

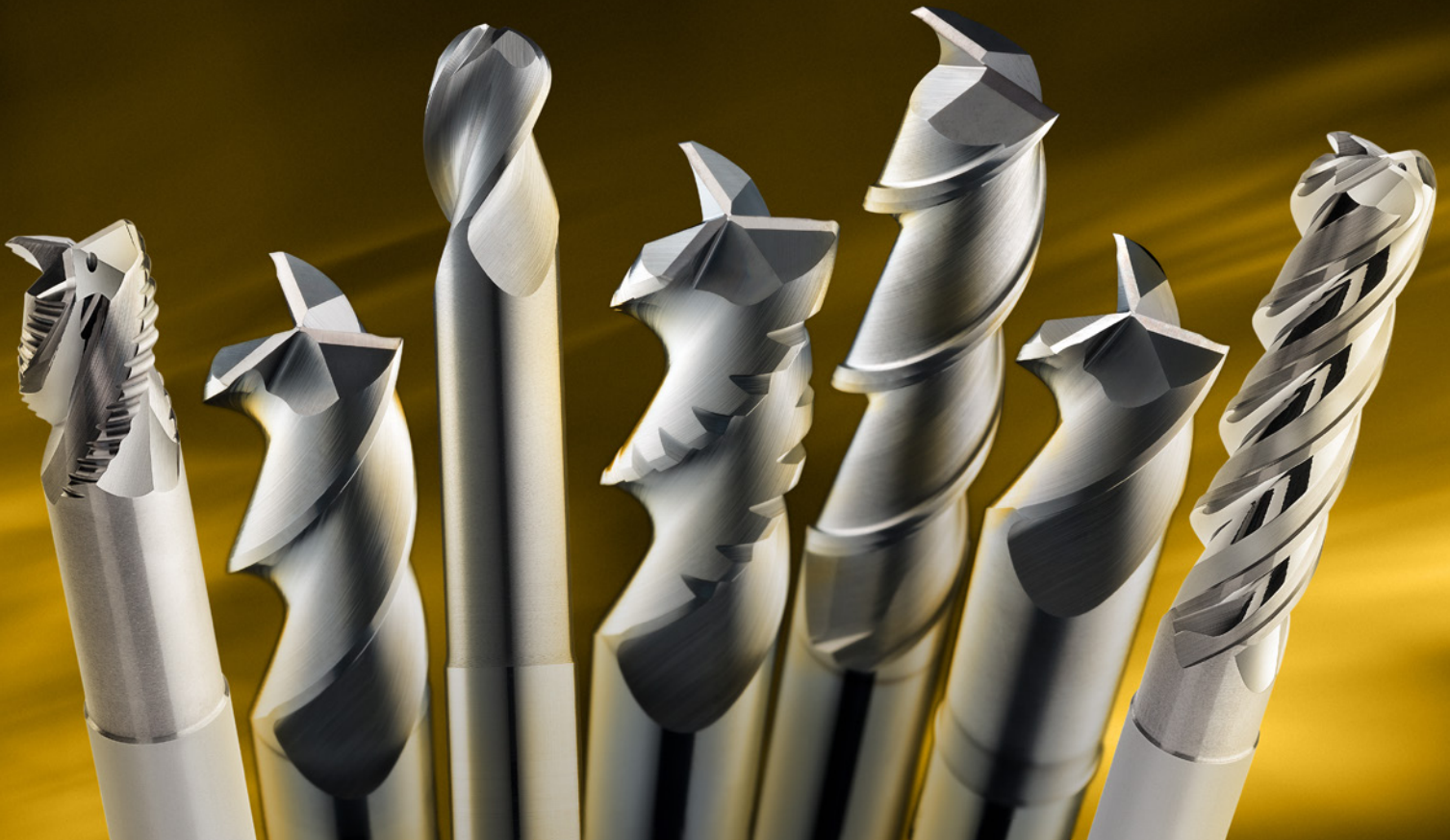
Aluminum

Tools For Aluminum | VALUE AT THE SPINDLE

New Expanded Offering



ISO 9001 Certified Company



S-CARB HIGH PERFORMANCE END MILLS

The original, symmetrical flute design features an engineered flute form that provides high performance results through a full range of machining conditions. These tools are designed for aggressive aluminum, non-ferrous, and non-metallic machining requiring a high level of material removal.

Engineered Flute Design

- Effective chip removal at high feed rates
- Lower cutting forces than comparable products
- Improved balance at high spindle speeds
- Improved workpiece finish through better balance
- More effective plunging vs. conventional designs

Circular Land

- Increased control at various speed and feed levels
- Reduced chatter

Various Reach, Neck and End Options Available

- Ball End design for complex workpieces
- Necked design with blended diameter transitions provide clearance to reach
- Short flutes for maximum rigidity
- Axial slotting up to 1xD

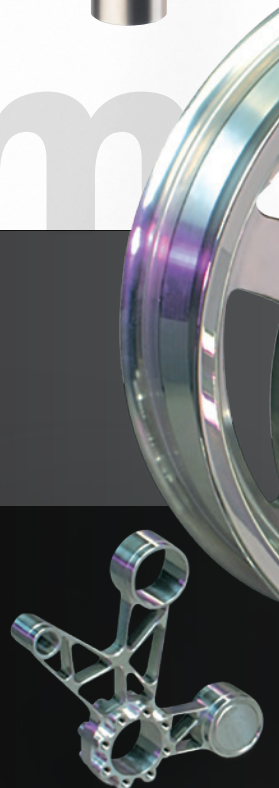


Aluminum

S-CARB END MILLS FOR
**ALUMINUM, NON-FERROUS &
NON-METALLIC MATERIALS**

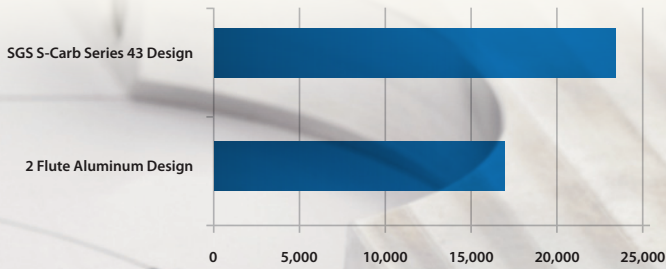
VALUE AT THE SPINDLE

ENHANCED PRODUCTIVITY RESULTING FROM A SUPERIOR FLUTE DESIGN THAT MANAGES THE SIZE AND VOLUME OF CHIPS PRODUCED DURING AGGRESSIVE MACHINING.



Maximum RPM Capability

Results of Independent Lab Balance Analysis Testing per the ISO G2.5 Tolerance
 1/2" Diameter Tools Equal Flute Lengths and Overall Lengths



Ti-NANITE-8

Available with TiB₂ Coating (Titanium Diboride). This ceramic based coating ensures a smooth surface and a low affinity to cold welding or edge build-up, which makes it optimal for aluminum and copper applications. It has high toughness and high hardness.

