

Super Tool, Inc.

2018

Carbide Tipped Milling Cutters Special Widths Special Radius Special Chamfers

3" • 4" • 5" • 6" Diameters



Width
Grind



Radius
Left Side



Radius
Right Side



Chamfer
Left Side



Chamfer
Right Side



Alternating
Right Left
Chamfer



Chamfer
Both Sides



Radius
Both Sides



Full Radius



Radius Right
Side Chamfer
Left Side



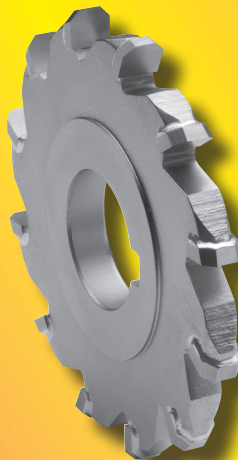
Alternating
Chamfer
Both Sides



Radius Left
Side Chamfer
Right Side



Triple Tooth
Grind



Phone 941-751-9677 Fax 941-756-6480

sales@supertoolinc.com

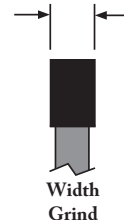
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3" CARBIDE TIPPED MILLING CUTTERS



Width grinds between .0600" and .5312"

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH - FINISHED TO DECIMAL WIDTH					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
3	.0600-.0703	.0555	60302D	\$296.55	\$275.10	\$271.40	\$269.45	\$268.30	\$241.20
3	.0704-.0859	.0711	60303D	325.55	304.10	300.40	298.45	297.20	270.20
3	.0860-.1015	.0867	60304D	296.55	275.10	271.40	269.45	268.30	241.20
3	.1016-.1171	.1024	60305D	285.55	264.20	260.45	258.50	257.30	230.25
3	.1172-.1406	.1180	60306D	275.25	253.80	250.05	248.10	246.95	219.90
3	.1407-.1718	.1562	60308D	280.55	259.20	255.45	253.50	252.35	225.20
3	.1719-.2031	.1875	60309D	285.95	264.50	260.75	258.85	257.70	230.60
3	.2032-.2343	.2188	60310D	293.20	271.90	268.15	266.15	265.00	237.90
3	.2344-.2812	.2500	60311D	300.50	279.10	275.30	273.35	272.20	245.05
3	.2813-.3437	.3125	60312D	323.85	302.45	298.70	296.80	295.65	268.45
3	.3438-.4062	.3750	60313D	349.00	327.60	323.85	321.85	320.70	293.65
3	.4063-.4687	.4375	60380D	374.40	353.00	349.25	347.30	346.15	319.10
3	.4688-.5312	.5000	60381D	399.85	378.40	374.65	372.75	371.60	344.40



Cutter Notes (All cutters on page)

- 12 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)

Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

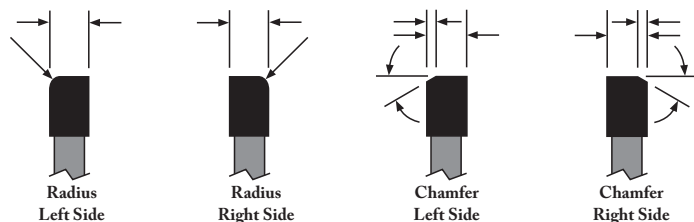
Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/2 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Corner Radius or Chamfer on ONE Side

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH FINISHED WITH RADIUS OR CHAMFER					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
3	.0600-.0703	.0555	60302R1	\$311.00	\$279.35	\$275.10	\$273.00	\$271.70	\$271.05
3	.0704-.0859	.0711	60303R1	340.05	308.35	304.10	301.95	300.65	300.00
3	.0860-.1015	.0867	60304R1	311.00	279.35	275.10	273.00	271.70	271.05
3	.1016-.1171	.1024	60305R1	300.10	268.40	264.20	262.05	260.70	260.00
3	.1172-.1406	.1180	60306R1	289.70	258.00	253.80	251.65	250.35	249.65
3	.1407-.1718	.1562	60308R1	295.05	263.40	259.20	257.00	255.70	255.00
3	.1719-.2031	.1875	60309R1	300.45	268.70	264.50	262.40	261.15	260.40
3	.2032-.2343	.2188	60310R1	307.70	276.10	271.90	269.65	268.40	267.65
3	.2344-.2812	.2500	60311R1	314.95	283.25	279.10	276.90	275.60	274.90
3	.2813-.3437	.3125	60312R1	338.35	306.70	302.45	300.30	299.05	298.25
3	.3438-.4062	.3750	60313R1	363.55	331.80	327.60	325.40	324.15	323.45
3	.4063-.4687	.4375	60380R1	388.90	357.20	353.00	350.85	349.60	348.85
3	.4688-.5312	.5000	60381R1	414.30	382.60	378.40	376.30	374.90	374.25

