

End Mills featuring high efficiency at speeds as low as 3,000 RPM and provide maximum performance at speeds of 10,000 RPM and higher!

Our flute designs are engineered to create less drag on the spindle and draw less power.

Applications for roughing and/or finishing can be accomplished with either low or high horsepower.

These selected families of End Mills provide maximum performance in following materials:

Aluminum Alloys
High Silicon Aluminum
Brass, Bronze, and Copper Alloys
Composites, Fiberglass, and Plastics

Die Cast Aluminum
Extruded Metal Materials
Non-Ferrous Materials
Magnesium Alloys



MATERIAL TYPES	Type of Cut	Axial D.O.C.	Radial D.O.C.	No. of Flutes	M/Min (Vc)	Cutter Diameter Chip Load per Tooth (Fz)						
						3	6	9	12	16	20	25
Non-Ferrous Materials												
Aluminum / Aluminum Alloys												
2024, 6061, 7075	Slotting	D x 1	D x 1	2	243	.051	.102	.152	.203	.254	.305	.406
	Roughing	D x 1	D x .75	3	304	.051	.0050	.191	.254	.305	.381	.508
	Finishing	D x 1.5	D x .01	3	365	.076	.0060	.229	.305	.406	.0200	.635
High Silicone Aluminum												
A380, A390	Slotting	D x 1	D x 1	3	122	.025	.051	.076	.102	.127	.152	.203
	Roughing	D x 1	D x .75	3	182	.038	.076	.114	.152	.191	.229	.305
	Finishing	D x 1.5	D x .01	3	243	.046	.089	.140	.178	.229	.279	.356
Brass / Bronze / Copper Alloys												
High Lead Brass, Red Brass, Yellow Brass, Naval Brass, Low Silicon Brass, Beryllium Copper, Nickel Silver, Oxygen Free Copper	Slotting	D x .75	D x 1	2	122	.025	.051	.076	.102	.127	.152	.203
	Roughing	D x 1	D x .75	3	144	.031	.064	.094	.127	.160	.191	.254
	Finishing	D x 1.5	D x .01	3	167	.038	.076	.114	.152	.191	.229	.305
Composites, Fiberglass, Plastics												
Acrylics, Fiberglass, Glass Epoxy, Phenolics, Plastics	Slotting	D x 1	D x 1	3	122	.025	.051	.076	.102	.127	.152	.203
	Roughing	D x 1	D x .75	3	182	.038	.076	.114	.152	.191	.229	.305
	Finishing	D x 1.5	D x .01	3	243	.046	.089	.140	.178	.229	.279	.365
Magnesium Alloys												
	Slotting	D x 1	D x 1	2	243	.051	.102	.152	.203	.254	.305	.406
	Roughing	D x 1	D x .75	3	304	.051	.127	.191	.254	.305	.381	.508
	Finishing	D x 1.5	D x .01	3	365	.076	.152	.229	.305	.406	.508	.635

The Machining Data shown below, is considered to be "safe starting conditions" and may need to be adjusted to obtain optimal tool performance.

Safety precautions must be implemented including safety glasses and machine shields to protect the operator and/or observers from hot flying chips.

Our Technical Team is ready to offer solutions for that difficult machining application. Whether you need tool specific speeds, feeds, depth of cuts, grade selection(s) or any questions and/or concerns regarding the application of MICRO 100 Solid Carbide Cutting Tools, they are there to help!

