	EC488	HMAF-FE-40625-08-T15	
	5/8	46	5/64	5/16	.9036	3	4	12x	EC491	HMAF-FE-40625-12-T15	
	3/4	24	3/32	3/8	1.1001	4	4	8x	EC494	HMAF-FE-40750-08-T15	
	3/4	64	3/32	3/8	1.1003	4	4	12x	EC497	HMAF-FE-40750-12-T15	
30°	1/4	8	1/16	1/8	.1075	2	4	8x	EC326	HMAF-FE-40250-08-T30	new
	1/4	10	1/16	1/8	.1075	2	4	12x	EC331	HMAF-FE-40250-12-T30	new
	3/8	12	3/64	3/16	.3281	2-1/2	4	8x	EC477	HMAF-FE-40375-08-T30	
	3/8	27	3/64	3/16	.3281	2-1/2	4	12x	EC480	HMAF-FE-40375-12-T30	
	1/2	16	1/16	1/4	.4375	3	4	8x	EC483	HMAF-FE-40500-08-T30	
	1/2	36	1/16	1/4	.4375	3	4	12x	EC486	HMAF-FE-40500-12-T30	
	5/8	20	5/64	5/16	.5489	3	4	8x	EC489	HMAF-FE-40625-08-T30	
	5/8	46	5/64	5/16	.5489	3	4	12x	EC492	HMAF-FE-40625-12-T30	
	3/4	24	3/32	3/8	.6582	4	4	8x	EC495	HMAF-FE-40750-08-T30	
	3/4	64	3/32	3/8	.6582	4	4	12x	EC498	HMAF-FE-40750-12-T30	
45°	1/4	8	1/16	1/32	.1121	2	4	8x	EC327	HMAF-FE-40250-08-T45	new
	1/4	10	1/16	1/32	.1121	2	4	12x	EC332	HMAF-FE-40250-12-T45	new
	3/8	12	3/64	3/64	.1075	2-1/2	4	8x	EC478	HMAF-FE-40375-08-T45	
	3/8	27	3/64	3/64	.1075	2-1/2	4	12x	EC481	HMAF-FE-40375-12-T45	
	1/2	16	1/16	1/16	.2500	3	4	8x	EC484	HMAF-FE-40500-08-T45	
	1/2	36	1/16	1/16	.2500	3	4	12x	EC487	HMAF-FE-40500-12-T45	
	5/8	20	5/64	5/64	.3125	3	4	8x	EC490	HMAF-FE-40625-08-T45	
	5/8	46	5/64	5/64	.3125	3	4	12x	EC493	HMAF-FE-40625-12-T45	
	3/4	24	3/32	3/32	.3750	4	4	8x	EC496	HMAF-FE-40750-08-T45	
	3/4	64	3/32	3/32	.3750	4	4	12x	EC499	HMAF-FE-40750-12-T45	

* .0005 max TIR

continued on next page



HMAF-FE-4

New Items!

MULTI-AXIS FINISHERS - 4 FLUTE

Taper Form (cont.)

continued from previous page

Ang. Per Side A1 $\begin{smallmatrix} +1^{\circ}30' \\ -1^{\circ}30' \end{smallmatrix}$	Shank Dia.* D2 (H)	Major Radius R1	Tip Radius R2	Corner Radius R3	Length of Cut L2	OAL L1 $\begin{smallmatrix} +.30" \\ -.60" \end{smallmatrix}$	Flutes	Benefit Multiple	T-plus Coated	Tool Description
new new new new new	1/4	8	1/16	1/64	.0715	2	4	8x	96328	HMAF-FE-40250-08-T65
	3/8	12	3/32	3/128	.1073	2-1/2	4	8x	96336	HMAF-FE-40375-08-T65
	1/2	16	1/8	1/32	.1430	3	4	8x	96344	HMAF-FE-40500-08-T65
	5/8	20	5/32	5/128	.1788	3	4	8x	96352	HMAF-FE-40625-08-T65
	3/4	24	3/16	3/64	.2146	4	4	8x	96360	HMAF-FE-40750-08-T65
new new new new new	1/4	8	1/16	1/64	.0433	2	4	8x	96329	HMAF-FE-40250-08-T75
	3/8	12	3/32	3/128	.0649	2-1/2	4	8x	96337	HMAF-FE-40375-08-T75
	1/2	16	1/8	1/32	.0866	3	4	8x	96345	HMAF-FE-40500-08-T75
	5/8	20	5/32	5/128	.1082	3	4	8x	96353	HMAF-FE-40625-08-T75
	3/4	24	3/16	3/64	.1298	4	4	8x	96361	HMAF-FE-40750-08-T75

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Multi-Axis Finishers - Technical Information - pg 243

When switching from a traditional ball end mill, the unique geometries of Multi-Axis Finishers allow for dramatically improved surface finish, while significantly reducing cycle times. Learn more about the Benefit Multiple, profile options, and how these superior tools can pay dividends at the spindle.



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MULTI-AXIS FINISHERS - 4 FLUTE

New Items!

HMAF-FE-4

Oval Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Oval form with two tangential radii for versatility in angle of approach and clearance in tight spaces
- 4 flute geometry specifically designed for semi-finishing and finishing in stainless steel, high temperature alloys, and other ferrous materials
- Center cutting
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 ±.001	Shank Dia. D2 H6	Major Radius R1	Tip Radius R2	Length of Cut L2	Overall Length L1 ±.001	Flutes	Benefit Multiple	Tplus Coated	Tool Description
3/8	3/8	3	3/32	.8260	2-1/2	4	2x	86472	HMAF-FE-40375-04-OVL
	3/8	3	3/32	.8260	4	4	4x	87979	HMAF-FE-40375-04-OVL <i>new</i>
1/2	1/2	4	1/8	1.1013	3	4	2x	86473	HMAF-FE-40506-04-OVL
	1/2	4	1/8	1.1013	4	4	4x	87980	HMAF-FE-40506-04-OVL <i>new</i>
5/8	5/8	5	5/32	1.3766	3-1/2	4	2x	86474	HMAF-FE-40625-04-OVL
	5/8	5	5/32	1.3766	6	4	4x	87981	HMAF-FE-40625-04-OVL <i>new</i>
3/4	3/4	6	3/16	1.6519	4	4	2x	86475	HMAF-FE-40756-04-OVL
	3/4	6	3/16	1.6519	6	4	4x	87982	HMAF-FE-40756-04-OVL <i>new</i>

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Multi-Axis Finishers - Technical Information - pg 243

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HMAF-FE-4

SPEEDS & FEEDS

4 Flute - Multi-Axis Finishers

HMAF-FE-4										
Material Grade		Hardness	SFM	Inches per Tooth (IPT)						
				1/8	3/16	1/4	5/16	3/8	7/16	1/2
				Fin	Fin	Fin	Fin	Fin	Fin	Fin
CARBON STEEL	10XX, 1XX, 12XX, 12LXX, ASTM A27, ASTM A98	<75 HRB	800	.0017	.0016	.0022	.0026	.0028	.0034	.0043
		75 -98 HRB	750	.0014	.0016	.0018	.0021	.0025	.0029	.0036
		21 -36 HRC	700	.0012	.0015	.0015	.0017	.0020	.0024	.0029
LOW ALLOY STEEL	120XX, 41XX, 420XX, 51XX, 860XX, 90XX	75 -98 HRB	600	.0013	.0015	.0017	.0020	.0022	.0027	.0033
		21 -36 HRC	550	.0011	.0013	.0015	.0017	.0020	.0023	.0028
		36 -50 HRC	400	.0011	.0012	.0014	.0016	.0018	.0022	.0027
TOOL STEEL	A2, H13, L6, P20, S7	>50 HRC	350	.0010	.0011	.0012	.0014	.0016	.0019	.0024
		75 -98 HRB	500	.0013	.0015	.0017	.0020	.0022	.0027	.0033
		21 -36 HRC	500	.0012	.0015	.0016	.0017	.0020	.0024	.0029
SPECIALTY STEEL	A2, H13, L6, P20, S7	36 -50 HRC	450	.0011	.0012	.0014	.0015	.0018	.0022	.0026
		>50 HRC	400	.0010	.0011	.0012	.0014	.0016	.0019	.0022
		75 -98 HRB	400	.0015	.0017	.0020	.0022	.0028	.0031	.0038
AUSTENITIC STAINLESS STEEL	304, Inconel 600, Inconel 718, Inconel 720, Inconel 740, Inconel 760, Inconel 780, Inconel 800, Inconel 820, Inconel 840, Inconel 860, Inconel 880, Inconel 900, Inconel 940, Inconel 980, Inconel 1000, Inconel 1020, Inconel 1040, Inconel 1060, Inconel 1080, Inconel 1100, Inconel 1120, Inconel 1140, Inconel 1160, Inconel 1180, Inconel 1200, Inconel 1220, Inconel 1240, Inconel 1260, Inconel 1280, Inconel 1300, Inconel 1320, Inconel 1340, Inconel 1360, Inconel 1380, Inconel 1400, Inconel 1420, Inconel 1440, Inconel 1460, Inconel 1480, Inconel 1500, Inconel 1520, Inconel 1540, Inconel 1560, Inconel 1580, Inconel 1600, Inconel 1620, Inconel 1640, Inconel 1660, Inconel 1680, Inconel 1700, Inconel 1720, Inconel 1740, Inconel 1760, Inconel 1780, Inconel 1800, Inconel 1820, Inconel 1840, Inconel 1860, Inconel 1880, Inconel 1900, Inconel 1920, Inconel 1940, Inconel 1960, Inconel 1980, Inconel 2000, Inconel 2020, Inconel 2040, Inconel 2060, Inconel 2080, Inconel 2100, Inconel 2120, Inconel 2140, Inconel 2160, Inconel 2180, Inconel 2200, Inconel 2220, Inconel 2240, Inconel 2260, Inconel 2280, Inconel 2300, Inconel 2320, Inconel 2340, Inconel 2360, Inconel 2380, Inconel 2400, Inconel 2420, Inconel 2440, Inconel 2460, Inconel 2480, Inconel 2500, Inconel 2520, Inconel 2540, Inconel 2560, Inconel 2580, Inconel 2600, Inconel 2620, Inconel 2640, Inconel 2660, Inconel 2680, Inconel 2700, Inconel 2720, Inconel 2740, Inconel 2760, Inconel 2780, Inconel 2800, Inconel 2820, Inconel 2840, Inconel 2860, Inconel 2880, Inconel 2900, Inconel 2920, Inconel 2940, Inconel 2960, Inconel 2980, Inconel 3000, Inconel 3020, Inconel 3040, Inconel 3060, Inconel 3080, Inconel 3100, Inconel 3120, Inconel 3140, Inconel 3160, Inconel 3180, Inconel 3200, Inconel 3220, Inconel 3240, Inconel 3260, Inconel 3280, Inconel 3300, Inconel 3320, Inconel 3340, Inconel 3360, Inconel 3380, Inconel 3400, Inconel 3420, Inconel 3440, Inconel 3460, Inconel 3480, Inconel 3500, Inconel 3520, Inconel 3540, Inconel 3560, Inconel 3580, Inconel 3600, Inconel 3620, Inconel 3640, Inconel 3660, Inconel 3680, Inconel 3700, Inconel 3720, Inconel 3740, Inconel 3760, Inconel 3780, Inconel 3800, Inconel 3820, Inconel 3840, Inconel 3860, Inconel 3880, Inconel 3900, Inconel 3920, Inconel 3940, Inconel 3960, Inconel 3980, Inconel 4000, Inconel 4020, Inconel 4040, Inconel 4060, Inconel 4080, Inconel 4100, Inconel 4120, Inconel 4140, Inconel 4160, Inconel 4180, Inconel 4200, Inconel 4220, Inconel 4240, Inconel 4260, Inconel 4280, Inconel 4300, Inconel 4320, Inconel 4340, Inconel 4360, Inconel 4380, Inconel 4400, Inconel 4420, Inconel 4440, Inconel 4460, Inconel 4480, Inconel 4500, Inconel 4520, Inconel 4540, Inconel 4560, Inconel 4580, Inconel 4600, Inconel 4620, Inconel 4640, Inconel 4660, Inconel 4680, Inconel 4700, Inconel 4720, Inconel 4740, Inconel 4760, Inconel 4780, Inconel 4800, Inconel 4820, Inconel 4840, Inconel 4860, Inconel 4880, Inconel 4900, Inconel 4920, Inconel 4940, Inconel 4960, Inconel 4980, Inconel 5000, Inconel 5020, Inconel 5040, Inconel 5060, Inconel 5080, Inconel 5100, Inconel 5120, Inconel 5140, Inconel 5160, Inconel 5180, Inconel 5200, Inconel 5220, Inconel 5240, Inconel 5260, Inconel 5280, Inconel 5300, Inconel 5320, Inconel 5340, Inconel 5360, Inconel 5380, Inconel 5400, Inconel 5420, Inconel 5440, Inconel 5460, Inconel 5480, Inconel 5500, Inconel 5520, Inconel 5540, Inconel 5560, Inconel 5580, Inconel 5600, Inconel 5620, Inconel 5640, Inconel 5660, Inconel 5680, Inconel 5700, Inconel 5720, Inconel 5740, Inconel 5760, Inconel 5780, Inconel 5800, Inconel 5820, Inconel 5840, Inconel 5860, Inconel 5880, Inconel 5900, Inconel 5920, Inconel 5940, Inconel 5960, Inconel 5980, Inconel 6000, Inconel 6020, Inconel 6040, Inconel 6060, Inconel 6080, Inconel 6100, Inconel 6120, Inconel 6140, Inconel 6160, Inconel 6180, Inconel 6200, Inconel 6220, Inconel 6240, Inconel 6260, Inconel 6280, Inconel 6300, Inconel 6320, Inconel 6340, Inconel 6360, Inconel 6380, Inconel 6400, Inconel 6420, Inconel 6440, Inconel 6460, Inconel 6480, Inconel 6500, Inconel 6520, Inconel 6540, Inconel 6560, Inconel 6580, Inconel 6600, Inconel 6620, Inconel 6640, Inconel 6660, Inconel 6680, Inconel 6700, Inconel 6720, Inconel 6740, Inconel 6760, Inconel 6780, Inconel 6800, Inconel 6820, Inconel 6840, Inconel 6860, Inconel 6880, Inconel 6900, Inconel 6920, Inconel 6940, Inconel 6960, Inconel 6980, Inconel 7000, Inconel 7020, Inconel 7040, Inconel 7060, Inconel 7080, Inconel 7100, Inconel 7120, Inconel 7140, Inconel 7160, Inconel 7180, Inconel 7200, Inconel 7220, Inconel 7240, Inconel 7260, Inconel 7280, Inconel 7300, Inconel 7320, Inconel 7340, Inconel 7360, Inconel 7380, Inconel 7400, Inconel 7420, Inconel 7440, Inconel 7460, Inconel 7480, Inconel 7500, Inconel 7520, Inconel 7540, Inconel 7560, Inconel 7580, Inconel 7600, Inconel 7620, Inconel 7640, Inconel 7660, Inconel 7680, Inconel 7700, Inconel 7720, Inconel 7740, Inconel 7760, Inconel 7780, Inconel 7800, Inconel 7820, Inconel 7840, Inconel 7860, Inconel 7880, Inconel 7900, Inconel 7920, Inconel 7940, Inconel 7960, Inconel 7980, Inconel 8000, Inconel 8020, Inconel 8040, Inconel 8060, Inconel 8080, Inconel 8100, Inconel 8120, Inconel 8140, Inconel 8160, Inconel 8180, Inconel 8200, Inconel 8220, Inconel 8240, Inconel 8260, Inconel 8280, Inconel 8300, Inconel 8320, Inconel 8340, Inconel 8360, Inconel 8380, Inconel 8400, Inconel 8420, Inconel 8440, Inconel 8460, Inconel 8480, Inconel 8500, Inconel 8520, Inconel 8540, Inconel 8560, Inconel 8580, Inconel 8600, Inconel 8620, Inconel 8640, Inconel 8660, Inconel 8680, Inconel 8700, Inconel 8720, Inconel 8740, Inconel 8760, Inconel 8780, Inconel 8800, Inconel 8820, Inconel 8840, Inconel 8860, Inconel 8880, Inconel 8900, Inconel 8920, Inconel 8940, Inconel 8960, Inconel 8980, Inconel 9000, Inconel 9020, Inconel 9040, Inconel 9060, Inconel 9080, Inconel 9100, Inconel 9120, Inconel 9140, Inconel 9160, Inconel 9180, Inconel 9200, Inconel 9220, Inconel 9240, Inconel 9260, Inconel 9280, Inconel 9300, Inconel 9320, Inconel 9340, Inconel 9360, Inconel 9380, Inconel 9400, Inconel 9420, Inconel 9440, Inconel 9460, Inconel 9480, Inconel 9500, Inconel 9520, Inconel 9540, Inconel 9560, Inconel 9580, Inconel 9600, Inconel 9620, Inconel 9640, Inconel 9660, Inconel 9680, Inconel 9700, Inconel 9720, Inconel 9740, Inconel 9760, Inconel 9780, Inconel 9800, Inconel 9820, Inconel 9840, Inconel 9860, Inconel 9880, Inconel 9900, Inconel 9920, Inconel 9940, Inconel 9960, Inconel 9980, Inconel 10000									
		75 -98 HRB	580	.0013	.0016	.0017	.0019	.0021	.0027	.0030
		MARTENSITIC & FERRITIC STAINLESS STEEL	400, 410, 416, 420, 440, 458, 446	21 -36 HRC	450	.0013	.0014	.0016	.0018	.0021
36 -50 HRC	400			.0011	.0012	.0014	.0016	.0019	.0023	.0028
75 -98 HRB	750			.0013	.0015	.0017	.0020	.0022	.0027	.0033
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 -36 HRC	400	.0011	.0012	.0014	.0016	.0018	.0022	.0027
		36 -50 HRC	400	.0011	.0012	.0014	.0016	.0018	.0022	.0027
		75 -98 HRB	600	.0017	.0019	.0022	.0026	.0028	.0034	.0042
GRAY CAST IRON	SAE J431, ASTM A48	21 -36 HRC	550	.0013	.0014	.0016	.0018	.0021	.0025	.0031
MALLEABLE CAST IRON	ASTM A47, ASTM A226, ASTM A402	75 -98 HRB	550	.0014	.0015	.0017	.0020	.0022	.0026	.0034
		21 -36 HRC	450	.0013	.0014	.0016	.0018	.0021	.0026	.0031
		75 -98 HRB	500	.0014	.0015	.0018	.0020	.0024	.0028	.0034
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM 887	21 -36 HRC	450	.0011	.0013	.0014	.0017	.0019	.0023	.0028
		36 -50 HRC	400	.0009	.0010	.0011	.0013	.0015	.0018	.0022
		75 -98 HRB	500	.0018	.0019	.0020	.0023	.0027	.0032	.0039
PURE NICKEL	Nickel 200, Nickel 201	75 -98 HRB	550	.0014	.0016	.0018	.0021	.0025	.0029	.0036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 -98 HRB	300	.0011	.0013	.0014	.0016	.0018	.0023	.0028
		21 -36 HRC	180	.0011	.0012	.0014	.0016	.0019	.0023	.0027
		36 -50 HRC	150	.0010	.0011	.0013	.0015	.0017	.0021	.0025
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	<75 HRB	350	.0018	.0021	.0024	.0027	.0030	.0038	.0046
		75 -98 HRB	400	.0017	.0019	.0022	.0025	.0028	.0035	.0042
		21 -36 HRC	325	.0015	.0017	.0018	.0022	.0025	.0030	.0036
TITANIUM ALLOY	Ti 3Al-2.5V, Ti6Al-4V, Ti 10V-2Fe-3Al	21 -36 HRC	300	.0013	.0015	.0017	.0019	.0022	.0027	.0032
		36 -50 HRC	250	.0012	.0014	.0016	.0018	.0021	.0025	.0031
		75 -98 HRB	225	.0012	.0013	.0015	.0018	.0021	.0024	.0030
COBALT ALLOY	ASTM F962, ASTM F960, ASTM F75, ASTM F759	21 -36 HRC	150	.0013	.0015	.0017	.0019	.0022	.0024	.0029
		36 -50 HRC	90	.0010	.0011	.0012	.0014	.0017	.0020	.0024
		75 -98 HRB	225	.0012	.0013	.0015	.0018	.0021	.0024	.0030

NOTES:

ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements.

If converting from a ball end mill, the benefit multiple can be used to recalculate stepover pass-to-pass.

STYLE	TOOLPATH	ADOC (STOCK REMOVAL)	RDOC (STEP/OVER FEED PASS)
HNAF-FS-4	Finishing (Fm)	0.05" - 0.10"	0.25 x Dia x Benefit Multiple

MULTI-AXIS FINISHERS - 6 FLUTE

HMAF-FE-6

Taper Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Taper form with three tangential radii and offered in a variety of angles for maximum performance and optimal clearance angle for any workpiece
- 6 flute geometry specifically designed for finishing in stainless steel, high temperature alloys, and other ferrous materials
- Center cutting
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Ang. Per Side A1 $\pm 0.02^\circ$ -0.03°	Shank Dia.* D2 #68	Major Radius R1	Tip Radius R2	Corner Radius R3	Length of Cut L2	OAL L1 ± 0.02 -0.03	Flutes	Benefit Multiple	Tplus Coated	Tool Description
15°	3/8	12	3/64	3/16	.5901	2-1/2	6	8x	86333	HMAF-FE-60375-08-T15
	3/8	27	3/64	3/16	.5902	2-1/2	6	12x	86338	HMAF-FE-60375-12-T15
	1/2	16	1/16	1/4	.7868	3	6	8x	86341	HMAF-FE-60600-08-T15
	1/2	36	1/16	1/4	.7869	3	6	12x	86346	HMAF-FE-60600-12-T15
	5/8	20	5/64	5/16	.8834	3	6	8x	86349	HMAF-FE-60625-08-T15
	5/8	45	5/64	5/16	.8835	3	6	12x	86354	HMAF-FE-60625-12-T15
	3/4	24	3/32	3/8	1.1801	4	6	8x	86357	HMAF-FE-60750-08-T15
	3/4	54	3/32	3/8	1.1803	4	6	12x	86362	HMAF-FE-60750-12-T15
30°	3/8	12	3/64	3/16	.3261	2-1/2	6	8x	86334	HMAF-FE-60375-08-T30
	3/8	27	3/64	3/16	.3261	2-1/2	6	12x	86339	HMAF-FE-60375-12-T30
	1/2	16	1/16	1/4	.4375	3	6	8x	86342	HMAF-FE-60600-08-T30
	1/2	36	1/16	1/4	.4375	3	6	12x	86347	HMAF-FE-60600-12-T30
	5/8	20	5/64	5/16	.5469	3	6	8x	86350	HMAF-FE-60625-08-T30
	5/8	45	5/64	5/16	.5469	3	6	12x	86355	HMAF-FE-60625-12-T30
	3/4	24	3/32	3/8	.6562	4	6	8x	86358	HMAF-FE-60750-08-T30
	3/4	54	3/32	3/8	.6562	4	6	12x	86363	HMAF-FE-60750-12-T30
45°	3/8	12	3/64	3/64	.1875	2-1/2	6	8x	86335	HMAF-FE-60375-08-T45
	3/8	27	3/64	3/64	.1875	2-1/2	6	12x	86340	HMAF-FE-60375-12-T45
	1/2	16	1/16	1/16	.2500	3	6	8x	86343	HMAF-FE-60600-08-T45
	1/2	36	1/16	1/16	.2500	3	6	12x	86348	HMAF-FE-60600-12-T45
	5/8	20	5/64	5/64	.3125	3	6	8x	86351	HMAF-FE-60625-08-T45
	5/8	45	5/64	5/64	.3125	3	6	12x	86356	HMAF-FE-60625-12-T45
	3/4	24	3/32	3/32	.3750	4	6	8x	86359	HMAF-FE-60750-08-T45
	3/4	54	3/32	3/32	.3750	4	6	12x	86364	HMAF-FE-60750-12-T45

* .0005 max TIR

Multi-Axis Finishers - Technical Information - pg 243

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Speeds & Feeds on Page 250

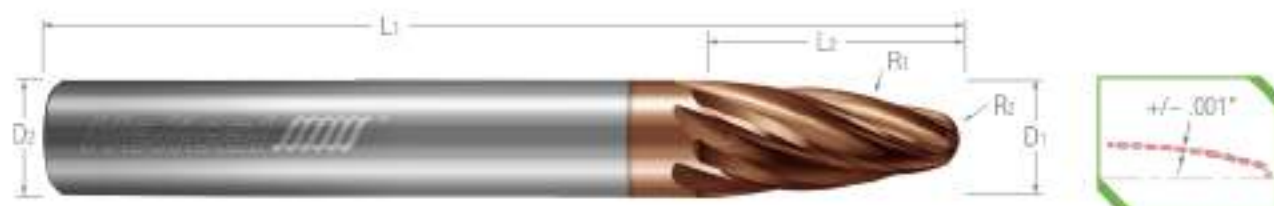
HMAF-FE-6

New Items!

MULTI-AXIS FINISHERS - 6 FLUTE

Oval Form

- Specially defined profile for massive reductions in cycle time and vastly improved surface finish
- Oval form with two tangential radii for versatility in angle of approach and clearance in tight spaces
- 6 flute geometry specifically designed for finishing in stainless steel, high temperature alloys, and other ferrous materials
- Center cutting
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



	Cutter Dia.* D1 $\pm .002$	Shank Dia. D2 #10	Major Radius R1	Tip Radius R2	Length of Cut L2	Overall Length L1 $\pm .002$	Flutes	Benefit Multiple	T _{plus} Coated	Tool Description
new	3/8	3/8	3	3/32	.8260	2-1/2	6	4x	86321	HMAF-FE-60375-04-OVL
		3/8	3	3/32	.8260	4	6	4x	87963	HMAF-FE-60075-04-OVL
new	1/2	1/2	4	1/8	1.1013	3	6	4x	86322	HMAF-FE-60590-04-OVL
		1/2	4	1/8	1.1013	4	6	4x	87964	HMAF-FE-60690-04-OVL
new	5/8	5/8	5	5/32	1.3766	3-1/2	6	4x	86323	HMAF-FE-60625-04-OVL
		5/8	5	5/32	1.3766	6	6	4x	87965	HMAF-FE-60625-04-OVL
new	3/4	3/4	6	3/16	1.6519	4	6	4x	86324	HMAF-FE-60750-04-OVL
		3/4	6	3/16	1.6519	6	6	4x	87966	HMAF-FE-60750-04-OVL

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Multi-Axis Finishers - Technical Information - pg 243

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Speeds & Feeds on Page 250

SPEEDS & FEEDS

6 Flute - Multi-Axis Finishers

HMAF-FE-6

HMAF-FE-6									
Material Guide		Hardness	SFM	Inches per Tooth (IPT)					
				1/8	3/16	1/4	3/8	1/2	5/8
				Fm	Fm	Fm	Fm	Fm	Fm
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	900	.0030	.0034	.0039	.0044	.0051	.0060
		75 - 95 HRB	750	.0025	.0028	.0032	.0037	.0044	.0051
		21 - 36 HRC	700	.0021	.0023	.0026	.0030	.0035	.0042
LOW ALLOY STEEL	10XX, 41XX, 43XX, 51XX, 80XX, 93XX	75 - 95 HRB	900	.0023	.0026	.0030	.0035	.0041	.0048
		21 - 36 HRC	550	.0019	.0023	.0026	.0030	.0035	.0041
		36 - 50 HRC	400	.0019	.0021	.0025	.0028	.0032	.0038
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	350	.0018	.0019	.0021	.0025	.0028	.0034
		75 - 95 HRB	550	.0023	.0026	.0030	.0035	.0041	.0048
		21 - 36 HRC	500	.0021	.0023	.0026	.0030	.0035	.0042
SPECIALTY STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	36 - 50 HRC	450	.0019	.0021	.0025	.0028	.0032	.0038
		> 50 HRC	400	.0018	.0019	.0021	.0025	.0028	.0034
		< 75 HRB	450	.0026	.0030	.0035	.0039	.0046	.0053
AUSTENITIC STAINLESS STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	75 - 95 HRB	500	.0023	.0026	.0030	.0035	.0041	.0048
		21 - 36 HRC	450	.0023	.0025	.0028	.0032	.0037	.0044
		36 - 50 HRC	400	.0019	.0021	.0025	.0028	.0034	.0041
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 95 HRB	750	.0023	.0026	.0030	.0035	.0041	.0048
		21 - 36 HRC	650	.0023	.0025	.0028	.0032	.0037	.0044
		36 - 50 HRC	400	.0019	.0021	.0025	.0028	.0034	.0041
PH STAINLESS STEEL	15-5, 17-4, Carpenter 435, Carpenter 485	21 - 36 HRC	450	.0019	.0023	.0026	.0030	.0035	.0041
		36 - 50 HRC	400	.0019	.0021	.0025	.0028	.0032	.0038
		75 - 95 HRB	600	.0030	.0034	.0039	.0044	.0051	.0060
GRAY CAST IRON	SAE J431, ASTM A48	21 - 36 HRC	550	.0023	.0026	.0030	.0035	.0041	.0048
		75 - 95 HRB	550	.0025	.0028	.0032	.0037	.0044	.0051
		21 - 36 HRC	450	.0023	.0025	.0028	.0032	.0037	.0044
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75 - 95 HRB	550	.0025	.0028	.0032	.0037	.0044	.0051
		21 - 36 HRC	450	.0023	.0025	.0028	.0032	.0037	.0044
		75 - 95 HRB	500	.0025	.0028	.0032	.0035	.0042	.0048
NOODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM A572	21 - 36 HRC	450	.0019	.0023	.0026	.0030	.0035	.0041
		36 - 50 HRC	400	.0018	.0019	.0021	.0025	.0028	.0034
		> 50 HRC	350	.0018	.0019	.0021	.0025	.0028	.0034
PURE NICKEL	Nickel 201, Nickel 201	< 75 HRB	600	.0028	.0032	.0035	.0041	.0046	.0053
		75 - 95 HRB	550	.0025	.0028	.0032	.0037	.0044	.0051
		21 - 36 HRC	500	.0023	.0026	.0030	.0035	.0041	.0048
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 95 HRB	300	.0019	.0023	.0026	.0030	.0035	.0041
		21 - 36 HRC	180	.0019	.0021	.0025	.0028	.0034	.0041
		36 - 50 HRC	150	.0018	.0019	.0021	.0025	.0028	.0034
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	350	.0034	.0037	.0042	.0048	.0056	.0067
		75 - 95 HRB	400	.0030	.0034	.0039	.0044	.0051	.0060
		21 - 36 HRC	320	.0026	.0030	.0034	.0039	.0044	.0053
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	300	.0023	.0026	.0030	.0034	.0039	.0048
		36 - 50 HRC	250	.0021	.0025	.0028	.0032	.0037	.0044
		75 - 95 HRB	220	.0021	.0023	.0026	.0030	.0035	.0042
COBALT ALLOY	ASTM F902, ASTM F903, ASTM F75, ASTM F759	21 - 36 HRC	150	.0021	.0023	.0026	.0030	.0035	.0042
		36 - 50 HRC	90	.0018	.0019	.0021	.0025	.0030	.0035
		> 50 HRC	50	.0018	.0019	.0021	.0025	.0030	.0035

NOTES:

ADOC and RDOC are recommended starting values, and should be adjusted according to your finish requirements.

If converting from a ball and mill, the benefit multiple can be used to recalculate stepover pass-to-pass

STYLE	TOOLPATH	ADOC (STOCK REMOVAL)	RDOC (STEP OVER PER PASS)
HMAF-FE-6	Finishing (Fm)	.005"-.010"	.025 x Dia x Benefit Multiple

HXF



New Items!

MULTI-FLUTE - CORNER RADIUS Finisher

- Offers proven performance and extended tool life in stainless steels, high temp alloys, and hardened steels up to 65 Rc
- Well-suited for increased wear resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, and cast iron
- Designed with high flute count for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications

- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

For steel applications, see page 184 for Aplus coating



Cutter Diameter*	Shank Diameter	Corner Radius	Length of Cut	Overall Length	Flutes	Tplus Coated	Tool Description
$D_1 \begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	$D_2 \text{ (R6)}$	$R \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	$L_2 \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	$L_1 \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$			
new 1/4	1/4	.020	3/8	2	7	59950	HXF-S-070250-R.020
	1/4	.020	1/2	2	7	83517	HXF-SR-070250-R.020
	1/4	.020	3/4	2-1/2	7	59960	HXF-R-070250-R.020
	1/4	.020	1	3	7	87753	HXF-M-070250-R.020
new 3/8	3/8	.020	1/2	2	7	59961	HXF-S-070375-R.020
	3/8	.020	3/4	2-1/2	7	83518	HXF-SR-070375-R.020
	3/8	.020	1	3	7	59962	HXF-R-070375-R.020
	3/8	.020	1-1/4	3	7	83519	HXF-M-070375-R.020
	3/8	.020	1-1/2	3-1/2	7	87755	HXF-L-070375-R.020
new 1/2	1/2	.010	5/8	2-1/2	8	87760	HXF-S-080500-R.010
	1/2	.010	1	3	8	87761	HXF-SR-080500-R.010
	1/2	.010	1-1/4	3	8	87762	HXF-R-080500-R.010
	1/2	.010	1-5/8	3-1/2	8	87763	HXF-M-080500-R.010
	1/2	.030	5/8	2-1/2	8	59963	HXF-S-080500-R.030
	1/2	.030	1	3	8	59964	HXF-SR-080500-R.030
	1/2	.030	1-1/4	3	8	59965	HXF-R-080500-R.030
	1/2	.030	1-5/8	3-1/2	8	83520	HXF-M-080500-R.030
	1/2	.030	2	3-1/2	8	87764	HXF-L-080500-R.030
new 5/8	5/8	.060	3/4	3	10	87765	HXF-S-100625-R.060
	5/8	.060	1-5/8	3-1/2	10	87766	HXF-R-100625-R.060
new 3/4	3/4	.060	1	3	12	59966	HXF-S-120750-R.060
	3/4	.060	1-5/8	4	12	59967	HXF-R-120750-R.060
	3/4	.060	2	4	12	87767	HXF-M-120750-R.060
new 1	1	.060	1-1/4	4	14	87768	HXF-S-141080-R.060
	1	.060	2	4-1/2	14	87769	HXF-R-141080-R.060

*.0005 max TIR



Speeds & Feeds on Page 185

6 FLUTE - CORNER RADIUS

Variable Pitch


HVNI-6

- Specially engineered for optimal performance in Inconel 718 and other nickel-based superalloys in High Efficiency Milling (HEM) and traditional roughing toolpaths.
- 6 flute variable pitch geometry results in higher quality parts by decreasing chatter and harmonics.
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders.
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials.
- Solid carbide
- CNC ground in the USA



Cutter Diameter* $D1 \pm .0005$	Shank Diameter $D2 \pm .001$	Corner Radius $R \pm .0005$	Length of Cut $L2 \pm .001$	Overall Length $L1 \pm .001$	Flutes	T _{plus} Coated	Tool Description
1/4	1/4	.010	3/8	2	6	87301	HVNI-015-60250-R-010
	1/4	.010	1/2	2-1/2	6	86178	HVNI-020-60250-R-010
	1/4	.010	3/4	2-1/2	6	86179	HVNI-030-60250-R-010
	1/4	.010	1	3	6	86180	HVNI-040-60250-R-010
	1/4	.030	3/8	2	6	87302	HVNI-015-60250-R-030
	1/4	.030	1/2	2-1/2	6	86181	HVNI-020-60250-R-030
	1/4	.030	3/4	2-1/2	6	86182	HVNI-030-60250-R-030
	1/4	.030	1	3	6	86183	HVNI-040-60250-R-030
3/8	3/8	.010	3/4	2-1/2	6	87303	HVNI-020-60375-R-010
	3/8	.010	1	3	6	86184	HVNI-026-60375-R-010
	3/8	.010	1-1/4	3	6	86185	HVNI-033-60375-R-010
	3/8	.010	1-1/2	3-1/2	6	86186	HVNI-040-60375-R-010
	3/8	.030	3/4	2-1/2	6	87304	HVNI-020-60375-R-030
	3/8	.030	1	3	6	86187	HVNI-026-60375-R-030
	3/8	.030	1-1/4	3	6	86188	HVNI-033-60375-R-030
	3/8	.030	1-1/2	3-1/2	6	86189	HVNI-040-60375-R-030
1/2	1/2	.010	1	3	6	87305	HVNI-020-60500-R-010
	1/2	.010	1-1/4	3	6	87306	HVNI-025-60500-R-010
	1/2	.010	1-5/8	4	6	87307	HVNI-032-60500-R-010
	1/2	.010	2	4	6	87308	HVNI-040-60500-R-010
	1/2	.030	1	3	6	86190	HVNI-020-60500-R-030
	1/2	.030	1-1/4	3	6	86191	HVNI-025-60500-R-030
	1/2	.030	1-5/8	4	6	86192	HVNI-032-60500-R-030
	1/2	.030	2	4	6	86193	HVNI-040-60500-R-030
	1/2	.060	1	3	6	86194	HVNI-020-60500-R-060
	1/2	.060	1-1/4	3	6	86195	HVNI-025-60500-R-060
	1/2	.060	1-5/8	4	6	86196	HVNI-032-60500-R-060
	1/2	.060	2	4	6	86197	HVNI-040-60500-R-060

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 255

HVNI-6



6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter D ₂ (in)	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut L ₃ $\begin{smallmatrix} +.002" \\ -.000" \end{smallmatrix}$	Overall Length L ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Tool Coated	Tool Description
1/2	1/2	.000	1	3	6	87309	HVN-020-60500-R.000
	1/2	.000	1-1/4	3	6	87310	HVN-025-60500-R.000
	1/2	.000	1-5/8	4	6	87311	HVN-032-60500-R.000
	1/2	.000	2	4	6	87312	HVN-040-60500-R.000
	1/2	.120	1	3	6	86198	HVN-020-60500-R.120
	1/2	.120	1-1/4	3	6	86199	HVN-025-60500-R.120
	1/2	.120	1-5/8	4	6	86200	HVN-032-60500-R.120
	1/2	.120	2	4	6	86201	HVN-040-60500-R.120
5/8	5/8	.000	1-5/8	3-1/2	6	87728	HVN-026-60625-R.000
	5/8	.000	2-1/8	4	6	87729	HVN-034-60625-R.000
	5/8	.000	2-1/2	5	6	87730	HVN-040-60625-R.000
	5/8	.000	1-5/8	3-1/2	6	87731	HVN-026-60625-R.060
	5/8	.000	2-1/8	4	6	87732	HVN-034-60625-R.060
	5/8	.000	2-1/2	5	6	87733	HVN-040-60625-R.060
	5/8	.125	1-5/8	3-1/2	6	87734	HVN-026-60625-R.125
	5/8	.125	2-1/8	4	6	87735	HVN-034-60625-R.125
3/4	3/4	.000	1-5/8	4	6	86202	HVN-021-60750-R.000
	3/4	.000	2-1/4	5	6	86203	HVN-030-60750-R.000
	3/4	.000	2-3/4	5	6	87313	HVN-036-60750-R.000
	3/4	.000	3-1/4	6	6	87314	HVN-043-60750-R.000
	3/4	.000	1-5/8	4	6	86204	HVN-021-60750-R.060
	3/4	.000	2-1/4	5	6	86205	HVN-030-60750-R.060
	3/4	.000	2-3/4	5	6	87315	HVN-036-60750-R.060
	3/4	.000	3-1/4	6	6	87316	HVN-043-60750-R.060
	3/4	.000	1-5/8	4	6	87317	HVN-021-60750-R.090
	3/4	.000	2-1/4	5	6	87318	HVN-030-60750-R.090
	3/4	.000	2-3/4	5	6	87319	HVN-036-60750-R.090
	3/4	.000	3-1/4	6	6	87320	HVN-043-60750-R.090
	3/4	.120	1-5/8	4	6	86206	HVN-021-60750-R.120
	3/4	.120	2-1/4	5	6	86207	HVN-030-60750-R.120
	3/4	.120	2-3/4	5	6	87321	HVN-036-60750-R.120
	3/4	.120	3-1/4	6	6	87322	HVN-043-60750-R.120