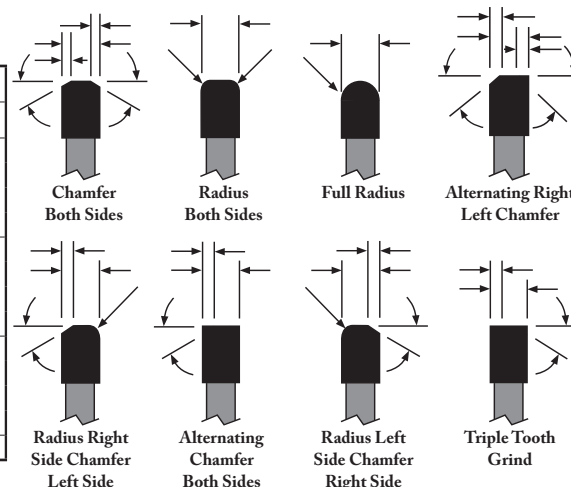
Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE WITH RADII, CHAMFERS OR COMBINATION					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
3	.0600-.0703	.0555	60302R2	\$318.75	\$283.60	\$279.00	\$276.50	\$275.05	\$274.30
3	.0704-.0859	.0711	60303R2	347.80	312.60	307.95	305.50	304.00	303.20
3	.0860-.1015	.0867	60304R2	318.75	283.60	279.00	276.50	275.05	274.30
3	.1016-.1171	.1024	60305R2	307.90	272.65	268.00	265.60	264.10	263.35
3	.1172-.1406	.1180	60306R2	297.50	262.30	257.60	255.20	253.70	252.95
3	.1407-.1718	.1562	60308R2	302.85	267.60	262.95	260.55	259.10	258.30
3	.1719-.2031	.1875	60309R2	308.15	273.00	268.35	265.90	264.45	263.70
3	.2032-.2343	.2188	60310R2	315.55	280.30	275.65	273.25	271.75	271.05
3	.2344-.2812	.2500	60311R2	322.70	287.45	282.85	280.40	279.00	278.20
3	.2813-.3437	.3125	60312R2	346.10	310.90	306.20	303.85	302.40	301.60
3	.3438-.4062	.3750	60313R2	371.30	336.05	331.40	329.00	327.50	326.75
3	.4063-.4687	.4375	60380R2	396.60	361.50	356.85	354.35	352.95	352.15
3	.4688-.5312	.5000	60381R2	422.05	386.95	382.20	379.80	378.35	377.55



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Made in the USA

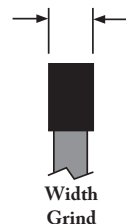
See back page for ordering information

4" CARBIDE TIPPED MILLING CUTTERS



Width grinds between .0600" and .5312"

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH - FINISHED TO DECIMAL WIDTH					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
4	.0600-.0703	.0545	60360D	\$339.50	\$314.95	\$310.45	\$308.15	\$306.75	\$274.35
4	.0704-.0859	.0701	60362D	379.55	354.90	350.40	348.10	346.75	314.30
4	.0860-.1015	.0858	60364D	339.50	314.95	310.45	308.15	306.75	274.35
4	.1016-.1171	.1014	60366D	390.50	365.90	361.40	359.15	357.70	325.25
4	.1172-.1406	.1170	60314D	339.15	314.50	309.95	307.65	306.30	273.90
4	.1407-.1718	.1562	60316D	346.30	321.70	317.20	314.95	313.50	281.10
4	.1719-.2031	.1875	60318D	355.25	330.65	326.15	323.90	322.45	290.05
4	.2032-.2343	.2188	60320D	364.40	339.80	335.30	333.00	331.55	299.15
4	.2344-.2812	.2500	60322D	371.60	346.95	342.45	340.15	338.70	306.35
4	.2813-.3437	.3125	60324D	393.10	368.50	364.00	361.70	360.30	327.95
4	.3438-.4062	.3750	60326D	418.40	393.80	389.30	387.00	385.50	353.10
4	.4063-.4687	.4375	60382D	443.75	419.20	414.65	412.35	410.90	378.55
4	.4688-.5312	.5000	60383D	469.20	444.50	440.05	437.75	436.35	403.95