- Microhardness: 4000 HV**
- Oxidation Temperature: 850°C / 1562°F**
- Coefficient of Friction: 0.45**
- Thickness: 1 - 2 Microns (based on tool diameter)**

S-CARB HIGH PERFORMANCE END MILLS ARE IDEAL FOR CYCLE TIME REDUCTION IN TARGET APPLICATIONS SUCH AS:

Aerospace

- Structure components

Automotive/Motorbike

- Performance aluminum wheels
- Non-ferrous housings, transmissions, manifolds, electronic pumps

Mold & Die

- Non-ferrous mold cavities

Firearms

- Aluminum components

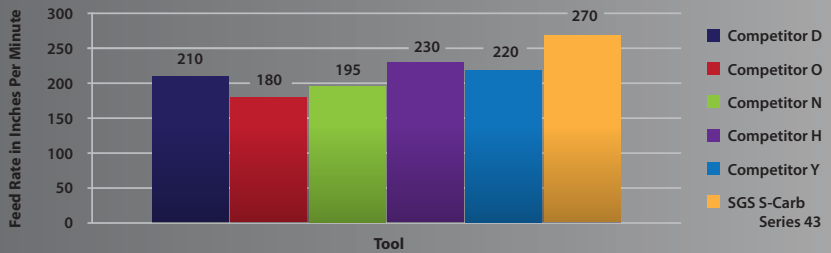
Semiconductor

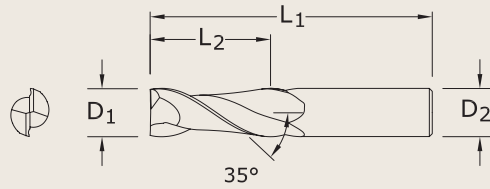
- Aluminum vacuum chambers



SLOTTING CAPABILITY: 3-FLUTE END MILLS

MAXIMUM FEED RATE ACHIEVED AT 100% SPINDLE LOAD ON A 30 HP VERTICAL MILL IN 6061 ALUMINUM @ 10,000 RPM .500" DEEP SLOT .500" DIAMETER TOOL

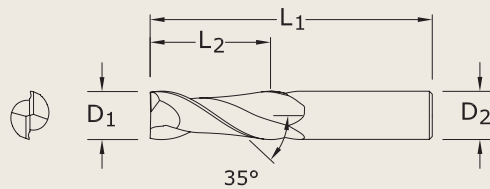
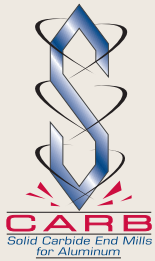




DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

**SERIES 47
(FRACTIONAL)**

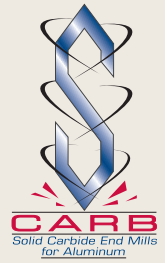
Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	3/8	1-1/2	1/8	34620	34660
3/16	9/16	2	3/16	34621	34661
1/4	3/4	2-1/2	1/4	34622	34662
5/16	13/16	2-1/2	5/16	34623	34663
3/8	1	2-1/2	3/8	34624	34664
1/2	1-1/4	3-1/4	1/2	34625	34665
5/8	1-5/8	3-3/4	5/8	34626	34666
3/4	1-5/8	4	3/4	34627	34667
1	2	4-1/2	1	34628	34668



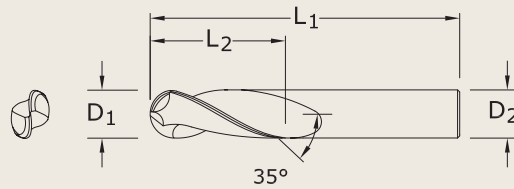
DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
≥ 3	+0,000 / -0,006	h6
> 3 - 6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6

**SERIES 47M
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
3,0	8,0	38,0	3,0	44550	44587
4,0	11,0	50,0	4,0	44551	44588
5,0	13,0	50,0	5,0	44552	44589
6,0	13,0	57,0	6,0	44553	44590
8,0	19,0	63,0	8,0	44554	44591
10,0	22,0	72,0	10,0	44555	44592
12,0	26,0	83,0	12,0	44556	44593
14,0	26,0	83,0	14,0	44557	44594
16,0	32,0	92,0	16,0	44558	44595
20,0	38,0	104,0	20,0	44559	44596
25,0	44,0	104,0	25,0	44560	44597



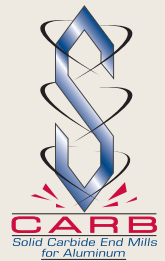
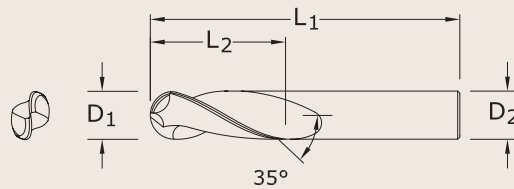
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



**SERIES 47B
(FRACTIONAL)**

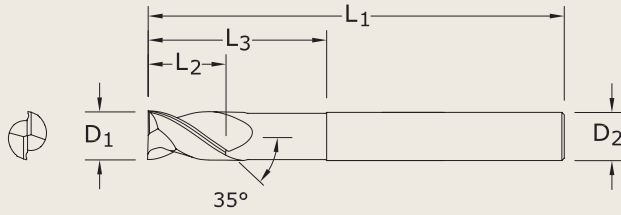
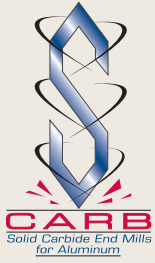
Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	3/8	1-1/2	1/8	34630	34669
3/16	9/16	2	3/16	34631	34670
1/4	3/4	2-1/2	1/4	34632	34671
5/16	13/16	2-1/2	5/16	34633	34672
3/8	1	2-1/2	3/8	34634	34673
1/2	1-1/4	3-1/4	1/2	34635	34674
5/8	1-5/8	3-3/4	5/8	34636	34675
3/4	1-5/8	4	3/4	34637	34676
1	2	4-1/2	1	34638	34677

DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
≥ 3	+0,000 / -0,006	h6
> 3 - 6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6



**SERIES 47MB
(METRIC)**

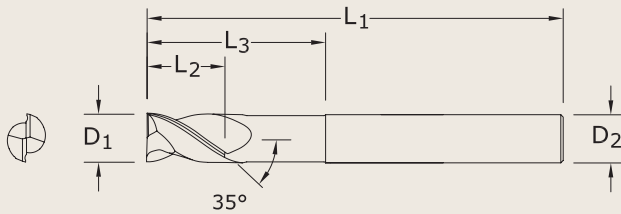
Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
3,0	8,0	38,0	3,0	44570	44598
4,0	11,0	50,0	4,0	44571	44599
5,0	13,0	50,0	5,0	44572	44600
6,0	13,0	57,0	6,0	44573	44601
8,0	19,0	63,0	8,0	44574	44602
10,0	22,0	72,0	10,0	44575	44603
12,0	26,0	83,0	12,0	44576	44604
14,0	26,0	83,0	14,0	44577	44605
16,0	32,0	92,0	16,0	44578	44606
20,0	38,0	104,0	20,0	44579	44607
25,0	44,0	104,0	25,0	44580	44608



DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

**SERIES 47L
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	4	1/4	2-1/8	34640	34678
3/8	1/2	4	3/8	2-1/8	34641	34679
1/2	5/8	6	1/2	2-1/8	34642	34680
1/2	5/8	6	1/2	3-3/8	34643	34681
5/8	3/4	6	5/8	2-3/8	34644	34682
5/8	3/4	6	5/8	3-3/8	34645	34683
3/4	1	6	3/4	2-1/2	34646	34684
3/4	1	6	3/4	3-3/8	34647	34685