*.0003 max TIR

6 FLUTE - CORNER RADIUS

Variable Pitch - Coolant Through


HVNIC-6

- Specially engineered for optimal performance in Inconel 718 and other nickel-based superalloys in High Efficiency Milling (HEM) and traditional roughing tool paths
- 6 flute variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 ± .0005	Shank Diameter D2 H6	Corner Radius R ± .0005	Length of Cut L1 ± .0005	Overall Length L2 ± .0005	Flutes	Tplus Coated	Tool Description
1/4	1/4	.010	1/2	2-1/2	6	87608	HVNC-020-60256-R.010
	1/4	.010	3/4	2-1/2	6	87609	HVNC-030-60256-R.010
	1/4	.030	1/2	2-1/2	6	87610	HVNC-020-60256-R.030
	1/4	.030	3/4	2-1/2	6	87611	HVNC-030-60256-R.030
3/8	3/8	.010	3/4	2-1/2	6	87612	HVNC-020-60375-R.010
	3/8	.010	1	3	6	87613	HVNC-027-60375-R.010
	3/8	.030	3/4	2-1/2	6	87614	HVNC-020-60375-R.030
	3/8	.030	1	3	6	87615	HVNC-027-60375-R.030
1/2	1/2	.030	1	3	6	87616	HVNC-020-60506-R.030
	1/2	.030	1-1/4	3	6	87617	HVNC-025-60506-R.030
	1/2	.030	1-5/8	4	6	87618	HVNC-030-60506-R.030
	1/2	.060	1	3	6	87619	HVNC-020-60506-R.060
	1/2	.060	1-1/4	3	6	87620	HVNC-025-60506-R.060
	1/2	.060	1-5/8	4	6	87621	HVNC-030-60506-R.060
3/4	3/4	.030	1-5/8	4	6	87622	HVNC-022-60756-R.030
	3/4	.030	2-1/4	5	6	87623	HVNC-030-60756-R.030
	3/4	.060	1-5/8	4	6	87624	HVNC-022-60756-R.060
	3/4	.060	2-1/4	5	6	87625	HVNC-030-60756-R.060

* .0005 max TIR



Speeds & Feeds on Page 255

HVNI-6


SPEEDS & FEEDS
 6 Flute - Variable Pitch

HVNI-6 / HVNIC-6

Material Grade	Hardness	SPM	Inches per Tooth (IPT)								
			1/4"			3/8"			1/2"		
			HEM	Rgh	Fin	HEM	Rgh	Fin	HEM	Rgh	Fin
PURE NICKEL Nickel 200, Nickel 201	< 75 HRS	285	.0060	.0025	.0010	.0088	.0041	.0021	.0116	.0054	.0025
	75 - 95 HRS	250	.0049	.0023	.0017	.0073	.0034	.0019	.0096	.0048	.0023
NICKEL ALLOY Hastelloy C-22, Inconel 625, Waspalloy, Rene 41, Inconel 718, Incoloy 28	75 - 95 HRS	80	.0030	.0014	.0013	.0045	.0021	.0015	.0068	.0027	.0018
	21 - 38 HRC	75	.0030	.0014	.0013	.0043	.0020	.0015	.0065	.0026	.0017
	38 - 50 HRC	70	.0028	.0012	.0012	.0038	.0017	.0014	.0047	.0022	.0016
PURE TITANIUM Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRS	300	.0047	.0036	.0021	.0071	.0037	.0024	.0099	.0074	.0038
	75 - 95 HRS	275	.0040	.0032	.0019	.0059	.0048	.0023	.0082	.0062	.0038
	21 - 38 HRC	250	.0030	.0024	.0017	.0045	.0030	.0019	.0062	.0047	.0023
TITANIUM ALLOY Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 38 HRC	180	.0034	.0019	.0014	.0037	.0028	.0017	.0049	.0037	.0020
	38 - 50 HRC	160	.0023	.0017	.0014	.0032	.0026	.0016	.0044	.0034	.0019
COBALT ALLOY ASTM F962, ASTM F90, ASTM F71, ASTM F78	75 - 95 HRS	210	.0034	.0016	.0014	.0051	.0024	.0016	.0096	.0031	.0019
	21 - 38 HRC	170	.0034	.0016	.0014	.0049	.0023	.0016	.0094	.0030	.0018
	38 - 50 HRC	85	.0021	.0010	.0011	.0034	.0016	.0013	.0043	.0020	.0015

MILLING PROCESS	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 90% Diameter
Rgh (Roughing)	Up to Max LOC	10%-20% Diameter
Fin (Finishing)	Up to Max LOC	4%-6% Diameter

Note: IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

Understanding Nickel Alloys: Popularity, Chemical Composition, & Classification

 In The Loupe
 MACHINING BLOG

Nickel-based alloys have been a cornerstone of manufacturing for decades, desirable for their broad range of varying resistances to heat, oxidation, and corrosion. Learn more about this unique and advantageous material, and dive into what makes it truly a staple in machine shops, by reading our "In the Loupe" post: *Understanding Nickel Alloys: Popularity, Chemical Composition, & Classification*.

www.harveyprecision.com/in-the-loupe/nickel-alloys/



SCAN TO READ

8 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling


HVNI-8

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Inconel 718 and other nickel-based superalloys
- 8 flute variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Not for use in traditional slotting and roughing toolpaths
- End cutting geometry (non-center cutting)
- H8 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .0007$ $\pm .0025$	Shank Diameter D2 (H8)	Corner Radius R $\pm .0007$ $\pm .0025$	Length of Cut L2 $\pm .002$ $\pm .007$	Overall Length L1 $\pm .002$ $\pm .007$	Flutes	T _{plus} Coated	Tool Description
3/8	3/8	.010	3/4	2-1/2	8	87323	HVNI-020-80379-R.010
	3/8	.010	1	3	8	86238	HVNI-026-80379-R.010
	3/8	.010	1-1/4	3	8	86239	HVNI-033-80379-R.010
	3/8	.010	1-1/2	3-1/2	8	86240	HVNI-040-80379-R.010
	3/8	.030	3/4	2-1/2	8	87324	HVNI-020-80379-R.030
	3/8	.030	1	3	8	86241	HVNI-026-80379-R.030
	3/8	.030	1-1/4	3	8	86242	HVNI-033-80379-R.030
	3/8	.030	1-1/2	3-1/2	8	86243	HVNI-040-80379-R.030
1/2	1/2	.010	1	3	8	87325	HVNI-020-80500-R.010
	1/2	.010	1-1/4	3	8	87326	HVNI-026-80500-R.010
	1/2	.010	1-5/8	4	8	87327	HVNI-032-80500-R.010
	1/2	.010	2	4	8	87328	HVNI-040-80500-R.010
	1/2	.030	1	3	8	86244	HVNI-020-80500-R.030
	1/2	.030	1-1/4	3	8	86245	HVNI-026-80500-R.030
	1/2	.030	1-5/8	4	8	86246	HVNI-032-80500-R.030
	1/2	.030	2	4	8	86247	HVNI-040-80500-R.030
	1/2	.060	1	3	8	86248	HVNI-020-80500-R.060
	1/2	.060	1-1/4	3	8	86249	HVNI-026-80500-R.060
	1/2	.060	1-5/8	4	8	86250	HVNI-032-80500-R.060
	1/2	.060	2	4	8	86251	HVNI-040-80500-R.060
	1/2	.090	1	3	8	87329	HVNI-020-80500-R.090
	1/2	.090	1-1/4	3	8	87330	HVNI-026-80500-R.090
	1/2	.090	1-5/8	4	8	87331	HVNI-032-80500-R.090
	1/2	.090	2	4	8	87332	HVNI-040-80500-R.090
	1/2	.120	1	3	8	86252	HVNI-020-80500-R.120
	1/2	.120	1-1/4	3	8	86253	HVNI-026-80500-R.120
	1/2	.120	1-5/8	4	8	86254	HVNI-032-80500-R.120
	1/2	.120	2	4	8	86255	HVNI-040-80500-R.120

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 258

HVNI-8



8 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling (cont.)

continued from previous page

Cutter Diameter* $D_1 \begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter $D_2 \text{ (in)}$	Corner Radius $R \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut $L_2 \begin{smallmatrix} +.001" \\ -.001" \end{smallmatrix}$	Overall Length $L_1 \begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Tplus Coated	Tool Description
5/8	5/8	.030	1-5/8	3-1/2	8	87737	HVNI-025-50825-R.030
	5/8	.030	2-1/8	4	8	87738	HVNI-034-50825-R.030
	5/8	.030	2-1/2	5	8	87739	HVNI-040-50825-R.030
	5/8	.060	1-5/8	3-1/2	8	87740	HVNI-025-50825-R.060
	5/8	.060	2-1/8	4	8	87741	HVNI-034-50825-R.060
	5/8	.060	2-1/2	5	8	87742	HVNI-040-50825-R.060
	5/8	.125	1-5/8	3-1/2	8	87743	HVNI-025-50825-R.125
	5/8	.125	2-1/8	4	8	87744	HVNI-034-50825-R.125
	5/8	.125	2-1/2	5	8	87745	HVNI-040-50825-R.125
3/4	3/4	.030	1-5/8	4	8	86256	HVNI-021-80750-R.030
	3/4	.030	2-1/4	5	8	86257	HVNI-030-80750-R.030
	3/4	.030	2-3/4	5	8	87333	HVNI-036-80750-R.030
	3/4	.030	3-1/4	6	8	87334	HVNI-043-80750-R.030
	3/4	.060	1-5/8	4	8	86258	HVNI-021-80750-R.060
	3/4	.060	2-1/4	5	8	86259	HVNI-030-80750-R.060
	3/4	.060	2-3/4	5	8	87335	HVNI-036-80750-R.060
	3/4	.060	3-1/4	6	8	87336	HVNI-043-80750-R.060
	3/4	.090	1-5/8	4	8	87337	HVNI-021-80750-R.090
	3/4	.090	2-1/4	5	8	87338	HVNI-030-80750-R.090
	3/4	.090	2-3/4	5	8	87339	HVNI-036-80750-R.090
	3/4	.090	3-1/4	6	8	87340	HVNI-043-80750-R.090
	3/4	.120	1-5/8	4	8	86260	HVNI-021-80750-R.120
	3/4	.120	2-1/4	5	8	86261	HVNI-030-80750-R.120
	3/4	.120	2-3/4	5	8	87341	HVNI-036-80750-R.120
	3/4	.120	3-1/4	6	8	87342	HVNI-043-80750-R.120
1	1	.060	2	4-1/2	8	86262	HVNI-020-81000-R.060
	1	.060	2-5/8	5	8	86263	HVNI-026-81000-R.060
	1	.060	3-1/4	6	8	87746	HVNI-033-81000-R.060
	1	.060	4-1/4	6	8	87747	HVNI-043-81000-R.060
	1	.125	2	4-1/2	8	87748	HVNI-020-81000-R.125
	1	.125	2-5/8	5	8	87749	HVNI-026-81000-R.125
	1	.125	3-1/4	6	8	87750	HVNI-033-81000-R.125
	1	.125	4-1/4	6	8	87751	HVNI-043-81000-R.125

*.0005 max TIR

SPEEDS & FEEDS

8 Flute - Variable Pitch - For High Efficiency Milling



HVNI-8

HVNI-8

Material Grade	Hardness	SFM	Inches per Tooth (IPT)									
			1/4		3/8		1/2		3/4		1	
			HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin
PURE NICKEL Nickel 201, Nickel 201	< 75 HRB	285	.0051	.0029	.0079	.0023	.0100	.0027	.0148	.0033	.0187	.0048
	75 - 99 HRB	250	.0043	.0018	.0066	.0022	.0084	.0025	.0125	.0036	.0157	.0038
NICKEL ALLOY Hastelloy C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Inconel 30	75 - 99 HRB	80	.0026	.0015	.0041	.0017	.0051	.0029	.0075	.0023	.0095	.0028
	21 - 36 HRC	75	.0025	.0014	.0039	.0016	.0049	.0019	.0072	.0023	.0092	.0026
	36 - 50 HRC	70	.0021	.0013	.0033	.0015	.0041	.0018	.0062	.0021	.0079	.0026
PURE TITANIUM Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0042	.0021	.0063	.0024	.0088	.0029	.0131	.0034	.0176	.0041
	75 - 99 HRB	270	.0035	.0019	.0053	.0023	.0073	.0026	.0110	.0031	.0146	.0036
	21 - 36 HRC	250	.0026	.0017	.0040	.0019	.0055	.0023	.0082	.0027	.0110	.0032
TITANIUM ALLOY Ti 3Al-2.5V, Ti 6Al-4V, Ti 15V-2Fe-3Al	21 - 36 HRC	180	.0022	.0014	.0033	.0017	.0043	.0020	.0065	.0025	.0086	.0028
	36 - 50 HRC	160	.0019	.0014	.0029	.0016	.0039	.0019	.0059	.0023	.0079	.0027
COBALT ALLOY ASTM F902, ASTM F90, ASTM F75, ASTM F739	75 - 99 HRB	210	.0030	.0018	.0049	.0019	.0051	.0021	.0085	.0026	.0108	.0031
	21 - 36 HRC	170	.0030	.0015	.0044	.0017	.0046	.0021	.0082	.0026	.0105	.0028
	36 - 50 HRC	85	.0020	.0013	.0030	.0015	.0038	.0017	.0065	.0020	.0071	.0024

MILLING PROCESS	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Fin (Finishing)	Up to Max LOC	4%-6% Diameter

Note: IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

Machining Nickel Alloys: Avoiding All-Too-Common Mishaps

In The Loupe

Don't make an all-too-common mistake when machining nickel-based alloys. Let us help! From work hardening to tool adhesion, and even excessive heat generation, CNC machining nickel-based alloys without the proper knowledge for avoiding these often devastating mishaps can result in scrapped parts. Our "In the Loupe" blog post: *Machining Nickel Alloys: Avoiding All-Too-Common Mishaps* is a great place to start.

www.harveyprecision.com/in-the-loupe/machining-nickel-alloys/



SCAN TO READ

HEV-C-5



New Items!

5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .002$ "	Shank Diameter D2 $\pm .001$ "	Corner Radius R $\pm .002$ "	Length of Cut L2 $\pm .002$ "	Overall Length L1 $\pm .002$ "	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	58391	HEV-C-S-50125-R.010
	1/8	.010	3/8	2	5	82213	HEV-C-SR-50125-R.010
	1/8	.010	1/2	2-1/2	5	58382	HEV-C-R-50125-R.010
	1/8	.010	5/8	2-1/2	5	82214	HEV-C-A-50125-R.010
	1/8	.010	3/4	2-1/2	5	83068	HEV-C-M-50125-R.010
	1/8	.020	1/4	1-1/2	5	87343	HEV-C-S-50125-R.020
	1/8	.020	3/8	2	5	87344	HEV-C-SR-50125-R.020
	1/8	.020	1/2	2-1/2	5	87345	HEV-C-R-50125-R.020
	1/8	.020	5/8	2-1/2	5	87346	HEV-C-A-50125-R.020
	1/8	.020	3/4	2-1/2	5	87347	HEV-C-M-50125-R.020
	1/8	.030	1/4	1-1/2	5	87348	HEV-C-S-50125-R.030
	1/8	.030	3/8	2	5	87349	HEV-C-SR-50125-R.030
	1/8	.030	1/2	2-1/2	5	87350	HEV-C-R-50125-R.030
	1/8	.030	5/8	2-1/2	5	87351	HEV-C-A-50125-R.030
	1/8	.030	3/4	2-1/2	5	87352	HEV-C-M-50125-R.030
3/16	3/16	.010	5/16	2	5	58393	HEV-C-S-50187-R.010
	3/16	.010	7/16	2	5	81956	HEV-C-SR-50187-R.010
	3/16	.010	9/16	2-1/2	5	58394	HEV-C-R-50187-R.010
	3/16	.010	3/4	2-1/2	5	81957	HEV-C-M-50187-R.010
	3/16	.010	1	2-1/2	5	83069	HEV-C-ML-50187-R.010
	3/16	.020	5/16	2	5	87353	HEV-C-S-50187-R.020
	3/16	.020	7/16	2	5	87354	HEV-C-SR-50187-R.020
	3/16	.020	9/16	2-1/2	5	87355	HEV-C-R-50187-R.020
	3/16	.020	3/4	2-1/2	5	87356	HEV-C-M-50187-R.020
	3/16	.020	1	2-1/2	5	87357	HEV-C-ML-50187-R.020
	3/16	.030	5/16	2	5	83070	HEV-C-S-50187-R.030
	3/16	.030	7/16	2	5	83071	HEV-C-SR-50187-R.030
	3/16	.030	9/16	2-1/2	5	83072	HEV-C-R-50187-R.030
	3/16	.030	3/4	2-1/2	5	83073	HEV-C-M-50187-R.030
	3/16	.030	1	2-1/2	5	87358	HEV-C-ML-50187-R.030

* .0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-C-5

Chipbreaker Rougher - Variable Pitch (cont.)

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Outer Diameter* D1 $^{+0.005}_{-0.005}$	Shank Diameter D2 #6	Corner Radius R $^{+0.005}_{-0.005}$	Length of Cut L1 $^{+0.025}_{-0.005}$	Overall Length L2 $^{+0.025}_{-0.005}$	Flutes	Aplis Coated	Tool Description	
1/4	1/4	.020	3/8	2	5	59395	HEV-C-S-50250-R.020	
	1/4	.020	1/2	2-1/2	5	59396	HEV-C-SR-50250-R.020	
	1/4	.020	3/4	2-1/2	5	59397	HEV-C-R-50250-R.020	
	1/4	.020	1	3	5	59398	HEV-C-M-50250-R.020	
	1/4	.020	1-1/4	3	5	82215	HEV-C-L-50250-R.020	
	1/4	.020	1-1/2	3	5	83074	HEV-C-LX-50250-R.020	
	1/4	.030	3/8	2	5	83075	HEV-C-S-50250-R.030	
	1/4	.030	1/2	2-1/2	5	83076	HEV-C-SR-50250-R.030	
	1/4	.030	3/4	2-1/2	5	83077	HEV-C-R-50250-R.030	
	1/4	.030	1	3	5	83078	HEV-C-M-50250-R.030	
	1/4	.030	1-1/4	3	5	88493	HEV-C-L-50250-R.030	new
	1/4	.060	3/8	2	5	87359	HEV-C-S-50250-R.060	
	1/4	.060	1/2	2-1/2	5	87360	HEV-C-SR-50250-R.060	
	1/4	.060	3/4	2-1/2	5	87361	HEV-C-R-50250-R.060	
	1/4	.060	1	3	5	87362	HEV-C-M-50250-R.060	
5/16	5/16	.020	7/16	2	5	59399	HEV-C-S-50312-R.020	
	5/16	.020	13/16	2-1/2	5	59400	HEV-C-R-50312-R.020	
	5/16	.020	1-1/4	3	5	82216	HEV-C-L-50312-R.020	
	5/16	.030	7/16	2	5	88494	HEV-C-S-50312-R.030	new
	5/16	.030	13/16	2-1/2	5	88495	HEV-C-R-50312-R.030	new
	5/16	.030	1-1/4	3	5	88496	HEV-C-L-50312-R.030	new
3/8	3/8	.020	1/2	2	5	59401	HEV-C-S-50375-R.020	
	3/8	.020	3/4	2-1/2	5	81958	HEV-C-SR-50375-R.020	
	3/8	.020	1	3	5	59402	HEV-C-R-50375-R.020	
	3/8	.020	1-1/4	3	5	59403	HEV-C-M-50375-R.020	
	3/8	.020	1-1/2	3-1/2	5	82217	HEV-C-L-50375-R.020	
	3/8	.020	2	4	5	83079	HEV-C-LX-50375-R.020	
	3/8	.030	1/2	2	5	83080	HEV-C-S-50375-R.030	
	3/8	.030	3/4	2-1/2	5	83081	HEV-C-SR-50375-R.030	
	3/8	.030	1	3	5	83082	HEV-C-R-50375-R.030	
	3/8	.030	1-1/4	3	5	83083	HEV-C-M-50375-R.030	
	3/8	.030	1-1/2	3-1/2	5	88497	HEV-C-L-50375-R.030	new
	3/8	.060	1/2	2	5	87363	HEV-C-S-50375-R.060	
	3/8	.060	3/4	2-1/2	5	87364	HEV-C-SR-50375-R.060	
	3/8	.060	1	3	5	87365	HEV-C-R-50375-R.060	
	3/8	.060	1-1/4	3	5	87366	HEV-C-M-50375-R.060	
1/2	1/2	.010	5/8	2-1/2	5	83084	HEV-C-S-50500-R.010	
	1/2	.010	1	3	5	83085	HEV-C-SR-50500-R.010	
	1/2	.010	1-1/4	3	5	83086	HEV-C-R-50500-R.010	
	1/2	.010	1-5/8	4	5	83087	HEV-C-M-50500-R.010	
	1/2	.010	2	4	5	83088	HEV-C-L-50500-R.010	
	1/2	.010	2-1/2	5	5	88503	HEV-C-LX-50500-R.010	new
	1/2	.020	5/8	2-1/2	5	88498	HEV-C-S-50500-R.020	new
	1/2	.020	1	3	5	88499	HEV-C-SR-50500-R.020	new
	1/2	.020	1-1/4	3	5	88500	HEV-C-R-50500-R.020	new
	1/2	.020	1-5/8	4	5	88501	HEV-C-M-50500-R.020	new
	1/2	.020	2	4	5	88502	HEV-C-L-50500-R.020	new

*.0005 max. TIR

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HEV-C-5



New Items!

5 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 H6	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L2 $\pm \frac{.012}{.007}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Aplic Coated	Tool Description
1/2	1/2	.030	5/8	2-1/2	5	59404	HEV-C-S-50500-R.030
	1/2	.030	1	3	5	59405	HEV-C-SR-50500-R.030
	1/2	.030	1-1/4	3	5	59406	HEV-C-R-50500-R.030
	1/2	.030	1-5/8	4	5	59407	HEV-C-M-50500-R.030
	1/2	.030	2	4	5	59408	HEV-C-L-50500-R.030
	1/2	.030	2-1/2	5	5	81959	HEV-C-LX-50500-R.030
	1/2	.030	3-1/8	6	5	82218	HEV-C-X-50500-R.030
	1/2	.030	3-5/8	6	5	82219	HEV-C-Y-50500-R.030
	1/2	.060	5/8	2-1/2	5	81960	HEV-C-S-50500-R.060
	1/2	.060	1	3	5	81961	HEV-C-SR-50500-R.060
	1/2	.060	1-1/4	3	5	81962	HEV-C-R-50500-R.060
	1/2	.060	1-5/8	4	5	81963	HEV-C-M-50500-R.060
	1/2	.060	2	4	5	81964	HEV-C-L-50500-R.060
	1/2	.060	2-1/2	5	5	81965	HEV-C-LX-50500-R.060
	1/2	.060	3-1/8	6	5	83089	HEV-C-X-50500-R.060
	1/2	.125	5/8	2-1/2	5	87367	HEV-C-S-50500-R.125
	1/2	.125	1	3	5	87368	HEV-C-SR-50500-R.125
	1/2	.125	1-1/4	3	5	87369	HEV-C-R-50500-R.125
	1/2	.125	1-5/8	4	5	87370	HEV-C-M-50500-R.125
5/8	5/8	.030	3/4	3	5	59409	HEV-C-S-50625-R.030
	5/8	.030	1-1/4	3-1/2	5	59410	HEV-C-SR-50625-R.030
	5/8	.030	1-5/8	3-1/2	5	59411	HEV-C-R-50625-R.030
	5/8	.030	2-1/8	4	5	59412	HEV-C-M-50625-R.030
	5/8	.030	2-1/2	5	5	82220	HEV-C-L-50625-R.030
	5/8	.030	3-1/4	6	5	82221	HEV-C-LX-50625-R.030
	5/8	.060	3/4	3	5	81966	HEV-C-S-50625-R.060
	5/8	.060	1-1/4	3-1/2	5	81967	HEV-C-SR-50625-R.060
	5/8	.060	1-5/8	3-1/2	5	81968	HEV-C-R-50625-R.060
	5/8	.060	2-1/8	4	5	81969	HEV-C-M-50625-R.060
	5/8	.060	2-1/2	5	5	88504	HEV-C-L-50625-R.060
	5/8	.060	3-1/4	6	5	88505	HEV-C-LX-50625-R.060
3/4	3/4	.030	1	3	5	59413	HEV-C-S-50750-R.030
	3/4	.030	1-5/8	4	5	59414	HEV-C-R-50750-R.030
	3/4	.030	2-1/4	5	5	59415	HEV-C-M-50750-R.030
	3/4	.030	2-3/4	5	5	59416	HEV-C-L-50750-R.030
	3/4	.030	3-1/4	6	5	59417	HEV-C-LX-50750-R.030
	3/4	.060	1	3-1/2	5	82222	HEV-C-X-50750-R.030
	3/4	.060	1	3	5	81970	HEV-C-S-50750-R.060
	3/4	.060	1-5/8	4	5	81971	HEV-C-R-50750-R.060
	3/4	.060	2-1/4	5	5	81972	HEV-C-M-50750-R.060
	3/4	.060	2-3/4	5	5	81973	HEV-C-L-50750-R.060
	3/4	.060	3-1/4	6	5	81974	HEV-C-LX-50750-R.060
	3/4	.060	4	6-1/2	5	88506	HEV-C-X-50750-R.060
	3/4	.125	1-5/8	4	5	87371	HEV-C-R-50750-R.125
	3/4	.125	2-1/4	5	5	87372	HEV-C-M-50750-R.125
	3/4	.125	2-3/4	5	5	87373	HEV-C-L-50750-R.125
	3/4	.125	3-1/4	6	5	87374	HEV-C-LX-50750-R.125
1	1	.030	1-1/4	4	5	59418	HEV-C-S-51000-R.030
	1	.030	2	4-1/2	5	59419	HEV-C-R-51000-R.030
	1	.030	2-5/8	5	5	88507	HEV-C-M-51000-R.030
	1	.030	3-1/4	6	5	88508	HEV-C-L-51000-R.030

*.0005 max TIR

6 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch - For High Efficiency Milling


HVTI-C-6

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Not for use in traditional slotting and roughing toolpaths
- Center cutting
- H6 shark tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{.002}{.002}$	Shank Diameter D2 (in)	Corner Radius R $\pm \frac{.002}{.002}$	Length of Cut L2 $\pm \frac{.002}{.002}$	Overall Length L1 $\pm \frac{.002}{.002}$	Flutes	Aplus Coated	Tool Description
1/4	.14	.010	1/2	2-1/2	6	84520	HVTI-C-020-60250-R.010
	.14	.010	3/4	2-1/2	6	84521	HVTI-C-030-60250-R.010
	.14	.010	1	3	6	84522	HVTI-C-040-60250-R.010
	.14	.030	1/2	2-1/2	6	84523	HVTI-C-020-60250-R.030
	.14	.030	3/4	2-1/2	6	84524	HVTI-C-030-60250-R.030
	.14	.030	1	3	6	84525	HVTI-C-040-60250-R.030
3/8	.38	.010	1	3	6	84526	HVTI-C-026-60375-R.010
	.38	.010	1-1/4	3	6	84527	HVTI-C-033-60375-R.010
	.38	.010	1-1/2	3-1/2	6	84528	HVTI-C-040-60375-R.010
	.38	.030	1	3	6	84529	HVTI-C-026-60375-R.030
	.38	.030	1-1/4	3	6	84530	HVTI-C-033-60375-R.030
	.38	.030	1-1/2	3-1/2	6	84531	HVTI-C-040-60375-R.030
1/2	.12	.010	1	3	6	84532	HVTI-C-020-60500-R.010
	.12	.010	1-1/4	3	6	84533	HVTI-C-025-60500-R.010
	.12	.010	1-5/8	4	6	84534	HVTI-C-032-60500-R.010
	.12	.010	2	4	6	84535	HVTI-C-040-60500-R.010
	.12	.030	1	3	6	84536	HVTI-C-020-60500-R.030
	.12	.030	1-1/4	3	6	84537	HVTI-C-025-60500-R.030
	.12	.030	1-5/8	4	6	84538	HVTI-C-032-60500-R.030
	.12	.030	2	4	6	84539	HVTI-C-040-60500-R.030
	.12	.060	1	3	6	84540	HVTI-C-020-60500-R.060
	.12	.060	1-1/4	3	6	84541	HVTI-C-025-60500-R.060
	.12	.060	1-5/8	4	6	84542	HVTI-C-032-60500-R.060
	.12	.060	2	4	6	84543	HVTI-C-040-60500-R.060
	.12	.120	1	3	6	84544	HVTI-C-020-60500-R.120
	.12	.120	1-1/4	3	6	84545	HVTI-C-025-60500-R.120
	.12	.120	1-5/8	4	6	84546	HVTI-C-032-60500-R.120
	.12	.120	2	4	6	84547	HVTI-C-040-60500-R.120
3/4	.34	.030	1-5/8	4	6	84548	HVTI-C-021-60750-R.030
	.34	.030	2-1/4	5	6	84549	HVTI-C-030-60750-R.030
	.34	.060	1-5/8	4	6	84550	HVTI-C-021-60750-R.060
	.34	.060	2-1/4	5	6	84551	HVTI-C-030-60750-R.060
	.34	.120	1-5/8	4	6	84552	HVTI-C-021-60750-R.120
	.34	.120	2-1/4	5	6	84553	HVTI-C-030-60750-R.120

*.0005 max TIR



Speeds & Feeds on Page 264

HVTIC-C-6



6 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Coolant Through -
Variable Pitch - For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Not for use in traditional slotting and roughing toolpaths
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (#)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Flutes	Aplus Coated	Tool Description
1/4	1/4	.030	1/2	2-1/2	6	89610	HVTIC-C-020-60250-R.030
	1/4	.030	3/4	2-1/2	6	89611	HVTIC-C-030-60250-R.030
3/8	3/8	.010	1/2	2	6	89612	HVTIC-C-013-60375-R.010
	3/8	.010	1	3	6	89613	HVTIC-C-026-60375-R.010
	3/8	.030	1/2	2	6	89614	HVTIC-C-013-60375-R.030
	3/8	.030	1	3	6	89615	HVTIC-C-026-60375-R.030
1/2	1/2	.030	1	3	6	89616	HVTIC-C-020-60500-R.030
	1/2	.030	1-1/4	3	6	89617	HVTIC-C-025-60500-R.030
	1/2	.030	1-5/8	4	6	89618	HVTIC-C-032-60500-R.030
	1/2	.060	1	3	6	89619	HVTIC-C-021-60500-R.060
	1/2	.060	1-1/4	3	6	89620	HVTIC-C-025-60500-R.060
	1/2	.060	1-5/8	4	6	89621	HVTIC-C-032-60500-R.060
3/4	3/4	.030	1-5/8	4	6	89622	HVTIC-C-021-60750-R.030
	3/4	.030	2-1/4	5	6	89623	HVTIC-C-030-60750-R.030
	3/4	.060	1-5/8	4	6	89624	HVTIC-C-021-60750-R.060
	3/4	.060	2-1/4	5	6	89625	HVTIC-C-030-60750-R.060

*.0005 max TIR



SPEEDS & FEEDS

6 Flute - Corner Radius - Chipbreaker Rougher -
Variable Pitch - For High Efficiency Milling



HVTIC-C-6

HVTI-C-6 / HVTIC-C-6

Material Guide		Hardness	SPM	Inches Per Tooth (IPT)				
				1/4	3/8	1/2	3/4	1
				HEM	HEM	HEM	HEM	HEM
PURE NICKEL	Nickel 201, Nickel 201	< 75 HRB	225	.0038	.0058	.0079	.0118	.0158
		75 - 98 HRB	250	.0032	.0049	.0066	.0099	.0134
NICKEL ALLOY	Inconel C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Inconel 70	75 - 98 HRB	80	.0019	.0029	.0041	.0060	.0081
		21 - 38 HRC	75	.0019	.0029	.0039	.0059	.0077
		36 - 52 HRC	70	.0016	.0024	.0034	.0049	.0066
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0052	.0079	.0110	.0164	.0220
		75 - 98 HRB	275	.0044	.0066	.0091	.0137	.0183
		21 - 38 HRC	250	.0033	.0050	.0069	.0102	.0137
TITANIUM ALLOY	Ti 5Al-2.5V, Ti 6Al-4V, Ti 19V-2Fe-3Al	21 - 38 HRC	160	.0027	.0041	.0054	.0081	.0108
		36 - 52 HRC	160	.0024	.0036	.0049	.0074	.0099
COBALT ALLOY	ASTM F502, ASTM F503, ASTM F75, ASTM F759	75 - 98 HRB	210	.0022	.0034	.0046	.0069	.0092
		21 - 38 HRC	170	.0021	.0032	.0044	.0067	.0088
		36 - 52 HRC	95	.0014	.0023	.0030	.0045	.0060

MILLING PROCESS	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 15% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools,
and should be adjusted for longer or shorter lengths of cut.
For more accurate running parameters, please refer to
Machining Advisor Pro.

Free HEM Guidebook

Download the free 50-page PDF and let High Efficiency Milling
lead the way to a more profitable, productive shop. Scan the QR
code to get started with HEM today.

freecaltool.com/hem


HEV-C-6



New Items!

6 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 6 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure

- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter*	Shank Diameter	Corner Radius	Length of Cut	Overall Length	Flutes	Aplus Coated	Tool Description
$D_1 = \frac{D_2}{0.007}$	D_2 (in)	$R = \frac{D_2}{32}$	$L_2 = \frac{D_2}{0.007}$	$L_1 = \frac{D_2}{0.007}$			
1/8	1/8	.010	1/4	1-1/2	6	84374	HEV-C-S-60125-R.010
	1/8	.010	3/8	2	6	84375	HEV-C-SR-60125-R.010
	1/8	.010	1/2	2-1/2	6	84376	HEV-C-R-60125-R.010
	1/8	.010	5/8	2-1/2	6	84377	HEV-C-A-60125-R.010
3/16	3/16	.010	5/16	2	6	84378	HEV-C-S-60187-R.010
	3/16	.010	7/16	2	6	84379	HEV-C-SR-60187-R.010
	3/16	.010	9/16	2-1/2	6	84380	HEV-C-R-60187-R.010
	3/16	.010	3/4	2-1/2	6	84381	HEV-C-M-60187-R.010
	3/16	.010	1	3	6	88518	HEV-C-ML-60187-R.010
1/4	1/4	.010	3/8	2	6	83125	HEV-C-S-60250-R.010
	1/4	.010	1/2	2-1/2	6	83126	HEV-C-SR-60250-R.010
	1/4	.010	3/4	2-1/2	6	83127	HEV-C-R-60250-R.010
	1/4	.010	1	3	6	83128	HEV-C-M-60250-R.010
	1/4	.020	3/8	2	6	82223	HEV-C-S-60250-R.020
	1/4	.020	1/2	2-1/2	6	82224	HEV-C-SR-60250-R.020
	1/4	.020	3/4	2-1/2	6	82225	HEV-C-R-60250-R.020
	1/4	.020	1	3	6	82226	HEV-C-M-60250-R.020
	1/4	.020	1-1/4	3	6	88519	HEV-C-L-60250-R.020
	1/4	.030	3/8	2	6	87403	HEV-C-S-60250-R.030
	1/4	.030	1/2	2-1/2	6	87404	HEV-C-SR-60250-R.030
	1/4	.030	3/4	2-1/2	6	87405	HEV-C-R-60250-R.030
	1/4	.030	1	3	6	87406	HEV-C-M-60250-R.030
	1/4	.060	3/8	2	6	87407	HEV-C-S-60250-R.060
	1/4	.060	1/2	2-1/2	6	87408	HEV-C-SR-60250-R.060
	1/4	.060	3/4	2-1/2	6	87409	HEV-C-R-60250-R.060
	1/4	.060	1	3	6	87410	HEV-C-M-60250-R.060
3/8	3/8	.010	1/2	2	6	83129	HEV-C-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	83130	HEV-C-SR-60375-R.010
	3/8	.010	1	3	6	83131	HEV-C-R-60375-R.010
	3/8	.010	1-1/4	3	6	83132	HEV-C-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	88520	HEV-C-L-60375-R.010
	3/8	.020	1/2	2	6	87411	HEV-C-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	87412	HEV-C-SR-60375-R.020

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 95

6 FLUTE - CORNER RADIUS

New Items!



HEV-C-6

Chipbreaker Rougher - Variable Pitch (cont.)

continued from previous page

Outer Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 (in)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Flutes	Aplic Coated	Tool Description
3/8	3/8	.020	1	3	6	87413	HEV-C-R-60375-R.020
	3/8	.020	1-1/4	3	6	87414	HEV-C-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	88521	HEV-C-L-60375-R.020
	3/8	.030	1/2	2	6	82227	HEV-C-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	82228	HEV-C-SA-60375-R.030
	3/8	.030	1	3	6	82229	HEV-C-R-60375-R.030
	3/8	.030	1-1/4	3	6	82230	HEV-C-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	88522	HEV-C-L-60375-R.030
	3/8	.060	1/2	2	6	87415	HEV-C-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	87416	HEV-C-SA-60375-R.060
	3/8	.060	1	3	6	87417	HEV-C-R-60375-R.060
	3/8	.060	1-1/4	3	6	87418	HEV-C-M-60375-R.060
1/2	1/2	.010	5/8	2-1/2	6	83133	HEV-C-S-60500-R.010
	1/2	.010	1	3	6	83134	HEV-C-SA-60500-R.010
	1/2	.010	1-1/4	3	6	83135	HEV-C-R-60500-R.010
	1/2	.010	1-5/8	4	6	83136	HEV-C-M-60500-R.010
	1/2	.010	2	4	6	83137	HEV-C-L-60500-R.010
	1/2	.010	2-1/2	5	6	83138	HEV-C-LX-60500-R.010
	1/2	.030	5/8	2-1/2	6	82231	HEV-C-S-60500-R.030
	1/2	.030	1	3	6	82232	HEV-C-SA-60500-R.030
	1/2	.030	1-1/4	3	6	82233	HEV-C-R-60500-R.030
	1/2	.030	1-5/8	4	6	82234	HEV-C-M-60500-R.030
	1/2	.030	2	4	6	82235	HEV-C-L-60500-R.030
	1/2	.030	2-1/2	5	6	82236	HEV-C-LX-60500-R.030
	1/2	.060	5/8	2-1/2	6	82237	HEV-C-S-60500-R.060
	1/2	.060	1	3	6	82238	HEV-C-SA-60500-R.060
	1/2	.060	1-1/4	3	6	82239	HEV-C-R-60500-R.060
	1/2	.060	1-5/8	4	6	82240	HEV-C-M-60500-R.060
	1/2	.060	2	4	6	82241	HEV-C-L-60500-R.060
	1/2	.060	2-1/2	5	6	82242	HEV-C-LX-60500-R.060
	1/2	.125	5/8	2-1/2	6	87419	HEV-C-S-60500-R.125
	1/2	.125	1	3	6	87420	HEV-C-SA-60500-R.125
	1/2	.125	1-1/4	3	6	87421	HEV-C-R-60500-R.125
	1/2	.125	1-5/8	4	6	87422	HEV-C-M-60500-R.125
5/8	5/8	.030	1-1/4	3-1/2	6	83139	HEV-C-SA-60625-R.030
	5/8	.030	1-5/8	3-1/2	6	83140	HEV-C-R-60625-R.030
	5/8	.030	2	4	6	83141	HEV-C-M-60625-R.030
	5/8	.060	3/4	3	6	88524	HEV-C-S-60625-R.060
	5/8	.060	1-1/4	3-1/2	6	82243	HEV-C-SA-60625-R.060
	5/8	.060	1-5/8	3-1/2	6	82244	HEV-C-R-60625-R.060
	5/8	.060	2	4	6	82245	HEV-C-M-60625-R.060
3/4	3/4	.030	1-5/8	4	6	83142	HEV-C-R-60750-R.030
	3/4	.030	2-1/4	5	6	83143	HEV-C-M-60750-R.030
	3/4	.030	2-3/4	5	6	83144	HEV-C-L-60750-R.030
	3/4	.030	3-1/4	6	6	88526	HEV-C-LX-60750-R.030
	3/4	.060	1-5/8	4	6	82246	HEV-C-R-60750-R.060
	3/4	.060	2-1/4	5	6	82247	HEV-C-M-60750-R.060
	3/4	.060	2-3/4	5	6	82248	HEV-C-L-60750-R.060
	3/4	.060	3-1/4	6	6	88527	HEV-C-LX-60750-R.060
	3/4	.125	1-5/8	4	6	87423	HEV-C-R-60750-R.125
	3/4	.125	2-1/4	5	6	87424	HEV-C-M-60750-R.125
	3/4	.125	2-3/4	5	6	87425	HEV-C-L-60750-R.125

* D005 max TIR

HEV-C-7



7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, reduced harmonics, and reduced tool pressure

- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Diameter D2 h6	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L2 $\pm \frac{.001}{.002}$	Overall Length L1 $\pm \frac{.001}{.002}$	Flutes	Aplus Coated	Tool Description
1/4	1/4	.020	3/8	.2	7	59420	HEV-C-S-70250-R.020
	1/4	.020	1/2	.3	7	59421	HEV-C-SR-70250-R.020
	1/4	.020	3/4	2-1/2	7	59422	HEV-C-R-70250-R.020
	1/4	.020	1	3	7	82249	HEV-C-M-70250-R.020
	1/4	.020	1-1/4	3	7	83163	HEV-C-L-70250-R.020
	1/4	.030	3/8	.2	7	87174	HEV-C-S-70250-R.030
	1/4	.030	1/2	.2	7	87175	HEV-C-SR-70250-R.030
	1/4	.030	3/4	2-1/2	7	87176	HEV-C-R-70250-R.030
3/8	3/8	.020	1/2	.2	7	59423	HEV-C-S-70375-R.020
	3/8	.020	3/4	2-1/2	7	59424	HEV-C-SR-70375-R.020
	3/8	.020	1	2-1/2	7	59425	HEV-C-R-70375-R.020
	3/8	.020	1-1/2	3-1/2	7	82250	HEV-C-M-70375-R.020
	3/8	.030	1/2	.2	7	87177	HEV-C-S-70375-R.030
	3/8	.030	3/4	2-1/2	7	87178	HEV-C-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87179	HEV-C-R-70375-R.030
	3/8	.060	1/2	.2	7	83164	HEV-C-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	83165	HEV-C-SR-70375-R.060
	3/8	.060	1	2-1/2	7	83166	HEV-C-R-70375-R.060
1/2	1/2	.010	5/8	2-1/2	7	87180	HEV-C-S-70500-R.010
	1/2	.010	1	3	7	87181	HEV-C-SR-70500-R.010
	1/2	.010	1-1/4	3	7	87182	HEV-C-R-70500-R.010
	1/2	.010	1-5/8	4	7	87183	HEV-C-M-70500-R.010
	1/2	.010	2	4	7	87184	HEV-C-L-70500-R.010
	1/2	.020	5/8	2-1/2	7	83167	HEV-C-S-70500-R.020
	1/2	.020	1	3	7	83168	HEV-C-SR-70500-R.020
	1/2	.020	1-1/4	3	7	83169	HEV-C-R-70500-R.020
	1/2	.020	1-5/8	4	7	83170	HEV-C-M-70500-R.020
	1/2	.020	2	4	7	83171	HEV-C-L-70500-R.020
	1/2	.030	5/8	2-1/2	7	59426	HEV-C-S-70500-R.030
	1/2	.030	1	3	7	59427	HEV-C-SR-70500-R.030
	1/2	.030	1-1/4	3	7	59428	HEV-C-R-70500-R.030
	1/2	.030	1-5/8	4	7	59429	HEV-C-M-70500-R.030
	1/2	.030	2	4	7	81975	HEV-C-L-70500-R.030
	1/2	.030	2-1/2	5	7	82251	HEV-C-LX-70500-R.030
	1/2	.030	3-1/8	6	7	82252	HEV-C-X-70500-R.030

* .0005 max TIR



Speeds & Feeds on Page 99

continued on next page

7 FLUTE - CORNER RADIUS

Chipbreaker Rougher - Variable Pitch (cont.)