Cutter Notes (All cutters on page)

- 14 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.0313"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)

Radius Notes

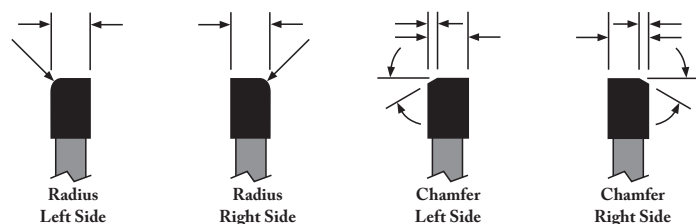
- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/3 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Corner Radius or Chamfer on **ONE** Side

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH FINISHED WITH RADIUS OR CHAMFER					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
4	.0600-.0703	.0545	60360R1	\$355.20	\$319.55	\$314.60	\$311.95	\$310.45	\$309.65
4	.0704-.0859	.0701	60362R1	395.15	359.50	354.55	351.90	350.40	349.60
4	.0860-.1015	.0858	60364R1	355.20	319.55	314.60	311.95	310.45	309.65
4	.1016-.1171	.1014	60366R1	406.20	370.50	365.50	362.95	361.40	360.55
4	.1172-.1406	.1170	60314R1	354.80	319.10	314.10	311.55	309.95	309.15
4	.1407-.1718	.1562	60316R1	361.95	326.25	321.35	318.75	317.20	316.35
4	.1719-.2031	.1875	60318R1	370.95	335.30	330.30	327.70	326.15	325.30
4	.2032-.2343	.2188	60320R1	380.10	344.35	339.40	336.85	335.30	334.40
4	.2344-.2812	.2500	60322R1	387.20	351.55	346.55	343.95	342.45	341.60
4	.2813-.3437	.3125	60324R1	408.80	373.05	368.15	365.55	364.00	363.10
4	.3438-.4062	.3750	60326R1	434.00	398.35	393.35	390.75	389.30	388.40
4	.4063-.4687	.4375	60382R1	459.45	423.80	418.75	416.20	414.65	413.80
4	.4688-.5312	.5000	60383R1	484.85	449.20	444.20	441.60	440.05	439.25