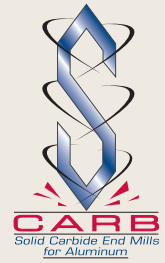
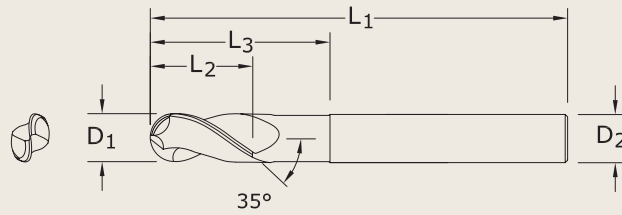


DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6

**SERIES 47ML
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
6,0	10,0	100,0	6,0	54,0	44561	44609
8,0	12,0	100,0	8,0	54,0	44562	44610
10,0	12,0	100,0	10,0	54,0	44563	44611
12,0	16,0	150,0	12,0	80,0	44564	44612
16,0	20,0	150,0	16,0	80,0	44565	44613
20,0	25,0	150,0	20,0	80,0	44566	44614

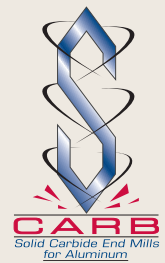
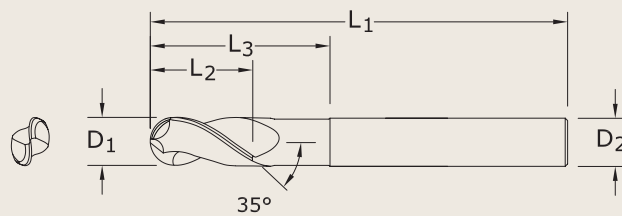
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



**SERIES 47LB
(FRACTIONAL)**

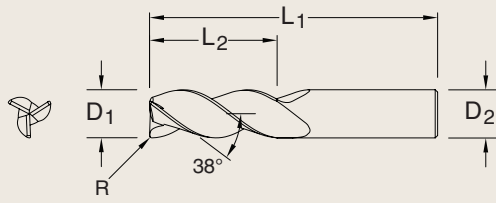
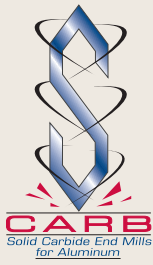
Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	4	1/4	2-1/8	34650	34686
3/8	1/2	4	3/8	2-1/8	34651	34687
1/2	5/8	6	1/2	2-1/8	34652	34688
1/2	5/8	6	1/2	3-3/8	34653	34689
5/8	3/4	6	5/8	3-3/8	34654	34691
5/8	3/4	6	5/8	2-3/8	34655	34690
3/4	1	6	3/4	2-1/2	34656	34693
3/4	1	6	3/4	3-3/8	34657	34692

DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6



**SERIES 47MLB
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
6,0	10,0	100,0	6,0	54,0	44581	44615
8,0	12,0	100,0	8,0	54,0	44582	44616
10,0	12,0	100,0	10,0	54,0	44583	44617
12,0	16,0	150,0	12,0	80,0	44584	44618
16,0	20,0	150,0	16,0	80,0	44585	44619
20,0	25,0	150,0	20,0	80,0	44586	44620



DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

CORNER RADIUS TOLERANCES (inch)	
R = +0.0000 / -0.0020	

New Expanded Tools

**SERIES 43CR
(FRACTIONAL)**

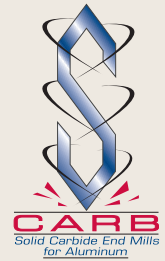
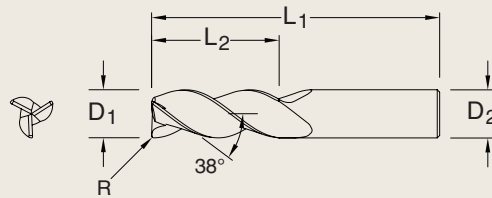
Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	3/8	1-1/2	1/8	.010	34771	34793
3/16	9/16	2	3/16	.010	34772	34794
1/4	3/8	2-1/2	1/4	.010	35575	35665
1/4	3/8	2-1/2	1/4	.015	35576	35666
1/4	3/8	2-1/2	1/4	.030	35577	35667
1/4	3/8	2-1/2	1/4	.060	35578	35668
1/4	3/4	2-1/2	1/4	.010	34773	34795
1/4	3/4	2-1/2	1/4	.015	35579	35669
1/4	3/4	2-1/2	1/4	.030	34774	34796
1/4	3/4	2-1/2	1/4	.060	35580	35670
1/4	1	3	1/4	.010	35581	35671
1/4	1	3	1/4	.015	35582	35672
1/4	1	3	1/4	.030	35583	35673
1/4	1	3	1/4	.060	35584	35674
5/16	5/8	2-1/2	5/16	.030	34775	34797
3/8	1/2	3	3/8	.010	35585	35675
3/8	1/2	3	3/8	.015	35586	35676
3/8	1/2	3	3/8	.030	35587	35677
3/8	1/2	3	3/8	.060	35588	35678
3/8	1/2	3	3/8	.090	35589	35679
3/8	1	2-1/2	3/8	.010	34776	34798
3/8	1	2-1/2	3/8	.030	34777	34799
3/8	1	2-1/2	3/8	.060	32761	32825
3/8	1	3	3/8	.015	35590	35680
3/8	1	3	3/8	.090	35591	35681
3/8	1-1/2	4	3/8	.010	35592	35682
3/8	1-1/2	4	3/8	.015	35593	35683
3/8	1-1/2	4	3/8	.030	35594	35684
3/8	1-1/2	4	3/8	.060	35595	35685
3/8	1-1/2	4	3/8	.090	35596	35686
1/2	5/8	3	1/2	.010	35597	35687
1/2	5/8	3	1/2	.015	35598	35688
1/2	5/8	3	1/2	.030	35599	35689
1/2	5/8	3	1/2	.060	35600	35690
1/2	5/8	3	1/2	.090	35601	35691
1/2	5/8	3	1/2	.120	35602	35692
1/2	1	3	1/2	.010	35603	35693
1/2	1	3	1/2	.015	35604	35694
1/2	1	3	1/2	.030	35605	35695
1/2	1	3	1/2	.060	35606	35696
1/2	1	3	1/2	.090	35607	35697
1/2	1	3	1/2	.120	35608	35698
1/2	1-1/4	3	1/2	.015	35609	35699
1/2	1-1/4	3-1/4	1/2	.010	34778	34800
1/2	1-1/4	3-1/4	1/2	.030	34779	34801
1/2	1-1/4	3-1/4	1/2	.060	34780	34802

(continued on next page)

DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

CORNER RADIUS TOLERANCES (inch)

R = +0.0000 / -0.0020

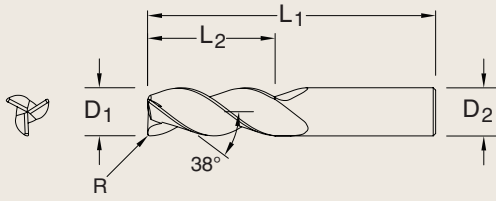
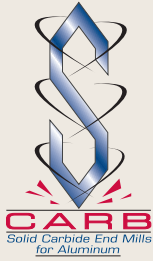