HEV-C-7

continued from previous page

Cutter Diameter* D1 $\pm \frac{.007}{.002}$	Shank Diameter D2 h9	Corner Radius R $\pm \frac{.007}{.002}$	Length of Cut L2 $\pm \frac{.007}{.002}$	Overall Length L1 $\pm \frac{.007}{.002}$	Flutes	Applus Coated	Tool Description
1/2	1/2	.060	5/8	2-1/2	7	81978	HEV-C-S-70500-R.060
	1/2	.060	1	3	7	81979	HEV-C-SR-70500-R.060
	1/2	.060	1-1/4	3	7	81980	HEV-C-R-70500-R.060
	1/2	.060	1-5/8	4	7	81981	HEV-C-M-70500-R.060
	1/2	.060	2	4	7	81982	HEV-C-L-70500-R.060
	1/2	.060	2-1/2	5	7	83172	HEV-C-LX-70500-R.060
5/8	5/8	.030	3/4	3	7	83173	HEV-C-S-70625-R.030
	5/8	.030	1-1/4	3-1/2	7	59430	HEV-C-SR-70625-R.030
	5/8	.030	1-5/8	4	7	59431	HEV-C-R-70625-R.030
	5/8	.030	2-1/8	4	7	81976	HEV-C-M-70625-R.030
	5/8	.060	1-1/4	3-1/2	7	81983	HEV-C-SR-70625-R.060
	5/8	.060	1-5/8	4	7	81984	HEV-C-R-70625-R.060
	5/8	.060	2-1/8	4	7	81985	HEV-C-M-70625-R.060
3/4	3/4	.030	1-1/4	3-1/2	7	83174	HEV-C-SR-70750-R.030
	3/4	.030	1-5/8	4	7	59432	HEV-C-R-70750-R.030
	3/4	.030	2-1/4	5	7	59433	HEV-C-M-70750-R.030
	3/4	.030	2-3/4	5	7	81977	HEV-C-L-70750-R.030
	3/4	.030	3-1/4	6	7	83175	HEV-C-LX-70750-R.030
	3/4	.030	4	6-1/2	7	87185	HEV-C-X-70750-R.030
	3/4	.060	1-1/4	3-1/2	7	83176	HEV-C-SR-70750-R.060
	3/4	.060	1-5/8	4	7	81986	HEV-C-R-70750-R.060
	3/4	.060	2-1/4	5	7	81987	HEV-C-M-70750-R.060
	3/4	.060	2-3/4	5	7	81988	HEV-C-L-70750-R.060
	3/4	.060	3-1/4	6	7	87186	HEV-C-LX-70750-R.060
	3/4	.060	4	6-1/2	7	87187	HEV-C-X-70750-R.060
1	1	.030	2-5/8	5	7	87188	HEV-C-M-71000-R.030
	1	.030	3-1/4	6	7	87189	HEV-C-L-71000-R.030
	1	.030	4-1/8	7	7	87190	HEV-C-X-71000-R.030

* .0005 max TIR

HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .001$ -.002	Shank Dia. D2 (h6)	Corner Radius R $\pm .002$ -.002	LOC L1 $\pm .001$ -.001	OAL L2 $\pm .002$ -.002	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/8	1/8	.010	1/4	1-1/2	5	44017		HEV-S-50125-R.010
	1/8	.010	3/8	2	5	81718		HEV-SR-50125-R.010
	1/8	.010	1/2	2-1/2	5	34032		HEV-R-50125-R.010
	1/8	.010	5/8	2-1/2	5	81719		HEV-A-50125-R.010
	1/8	.010	3/4	2-1/2	5	34047		HEV-M-50125-R.010
	1/8	.010	7/8	2-1/2	5	84636		HEV-L-50125-R.010
	1/8	.015	1/4	1-1/2	5	81720		HEV-S-50125-R.015
	1/8	.015	3/8	2	5	82530		HEV-SR-50125-R.015
	1/8	.015	1/2	2-1/2	5	81721		HEV-R-50125-R.015
	1/8	.015	5/8	2-1/2	5	84637		HEV-A-50125-R.015
	1/8	.020	1/4	1-1/2	5	84638		HEV-S-50125-R.020
	1/8	.020	3/8	2	5	84639		HEV-SR-50125-R.020
	1/8	.020	1/2	2-1/2	5	84640		HEV-R-50125-R.020
	1/8	.030	1/4	1-1/2	5	45017		HEV-S-50125-R.030
	1/8	.030	3/8	2	5	82531		HEV-SR-50125-R.030
	1/8	.030	1/2	2-1/2	5	45032		HEV-R-50125-R.030
	1/8	.030	5/8	2-1/2	5	82532		HEV-A-50125-R.030
	1/8	.030	3/4	2-1/2	5	45047		HEV-M-50125-R.030
	1/8	.030	7/8	2-1/2	5	84641		HEV-L-50125-R.030
5/32	3/16	.010	3/16	2	5	81722		HEV-S-50156-R.010
	3/16	.010	5/16	2	5	84642		HEV-SR-50156-R.010
	3/16	.010	7/16	2-1/2	5	81723		HEV-R-50156-R.010
	3/16	.010	9/16	2-1/2	5	81724		HEV-M-50156-R.010
	3/16	.010	3/4	2-1/2	5	84643		HEV-ML-50156-R.010
	3/16	.030	3/16	2	5	88258		HEV-S-50156-R.030
	3/16	.030	5/16	2	5	88260		HEV-SR-50156-R.030
	3/16	.030	7/16	2-1/2	5	88261		HEV-R-50156-R.030
	3/16	.030	9/16	2-1/2	5	88262		HEV-M-50156-R.030
3/16	3/16	.010	3/4	2-1/2	5	88263		HEV-ML-50156-R.030
	3/16	.010	5/8	2	5	34062		HEV-S-50187-R.010
	3/16	.010	7/8	2	5	81725		HEV-SR-50187-R.010
	3/16	.010	9/8	2-1/2	5	34077		HEV-R-50187-R.010
	3/16	.010	3	2-1/2	5	34082		HEV-M-50187-R.010
	3/16	.010	1	2-1/2	5	81726		HEV-ML-50187-R.010
	3/16	.010	1-3/16	3	5	84644		HEV-L-50187-R.010
	3/16	.015	5/8	2	5	81727		HEV-S-50187-R.015

* .0005 max TIR

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Speeds & Feeds on Page 151

5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

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Cutter Dia.* D1: $^{+0.007}_{-0.007}$	Shank Dia. D2 (in)	Corner Radius R: $^{+0.007}_{-0.007}$	LOC L2: $^{+0.007}_{-0.007}$	OAL L1: $^{+0.007}_{-0.007}$	Flutes	Applus Coated	Applus Coated + Weldon Flat	Tool Description
3/16	3/16	.015	7/16	2	5	82533		HEV-SR-50187-R.015
	3/16	.015	9/16	2-1/2	5	81728		HEV-R-50187-R.015
	3/16	.015	3/4	2-1/2	5	82534		HEV-M-50187-R.015
	3/16	.015	1	2-1/2	5	82535		HEV-ML-50187-R.015
	3/16	.020	5/16	2	5	84645		HEV-S-50187-R.020
	3/16	.020	7/16	2	5	84646		HEV-SR-50187-R.020
	3/16	.020	9/16	2-1/2	5	84647		HEV-R-50187-R.020
	3/16	.030	5/16	2	5	45062		HEV-S-50187-R.030
	3/16	.030	7/16	2	5	81729		HEV-SR-50187-R.030
	3/16	.030	9/16	2-1/2	5	45077		HEV-R-50187-R.030
	3/16	.030	3/4	2-1/2	5	45082		HEV-M-50187-R.030
	3/16	.030	1	2-1/2	5	82536		HEV-ML-50187-R.030
	3/16	.030	1-3/16	3	5	84648		HEV-L-50187-R.030
7/32	1/4	.010	5/16	2	5	81730		HEV-S-50218-R.010
	1/4	.010	7/16	2-1/2	5	81731		HEV-R-50218-R.010
1/4	1/4	.010	3/8	2	5	81732		HEV-S-50250-R.010
	1/4	.010	1/2	2-1/2	5	81733		HEV-SR-50250-R.010
	1/4	.010	3/4	2-1/2	5	81734		HEV-R-50250-R.010
	1/4	.010	1	3	5	82537		HEV-M-50250-R.010
	1/4	.010	1-1/4	3	5	82538		HEV-L-50250-R.010
	1/4	.015	3/8	2	5	81735		HEV-S-50250-R.015
	1/4	.015	1/2	2-1/2	5	81736		HEV-SR-50250-R.015
	1/4	.015	3/4	2-1/2	5	81737		HEV-R-50250-R.015
	1/4	.015	1	3	5	82539		HEV-M-50250-R.015
	1/4	.015	1-1/4	3	5	82540		HEV-L-50250-R.015
	1/4	.020	3/8	2	5	34107	34107W	HEV-S-50250-R.020
	1/4	.020	3/8	4	5	82858		HEV-S-50250-R.020
	1/4	.020	1/2	2-1/2	5	34122	34122W	HEV-SR-50250-R.020
	1/4	.020	3/4	2-1/2	5	34137	34137W	HEV-R-50250-R.020
	1/4	.020	3/4	4	5	82859		HEV-R-50250-R.020
	1/4	.020	1	3	5	34152	34152W	HEV-M-50250-R.020
	1/4	.020	1-1/4	3	5	34157		HEV-L-50250-R.020
	1/4	.020	1-1/2	3	5	82541		HEV-LX-50250-R.020
	1/4	.030	3/8	2	5	45107	45107W	HEV-S-50250-R.030
	1/4	.030	1/2	2-1/2	5	45122	45122W	HEV-SR-50250-R.030
	1/4	.030	3/4	2-1/2	5	45137	45137W	HEV-R-50250-R.030
	1/4	.030	1	3	5	45152	45152W	HEV-M-50250-R.030
	1/4	.030	1-1/4	3	5	45157		HEV-L-50250-R.030
	1/4	.030	1-1/2	3	5	82542		HEV-LX-50250-R.030
	1/4	.040	3/8	2	5	88204		HEV-S-50250-R.040
	1/4	.040	1/2	2-1/2	5	88205		HEV-SR-50250-R.040
	1/4	.040	3/4	2-1/2	5	88206		HEV-R-50250-R.040
	1/4	.040	1	3	5	88207		HEV-M-50250-R.040
	1/4	.060	3/8	2	5	45108	45108W	HEV-S-50250-R.060
	1/4	.060	1/2	2-1/2	5	45123	45123W	HEV-SR-50250-R.060
	1/4	.060	3/4	2-1/2	5	45138	45138W	HEV-R-50250-R.060
	1/4	.060	1	3	5	45153	45153W	HEV-M-50250-R.060
	1/4	.060	1-1/4	3	5	45158		HEV-L-50250-R.060
	1/4	.060	1-1/2	3	5	82543		HEV-LX-50250-R.060

* .0005 max. TIR

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new
new
new
new

HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

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Cutter Dia.* D1 $\begin{smallmatrix} +.000" \\ -.000" \end{smallmatrix}$	Shank Dia. D1 #16	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.002" \\ -.000" \end{smallmatrix}$	OAL L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Applus Coated	Applus Coated + Weiden Flat	Tool Description
9/32	5/16	.020	7/16	2	5	81738		HEV-S-50281-R.020
	5/16	.020	3/4	2-1/2	5	81739		HEV-R-50281-R.020
	5/16	.020	1	3	5	81740		HEV-M-50281-R.020
new 5/16	5/16	.010	7/16	2	5	81741		HEV-S-50312-R.010
	5/16	.010	13/16	2-1/2	5	81742		HEV-R-50312-R.010
	5/16	.010	1	3	5	84649		HEV-M-50312-R.010
	5/16	.010	1-1/4	3	5	85265		HEV-L-50312-R.010
	5/16	.015	7/16	2	5	84650		HEV-S-50312-R.015
	5/16	.015	13/16	2-1/2	5	84651		HEV-R-50312-R.015
	5/16	.015	1	3	5	84652		HEV-M-50312-R.015
	5/16	.015	1-1/4	3	5	85269		HEV-L-50312-R.015
	5/16	.020	7/16	2	5	34167	34167W	HEV-S-50312-R.020
	5/16	.020	5/8	2-1/2	5	84653		HEV-SR-50312-R.020
	5/16	.020	13/16	2-1/2	5	34182	34182W	HEV-R-50312-R.020
	5/16	.020	1	3	5	34197	34197W	HEV-M-50312-R.020
	5/16	.020	1-1/4	3	5	81743		HEV-L-50312-R.020
	5/16	.020	1-9/16	4	5	82544		HEV-LX-50312-R.020
	5/16	.030	7/16	2	5	45167	45167W	HEV-S-50312-R.030
	5/16	.030	5/8	2-1/2	5	84654		HEV-SR-50312-R.030
	5/16	.030	13/16	2-1/2	5	45182	45182W	HEV-R-50312-R.030
	5/16	.030	1	3	5	45197	45197W	HEV-M-50312-R.030
	5/16	.030	1-1/4	3	5	82545		HEV-L-50312-R.030
new 3/8	5/16	.060	7/16	2	5	45168		HEV-S-50312-R.060
	5/16	.060	13/16	2-1/2	5	45183		HEV-R-50312-R.060
	5/16	.060	1	3	5	45198		HEV-M-50312-R.060
	5/16	.060	1-1/4	3	5	85270		HEV-L-50312-R.060
	3/8	.010	1/2	2	5	81744		HEV-S-50375-R.010
	3/8	.010	3/4	2-1/2	5	82546		HEV-SR-50375-R.010
	3/8	.010	1	3	5	81745		HEV-R-50375-R.010
	3/8	.010	1-1/4	3	5	81746		HEV-M-50375-R.010
	3/8	.010	1-1/2	3-1/2	5	81747		HEV-L-50375-R.010
	3/8	.015	1/2	2	5	81748		HEV-S-50375-R.015
	3/8	.015	3/4	2-1/2	5	82547		HEV-SR-50375-R.015
	3/8	.015	1	3	5	81749		HEV-R-50375-R.015
	3/8	.015	1-1/4	3	5	82548		HEV-M-50375-R.015
	3/8	.015	1-1/2	3-1/2	5	85271		HEV-L-50375-R.015
	3/8	.020	1/2	2	5	34212	34212W	HEV-S-50375-R.020
	3/8	.020	1/2	4	5	82960		HEV-S-50375-R.020
	3/8	.020	3/4	2-1/2	5	81750		HEV-SR-50375-R.020
	3/8	.020	1	3	5	34227	34227W	HEV-R-50375-R.020
	3/8	.020	1	6	5	82961		HEV-R-50375-R.020
	3/8	.020	1-1/4	3	5	34242	34242W	HEV-M-50375-R.020
	3/8	.020	1-1/2	3-1/2	5	34247		HEV-L-50375-R.020
	3/8	.020	2	4	5	84655		HEV-LX-50375-R.020
	3/8	.030	1/2	2	5	45212	45212W	HEV-S-50375-R.030
	3/8	.030	3/4	2-1/2	5	81751		HEV-SR-50375-R.030
	3/8	.030	1	3	5	45227	45227W	HEV-R-50375-R.030
	3/8	.030	1-1/4	3	5	45242	45242W	HEV-M-50375-R.030
	3/8	.030	1-1/2	3-1/2	5	45247	45247W	HEV-L-50375-R.030
	3/8	.030	2	4	5	84656		HEV-LX-50375-R.030

*.0005 max TIR

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5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

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Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Dia. D2 $\pm .000$	Corner Radius R $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	LOC L2 $\begin{smallmatrix} +.037 \\ -.000 \end{smallmatrix}$	OWL L1 $\begin{smallmatrix} +.062 \\ -.000 \end{smallmatrix}$	Flutes	Apex Coated	Apex Coated + Weldon Flat	Tool Description	
3/8	3/8	.040	1/2	2	3	18272		HEV-S-50375-R.040	new
	3/8	.040	3/4	2-1/2	5	18273		HEV-SR-50375-R.040	new
	3/8	.040	1	3	5	18274		HEV-R-50375-R.040	new
	3/8	.040	1-1/4	3	5	18275		HEV-M-50375-R.040	new
	3/8	.060	1/2	2	3	45213	45213W	HEV-S-50375-R.060	
	3/8	.060	3/4	2-1/2	5	81752		HEV-SR-50375-R.060	
	3/8	.060	1	3	5	45223	45228W	HEV-R-50375-R.060	
	3/8	.060	1-1/4	3	5	45243	45243W	HEV-M-50375-R.060	
	3/8	.060	1-1/2	3-1/2	5	45243		HEV-L-50375-R.060	
	3/8	.060	2	4	5	84657		HEV-LX-50375-R.060	
	3/8	.090	1/2	2	5	45214		HEV-S-50375-R.090	
	3/8	.090	3/4	2-1/2	5	84658		HEV-SR-50375-R.090	
	3/8	.090	1	3	5	45229		HEV-R-50375-R.090	
	3/8	.090	1-1/4	3	5	45244		HEV-M-50375-R.090	
	3/8	.090	1-1/2	3-1/2	5	45249		HEV-L-50375-R.090	
	3/8	.120	1/2	2	5	18276		HEV-S-50375-R.120	new
	3/8	.120	3/4	2-1/2	5	18277		HEV-SR-50375-R.120	new
	3/8	.120	1	3	5	18278		HEV-R-50375-R.120	new
	3/8	.120	1-1/4	3	5	18279		HEV-M-50375-R.120	new
	3/8	.120	1-1/2	3-1/2	5	18280		HEV-L-50375-R.120	new
	3/8	.125	1/2	2	5	82549		HEV-S-50375-R.125	
	3/8	.125	3/4	2-1/2	5	84659		HEV-SR-50375-R.125	
	3/8	.125	1	3	5	82550		HEV-R-50375-R.125	
	3/8	.125	1-1/4	3	5	82551		HEV-M-50375-R.125	
	3/8	.125	1-1/2	3-1/2	5	84660		HEV-L-50375-R.125	
7/16	7/16	.010	5/8	2-3/4	3	18281		HEV-S-50437-R.010	new
	7/16	.010	7/8	2-3/4	5	18282		HEV-R-50437-R.010	new
	7/16	.010	1-1/8	3-1/2	5	18283		HEV-M-50437-R.010	new
	7/16	.030	5/8	2-3/4	5	18284		HEV-S-50437-R.030	new
	7/16	.030	7/8	2-3/4	5	18285		HEV-R-50437-R.030	new
	7/16	.030	1-1/8	3-1/2	5	18286		HEV-M-50437-R.030	new
	7/16	.060	5/8	2-3/4	5	18287		HEV-S-50437-R.060	new
	7/16	.060	7/8	2-3/4	5	18288		HEV-R-50437-R.060	new
1/2	1/2	.010	5/8	2-1/2	5	81753	81753W	HEV-S-50500-R.010	
	1/2	.010	1	3	5	81754	81754W	HEV-SR-50500-R.010	
	1/2	.010	1-1/4	3	5	81755	81755W	HEV-R-50500-R.010	
	1/2	.010	1-5/8	4	5	81756		HEV-M-50500-R.010	
	1/2	.010	2	4	5	81757		HEV-L-50500-R.010	
	1/2	.010	2-1/2	5	5	84661		HEV-LX-50500-R.010	
	1/2	.015	5/8	2-1/2	5	81758	81758W	HEV-S-50500-R.015	
	1/2	.015	1	3	5	81759	81759W	HEV-SR-50500-R.015	
	1/2	.015	1-1/4	3	5	81760	81760W	HEV-R-50500-R.015	
	1/2	.015	1-5/8	4	5	82552		HEV-M-50500-R.015	
	1/2	.015	2	4	5	82553		HEV-L-50500-R.015	
	1/2	.015	2-1/2	5	5	18290		HEV-LX-50500-R.015	new
	1/2	.020	5/8	2-1/2	5	81761	81761W	HEV-S-50500-R.020	
	1/2	.020	1	3	5	81762	81762W	HEV-SR-50500-R.020	
	1/2	.020	1-1/4	3	5	81763	81763W	HEV-R-50500-R.020	
	1/2	.020	1-5/8	4	5	82554		HEV-M-50500-R.020	
	1/2	.020	2	4	5	82555		HEV-L-50500-R.020	
	1/2	.020	2-1/2	5	5	18291		HEV-LX-50500-R.020	new

*.0005 max TIR

continued on next page

HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D ₁ $\begin{smallmatrix} +.000" \\ -.002" \end{smallmatrix}$	Shank Dia. D ₂ (in)	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	LOC L ₂ $\begin{smallmatrix} +.002" \\ -.000" \end{smallmatrix}$	OAL L ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Aplus Coated	Aplus Coated + Weldon Flat	Tool Description
1/2	1/2	.030	5/8	2-1/2	5	34257	34257W	HEV-S-50500-R.030
	1/2	.030	5/8	4	5	82902		HEV-S-50500-R.030
	1/2	.030	1	3	5	34272	34272W	HEV-SR-50500-R.030
	1/2	.030	1-1/4	3	5	34287	34287W	HEV-R-50500-R.030
	1/2	.030	1-1/4	5	5	82963		HEV-R-50500-R.030
	1/2	.030	1-5/8	4	5	34302	34302W	HEV-M-50500-R.030
	1/2	.030	2	4	5	34307	34307W	HEV-L-50500-R.030
	1/2	.030	2-1/2	5	5	81754		HEV-LX-50500-R.030
	1/2	.030	3-1/8	5	5	82556		HEV-X-50500-R.030
	1/2	.030	3-5/8	5	5	82557		HEV-Y-50500-R.030
	1/2	.040	5/8	2-1/2	5	88292		HEV-S-50500-R.040
	1/2	.040	1	3	5	88293		HEV-SR-50500-R.040
	1/2	.040	1-1/4	3	5	88294		HEV-R-50500-R.040
	1/2	.040	1-5/8	4	5	88295		HEV-M-50500-R.040
	1/2	.040	2	4	5	88296		HEV-L-50500-R.040
	1/2	.060	5/8	2-1/2	5	45257	45257W	HEV-S-50500-R.060
	1/2	.060	5/8	4	5	82964		HEV-S-50500-R.060
	1/2	.060	1	3	5	45272	45272W	HEV-SR-50500-R.060
	1/2	.060	1-1/4	3	5	45287	45287W	HEV-R-50500-R.060
	1/2	.060	1-1/4	5	5	82965		HEV-R-50500-R.060
	1/2	.060	1-5/8	4	5	45302	45302W	HEV-M-50500-R.060
	1/2	.060	2	4	5	45307	45307W	HEV-L-50500-R.060
	1/2	.060	2-1/2	5	5	81765		HEV-LX-50500-R.060
	1/2	.090	5/8	2-1/2	5	45258	45258W	HEV-S-50500-R.090
	1/2	.090	1	3	5	45273	45273W	HEV-SR-50500-R.090
	1/2	.090	1-1/4	3	5	45288	45288W	HEV-R-50500-R.090
	1/2	.090	1-5/8	4	5	45303		HEV-M-50500-R.090
	1/2	.090	2	4	5	45308		HEV-L-50500-R.090
	1/2	.090	2-1/2	5	5	82558		HEV-LX-50500-R.090
	1/2	.120	5/8	2-1/2	5	45259	45259W	HEV-S-50500-R.120
	1/2	.120	1	3	5	45274	45274W	HEV-SR-50500-R.120
	1/2	.120	1-1/4	3	5	45289	45289W	HEV-R-50500-R.120
	1/2	.120	1-5/8	4	5	45304	45304W	HEV-M-50500-R.120
	1/2	.120	2	4	5	45309	45309W	HEV-L-50500-R.120
	1/2	.120	2-1/2	5	5	82559		HEV-LX-50500-R.120
	1/2	.125	5/8	2-1/2	5	81766		HEV-S-50500-R.125
	1/2	.125	1	3	5	81767		HEV-SR-50500-R.125
	1/2	.125	1-1/4	3	5	81768		HEV-R-50500-R.125
	1/2	.125	1-5/8	4	5	82560		HEV-M-50500-R.125
	1/2	.125	2	4	5	88297		HEV-L-50500-R.125
	1/2	.125	2-1/2	5	5	88298		HEV-LX-50500-R.125
5/8	5/8	.015	3/4	3	5	88299		HEV-S-50625-R.015
	5/8	.015	1-1/4	3-1/2	5	84962		HEV-SR-50625-R.015
	5/8	.015	1-5/8	3-1/2	5	84963		HEV-R-50625-R.015
	5/8	.015	2-1/8	4	5	84964		HEV-M-50625-R.015
	5/8	.015	2-1/2	5	5	88300		HEV-L-50625-R.015
	5/8	.030	3/4	3	5	34317		HEV-S-50625-R.030
	5/8	.030	1-1/4	3-1/2	5	34322	34322W	HEV-SR-50625-R.030

*.0005 max TIR

continued on next page

5 FLUTE - CORNER RADIUS

New Items!



HEV-5

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D1 $\pm .002$ -.002	Shank Dia. D2 (in)	Corner Radius R $\pm .002$ -.002	LOC L2 $\pm .002$ -.002	OAL L1 $\pm .002$ -.002	Flutes	Aplus Coated	Aplus Coated + Welded Flat	Tool Description
5/8	5/8	.030	1-5/8	3-1/2	5	34332	34332W	HEV-R-50625-R.030
	5/8	.030	2-1/8	4	5	34347	34347W	HEV-M-50625-R.030
	5/8	.030	2-1/2	5	5	34352		HEV-L-50625-R.030
	5/8	.030	3-1/4	6	5	82561		HEV-LX-50625-R.030
	5/8	.060	3/4	3	5	45317		HEV-S-50625-R.060
	5/8	.060	1-1/4	3-1/2	5	45322		HEV-SR-50625-R.060
	5/8	.060	1-5/8	3-1/2	5	45332		HEV-R-50625-R.060
	5/8	.060	2-1/8	4	5	45347		HEV-M-50625-R.060
	5/8	.060	2-1/2	5	5	45352		HEV-L-50625-R.060
	5/8	.090	3/4	3	5	45318		HEV-S-50625-R.090
	5/8	.090	1-1/4	3-1/2	5	45323		HEV-SR-50625-R.090
	5/8	.090	1-5/8	3-1/2	5	45333		HEV-R-50625-R.090
	5/8	.090	2-1/8	4	5	45348		HEV-M-50625-R.090
	5/8	.090	2-1/2	5	5	45353		HEV-L-50625-R.090
	5/8	.120	3/4	3	5	45319		HEV-S-50625-R.120
	5/8	.120	1-1/4	3-1/2	5	45324		HEV-SR-50625-R.120
	5/8	.120	1-5/8	3-1/2	5	45334		HEV-R-50625-R.120
	5/8	.120	2-1/8	4	5	45349		HEV-M-50625-R.120
	5/8	.120	2-1/2	5	5	45354		HEV-L-50625-R.120
	5/8	.120	3-1/4	6	5	82562		HEV-LX-50625-R.120
3/4	3/4	.010	1	3	5	81769		HEV-S-50750-R.010
	3/4	.010	1-5/8	4	5	81770		HEV-R-50750-R.010
	3/4	.010	2-1/4	5	5	81771		HEV-M-50750-R.010
	3/4	.010	2-3/4	5	5	88301		HEV-L-50750-R.010
	3/4	.015	1	3	5	81772		HEV-S-50750-R.015
	3/4	.015	1-5/8	4	5	81773		HEV-R-50750-R.015
	3/4	.015	2-1/4	5	5	81774		HEV-M-50750-R.015
	3/4	.015	2-3/4	5	5	88302		HEV-L-50750-R.015
	3/4	.020	1	3	5	81775		HEV-S-50750-R.020
	3/4	.020	1-5/8	4	5	81776		HEV-R-50750-R.020
	3/4	.020	2-1/4	5	5	81777		HEV-M-50750-R.020
	3/4	.020	2-3/4	5	5	88303		HEV-L-50750-R.020
	3/4	.030	1	3	5	34362	34362W	HEV-S-50750-R.030
	3/4	.030	1	6	5	82968		HEV-R-50750-R.030
	3/4	.030	1-1/4	4	5	81778	81778W	HEV-SR-50750-R.030
	3/4	.030	1-5/8	4	5	34377	34377W	HEV-R-50750-R.030
	3/4	.030	1-5/8	6	5	82967		HEV-R-50750-R.030
	3/4	.030	2-1/4	5	5	34392	34392W	HEV-M-50750-R.030
	3/4	.030	2-3/4	5	5	34397	34397W	HEV-L-50750-R.030
	3/4	.030	3-1/4	6	5	34402	34402W	HEV-LX-50750-R.030
	3/4	.030	4	6-1/2	5	82563		HEV-X-50750-R.030
	3/4	.060	1	3	5	45362	45362W	HEV-S-50750-R.060
	3/4	.060	1	6	5	82968		HEV-R-50750-R.060
	3/4	.060	1-1/4	4	5	81779		HEV-SR-50750-R.060
	3/4	.060	1-5/8	4	5	45377	45377W	HEV-R-50750-R.060
	3/4	.060	1-5/8	6	5	82969		HEV-R-50750-R.060
	3/4	.060	2-1/4	5	5	45392	45392W	HEV-M-50750-R.060
	3/4	.060	2-3/4	5	5	45397		HEV-L-50750-R.060
	3/4	.060	3-1/4	6	5	45402		HEV-LX-50750-R.060
	3/4	.060	4	6-1/2	5	82564		HEV-X-50750-R.060

*.0005 max TIR

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HEV-5



New Items!

5 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Dia.* D ₁ ± .002	Shank Dia. D ₂ (H6)	Corner Radius R ± .002 D ₂ ± .002	LOC L ₂ ± .002 D ₂ ± .002	OAL L ₁ ± .002 D ₂ ± .002	Flutes	Applus Coated	Applus Coated + Weldon Flat	Tool Description
3/4	3/4	.090	1	3	5	45363		HEV-S-50750-R.090
	3/4	.090	1-1/4	4	5	84665		HEV-SR-50750-R.090
	3/4	.090	1-5/8	4	5	45378	45378W	HEV-R-50750-R.090
	3/4	.090	2-1/4	5	5	45393		HEV-M-50750-R.090
	3/4	.090	2-3/4	5	5	45398		HEV-L-50750-R.090
	3/4	.090	3-1/4	6	5	45403		HEV-LX-50750-R.090
	3/4	.120	1	3	5	45364		HEV-S-50750-R.120
	3/4	.120	1-1/4	4	5	81780		HEV-SR-50750-R.120
	3/4	.120	1-5/8	4	5	45379	45379W	HEV-R-50750-R.120
	3/4	.120	2-1/4	5	5	45394	45394W	HEV-M-50750-R.120
	3/4	.120	2-3/4	5	5	45399		HEV-L-50750-R.120
	3/4	.120	3-1/4	6	5	45404		HEV-LX-50750-R.120
	3/4	.190	1	3	5	45365		HEV-S-50750-R.190
	3/4	.190	1-1/4	4	5	84666		HEV-SR-50750-R.190
	3/4	.190	1-5/8	4	5	45380	45380W	HEV-R-50750-R.190
	3/4	.190	2-1/4	5	5	45395		HEV-M-50750-R.190
	3/4	.190	2-3/4	5	5	45400		HEV-L-50750-R.190
	3/4	.190	3-1/4	6	5	45405		HEV-LX-50750-R.190
	3/4	.250	1	3	5	45366		HEV-S-50750-R.250
	3/4	.250	1-1/4	4	5	84667		HEV-SR-50750-R.250
	3/4	.250	1-5/8	4	5	45381	45381W	HEV-R-50750-R.250
	3/4	.250	2-1/4	5	5	45396		HEV-M-50750-R.250
	3/4	.250	2-3/4	5	5	45401	45401W	HEV-L-50750-R.250
	3/4	.250	3-1/4	6	5	45406		HEV-LX-50750-R.250
1	1	.030	1-1/4	4	5	34407	34407W	HEV-S-51000-R.030
	1	.030	2	4-1/2	5	34422	34422W	HEV-R-51000-R.030
	1	.030	2-5/8	5	5	34437	34437W	HEV-M-51000-R.030
	1	.030	3-1/4	6	5	34442	34442W	HEV-L-51000-R.030
	1	.030	4-1/4	7	5	34447	34447W	HEV-X-51000-R.030
	1	.030	5-1/4	8	5	84668		HEV-Y-51000-R.030
	1	.060	1-1/4	4	5	45407		HEV-S-51000-R.060
	1	.060	2	4-1/2	5	45422		HEV-R-51000-R.060
	1	.060	2-5/8	5	5	45437		HEV-M-51000-R.060
	1	.060	3-1/4	6	5	45442		HEV-L-51000-R.060
	1	.060	4-1/4	7	5	45447		HEV-X-51000-R.060
	1	.090	1-1/4	4	5	45408		HEV-S-51000-R.090
	1	.090	2	4-1/2	5	45423		HEV-R-51000-R.090
	1	.090	2-5/8	5	5	45438		HEV-M-51000-R.090
	1	.120	1-1/4	4	5	45409		HEV-S-51000-R.120
	1	.120	2	4-1/2	5	45424		HEV-R-51000-R.120
	1	.120	2-5/8	5	5	45439		HEV-M-51000-R.120
	1	.120	3-1/4	6	5	45444		HEV-L-51000-R.120
	1	.120	4-1/4	7	5	45449		HEV-X-51000-R.120
	1	.190	2	4-1/2	5	45425		HEV-R-51000-R.190
	1	.190	3-1/4	6	5	45445		HEV-L-51000-R.190
	1	.190	4-1/4	7	5	45450		HEV-X-51000-R.190
	1	.250	1-1/4	4	5	45411		HEV-S-51000-R.250
	1	.250	2	4-1/2	5	45426		HEV-R-51000-R.250
	1	.250	2-5/8	5	5	45441		HEV-M-51000-R.250
	1	.250	3-1/4	6	5	45446		HEV-L-51000-R.250
	1	.250	4-1/4	7	5	45451		HEV-X-51000-R.250
1-1/4	1-1/4	.060	2	4-1/2	5	34467		HEV-R-51250-R.060
	1-1/4	.060	2-5/8	5-1/2	5	34482		HEV-M-51250-R.060
	1-1/4	.060	3-1/4	6	5	34497		HEV-L-51250-R.060
	1-1/4	.060	4-1/2	7	5	34512		HEV-LX-51250-R.060

* .0005 max TIR

5 FLUTE - CORNER RADIUS - METRIC

Variable Pitch


MHEV-5
METRIC

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h8 shank tolerance for high precision tool holders
- Aplus-coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1: +30 mm -35 mm	Shank Dia. D2: H6	Corner Radius R: +.5 mm -.5 mm	Length of Cut L1: +.80 mm -.80 mm	Overall Length L2: +1.68 mm -1.68 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	5	59517	MHEV-015-50500-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	5	59535	MHEV-020-50500-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	5	59569	MHEV-030-50500-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	5	59518	MHEV-015-50500-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	5	59536	MHEV-020-50500-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	5	59570	MHEV-030-50500-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	5	59520	MHEV-015-50800-R0.50
	8.00 mm	.50 mm	16.00 mm	83 mm	5	59538	MHEV-020-50800-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	5	59572	MHEV-030-50800-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	5	59521	MHEV-015-50800-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	5	59539	MHEV-020-50800-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	5	59573	MHEV-030-50800-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	5	59523	MHEV-015-51000-R0.50
	10.00 mm	.50 mm	20.00 mm	83 mm	5	59541	MHEV-020-51000-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	5	59555	MHEV-025-51000-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	5	59524	MHEV-015-51000-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	5	59542	MHEV-020-51000-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	5	59556	MHEV-025-51000-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	5	59526	MHEV-015-51200-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	5	59544	MHEV-020-51200-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	5	59558	MHEV-025-51200-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	5	59527	MHEV-015-51200-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	5	59545	MHEV-020-51200-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	5	59559	MHEV-025-51200-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	99 mm	5	59529	MHEV-015-51600-R0.50
	16.00 mm	.50 mm	32.00 mm	99 mm	5	59547	MHEV-020-51600-R0.50
	16.00 mm	.50 mm	40.00 mm	99 mm	5	59561	MHEV-025-51600-R0.50
	16.00 mm	1.00 mm	24.00 mm	99 mm	5	59530	MHEV-015-51600-R1.00
	16.00 mm	1.00 mm	32.00 mm	99 mm	5	59548	MHEV-020-51600-R1.00
	16.00 mm	1.00 mm	40.00 mm	99 mm	5	59562	MHEV-025-51600-R1.00
20 mm	20.00 mm	.50 mm	30.00 mm	99 mm	5	59532	MHEV-015-52000-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	5	59550	MHEV-020-52000-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	5	59564	MHEV-025-52000-R0.50
	20.00 mm	1.00 mm	30.00 mm	99 mm	5	59533	MHEV-015-52000-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	5	59551	MHEV-020-52000-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	5	59565	MHEV-025-52000-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	5	59553	MHEV-020-52500-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	5	59567	MHEV-025-52500-R1.00

* .013 mm max TIR



Speeds & Feeds on Page 151

HVTI-6



6 FLUTE - SQUARE

Variable Pitch - For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Not for use in traditional slotting and roughing toolpaths
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Extensive testing has proven HVTI-6's excellence in extending tool life for HEM operations in Titanium

Cutter Diameter* D1 $^{+0.007}_{-0.002}$	Shank Diameter D2 h6	Length of Cut L2 $^{+0.002}_{-0.001}$	Overall Length L1 $^{+0.002}_{-0.001}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	2-1/2	6	87209	HVTI-000-60125
	1/8	3/8	2-1/2	6	87210	HVTI-020-60125
	1/8	1/2	2-1/2	6	87211	HVTI-040-60125
	1/8	5/8	2-1/2	6	87212	HVTI-060-60125
3/16	1/4	5/16	2-1/2	6	87213	HVTI-016-60187
	1/4	7/16	2-1/2	6	87214	HVTI-023-60187
	1/4	9/16	2-1/2	6	87215	HVTI-030-60187
	1/4	3/4	2-1/2	6	87216	HVTI-040-60187
1/4	1/4	3/8	2	6	87217	HVTI-015-60250
	1/4	1/2	2-1/2	6	84564	HVTI-020-60250
	1/4	3/4	2-1/2	6	84565	HVTI-030-60250
	1/4	1	3	6	84566	HVTI-040-60250
	1/4	1-1/4	3	6	87218	HVTI-060-60250
5/16	5/16	7/16	2	6	87219	HVTI-014-60312
	5/16	3/4	2-1/2	6	87220	HVTI-024-60312
	5/16	1	3	6	87221	HVTI-032-60312
3/8	3/8	1/2	2	6	87222	HVTI-013-60375
	3/8	3/4	2-1/2	6	87223	HVTI-020-60375
	3/8	1	3	6	84567	HVTI-026-60375
	3/8	1-1/4	3	6	84568	HVTI-035-60375
	3/8	1-1/2	3-1/2	6	84569	HVTI-040-60375
1/2	1/2	3/4	2-1/2	6	87224	HVTI-012-60500
	1/2	1	3	6	84560	HVTI-020-60500
	1/2	1-1/4	3	6	84561	HVTI-025-60500
	1/2	1-5/8	4	6	84562	HVTI-032-60500
	1/2	2	4	6	84563	HVTI-040-60500
5/8	5/8	1-1/4	3-1/2	6	87225	HVTI-020-60625
	5/8	1-5/8	3-1/2	6	87226	HVTI-026-60625
3/4	3/4	1-1/4	4	6	87227	HVTI-016-60750
	3/4	1-5/8	4	6	84564	HVTI-021-60750
	3/4	2-1/4	5	6	84565	HVTI-030-60750