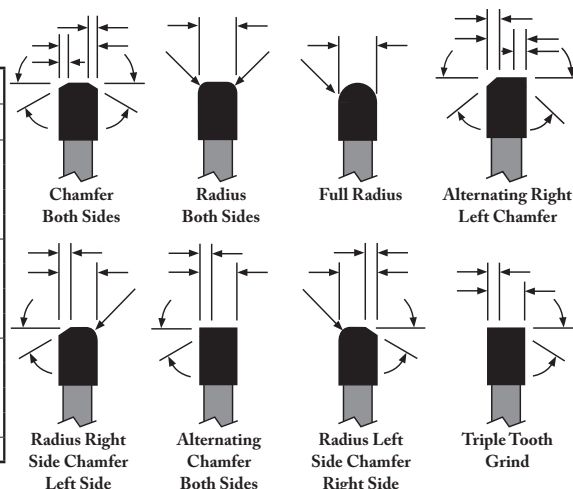
Specify side for radius or chamfer



Corner Radius or Chamfer on **BOTH** Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE WITH RADII, CHAMFERS OR COMBINATION					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
4	.0600-.0703	.0545	60360R2	\$363.55	\$324.20	\$318.65	\$315.85	\$314.10	\$313.20
4	.0704-.0859	.0701	60362R2	403.40	364.10	358.60	355.80	354.05	353.10
4	.0860-.1015	.0858	60364R2	363.55	324.20	318.65	315.85	314.10	313.20
4	.1016-.1171	.1014	60366R2	414.45	375.15	369.60	366.80	365.05	364.10
4	.1172-.1406	.1170	60314R2	363.00	323.70	318.20	315.35	313.65	312.70
4	.1407-.1718	.1562	60316R2	370.25	330.95	325.35	322.60	320.80	319.90
4	.1719-.2031	.1875	60318R2	379.25	339.90	334.40	331.55	329.75	328.95
4	.2032-.2343	.2188	60320R2	388.35	349.00	343.50	340.70	339.00	338.05
4	.2344-.2812	.2500	60322R2	395.45	356.15	350.65	347.80	346.10	345.15
4	.2813-.3437	.3125	60324R2	417.05	377.75	372.20	369.40	367.65	366.75
4	.3438-.4062	.3750	60326R2	442.30	402.95	397.45	394.65	392.95	392.00
4	.4063-.4687	.4375	60382R2	467.70	428.40	422.90	420.00	418.30	417.45
4	.4688-.5312	.5000	60383R2	493.10	453.85	448.25	445.40	443.70	442.75

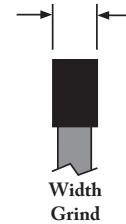


5" CARBIDE TIPPED MILLING CUTTERS



Width grinds between .0704" and .5312"

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH - FINISHED TO DECIMAL WIDTH					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
5	.0704-.0859	.0691	60368D	\$454.00	\$428.75	\$424.15	\$421.85	\$420.45	\$387.25
5	.0860-.1015	.0848	60370D	398.90	373.70	369.15	366.80	365.40	332.15
5	.1016-.1171	.1004	60372D	432.00	406.85	402.20	399.90	398.45	365.35
5	.1172-.1406	.1160	60328D	389.30	364.00	359.50	357.10	355.75	322.55
5	.1407-.1718	.1562	60330D	399.95	374.75	370.25	367.80	366.40	333.20
5	.1719-.2031	.1875	60332D	418.05	392.90	388.35	386.00	384.55	351.35
5	.2032-.2343	.2188	60334D	436.15	410.90	406.35	404.00	402.55	369.40
5	.2344-.2812	.2500	60336D	454.05	428.80	424.30	421.95	420.55	387.30
5	.2813-.3437	.3125	60338D	484.65	459.45	454.90	452.50	451.10	417.95
5	.3438-.4062	.3750	60340D	517.10	491.90	487.40	485.00	483.55	450.45
5	.4063-.4687	.4375	60384D	542.50	517.35	512.85	510.45	509.00	475.85
5	.4688-.5312	.5000	60385D	567.95	542.75	538.20	535.85	534.40	501.20



Cutter Notes (All cutters on page)

- 16 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.013"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)

Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

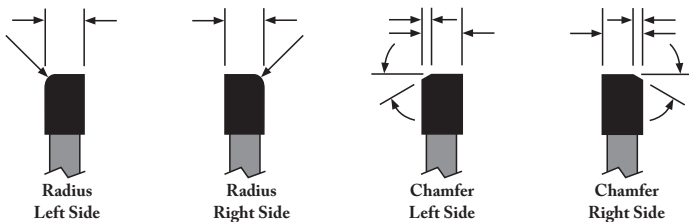
Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/3 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Corner Radius or Chamfer on ONE Side

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH FINISHED WITH RADIUS OR CHAMFER					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
5	.0704-.0859	.0691	60368R1	\$469.80	\$433.40	\$428.35	\$425.65	\$424.05	\$423.25
5	.0860-.1015	.0848	60370R1	414.80	378.35	373.25	370.65	369.05	368.15
5	.1016-.1171	.1004	60372R1	447.85	411.50	406.35	403.75	402.10	401.30
5	.1172-.1406	.1160	60328R1	405.10	368.65	363.65	360.95	359.40	358.55
5	.1407-.1718	.1562	60330R1	415.85	379.35	374.30	371.70	370.05	369.25
5	.1719-.2031	.1875	60332R1	433.90	397.50	392.40	389.75	388.20	387.30
5	.2032-.2343	.2188	60334R1	451.95	415.50	410.45	407.85	406.20	405.35
5	.2344-.2812	.2500	60336R1	469.90	433.55	428.40	425.80	424.15	423.30
5	.2813-.3437	.3125	60338R1	500.50	464.05	459.00	456.35	454.80	453.95
5	.3438-.4062	.3750	60340R1	532.95	496.55	491.45	488.80	487.30	486.45
5	.4063-.4687	.4375	60384R1	558.40	522.00	516.85	514.25	512.65	511.80
5	.4688-.5312	.5000	60385R1	583.75	547.40	542.30	539.70	538.00	537.20