New Expanded Tools

**SERIES 43CR
(FRACTIONAL)
(CONTINUED)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/2	1-1/4	3-1/4	1/2	.090	34781	34803
1/2	1-1/4	3-1/4	1/2	.120	32766	32830
1/2	1-5/8	4	1/2	.010	35610	35700
1/2	1-5/8	4	1/2	.015	35611	35701
1/2	1-5/8	4	1/2	.030	35612	35702
1/2	1-5/8	4	1/2	.060	35613	35703
1/2	1-5/8	4	1/2	.090	35614	35704
1/2	1-5/8	4	1/2	.120	35615	35705
1/2	2	4	1/2	.010	35616	35706
1/2	2	4	1/2	.015	35617	35707
1/2	2	4	1/2	.030	35618	35708
1/2	2	4	1/2	.060	35619	35709
1/2	2	4	1/2	.090	35620	35710
1/2	2	4	1/2	.120	35621	35711
5/8	3/4	3-1/2	5/8	.030	35622	35712
5/8	3/4	3-1/2	5/8	.060	35623	35713
5/8	3/4	3-1/2	5/8	.090	35624	35714
5/8	3/4	3-1/2	5/8	.120	35625	35715
5/8	1-5/8	3-1/2	5/8	.120	35626	35716
5/8	1-5/8	3-3/4	5/8	.030	34782	34804
5/8	1-5/8	3-3/4	5/8	.060	34783	34805
5/8	1-5/8	3-3/4	5/8	.090	34784	34806
3/4	1	4	3/4	.030	35627	35717
3/4	1	4	3/4	.060	35628	35718
3/4	1	4	3/4	.090	35629	35719
3/4	1	4	3/4	.120	35630	35720
3/4	1	4	3/4	.190	35631	35721
3/4	1	4	3/4	.250	35632	35722
3/4	1-5/8	4	3/4	.030	34785	34807
3/4	1-5/8	4	3/4	.060	34786	34808
3/4	1-5/8	4	3/4	.090	34787	34809
3/4	1-5/8	4	3/4	.120	34815	34817
3/4	1-5/8	4	3/4	.190	35633	35723
3/4	1-5/8	4	3/4	.250	35634	35724
3/4	2-1/4	5	3/4	.030	35635	35725
3/4	2-1/4	5	3/4	.060	35636	35726
3/4	2-1/4	5	3/4	.090	35637	35727
3/4	2-1/4	5	3/4	.120	35638	35728
3/4	2-1/4	5	3/4	.190	35639	35729
3/4	2-1/4	5	3/4	.250	35640	35730
1	1-1/4	5	1	.030	35641	35731
1	1-1/4	5	1	.060	35642	35732
1	1-1/4	5	1	.090	35643	35733
1	1-1/4	5	1	.120	35644	35734
1	1-1/4	5	1	.190	35645	35735
1	1-1/4	5	1	.250	35646	35736

(continued on next page)



DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

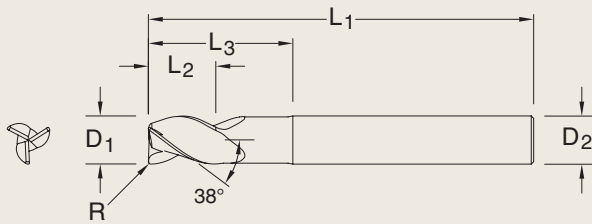
CORNER RADIUS TOLERANCES (inch)

R = +0.0000 / -0.0020

New Expanded Tools

**SERIES 43CR
(FRACTIONAL)
(CONTINUED)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1	2	5	1	.190	35647	35737
1	2	5	1	.250	35648	35738
1	2	4-1/2	1	.030	34789	34811
1	2	4-1/2	1	.060	34790	34812
1	2	4-1/2	1	.090	34791	34813
1	2	4-1/2	1	.120	34816	34818
1	3-1/4	6	1	.030	35649	35739
1	3-1/4	6	1	.060	35650	35740
1	3-1/4	6	1	.090	35651	35741
1	3-1/4	6	1	.120	35652	35742
1	3-1/4	6	1	.190	35653	35743
1	3-1/4	6	1	.250	35654	35744



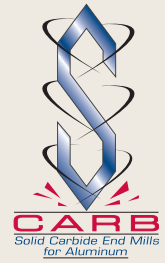
DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6

CORNER RADIUS TOLERANCES (mm)

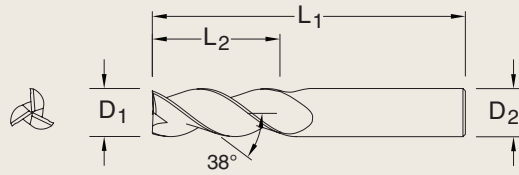
R = +0,00 / -0,05

**SERIES 43MCR
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
6,0	10,0	63,0	6,0	20,0	0,5	44769	44789
6,0	10,0	63,0	6,0	20,0	1,0	44770	44790
6,0	13,0	72,0	6,0	30,0	0,5	44771	44791
6,0	13,0	72,0	6,0	30,0	1,0	44772	44792
8,0	12,0	75,0	8,0	25,0	0,3	44773	44793
8,0	12,0	75,0	8,0	25,0	0,5	44774	44794
8,0	12,0	75,0	8,0	25,0	1,0	44775	44795
8,0	12,0	75,0	8,0	25,0	1,5	44776	44796
10,0	14,0	100,0	10,0	35,0	0,3	44777	44797
10,0	14,0	100,0	10,0	35,0	0,5	44778	44798
10,0	14,0	100,0	10,0	35,0	1,0	44779	44799
10,0	14,0	100,0	10,0	35,0	1,5	44780	44800
12,0	16,0	100,0	12,0	40,0	0,5	44781	44801
12,0	16,0	100,0	12,0	40,0	1,0	44782	44802
12,0	16,0	100,0	12,0	40,0	1,5	44783	44803
12,0	16,0	100,0	12,0	40,0	2,0	44784	44804
16,0	20,0	125,0	16,0	50,0	2,0	44785	44805
16,0	20,0	125,0	16,0	50,0	4,0	44786	44806
20,0	25,0	150,0	20,0	65,0	2,0	44787	44807
20,0	25,0	150,0	20,0	65,0	4,0	44788	44808



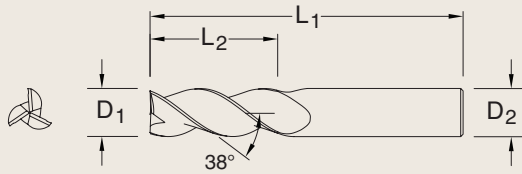
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



New Expanded Tools

SERIES 43
(FRACTIONAL)