* .0005 max TP



Speeds & Feeds on Page 283

6 FLUTE - BALL

Variable Pitch - For High Efficiency Milling


HVTI-6

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Not for use in traditional slotting and roughing toolpaths
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Extensive testing has proven HVTI-6's excellence in extending tool life for HEM operations in Titanium

Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 $\begin{smallmatrix} +.0004 \\ -.0004 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/4	1/4	2-1/2	6	87228	HVTI-020-60125-8N
	1/4	3/8	2-1/2	6	87229	HVTI-030-60125-8N
	1/4	1/2	2-1/2	6	87230	HVTI-040-60125-8N
	1/4	5/8	2-1/2	6	87231	HVTI-050-60125-8N
3/16	1/4	5/16	2-1/2	6	87232	HVTI-016-60187-8N
	1/4	7/16	2-1/2	6	87233	HVTI-025-60187-8N
	1/4	9/16	2-1/2	6	87234	HVTI-030-60187-8N
	1/4	3/4	2-1/2	6	87235	HVTI-040-60187-8N
1/4	1/4	3/8	2	6	87236	HVTI-015-60250-8N
	1/4	1/2	2-1/2	6	84566	HVTI-020-60250-8N
	1/4	3/4	2-1/2	6	84567	HVTI-030-60250-8N
	1/4	1	3	6	84568	HVTI-040-60250-8N
	1/4	1-1/4	3	6	87237	HVTI-050-60250-8N
5/16	5/16	7/16	2	6	87238	HVTI-014-60312-8N
	5/16	3/4	2-1/2	6	87239	HVTI-024-60312-8N
	5/16	1	3	6	87240	HVTI-032-60312-8N
3/8	3/8	1/2	2	6	87241	HVTI-013-60375-8N
	3/8	3/4	2-1/2	6	87242	HVTI-020-60375-8N
	3/8	1	3	6	84569	HVTI-026-60375-8N
	3/8	1-1/4	3	6	84570	HVTI-033-60375-8N
	3/8	1-1/2	3-1/2	6	84571	HVTI-040-60375-8N
1/2	1/2	5/8	2-1/2	6	87243	HVTI-012-60500-8N
	1/2	1	3	6	84572	HVTI-020-60500-8N
	1/2	1-1/8	3	6	84573	HVTI-025-60500-8N
	1/2	1-5/8	4	6	84574	HVTI-032-60500-8N
	1/2	2	4	6	84575	HVTI-040-60500-8N
5/8	5/8	1-1/4	3-1/2	6	87244	HVTI-020-60625-8N
	5/8	1-5/8	3-1/2	6	87245	HVTI-026-60625-8N
3/4	3/4	1-1/4	4	6	87246	HVTI-016-60750-8N
	3/4	1-5/8	4	6	84576	HVTI-021-60750-8N
	3/4	2-1/4	5	6	84577	HVTI-030-60750-8N

* .0005 max TIR



Speeds & Feeds on Page 283

HVTI-6



6 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Not for use in traditional slotting and roughing toolpaths
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Extensive testing has proven HVTI-6's excellence in extending tool life for HEM operations in Titanium

Cutter Diameter* D1 $\begin{smallmatrix} +.001" \\ -.002" \end{smallmatrix}$	Shank Diameter D2 H6	Corner Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002" \\ -.001" \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/4	.010	1/4	2-1/2	6	84358	HVTI-020-60125-R.010
	1/4	.010	3/8	2-1/2	6	84359	HVTI-030-60125-R.010
	1/4	.010	1/2	2-1/2	6	84360	HVTI-040-60125-R.010
	1/4	.010	5/8	2-1/2	6	84361	HVTI-050-60125-R.010
	1/4	.030	1/4	2-1/2	6	84362	HVTI-020-60125-R.030
	1/4	.030	3/8	2-1/2	6	84363	HVTI-030-60125-R.030
	1/4	.030	1/2	2-1/2	6	84364	HVTI-040-60125-R.030
	1/4	.030	5/8	2-1/2	6	84365	HVTI-050-60125-R.030
3/16	1/4	.010	5/16	2-1/2	6	84366	HVTI-016-60187-R.010
	1/4	.010	7/16	2-1/2	6	84367	HVTI-025-60187-R.010
	1/4	.010	9/16	2-1/2	6	84368	HVTI-030-60187-R.010
	1/4	.010	3/4	2-1/2	6	84369	HVTI-040-60187-R.010
	1/4	.010	1	2-1/2	6	87247	HVTI-053-60187-R.010
	1/4	.030	5/16	2-1/2	6	84370	HVTI-016-60187-R.030
	1/4	.030	7/16	2-1/2	6	84371	HVTI-025-60187-R.030
	1/4	.030	9/16	2-1/2	6	84372	HVTI-030-60187-R.030
	1/4	.030	3/4	2-1/2	6	84373	HVTI-040-60187-R.030
	1/4	.030	1	2-1/2	6	87248	HVTI-053-60187-R.030
1/4	1/4	.010	3/8	2	6	83887	HVTI-015-60250-R.010
	1/4	.010	1/2	2-1/2	6	82059	HVTI-020-60250-R.010
	1/4	.010	3/4	2-1/2	6	82060	HVTI-030-60250-R.010
	1/4	.010	1	3	6	82061	HVTI-040-60250-R.010
	1/4	.010	1-1/4	3	6	83888	HVTI-050-60250-R.010
	1/4	.020	3/8	2	6	87249	HVTI-015-60250-R.020
	1/4	.020	1/2	2-1/2	6	83889	HVTI-020-60250-R.020
	1/4	.020	3/4	2-1/2	6	83890	HVTI-030-60250-R.020
	1/4	.020	1	3	6	83891	HVTI-040-60250-R.020
	1/4	.030	3/8	2	6	83892	HVTI-015-60250-R.030
	1/4	.030	1/2	2-1/2	6	82062	HVTI-020-60250-R.030
	1/4	.030	3/4	2-1/2	6	82063	HVTI-030-60250-R.030
	1/4	.030	1	3	6	82064	HVTI-040-60250-R.030
	1/4	.030	1-1/4	3	6	83893	HVTI-050-60250-R.030
	1/4	.060	3/8	2	6	87250	HVTI-015-60250-R.060
	1/4	.060	1/2	2-1/2	6	83894	HVTI-020-60250-R.060
	1/4	.060	3/4	2-1/2	6	83895	HVTI-030-60250-R.060
	1/4	.060	1	3	6	83896	HVTI-040-60250-R.060

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 283

6 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling (cont.)



HVTI-6

continued from previous page

Cutter Diameter* D1 $\pm .002$ "	Shank Diameter D2 (H)	Corner Radius R $\pm .002$ "	Length of Cut L2 $\pm .032$ "	Overall Length L1 $\pm .002$ "	Flutes	Aplics Coated	Tool Description
5/16	5/16	.010	7/16	2	6	87251	HVTI-014-60312-R010
	5/16	.010	3/4	2-1/2	6	87252	HVTI-024-60312-R010
	5/16	.010	1	3	6	87253	HVTI-032-60312-R010
	5/16	.010	1-1/4	3	6	87254	HVTI-040-60312-R010
	5/16	.030	7/16	2	6	83897	HVTI-014-60312-R030
	5/16	.030	3/4	2-1/2	6	83898	HVTI-024-60312-R030
	5/16	.030	1	3	6	83899	HVTI-032-60312-R030
	5/16	.030	1-1/4	3	6	83900	HVTI-040-60312-R030
	5/16	.060	7/16	2	6	83901	HVTI-014-60312-R060
	5/16	.060	3/4	2-1/2	6	83902	HVTI-024-60312-R060
	5/16	.060	1	3	6	83903	HVTI-032-60312-R060
	5/16	.060	1-1/4	3	6	83904	HVTI-040-60312-R060
3/8	3/8	.010	1/2	2	6	83905	HVTI-013-60375-R010
	3/8	.010	3/4	2-1/2	6	83906	HVTI-020-60375-R010
	3/8	.010	1	3	6	82065	HVTI-026-60375-R010
	3/8	.010	1-1/4	3	6	82066	HVTI-033-60375-R010
	3/8	.010	1-1/2	3-1/2	6	82067	HVTI-040-60375-R010
	3/8	.010	1-3/4	4	6	83907	HVTI-046-60375-R010
	3/8	.020	1	3	6	83908	HVTI-026-60375-R020
	3/8	.020	1-1/4	3	6	83909	HVTI-033-60375-R020
	3/8	.020	1-1/2	3-1/2	6	83910	HVTI-040-60375-R020
	3/8	.030	1/2	2	6	83911	HVTI-013-60375-R030
	3/8	.030	3/4	2-1/2	6	83912	HVTI-020-60375-R030
	3/8	.030	1	3	6	82068	HVTI-026-60375-R030
	3/8	.030	1-1/4	3	6	82069	HVTI-033-60375-R030
	3/8	.030	1-1/2	3-1/2	6	82070	HVTI-040-60375-R030
	3/8	.030	1-3/4	4	6	83913	HVTI-046-60375-R030
	3/8	.060	1	3	6	83914	HVTI-026-60375-R060
	3/8	.060	1-1/4	3	6	83915	HVTI-033-60375-R060
	3/8	.060	1-1/2	3-1/2	6	83916	HVTI-040-60375-R060
1/2	1/2	.010	5/8	2-1/2	6	84980	HVTI-012-60690-R010
	1/2	.010	1	3	6	82071	HVTI-020-60690-R010
	1/2	.010	1-1/4	3	6	82072	HVTI-025-60690-R010
	1/2	.010	1-5/8	4	6	82073	HVTI-032-60690-R010
	1/2	.010	2	4	6	82074	HVTI-040-60690-R010
	1/2	.010	2-1/2	5	6	83917	HVTI-050-60690-R010
	1/2	.020	5/8	2-1/2	6	87255	HVTI-012-60690-R020
	1/2	.020	1	3	6	83918	HVTI-020-60690-R020
	1/2	.020	1-1/4	3	6	83919	HVTI-025-60690-R020
	1/2	.020	1-5/8	4	6	83920	HVTI-032-60690-R020
	1/2	.020	2	4	6	83921	HVTI-040-60690-R020
	1/2	.030	5/8	2-1/2	6	83922	HVTI-012-60690-R030
	1/2	.030	1	3	6	82075	HVTI-020-60690-R030
	1/2	.030	1-1/4	3	6	82076	HVTI-025-60690-R030
	1/2	.030	1-5/8	4	6	82077	HVTI-032-60690-R030
	1/2	.030	2	4	6	82078	HVTI-040-60690-R030
	1/2	.030	2-1/2	5	6	83923	HVTI-050-60690-R030
	1/2	.030	3-1/8	6	6	83924	HVTI-062-60690-R030
	1/2	.060	5/8	2-1/2	6	83925	HVTI-012-60690-R060
	1/2	.060	1	3	6	82079	HVTI-020-60690-R060
	1/2	.060	1-1/4	3	6	82080	HVTI-025-60690-R060
	1/2	.060	1-5/8	4	6	82081	HVTI-032-60690-R060
	1/2	.060	2	4	6	82082	HVTI-040-60690-R060

* .0005 max TIR

continued on next page

HVTI-6



6 FLUTE - CORNER RADIUS

Variable Pitch - For High Efficiency Milling (cont.)

continued from previous page

Cutter Diameter* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Diameter D2 (d6)	Corner Radius R $\begin{smallmatrix} +.0027 \\ -.0027 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.0327 \\ -.0327 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0627 \\ -.0627 \end{smallmatrix}$	Flutes	Alphas Coated	Tool Description
1/2	1/2	.090	5/8	2-1/2	6	87256	HVT-012-60500-R.090
	1/2	.090	1	3	6	84081	HVT-020-60500-R.090
	1/2	.090	1-1/4	3	6	84982	HVT-025-60500-R.090
	1/2	.090	1-5/8	4	6	84983	HVT-032-60500-R.090
	1/2	.090	2	4	6	87257	HVT-040-60500-R.090
	1/2	.120	5/8	2-1/2	6	84984	HVT-012-60500-R.120
	1/2	.120	1	3	6	82083	HVT-020-60500-R.120
	1/2	.120	1-1/4	3	6	82084	HVT-025-60500-R.120
	1/2	.120	1-5/8	4	6	82085	HVT-032-60500-R.120
	1/2	.120	2	4	6	82086	HVT-040-60500-R.120
5/8	5/8	.030	1-1/4	3-1/2	6	83926	HVT-020-60625-R.030
	5/8	.030	1-5/8	3-1/2	6	83927	HVT-025-60625-R.030
	5/8	.030	2	4	6	83928	HVT-032-60625-R.030
	5/8	.030	2-1/2	5	6	83929	HVT-040-60625-R.030
	5/8	.060	1-1/4	3-1/2	6	83930	HVT-020-60625-R.060
	5/8	.060	1-5/8	3-1/2	6	83931	HVT-025-60625-R.060
	5/8	.060	2	4	6	83932	HVT-032-60625-R.060
	5/8	.060	2-1/2	5	6	83933	HVT-040-60625-R.060
	5/8	.120	1-1/4	3-1/2	6	83934	HVT-020-60625-R.120
	5/8	.120	1-5/8	3-1/2	6	83935	HVT-025-60625-R.120
	5/8	.120	2	4	6	83936	HVT-032-60625-R.120
	5/8	.120	2-1/2	5	6	83937	HVT-040-60625-R.120
3/4	3/4	.030	1-1/4	4	6	87258	HVT-016-60750-R.030
	3/4	.030	1-5/8	4	6	82087	HVT-021-60750-R.030
	3/4	.030	2-1/4	5	6	82088	HVT-030-60750-R.030
	3/4	.030	2-3/4	5	6	83938	HVT-036-60750-R.030
	3/4	.030	3-1/4	6	6	84985	HVT-043-60750-R.030
	3/4	.030	4	6-1/2	6	87259	HVT-053-60750-R.030
	3/4	.060	1-1/4	4	6	87260	HVT-016-60750-R.060
	3/4	.060	1-5/8	4	6	82089	HVT-021-60750-R.060
	3/4	.060	2-1/4	5	6	82090	HVT-030-60750-R.060
	3/4	.060	2-3/4	5	6	83939	HVT-036-60750-R.060
	3/4	.060	3-1/4	6	6	87261	HVT-043-60750-R.060
	3/4	.090	1-1/4	4	6	87262	HVT-016-60750-R.090
	3/4	.090	1-5/8	4	6	82091	HVT-021-60750-R.090
	3/4	.090	2-1/4	5	6	82092	HVT-030-60750-R.090
	3/4	.090	2-3/4	5	6	87263	HVT-036-60750-R.090
	3/4	.090	3-1/4	6	6	87264	HVT-043-60750-R.090
	3/4	.120	1-1/4	4	6	87265	HVT-016-60750-R.120
	3/4	.120	1-5/8	4	6	82093	HVT-021-60750-R.120
	3/4	.120	2-1/4	5	6	82094	HVT-030-60750-R.120
	3/4	.120	2-3/4	5	6	83940	HVT-036-60750-R.120
	3/4	.120	3-1/4	6	6	87266	HVT-043-60750-R.120
1	1	.030	2	4-1/2	6	82095	HVT-020-61900-R.030
	1	.030	2-5/8	5	6	82096	HVT-026-61900-R.030
	1	.060	2	4-1/2	6	82097	HVT-020-61900-R.060
	1	.060	2-5/8	5	6	82098	HVT-026-61900-R.060
	1	.120	2	4-1/2	6	82099	HVT-020-61900-R.120
	1	.120	2-5/8	5	6	82100	HVT-026-61900-R.120

* .0005 max TIR

6 FLUTE - CORNER RADIUS

Coolant Through - Variable Pitch - For High Efficiency Milling


HVTIC-6

- Specially engineered for optimal performance in High Efficiency Milling (HEM) of Titanium 6Al4V and other titanium alloys
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Not for use in traditional slotting and roughing toolpaths
- Radial coolant holes for reduced heat, enhanced chip evacuation, and increased material removal rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Extensive testing has proven HVTI-6's excellence in extending tool life for HEM operations in Titanium

Cutter Diameter* D1 $\begin{smallmatrix} +.002'' \\ -.002'' \end{smallmatrix}$	Shank Diameter D2 (H6)	Corner Radius R $\begin{smallmatrix} +.005'' \\ -.005'' \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.025'' \\ -.000'' \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002'' \\ -.002'' \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/4	1/4	.001	1/2	2-1/2	6	84504	HVTIC-020-60250-R.001
	1/4	.030	3/4	2-1/2	6	84505	HVTIC-030-60250-R.030
3/8	3/8	.010	1/2	2	6	84506	HVTIC-013-60375-R.010
	3/8	.010	1	3	6	84507	HVTIC-026-60375-R.010
	3/8	.030	1/2	2	6	84508	HVTIC-013-60375-R.030
	3/8	.030	1	3	6	84509	HVTIC-026-60375-R.030
	3/8	.060	1	3	6	84510	HVTIC-020-60500-R.060
1/2	1/2	.030	1	3	6	84511	HVTIC-020-60500-R.030
	1/2	.030	1-1/4	3	6	84512	HVTIC-032-60500-R.030
	1/2	.030	1-5/8	4	6	84513	HVTIC-032-60500-R.030
	1/2	.060	1	3	6	84514	HVTIC-020-60500-R.060
	1/2	.060	1-1/4	3	6	84515	HVTIC-020-60500-R.060
	1/2	.060	1-5/8	4	6	84516	HVTIC-032-60500-R.060
3/4	3/4	.030	1-5/8	4	6	84517	HVTIC-030-60750-R.030
	3/4	.030	2-1/4	5	6	84518	HVTIC-030-60750-R.030
	3/4	.060	1-3/8	4	6	84519	HVTIC-021-60750-R.060
	3/4	.060	2-1/4	5	6	84520	HVTIC-030-60750-R.060

* .0005 max TIR



Speeds & Feeds on Page 283

HVTI-6



SPEEDS & FEEDS

6 Flute - For High Efficiency Milling

HVTI-6 / HVTIC-6

Material Grade		Hardness		1/8		3/16		1/4		3/8		1/2		3/4		1	
				HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0019	.0014	.0029	.0017	.0038	.0020	.0058	.0025	.0079	.0027	.0118	.0032	.0158	.0038
		75 - 98 HRB	250	.0016	.0012	.0024	.0015	.0032	.0018	.0049	.0021	.0066	.0025	.0089	.0029	.0134	.0036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, Rene 41, Inconel 718, Incoloy 25	75 - 98 HRE	80	.0010	.0010	.0014	.0012	.0019	.0014	.0029	.0016	.0041	.0016	.0068	.0020	.0081	.0028
		21 - 36 HRC	75	.0010	.0010	.0014	.0012	.0019	.0014	.0028	.0016	.0039	.0016	.0068	.0022	.0077	.0027
		36 - 50 HRC	70	.0008	.0008	.0012	.0011	.0016	.0013	.0024	.0015	.0034	.0017	.0049	.0021	.0066	.0025
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 5, Ti Grade 12	< 75 HRB	300	.0026	.0015	.0039	.0019	.0062	.0023	.0079	.0027	.0110	.0032	.0164	.0038	.0225	.0045
		75 - 98 HRE	275	.0022	.0013	.0033	.0017	.0044	.0021	.0066	.0025	.0081	.0029	.0137	.0034	.0183	.0042
		21 - 36 HRC	250	.0017	.0015	.0028	.0017	.0035	.0019	.0050	.0021	.0069	.0025	.0102	.0030	.0137	.0036
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	190	.0014	.0010	.0020	.0010	.0027	.0016	.0041	.0019	.0054	.0022	.0081	.0026	.0108	.0032
		36 - 50 HRC	160	.0012	.0012	.0019	.0014	.0024	.0016	.0038	.0016	.0040	.0021	.0074	.0025	.0099	.0030
COBALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRE	210	.0011	.0011	.0017	.0013	.0022	.0015	.0034	.0017	.0046	.0020	.0069	.0024	.0092	.0029
		21 - 36 HRC	170	.0011	.0011	.0016	.0013	.0021	.0015	.0032	.0017	.0044	.0020	.0067	.0024	.0088	.0029
		36 - 50 HRC	85	.0007	.0008	.0011	.0010	.0014	.0012	.0023	.0014	.0030	.0016	.0045	.0015	.0060	.0024

MILLING PROCESS	HEM	FIN
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Fin (Finishing)	Up to Max LOC	4% - 6% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

High Efficiency Milling for Titanium Made Easy with Helical's HVTI Cutter

In The Loupe

Titanium is a notoriously difficult material to machine, especially in aggressive toolpaths, such as those associated with High Efficiency Milling (HEM). Helical's HVTI-6 tool, is optimized for Titanium 6Al4V and other titanium alloys, and is engineered to achieve exceptional performance in HEM operations. Learn more about this unique tool by reading our "In the Loupe" blog post *High Efficiency Milling for Titanium Made Easy With Helical's HVTI Cutter*.

www.harveyprecision.com/in-the-loupe/hem-titanium-helical-hvti/



SCAN TO READ

6 FLUTE - BALL

New Items!



HEV-6

Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys.
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm .0007$ $\pm .002$	Shank Diameter D2 (H8)	Length of Cut L2 $\pm .002$ $\pm .007$	Overall Length L1 $\pm .002$ $\pm .007$	Flutes	Aplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	6	84406	HEV-S-60125-BN
	1/8	3/8	2	6	84407	HEV-SR-60125-BN
	1/8	1/2	2-1/2	6	84408	HEV-R-60125-BN
	1/8	5/8	2-1/2	6	84409	HEV-A-60125-BN
	1/8	3/4	2-1/2	6	88353	HEV-M-60125-BN new
3/16	3/16	5/16	2	6	84410	HEV-S-60187-BN
	3/16	7/16	2	6	84411	HEV-SR-60187-BN
	3/16	9/16	2-1/2	6	84412	HEV-R-60187-BN
	3/16	3/4	2-1/2	6	84413	HEV-M-60187-BN
	3/16	1	3	6	88354	HEV-ML-60187-BN new
1/4	1/4	3/8	2	6	59434	HEV-S-60250-BN
	1/4	1/2	2-1/2	6	59435	HEV-SR-60250-BN
	1/4	3/4	2-1/2	6	59436	HEV-R-60250-BN
	1/4	1	3	6	59437	HEV-M-60250-BN
	1/4	1-1/4	3	6	59438	HEV-L-60250-BN
	1/4	1-1/2	3	6	83361	HEV-LX-60250-BN
5/16	5/16	7/16	2	6	59439	HEV-S-60312-BN
	5/16	3/4	2-1/2	6	59440	HEV-R-60312-BN
	5/16	1	3	6	59441	HEV-M-60312-BN
	5/16	1-1/4	3	6	88355	HEV-ML-60312-BN new
3/8	3/8	1/2	2	6	59442	HEV-S-60375-BN
	3/8	3/4	2-1/2	6	82382	HEV-SR-60375-BN
	3/8	1	3	6	59443	HEV-R-60375-BN
	3/8	1-1/4	3	6	59444	HEV-M-60375-BN
	3/8	1-1/2	3-1/2	6	59445	HEV-L-60375-BN
	3/8	2	4	6	83362	HEV-LX-60375-BN
	3/8	2-1/2	5	6	88356	HEV-X-60375-BN new

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 157

HEV-6



New Items!

6 FLUTE - BALL

Variable Pitch

continued from previous page

new

new

new

Cutter Diameter* $D_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Shank Diameter $D_2 \text{ (H8)}$	Length of Cut $L_2 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Overall Length $L_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/2	1/2	5/8	2-1/2	6	59446	HEV-S-60500-BN
	1/2	1	3	6	59447	HEV-SR-60500-BN
	1/2	1-1/4	3	6	59448	HEV-R-60500-BN
	1/2	1-5/8	4	6	59449	HEV-M-60500-BN
	1/2	2	4	6	59450	HEV-L-60500-BN
	1/2	2-1/2	5	6	82593	HEV-LX-60500-BN
5/8	5/8	3-1/8	6	6	88357	HEV-X-60500-BN
	5/8	3/4	3	6	59451	HEV-S-60625-BN
	5/8	1-1/4	3-1/2	6	59452	HEV-SR-60625-BN
3/4	3/4	1-5/8	3-1/2	6	59453	HEV-R-60625-BN
	3/4	1	3	6	59454	HEV-S-60750-BN
	3/4	1-5/8	4	6	59455	HEV-R-60750-BN
	3/4	2-1/4	5	6	59456	HEV-M-60750-BN
	3/4	2-3/4	5	6	81303	HEV-L-60750-BN
1	3/4	2-1/4	6	6	88358	HEV-LX-60750-BN
	1	2	4-1/2	6	59457	HEV-R-61000-BN
	1	2-5/8	5	6	82594	HEV-M-61000-BN
1	1	2-1/4	6	6	88359	HEV-L-61000-BN

* .0005 max TIR

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\begin{smallmatrix} +.001 \\ -.002 \end{smallmatrix}$	Shank Diameter D2 (h6)	Corner Radius R $\begin{smallmatrix} +.002 \\ -.001 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.002 \\ -.001 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.002 \\ -.001 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	6	84391	HEV-S-60125-R.010
	1/8	.010	3/8	2	6	84391	HEV-SR-60125-R.010
	1/8	.010	1/2	2-1/2	6	84392	HEV-R-60125-R.010
	1/8	.010	5/8	2-1/2	6	84393	HEV-A-60125-R.010
	1/8	.030	1/4	1-1/2	6	84394	HEV-S-60125-R.030
	1/8	.030	3/8	2	6	84395	HEV-SR-60125-R.030
	1/8	.030	1/2	2-1/2	6	84396	HEV-R-60125-R.030
	1/8	.030	5/8	2-1/2	6	84397	HEV-A-60125-R.030
3/16	3/16	.010	5/16	2	6	84398	HEV-S-60187-R.010
	3/16	.010	7/16	2	6	84399	HEV-SR-60187-R.010
	3/16	.010	9/16	2-1/2	6	84400	HEV-R-60187-R.010
	3/16	.010	3/4	2-1/2	6	84401	HEV-M-60187-R.010
	3/16	.030	5/16	2	6	84402	HEV-S-60187-R.030
	3/16	.030	7/16	2	6	84403	HEV-SR-60187-R.030
	3/16	.030	9/16	2-1/2	6	84404	HEV-R-60187-R.030
	3/16	.030	3/4	2-1/2	6	84405	HEV-M-60187-R.030
1/4	1/4	.010	3/8	2	6	84905	HEV-S-60250-R.010
	1/4	.010	1/2	2-1/2	6	84906	HEV-SR-60250-R.010
	1/4	.010	3/4	2-1/2	6	84907	HEV-R-60250-R.010
	1/4	.010	1	3	6	87550	HEV-M-60250-R.010
	1/4	.010	1-1/4	3	6	87551	HEV-L-60250-R.010
	1/4	.010	1-1/2	3	6	87552	HEV-LX-60250-R.010
	1/4	.030	3/8	2	6	89280	HEV-S-60250-R.030
	1/4	.030	1/2	2-1/2	6	89281	HEV-SR-60250-R.030
	1/4	.030	3/4	2-1/2	6	89286	HEV-R-60250-R.030
	1/4	.030	1	3	6	89289	HEV-M-60250-R.030
	1/4	.030	1-1/4	3	6	89292	HEV-L-60250-R.030
	1/4	.030	1-1/2	3	6	82569	HEV-LX-60250-R.030
	1/4	.030	3/8	2	6	89281	HEV-S-60250-R.030
	1/4	.030	1/2	2-1/2	6	89284	HEV-SR-60250-R.030
	1/4	.030	3/4	2-1/2	6	89287	HEV-R-60250-R.030
	1/4	.030	1	3	6	89290	HEV-M-60250-R.030
	1/4	.030	1-1/4	3	6	89293	HEV-L-60250-R.030
	1/4	.030	1-1/2	3	6	87553	HEV-LX-60250-R.030

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 157

HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\pm .0007$ -.002	Shank Diameter D2 #6	Corner Radius R $\pm .0007$ -.002	Length of Cut L2 $\pm .0007$ -.002	Overall Length L1 $\pm .0007$ -.002	Flutes	Aplus Coated	Tool Description
1/4	1/4	.060	3/8	2	6	59292	HEV-S-60250-R.060
	1/4	.060	1/2	2-1/2	6	59295	HEV-SR-60250-R.060
	1/4	.060	3/4	2-1/2	6	59298	HEV-R-60250-R.060
	1/4	.060	1	3	6	59291	HEV-M-60250-R.060
	1/4	.060	1-1/4	3	6	59294	HEV-L-60250-R.060
	1/4	.060	1-1/2	3	6	02570	HEV-LX-60250-R.060
5/16	5/16	.010	7/16	2	6	87554	HEV-S-60312-R.010
	5/16	.010	3/4	2-1/2	6	87555	HEV-SR-60312-R.010
	5/16	.010	1	3	6	87556	HEV-R-60312-R.010
	5/16	.020	7/16	2	6	59295	HEV-S-60312-R.020
	5/16	.020	3/4	2-1/2	6	59298	HEV-SR-60312-R.020
	5/16	.020	1	3	6	59301	HEV-R-60312-R.020
	5/16	.020	1-1/4	3	6	88371	HEV-M-60312-R.020
	5/16	.030	7/16	2	6	59296	HEV-S-60312-R.030
	5/16	.030	3/4	2-1/2	6	59299	HEV-SR-60312-R.030
	5/16	.030	1	3	6	59302	HEV-R-60312-R.030
	5/16	.030	1-1/4	3	6	88372	HEV-M-60312-R.030
	5/16	.060	7/16	2	6	59297	HEV-S-60312-R.060
	5/16	.060	3/4	2-1/2	6	59300	HEV-SR-60312-R.060
	5/16	.060	1	3	6	59303	HEV-R-60312-R.060
	5/16	.060	1-1/4	3	6	88373	HEV-M-60312-R.060
3/8	3/8	.010	1/2	2	6	84998	HEV-S-60375-R.010
	3/8	.010	3/4	2-1/2	6	84999	HEV-SR-60375-R.010
	3/8	.010	1	3	6	86000	HEV-R-60375-R.010
	3/8	.010	1-1/4	3	6	86001	HEV-M-60375-R.010
	3/8	.010	1-1/2	3-1/2	6	87557	HEV-L-60375-R.010
	3/8	.010	2	4	6	87558	HEV-LX-60375-R.010
	3/8	.015	1/2	2	6	88374	HEV-S-60375-R.015
	3/8	.015	3/4	2-1/2	6	88375	HEV-SR-60375-R.015
	3/8	.015	1	3	6	88376	HEV-R-60375-R.015
	3/8	.015	1-1/4	3	6	88377	HEV-M-60375-R.015
	3/8	.020	1/2	2	6	59304	HEV-S-60375-R.020
	3/8	.020	3/4	2-1/2	6	02571	HEV-SR-60375-R.020
	3/8	.020	1	3	6	59308	HEV-R-60375-R.020
	3/8	.020	1-1/4	3	6	59312	HEV-M-60375-R.020
	3/8	.020	1-1/2	3-1/2	6	59316	HEV-L-60375-R.020
	3/8	.020	2	4	6	83318	HEV-LX-60375-R.020
	3/8	.030	1/2	2	6	59305	HEV-S-60375-R.030
	3/8	.030	3/4	2-1/2	6	02572	HEV-SR-60375-R.030
	3/8	.030	1	3	6	59309	HEV-R-60375-R.030
	3/8	.030	1-1/4	3	6	59313	HEV-M-60375-R.030
	3/8	.030	1-1/2	3-1/2	6	59317	HEV-L-60375-R.030
	3/8	.030	2	4	6	02573	HEV-LX-60375-R.030

*.0005 max TIR

continued on next page

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* $D_1 \pm \frac{.001}{.002}$	Shank Diameter $D_2 \pm .001$	Corner Radius $R \pm \frac{.002}{.002}$	Length of Cut $L_2 \pm \frac{.002}{.002}$	Overall Length $L_1 \pm \frac{.002}{.002}$	Flutes	Aplic Coated	Tool Description
3/8	3/8	.060	1/2	2	6	59306	HEV-S-60375-R.060
	3/8	.060	3/4	2-1/2	6	82574	HEV-SR-60375-R.060
	3/8	.060	1	3	6	59310	HEV-R-60375-R.060
	3/8	.060	1-1/4	3	6	59314	HEV-M-60375-R.060
	3/8	.060	1-1/2	3-1/2	6	59318	HEV-L-60375-R.060
	3/8	.060	2	4	6	82575	HEV-LX-60375-R.060
	3/8	.090	1/2	2	6	59307	HEV-S-60375-R.090
	3/8	.090	3/4	2-1/2	6	82576	HEV-SR-60375-R.090
	3/8	.090	1	3	6	59311	HEV-R-60375-R.090
	3/8	.090	1-1/4	3	6	59315	HEV-M-60375-R.090
	3/8	.090	1-1/2	3-1/2	6	59319	HEV-L-60375-R.090
	3/8	.090	2	4	6	82577	HEV-LX-60375-R.090
	3/8	.125	1/2	2	6	87559	HEV-S-60375-R.125
	3/8	.125	3/4	2-1/2	6	87560	HEV-SR-60375-R.125
	3/8	.125	1	3	6	87561	HEV-R-60375-R.125
	3/8	.125	1-1/4	3	6	87562	HEV-M-60375-R.125
1/2	1/2	.010	5/8	2-1/2	6	83319	HEV-S-60500-R.010
	1/2	.010	1	3	6	82578	HEV-SR-60500-R.010
	1/2	.010	1-1/4	3	6	82579	HEV-R-60500-R.010
	1/2	.010	1-5/8	4	6	86002	HEV-M-60500-R.010
	1/2	.010	2	4	6	87563	HEV-L-60500-R.010
	1/2	.010	2-1/2	5	6	87564	HEV-LX-60500-R.010
	1/2	.015	5/8	2-1/2	6	83320	HEV-S-60500-R.015
	1/2	.015	1	3	6	82580	HEV-SR-60500-R.015
	1/2	.015	1-1/4	3	6	82581	HEV-R-60500-R.015
	1/2	.015	1-5/8	4	6	86003	HEV-M-60500-R.015
	1/2	.015	2	4	6	87565	HEV-L-60500-R.015
	1/2	.015	2-1/2	5	6	87566	HEV-LX-60500-R.015
	1/2	.020	5/8	2-1/2	6	87567	HEV-S-60500-R.020
	1/2	.020	1	3	6	82582	HEV-SR-60500-R.020
	1/2	.020	1-1/4	3	6	82583	HEV-R-60500-R.020
	1/2	.020	1-5/8	4	6	88378	HEV-M-60500-R.020
	1/2	.020	2	4	6	87568	HEV-L-60500-R.020
	1/2	.020	2-1/2	5	6	87569	HEV-LX-60500-R.020
	1/2	.030	5/8	2-1/2	6	59320	HEV-S-60500-R.030
	1/2	.030	1	3	6	59324	HEV-SR-60500-R.030
	1/2	.030	1-1/4	3	6	59328	HEV-R-60500-R.030
	1/2	.030	1-5/8	4	6	59332	HEV-M-60500-R.030
	1/2	.030	2	4	6	59336	HEV-L-60500-R.030
	1/2	.030	2-1/2	5	6	82584	HEV-LX-60500-R.030
	1/2	.030	3-1/8	6	6	86004	HEV-X-60500-R.030
	1/2	.060	5/8	2-1/2	6	59321	HEV-S-60500-R.060
	1/2	.060	1	3	6	59325	HEV-SR-60500-R.060
	1/2	.060	1-1/4	3	6	59329	HEV-R-60500-R.060
	1/2	.060	1-5/8	4	6	59333	HEV-M-60500-R.060
	1/2	.060	2	4	6	59337	HEV-L-60500-R.060
	1/2	.060	2-1/2	5	6	82585	HEV-LX-60500-R.060

*.0005 max TIR

continued on next page

HEV-6



New Items!

6 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D ₁ $\pm \frac{.001}{.002}$	Shank Diameter D ₂ (in)	Corner Radius R $\pm \frac{.002}{.003}$	Length of Cut L ₂ $\pm \frac{.002}{.003}$	Overall Length L ₁ $\pm \frac{.002}{.003}$	Flutes	Aptar Coated	Tool Description
1/2	1/2	.090	5/8	2-1/2	6	59322	HEV-S-60500-R.090
	1/2	.090	1	3	6	59326	HEV-SR-60500-R.090
	1/2	.090	1-1/4	3	6	59330	HEV-R-60500-R.090
	1/2	.090	1-5/8	4	6	59334	HEV-M-60500-R.090
	1/2	.090	2	4	6	59338	HEV-L-60500-R.090
	1/2	.090	2-1/2	5	6	82586	HEV-LX-60500-R.090
	1/2	.120	5/8	2-1/2	6	87570	HEV-S-60500-R.120
	1/2	.120	1	3	6	87571	HEV-SR-60500-R.120
	1/2	.120	1-1/4	3	6	87572	HEV-R-60500-R.120
	1/2	.120	1-5/8	4	6	87573	HEV-M-60500-R.120
	1/2	.125	5/8	2-1/2	6	59323	HEV-S-60500-R.125
	1/2	.125	1	3	6	59327	HEV-SR-60500-R.125
	1/2	.125	1-1/4	3	6	59331	HEV-R-60500-R.125
	1/2	.125	1-5/8	4	6	59335	HEV-M-60500-R.125
	1/2	.125	2	4	6	59339	HEV-L-60500-R.125
	1/2	.125	2-1/2	5	6	83321	HEV-LX-60500-R.125
5/8	5/8	.030	3/4	3	6	59340	HEV-S-60625-R.030
	5/8	.030	1-1/4	3-1/2	6	59341	HEV-SR-60625-R.030
	5/8	.030	1-5/8	3-1/2	6	59345	HEV-R-60625-R.030
	5/8	.030	2	4	6	59349	HEV-M-60625-R.030
	5/8	.030	2-1/2	5	6	59353	HEV-L-60625-R.030
	5/8	.030	3-1/4	6	6	88379	HEV-LX-60625-R.030
	5/8	.060	3/4	3	6	87574	HEV-S-60625-R.060
	5/8	.060	1-1/4	3-1/2	6	59342	HEV-SR-60625-R.060
	5/8	.060	1-5/8	3-1/2	6	59346	HEV-R-60625-R.060
	5/8	.060	2	4	6	59350	HEV-M-60625-R.060
	5/8	.060	2-1/2	5	6	87575	HEV-L-60625-R.060
	5/8	.090	1-1/4	3-1/2	6	59343	HEV-SR-60625-R.090
	5/8	.090	1-5/8	3-1/2	6	59347	HEV-R-60625-R.090
	5/8	.090	2	4	6	59351	HEV-M-60625-R.090
	5/8	.125	3/4	3	6	87576	HEV-S-60625-R.125
	5/8	.125	1-1/4	3-1/2	6	59344	HEV-SR-60625-R.125
	5/8	.125	1-5/8	3-1/2	6	59348	HEV-R-60625-R.125
	5/8	.125	2	4	6	59352	HEV-M-60625-R.125
	5/8	.125	2-1/2	5	6	86085	HEV-L-60625-R.125
3/4	3/4	.010	1	3	6	88380	HEV-S-60750-R.010
	3/4	.010	1-5/8	4	6	88381	HEV-R-60750-R.010
	3/4	.010	2-1/4	5	6	88382	HEV-M-60750-R.010
	3/4	.010	2-3/4	5	6	88383	HEV-L-60750-R.010
	3/4	.010	3-1/4	6	6	88384	HEV-LX-60750-R.010
	3/4	.030	1	3	6	59354	HEV-S-60750-R.030
	3/4	.030	1-5/8	4	6	59360	HEV-R-60750-R.030
	3/4	.030	2-1/4	5	6	59366	HEV-M-60750-R.030
	3/4	.030	2-3/4	5	6	59372	HEV-L-60750-R.030
	3/4	.030	3-1/4	6	6	59378	HEV-LX-60750-R.030
	3/4	.060	4	6-1/2	6	86086	HEV-X-60750-R.060
	3/4	.060	1	3	6	59355	HEV-S-60750-R.060
	3/4	.060	1-5/8	4	6	59361	HEV-R-60750-R.060
	3/4	.060	2-1/4	5	6	59367	HEV-M-60750-R.060
	3/4	.060	2-3/4	5	6	59373	HEV-L-60750-R.060
	3/4	.060	3-1/4	6	6	83322	HEV-LX-60750-R.060

*.0005 max TIR

continued on next page

6 FLUTE - CORNER RADIUS

New Items!