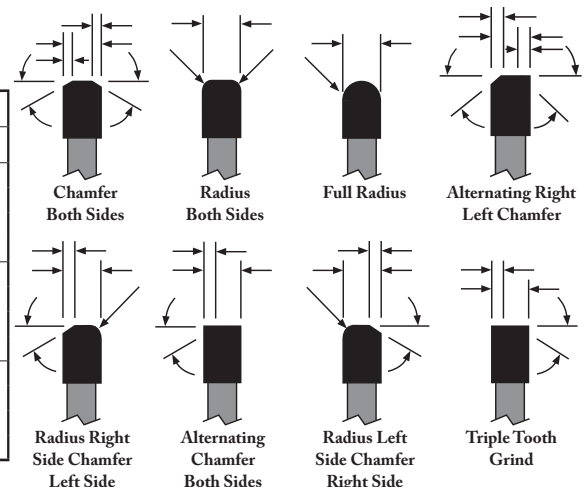
Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE WITH RADII, CHAMFERS OR COMBINATION					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
5	.0704-.0859	.0691	60368R2	\$486.35	\$442.65	\$436.50	\$433.35	\$431.45	\$430.45
5	.0860-.1015	.0848	60370R2	431.30	387.55	381.45	378.30	376.40	375.40
5	.1016-.1171	.1004	60372R2	464.35	420.65	414.55	411.40	409.55	408.45
5	.1172-.1406	.1160	60328R2	421.60	377.90	371.80	368.60	366.75	365.75
5	.1407-.1718	.1562	60330R2	432.30	388.60	382.50	379.35	377.45	376.40
5	.1719-.2031	.1875	60332R2	450.45	406.70	400.55	397.45	395.55	394.55
5	.2032-.2343	.2188	60334R2	468.40	424.80	418.65	415.50	413.60	412.60
5	.2344-.2812	.2500	60336R2	486.45	442.70	436.55	433.45	431.60	430.55
5	.2813-.3437	.3125	60338R2	516.95	473.30	467.20	464.00	462.10	461.10
5	.3438-.4062	.3750	60340R2	549.50	505.75	499.70	496.50	494.60	493.65
5	.4063-.4687	.4375	60384R2	574.95	531.15	525.05	521.95	520.05	519.05
5	.4688-.5312	.5000	60385R2	600.30	556.60	550.50	547.40	545.40	544.40

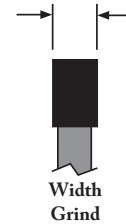


6" CARBIDE TIPPED MILLING CUTTERS



Width grinds between .0704" and .5312"

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH - FINISHED TO DECIMAL WIDTH					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
6	.0704-.0859	.0681	60374D	\$505.20	\$478.85	\$474.10	\$471.65	\$470.10	\$435.50
6	.0860-.1015	.0838	60376D	470.70	444.40	439.65	437.20	435.65	401.05
6	.1016-.1171	.0994	60378D	506.65	480.40	475.55	473.10	471.65	437.00
6	.1172-.1406	.1150	60342D	482.15	455.90	451.10	448.60	447.15	412.55
6	.1407-.1718	.1562	60344D	500.15	473.95	469.15	466.65	465.20	430.55
6	.1719-.2031	.1875	60346D	518.25	491.90	487.25	484.65	483.15	448.55
6	.2032-.2343	.2188	60348D	536.25	509.95	505.20	502.70	501.20	466.60
6	.2344-.2812	.2500	60350D	561.15	534.90	530.05	527.60	526.15	491.50
6	.2813-.3437	.3125	60352D	583.15	556.80	552.10	549.60	548.15	513.45
6	.3438-.4062	.3750	60354D	602.90	576.55	571.85	569.35	567.85	533.20
6	.4063-.4687	.4375	60386D	628.25	601.95	597.20	594.70	593.25	558.60
6	.4688-.5312	.5000	60387D	653.65	627.40	622.60	620.15	618.65	584.05