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	3/8	1-1/2	1/8	34701	34728
3/16	5/16	2-1/2	3/16	34822	34857
3/16	9/16	2	3/16	34702	34729
3/16	3/4	2-1/2	3/16	34823	34858
1/4	3/8	2	1/4	34703	34730
1/4	1/2	2-1/2	1/4	34824	34859
1/4	3/4	2-1/2	1/4	34704	34731
1/4	1	3	1/4	34825	34860
1/4	1-1/4	3-1/2	1/4	34705	34732
1/4	1-3/4	4	1/4	34826	34861
5/16	7/16	2	5/16	34706	34733
5/16	5/8	2-1/2	5/16	34707	34734
5/16	1-1/4	4	5/16	34708	34735
3/8	1/2	2	3/8	34709	34736
3/8	1	2-1/2	3/8	34710	34737
3/8	1-1/4	3-1/2	3/8	34827	34862
3/8	1-1/2	3-1/2	3/8	34711	34738
3/8	2	4	3/8	34828	34863
1/2	5/8	2-1/2	1/2	34712	34739
1/2	1	3	1/2	34830	34865
1/2	1-1/4	3-1/4	1/2	34713	34740
1/2	1-5/8	4	1/2	34831	34866
1/2	2-1/2	5	1/2	34832	34867
1/2	2	4	1/2	34714	34741
1/2	3-1/8	6	1/2	34715	34742
5/8	3/4	3	5/8	34716	34743
5/8	1-5/8	3-3/4	5/8	34717	34744
5/8	2-1/8	4	5/8	34833	34868
5/8	2-1/2	5	5/8	34718	34745
5/8	3-1/4	6	5/8	34834	34869
5/8	3-3/4	6	5/8	34719	34746
3/4	1	3	3/4	34720	34747
3/4	1-5/8	4	3/4	34721	34748
3/4	2-1/4	5	3/4	34722	34749
3/4	3-1/4	6	3/4	34723	34750
1	1-1/4	4	1	34724	34751
1	2	4-1/2	1	34725	34752
1	2-5/8	6	1	34726	34753
1	3-1/4	6	1	34727	34754
1	4-1/8	7	1	34835	34870

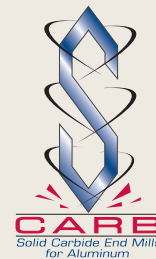


DIAMETER	TOLERANCES (mm)	
	D ₁	D ₂
6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6

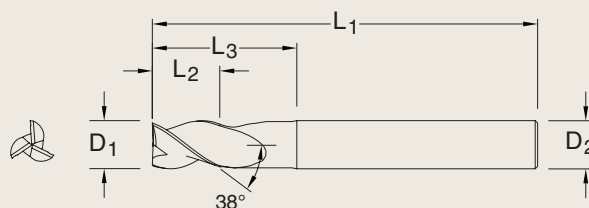
**SERIES 43M
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
6,0	13,0	57,0	6,0	44701	44715
6,0	13,0	72,0	6,0	44702	44716
8,0	19,0	63,0	8,0	44703	44717
10,0	22,0	72,0	10,0	44705	44719
12,0	26,0	83,0	12,0	44708	44722
16,0	32,0	92,0	16,0	44711	44725
20,0	38,0	104,0	20,0	44714	44728





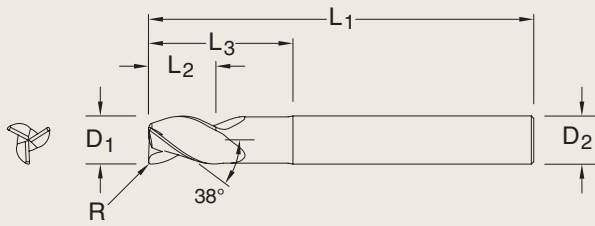
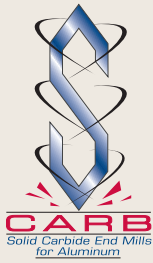
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



New Expanded Tools

**SERIES 43L
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	5/32	3	1/8	1/2	32700	32725
1/8	5/32	3	1/8	3/4	32691	34888
3/16	7/32	3	3/16	1/2	32701	32726
3/16	7/32	3	3/16	3/4	32692	34889
1/4	3/8	4	1/4	3/4	32702	32727
1/4	3/8	4	1/4	1-1/2	32703	32728
1/4	3/8	4	1/4	2-1/8	32704	32729
5/16	7/16	4	5/16	1-1/8	32705	32730
5/16	7/16	4	5/16	2-1/8	32706	32731
3/8	1/2	4	3/8	1-1/8	32707	32732
3/8	1/2	4	3/8	2-1/8	32708	32733
1/2	5/8	4	1/2	1-3/8	32709	32734
1/2	5/8	6	1/2	2-1/8	32710	32735
1/2	5/8	6	1/2	3-3/8	32711	32736
1/2	5/8	6	1/2	4-1/4	32697	34894
5/8	3/4	4	5/8	1-3/4	32712	32737
5/8	3/4	4	5/8	2-3/8	32713	32738
5/8	3/4	6	5/8	3-3/8	32714	32739
5/8	3/4	6	5/8	4-3/8	32698	34895
3/4	1	4	3/4	1-3/4	32715	32740
3/4	1	6	3/4	2-3/8	32716	32741
3/4	1	6	3/4	3-3/8	32717	32742
3/4	1	6	3/4	4-3/8	32699	34896
1	1-1/4	6	1	2-3/8	32718	32743
1	1-1/4	6	1	3-3/8	32719	32744
1	1-1/4	7	1	4-3/8	32720	32745



DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

CORNER RADIUS TOLERANCES (inch)	
R =	+0.0000 / -0.0020

New Expanded Tools

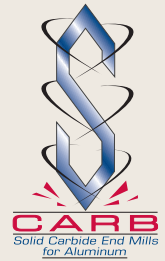
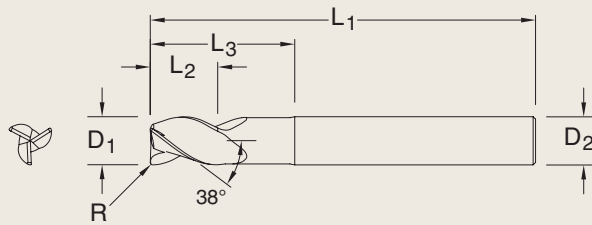
SERIES 43LC (FRACTIONAL)

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/8	5/32	3	1/8	1/2	.010	32751	32815
3/16	7/32	3	3/16	1/2	.010	32752	32816
1/4	3/8	2-1/2	1/4	3/4	.015	35787	36235
1/4	3/8	2-1/2	1/4	3/4	.060	35788	36236
1/4	3/8	4	1/4	3/4	.010	32753	32817
1/4	3/8	4	1/4	3/4	.030	32754	32818
1/4	3/8	4	1/4	1-1/2	.010	32755	32819
1/4	3/8	4	1/4	1-1/2	.030	32756	32820
1/4	3/8	4	1/4	2-1/8	.010	32757	32821
1/4	3/8	4	1/4	2-1/8	.030	32758	32822
5/16	7/16	4	5/16	1-1/8	.030	32759	32823
5/16	7/16	4	5/16	2-1/8	.030	32760	32824
3/8	1/2	3	3/8	1-1/8	.015	35791	36239
3/8	1/2	3	3/8	1-1/8	.090	35792	36240
3/8	1/2	4	3/8	1-1/8	.030	32762	32826
3/8	1/2	4	3/8	1-1/8	.060	32763	32827
3/8	1/2	4	3/8	2-1/8	.030	32764	32828
3/8	1/2	4	3/8	2-1/8	.060	32765	32829
1/2	5/8	3	1/2	1-3/8	.015	35795	36243
1/2	5/8	4	1/2	1-3/8	.030	32767	32831
1/2	5/8	4	1/2	1-3/8	.060	32768	32832
1/2	5/8	4	1/2	1-3/8	.090	32769	32833
1/2	5/8	4	1/2	1-3/8	.120	32770	32834
1/2	5/8	4	1/2	2-1/4	.015	35796	36244
1/2	5/8	6	1/2	2-1/8	.030	32771	32835
1/2	5/8	6	1/2	2-1/8	.060	32772	32836
1/2	5/8	6	1/2	2-1/8	.090	32773	32837
1/2	5/8	6	1/2	2-1/8	.120	32774	32838
1/2	5/8	6	1/2	3-3/8	.030	32775	32839
1/2	5/8	6	1/2	3-3/8	.060	32776	32840
1/2	5/8	6	1/2	3-3/8	.090	32777	32841
1/2	5/8	6	1/2	3-3/8	.120	32778	32842
5/8	3/4	4	5/8	1-3/4	.030	32779	32843
5/8	3/4	4	5/8	1-3/4	.060	32780	32844
5/8	3/4	4	5/8	1-3/4	.090	32781	32845
5/8	3/4	4	5/8	1-3/4	.120	32782	32846