HEV-6

Variable Pitch (cont.)

continued from previous page

Cutter Diameter* D1 $\frac{+0.007}{-0.002}$ "	Shank Diameter D2 (H9)	Corner Radius R $\frac{+0.007}{-0.002}$ "	Length of Cut L2 $\frac{+0.007}{-0.007}$ "	Overall Length L1 $\frac{+0.007}{-0.002}$ "	Flutes	Applus Coated	Tool Description
3/4	3/4	.090	1	.3	6	59356	HEV-S-60750-R.090
	3/4	.090	1-5/8	.4	6	59362	HEV-R-60750-R.090
	3/4	.090	2-1/4	.5	6	59368	HEV-M-60750-R.090
	3/4	.090	2-3/4	.5	6	59374	HEV-L-60750-R.090
	3/4	.120	1	.3	6	87577	HEV-S-60750-R.120
	3/4	.120	1-5/8	.4	6	87578	HEV-R-60750-R.120
	3/4	.120	2-1/4	.5	6	87579	HEV-M-60750-R.120
	3/4	.125	1	.3	6	59357	HEV-S-60750-R.125
	3/4	.125	1-5/8	.4	6	59363	HEV-R-60750-R.125
	3/4	.125	2-1/4	.5	6	59369	HEV-M-60750-R.125
	3/4	.125	2-3/4	.5	6	59375	HEV-L-60750-R.125
	3/4	.125	3-1/4	.6	6	85385	HEV-LX-60750-R.125
	3/4	.190	1	.3	6	59358	HEV-S-60750-R.190
	3/4	.190	1-5/8	.4	6	59364	HEV-R-60750-R.190
	3/4	.190	2-1/4	.5	6	59370	HEV-M-60750-R.190
	3/4	.190	2-3/4	.5	6	59376	HEV-L-60750-R.190
	3/4	.250	1	.3	6	59359	HEV-S-60750-R.250
	3/4	.250	1-5/8	.4	6	59365	HEV-R-60750-R.250
	3/4	.250	2-1/4	.5	6	59371	HEV-M-60750-R.250
	3/4	.250	2-3/4	.5	6	59377	HEV-L-60750-R.250
	3/4	.250	3-1/4	.6	6	83323	HEV-LX-60750-R.250
1	1	.030	2	4-1/2	6	59379	HEV-R-61000-R.030
	1	.030	2-5/8	.5	6	59383	HEV-M-61000-R.030
	1	.030	3-1/4	.6	6	59387	HEV-L-61000-R.030
	1	.060	2	4-1/2	6	59389	HEV-R-61000-R.060
	1	.060	2-5/8	.5	6	59394	HEV-M-61000-R.060
	1	.060	3-1/4	.6	6	59388	HEV-L-61000-R.060
	1	.125	2	4-1/2	6	59381	HEV-R-61000-R.125
	1	.125	2-5/8	.5	6	59385	HEV-M-61000-R.125
	1	.125	3-1/4	.6	6	59388	HEV-L-61000-R.125
	1	.250	2	4-1/2	6	59382	HEV-R-61000-R.250
	1	.250	2-5/8	.5	6	59386	HEV-M-61000-R.250
	1	.250	3-1/4	.6	6	59390	HEV-L-61000-R.250

* .0005 max TIR

new



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MHEV-6
METRIC

6 FLUTE - CORNER RADIUS - METRIC
Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys.
- Engineered for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications
- 6 flute variable pitch design for reduced harmonics and increased feed rates

- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 ± .02 mm - .03 mm	Shank Diameter D2 H9	Corner Radius R ± .02 mm - .03 mm	Length of Cut L2 ± .02 mm - .03 mm	Overall Length L1 ± 0.0 mm - 0.1 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	.50 mm	9.00 mm	63 mm	6	99575	MHEV-015-60603-R0.50
	6.00 mm	.50 mm	12.00 mm	63 mm	6	99593	MHEV-020-60603-R0.50
	6.00 mm	.50 mm	18.00 mm	63 mm	6	99627	MHEV-030-60603-R0.50
	6.00 mm	1.00 mm	9.00 mm	63 mm	6	99576	MHEV-015-60603-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	6	99594	MHEV-020-60603-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	6	99628	MHEV-030-60603-R1.00
8 mm	8.00 mm	.50 mm	12.00 mm	63 mm	6	99578	MHEV-015-60803-R0.50
	8.00 mm	.50 mm	16.00 mm	63 mm	6	99596	MHEV-020-60803-R0.50
	8.00 mm	.50 mm	24.00 mm	75 mm	6	99630	MHEV-030-60803-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	6	99579	MHEV-015-60803-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	6	99597	MHEV-020-60803-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	6	99631	MHEV-030-60803-R1.00
10 mm	10.00 mm	.50 mm	15.00 mm	63 mm	6	99581	MHEV-015-61003-R0.50
	10.00 mm	.50 mm	20.00 mm	63 mm	6	99599	MHEV-020-61003-R0.50
	10.00 mm	.50 mm	25.00 mm	75 mm	6	99613	MHEV-025-61003-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	6	99582	MHEV-015-61003-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	6	99600	MHEV-020-61003-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	6	99614	MHEV-025-61003-R1.00
12 mm	12.00 mm	.50 mm	18.00 mm	75 mm	6	99584	MHEV-015-61203-R0.50
	12.00 mm	.50 mm	24.00 mm	75 mm	6	99602	MHEV-020-61203-R0.50
	12.00 mm	.50 mm	30.00 mm	75 mm	6	99616	MHEV-025-61203-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	6	99585	MHEV-015-61203-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	6	99603	MHEV-020-61203-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	6	99617	MHEV-025-61203-R1.00
16 mm	16.00 mm	.50 mm	24.00 mm	89 mm	6	99587	MHEV-015-61603-R0.50
	16.00 mm	.50 mm	32.00 mm	89 mm	6	99605	MHEV-020-61603-R0.50
	16.00 mm	.50 mm	40.00 mm	89 mm	6	99619	MHEV-025-61603-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	6	99588	MHEV-015-61603-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	6	99606	MHEV-020-61603-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	6	99620	MHEV-025-61603-R1.00
20 mm	20.00 mm	.50 mm	30.00 mm	89 mm	6	99590	MHEV-015-62003-R0.50
	20.00 mm	.50 mm	40.00 mm	100 mm	6	99608	MHEV-020-62003-R0.50
	20.00 mm	.50 mm	50.00 mm	125 mm	6	99622	MHEV-025-62003-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	6	99591	MHEV-015-62003-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	6	99609	MHEV-020-62003-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	6	99623	MHEV-025-62003-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	6	99611	MHEV-020-62503-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	6	99625	MHEV-025-62503-R1.00

* .013 mm max TIR



Speeds & Feeds on Page 167

7 FLUTE - CORNER RADIUS

Variable Pitch


HEV-7

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* $D1 \pm \frac{0.001}{0.001}$	Shank Diameter $D2 \pm 0.001$	Corner Radius $R \pm \frac{0.001}{0.001}$	Length of Cut $L2 \pm \frac{0.001}{0.001}$	Overall Length $L1 \pm \frac{0.001}{0.001}$	Flutes	Aplus Coated	Tool Description
1/8	1/8	.010	1/4	1-1/2	7	84422	HEV-S-70125-R.010
	1/8	.010	3/8	2	7	84423	HEV-SR-70125-R.010
	1/8	.010	1/2	2-1/2	7	84424	HEV-R-70125-R.010
	1/8	.010	5/8	2-1/2	7	84425	HEV-A-70125-R.010
	1/8	.030	1/4	1-1/2	7	84426	HEV-S-70125-R.030
	1/8	.030	3/8	2	7	84427	HEV-SR-70125-R.030
	1/8	.030	1/2	2-1/2	7	84428	HEV-R-70125-R.030
	1/8	.030	5/8	2-1/2	7	84429	HEV-A-70125-R.030
3/16	3/16	.010	5/16	2	7	84430	HEV-S-70187-R.010
	3/16	.010	7/16	2	7	84431	HEV-SR-70187-R.010
	3/16	.010	9/16	2-1/2	7	84432	HEV-R-70187-R.010
	3/16	.010	3/4	2-1/2	7	84433	HEV-A-70187-R.010
	3/16	.030	5/16	2	7	84434	HEV-S-70187-R.030
	3/16	.030	7/16	2	7	84435	HEV-SR-70187-R.030
	3/16	.030	9/16	2-1/2	7	84436	HEV-R-70187-R.030
	3/16	.030	3/4	2-1/2	7	84437	HEV-A-70187-R.030
1/4	1/4	.010	3/8	2	7	83376	HEV-S-70250-R.010
	1/4	.010	1/2	2	7	83377	HEV-SR-70250-R.010
	1/4	.010	3/4	2-1/2	7	83378	HEV-R-70250-R.010
	1/4	.010	1	3	7	83379	HEV-A-70250-R.010
	1/4	.010	1-1/4	3	7	86040	HEV-L-70250-R.010
	1/4	.020	3/8	2	7	27107	HEV-S-70250-R.020
	1/4	.020	1/2	2	7	27122	HEV-SR-70250-R.020
	1/4	.020	3/4	2-1/2	7	27137	HEV-R-70250-R.020
	1/4	.020	1	3	7	27152	HEV-M-70250-R.020
	1/4	.020	1-1/4	3	7	82655	HEV-L-70250-R.020
	1/4	.020	1-1/2	3	7	86041	HEV-LX-70250-R.020
	1/4	.030	3/8	2	7	87106	HEV-S-70250-R.030
	1/4	.030	1/2	2	7	87107	HEV-SR-70250-R.030
	1/4	.030	3/4	2-1/2	7	87108	HEV-R-70250-R.030
	1/4	.030	1	3	7	87109	HEV-M-70250-R.030
	1/4	.030	1-1/4	3	7	87110	HEV-L-70250-R.030
	1/4	.060	3/8	2	7	81807	HEV-S-70250-R.060
	1/4	.060	1/2	2	7	81808	HEV-SR-70250-R.060
	1/4	.060	3/4	2-1/2	7	81809	HEV-R-70250-R.060
	1/4	.060	1	3	7	81810	HEV-M-70250-R.060
	1/4	.060	1-1/4	3	7	87111	HEV-L-70250-R.060

* .0005 max TIR

continued on next page



Speeds & Feeds on Page 178

HEV-7



7 FLUTE - CORNER RADIUS

Variable Pitch (cont.)

continued from previous page

Cutter Diameter*	Shank Diameter	Corner Radius	Length of Cut	Overall Length	Flutes	Apex Coated	Tool Description
$D_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	$D_2 \text{ (in)}$	$R \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	$L_2 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$	$L_1 \begin{smallmatrix} +.002 \\ -.002 \end{smallmatrix}$			
3/8	3/8	.010	1/2	2	7	83380	HEV-S-70375-R.010
	3/8	.010	3/4	2-1/2	7	83381	HEV-SR-70375-R.010
	3/8	.010	1	2-1/2	7	83382	HEV-R-70375-R.010
	3/8	.010	1-1/4	3	7	88042	HEV-M-70375-R.010
	3/8	.010	1-1/2	3-1/2	7	83383	HEV-L-70375-R.010
	3/8	.020	1/2	2	7	27212	HEV-S-70375-R.020
	3/8	.020	3/4	2-1/2	7	27227	HEV-SR-70375-R.020
	3/8	.020	1	2-1/2	7	27242	HEV-R-70375-R.020
	3/8	.020	1-1/4	3	7	87112	HEV-M-70375-R.020
	3/8	.020	1-1/2	3-1/2	7	27247	HEV-L-70375-R.020
	3/8	.020	2	4	7	82656	HEV-LX-70375-R.020
	3/8	.030	1/2	2	7	87113	HEV-S-70375-R.030
	3/8	.030	3/4	2-1/2	7	87114	HEV-SR-70375-R.030
	3/8	.030	1	2-1/2	7	87115	HEV-R-70375-R.030
	3/8	.030	1-1/4	3	7	87116	HEV-M-70375-R.030
	3/8	.030	1-1/2	3-1/2	7	87117	HEV-L-70375-R.030
	3/8	.060	1/2	2	7	81811	HEV-S-70375-R.060
	3/8	.060	3/4	2-1/2	7	81812	HEV-SR-70375-R.060
	3/8	.060	1	2-1/2	7	81813	HEV-R-70375-R.060
	3/8	.060	1-1/4	3	7	87118	HEV-M-70375-R.060
	3/8	.060	1-1/2	3-1/2	7	87119	HEV-L-70375-R.060
	3/8	.125	1/2	2	7	87120	HEV-S-70375-R.125
	3/8	.125	3/4	2-1/2	7	87121	HEV-SR-70375-R.125
	3/8	.125	1	2-1/2	7	87122	HEV-R-70375-R.125
	3/8	.125	1-1/4	3	7	87123	HEV-M-70375-R.125
	3/8	.125	1-1/2	3-1/2	7	87124	HEV-L-70375-R.125
1/2	1/2	.010	5/8	2-1/2	7	83384	HEV-S-70500-R.010
	1/2	.010	1	3	7	83385	HEV-SR-70500-R.010
	1/2	.010	1-1/4	3	7	83386	HEV-R-70500-R.010
	1/2	.010	1-5/8	4	7	83387	HEV-M-70500-R.010
	1/2	.010	2	4	7	83388	HEV-L-70500-R.010
	1/2	.010	2-1/2	5	7	87125	HEV-LX-70500-R.010
	1/2	.020	5/8	2-1/2	7	81814	HEV-S-70500-R.020
	1/2	.020	1	3	7	81815	HEV-SR-70500-R.020
	1/2	.020	1-1/4	3	7	81816	HEV-R-70500-R.020
	1/2	.020	1-5/8	4	7	81817	HEV-M-70500-R.020
	1/2	.020	2	4	7	81818	HEV-L-70500-R.020
	1/2	.020	2-1/2	5	7	87126	HEV-LX-70500-R.020
	1/2	.030	5/8	2-1/2	7	27257	HEV-S-70500-R.030
	1/2	.030	1	3	7	27272	HEV-SR-70500-R.030
	1/2	.030	1-1/4	3	7	27287	HEV-R-70500-R.030
	1/2	.030	1-5/8	4	7	27302	HEV-M-70500-R.030
	1/2	.030	2	4	7	27307	HEV-L-70500-R.030
	1/2	.030	2-1/2	5	7	82657	HEV-LX-70500-R.030
	1/2	.030	3-1/8	6	7	82658	HEV-X-70500-R.030
	1/2	.060	5/8	2-1/2	7	81819	HEV-S-70500-R.060
	1/2	.060	1	3	7	81820	HEV-SR-70500-R.060
	1/2	.060	1-1/4	3	7	81821	HEV-R-70500-R.060
	1/2	.060	1-5/8	4	7	81822	HEV-M-70500-R.060
	1/2	.060	2	4	7	81823	HEV-L-70500-R.060
	1/2	.060	2-1/2	5	7	87127	HEV-LX-70500-R.060

* .0005 max TIR

continued on next page

7 FLUTE - CORNER RADIUS

Variable Pitch (cont.)



HEV-7

continued from previous page

Cutter Diameter* D ₁ $\frac{+0.01}{-0.02}$	Shank Diameter D ₂ (#6)	Corner Radius R $\frac{+0.02}{-0.01}$	Length of Cut L ₂ $\frac{+0.02}{-0.01}$	Overall Length L ₁ $\frac{+0.02}{-0.02}$	Flutes	Apex Coated	Tool Description
1/2	1/2	.125	5/8	2-1/2	7	87128	HEV-S-70500-R.125
	1/2	.125	1	3	7	87129	HEV-SR-70500-R.125
	1/2	.125	1-1/4	3	7	87130	HEV-R-70500-R.125
	1/2	.125	1-5/8	4	7	87131	HEV-M-70500-R.125
	1/2	.125	2	4	7	87132	HEV-L-70500-R.125
5/8	5/8	.010	3/4	3	7	87133	HEV-S-70625-R.010
	5/8	.010	1-1/4	3-1/2	7	87134	HEV-SR-70625-R.010
	5/8	.010	1-5/8	4	7	87135	HEV-R-70625-R.010
	5/8	.010	2-1/8	4	7	87136	HEV-M-70625-R.010
	5/8	.030	3/4	3	7	27317	HEV-S-70625-R.030
	5/8	.030	1-1/4	3-1/2	7	27322	HEV-SR-70625-R.030
	5/8	.030	1-5/8	4	7	27332	HEV-R-70625-R.030
	5/8	.030	2-1/8	4	7	27347	HEV-M-70625-R.030
	5/8	.030	2-1/2	5	7	82659	HEV-L-70625-R.030
	5/8	.060	3/4	3	7	88043	HEV-S-70625-R.060
	5/8	.060	1-1/4	3-1/2	7	81824	HEV-SR-70625-R.060
	5/8	.060	1-5/8	4	7	81825	HEV-R-70625-R.060
	5/8	.060	2-1/8	4	7	88044	HEV-M-70625-R.060
3/4	3/4	.030	1	3	7	27362	HEV-S-70750-R.030
	3/4	.030	1-1/4	3-1/2	7	27367	HEV-SR-70750-R.030
	3/4	.030	1-5/8	4	7	27377	HEV-R-70750-R.030
	3/4	.030	2-1/8	5	7	27382	HEV-M-70750-R.030
	3/4	.030	2-3/4	5	7	82660	HEV-L-70750-R.030
	3/4	.030	3-1/4	6	7	82661	HEV-LX-70750-R.030
	3/4	.060	1	3	7	81826	HEV-S-70750-R.060
	3/4	.060	1-5/8	4	7	81827	HEV-R-70750-R.060
	3/4	.060	2-1/4	5	7	81828	HEV-M-70750-R.060
	3/4	.060	2-3/4	5	7	88045	HEV-L-70750-R.060
	3/4	.060	3-1/4	6	7	87137	HEV-LX-70750-R.060
	3/4	.125	1	3	7	87138	HEV-S-70750-R.125
	3/4	.125	1-5/8	4	7	87139	HEV-R-70750-R.125
	3/4	.125	2-1/4	5	7	87140	HEV-M-70750-R.125
	3/4	.250	1	3	7	87141	HEV-S-70750-R.250
	3/4	.250	1-5/8	4	7	87142	HEV-R-70750-R.250
	3/4	.250	2-1/4	5	7	87143	HEV-M-70750-R.250
1	1	.030	1-1/4	4	7	27407	HEV-S-71000-R.030
	1	.030	2	5	7	27422	HEV-R-71000-R.030
	1	.030	2-5/8	5	7	88046	HEV-M-71000-R.030
	1	.030	3-1/4	6	7	27442	HEV-L-71000-R.030
	1	.030	4-1/4	7	7	88047	HEV-X-71000-R.030

* .0005 max TIR

MHEV-7
METRIC

7 FLUTE - CORNER RADIUS - METRIC
Variable Pitch

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys
- Engineered for excellent performance in High Efficiency Milling (HEM)
- 7 flute variable pitch design for reduced harmonics and increased feed rates
- End cutting geometry (non-center cutting)
- h8 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 ± 0.01 mm	Shank Diameter D2 (h8)	Corner Radius R ± 0.01 mm	Length of Cut L2 ± 0.01 mm	Overall Length L1 ± 0.01 mm	Flutes	Aplus Coated	Tool Description
6 mm	6.00 mm	50 mm	8.00 mm	63 mm	7	59633	MHEV-015-70600-R0.50
	6.00 mm	50 mm	12.00 mm	63 mm	7	59651	MHEV-020-70600-R0.50
	6.00 mm	50 mm	18.00 mm	63 mm	7	59685	MHEV-030-70600-R0.50
	6.00 mm	1.00 mm	8.00 mm	63 mm	7	59634	MHEV-015-70600-R1.00
	6.00 mm	1.00 mm	12.00 mm	63 mm	7	59652	MHEV-020-70600-R1.00
	6.00 mm	1.00 mm	18.00 mm	63 mm	7	59686	MHEV-030-70600-R1.00
8 mm	8.00 mm	50 mm	12.00 mm	63 mm	7	59636	MHEV-015-70800-R0.50
	8.00 mm	50 mm	16.00 mm	63 mm	7	59654	MHEV-020-70800-R0.50
	8.00 mm	50 mm	24.00 mm	75 mm	7	59688	MHEV-030-70800-R0.50
	8.00 mm	1.00 mm	12.00 mm	63 mm	7	59637	MHEV-015-70800-R1.00
	8.00 mm	1.00 mm	16.00 mm	63 mm	7	59655	MHEV-020-70800-R1.00
	8.00 mm	1.00 mm	24.00 mm	75 mm	7	59689	MHEV-030-70800-R1.00
10 mm	10.00 mm	50 mm	15.00 mm	63 mm	7	59639	MHEV-015-71000-R0.50
	10.00 mm	50 mm	20.00 mm	63 mm	7	59657	MHEV-020-71000-R0.50
	10.00 mm	50 mm	25.00 mm	75 mm	7	59671	MHEV-025-71000-R0.50
	10.00 mm	1.00 mm	15.00 mm	63 mm	7	59640	MHEV-015-71000-R1.00
	10.00 mm	1.00 mm	20.00 mm	63 mm	7	59658	MHEV-020-71000-R1.00
	10.00 mm	1.00 mm	25.00 mm	75 mm	7	59672	MHEV-025-71000-R1.00
12 mm	12.00 mm	50 mm	18.00 mm	75 mm	7	59642	MHEV-015-71200-R0.50
	12.00 mm	50 mm	24.00 mm	75 mm	7	59660	MHEV-020-71200-R0.50
	12.00 mm	50 mm	30.00 mm	75 mm	7	59674	MHEV-025-71200-R0.50
	12.00 mm	1.00 mm	18.00 mm	75 mm	7	59643	MHEV-015-71200-R1.00
	12.00 mm	1.00 mm	24.00 mm	75 mm	7	59661	MHEV-020-71200-R1.00
	12.00 mm	1.00 mm	30.00 mm	75 mm	7	59675	MHEV-025-71200-R1.00
16 mm	16.00 mm	50 mm	24.00 mm	89 mm	7	59645	MHEV-015-71600-R0.50
	16.00 mm	50 mm	32.00 mm	89 mm	7	59663	MHEV-020-71600-R0.50
	16.00 mm	50 mm	40.00 mm	89 mm	7	59677	MHEV-025-71600-R0.50
	16.00 mm	1.00 mm	24.00 mm	89 mm	7	59646	MHEV-015-71600-R1.00
	16.00 mm	1.00 mm	32.00 mm	89 mm	7	59664	MHEV-020-71600-R1.00
	16.00 mm	1.00 mm	40.00 mm	89 mm	7	59678	MHEV-025-71600-R1.00
20 mm	20.00 mm	50 mm	30.00 mm	89 mm	7	59648	MHEV-015-72000-R0.50
	20.00 mm	50 mm	40.00 mm	100 mm	7	59666	MHEV-020-72000-R0.50
	20.00 mm	50 mm	50.00 mm	125 mm	7	59680	MHEV-025-72000-R0.50
	20.00 mm	1.00 mm	30.00 mm	89 mm	7	59649	MHEV-015-72000-R1.00
	20.00 mm	1.00 mm	40.00 mm	100 mm	7	59667	MHEV-020-72000-R1.00
	20.00 mm	1.00 mm	50.00 mm	125 mm	7	59681	MHEV-025-72000-R1.00
25 mm	25.00 mm	1.00 mm	50.00 mm	125 mm	7	59669	MHEV-020-72500-R1.00
	25.00 mm	1.00 mm	64.00 mm	125 mm	7	59683	MHEV-025-72500-R1.00

* .013 mm max TIR

MULTI-FLUTE - CORNER RADIUS

New Items!



HXF

Finisher

- Offers outstanding performance and high temperature resistance in titanium and titanium alloys.
- Designed with high flute count for excellent performance in light profiling, High Efficiency Milling (HEM), and finishing applications.
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Cutter Diameter* D1 $\pm \frac{.001}{.002}$	Shank Dia. D2 (H6)	Corner Radius R $\pm \frac{.001}{.002}$	Length of Cut L1 $\pm \frac{.001}{.002}$	Overall Length L2 $\pm \frac{.001}{.002}$	Flutes	Aplus Coated	Tool Description	
1/4	1/4	.020	3/8	2	7	36016	HXF-S-070250-R.020	
	1/4	.020	1/2	2	7	81832	HXF-SR-070250-R.020	
	1/4	.020	3/4	2-1/2	7	36031	HXF-R-070250-R.020	
	1/4	.020	1	3	7	87752	HXF-M-070250-R.020	new
3/8	3/8	.020	1/2	2	7	36046	HXF-S-070375-R.020	
	3/8	.020	3/4	2-1/2	7	81833	HXF-SR-070375-R.020	
	3/8	.020	1	3	7	36061	HXF-R-070375-R.020	
	3/8	.020	1-1/4	3	7	81834	HXF-M-070375-R.020	
	3/8	.020	1-1/2	3-1/2	7	87754	HXF-L-070375-R.020	new
1/2	1/2	.010	5/8	2-1/2	8	87756	HXF-S-080300-R.010	new
	1/2	.010	1	3	8	87757	HXF-SR-080300-R.010	new
	1/2	.010	1-1/4	3	8	87758	HXF-R-080300-R.010	new
	1/2	.010	1-3/8	3-1/2	8	87759	HXF-M-080300-R.010	new
	1/2	.030	5/8	2-1/2	8	36076	HXF-S-080300-R.030	
	1/2	.030	1	3	8	36091	HXF-SR-080300-R.030	
	1/2	.030	1-1/4	3	8	36106	HXF-R-080300-R.030	
	1/2	.030	1-3/8	3-1/2	8	81835	HXF-M-080300-R.030	
	1/2	.030	2	3-1/2	8	81836	HXF-L-080300-R.030	
5/8	5/8	.060	3/4	3	10	36121	HXF-S-100325-R.060	
	5/8	.060	1-3/8	3-1/2	10	36136	HXF-R-100325-R.060	
3/4	3/4	.060	1	3	12	36151	HXF-S-120750-R.060	
	3/4	.060	1-3/8	4	12	36166	HXF-R-120750-R.060	
	3/4	.060	2	4	12	81837	HXF-M-120750-R.060	
1	1	.060	1-1/4	4	14	36181	HXF-S-141000-R.060	
	1	.060	2	4-1/2	14	36196	HXF-R-141000-R.060	

* .0005 max TIR



Speeds & Feeds on Page 185

HFAL-2

HIGH FEED END MILLS
Aluminum - Reduced Neck

- Designed for outstanding performance and maximum feed rates in aluminum and non-ferrous materials
- Specifically engineered end profile for optimal tool engagement and reduced cutting forces
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $^{+0.015}_{-0.002}$	Shank Dia. D2 H6/g6	Length of Cut L2 $^{+0.017}_{-0.002}$	OAL L1 $^{+0.002}_{-0.002}$	Reach (LBS) L3	Neck Dia. L4	Flutes	Theoretical Radius**	Zplus Coated	Tool Description
1/8	1/4	1/8	2-1/2	1/2	.118	2	.0213	84439	HFAL-FN-040-20125
	1/4	1/8	2-1/2	3/4	.118	2	.0213	84441	HFAL-FN-060-20125
	1/4	1/8	2-1/2	1	.118	2	.0213	84443	HFAL-FN-080-20125
	1/4	1/8	2-1/2	1-1/4	.118	2	.0213	87287	HFAL-FN-100-20125
3/16	1/4	3/16	2-1/2	3/4	.178	2	.0319	84445	HFAL-FN-040-20187
	1/4	3/16	2-1/2	1-1/8	.178	2	.0319	84447	HFAL-FN-060-20187
	1/4	3/16	3	1-1/2	.178	2	.0319	84449	HFAL-FN-080-20187
	1/4	3/16	3	1-7/8	.178	2	.0319	87288	HFAL-FN-100-20187
1/4	1/4	1/4	3	1	.237	2	.0425	84451	HFAL-FN-040-20250
	1/4	1/4	3	1-1/2	.237	2	.0425	84453	HFAL-FN-060-20250
	1/4	1/4	4	2	.237	2	.0425	84455	HFAL-FN-080-20250
	1/4	1/4	4	2-1/2	.237	2	.0425	87289	HFAL-FN-100-20250
5/16	5/16	5/16	4	1-1/4	.296	2	.0531	87290	HFAL-FN-040-20312
	5/16	5/16	4	1-7/8	.296	2	.0531	87291	HFAL-FN-060-20312
	5/16	5/16	4	2-1/2	.296	2	.0531	87292	HFAL-FN-080-20312
3/8	3/8	3/8	4	1-1/2	.358	2	.0638	84457	HFAL-FN-040-20375
	3/8	3/8	4	2-1/4	.358	2	.0638	84459	HFAL-FN-060-20375
	3/8	3/8	6	3	.358	2	.0638	84461	HFAL-FN-080-20375
	3/8	3/8	6	3-3/4	.358	2	.0638	87293	HFAL-FN-100-20375
1/2	1/2	1/2	6	2	.475	2	.0850	84463	HFAL-FN-040-20500
	1/2	1/2	6	3	.475	2	.0850	84465	HFAL-FN-060-20500
	1/2	1/2	7	4	.475	2	.0850	84467	HFAL-FN-080-20500
	1/2	1/2	7	5	.475	2	.0850	87294	HFAL-FN-100-20500
5/8	5/8	5/8	4	2-1/2	.593	2	.1063	87295	HFAL-FN-040-20625
	5/8	5/8	6	3-3/4	.593	2	.1063	87296	HFAL-FN-060-20625
	5/8	5/8	7	5	.593	2	.1063	87297	HFAL-FN-080-20625
3/4	3/4	3/4	6	3	.712	2	.1275	87298	HFAL-FN-040-20750
	3/4	3/4	7	4-1/2	.712	2	.1275	87299	HFAL-FN-060-20750
	3/4	3/4	8	6	.712	2	.1275	87300	HFAL-FN-080-20750

*.0005 max TIR **Theoretical radius for use when programming in CAM software

See page 296 for diagram of theoretical radius



Speeds & Feeds on Page 299

HIGH FEED END MILLS - METRIC

Aluminum - Reduced Neck

MHFAL-2

METRIC

- Designed for outstanding performance and maximum feed rates in aluminum and non-ferrous materials
- Specifically engineered end profile for optimal tool engagement and reduced cutting forces
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- End cutting geometry (non-center cutting)
- H6 shark tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Solid carbide
- CNC ground in the USA

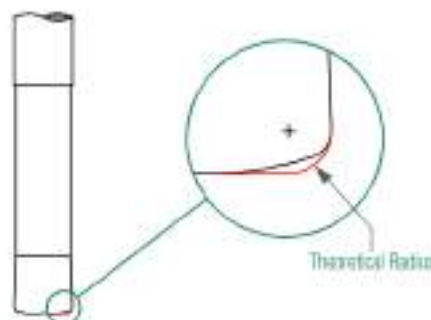


Cutter Dia.* D1 +0.05 mm -0.05 mm	Shank Dia. D2 (H6)	Length of Cut L2 +30 mm -30 mm	OAL L1 +1.00 mm -1.00 mm	Reach (LBS) L3	Neck Dia.	Flutes	Theoretical Radius**	Zplus Coated	Tool Description
3 mm	6.00 mm	3.00 mm	63 mm	12.00 mm	2.85 mm	2	0.51 mm	84942	MHFAL-FN-040-20300
	6.00 mm	3.00 mm	63 mm	18.00 mm	2.85 mm	2	0.51 mm	84943	MHFAL-FN-060-20300
	6.00 mm	3.00 mm	63 mm	24.00 mm	2.85 mm	2	0.51 mm	84944	MHFAL-FN-080-20300
4 mm	6.00 mm	4.00 mm	63 mm	16.00 mm	3.80 mm	2	0.68 mm	84945	MHFAL-FN-040-20400
	6.00 mm	4.00 mm	63 mm	24.00 mm	3.80 mm	2	0.68 mm	84946	MHFAL-FN-060-20400
	6.00 mm	4.00 mm	63 mm	32.00 mm	3.80 mm	2	0.68 mm	84947	MHFAL-FN-080-20400
6 mm	6.00 mm	6.00 mm	75 mm	24.00 mm	5.70 mm	2	1.02 mm	84948	MHFAL-FN-040-20600
	6.00 mm	6.00 mm	75 mm	36.00 mm	5.70 mm	2	1.02 mm	84949	MHFAL-FN-060-20600
	6.00 mm	6.00 mm	75 mm	48.00 mm	5.70 mm	2	1.02 mm	84950	MHFAL-FN-080-20600
8 mm	8.00 mm	8.00 mm	100 mm	32.00 mm	7.60 mm	2	1.38 mm	84951	MHFAL-FN-040-20800
	8.00 mm	8.00 mm	100 mm	48.00 mm	7.60 mm	2	1.38 mm	84952	MHFAL-FN-060-20800
	8.00 mm	8.00 mm	100 mm	64.00 mm	7.60 mm	2	1.38 mm	84953	MHFAL-FN-080-20800
10 mm	10.00 mm	10.00 mm	125 mm	40.00 mm	9.50 mm	2	1.70 mm	84954	MHFAL-FN-040-21000
	10.00 mm	10.00 mm	125 mm	80.00 mm	9.50 mm	2	1.70 mm	84955	MHFAL-FN-060-21000
	10.00 mm	10.00 mm	125 mm	90.00 mm	9.50 mm	2	1.70 mm	84956	MHFAL-FN-080-21000
12 mm	12.00 mm	12.00 mm	125 mm	48.00 mm	11.40 mm	2	2.04 mm	84957	MHFAL-FN-040-21200
	12.00 mm	12.00 mm	125 mm	72.00 mm	11.40 mm	2	2.04 mm	84958	MHFAL-FN-060-21200
	12.00 mm	12.00 mm	150 mm	96.00 mm	11.40 mm	2	2.04 mm	84959	MHFAL-FN-080-21200

* D13 mm max TIR **Theoretical radius for use when programming in CAM software.

Visit www.helicaltool.com to download precise Simulation Files for all Feed Mills.

In the absence of a Simulation File, use the Theoretical Radius to approximate Helical's feed mills as corner radius end mills within your CAM software.



Speeds & Feeds on Page 299

HFAL-2

SPEEDS & FEEDS
High Feed End Mills - Aluminum

HFAL-2/MHFAL-2

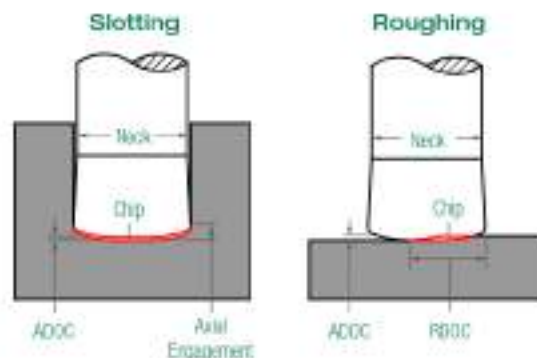
Material Guide		SFM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		5/16		3/4		1		1 1/4	
			Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph
WROUGHT ALUMINUM ALLOY	2014, 5082, 6061, 7050, 7072, 7475	2500	.0025	.0032	.0038	.0048	.0053	.0065	.0082	.0081	.0100	.0114	.0180	.0182	.0205	.0228
CAST ALUMINUM ALLOY	319.0, 325.0, 355.0, 390.0, 390.0, 393.0, 390.0, 520.0, 535.0	1400	.0041	.0048	.0058	.0082	.0082	.0130	.0128	.0160	.0190	.0205	.0251	.0319	.0319	.0410
COPPER ALLOY	Cu-ETP, CuBe2, CuZn30, CuZn39Pb3, CuZn15, CuSn5	775	.0027	.0038	.0041	.0055	.0055	.0080	.0081	.0180	.0114	.0137	.0192	.0205	.0228	.0274

MILLING PROCESS	ADOC	RDOC
Slot (Full Slotting)	3.93% - 5.00% Diameter	100% Diameter
Rph (Traditional Roughing)	3.93% - 5.00% Diameter	Up to 65% Diameter

NOTES:

IPT values shown are for 4xD reach tools, for tools with reaches greater than 4xD, IPT should be reduced.

Please note for slotting applications, axial engagement will increase while axial stepdown (ADOC) remains the same.



The Secret Mechanics of High Feed End Mills

In The Loupe
BLOG

A High Feed End Mill is a type of High Efficiency Milling (HEM) tool with a specialized end profile that allows the tool to utilize chip thinning to have dramatically increased feed rates. These tools are meant to operate with an extremely low axial depth of cut so that the cutting action takes place along the curved edge of the bottom profile. Read more from our "In the Loupe" blog post *The Secret Mechanics of High Feed End Mills*.

www.harveyprecision.com/in-the-loupe/the-secret-mechanics-of-high-feed-end-mills/



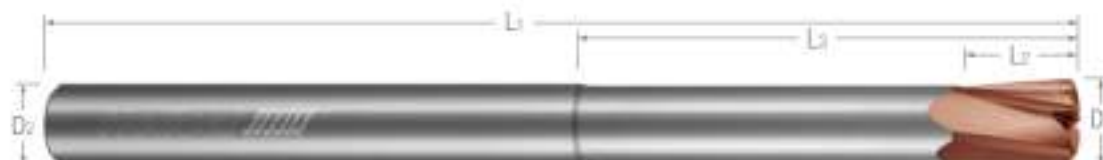
SCAN TO READ

HIGH FEED END MILLS

HFV

Steels Up to 45 Rc - Variable Pitch - Reduced Neck

- Specifically engineered end profile for optimal tool engagement and reduced cutting forces
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Geometry proven to achieve maximum feed rates in steels up to 45 Rc
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- End cutting geometry (non-center cutting)
- H6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .001$ - .002	Shank Dia. D2 (H6)	Length of Cut L2 $\pm .002$ - .003	OAL L1 $\pm .002$ - .003	Reach (LBS) L3	Neck Dia.	Flutes	Theoretical Radius**	Tplus Coated	Tool Description
1/8	1/8	1/8	2	1/4	.110	4	.0157	82663	HFV-RN-020-40125
	1/8	1/8	2	1/2	.110	4	.0157	82664	HFV-RN-040-40125
	1/4	1/8	2-1/2	1/2	.110	4	.0157	83725	HFV-RN-040-40125
	1/8	1/8	2	3/4	.110	4	.0157	82665	HFV-RN-060-40125
	1/4	1/8	2-1/2	3/4	.110	4	.0157	83726	HFV-RN-060-40125
	1/4	1/8	2-1/2	1	.110	4	.0157	83727	HFV-RN-080-40125
	1/4	1/8	2-1/2	1-1/4	.110	4	.0157	83728	HFV-RN-100-40125
3/16	3/16	3/16	2-1/2	3/8	.165	4	.0235	82666	HFV-RN-020-40137
	3/16	3/16	2-1/2	3/4	.165	4	.0235	82667	HFV-RN-040-40137
	1/4	3/16	2-1/2	3/4	.165	4	.0235	83729	HFV-RN-040-40137
	3/16	3/16	2-1/2	1-1/8	.165	4	.0235	82668	HFV-RN-060-40137
	1/4	3/16	2-1/2	1-1/8	.165	4	.0235	83730	HFV-RN-060-40137
	1/4	3/16	3	1-1/2	.165	4	.0235	83731	HFV-RN-080-40137
	1/4	3/16	3	1-7/8	.165	4	.0235	83732	HFV-RN-100-40137
1/4	1/4	1/4	3	1/2	.220	5	.0314	82669	HFV-RN-020-50250
	1/4	1/4	3	1	.220	5	.0314	82670	HFV-RN-040-50250
	1/4	1/4	3	1-1/2	.220	5	.0314	82671	HFV-RN-060-50250
	1/4	1/4	4	2	.220	5	.0314	83719	HFV-RN-080-50250
	1/4	1/4	4	2-1/2	.220	5	.0314	83720	HFV-RN-100-50250
5/16	5/16	5/16	3	5/8	.275	5	.0393	87267	HFV-RN-020-50312
	5/16	5/16	4	1-1/4	.275	5	.0393	87268	HFV-RN-040-50312
	5/16	5/16	4	1-7/8	.275	5	.0393	87269	HFV-RN-060-50312
	5/16	5/16	4	2-1/2	.275	5	.0393	87270	HFV-RN-080-50312
3/8	3/8	3/8	4	3/4	.330	5	.0471	82672	HFV-RN-020-50375
	3/8	3/8	4	1-1/2	.330	5	.0471	82673	HFV-RN-040-50375
	3/8	3/8	4	2-1/4	.330	5	.0471	82674	HFV-RN-060-50375
	3/8	3/8	6	3	.330	5	.0471	83721	HFV-RN-080-50375
	3/8	3/8	6	3-3/4	.330	5	.0471	83722	HFV-RN-100-50375
1/2	1/2	1/2	5	1	.440	5	.0628	82675	HFV-RN-020-50690
	1/2	1/2	5	2	.440	5	.0628	82676	HFV-RN-040-50690
	1/2	1/2	5	3	.440	5	.0628	82677	HFV-RN-060-50690
	1/2	1/2	7	4	.440	5	.0628	83723	HFV-RN-080-50690
	1/2	1/2	7	5	.440	5	.0628	83724	HFV-RN-100-50690

* .0005 max TIR **Theoretical radius for use when programming in CAM software

continued on next page



Speeds & Feeds on Page 305

HFV

HIGH FEED END MILLS

Steels Up to 45 Rc - Variable Pitch - Reduced Neck (cont.)