Cutter Notes (All cutters on page)

- 18 Teeth
- C-2(m) Carbide
- 5° Positive Radial Rake
- Width Tolerance: +.001"/-.000"
- OD tolerance: +.013"/-.000"
- 1" Arbor hole +.001"/-.000"
- ANSI standard keyway dimensions
- Add 5% to grind the hub width thinner
- Add 5% to match OD's on cutter sets within .001"
- Not designed to be used on heat treated materials greater than 363 Brinell (39Rc)

Radius Notes

- Maximum radius on one side is .2656"
- Full radius and maximum radius on both sides is 1/2 the width of the cutter
- A non-tangent radii must be quoted

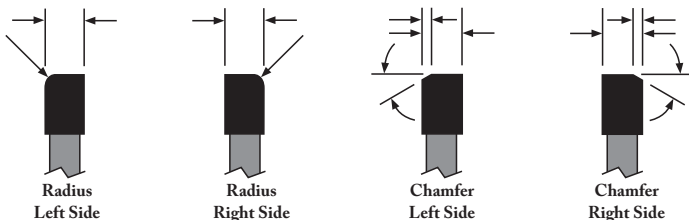
Chamfer Notes

- Chamfer Angles can range from 0° to 45°
- Chamfer is measured off of the OD
- Maximum chamfer is the LESSER of 1/3 the width of the cutter OR .2656" length of angle when measured across the OD
- Chamfer Angle Tolerance: +/- 1/2°
- Chamfers greater than 45° must be quoted

Corner Radius or Chamfer on ONE Side

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE EACH FINISHED WITH RADIUS OR CHAMFER					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
6	.0704-.0859	.0681	60374R1	\$521.30	\$483.45	\$478.15	\$475.45	\$473.80	\$472.90
6	.0860-.1015	.0838	60376R1	486.85	449.00	443.70	441.00	439.35	438.45
6	.1016-.1171	.0994	60378R1	522.85	484.95	479.65	476.90	475.25	474.40
6	.1172-.1406	.1150	60342R1	498.35	460.45	455.15	452.40	450.80	449.90
6	.1407-.1718	.1562	60344R1	516.40	478.55	473.20	470.55	468.85	467.95
6	.1719-.2031	.1875	60346R1	534.40	496.55	491.25	488.50	486.85	486.00
6	.2032-.2343	.2188	60348R1	552.40	514.60	509.35	506.50	504.95	504.05
6	.2344-.2812	.2500	60350R1	577.35	539.55	534.20	531.50	529.80	528.90
6	.2813-.3437	.3125	60352R1	599.30	561.50	556.25	553.45	551.80	550.90
6	.3438-.4062	.3750	60354R1	619.05	581.20	575.90	573.15	571.55	570.65
6	.4063-.4687	.4375	60386R1	644.45	606.65	601.35	598.60	596.90	596.05
6	.4688-.5312	.5000	60387R1	669.85	632.00	626.65	624.00	622.35	621.40