(continued on next page)

DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/8 - 3/16	+0.00000 / -0.00032	h6
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

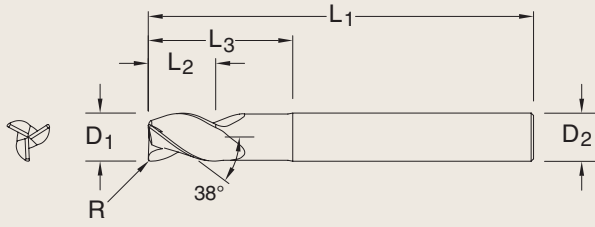
CORNER RADIUS TOLERANCES (inch)	
R =	+0.0000 / -0.0020



New Expanded Tools

SERIES 43LC (FRACTIONAL)

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
5/8	3/4	4	5/8	2-3/8	.030	32783	32847
5/8	3/4	4	5/8	2-3/8	.060	32784	32848
5/8	3/4	4	5/8	2-3/8	.090	32785	32849
5/8	3/4	4	5/8	2-3/8	.120	32786	32850
5/8	3/4	6	5/8	3-3/8	.030	32787	32851
5/8	3/4	6	5/8	3-3/8	.060	32788	32852
5/8	3/4	6	5/8	3-3/8	.090	32789	32853
5/8	3/4	6	5/8	3-3/8	.120	32790	32854
3/4	1	4	3/4	1-3/4	.030	32791	32855
3/4	1	4	3/4	1-3/4	.060	32792	32856
3/4	1	4	3/4	1-3/4	.090	32793	32857
3/4	1	4	3/4	1-3/4	.120	32794	32858
3/4	1	4	3/4	2	.190	35803	36251
3/4	1	4	3/4	2	.250	35804	36252
3/4	1	6	3/4	2-3/8	.030	32795	32859
3/4	1	6	3/4	2-3/8	.060	32796	32860
3/4	1	6	3/4	2-3/8	.090	32797	32861
3/4	1	6	3/4	2-3/8	.120	32798	32862
3/4	1	6	3/4	3-3/8	.030	32799	32863
3/4	1	6	3/4	3-3/8	.060	32800	32864
3/4	1	6	3/4	3-3/8	.090	32801	32865
3/4	1	6	3/4	3-3/8	.120	32802	32866
1	1-1/4	5	1	2-5/8	.190	35809	36257
1	1-1/4	5	1	2-5/8	.250	35810	36258
1	1-1/4	6	1	2-3/8	.030	32803	32867
1	1-1/4	6	1	2-3/8	.060	32804	32868
1	1-1/4	6	1	2-3/8	.090	32805	32869
1	1-1/4	6	1	2-3/8	.120	32806	32870
1	1-1/4	6	1	3-3/8	.030	32807	32871
1	1-1/4	6	1	3-3/8	.060	32808	32872
1	1-1/4	6	1	3-3/8	.090	32809	32873
1	1-1/4	6	1	3-3/8	.120	32810	32874
1	1-1/4	6	1	3-3/8	.190	35811	36259
1	1-1/4	6	1	3-3/8	.250	35812	36260



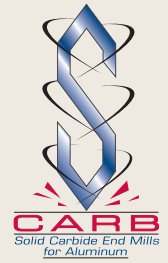
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

CORNER RADIUS TOLERANCES (inch)	
R =	+0.0000 / -0.0020

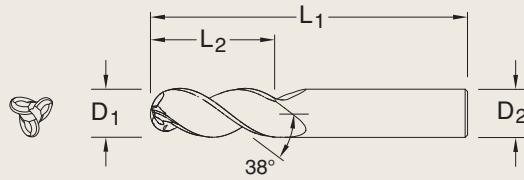
New Expanded Tools

**SERIES 43EC
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	3	1/4	1-1/8	.015	35789	36237
1/4	3/8	3	1/4	1-1/8	.060	35790	36238
3/8	1/2	4	3/8	2-1/8	.015	35793	36241
3/8	1/2	4	3/8	2-1/8	.090	35794	36242
1/2	5/8	5	1/2	3-3/8	.015	35797	36245
1/2	5/8	6	1/2	4-1/4	.015	35798	36246
1/2	5/8	6	1/2	4-1/4	.030	35799	36247
1/2	5/8	6	1/2	4-1/4	.060	35800	36248
1/2	5/8	6	1/2	4-1/4	.090	35801	36249
1/2	5/8	6	1/2	4-1/4	.120	35802	36250
3/4	1	6	3/4	3-3/8	.190	35805	36253
3/4	1	6	3/4	3-3/8	.250	35806	36254
1	1-1/4	7	1	4-3/8	.030	35813	36261
1	1-1/4	7	1	4-3/8	.060	35814	36262
1	1-1/4	7	1	4-3/8	.090	35815	36263
1	1-1/4	7	1	4-3/8	.120	35816	36264
1	1-1/4	7	1	4-3/8	.190	35817	36265
1	1-1/4	7	1	4-3/8	.250	35818	36266



DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

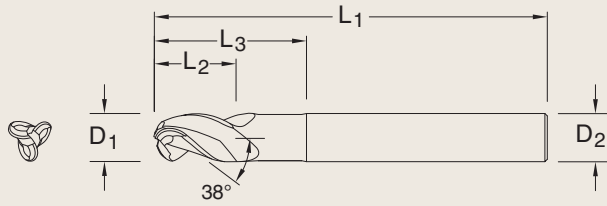
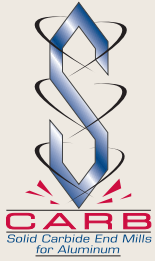


New Expanded Tools

SERIES 43B (FRACTIONAL)

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	2	1/4	34916	34972
1/4	3/4	2-1/2	1/4	34917	34973
1/4	1	3	1/4	34918	34974
3/8	1/2	2	3/8	34919	34975
3/8	1	2-1/2	3/8	34920	34976
3/8	1-1/2	3-1/2	3/8	34921	34977
1/2	5/8	2-1/2	1/2	34922	34978
1/2	1	3	1/2	34923	34979
1/2	1-1/4	3	1/2	34924	34980
1/2	1-5/8	4	1/2	34925	34981
1/2	2	4	1/2	34926	34982
5/8	3/4	3	5/8	34927	34983
5/8	1-5/8	4	5/8	34928	34984
3/4	1	3	3/4	34929	34985
3/4	1-5/8	4	3/4	34930	34986
3/4	2-1/4	5	3/4	34931	34987
1	1-1/4	4	1	34932	34988
1	2	5	1	34933	34989
1	3-1/4	6	1	34934	34990





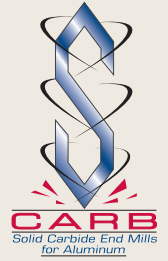
DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