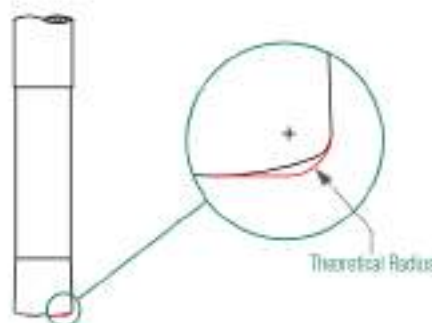
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Cutter Dia.* D ₁ = $\frac{.001}{.002}$	Shank Dia. D ₂ (in)	Length of Cut L _z = $\frac{.001}{.002}$	OAL L ₁ = $\frac{.001}{.002}$	Reach (LBS) L ₂	Neck Dia.	Flutes	Theoretical Radius**	T plus Coated	Tool Description
5/8	5/8	5/8	4	1-1/4	.550	5	.0785	87271	HFV-RN-020-50625
	5/8	5/8	4	2-1/2	.550	5	.0785	87272	HFV-RN-040-50625
	5/8	5/8	6	3-3/4	.550	5	.0785	87273	HFV-RN-060-50625
	5/8	5/8	7	5	.550	5	.0785	87274	HFV-RN-080-50625
3/4	3/4	3/4	4	1-1/2	.660	5	.0942	87275	HFV-RN-020-50750
	3/4	3/4	6	3	.660	5	.0942	87276	HFV-RN-040-50750
	3/4	3/4	7	4-1/2	.660	5	.0942	87277	HFV-RN-060-50750
	3/4	3/4	8	6	.660	5	.0942	87278	HFV-RN-080-50750

*.0005 max TIR **Theoretical radius for use when programming in CAM software

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In the absence of a Simulation File, use the Theoretical Radius to approximate Helical's feed mills as corner radius end mills within your CAM software.



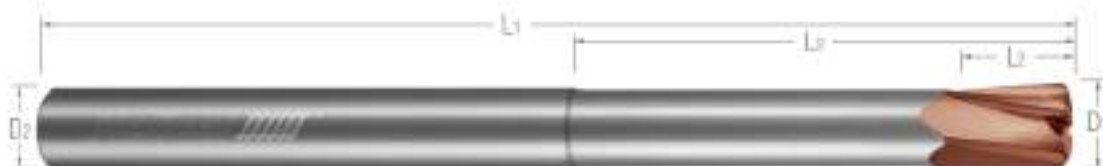
HIGH FEED END MILLS - METRIC

Steels Up to 45 Rc - Variable Pitch - Reduced Neck

MHFV

METRIC

- Specifically engineered end profile for optimal tool engagement and reduced cutting forces
- Variable pitch geometry results in higher quality parts by decreasing chatter and harmonics
- Geometry proven to achieve maximum feed rates in steels up to 45 Rc
- Reduced neck provides maximum strength in long reach and deep pocketing applications
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tiplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

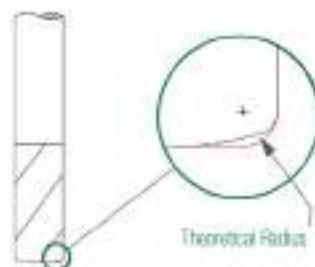


Cutter Dia.* D1 +0.01 mm -0.01 mm	Shank Dia. D2 H6/f6	Length of Cut L2 +0.01 mm -0.01 mm	OAL L1 +1.00 mm -1.00 mm	Reach (LBS) L3	Neck Dia.	Flutes	Theoretical Radius**	Tiplus Coated	Tool Description
3 mm	3.00 mm	3.00 mm	50 mm	6.00 mm	2.64 mm	4	.377 mm	82679	MHFV-RN-020-40300
	3.00 mm	3.00 mm	90 mm	12.00 mm	2.64 mm	4	.377 mm	82679	MHFV-RN-040-40300
	3.00 mm	3.00 mm	50 mm	18.00 mm	2.64 mm	4	.377 mm	82680	MHFV-RN-060-40300
	3.00 mm	3.00 mm	92 mm	24.00 mm	2.64 mm	4	.377 mm	87279	MHFV-RN-080-40300
4 mm	4.00 mm	4.00 mm	63 mm	8.00 mm	3.52 mm	4	.502 mm	82681	MHFV-RN-020-40400
	4.00 mm	4.00 mm	92 mm	16.00 mm	3.52 mm	4	.502 mm	82682	MHFV-RN-040-40400
	4.00 mm	4.00 mm	63 mm	24.00 mm	3.52 mm	4	.502 mm	82683	MHFV-RN-060-40400
	4.00 mm	4.00 mm	92 mm	32.00 mm	3.52 mm	4	.502 mm	87280	MHFV-RN-080-40400
6 mm	6.00 mm	6.00 mm	75 mm	12.00 mm	5.28 mm	5	.754 mm	82684	MHFV-RN-020-50600
	6.00 mm	6.00 mm	75 mm	24.00 mm	5.28 mm	5	.754 mm	82685	MHFV-RN-040-50600
	6.00 mm	6.00 mm	75 mm	36.00 mm	5.28 mm	5	.754 mm	82686	MHFV-RN-060-50600
	6.00 mm	6.00 mm	75 mm	48.00 mm	5.28 mm	5	.754 mm	87281	MHFV-RN-080-50600
8 mm	8.00 mm	8.00 mm	100 mm	16.00 mm	7.04 mm	5	1.005 mm	82687	MHFV-RN-020-50800
	8.00 mm	8.00 mm	100 mm	32.00 mm	7.04 mm	5	1.005 mm	82688	MHFV-RN-040-50800
	8.00 mm	8.00 mm	100 mm	48.00 mm	7.04 mm	5	1.005 mm	82689	MHFV-RN-060-50800
	8.00 mm	8.00 mm	100 mm	64.00 mm	7.04 mm	5	1.005 mm	87282	MHFV-RN-080-50800
10 mm	10.00 mm	10.00 mm	125 mm	20.00 mm	8.80 mm	5	1.257 mm	82690	MHFV-RN-020-51000
	10.00 mm	10.00 mm	125 mm	40.00 mm	8.80 mm	5	1.257 mm	82691	MHFV-RN-040-51000
	10.00 mm	10.00 mm	125 mm	60.00 mm	8.80 mm	5	1.257 mm	82692	MHFV-RN-060-51000
12 mm	12.00 mm	12.00 mm	125 mm	24.00 mm	10.55 mm	5	1.508 mm	82693	MHFV-RN-020-51200
	12.00 mm	12.00 mm	125 mm	48.00 mm	10.55 mm	5	1.508 mm	82694	MHFV-RN-040-51200
	12.00 mm	12.00 mm	125 mm	72.00 mm	10.55 mm	5	1.508 mm	82695	MHFV-RN-060-51200

* .013 mm max TIR **Theoretical radius for use when programming in CAM software

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Speeds & Feeds on Page 305

HFVC

HIGH FEED END MILLS

Steels up to 45 Rc - Variable Pitch - Coolant Through -
Reduced Neck

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- CNC ground in the USA

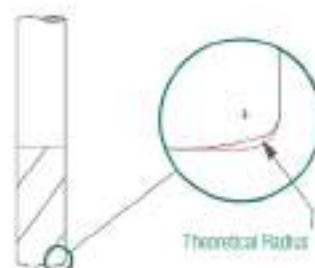


Cutter Dia.* D1 $^{+0.001}_{-0.002}$	Shank Dia. D2 (H6)	Length of Cut L2 $^{+0.002}_{-0.001}$	OAL L1 $^{+0.002}_{-0.002}$	Reach (LBS) L3	Neck Dia.	Flutes	Theoretical Radius**	Tplus Coated	Tool Description
1/4	1/4	1/4	3	1/2	.220	5	.0314	83686	HFVC-FR-020-50250
	1/4	1/4	2	1	.220	5	.0314	83687	HFVC-FR-040-50250
	1/4	1/4	3	1-1/2	.220	5	.0314	83688	HFVC-FR-060-50250
	1/4	1/4	4	2	.220	5	.0314	83733	HFVC-FR-080-50250
	1/4	1/4	4	2-1/2	.220	5	.0314	83734	HFVC-FR-100-50250
3/8	3/8	3/8	4	3/4	.330	5	.0471	83689	HFVC-FR-020-50375
	3/8	3/8	4	1-1/2	.330	5	.0471	83700	HFVC-FR-040-50375
	3/8	3/8	4	2-1/4	.330	5	.0471	83701	HFVC-FR-060-50375
	3/8	3/8	6	3	.330	5	.0471	83735	HFVC-FR-080-50375
	3/8	3/8	6	3-3/4	.330	5	.0471	83736	HFVC-FR-100-50375
1/2	1/2	1/2	5	1	.440	5	.0628	83702	HFVC-FR-020-50500
	1/2	1/2	5	2	.440	5	.0628	83703	HFVC-FR-040-50500
	1/2	1/2	5	3	.440	5	.0628	83704	HFVC-FR-060-50500
	1/2	1/2	7	4	.440	5	.0628	83737	HFVC-FR-080-50500
	1/2	1/2	7	5	.440	5	.0628	83738	HFVC-FR-100-50500

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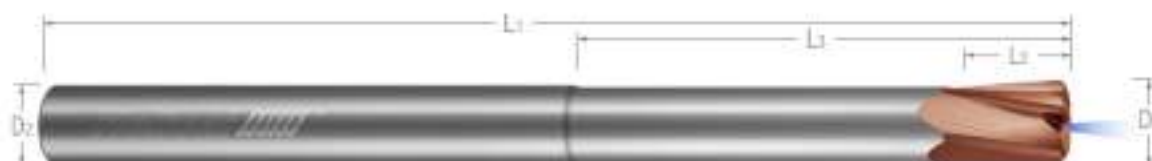
MHFVC

METRIC

HIGH FEED END MILLS - METRIC

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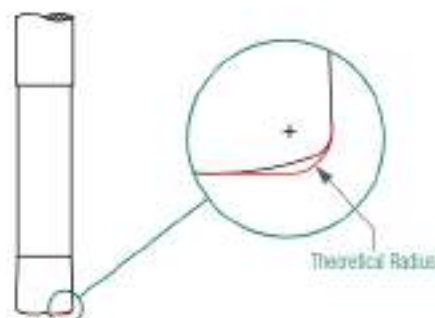


Cutter Dia.* D1 ±.00 mm ±.00 mm	Shank Dia. D2 (h6)	Length of Cut L2 ±.00 mm ±.00 mm	OAL L1 ±.00 mm ±.00 mm	Reach (LBS) L3	Neck Diameter	Flutes	Theoretical Radius**	Tiplus Coated	Tool Description
6 mm	6.00 mm	6.00 mm	75 mm	12.00 mm	5.28 mm	6	.734 mm	82705	MHFVC-RN-020-50900
	6.00 mm	6.00 mm	75 mm	24.00 mm	5.28 mm	6	.734 mm	82706	MHFVC-RN-040-50900
	6.00 mm	6.00 mm	75 mm	36.00 mm	5.28 mm	6	.734 mm	82707	MHFVC-RN-060-50900
8 mm	8.00 mm	8.00 mm	100 mm	16.00 mm	7.04 mm	6	.979 mm	82708	MHFVC-RN-020-50900
	8.00 mm	8.00 mm	100 mm	32.00 mm	7.04 mm	6	.979 mm	82709	MHFVC-RN-040-50900
	8.00 mm	8.00 mm	100 mm	48.00 mm	7.04 mm	6	.979 mm	82710	MHFVC-RN-060-50900
10 mm	10.00 mm	10.00 mm	125 mm	20.00 mm	8.80 mm	6	1.224 mm	82711	MHFVC-RN-020-51000
	10.00 mm	10.00 mm	125 mm	40.00 mm	8.80 mm	6	1.224 mm	82712	MHFVC-RN-040-51000
	10.00 mm	10.00 mm	125 mm	60.00 mm	8.80 mm	6	1.224 mm	82713	MHFVC-RN-060-51000
12 mm	12.00 mm	12.00 mm	125 mm	24.00 mm	10.55 mm	6	1.469 mm	82714	MHFVC-RN-020-51200
	12.00 mm	12.00 mm	125 mm	48.00 mm	10.55 mm	6	1.469 mm	82715	MHFVC-RN-040-51200
	12.00 mm	12.00 mm	125 mm	72.00 mm	10.55 mm	6	1.469 mm	82716	MHFVC-RN-060-51200

* .013 mm max TIR **Theoretical radius for use when programming in CAM software

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HFV

SPEEDS & FEEDS
High Feed End Mills

HFV / HFVC

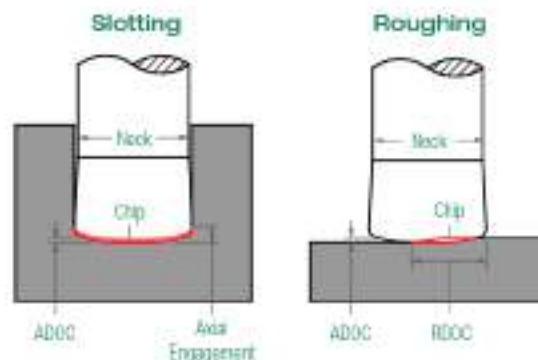
Material Guide		Hardness	SFM	Inches Per Tooth (IPT)														
				1/8		3/16		1/4		3/8		1/2		5/8		3/4		
				Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	Slot	Rgt	
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRC	800	.0027	.0057	.0040	.0035	.0053	.0113	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		75 - 88 HRC	750	.0020	.0037	.0030	.0025	.0048	.0073	.0080	.0110	.0080	.0147	.0100	.0164	.0120	.0221	
		21 - 38 HRC	700	.0013	.0025	.0020	.0016	.0027	.0050	.0050	.0040	.0075	.0053	.0100	.0066	.0105	.0079	.0150
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 80XX, 93XX	75 - 88 HRC	600	.0027	.0057	.0040	.0035	.0053	.0113	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		21 - 38 HRC	550	.0027	.0047	.0040	.0030	.0053	.0060	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		38 - 50 HRC	400	.0020	.0033	.0030	.0020	.0048	.0067	.0080	.0100	.0080	.0133	.0100	.0166	.0120	.0199	
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	350	.0013	.0026	.0020	.0016	.0027	.0040	.0040	.0060	.0053	.0080	.0066	.0100	.0079	.0120	
		75 - 88 HRC	550	.0027	.0057	.0040	.0035	.0053	.0113	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		21 - 38 HRC	500	.0027	.0047	.0040	.0030	.0053	.0060	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	38 - 50 HRC	450	.0020	.0033	.0030	.0020	.0048	.0067	.0080	.0100	.0080	.0133	.0100	.0166	.0120	.0199	
		> 50 HRC	400	.0013	.0026	.0020	.0016	.0027	.0040	.0040	.0060	.0053	.0080	.0066	.0100	.0079	.0120	
		< 75 HRC	450	.0027	.0067	.0040	.0030	.0053	.0133	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Inconel 27-TMO, 216, 216L, 321, 347	75 - 88 HRC	500	.0027	.0063	.0040	.0030	.0053	.0107	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		21 - 38 HRC	450	.0027	.0047	.0040	.0030	.0053	.0060	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		38 - 50 HRC	400	.0022	.0040	.0030	.0020	.0048	.0060	.0080	.0100	.0080	.0133	.0100	.0166	.0120	.0199	
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 440, 446	75 - 88 HRC	750	.0025	.0037	.0038	.0035	.0058	.0073	.0075	.0110	.0100	.0147	.0125	.0164	.0150	.0221	
		21 - 38 HRC	650	.0027	.0053	.0040	.0030	.0053	.0107	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		15-5, 17-4, Carpenter 450, Carpenter 465	21 - 38 HRC	450	.0025	.0037	.0038	.0035	.0058	.0073	.0075	.0110	.0100	.0147	.0125	.0164	.0150	.0221
GRAY CAST IRON	SAE J403, ASTM A48	21 - 38 HRC	550	.0027	.0063	.0040	.0030	.0053	.0127	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		15 - 98 HRC	600	.0027	.0063	.0040	.0030	.0053	.0125	.0053	.0140	.0080	.0140	.0167	.0187	.0134	.0234	
		38 - 50 HRC	400	.0020	.0033	.0030	.0020	.0048	.0067	.0080	.0100	.0080	.0133	.0100	.0166	.0120	.0199	
MALLEABLE CAST IRON	ASTM A27, ASTM A222, ASTM A226	15 - 98 HRC	550	.0027	.0066	.0040	.0030	.0053	.0111	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		21 - 38 HRC	450	.0027	.0040	.0040	.0030	.0053	.0080	.0080	.0120	.0167	.0187	.0134	.0234	.0161	.0281	
		38 - 50 HRC	400	.0013	.0020	.0020	.0020	.0027	.0040	.0040	.0060	.0053	.0080	.0066	.0100	.0079	.0150	
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 657	75 - 98 HRC	500	.0027	.0066	.0040	.0030	.0053	.0111	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		21 - 38 HRC	450	.0027	.0040	.0040	.0030	.0053	.0080	.0080	.0120	.0167	.0187	.0134	.0234	.0161	.0281	
		38 - 50 HRC	400	.0013	.0020	.0020	.0020	.0027	.0040	.0040	.0060	.0053	.0080	.0066	.0100	.0079	.0150	
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRC	600	.0027	.0047	.0040	.0030	.0053	.0064	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	
		75 - 98 HRC	550	.0027	.0043	.0040	.0030	.0053	.0067	.0080	.0130	.0167	.0172	.0134	.0214	.0161	.0256	
		Hastelloy C-22, Inconel 625, Waspalloy René 41, Inconel 718, Inconel 20	75 - 98 HRC	200	.0027	.0058	.0040	.0030	.0053	.0075	.0080	.0113	.0167	.0150	.0134	.0167	.0161	.0234
NICKEL ALLOY		21 - 38 HRC	180	.0027	.0030	.0040	.0030	.0053	.0060	.0080	.0080	.0130	.0167	.0130	.0134	.0162	.0161	.0194
		38 - 50 HRC	150	.0022	.0028	.0030	.0030	.0043	.0043	.0050	.0060	.0080	.0080	.0112	.0100	.0140	.0131	.0168
		Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRC	350	.0027	.0047	.0040	.0030	.0053	.0064	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 98 HRC	300	.0027	.0033	.0040	.0030	.0053	.0066	.0080	.0080	.0167	.0130	.0134	.0162	.0161	.0194	
		21 - 38 HRC	250	.0025	.0023	.0030	.0030	.0035	.0059	.0047	.0075	.0070	.0180	.0083	.0125	.0118	.0150	.0139
		38 - 50 HRC	225	.0020	.0023	.0030	.0035	.0048	.0047	.0060	.0070	.0080	.0083	.0100	.0118	.0120	.0139	.0139
COBALT ALLOY	ASTM F960, ASTM F961, ASTM F75, ASTM F706	21 - 38 HRC	150	.0027	.0035	.0040	.0035	.0053	.0070	.0080	.0105	.0167	.0140	.0134	.0175	.0161	.0210	.0210
		38 - 50 HRC	80	.0020	.0023	.0030	.0035	.0048	.0047	.0060	.0070	.0080	.0083	.0100	.0118	.0120	.0139	.0139
		< 75 HRC	450	.0027	.0067	.0040	.0030	.0053	.0133	.0080	.0140	.0167	.0187	.0134	.0234	.0161	.0281	.0281

MILLING PROCESS	HARDNESS	ADOC	RDOC
Slot (Full Slotting)	< 35 HRC	3.00%-5.00% Diameter	100% Diameter
	≥ 35 HRC	2.50%-4.00% Diameter	100% Diameter
Rgt (Traditional Roughing)	< 35 HRC	3.00%-5.00% Diameter	Up to 65% Diameter
	≥ 35 HRC	2.15%-4.25% Diameter	Up to 65% Diameter

NOTES:

IPT values shown are for 3xD reach tools, and should be adjusted for longer or shorter reaches. For tools with reaches greater than 3xD, IPT should be reduced.

Please note for slotting applications, axial engagement will increase while axial stepdown (ADOC) remains the same.



COMBINATION FEED & HEM - 4 FLUTE

Chipbreaker Rougher - Variable Pitch



HEVF-C-4

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, cast iron, titanium, and titanium alloys
- Combination of specialized end profile and CD geometry for both high feed and HEM applications
- 4 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tiplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

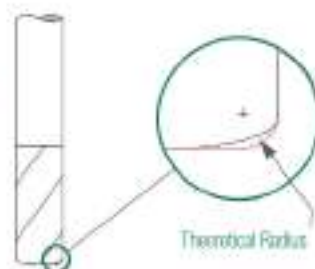


Cutter Dia.* $D1 \pm .0007$ -.002	Shank Dia. $D2 \pm .001$	Length of Cut $L2 \pm .002$ -.001	Overall Length $L1 \pm .002$ -.001	Flutes	Theoretical Radius**	Tiplus Coated	Tool Description
1/8	1/8	1/4	1-1/2	4	.0157	04468	HEVF-C-020-40125
	1/8	3/8	2	4	.0157	04469	HEVF-C-030-40125
	1/8	1/2	2-1/2	4	.0157	04470	HEVF-C-040-40125
3/16	3/16	5/16	2	4	.0235	04471	HEVF-C-016-40187
	3/16	7/16	2	4	.0235	04472	HEVF-C-023-40187
	3/16	9/16	2-1/2	4	.0235	04473	HEVF-C-030-40187
1/4	1/4	3/8	2	4	.0314	04474	HEVF-C-015-40250
	1/4	1/2	2-1/2	4	.0314	04475	HEVF-C-020-40250
	1/4	3/4	2-1/2	4	.0314	04476	HEVF-C-030-40250
3/8	3/8	1/2	2	4	.0471	04477	HEVF-C-013-40375
	3/8	1	3	4	.0471	04478	HEVF-C-026-40375
	3/8	1-1/4	3	4	.0471	04479	HEVF-C-033-40375
1/2	1/2	1	3	4	.0628	04480	HEVF-C-020-40500
	1/2	1-1/4	3	4	.0628	04481	HEVF-C-025-40500
	1/2	1-5/8	4	4	.0628	04482	HEVF-C-032-40500
5/8	5/8	1-1/4	3-1/2	4	.0785	04483	HEVF-C-020-40625
	5/8	1-5/8	3-1/2	4	.0785	04484	HEVF-C-036-40625
	5/8	2-1/8	4	4	.0785	04485	HEVF-C-034-40625
3/4	3/4	1	3	4	.0942	04486	HEVF-C-013-40750
	3/4	1-5/8	4	4	.0942	04487	HEVF-C-021-40750
	3/4	2-1/4	5	4	.0942	04488	HEVF-C-030-40750

* .0005 max TIR **Theoretical radius for use when programming in CAM software

Visit www.helicaltool.com to download precise Simulation Files for all Feed Mills.

In the absence of a Simulation File, use the Theoretical Radius to approximate Helical's feed mills as corner radius end mills within your CAM software.



Speeds & Feeds on Page 308

HEVFC-C-4



COMBINATION FEED & HEM - 4 FLUTE

Chipbreaker Rougher - Variable Pitch - Coolant Through

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, cast iron, titanium, and titanium alloys
- Combination of specialized end profile and OD geometry for both high feed and High Efficiency Milling (HEM) applications
- 4 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Center coolant hole for reduced heat, enhanced chip evacuation, and increased material removal rates
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA



Cutter Dia.* D1 $\pm .001$ mm	Shank Dia. D2 (h6)	Length of Cut L2 $\pm .002$ mm	Overall Length L1 $\pm .002$ mm	Flutes	Theoretical Radius**	T _{plus} Coated	Tool Description
1/4	1/4	3/8	2	4	.0314	06412	HEVFC-C-015-40250
	1/4	1/2	2-1/2	4	.0314	06413	HEVFC-C-020-40250
	1/4	3/4	2-1/2	4	.0314	06414	HEVFC-C-030-40250
3/8	3/8	1/2	2	4	.0471	06415	HEVFC-C-015-40375
	3/8	1	3	4	.0471	06416	HEVFC-C-020-40375
	3/8	1-1/4	3	4	.0471	06417	HEVFC-C-030-40375
1/2	1/2	1	3	4	.0628	06418	HEVFC-C-020-40500
	1/2	1-1/4	3	4	.0628	06419	HEVFC-C-025-40500
	1/2	1-5/8	4	4	.0628	06420	HEVFC-C-032-40500
5/8	5/8	1-1/4	3-1/2	4	.0785	06421	HEVFC-C-020-40625
	5/8	1-5/8	3-1/2	4	.0785	06422	HEVFC-C-026-40625
	5/8	2-1/8	4	4	.0785	06423	HEVFC-C-034-40625
3/4	3/4	1	3	4	.0942	06424	HEVFC-C-013-40750
	3/4	1-5/8	4	4	.0942	06425	HEVFC-C-021-40750
	3/4	2-1/4	5	4	.0942	06426	HEVFC-C-030-40750

*.0005 max TIR **Theoretical radius for use when programming in CAM software

See page 304 for diagram of theoretical radius

4 Key Benefits of Combination Feed & HEM End Mills

In The Loupe
Blog Post

Machinists have lauded this tool's amazing benefits, including its ability to cut down on part cycle times, address machine limitations, and limit complexity of use, among others. For a full breakdown of this Helical fan-favorite, check out our "In the Loupe" blog post: *4 Key Benefits of Combination Feed & HEM End Mills*

www.harveperformance.com/in-the-loupe/4-key-benefits-of-combination-feed-hem/



SCAN TO READ



Speeds & Feeds on Page 308

SPEEDS & FEEDS

Combination Feed & HEM - 4 Flute

HEVF-C-4

HEVF-C-4 / HEVFC-C-4

Material Guide	Hardness	SFM	Inches per Tooth (IPT)													
			1/8		3/16		1/4		5/16		3/8		7/8		1	
			Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn	Slot	Rgn
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 70 HRC	.0027	.012	.0040	.016	.0063	.024	.0080	.036	.0107	.047	.0160	.067	.0214	.086
		75 - 90 HRC	.0030	.0090	.0030	.013	.0040	.016	.0060	.026	.0080	.034	.0120	.046	.0160	.060
		21 - 36 HRC	.0030	.0060	.0020	.009	.0027	.011	.0040	.017	.0053	.022	.0080	.033	.0106	.041
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 60XX, 60XX	75 - 90 HRC	.0027	.0080	.0040	.011	.0063	.015	.0080	.023	.0107	.030	.0160	.040	.0214	.054
		21 - 36 HRC	.0027	.0060	.0040	.009	.0063	.012	.0080	.017	.0107	.022	.0160	.033	.0214	.040
		36 - 50 HRC	.0030	.0030	.0030	.007	.0040	.010	.0060	.015	.0080	.015	.0120	.026	.0160	.030
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	.0013	.004	.0020	.006	.0027	.008	.0040	.012	.0053	.015	.0080	.022	.0106	.028
		75 - 90 HRC	.0027	.0080	.0040	.011	.0063	.015	.0080	.023	.0107	.030	.0160	.040	.0214	.054
		21 - 36 HRC	.0027	.0060	.0040	.009	.0063	.012	.0080	.017	.0107	.022	.0160	.033	.0214	.040
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 70 HRC	.0027	.010	.0040	.015	.0063	.020	.0080	.030	.0107	.039	.0160	.056	.0214	.071
		75 - 90 HRC	.0027	.007	.0040	.010	.0063	.014	.0080	.021	.0107	.021	.0160	.038	.0214	.049
		21 - 36 HRC	.0027	.0060	.0040	.009	.0063	.012	.0080	.016	.0107	.024	.0160	.034	.0214	.041
AUSTENITIC STAINLESS STEEL	Ni60, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	36 - 50 HRC	.0020	.006	.0030	.008	.0040	.011	.0060	.016	.0080	.021	.0120	.031	.0160	.039
		> 50 HRC	.0013	.004	.0020	.005	.0027	.007	.0040	.010	.0053	.013	.0080	.019	.0106	.024
MARTENSITIC & FERRITIC STAINLESS STEEL	Ni60, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	75 - 90 HRC	.0027	.0080	.0040	.011	.0063	.015	.0080	.022	.0107	.029	.0160	.042	.0214	.053
		21 - 36 HRC	.0027	.007	.0040	.010	.0063	.014	.0080	.020	.0107	.026	.0160	.038	.0214	.046
		36 - 50 HRC	.0020	.006	.0030	.008	.0040	.011	.0060	.016	.0080	.021	.0120	.031	.0160	.039
PH STAINLESS STEEL	403, 410, 416, 420, 440, 438, 448	75 - 90 HRC	.0025	.008	.0038	.011	.0060	.016	.0075	.023	.0106	.030	.0150	.040	.0200	.055
		21 - 36 HRC	.0027	.007	.0040	.010	.0060	.013	.0080	.020	.0107	.026	.0160	.037	.0214	.047
GRAY CAST IRON	15-5, 17-4, Carpenter 450, Carpenter 460	21 - 36 HRC	.0025	.006	.0038	.008	.0050	.011	.0075	.017	.0106	.022	.0150	.031	.0200	.040
		36 - 50 HRC	.0020	.005	.0030	.007	.0040	.010	.0060	.014	.0080	.019	.0120	.027	.0160	.035
MALLEABLE CAST IRON	SAE J431, ASTM A48	75 - 90 HRC	.0027	.013	.0040	.019	.0063	.025	.0080	.037	.0107	.040	.0160	.069	.0214	.088
		21 - 36 HRC	.0027	.007	.0040	.010	.0060	.013	.0080	.020	.0107	.026	.0160	.038	.0214	.046
NODULAR (DUCTILE) CAST IRON	ASTM A27, ASTM A229, ASTM A502	75 - 90 HRC	.0027	.006	.0040	.012	.0063	.016	.0080	.023	.0107	.031	.0160	.044	.0214	.056
		21 - 36 HRC	.0027	.007	.0040	.010	.0063	.014	.0080	.020	.0107	.026	.0160	.038	.0214	.046
		36 - 50 HRC	.0020	.006	.0040	.008	.0053	.011	.0060	.016	.0107	.021	.0160	.038	.0214	.046
PURE NICKEL	ASTM A206, ASTM B97	75 - 90 HRC	.0027	.0080	.0040	.012	.0063	.016	.0080	.024	.0107	.032	.0160	.046	.0214	.059
		21 - 36 HRC	.0027	.006	.0040	.008	.0053	.011	.0060	.016	.0107	.021	.0160	.038	.0214	.046
		36 - 50 HRC	.0020	.006	.0030	.005	.0027	.007	.0040	.010	.0053	.013	.0080	.019	.0106	.024
INDEL ALLOY	Nickel 200, Nickel 201	< 70 HRC	.0027	.011	.0040	.016	.0063	.021	.0080	.031	.0107	.041	.0160	.059	.0214	.075
		75 - 90 HRC	.0027	.009	.0040	.013	.0053	.016	.0080	.026	.0107	.034	.0160	.046	.0214	.063
INDEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, René 41, Inconel 718, Inconel 718	75 - 90 HRC	.0027	.005	.0040	.008	.0063	.011	.0080	.016	.0107	.021	.0160	.038	.0214	.046
		21 - 36 HRC	.0027	.005	.0040	.008	.0063	.010	.0080	.015	.0107	.020	.0160	.039	.0214	.046
		36 - 50 HRC	.0020	.005	.0030	.007	.0040	.009	.0065	.013	.0080	.017	.0130	.025	.0174	.031
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 5, Ti Grade 6, Ti Grade 7, Ti Grade 12	< 70 HRC	.0027	.015	.0040	.022	.0063	.029	.0080	.043	.0107	.057	.0160	.081	.0214	.103
		75 - 90 HRC	.0027	.012	.0040	.016	.0053	.024	.0080	.036	.0107	.047	.0160	.068	.0214	.087
		21 - 36 HRC	.0027	.009	.0040	.014	.0053	.018	.0080	.027	.0107	.036	.0160	.051	.0214	.066
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 90 HRC	.0027	.007	.0040	.011	.0063	.014	.0080	.021	.0107	.026	.0160	.040	.0214	.051
		21 - 36 HRC	.0027	.007	.0038	.010	.0050	.013	.0075	.020	.0106	.026	.0150	.037	.0200	.047
COBALT ALLOY	ASTM F963, ASTM F964, ASTM F965, ASTM F966	75 - 90 HRC	.0020	.006	.0030	.009	.0040	.012	.0060	.018	.0080	.024	.0120	.034	.0160	.040
		21 - 36 HRC	.0027	.006	.0040	.008	.0053	.012	.0080	.017	.0107	.023	.0160	.033	.0214	.040
		36 - 50 HRC	.0020	.004	.0030	.006	.0040	.008	.0060	.012	.0080	.016	.0120	.022	.0160	.030

MILLING PROCESS	HARDNESS	ADOC	RDOC
Slot (Full Slotting)	< 35 HRC	3.00%-5.00% Diameter	100% Diameter
	≥ 35 HRC	2.50%-4.00% Diameter	100% Diameter
Rgn (Traditional Roughing)	< 35 HRC	Up to Max LOC	20%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-35% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.

HEVF-C-5



COMBINATION FEED & HEM - 5 FLUTE

Chipbreaker Rougher - Variable Pitch

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, cast iron, titanium, and titanium alloys.
- Combination of specialized end profile and OD geometry for both high feed and HEM applications
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- T_{plus} coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

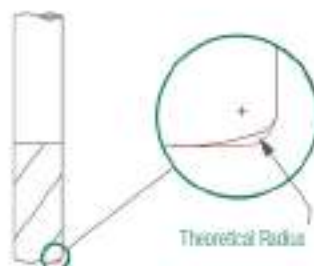


Cutter Dia.* D1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Shank Dia. D2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Length of Cut L2 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Overall Length L1 $\begin{smallmatrix} +.0007 \\ -.0007 \end{smallmatrix}$	Flutes	Theoretical Radius**	T _{plus} Coated	Tool Description
1/4	1/4	3/8	2	5	.0314	84488	HEVF-C-015-50250
	1/4	1/2	2-1/2	5	.0314	84490	HEVF-C-020-50250
	1/4	3/4	2-1/2	5	.0314	84491	HEVF-C-030-50250
	1/4	1	3	5	.0314	87283	HEVF-C-040-50250
3/8	3/8	1/2	2	5	.0471	84492	HEVF-C-013-50375
	3/8	1	3	5	.0471	84493	HEVF-C-026-50375
	3/8	1-1/4	3	5	.0471	84494	HEVF-C-033-50375
	3/8	1-1/2	3-1/2	5	.0471	87284	HEVF-C-040-50375
1/2	1/2	5/8	2-1/2	5	.0628	87285	HEVF-C-012-50600
	1/2	1	3	5	.0628	84495	HEVF-C-020-50600
	1/2	1-1/4	3	5	.0628	84496	HEVF-C-025-50600
	1/2	1-5/8	4	5	.0628	84497	HEVF-C-032-50600
	1/2	2	4	5	.0628	87286	HEVF-C-040-50600
5/8	5/8	1-1/4	3-1/2	5	.0765	84498	HEVF-C-020-50625
	5/8	1-5/8	3-1/2	5	.0765	84499	HEVF-C-026-50625
	5/8	2-1/8	4	5	.0765	84500	HEVF-C-034-50625
3/4	3/4	1	3	5	.0942	84501	HEVF-C-013-50750
	3/4	1-5/8	4	5	.0942	84502	HEVF-C-021-50750
	3/4	2-1/4	5	5	.0942	84503	HEVF-C-030-50750

*.0005 max TIR **Theoretical radius for use when programming in CAM software

Visit www.helicaltool.com to download precise Simulation Files for all Feed Mills.

In the absence of a Simulation File, use the Theoretical Radius to approximate Helical's feed mills as corner radius end mills within your CAM software.



COMBINATION FEED & HEM - 5 FLUTE

Chipbreaker Rougher - Variable Pitch - Coolant Through



HEVFC-C-5

- Offers outstanding performance and high temperature resistance in a wide range of ferrous materials, including low and medium alloy steels, tool steels, cast iron, titanium, and titanium alloys
- Combination of specialized end profile and CD geometry for both high feed and High Efficiency Milling (HEM) applications
- 5 flute variable pitch and offset chipbreaker geometry for optimal chip evacuation, minimized harmonics, and reduced tool pressure
- Center coolant hole for reduced heat, enhanced chip evacuation, and increased material removal rates
- End cutting geometry (non-center cutting)
- h6 shank tolerance for high precision tool holders
- Tplus coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- Solid carbide
- CNC ground in the USA

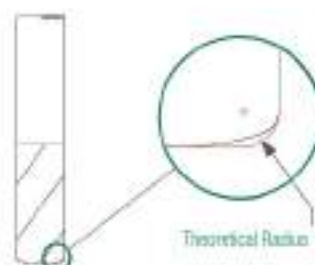


Cutter Dia.* $D_1 \pm .0007$ -.002	Shank Dia. $D_2 \pm .0005$	Length of Cut $L_2 \pm .002$ -.001	Overall Length $L_1 \pm .002$ -.001	Flutes	Theoretical Radius**	Tplus Coated	Tool Description
1/4	1/4	3/8	2	5	.0314	96427	HEVFC C-015-50250
	1/4	1/2	2-1/2	5	.0314	96428	HEVFC C-020-50250
	1/4	3/4	2-1/2	5	.0314	96429	HEVFC C-030-50250
3/8	3/8	1/2	2	5	.0471	96430	HEVFC C-013-50375
	3/8	1	3	5	.0471	96431	HEVFC C-026-50375
	3/8	1-1/4	3	5	.0471	96432	HEVFC C-033-50375
1/2	1/2	1	3	5	.0628	96433	HEVFC C-020-50500
	1/2	1-1/4	3	5	.0628	96434	HEVFC C-035-50500
	1/2	1-5/8	4	5	.0628	96435	HEVFC C-032-50500
5/8	5/8	1-1/4	3-1/2	5	.0785	96436	HEVFC C-030-50625
	5/8	1-5/8	3-1/2	5	.0785	96437	HEVFC C-036-50625
	5/8	2-1/8	4	5	.0785	96438	HEVFC C-034-50625
3/4	3/4	1	3	5	.0942	96439	HEVFC C-013-50750
	3/4	1-5/8	4	5	.0942	96440	HEVFC C-021-50750
	3/4	2-1/4	5	5	.0942	96441	HEVFC C-030-50750

* .0005 max TIR **Theoretical radius for use when programming in CAM software

Visit www.helicaltool.com to download precise Simulation Files for all Feed Mills.

In the absence of a Simulation File, use the Theoretical Radius to approximate Helical's feed mills as corner radius end mills within your CAM software.