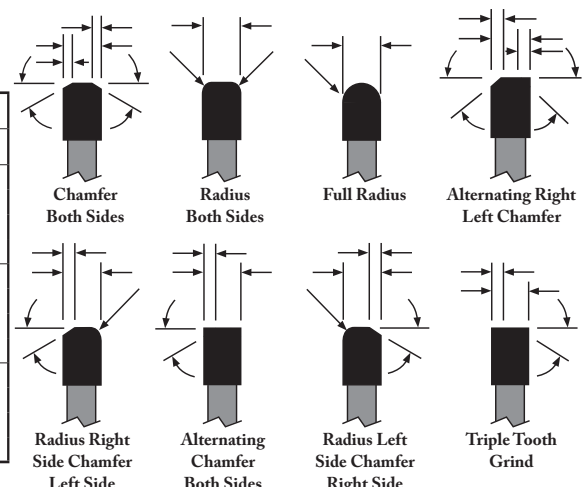
Specify side for radius or chamfer



Corner Radius or Chamfer on BOTH Sides OR a Full Radius

- Alternating Chamfers add 5%

TOOL DIAM.	FACE WIDTH RANGE	HUB WIDTH	1" ARBOR EDP NO.	PRICE WITH RADII, CHAMFERS OR COMBINATION					
				1 PC.	2 PC.	3 PC.	4 PC.	5 PC.	6 PC.
6	.0704-.0859	.0681	60374R2	\$537.85	\$492.75	\$486.45	\$483.15	\$481.15	\$480.05
6	.0860-.1015	.0838	60376R2	503.40	458.30	451.95	448.65	446.70	445.60
6	.1016-.1171	.0994	60378R2	539.40	494.20	487.85	484.65	482.65	481.60
6	.1172-.1406	.1150	60342R2	514.90	469.75	463.40	460.15	458.20	457.10
6	.1407-.1718	.1562	60344R2	532.90	487.75	481.45	478.15	476.20	475.15
6	.1719-.2031	.1875	60346R2	550.90	505.75	499.45	496.25	494.30	493.20
6	.2032-.2343	.2188	60348R2	568.95	523.85	517.50	514.25	512.25	511.20
6	.2344-.2812	.2500	60350R2	593.85	548.70	542.40	539.10	537.15	536.15
6	.2813-.3437	.3125	60352R2	615.80	570.75	564.40	561.15	559.15	558.10
6	.3438-.4062	.3750	60354R2	635.50	590.40	584.10	580.90	578.90	577.85
6	.4063-.4687	.4375	60386R2	660.95	615.80	609.55	606.30	604.30	603.25
6	.4688-.5312	.5000	60387R2	686.40	641.25	634.95	631.75	629.75	628.65



SUPER TOOL, INC. - Phone 941-751-9677 - Fax 941-756-6480

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See back page for ordering information

FEEDS & SPEEDS FOR MILLS & SAWS - CARBIDE TIPPED

Feeds & speeds are a starting recommendation only. Factors such as machine, fixture and tooling rigidity, horsepower available, coolant application and others will significantly affect the performance. Read machine operators instructions and use safety shields and glasses before performing these operations.

$$\text{RPM} = \text{SFPM} * 3.82 / \text{CUTTER DIAMETER}$$

$$\text{IPM} = \text{IPT} * \text{RPM} * \# \text{TEETH}$$

CLASS OF MATERIALS	MATERIAL	BRINELL	SURFACE FEET PER MINUTE (SFPM)	INCHES PER TOOTH (IPT)
NON-FERROUS (SOFT)	ALUMINUM ALLOY - WROUGHT	30 - 150*	1000 - 2000	.004-.008
	MAGNESIUM ALLOY	50 - 90*	750 - 1500	.004-.008
	LEAD ALLOY	10 - 20*	300 - 1000	.004-.008
	NON-METAL AND PLASTIC	-	1500 - 3000	.004-.008
	ZINC ALLOY - DIE CAST	80 - 100	750 - 1500	.005-.010
NON-FERROUS (HARD)	ALUMINUM BRONZE	40 - 175	200 - 600	.003-.006
	BRASS ALLOY - LEADED AND FREE CUTTING	10 - 100Rb	400 - 800	.004-.008
	NICKEL SILVER	10 - 100Rb	200 - 400	.003-.006
	COPPER ALLOY - TOUGH	40 - 200*	200 - 500	.004-.008
CAST IRON	DUCTILE CAST IRON - AUSTENITIC	120 - 275	75 - 150	.002-.004
	DUCTILE CAST IRON - FERRITIC	140 - 270	250 - 400	.003-.006
	DUCTILE CAST IRON - MARTENSITIC	270 - 363	200 - 300	.003-.006
	GRAY - PEARLITIC	220 - 320	120 - 300	.002-.004
	GRAY - FERRITIC	110 - 240	250 - 425	.003-.006
	MALLEABLE CAST IRON - MARTENSITIC	200 - 320	130 - 225	.002-.004
	MALLEABLE CAST IRON - FERRITIC & PEARLITIC	110 - 240	200 - 400	.003-.006
LOW CARBON STEELS	LOW AND MEDIUM CARBON STEEL - FREE MACHINING	100 - 250	250 - 500	.003-.006
	LOW AND MEDIUM CARBON STEEL - WROUGHT	100 - 363	200 - 400	.002-.004
MEDIUM STRENGTH STEELS	LOW AND MEDIUM CARBON ALLOY STEEL - FREE MACHINING	100 - 275	200 - 400	.002-.004
	LOW AND MEDIUM CARBON ALLOY STEEL	85 - 363	150 - 300	.002-.005
	STAINLESS STEEL - 400 SERIES	135 - 325	200 - 400	.003-.006
	STAINLESS STEEL - 400 SERIES FREE MACHINING	135 - 275	250 - 500	.003-.006
HIGH STRENGTH STEELS	HIGH STRENGTH STEEL - WROUGHT & TOOL STEEL	175 - 363	75 - 150	.002-.004
HIGH TEMP. ALLOYS	HIGH TEMP ALLOYS NICKEL & IRON BASE ALLOY	140 - 300	50 - 150	.002-.004
	STAINLESS STEEL - 300 SERIES	135 - 363	75 - 150	.002-.004
	STAINLESS STEEL - PH SERIES	150 - 363	75 - 150	.002-.004
	TITANIUM ALLOY	110 - 363	100 - 200	.002-.004