New Expanded Tools

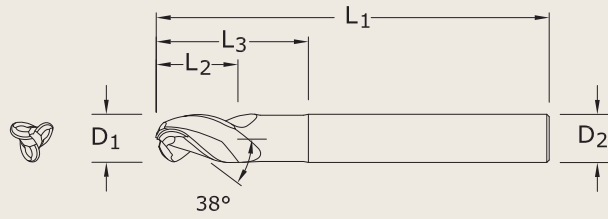
**SERIES 43LB
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	2-1/2	1/4	3/4	34941	35005
3/8	1/2	3	3/8	1-1/8	34943	35007
1/2	5/8	3	1/2	1-3/8	34945	35009
1/2	5/8	4	1/2	2-1/4	34946	35010
5/8	3/4	4	5/8	1-5/8	34949	35013
3/4	1	4	3/4	2	34951	35015
1	1-1/4	5	1	2-5/8	34954	35018
1	1-1/4	6	1	3-3/8	34955	35019





DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



New Expanded Tools

**SERIES 43EB
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	3	1/4	1-1/8	34942	35006
3/8	1/2	4	3/8	2-1/8	34944	35008
1/2	5/8	5	1/2	3-3/8	34947	35011
1/2	5/8	6	1/2	4-1/4	34948	35012
5/8	3/4	6	5/8	3-3/8	34950	35014
3/4	1	6	3/4	3-3/8	34952	35016
1	1-1/4	7	1	4-3/8	34956	35020



HIGH PERFORMANCE S-CARB CHIP BREAKER ROUGHING END MILLS

The original, symmetrical 3-flute design features an engineered flute form that provides high performance results through a full range of machining conditions. This expanded offering includes a variety of standard, reach, and corner radius options that are available with exclusive Ti-NAMITE-B coating for improved tool life.



VALUE AT THE SPINDLE
DESIGN AND ENGINEERING
ENSURE OUTSTANDING
PERFORMANCE IN A VARIETY
OF ALUMINUM APPLICATIONS.



SERIES **43CB** & **43MCB** FOR ALUMINUM, NON-FERROUS, & NON-METALLIC MATERIALS



SYMMETRICAL END GASHING:

Superior balance in a high-speed environment reduces vibration and increases plunging capabilities compared to traditional 3-flute designs

ENGINEERED FLUTE DESIGN:

Unique flute shape facilitates the rapid movement of the large volume of chips created during aggressive machining

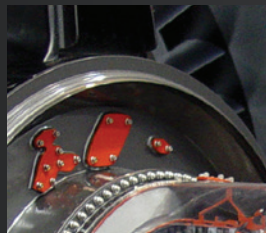
SPECIALIZED CHIP BREAKER:

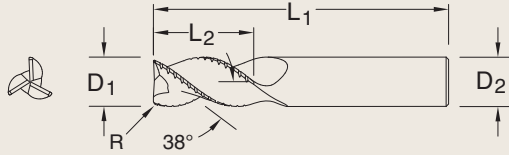
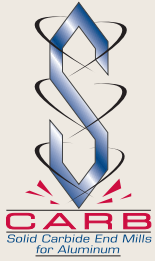
The chip breaker disrupts the chip flow along the cutting edge, resulting in smaller and more controlled chips, while preventing material build-up between the cutting edge and tool

ENGINEERED



- Unique symmetrical 3-flute design with engineered flute form
- Engineered Chip Breakers reduce the load produced by a typical cutting edge: Ideal for low horsepower situations
- Unsurpassed plunging and pocketing capabilities





DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

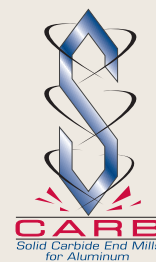
CORNER RADIUS TOLERANCES (inch)

R = +0.0000 / -0.0020

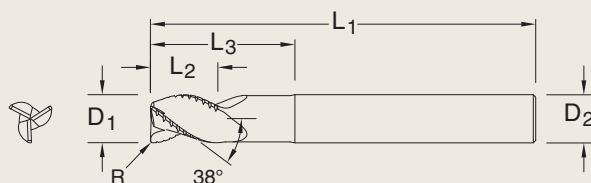
New Expanded Tools

**SERIES 43CB
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	2-1/2	1/4	.020	33390	33450
1/4	1/2	2-1/2	1/4	.020	33391	33451
1/4	3/4	2-1/2	1/4	.020	33392	33452
1/4	1	3	1/4	.020	33393	33453
1/4	1-1/4	3-1/2	1/4	.020	33394	33454
1/4	1-3/4	4	1/4	.020	33395	33455
5/16	7/16	2-1/2	5/16	.020	33396	33456
5/16	11/16	2-1/2	5/16	.020	33397	33457
5/16	1	3	5/16	.020	33398	33458
5/16	2-1/8	4	5/16	.020	33400	33460
3/8	1/2	3	3/8	.020	33401	33461
3/8	1	2-1/2	3/8	.020	34300	34305
3/8	1-1/4	3-1/2	3/8	.020	33402	33462
3/8	1-1/2	4	3/8	.020	33403	33463
3/8	2	4	3/8	.020	33404	33464
1/2	5/8	3	1/2	.030	33406	33466
1/2	1	3	1/2	.030	33407	33467
1/2	1-1/4	3-1/4	1/2	.030	34301	34306
1/2	1-5/8	4	1/2	.030	33408	33468
1/2	2	4	1/2	.030	33409	33469
1/2	2-1/2	5	1/2	.030	33410	33470
1/2	3-1/8	6	1/2	.030	33411	33471
5/8	3/4	3-1/2	5/8	.030	33412	33472
5/8	1-5/8	3-3/4	5/8	.030	34302	34307
5/8	2-1/8	4	5/8	.030	33413	33473
5/8	3-1/4	6	5/8	.030	33415	33475
5/8	3-3/4	6	5/8	.030	33416	33476
3/4	1	4	3/4	.030	33417	33477
3/4	1-5/8	4	3/4	.030	34303	34308
3/4	2-1/4	4	3/4	.030	33418	33478
3/4	3-1/4	6	3/4	.030	33419	33479
3/4	4	6	3/4	.030	33420	33480
1	1-1/4	5	1	.030	33421	33481
1	2	4-1/2	1	.030	34304	34309
1	2-5/8	6	1	.030	33422	33482
1	3-1/4	6	1	.030	33423	33483
1	4-1/8	7	1	.030	33424	33484



TOLERANCES (inch)		
DIAMETER	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6



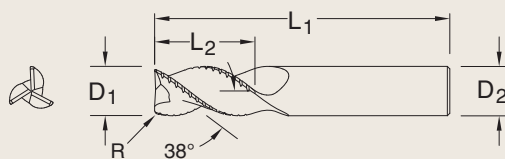
CORNER RADIUS TOLERANCES (inch)		
R = +0.0000 / -0.0020		