Speeds & Feeds on Page 311

HEVF-C-5

SPEEDS & FEEDS
Combination Feed & End Mill - 5 Flute

HEVF-C-5 / HEVFC-C-5

Material Guide	Hardness	IFM	Inches Per Tooth (IPT)													
			1/8		3/16		1/4		5/16		3/8		7/16		1/2	
			Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph	Slot	Rph
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	.0027	.0015	.0040	.0021	.0053	.0029	.0080	.0045	.0107	.0056	.0160	.0080	.0214	.0102
	75-98 HRB	.445	.0020	.0011	.0030	.0015	.0040	.0021	.0060	.0031	.0080	.0041	.0120	.0059	.0160	.0075
	21-36 HRC	.400	.0013	.0007	.0020	.0010	.0027	.0014	.0040	.0020	.0053	.0026	.0080	.0036	.0106	.0046
LOW ALLOY STEEL	75-98 HRB	.390	.0027	.0009	.0040	.0013	.0053	.0018	.0080	.0027	.0107	.0035	.0160	.0051	.0214	.0065
	21-36 HRC	.340	.0027	.0007	.0040	.0010	.0053	.0013	.0080	.0020	.0107	.0026	.0160	.0036	.0214	.0046
	36-50 HRC	.260	.0020	.0006	.0030	.0009	.0040	.0012	.0060	.0017	.0080	.0023	.0120	.0033	.0160	.0042
TOOL STEEL	> 50 HRC	.155	.0013	.0006	.0020	.0007	.0027	.0009	.0040	.0014	.0053	.0016	.0080	.0026	.0106	.0033
	75-98 HRB	.340	.0027	.0009	.0040	.0013	.0053	.0018	.0080	.0027	.0107	.0035	.0160	.0051	.0214	.0065
	21-36 HRC	.250	.0027	.0007	.0040	.0011	.0053	.0015	.0080	.0022	.0107	.0026	.0160	.0040	.0214	.0051
SPECIALTY STEEL	36-50 HRC	.145	.0020	.0006	.0030	.0008	.0040	.0011	.0060	.0017	.0080	.0022	.0120	.0031	.0160	.0040
	> 50 HRC	.08	.0013	.0006	.0020	.0007	.0027	.0009	.0040	.0014	.0053	.0016	.0080	.0026	.0106	.0033
	75-98 HRB	.290	.0027	.0012	.0040	.0018	.0053	.0024	.0080	.0035	.0107	.0046	.0160	.0066	.0214	.0065
ALUMINUM	300M, Inconel 28, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	75-98 HRB	.0027	.0009	.0040	.0012	.0053	.0015	.0080	.0024	.0107	.0032	.0160	.0045	.0214	.0056
	21-36 HRC	.175	.0027	.0009	.0040	.0011	.0053	.0015	.0080	.0022	.0107	.0029	.0160	.0041	.0214	.0052
	36-50 HRC	.150	.0020	.0007	.0030	.0010	.0040	.0013	.0060	.0019	.0080	.0026	.0120	.0037	.0160	.0046
AUSTENITIC STAINLESS STEEL	> 50 HRC	.05	.0013	.0004	.0020	.0009	.0027	.0009	.0040	.0012	.0053	.0016	.0080	.0022	.0106	.0033
	75-98 HRB	.295	.0027	.0009	.0040	.0013	.0053	.0018	.0080	.0026	.0107	.0034	.0160	.0046	.0214	.0065
	21-36 HRC	.225	.0027	.0009	.0040	.0012	.0053	.0015	.0080	.0024	.0107	.0031	.0160	.0044	.0214	.0057
MARTENSITIC & FERRITIC STAINLESS STEEL	Incoloy 27-TMO, 316, 316L, 321, 347	36-50 HRC	.180	.0020	.0007	.0033	.0009	.0043	.0013	.0065	.0019	.0087	.0025	.0130	.0036	.0174
	75-98 HRB	.300	.0025	.0008	.0038	.0013	.0050	.0018	.0075	.0027	.0100	.0035	.0150	.0051	.0200	.0065
	21-36 HRC	.280	.0027	.0008	.0040	.0012	.0053	.0016	.0080	.0024	.0107	.0031	.0160	.0044	.0214	.0056
PH STAINLESS STEEL	405, 410, 416, 438, 440, 442, 446	21-36 HRC	.200	.0025	.0007	.0038	.0010	.0050	.0013	.0075	.0020	.0100	.0036	.0150	.0037	.0200
	36-50 HRC	.140	.0020	.0006	.0030	.0009	.0040	.0012	.0060	.0017	.0080	.0023	.0120	.0032	.0160	.0041
	75-98 HRB	.410	.0027	.0015	.0040	.0022	.0053	.0024	.0080	.0044	.0107	.0057	.0160	.0062	.0214	.0104
GRAY CAST IRON	SAE J431, ASTM A48	21-36 HRC	.370	.0027	.0008	.0040	.0012	.0053	.0016	.0080	.0024	.0107	.0031	.0160	.0045	.0214
	75-98 HRB	.345	.0027	.0011	.0040	.0014	.0053	.0019	.0080	.0028	.0107	.0036	.0160	.0052	.0214	.0066
	ASTM A47, ASTM A226, ASTM A502	21-36 HRC	.335	.0027	.0009	.0040	.0012	.0053	.0019	.0080	.0024	.0107	.0031	.0160	.0045	.0214
MALLEABLE CAST IRON	75-98 HRB	.310	.0027	.0011	.0040	.0014	.0053	.0020	.0080	.0029	.0107	.0038	.0160	.0054	.0214	.0066
	21-36 HRC	.260	.0027	.0007	.0040	.0010	.0053	.0013	.0080	.0019	.0107	.0025	.0160	.0036	.0214	.0046
	36-50 HRC	.135	.0013	.0004	.0020	.0009	.0027	.0008	.0040	.0012	.0053	.0016	.0080	.0023	.0106	.0033
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 697	< 75 HRB	.285	.0027	.0013	.0040	.0018	.0053	.0025	.0080	.0037	.0107	.0048	.0160	.0070	.0214
	75-98 HRB	.250	.0027	.0011	.0040	.0015	.0053	.0021	.0080	.0031	.0107	.0041	.0160	.0056	.0214	.0074
	21-36 HRC	.210	.0027	.0008	.0040	.0012	.0053	.0016	.0080	.0028	.0107	.0034	.0160	.0048	.0214	.0061
PURE NICKEL	Nickel 200, Nickel 201	75-98 HRB	.85	.0027	.0008	.0040	.0009	.0053	.0013	.0080	.0019	.0107	.0025	.0160	.0035	.0214
	21-36 HRC	.75	.0027	.0006	.0040	.0009	.0053	.0012	.0080	.0018	.0107	.0024	.0160	.0034	.0214	.0043
	36-50 HRC	.70	.0020	.0005	.0030	.0008	.0043	.0010	.0065	.0015	.0087	.0020	.0130	.0029	.0174	.0037
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	< 75 HRB	.300	.0027	.0017	.0040	.0025	.0053	.0035	.0080	.0051	.0107	.0067	.0160	.0096	.0214
	75-98 HRB	.275	.0027	.0013	.0040	.0021	.0053	.0029	.0080	.0045	.0107	.0056	.0160	.0061	.0214	.0103
	21-36 HRC	.250	.0027	.0011	.0040	.0018	.0053	.0022	.0080	.0032	.0107	.0042	.0160	.0060	.0214	.0077
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	21-36 HRC	.180	.0027	.0009	.0040	.0013	.0053	.0017	.0080	.0025	.0107	.0033	.0160	.0048	.0214
	36-50 HRC	.160	.0020	.0008	.0038	.0012	.0050	.0016	.0075	.0023	.0100	.0030	.0150	.0043	.0200	.0055
	75-98 HRB	.210	.0020	.0007	.0030	.0011	.0040	.0015	.0060	.0021	.0080	.0026	.0120	.0030	.0160	.0051
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21-36 HRC	.170	.0027	.0007	.0040	.0010	.0053	.0014	.0080	.0021	.0107	.0027	.0160	.0038	.0214
	36-50 HRC	.05	.0020	.0006	.0030	.0007	.0040	.0010	.0060	.0014	.0080	.0016	.0120	.0026	.0160	.0034
	75-98 HRB	.210	.0020	.0007	.0030	.0011	.0040	.0015	.0060	.0021	.0080	.0026	.0120	.0030	.0160	.0051
COBALT ALLOY	ASTM F962, ASTM F966, ASTM F75, ASTM F799	21-36 HRC	.170	.0027	.0007	.0040	.0010	.0053	.0014	.0080	.0021	.0107	.0027	.0160	.0038	.0214
	36-50 HRC	.05	.0020	.0006	.0030	.0007	.0040	.0010	.0060	.0014	.0080	.0016	.0120	.0026	.0160	.0034
	75-98 HRB	.210	.0020	.0007	.0030	.0011	.0040	.0015	.0060	.0021	.0080	.0026	.0120	.0030	.0160	.0051

MILLING PROCESS	HARDNESS	ADOC	ROOC
Slot (Full Slotting)	< 35 HRC	1.00%-5.00% Diameter	100% Diameter
	≥ 35 HRC	2.50%-4.00% Diameter	100% Diameter
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	15%-30% Diameter
	≥ 35 HRC	Up to Max LOC	10%-20% Diameter

Note: IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Adviser Pro.

TAPERED END MILLS - 4 FLUTE

Ball - Variable Pitch

HTPR-4

- Tapered profile designed for use in mold and die pockets and other tapered wall applications
- Engineered for excellent performance in light profiling and finishing applications
- 4 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- h6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Angle Per Side $A_1 \begin{smallmatrix} +0.30^\circ \\ -0.20^\circ \end{smallmatrix}$	Cutter Diameter* $D_1 \begin{smallmatrix} +0.0015\" \\ -0.002\" \end{smallmatrix}$	Shank Diameter $D_2 \text{ (h6)}$	Length of Cut L_2	Overall Length $L_1 \begin{smallmatrix} +0.02\" \\ -0.02\" \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
0.5°	1/8	3/16	3/8	2	4	84870	HTPR05-030-40125-BN
	1/8	3/16	5/8	2	4	84888	HTPR05-050-40125-BN
	3/16	1/4	5/8	2-1/2	4	84876	HTPR05-030-40187-BN
	3/16	1/4	1	2-1/2	4	84894	HTPR05-050-40187-BN
	1/4	5/16	3/4	2-1/2	4	84882	HTPR05-030-40250-BN
	1/4	5/16	1-1/4	3	4	84900	HTPR05-050-40250-BN
1°	1/8	3/16	3/8	2	4	84871	HTPR10-030-40125-BN
	1/8	3/16	5/8	2	4	84889	HTPR10-050-40125-BN
	3/16	1/4	5/8	2-1/2	4	84877	HTPR10-030-40187-BN
	3/16	1/4	1	2-1/2	4	84895	HTPR10-050-40187-BN
	1/4	5/16	3/4	2-1/2	4	84883	HTPR10-030-40250-BN
	1/4	5/16	1-1/4	3	4	84901	HTPR10-050-40250-BN
1.5°	1/8	3/16	3/8	2	4	84872	HTPR15-030-40125-BN
	1/8	3/16	5/8	2	4	84890	HTPR15-050-40125-BN
	3/16	1/4	5/8	2-1/2	4	84878	HTPR15-030-40187-BN
	3/16	1/4	1	2-1/2	4	84896	HTPR15-050-40187-BN
	1/4	5/16	3/4	2-1/2	4	84884	HTPR15-030-40250-BN
	1/4	5/16	1-1/4	3	4	84902	HTPR15-050-40250-BN
2°	1/8	3/16	3/8	2	4	84873	HTPR20-030-40125-BN
	1/8	3/16	5/8	2	4	84891	HTPR20-050-40125-BN
	3/16	1/4	5/8	2-1/2	4	84879	HTPR20-030-40187-BN
	3/16	5/16	1	2-1/2	4	84897	HTPR20-050-40187-BN
	1/4	5/16	3/4	2-1/2	4	84885	HTPR20-030-40250-BN
	1/4	3/8	1-1/4	3	4	84903	HTPR20-050-40250-BN
3°	1/8	3/16	3/8	2	4	84874	HTPR30-030-40125-BN
	1/8	1/4	5/8	2	4	84892	HTPR30-050-40125-BN
	3/16	5/16	5/8	2-1/2	4	84880	HTPR30-030-40187-BN
	3/16	5/16	1	2-1/2	4	84898	HTPR30-050-40187-BN
	1/4	3/8	3/4	2-1/2	4	84886	HTPR30-030-40250-BN
	1/4	1/2	1-1/4	3	4	84904	HTPR30-050-40250-BN
5°	1/8	1/4	3/8	2	4	84875	HTPR50-030-40125-BN
	1/8	1/4	5/8	2	4	84893	HTPR50-050-40125-BN
	3/16	5/16	5/8	2-1/2	4	84881	HTPR50-030-40187-BN
	3/16	3/8	1	2-1/2	4	84899	HTPR50-050-40187-BN
	1/4	1/2	3/4	2-1/2	4	84887	HTPR50-030-40250-BN
	1/4	1/2	1-1/4	3	4	84905	HTPR50-050-40250-BN

*0.0005 max TIR



Speeds & Feeds on Page 313

HTPR-4

SPEEDS & FEEDS

Tapered End Mill - 4 Flute - Ball - Variable Pitch

HTPR-4

Material Guide		Hardness	SPM	Inches Per Tooth (IPT)									
				1/8		1/16		1/4		3/8		1/2	
				Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin	Rph	Fin
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	< 75 HRB	455	.0012	.0016	.0018	.0019	.0024	.0021	.0036	.0024	.0047	.0026
		75-90 HRB	445	.0009	.0014	.0013	.0016	.0018	.0016	.0026	.0021	.0034	.0024
		21-35 HRC	430	.0006	.0011	.0008	.0013	.0011	.0014	.0017	.0017	.0022	.0019
LOW ALLOY STEEL	10XX, 41XX, 43XX, 51XX, 80XX, 93XX	75-90 HRB	390	.0006	.0013	.0011	.0015	.0015	.0017	.0023	.0019	.0030	.0023
		21-35 HRC	340	.0006	.0011	.0008	.0013	.0012	.0014	.0017	.0017	.0022	.0019
		35-50 HRC	290	.0005	.0010	.0007	.0012	.0010	.0013	.0015	.0015	.0019	.0018
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	155	.0004	.0008	.0006	.0010	.0006	.0012	.0012	.0014	.0015	.0016
		75-90 HRB	340	.0006	.0013	.0011	.0015	.0015	.0017	.0023	.0019	.0030	.0023
		21-35 HRC	290	.0006	.0012	.0008	.0013	.0012	.0015	.0016	.0017	.0024	.0020
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	35-50 HRC	145	.0005	.0010	.0007	.0012	.0010	.0013	.0014	.0015	.0019	.0018
		> 50 HRC	85	.0004	.0008	.0006	.0010	.0006	.0012	.0012	.0014	.0015	.0016
		< 75 HRB	290	.0010	.0015	.0016	.0017	.0020	.0019	.0030	.0022	.0039	.0026
AUSTENITIC STAINLESS STEEL	Nitinol 50, Nitronic 50, 301, 305, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75-90 HRB	285	.0006	.0013	.0011	.0015	.0015	.0017	.0022	.0019	.0026	.0022
		21-35 HRC	225	.0007	.0012	.0010	.0014	.0014	.0016	.0020	.0018	.0026	.0021
		35-50 HRC	180	.0006	.0011	.0008	.0012	.0011	.0014	.0016	.0016	.0021	.0019
MARTENSITIC & PHENITIC STAINLESS STEEL	403, 410, 416, 420, 440, 450, 446	75-90 HRB	300	.0006	.0013	.0011	.0015	.0016	.0017	.0023	.0019	.0030	.0023
		21-35 HRC	280	.0007	.0012	.0010	.0014	.0013	.0016	.0020	.0018	.0026	.0021
		> 50 HRC	145	.0005	.0010	.0007	.0012	.0010	.0014	.0014	.0015	.0019	.0018
PH STAINLESS STEEL	15-7, 17-4, Carpenter 430, Carpenter 455	21-35 HRC	290	.0006	.0011	.0008	.0012	.0011	.0014	.0017	.0016	.0022	.0019
		35-50 HRC	145	.0005	.0010	.0007	.0012	.0010	.0014	.0014	.0015	.0019	.0018
		< 75 HRB	285	.0006	.0013	.0011	.0015	.0015	.0017	.0022	.0019	.0026	.0022
GRAY CAST IRON	SAE J431, ASTM A48	75-90 HRB	410	.0013	.0017	.0018	.0019	.0025	.0021	.0037	.0025	.0048	.0029
		21-35 HRC	370	.0007	.0012	.0010	.0014	.0013	.0016	.0020	.0018	.0026	.0021
		> 50 HRC	135	.0004	.0008	.0006	.0010	.0007	.0012	.0012	.0014	.0015	.0016
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A480	75-90 HRB	345	.0006	.0013	.0012	.0015	.0016	.0017	.0023	.0019	.0031	.0023
		21-35 HRC	335	.0007	.0012	.0010	.0014	.0014	.0016	.0020	.0018	.0026	.0021
		> 50 HRC	135	.0004	.0008	.0006	.0010	.0007	.0012	.0012	.0014	.0015	.0016
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM A537	75-90 HRB	370	.0006	.0013	.0012	.0015	.0016	.0017	.0023	.0019	.0031	.0023
		21-35 HRC	360	.0006	.0011	.0008	.0012	.0011	.0014	.0016	.0016	.0021	.0019
		35-50 HRC	135	.0004	.0008	.0006	.0010	.0007	.0012	.0012	.0014	.0015	.0016
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0011	.0015	.0016	.0017	.0021	.0020	.0031	.0023	.0041	.0026
		75-90 HRB	250	.0009	.0014	.0013	.0016	.0016	.0018	.0025	.0021	.0034	.0024
		> 50 HRC	135	.0004	.0008	.0006	.0010	.0007	.0012	.0012	.0014	.0015	.0016
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, Rene 41, Inconel 718, Incoloy 20	75-90 HRB	60	.0005	.0011	.0008	.0012	.0011	.0014	.0016	.0016	.0021	.0019
		21-35 HRC	75	.0005	.0011	.0008	.0012	.0010	.0014	.0015	.0016	.0020	.0018
		35-50 HRC	70	.0005	.0010	.0007	.0011	.0008	.0013	.0013	.0015	.0017	.0017
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0015	.0018	.0022	.0020	.0025	.0023	.0043	.0027	.0057	.0031
		75-90 HRB	275	.0012	.0017	.0016	.0019	.0024	.0021	.0036	.0024	.0047	.0028
		21-35 HRC	250	.0009	.0014	.0014	.0016	.0018	.0016	.0027	.0021	.0036	.0025
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21-35 HRC	180	.0007	.0013	.0011	.0014	.0014	.0016	.0021	.0019	.0026	.0022
		35-50 HRC	180	.0007	.0012	.0010	.0014	.0013	.0016	.0020	.0018	.0026	.0021
		> 50 HRC	135	.0004	.0008	.0006	.0010	.0007	.0012	.0012	.0014	.0015	.0016
COBALT ALLOY	ASTM F962, ASTM F960, ASTM F75, ASTM F759	75-90 HRB	210	.0006	.0012	.0008	.0013	.0012	.0015	.0016	.0017	.0024	.0020
		21-35 HRC	170	.0006	.0011	.0008	.0013	.0012	.0015	.0017	.0017	.0023	.0020
		35-50 HRC	65	.0004	.0008	.0006	.0010	.0006	.0012	.0012	.0014	.0015	.0016

MILLING PROCESS	HARDNESS	APOC	RPOC
Rph (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-35% Diameter
Fin (Finishing)	< 35 HRC	Up to Max LOC	4%-6% Diameter
	≥ 35 HRC	Up to Max LOC	4%-6% Diameter

Note: Speed (SPM) and feed (IPT) numbers shown in table above are considered to be average values. Use a tolerance of +/-25% as needed.

Effective cutter diameter should be used to select the proper chipload per tooth.

TAPERED END MILLS - 5 FLUTE

Square - Variable Pitch

HTPR-5

- Tapered profile designed for use in mold and die pockets and other tapered wall applications
- Engineered for excellent performance in light profiling and finishing applications
- 5 flute variable pitch design for reduced harmonics and increased feed rates
- Center cutting
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Angle Per Side A1 $\begin{smallmatrix} +0.02 \\ -0.02 \end{smallmatrix}$	Cutter Dia.* D1 $\begin{smallmatrix} +0.007 \\ -0.02 \end{smallmatrix}$	Shank Diameter D2 H9	Length of Cut L2	Overall Length L1 $\begin{smallmatrix} +0.02 \\ -0.02 \end{smallmatrix}$	Flutes	Aplus Coated	Tool Description
0.5°	1/8	3/16	3/8	2	5	84906	HTPR005-030-50125
	1/8	3/16	5/8	2	5	84924	HTPR005-150-50125
	3/16	1/4	5/8	2-1/2	5	84912	HTPR005-033-50187
	3/16	1/4	1	2-1/2	5	84930	HTPR005-153-50187
	1/4	5/16	3/4	2-1/2	5	84918	HTPR005-030-50250
	1/4	5/16	1-1/4	3	5	84936	HTPR005-150-50250
1°	1/8	3/16	3/8	2	5	84907	HTPR010-030-50125
	1/8	3/16	5/8	2	5	84925	HTPR010-150-50125
	3/16	1/4	5/8	2-1/2	5	84913	HTPR010-033-50187
	3/16	1/4	1	2-1/2	5	84931	HTPR010-153-50187
	1/4	5/16	3/4	2-1/2	5	84919	HTPR010-030-50250
	1/4	5/16	1-1/4	3	5	84937	HTPR010-150-50250
1.5°	1/8	3/16	3/8	2	5	84908	HTPR015-030-50125
	1/8	3/16	5/8	2	5	84926	HTPR015-150-50125
	3/16	1/4	5/8	2-1/2	5	84914	HTPR015-033-50187
	3/16	1/4	1	2-1/2	5	84932	HTPR015-153-50187
	1/4	5/16	3/4	2-1/2	5	84920	HTPR015-030-50250
	1/4	3/8	1-1/4	3	5	84938	HTPR015-150-50250
2°	1/8	3/16	3/8	2	5	84909	HTPR020-030-50125
	1/8	3/16	5/8	2	5	84927	HTPR020-150-50125
	3/16	1/4	5/8	2-1/2	5	84915	HTPR020-033-50187
	3/16	5/16	1	2-1/2	5	84933	HTPR020-153-50187
	1/4	5/16	3/4	2-1/2	5	84921	HTPR020-030-50250
	1/4	3/8	1-1/4	3	5	84939	HTPR020-150-50250
3°	1/8	3/16	3/8	2	5	84910	HTPR030-030-50125
	1/8	1/4	5/8	2	5	84928	HTPR030-150-50125
	3/16	5/16	5/8	2-1/2	5	84916	HTPR030-033-50187
	3/16	5/16	1	2-1/2	5	84934	HTPR030-153-50187
	1/4	3/8	3/4	2-1/2	5	84922	HTPR030-030-50250
	1/4	1/2	1-1/4	3	5	84940	HTPR030-150-50250
5°	1/8	1/4	3/8	2	5	84911	HTPR050-030-50125
	1/8	1/4	5/8	2	5	84929	HTPR050-150-50125
	3/16	5/16	5/8	2-1/2	5	84917	HTPR050-033-50187
	3/16	3/8	1	2-1/2	5	84935	HTPR050-153-50187
	1/4	1/2	3/4	2-1/2	5	84923	HTPR050-030-50250
	1/4	1/2	1-1/4	3	5	84941	HTPR050-150-50250

*0.005 max TIR

HTPR-5

SPEEDS & FEEDS

Tapered End Mill - 5 Flute - Square - Variable Pitch

HTPR-5													
Material Grade		Hardness	SFM	Inches Per Tooth (IPT)									
				1/8		3/16		1/4		3/8		1/2	
				Rph	Fp	Rph	Fp	Rph	Fp	Rph	Fp	Rph	Fp
CARBON STEEL	10XX, 11XX, 12XX, 13XX, ASTM A27, ASTM A36	<75 HRB	455	.0015	.0016	.0021	.0020	.0029	.0022	.0043	.0026	.0030	
		75-98 HRC	445	.0011	.0008	.0015	.0017	.0021	.0018	.0031	.0022	.0041	
		21-35 HRC	405	.0017	.0012	.0010	.0014	.0014	.0015	.0020	.0018	.0028	
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 82XX	75-98 HRC	390	.0009	.0014	.0013	.0016	.0016	.0018	.0027	.0021	.0035	
		21-35 HRC	340	.0017	.0012	.0010	.0013	.0013	.0015	.0020	.0019	.0028	
		36-50 HRC	290	.0006	.0011	.0008	.0013	.0012	.0014	.0017	.0017	.0023	
TOOL STEEL	A2, H13, L6, P30, S7	>50 HRC	155	.0005	.0010	.0007	.0011	.0009	.0013	.0016	.0015	.0018	
		75-98 HRC	340	.0009	.0014	.0013	.0016	.0016	.0018	.0027	.0021	.0035	
		21-35 HRC	290	.0017	.0012	.0010	.0014	.0015	.0016	.0022	.0019	.0028	
SPECIALTY STEEL	300M, Invar 36, Kovar, Monel 200, Monel 201, Monel 300, Monel 304	75-98 HRC	340	.0009	.0014	.0013	.0016	.0016	.0018	.0027	.0021	.0035	
		21-35 HRC	290	.0017	.0012	.0010	.0014	.0015	.0016	.0022	.0019	.0028	
		36-50 HRC	155	.0005	.0010	.0007	.0011	.0009	.0013	.0016	.0015	.0018	
AUSTENITIC STAINLESS STEEL	30XX, Invar 36, Kovar, Monel 200, Monel 201, Monel 300, Monel 304	<75 HRB	290	.0012	.0016	.0018	.0016	.0024	.0020	.0035	.0024	.0048	
		75-98 HRC	250	.0008	.0013	.0012	.0015	.0015	.0017	.0024	.0019	.0032	
		21-35 HRC	170	.0008	.0013	.0011	.0014	.0015	.0018	.0022	.0019	.0029	
FERRITIC & MARTENSITIC STAINLESS STEEL	403, 410, 416, 420, 440, 440, 445	75-98 HRC	290	.0009	.0014	.0013	.0016	.0016	.0018	.0027	.0021	.0035	
		21-35 HRC	220	.0008	.0013	.0012	.0015	.0015	.0017	.0024	.0019	.0031	
		36-50 HRC	180	.0007	.0012	.0009	.0013	.0013	.0015	.0019	.0017	.0025	
PH STAINLESS STEEL	17-4, 17-7, Carpenter 465, Carpenter 468	75-98 HRC	300	.0009	.0014	.0013	.0016	.0016	.0018	.0027	.0021	.0035	
		21-35 HRC	290	.0008	.0013	.0012	.0015	.0015	.0017	.0024	.0019	.0031	
		36-50 HRC	145	.0006	.0011	.0009	.0013	.0012	.0014	.0017	.0016	.0023	
GRAY CAST IRON	SAE J431, ASTM A48	75-98 HRC	410	.0015	.0016	.0022	.0020	.0029	.0023	.0044	.0026	.0030	
		21-35 HRC	370	.0009	.0013	.0012	.0015	.0015	.0017	.0024	.0019	.0031	
		36-50 HRC	340	.0010	.0014	.0014	.0016	.0019	.0018	.0028	.0021	.0036	
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A222	75-98 HRC	340	.0010	.0014	.0014	.0016	.0019	.0018	.0028	.0021	.0036	
		21-35 HRC	335	.0008	.0013	.0012	.0015	.0015	.0017	.0024	.0019	.0031	
		36-50 HRC	310	.0010	.0014	.0014	.0016	.0019	.0018	.0028	.0021	.0036	
MODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 807	75-98 HRC	310	.0010	.0014	.0014	.0016	.0019	.0018	.0028	.0021	.0036	
		21-35 HRC	260	.0007	.0012	.0010	.0013	.0013	.0015	.0019	.0017	.0025	
		36-50 HRC	135	.0004	.0009	.0008	.0010	.0009	.0012	.0012	.0014	.0018	
PURE NICKEL	Nickel 200, Nickel 201	<75 HRB	285	.0013	.0017	.0018	.0019	.0025	.0021	.0037	.0024	.0049	
		75-98 HRC	250	.0011	.0015	.0015	.0017	.0021	.0019	.0031	.0022	.0041	
		21-35 HRC	70	.0006	.0012	.0009	.0013	.0013	.0015	.0019	.0017	.0025	
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Inconel 29	75-98 HRC	80	.0006	.0012	.0009	.0013	.0013	.0015	.0019	.0017	.0025	
		21-35 HRC	70	.0006	.0012	.0009	.0013	.0013	.0015	.0019	.0017	.0025	
		36-50 HRC	70	.0005	.0010	.0008	.0012	.0010	.0014	.0015	.0015	.0020	
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	<75 HRB	300	.0017	.0019	.0025	.0022	.0035	.0025	.0051	.0028	.0033	
		75-98 HRC	275	.0015	.0016	.0021	.0020	.0029	.0023	.0043	.0026	.0030	
		21-35 HRC	250	.0011	.0015	.0016	.0017	.0022	.0020	.0032	.0022	.0042	
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 12V-2Fe-3Al	75-98 HRC	160	.0009	.0014	.0013	.0015	.0017	.0017	.0025	.0020	.0033	
		21-35 HRC	160	.0008	.0013	.0012	.0015	.0015	.0017	.0023	.0019	.0030	
		36-50 HRC	160	.0008	.0013	.0012	.0015	.0015	.0017	.0023	.0019	.0030	
COBALT ALLOY	ASTM F962, ASTM F90, ASTM F75, ASTM F799	75-98 HRC	210	.0007	.0012	.0011	.0014	.0015	.0016	.0021	.0019	.0028	
		21-35 HRC	170	.0007	.0012	.0010	.0014	.0014	.0016	.0021	.0018	.0027	
		36-50 HRC	85	.0005	.0010	.0007	.0011	.0010	.0013	.0014	.0015	.0018	

Note: Speed (SFM) and feed (IPT) numbers shown in table above are considered to be average values. Use a tolerance of +/-25% as needed.

Effective cutter diameter should be used to select the proper chipload per tooth.

MILLING PROCESS	HARDNESS	APOG	RPOG
Rph (Traditional Roughing)	<35 HRC	Up to Max LOC	30%-40% Diameter
	≥35 HRC	Up to Max LOC	25%-35% Diameter
Fp (Finishing)	<35 HRC	Up to Max LOC	4%-6% Diameter
	≥35 HRC	Up to Max LOC	4%-6% Diameter

CHAMFER MILLS - STRAIGHT FLUTE

HCM

2 & 4 Flute

- Designed for universal chamfering applications
- Offered with 2 and 4 flutes for soft and hard materials
- Ground with positive axial rake and clearance for optimal performance
- H6 shank tolerance for high precision tool holders
- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life
- Solid carbide
- CNC ground in the USA



Included Angle A $\pm \frac{0.001}{0.001}$	Shank Diameter* D2 (in)	Web Thickness (in)	Length of Cut L2	Overall Length L1 $\pm \frac{0.002}{0.002}$	Flutes	Uncoated	Aplus Coated	Tool Description
60°	1/8	.015	.108	2	2	06225	06228	HCM60-20125
	3/16	.018	.162	2	2	06240	06243	HCM60-20187
	3/16	.018	.162	2	4	06330	06333	HCM60-40187
	1/4	.020	.216	2-1/2	2	06255	06258	HCM60-20250
	1/4	.020	.216	2-1/2	4	06340	06348	HCM60-40250
	5/16	.028	.270	2-1/2	2	06772	06773	HCM60-20312
	5/16	.028	.270	2-1/2	4	06774	06775	HCM60-40312
	3/8	.035	.324	2-1/2	2	06270	06273	HCM60-20375
	3/8	.035	.324	2-1/2	4	06360	06363	HCM60-40375
	1/2	.040	.433	3	2	06285	06288	HCM60-20500
	1/2	.040	.433	3	4	06375	06378	HCM60-40500
	5/8	.042	.541	3	2	06780	06781	HCM60-20625
	5/8	.042	.541	3	4	06782	06783	HCM60-40625
	3/4	.045	.649	3	2	06788	06789	HCM60-20750
	3/4	.045	.649	3	4	06390	06393	HCM60-40750
90°	1/8	.015	.062	2	2	06015	06018	HCM90-20125
	3/16	.018	.093	2	2	06030	06033	HCM90-20187
	3/16	.018	.093	2	4	06120	06123	HCM90-40187
	1/4	.020	.125	2-1/2	2	06045	06048	HCM90-20250
	1/4	.020	.125	2-1/2	4	06135	06138	HCM90-40250
	5/16	.028	.156	2-1/2	2	06776	06777	HCM90-20312
	5/16	.028	.156	2-1/2	4	06778	06779	HCM90-40312
	3/8	.035	.187	2-1/2	2	06060	06063	HCM90-20375
	3/8	.035	.187	2-1/2	4	06150	06153	HCM90-40375
	1/2	.040	.250	3	2	06075	06078	HCM90-20500
	1/2	.040	.250	3	4	06165	06168	HCM90-40500
	5/8	.042	.312	3	2	06784	06785	HCM90-20625
	5/8	.042	.312	3	4	06786	06787	HCM90-40625
	3/4	.045	.375	3	2	06790	06791	HCM90-20750
	3/4	.045	.375	3	4	06180	06183	HCM90-40750
120°	1/8	.015	.037	2	2	06405	06408	HCM120-20125
	3/16	.018	.056	2	2	06420	06423	HCM120-20187
	3/16	.018	.056	2	4	06480	06483	HCM120-40187
	1/4	.020	.075	2-1/2	2	06435	06438	HCM120-20250
	1/4	.020	.075	2-1/2	4	06495	06498	HCM120-40250
	3/8	.025	.112	2-1/2	2	06450	06453	HCM120-20375
	3/8	.025	.112	2-1/2	4	06510	06513	HCM120-40375
	1/2	.040	.150	3	2	06465	06468	HCM120-20500
	1/2	.040	.150	3	4	06525	06528	HCM120-40500
	3/4	.045	.225	3	4	06540	06543	HCM120-40750

* .0005 max TIR



Speeds & Feeds on Page 317

HCM

SPEEDS & FEEDS
Chamfer Mills - Straight Flute

HCM												
Material Guide		Hardness	SFM	Inches Per Tooth (IPT)								
				Effective Cutting Diameter (Def)								
				< .125	≥ .125 < .1875	≥ .1875 < .25	≥ .25 < .3125	≥ .3125 < .375	≥ .375 < .5	≥ .5 < .625	≥ .625 < .75	≥ .75
WEIGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	< 120 HBS	2200	.0009	.0018	.0028	.0035	.0045	.0055	.0070	.0090	.0110
		≥ 120 HBS	2200	.0006	.0012	.0018	.0022	.0028	.0035	.0045	.0055	.0070
CAST ALUMINUM ALLOY	315.0, 335.0, 355.0, 390.0, 390.0, 393.0, 420.0, 520.0, 535.0	< 120 HBS	1800	.0012	.0025	.0040	.0060	.0080	.0090	.0100	.0130	.0150
		≥ 120 HBS	1800	.0010	.0020	.0030	.0040	.0050	.0060	.0080	.0100	.0120
COPPER ALLOY	Cu-60TP, Cu-60Z, Cu-20Zn, Cu-20Pb, Cu-20Sn, Cu-60S	< 75 HRC	600	.0007	.0015	.0023	.0030	.0035	.0045	.0060	.0070	.0090
		75-90 HRC	450	.0007	.0010	.0023	.0028	.0035	.0045	.0055	.0070	.0090
CARBON STEEL	100X, 110X, 120X, 12LXX, ASTM A27, ASTM A36	< 75 HRC	450	.0010	.0020	.0030	.0040	.0050	.0060	.0080	.0100	.0120
		75-90 HRC	450	.0007	.0015	.0020	.0028	.0035	.0040	.0055	.0070	.0090
		21-36 HRC	400	.0005	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
		36-50 HRC	300	.0003	.0006	.0009	.0012	.0015	.0020	.0025	.0030	.0040
LOW ALLOY STEEL	100X, 410X, 430X, 51XX, 86XX, 93XX	75-90 HRC	400	.0006	.0012	.0018	.0025	.0030	.0035	.0050	.0060	.0070
		21-36 HRC	380	.0005	.0009	.0015	.0018	.0022	.0028	.0035	.0045	.0055
		36-50 HRC	300	.0003	.0006	.0009	.0012	.0015	.0020	.0025	.0030	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
TOOL STEEL	A2, H13, L8, P20, S7	75-90 HRC	325	.0005	.0011	.0018	.0022	.0028	.0035	.0045	.0055	.0070
		21-36 HRC	290	.0005	.0009	.0015	.0018	.0022	.0028	.0035	.0045	.0055
		36-50 HRC	190	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0030	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRC	390	.0006	.0012	.0020	.0025	.0030	.0040	.0050	.0060	.0080
		75-90 HRC	400	.0005	.0011	.0015	.0020	.0028	.0030	.0040	.0055	.0060
		21-36 HRC	225	.0004	.0009	.0012	.0018	.0022	.0025	.0035	.0045	.0050
		36-50 HRC	140	.0004	.0008	.0012	.0015	.0020	.0022	.0030	.0040	.0045
AUSTENITIC STAINLESS STEEL	304, 304L, 316, 316L, 321, 347	75-90 HRC	250	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		21-36 HRC	225	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0050
		36-50 HRC	175	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75-90 HRC	325	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		21-36 HRC	300	.0005	.0011	.0018	.0022	.0028	.0035	.0045	.0055	.0070
		36-50 HRC	190	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
PH STAINLESS STEEL	15-5, 17-4, Carpenter 405, Carpenter 480	21-36 HRC	225	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		36-50 HRC	120	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
GRAY CAST IRON	SAE J431, ASTM A48	75-90 HRC	450	.0011	.0022	.0035	.0045	.0055	.0070	.0090	.0110	.0130
		21-36 HRC	400	.0006	.0015	.0022	.0030	.0040	.0045	.0060	.0080	.0090
		36-50 HRC	300	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A802	75-90 HRC	380	.0007	.0012	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		21-36 HRC	300	.0005	.0009	.0015	.0020	.0022	.0028	.0040	.0045	.0055
		36-50 HRC	225	.0007	.0012	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		21-36 HRC	270	.0005	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
MODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 687	75-90 HRC	325	.0007	.0012	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		21-36 HRC	270	.0005	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
		36-50 HRC	190	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRC	450	.0006	.0015	.0022	.0030	.0040	.0045	.0060	.0080	.0090
		75-90 HRC	450	.0007	.0015	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		36-50 HRC	300	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Inconel 20	75-90 HRC	175	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		21-36 HRC	190	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0050
		36-50 HRC	120	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRC	390	.0009	.0018	.0028	.0035	.0045	.0055	.0070	.0090	.0110
		75-90 HRC	400	.0005	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
		21-36 HRC	350	.0005	.0011	.0015	.0022	.0028	.0030	.0045	.0055	.0060
		36-50 HRC	200	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75-90 HRC	325	.0007	.0012	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		21-36 HRC	270	.0005	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
		36-50 HRC	190	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030
COBALT ALLOY	ASTM F962, ASTM F963, ASTM F75, ASTM F799	75-90 HRC	225	.0003	.0008	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		21-36 HRC	190	.0004	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0050
		36-50 HRC	120	.0003	.0007	.0010	.0012	.0015	.0020	.0025	.0035	.0040
		> 50 HRC	80	.0002	.0005	.0007	.0010	.0012	.0015	.0020	.0025	.0030

NOTES:

Speed (SFM) and feed (IPT) numbers shown in the table above are considered to be average values. Use a tolerance of $\pm 25\%$ as needed.

Hardness Scales: HBS = Brinell (500-kgf steel ball)

HRB = Rockwell B

HRC = Rockwell C

CHAMFER MILLS - HELICAL FLUTE

New Items!

HPCM

2 & 4 Flute - High Performance - Pointed

- Helically ground with positive axial rake and clearance for high performance chamfering
- Helical flute geometry results in superior part finish
- Pointed tip for precise applications and detailed workpieces
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance
- Aplus coating for added lubricity and higher speeds and feeds in a wide variety of ferrous metals and titanium alloys
- Solid carbide
- CNC ground in the USA



Incl. Angle A +0°30' -0°30'	Shank Dia.* D2 H6	LOC L2	Overall Length L1 +0°30' -0°30'	Web Thickness MAX	Flutes	Zplus Coated	Aplus Coated	Tool Description	
60°	1/8	100	1-1/2	.010	2	83836	83780	HPCM60-20125	
	1/8	90	1-1/2	.010	4		88809	HPCM60-40125	new
	3/16	154	2	.010	2	83838	83782	HPCM60-20187	
	3/16	154	2	.010	4		83784	HPCM60-40187	
	1/4	208	2-1/2	.010	2	83840	83786	HPCM60-20250	
	1/4	208	2-1/2	.010	4		83788	HPCM60-40250	
	3/8	316	2-1/2	.010	2	83842	83790	HPCM60-20375	
	3/8	316	2-1/2	.010	4		83792	HPCM60-40375	
	1/2	424	3	.010	2	83844	83794	HPCM60-20500	
	1/2	424	3	.010	4		83796	HPCM60-40500	
	5/8	533	3	.015	4		88810	HPCM60-40625	new
	3/4	637	3	.015	4		88811	HPCM60-40750	new
90°	1/8	058	1-1/2	.010	2	83846	83798	HPCM90-20125	
	1/8	058	1-1/2	.010	4		83800	HPCM90-40125	
	3/16	089	2	.010	2	83848	83802	HPCM90-20187	
	3/16	089	2	.010	4		83804	HPCM90-40187	
	1/4	120	2-1/2	.010	2	83850	83806	HPCM90-20250	
	1/4	120	2-1/2	.010	4		83808	HPCM90-40250	
	3/8	183	2-1/2	.010	2	83852	83810	HPCM90-20375	
	3/8	183	2-1/2	.010	4		83812	HPCM90-40375	
	1/2	245	3	.010	2	83854	83814	HPCM90-20500	
	1/2	245	3	.010	4		83816	HPCM90-40500	
	5/8	308	3	.015	4		88812	HPCM90-40625	new
	3/4	370	3	.015	4		88813	HPCM90-40750	new
120°	1/8	033	1-1/2	.010	2	83856	83818	HPCM120-20125	
	1/8	033	1-1/2	.010	4		88814	HPCM120-40125	new
	3/16	051	2	.010	2	83858	83820	HPCM120-20187	
	3/16	051	2	.010	4		83822	HPCM120-40187	
	1/4	069	2-1/2	.010	2	83860	83824	HPCM120-20250	
	1/4	069	2-1/2	.010	4		83826	HPCM120-40250	
	3/8	105	2-1/2	.010	2	83862	83828	HPCM120-20375	
	3/8	105	2-1/2	.010	4		83830	HPCM120-40375	
	1/2	141	3	.010	2	83864	83832	HPCM120-20500	
	1/2	141	3	.010	4		83834	HPCM120-40500	
	5/8	178	3	.015	4		88815	HPCM120-40625	new
	3/4	214	3	.015	4		88816	HPCM120-40750	new

* .0005 max TIR



Speeds & Feeds on Page 321

HPCM

New Items!