*500 kg

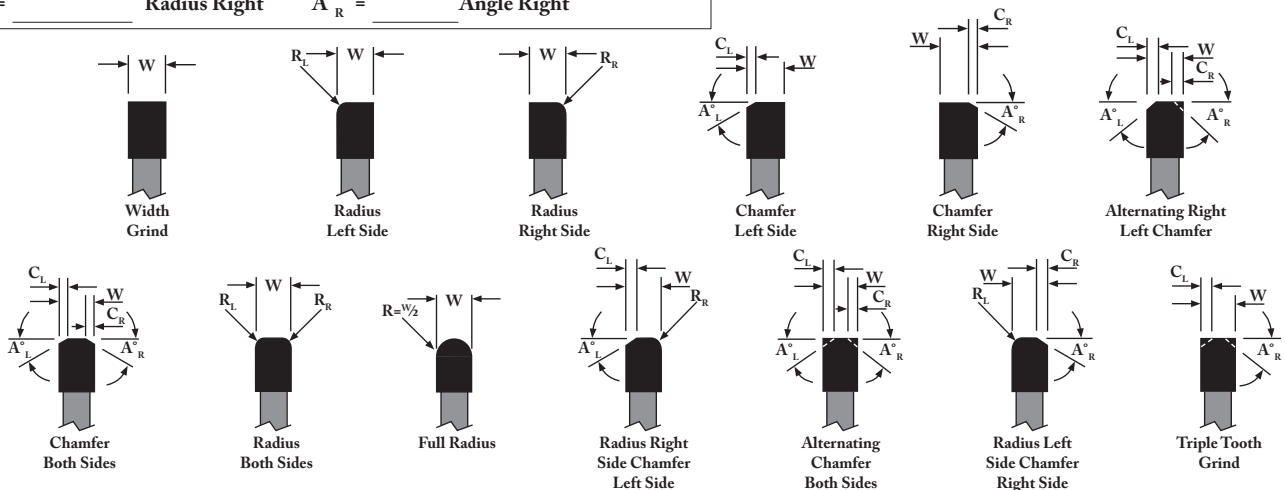
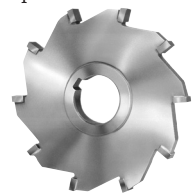
Name _____ **Phone** _____
Distributor _____ **Fax** _____
Ship to Address _____
Purchase Order# _____ **Quantity** _____
Material Being Cut _____

DIMENSION INFORMATION

EDP = _____ C_L = _____ **Chamfer Length Left**
 W = _____ **Width** C_R = _____ **Chamfer Length Right**
 R_L = _____ **Radius Left** A°_L = _____ **Angle Left**
 R_R = _____ **Radius Right** A°_R = _____ **Angle Right**

ORDERING INFORMATION

1. Specify EDP number from charts on previous pages
2. Circle desired grind style from diagrams below
3. Fill in applicable dimensions in space provided
4. Fill in required contact information
5. Call, fax, or email to Super Tool using contact information at bottom of page



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