CHAMFER MILLS - HELICAL FLUTE
3 & 5 Flute - High Performance - Tipped-Off

- Helically ground with positive axial rake and clearance for high performance chamfering
- Helical flute geometry results in superior part finish
- Flat tip diameter for programming accuracy and increased strength
- h6 shank tolerance for high precision tool holders
- Zplus coating offers higher hardness and added lubricity for maximum performance in non-ferrous materials

- Aplus coating offers added lubricity and high temperature resistance for faster speeds and feeds and improved tool life in ferrous materials
- Solid carbide
- CNC ground in the USA



	Incl. Angle A	Shank Dia.* D2	LDC L2	Overall Length L1	Theoretical Tip Length L3	Tip Diameter D3	Flutes	Zplus Coated	Aplus Coated	Tool Description
	$A = \frac{17.32}{0.707}$			$L1 = \frac{0.625}{0.625}$		$D3 = \frac{0.625}{0.625}$				
new	60°	1/8	0736	1-1/2	035	040	3	83880	83866	HPCM60-30125
		1/8	0736	1-1/2	035	040	5	88440	84582	HPCM60-50125
		3/16	1190	2	043	050	3	83862	83868	HPCM60-30187
		3/16	1190	2	043	050	5	88441	83870	HPCM60-50187
		1/4	1645	2-1/2	052	060	3	59815	07001	HPCM60-30250
		1/4	1645	2-1/2	052	060	5	88442	59806	HPCM60-50250
		3/8	2641	2-1/2	061	070	3	59816	07002	HPCM60-30375
		3/8	2641	2-1/2	061	070	5	88443	07002	HPCM60-50375
		1/2	3637	3	069	080	3	59817	07003	HPCM60-30500
		1/2	3637	3	069	080	5	88444	07003	HPCM60-50500
		5/8	4633	3	078	090	3	59818	07004	HPCM60-30625
		5/8	4633	3	078	090	5	88445	07004	HPCM60-50625
new	82°	3/4	5629	3	087	100	3	59819	07005	HPCM60-30750
		3/4	5629	3	087	100	5	88446	07005	HPCM60-50750
		1/8	0408	1-1/2	023	040	3	84586	84580	HPCM82-30125
		1/8	0408	1-1/2	023	040	5	88447	84584	HPCM82-50125
		3/16	0799	2	029	050	3	84586	84585	HPCM82-30187
		3/16	0799	2	029	050	5	88448	84586	HPCM82-50187
		1/4	1092	2-1/2	035	060	3	84607	84601	HPCM82-30250
		1/4	1092	2-1/2	035	060	5	88449	84602	HPCM82-50250
		3/8	1754	2-1/2	040	070	3	84608	84603	HPCM82-30375
		3/8	1754	2-1/2	040	070	5	88450	84604	HPCM82-50375
		1/2	2415	3	046	080	3	84609	84605	HPCM82-30500
		1/2	2415	3	046	080	5	88451	84606	HPCM82-50500
new	90°	5/8	3077	3	052	090	3	88420	88421	HPCM82-30625
		5/8	3077	3	052	090	5	88422	88423	HPCM82-50625
		3/4	3738	3	058	100	3	88424	88425	HPCM82-30750
		3/4	3738	3	058	100	5	88426	88427	HPCM82-50750
		1/8	0425	1-1/2	020	040	3	83884	83872	HPCM90-30125
		1/8	0425	1-1/2	020	040	5	88452	83874	HPCM90-50125
new	90°	3/16	0687	2	025	050	3	83886	83876	HPCM90-30187
		3/16	0687	2	025	050	5	88453	83878	HPCM90-50187
		1/4	0969	2-1/2	030	060	3	59820	07008	HPCM90-30250
new	90°	1/4	0969	2-1/2	030	060	5	88454	59807	HPCM90-50250

* .0005 max TIR

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Speeds & Feeds on Page 321

CHAMFER MILLS - HELICAL FLUTE

New Items!

HPCM

3 & 5 Flute - High Performance - Tipped-Off (cont.)

continued from previous page

Incl. Angle	Shank Dia.*	LOC	Overall Length	Theoretical Tip Length	Tip Diameter	Flutes	Zrflute Coated	Apflute Coated	Tool Description	
A $\pm \frac{.0025}{.0025}$	D2 (H8)	L2	L1 $\pm \frac{.002}{.002}$	L3	D3 $\pm \frac{.002}{.002}$					
90°	5/16	.1237	2-1/2	.033	.065	3	88428	88429	HPCM90-30312	new
	5/16	.1237	2-1/2	.033	.065	5	88430	88431	HPCM90-30312	new
	3/8	.1525	2-1/2	.035	.070	3	59021	07009	HPCM90-30375	
	3/8	.1525	2-1/2	.035	.070	5	88455	07020	HPCM90-30375	new
	3/8	.1525	4	.026	.070	5	88456	81838	HPCM90-30375	new
	1/2	.2100	3	.040	.080	3	59022	07010	HPCM90-30500	
	1/2	.2100	3	.040	.080	5	88457	07029	HPCM90-30500	new
	1/2	.2100	6	.040	.080	5	88458	81839	HPCM90-30500	new
	5/8	.2675	3	.045	.090	3	59023	07011	HPCM90-30625	
	5/8	.2675	3	.045	.090	5	88459	07030	HPCM90-30625	new
	3/4	.3250	3	.050	.100	3	59024	07012	HPCM90-30750	
	3/4	.3250	3	.050	.100	5	88460	07031	HPCM90-30750	new
100°	1	.4400	4	.060	.120	5	88461	82662	HPCM90-51000	new
	1/8	.0356	1-1/2	.017	.040	3	84597	84587	HPCM100-30125	
	1/8	.0356	1-1/2	.017	.040	5	88462	84588	HPCM100-30125	new
	3/16	.0578	2	.021	.050	3	84598	84589	HPCM100-30187	
	3/16	.0578	2	.021	.050	5	88463	84590	HPCM100-30187	new
	1/4	.0797	2-1/2	.025	.060	3	59025	59009	HPCM100-30250	
	1/4	.0797	2-1/2	.025	.060	5	88464	59812	HPCM100-30250	new
	3/8	.1279	2-1/2	.029	.070	3	59026	59810	HPCM100-30375	
	3/8	.1279	2-1/2	.029	.070	5	88465	59813	HPCM100-30375	new
	1/2	.1762	3	.034	.080	3	59027	59811	HPCM100-30500	
	1/2	.1762	3	.034	.080	5	88466	59814	HPCM100-30500	new
	5/8	.2244	3	.038	.090	3	88432	88433	HPCM100-30625	new
120°	5/8	.2244	3	.038	.090	5	88434	88435	HPCM100-30625	new
	3/4	.2727	3	.042	.100	3	88436	88437	HPCM100-30750	new
	3/4	.2727	3	.042	.100	5	88438	88439	HPCM100-30750	new
	1/8	.0245	1-1/2	.012	.040	3	84599	84591	HPCM120-30125	
	1/8	.0245	1-1/2	.012	.040	5	88467	84592	HPCM120-30125	new
	3/16	.0396	2	.014	.050	3	84600	84593	HPCM120-30187	
	3/16	.0396	2	.014	.050	5	88468	84594	HPCM120-30187	new
	1/4	.0548	2-1/2	.017	.060	3	59028	07015	HPCM120-30250	
	1/4	.0548	2-1/2	.017	.060	5	88469	59806	HPCM120-30250	new
	3/8	.0880	2-1/2	.020	.070	3	59029	07016	HPCM120-30375	
	3/8	.0880	2-1/2	.020	.070	5	88470	07034	HPCM120-30375	new
	1/2	.1212	3	.023	.080	3	59030	07017	HPCM120-30500	
	1/2	.1212	3	.023	.080	5	88471	07035	HPCM120-30500	new
	5/8	.1544	3	.026	.090	3	59031	07018	HPCM120-30625	
	5/8	.1544	3	.026	.090	5	88472	07036	HPCM120-30625	new
	3/4	.1876	3	.029	.100	3	59032	07019	HPCM120-30750	
	3/4	.1876	3	.029	.100	5	88473	07037	HPCM120-30750	new

*.0005 max TIR

HPCM

SPEEDS & FEEDS
Chamfer Mills - Helical Flute

HPCM												
Material Guide		Hardness	SFM	Inches Per Tooth (IPT)								
				Effective Cutting Diameter (Def)								
				< .125	≥ .125 < .1875	≥ .1875 < .25	≥ .25 < .3125	≥ .3125 < .375	≥ .375 < .5	≥ .5 < .625	≥ .625 < .75	≥ .75
WROUGHT ALUMINUM ALLOY	2014, 5052, 6061, 7050, 7075, 7475	< 120 HBS	2200	.0019	.0018	.0028	.0035	.0045	.0055	.0070	.0090	.0110
		≥ 120 HBS	2200	.0016	.0012	.0018	.0022	.0030	.0035	.0045	.0060	.0070
CAST ALUMINUM ALLOY	319.0, 320.0, 354.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	< 120 HBS	1800	.0012	.0020	.0040	.0050	.0070	.0080	.0110	.0130	.0160
		≥ 120 HBS	1800	.0011	.0022	.0030	.0045	.0065	.0080	.0090	.0110	.0130
COPPER ALLOY	Cu-ETP Cu62, CuZn30, CuZn38Pb3, CuZn10, Cu60	< 75 HRB	600	.0024	.0015	.0023	.0030	.0040	.0045	.0060	.0080	.0090
		75-98 HRB	450	.0027	.0015	.0023	.0030	.0035	.0045	.0060	.0070	.0090
CARBON STEEL	100K, 110K, 120K, 12LXX, ASTM A27, ASTM A36	< 75 HRB	450	.0010	.0020	.0030	.0040	.0050	.0060	.0080	.0100	.0120
		75-98 HRB	450	.0017	.0015	.0022	.0028	.0035	.0045	.0055	.0070	.0090
		21-38 HRC	400	.0025	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
LOW ALLOY STEEL	130K, 410K, 430K, 510K, 860K, 930K	75-98 HRB	400	.0014	.0012	.0020	.0025	.0030	.0040	.0050	.0060	.0080
		21-38 HRC	350	.0018	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0065
		36-50 HRC	200	.0013	.0007	.0010	.0012	.0018	.0020	.0028	.0035	.0040
TOOL STEEL	A2, H13, L8, P20, S7	> 50 HRC	90	.0013	.0005	.0008	.0010	.0012	.0015	.0020	.0025	.0030
		75-98 HRB	325	.0014	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
		21-38 HRC	250	.0015	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0065
SPECIALTY STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	36-50 HRC	150	.0013	.0007	.0010	.0012	.0018	.0020	.0028	.0035	.0040
		> 50 HRC	90	.0013	.0005	.0008	.0010	.0012	.0015	.0020	.0025	.0030
		75-98 HRB	350	.0014	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
AUSTENITIC STAINLESS STEEL	300M, Invar 36, Kovar, Manganese 200, Manganese 250, Manganese 300, Manganese 350	75-98 HRB	400	.0010	.0020	.0030	.0040	.0050	.0060	.0080	.0100	.0120
		21-38 HRC	450	.0017	.0015	.0022	.0028	.0035	.0045	.0055	.0070	.0090
		36-50 HRC	225	.0014	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 440	36-50 HRC	140	.0014	.0008	.0012	.0015	.0020	.0025	.0030	.0040	.0050
		> 50 HRC	45	.0013	.0005	.0008	.0010	.0012	.0015	.0020	.0025	.0030
		75-98 HRB	350	.0014	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
PH STAINLESS STEEL	15-7, 17-4, Carpenter 450, Carpenter 460	75-98 HRB	325	.0014	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
		21-38 HRC	300	.0014	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
		36-50 HRC	120	.0013	.0007	.0010	.0015	.0018	.0020	.0028	.0035	.0040
GRAY CAST IRON	SAE J431, ASTM A48	75-98 HRB	450	.0012	.0022	.0035	.0045	.0065	.0070	.0090	.0110	.0140
		21-38 HRC	400	.0018	.0015	.0025	.0030	.0040	.0050	.0060	.0080	.0100
DUCTILE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75-98 HRB	350	.0017	.0013	.0020	.0028	.0035	.0040	.0055	.0070	.0080
		21-38 HRC	300	.0015	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 887	75-98 HRB	325	.0017	.0015	.0025	.0028	.0035	.0040	.0055	.0070	.0080
		21-38 HRC	275	.0018	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060
		36-50 HRC	180	.0013	.0005	.0008	.0010	.0012	.0015	.0020	.0025	.0030
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	450	.0014	.0015	.0022	.0030	.0040	.0045	.0060	.0080	.0090
		75-98 HRB	450	.0017	.0015	.0022	.0030	.0035	.0045	.0060	.0070	.0090
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspalloy, René 41, Inconel 718, Inconel 30	75-98 HRB	175	.0015	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		21-38 HRC	150	.0014	.0008	.0012	.0018	.0020	.0025	.0035	.0040	.0050
		36-50 HRC	90	.0014	.0007	.0011	.0018	.0020	.0022	.0030	.0035	.0045
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0019	.0020	.0028	.0040	.0045	.0055	.0080	.0090	.0110
		75-98 HRB	400	.0015	.0011	.0015	.0020	.0028	.0030	.0040	.0055	.0060
		21-38 HRC	350	.0016	.0010	.0018	.0022	.0028	.0035	.0045	.0055	.0070
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 15V-2Fe-3Al	21-38 HRC	200	.0019	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		36-50 HRC	140	.0014	.0008	.0012	.0018	.0020	.0022	.0030	.0040	.0045
COBALT ALLOY	ASTM F902, ASTM F90, ASTM F75, ASTM F798	75-98 HRB	225	.0013	.0008	.0009	.0012	.0015	.0018	.0022	.0030	.0035
		21-38 HRC	150	.0014	.0009	.0012	.0018	.0022	.0028	.0035	.0045	.0055
		36-50 HRC	90	.0013	.0007	.0010	.0012	.0018	.0020	.0028	.0035	.0040

NOTES:

Speed (SFM) and feed (IPT) numbers shown in the table above are considered to be average values. Use a tolerance of $\pm 25\%$ as needed.

Hardness Scales: HBS = Brinell (500-kgf steel ball)

HRB = Rockwell B

HRC = Rockwell C

COMBINATION CHAMFER / END MILLS

HCCM

4 Flute - High Performance

- Engineered for versatility and excellent performance in chamfering and side milling applications
- Specialized helically fluted tip design for superior performance, surface finish, and chip evacuation
- Variable geometry reduces chatter and harmonics and increases material removal rates
- Tplus-coating offers high hardness for improved tool life and increased edge strength in difficult-to-machine materials
- H6 shank tolerance for high precision tool holders
- Solid carbide
- CNC ground in the USA



Incl. Angle A +2°-30° -2°-30°	Cutter Diameter* D1 +0.002" -0.002"	Shank Diameter D2 (H6)	Web Thickness (MAX)	LOC L2 +0.02" -0.002"	Overall Length L1 +0.02" -0.02"	Flutes	Tplus Coated	Tool Description
60°	1/8	1/8	.009	1/2	1-1/2	4	83760	HCCM60-40125
	3/16	3/16	.010	5/8	2	4	83762	HCCM60-40187
	1/4	1/4	.010	3/4	2-1/2	4	83764	HCCM60-40250
	3/8	3/8	.013	7/8	2-1/2	4	83766	HCCM60-40375
	1/2	1/2	.013	1	3	4	83768	HCCM60-40500
90°	1/8	1/8	.009	1/2	1-1/2	4	83750	HCCM90-40125
	3/16	3/16	.010	5/8	2	4	83752	HCCM90-40187
	1/4	1/4	.010	3/4	2-1/2	4	83754	HCCM90-40250
	3/8	3/8	.013	7/8	2-1/2	4	83756	HCCM90-40375
	1/2	1/2	.013	1	3	4	83758	HCCM90-40500
100°	1/8	1/8	.009	1/2	1-1/2	4	83760	HCCM100-40125
	3/16	3/16	.010	5/8	2-1/2	4	83764	HCCM100-40250
	1/4	1/4	.010	3/4	2-1/2	4	83766	HCCM100-40375
	3/8	3/8	.013	7/8	2-1/2	4	83768	HCCM100-40500
	1/2	1/2	.013	1	3	4	83770	HCCM100-40500
120°	1/8	1/8	.009	1/2	1-1/2	4	83770	HCCM120-40125
	3/16	3/16	.010	5/8	2	4	83772	HCCM120-40187
	1/4	1/4	.010	3/4	2-1/2	4	83774	HCCM120-40250
	3/8	3/8	.013	7/8	2-1/2	4	83776	HCCM120-40375
	1/2	1/2	.013	1	3	4	83778	HCCM120-40500

* .0005 max TIR

The Multiple Uses of a Chamfer Mill

Did you know that a Chamfer Cutter, or Chamfer Mill, is one of the most versatile tools you can have in your carousel? Learn how this single tool can perform several different machining operations in our "In the Loupe" blog post *The Multiple Uses of a Chamfer Mill*.

www.harveyprecision.com/in-the-loupe/multiple-uses-chamfer-mill/

In The Loupe

BLOG POST



SCAN TO READ



Speeds & Feeds on Page 323

HCCM

SPEEDS AND FEEDS

Combination Chamfer / End Mills - 4 Flute - High Performance

HCCM													
Material Guide		Hardness	SPM	Inches Per Tooth (IPT)									
				1/8		3/16		1/4		5/8		1/2	
				Rgt	Chf	Rgt	Chf	Rgt	Chf	Rgt	Chf	Rgt	Chf
CARBON STEEL	10XX, 10XX, 12XX, 12XX, ASTM A27, ASTM A36	< 70 HRB	455	.012	.010	.018	.020	.024	.030	.030	.050	.047	.090
		70 - 98 HRC	445	.009	.007	.013	.015	.018	.022	.026	.035	.034	.045
		21 - 38 HRC	400	.006	.005	.009	.010	.011	.015	.017	.025	.022	.030
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 80XX, 93XX	70 - 98 HRC	380	.008	.006	.011	.012	.015	.020	.023	.030	.030	.040
		21 - 38 HRC	340	.006	.005	.009	.010	.012	.015	.017	.025	.022	.028
		36 - 50 HRC	260	.005	.003	.007	.007	.010	.010	.015	.018	.018	.020
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	155	.004	.003	.006	.006	.008	.008	.012	.012	.015	.015
		70 - 98 HRC	340	.008	.006	.011	.010	.015	.018	.023	.028	.030	.035
		21 - 38 HRC	250	.006	.005	.009	.010	.012	.015	.018	.025	.024	.028
SPECIALTY STEEL	30XX, Invar 38, Kovar, Maraging 300, Maraging 250, Maraging 300, Maraging 350	36 - 50 HRC	145	.005	.003	.007	.007	.010	.010	.014	.018	.018	.020
		> 50 HRC	85	.004	.002	.006	.006	.008	.007	.012	.012	.015	.015
		< 70 HRB	290	.010	.006	.010	.012	.020	.020	.030	.030	.038	.040
ALTERNATIVE STAINLESS STEEL	Nitoric 50, Nitoric 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	70 - 98 HRC	250	.007	.005	.010	.014	.014	.018	.021	.028	.027	.035
		21 - 38 HRC	175	.006	.004	.009	.009	.012	.012	.018	.022	.024	.028
		36 - 50 HRC	150	.006	.004	.008	.008	.011	.012	.016	.020	.021	.025
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 440	> 50 HRC	55	.004	.003	.005	.005	.007	.008	.010	.012	.015	.015
		70 - 98 HRC	265	.008	.005	.011	.009	.015	.015	.022	.022	.029	.028
		21 - 38 HRC	225	.007	.005	.010	.009	.014	.012	.020	.022	.026	.028
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 480	36 - 50 HRC	180	.006	.004	.008	.007	.011	.011	.016	.018	.021	.020
		70 - 98 HRC	300	.008	.004	.011	.009	.016	.012	.023	.022	.030	.025
		21 - 38 HRC	260	.007	.006	.010	.012	.013	.018	.020	.028	.026	.035
GRAY CAST IRON	SAE 4031, ASTM A48	21 - 38 HRC	200	.006	.005	.008	.009	.011	.012	.017	.022	.022	.028
		36 - 50 HRC	145	.005	.003	.007	.007	.010	.010	.014	.018	.019	.020
		70 - 98 HRC	410	.013	.012	.019	.022	.025	.038	.037	.055	.048	.070
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A802	21 - 38 HRC	370	.007	.006	.010	.015	.013	.025	.020	.040	.028	.050
		70 - 98 HRC	340	.008	.007	.012	.012	.016	.020	.023	.035	.031	.040
		21 - 38 HRC	335	.007	.005	.010	.010	.014	.015	.020	.025	.026	.030
MODULAR (DUCTILE) CAST IRON	ASTM A336, ASTM 807	70 - 98 HRC	310	.008	.007	.012	.015	.016	.020	.024	.035	.032	.040
		21 - 38 HRC	260	.006	.005	.008	.010	.011	.015	.016	.025	.021	.030
		36 - 50 HRC	155	.004	.003	.006	.006	.007	.008	.010	.012	.015	.015
PURE NICKEL	Nickel 200, Nickel 201	< 70 HRB	260	.011	.008	.018	.015	.021	.022	.031	.040	.041	.045
		70 - 98 HRC	250	.009	.007	.013	.015	.016	.022	.026	.035	.034	.045
		21 - 38 HRC	250	.009	.007	.013	.015	.016	.022	.026	.035	.034	.045
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 90	70 - 98 HRC	80	.005	.005	.008	.009	.011	.012	.016	.022	.021	.028
		21 - 38 HRC	75	.005	.004	.008	.008	.010	.012	.015	.020	.020	.025
		36 - 50 HRC	70	.005	.004	.007	.007	.009	.011	.013	.016	.017	.022
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 70 HRB	300	.015	.008	.022	.020	.028	.028	.040	.045	.057	.055
		70 - 98 HRC	275	.012	.006	.018	.011	.024	.015	.036	.028	.047	.030
		21 - 38 HRC	250	.009	.006	.014	.010	.016	.018	.027	.028	.036	.035
TITANIUM ALLOY	Ti 34-3.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	70 - 98 HRC	180	.007	.005	.011	.009	.014	.012	.021	.022	.028	.028
		21 - 38 HRC	160	.007	.004	.010	.008	.013	.012	.020	.020	.026	.022
		36 - 50 HRC	160	.007	.004	.010	.008	.013	.012	.020	.020	.026	.022
COBALT ALLOY	ASTM F902, ASTM F903, ASTM F75, ASTM F759	70 - 98 HRC	210	.006	.003	.009	.006	.012	.009	.018	.015	.024	.018
		21 - 38 HRC	170	.006	.004	.009	.009	.012	.012	.017	.028	.023	.028
		> 50 HRC	85	.004	.003	.006	.007	.008	.010	.012	.018	.018	.020

MILLING PROCESS	HARDNESS	APOC	RPOC
Rgt (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-30% Diameter
Chf (Chamfering)	NA	3 Passes	

NOTES:

Speed (SPM) and feed (IPT) numbers shown in table above are considered to be average values. Use a tolerance of +/-25% as needed.

Effective cutter diameter should be used to select the proper chipload per tooth for chamfering operations.

CORNER ROUNDING END MILLS

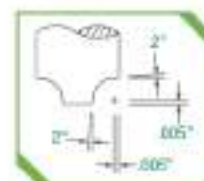
Helical Flute - 3 & 5 Flute - High Performance

New Items!

HPCR

- Helically ground with positive rake for high performance and superior part finish
- Large pilot diameters for maximum tool strength and consistent performance
- 2° flares for smooth transitions
- Radius center is offset .005" from OD and end of tool
- h6 shank tolerance for high precision tool holders

- Zplus coating offers higher hardness and added lubricity for maximum performance in aluminum and non-ferrous alloys
- Aplus coating for added lubricity and higher speeds and feeds in a wide variety of ferrous metals and titanium alloys
- Solid carbide
- CNC ground in the USA



Radius $R \pm \frac{.002}{.002}$	Pilot Diameter $D_1 \pm \frac{.002}{.002}$	Shank Diameter $D_2 \text{ (H6)}$	Overall Length $L_1 \pm \frac{.002}{.002}$	Flutes	Zplus Coated	Aplus Coated	Tool Description	
.010	.065	1/8	1-1/2	3	87626	87645	HPCR-30125-R.010	
.010	.065	1/8	1-1/2	5	88474	87664	HPCR-30125-R.010	new
.015	.065	1/8	1-1/2	3	87627	87646	HPCR-30125-R.015	
.015	.065	1/8	1-1/2	5	88475	87665	HPCR-30125-R.015	new
.020	.075	1/8	1-1/2	3	87628	87647	HPCR-30125-R.020	
.020	.075	1/8	1-1/2	5	88476	87666	HPCR-30125-R.020	new
.025	.085	1/8	1-1/2	3	87629	87648	HPCR-30125-R.025	
.025	.085	1/8	1-1/2	5	88477	87667	HPCR-30125-R.025	new
.030	.095	1/8	1-1/2	3	87630	87649	HPCR-30125-R.030	
.030	.095	1/8	1-1/2	5	88478	87668	HPCR-30125-R.030	new
.031	.093	1/8	1-1/2	3	87631	87650	HPCR-30125-R.031	
.031	.093	1/8	1-1/2	5	88479	87669	HPCR-30125-R.031	new
.039	.099	3/16	2	3	87632	87651	HPCR-30187-R.039	
.039	.099	3/16	2	5	88480	87670	HPCR-30187-R.039	new
.040	.097	3/16	2	3	87633	87652	HPCR-30187-R.040	
.040	.097	3/16	2	5	88481	87671	HPCR-30187-R.040	new
.047	.083	3/16	2	3	87634	87653	HPCR-30187-R.047	
.047	.083	3/16	2	5	88482	87672	HPCR-30187-R.047	new
.050	.077	3/16	2	3	87635	87654	HPCR-30187-R.050	
.050	.077	3/16	2	5	88483	87673	HPCR-30187-R.050	new
.060	.120	1/4	2	3	87636	87655	HPCR-30250-R.060	
.060	.120	1/4	2	5	88484	87674	HPCR-30250-R.060	new
.062	.116	1/4	2	3	87637	87656	HPCR-30250-R.062	
.062	.116	1/4	2	5	88485	87675	HPCR-30250-R.062	new
.076	.156	5/16	2	3	87638	87657	HPCR-30312-R.076	
.076	.156	5/16	2	5	88486	87676	HPCR-30312-R.076	new
.093	.166	5/16	2	3	87639	87658	HPCR-30312-R.093	
.093	.166	5/16	2	5	88487	87677	HPCR-30312-R.093	new

continued on next page.



HPCR

New Items! CORNER ROUNDING END MILLS

Helical Flute - 3 & 5 Flute - High Performance (cont.)

continued from previous page

	Radius R $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Pilot Diameter D ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Shank Diameter D ₂ (#6)	Overall Length L ₁ $\begin{smallmatrix} +.002" \\ -.002" \end{smallmatrix}$	Flutes	Zplus Coated	Aplus Coated	Tool Description
	.100	.100	3/8	2	3	87640	87659	HPCR-30375-R.100
NEW	.100	.100	3/8	2	5	88488	87678	HPCR-50375-R.100
	.125	.177	7/16	2-3/4	3	87641	87660	HPCR-30437-R.125
NEW	.125	.177	7/16	2-3/4	5	88489	87679	HPCR-50437-R.125
	.156	.177	1/2	2-1/2	3	87642	87661	HPCR-30500-R.156
NEW	.156	.177	1/2	2-1/2	5	88490	87680	HPCR-50500-R.156
	.187	.240	5/8	3	3	87643	87662	HPCR-30625-R.187
NEW	.187	.240	5/8	3	5	88491	87681	HPCR-50625-R.187
	.250	.239	3/4	3	3	87644	87663	HPCR-30700-R.250
NEW	.250	.239	3/4	3	5	88492	87682	HPCR-50750-R.250



SKU: 50807
Coating: Aplus
Included Angle: 90°
Length of Cut: .095"
Tip Diameter: .060"

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SPEEDS AND FEEDS

Corner Rounding Mills - 3 & 5 Flute

HPCR

HPCR

Material Grade	Hardness	SFM	Inches Per Tooth (IPT)							
			Effective Cutting Diameter (Def)							
			1/8	3/16	1/4	3/8	1/2	3/4	1	
WROUGHT ALUMINUM ALLOY	2014, 9052, 6061, 7050, 7075, 7475	< 125 HBS 2200	.0008	.0018	.0029	.0045	.0055	.0090	.0110	
		≥ 125 HBS 2200	.0008	.0012	.0018	.0030	.0035	.0060	.0070	
CAST ALUMINUM ALLOY	319.0, 320.0, 360.0, 360.0, 380.0, 380.0, 520.0, 535.0	< 125 HBS 1800	.0012	.0020	.0040	.0070	.0080	.0130	.0160	
		≥ 125 HBS 1800	.0011	.0022	.0038	.0055	.0068	.0110	.0130	
COPPER ALLOY	C-ETP CuBe2, CuZn30, CuZn36Pb3, CuZn16, CuSn5	< 75 HRB 600	.0008	.0015	.0022	.0040	.0045	.0080	.0090	
		75 - 98 HRB 450	.0007	.0015	.0022	.0035	.0045	.0070	.0080	
CARBON STEEL	1018X, 1118X, 1218X, 12LXX, ASTM A27, ASTM A36	< 75 HRB 455	.0012	.0018	.0025	.0036	.0048	.0068	.0067	
		75 - 98 HRB 445	.0008	.0013	.0018	.0026	.0034	.0049	.0050	
		21 - 36 HRC 400	.0008	.0009	.0011	.0018	.0022	.0032	.0041	
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB 380	.0008	.0011	.0015	.0023	.0038	.0043	.0055	
		21 - 36 HRC 340	.0008	.0009	.0011	.0017	.0022	.0032	.0041	
		36 - 50 HRC 360	.0008	.0007	.0013	.0016	.0018	.0026	.0036	
		> 50 HRC 155	.0004	.0006	.0008	.0011	.0015	.0022	.0028	
TOOL STEEL	A2, H13, L6, P20, S7	75 - 98 HRB 340	.0008	.0011	.0015	.0023	.0038	.0043	.0055	
		21 - 36 HRC 250	.0008	.0009	.0012	.0018	.0024	.0034	.0044	
		36 - 50 HRC 145	.0008	.0007	.0013	.0014	.0018	.0026	.0036	
		> 50 HRC 85	.0004	.0006	.0008	.0011	.0015	.0022	.0028	
SPECIALTY STEEL	300M, Invar 36, Kovar, Manganese 300, Manganese 200, Manganese 300, Manganese 350	< 75 HRB 280	.0011	.0015	.0023	.0038	.0048	.0056	.0072	
		75 - 98 HRB 255	.0007	.0011	.0014	.0020	.0027	.0039	.0049	
		21 - 36 HRC 175	.0008	.0009	.0012	.0018	.0024	.0034	.0045	
		36 - 50 HRC 150	.0008	.0008	.0011	.0017	.0022	.0031	.0040	
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-TMO, 316, 316L, 321, 347	75 - 98 HRB 200	.0008	.0011	.0015	.0022	.0029	.0042	.0054	
		21 - 36 HRC 225	.0007	.0010	.0013	.0020	.0028	.0038	.0048	
MARTENSITIC & FERRITIC STAINLESS STEEL	400, 410, 416, 420, 430, 435, 440	75 - 98 HRB 300	.0008	.0011	.0014	.0023	.0030	.0043	.0055	
		21 - 36 HRC 280	.0007	.0010	.0013	.0020	.0028	.0036	.0046	
PH STAINLESS STEEL	15-5, 17-4, Carpenter 400, Carpenter 408	21 - 36 HRC 200	.0008	.0009	.0011	.0017	.0022	.0032	.0041	
		36 - 50 HRC 145	.0008	.0007	.0013	.0015	.0019	.0027	.0036	
GRAY CAST IRON	SAE J431, ASTM A48	75 - 98 HRB 410	.0012	.0018	.0029	.0037	.0048	.0070	.0080	
		21 - 36 HRC 370	.0007	.0010	.0013	.0020	.0025	.0036	.0048	
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A502	75 - 98 HRB 345	.0008	.0011	.0014	.0024	.0031	.0044	.0057	
		21 - 36 HRC 325	.0007	.0010	.0014	.0020	.0028	.0036	.0046	
MODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 807	75 - 98 HRB 310	.0008	.0012	.0017	.0025	.0032	.0046	.0059	
		21 - 36 HRC 260	.0008	.0008	.0011	.0017	.0021	.0031	.0039	
		36 - 50 HRC 135	.0004	.0005	.0007	.0011	.0013	.0019	.0025	
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB 285	.0011	.0016	.0021	.0032	.0041	.0059	.0075	
		75 - 98 HRB 250	.0008	.0013	.0018	.0026	.0034	.0049	.0063	
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Monopoly, René 41, Inconel 718, Incoloy 28	75 - 98 HRB 80	.0008	.0008	.0011	.0016	.0021	.0030	.0039	
		21 - 36 HRC 75	.0008	.0008	.0011	.0015	.0023	.0029	.0037	
		36 - 50 HRC 70	.0004	.0006	.0009	.0013	.0019	.0025	.0032	
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB 300	.0011	.0021	.0029	.0043	.0057	.0092	.0105	
		75 - 98 HRB 275	.0012	.0018	.0025	.0036	.0048	.0069	.0088	
		21 - 36 HRC 250	.0011	.0013	.0018	.0027	.0038	.0051	.0066	
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC 180	.0008	.0011	.0015	.0021	.0028	.0041	.0052	
		36 - 50 HRC 160	.0007	.0010	.0013	.0019	.0025	.0037	.0048	
COBALT ALLOY	ASTM F502, ASTM F90, ASTM F75, ASTM F793	75 - 98 HRB 210	.0008	.0009	.0012	.0018	.0024	.0034	.0044	
		21 - 36 HRC 170	.0008	.0009	.0012	.0018	.0023	.0033	.0042	
		36 - 50 HRC 85	.0004	.0006	.0008	.0012	.0018	.0022	.0029	

MILLING PROCESS	HARDNESS	ADOC	RDOC
Non-Ferrous Corner Rounding	N/A	100%	1 Pass at Full Depth
Ferrous Corner Rounding	< 35 HRC	100%	1 Pass at Full Depth
	≥ 35 HRC	100%	2 Passes to Full Depth

NOTES:

Speed (SFM) numbers shown in table above are considered to be average values. Use a tolerance of +/-25% as needed

Feed (IPT) numbers shown in table above are considered to be starting values and may be increased given optimal conditions

Effective cutter diameter should be used to calculate RPM and to select the proper chipload per tooth

Effective Cutter Diameter = Pilot Diameter + Radius

CUSTOM TOOLS

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TOOL MODIFICATIONS

What We Offer

Custom tool needs can often be accommodated by modifying one of our standard tools. We're able to modify our standard tools in a variety of ways, including by adding corner radii, coatings, neck lengthening (or additions), overall length adjustments, or even chipbreakers.

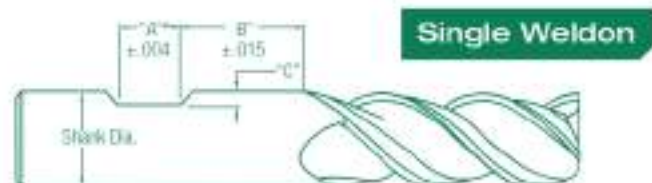
Upon receiving a custom tool RFQ, we will evaluate each modification request to confirm optimal performance. Should we feel a full custom tool design is warranted, we'll quote accordingly. Call your preferred distributor today to get started!



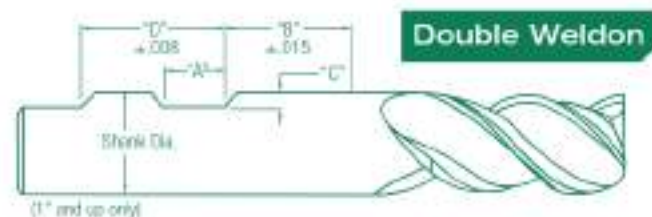
SHANK MODIFICATIONS

Weldon Flat Specifications

Factory-ground flats have several key advantages, including that they are ground parallel with the centerline of the tool, are consistently level for the entire length of the flat, and are accurately ground with no excess runout. Helical Solutions employs a "flat location procedure" to ensure that flutes will not end up inside of the tool holder, avoiding chip compaction, and that tool "stick out" is minimal in order to achieve optimum tool strength.



Single Weldon



Double Weldon



Single Weldon
Reduced Neck

In reduced neck tooling, weldon flat are measured from neck/shank intersection

Weldon Flat Specifications

Shank Dia.	"A"	"B"	"C"	"D"
1.250	.155	.500	.012 +.005/- .000	-
1.875	.155	.500	.015 +.005/- .000	-
2.50	.155	.500	.017 +.005/- .000	-
3.125	.295	.750	.020 +.005/- .000	-
3.75	.295	.750	.060 +.015/- .000	-
4.375	.345	.835	.060 +.015/- .000	-
5.00	.345	.835	.060 +.015/- .000	-
6.25	.415	.900	.065 +.015/- .000	-
7.50	.470	.900	.075 +.015/- .000	-
1.0000	.530	1.000	.075 +.015/- .000	.900*
1.2500	.530	1.000	.095 +.015/- .000	.900*

*Note: Not applicable to 1" dia. tools with ≤4 OAL.

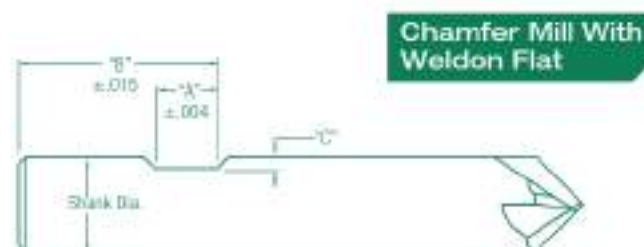
Weldon Flat specifications are typically based on NAS 986, a high speed steel tool standard, and are measured from the shank end. Currently, there is no standardized specification for high performance solid carbide end mills. All flats will be ground using the dimension chart above unless specified otherwise at the time of quote/order. Some tool holding systems on the market are designed to the exact NAS 986 standard, and may not be directly compatible with the Helical Solutions Weldon dimensions outlined here.

SHANK MODIFICATIONS

Chamfer Mill with Weldon Flat Specifications

Shank Dia.	"A"	"B"	"C"
.1250	.155	.928	.012 +.005/- .000
.1875	.155	.928	.015 +.005/- .000
.2500	.155	.928	.017 +.005/- .000
.3750	.295	.928	.050 +.015/- .000
.5000	.345	1.064	.060 +.015/- .000
.7500	.470	1.250	.075 +.015/- .000

Weldon Flat specifications are typically based on NAS 986, a high speed steel tool standard, and are measured from the shank end. Currently, there is no standardized specification for high performance solid carbide end mills. All flats will be ground using the dimension chart above unless specified otherwise at the time of quote/order. Some tool holding systems on the market are designed to the exact NAS 986 standard, and may not be directly compatible with the Helical Solutions Weldon dimensions outlined here.

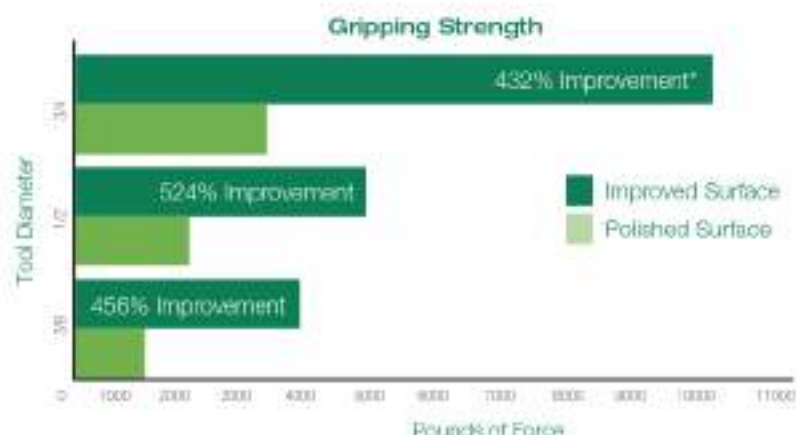


Chamfer Mill With Weldon Flat

ToughGRIP™ Shank

Are you familiar with ToughGRIP™ Shanks? They provide increased friction for superior gripping strength, as the mirror finish provided on most shanks does not always provide the necessary amount of tool holding security. Helical's ToughGRIP™ Shank maintains shank concentricity and h6 shrink-fit tolerance, and features 30 +/- 3 Ra surface roughness, consistent with 2 Ra.

ToughGRIP™ Shank provides increased friction for superior gripping strength



Based on independent laboratory testing. All tests were completed utilizing Command Tooling Systems' line of HYDRO-GRIP® HD Hydraulic tool holders by ETP Transmission.

* Improved surface finish from the ToughGRIP™ exceeded laboratory testing equipment.

Haimer Safe-Lock™ System

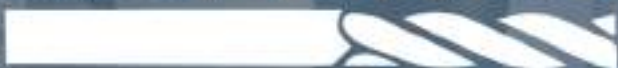
Looking for even more tool holding security? Helical Solutions was the first Haimer Safe-Lock licensee, and have been manufacturing this shank configuration - added groove on the cutting shank that work opposite the cutting direction of the flutes - since 2008.

- + Minimizes runout
- + Up to 5x the tool life
- + No pull-out or spinning



For more information on any Helical Solutions Shank Modifications, including Weldon Flats, ToughGRIP Shanks, or the Haimer Safe-Lock™ System, visit our website at helicaltool.com/resources

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New Tools for 2024



Dplus Coating

3 Flute - Corner Radius - 35° Helix - Variable pitch Pg. 11

Square, Ball, and Corner Radius - 3 Flute - 40° Helix Variable Pitch Pg. 50, 52, 54



Coolant Through for Aluminum

3 Flute - 35° Helix - Corner Radius - Chipbreaker Rougher - Coolant Through Pg. 14

3 Flute - 40° Helix - Corner Radius Coolant Through Pg. 59



High Efficiency Milling

5 Flute - Square - Variable pitch Pg. 76



End Mills for Aluminum - Enlarged Shank

Square and Corner Radius - 3 Flute - 40° Helix Variable pitch Pg. 50, 54

Looking for the Index?

Visit www.helicaltool.com and search by the 5-digit EDP number. Each tool detail page will show the page number of the catalog where you can find that tool.

Additionally, to see a PDF of the index with all EDP numbers from the 2024 catalog, scan the QR code below or visit www.helicaltool.com/catalog-request and download the index document.





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