New Expanded Tools

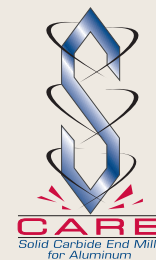
**SERIES 43LCB
LONG REACH
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Reach L ₃	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
1/4	3/8	4	1/4	3/4	.020	33500	33540
1/4	3/8	4	1/4	1-1/8	.020	33501	33541
1/4	3/8	4	1/4	2-1/8	.020	33502	33542
5/16	7/16	4	5/16	1-1/8	.020	33503	33543
5/16	7/16	4	5/16	2-1/8	.020	33504	33544
3/8	1/2	4	3/8	1-1/8	.020	33507	33547
3/8	1/2	4	3/8	2-1/8	.020	33508	33548
1/2	5/8	4	1/2	1-3/8	.030	33511	33551
1/2	5/8	4	1/2	2-1/4	.030	33512	33552
1/2	5/8	6	1/2	3-3/8	.030	33513	33553
1/2	5/8	6	1/2	4-1/4	.030	33514	33554
5/8	3/4	4	5/8	1-5/8	.030	33515	33555
5/8	3/4	6	5/8	2-3/8	.030	33516	33556
5/8	3/4	6	5/8	3-3/8	.030	33517	33557
5/8	3/4	6	5/8	4-3/8	.030	33518	33558
3/4	1	4	3/4	2	.030	33519	33559
3/4	1	6	3/4	2-1/2	.030	33520	33560
3/4	1	6	3/4	3-3/8	.030	33521	33561
3/4	1	6	3/4	4-3/8	.030	33522	33562
1	1-1/4	6	1	2-5/8	.030	33523	33563
1	1-1/4	6	1	3-3/8	.030	33524	33564
1	1-1/4	7	1	4-3/8	.030	33525	33565

TOLERANCES (mm)		
DIAMETER	D ₁	D ₂
> 8 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6



CORNER RADIUS TOLERANCES (mm)		
R = +0,00 / -0,05		



**SERIES 43MCB
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No.	Ti-NAMITE-B (TiB ₂) EDP No.
8,0	19,0	63,0	8,0	0,3	44300	44305
10,0	22,0	72,0	10,0	0,3	44301	44306
12,0	26,0	83,0	12,0	1,0	44302	44307
16,0	32,0	92,0	16,0	1,0	44303	44308
20,0	38,0	104,0	20,0	1,0	44304	44309

HIGH PERFORMANCE ALUMINUM MACHINING APR - APF

NEW!

ADVANCED
PRODUCTIVITY
ROUGHING
AND FINISHING
ENDMILLS

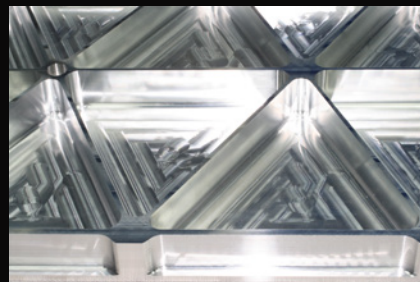


S-Carb APR

Developed and engineered for high power, high efficiency machining of aluminium aerospace structural parts (i.e. ribs, spars) and their equivalent. Material removal rates of 550 cubic inches achievable, dependent on machine.

S-Carb APF

Developed and engineered for high-feed finishing of thin wall aluminium sections typically on aerospace ribs. Vast reduction in machining times, with straighter walls and superior finishes compared to waterlining.



VALUE AT THE SPINDLE

Design and engineering ensure outstanding performance in a variety of aluminum applications.

Please contact your SGS representative for more information.

APR

S-CARB APR



- 3 flute design for high feed power roughing
- High feed direct plunge ability
- Through coolant design
- Polished flute design to maximize chip evacuation



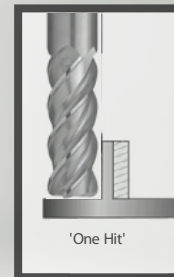
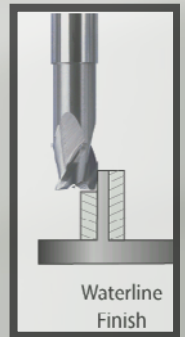
APF

S-CARB APF



- 4 flute unique variable geometry reduces vibration and allows finishing of thin walls in one pass
- Through coolant design
- Polished flutes for superior finishes
- Significant reduction in cycle times

Typical Method:
High-speed waterline finishing, multiple passes at numerous levels to produce acceptable thin walls

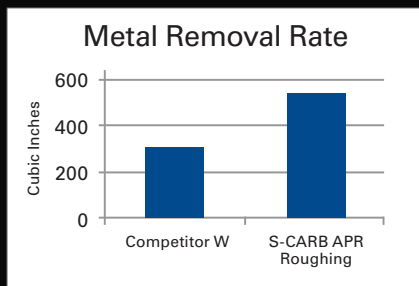


APF Method:
High speed finishing at full depth without wall distortion

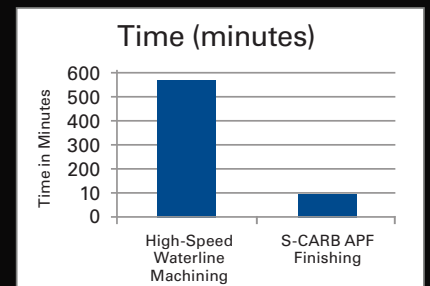
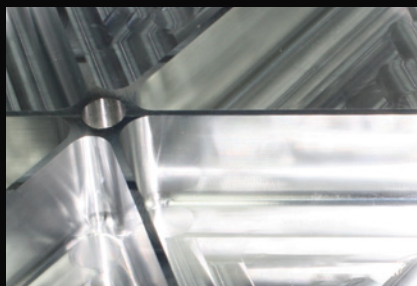
Please contact your SGS representative for more information.

Flute Design

ENGINEERED



Superior metal removal rate achievement over competition.



Dramatic increase in productivity versus the high speed waterline finishing method, which multiple passes are made to produce acceptable thin walls.

SKI-CARB END MILLS

FOR NON-FERROUS, ALUMINUM, & NON-METALLIC APPLICATIONS

The Original 2 Flute **High Performance** End Mill for Aluminum

Design Features:

Varied Speed and Feed

- Circular Land reduces edge aggressiveness for varied speed and feed rates and allows for milling into corners while significantly reducing chatter.

Superior Chip Control

- Ski Land with primary and secondary flute wall construction minimizes chip interference by directing chips away from secondary flute.

Optimal Rake

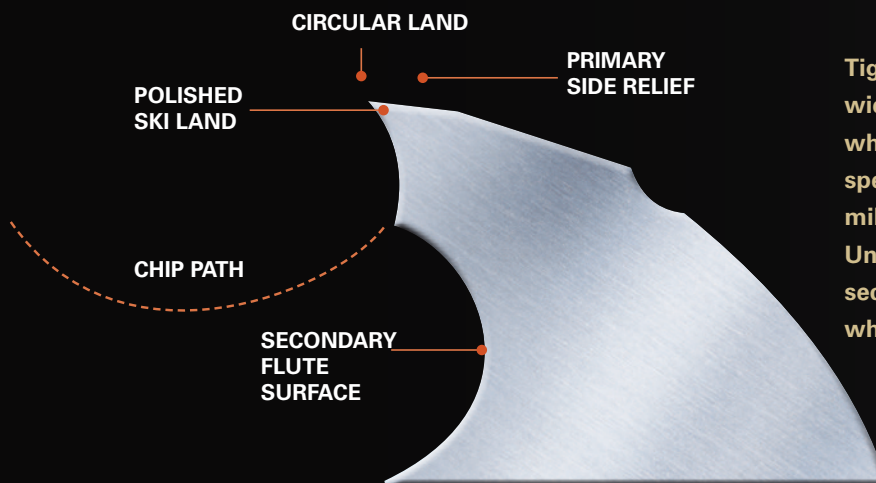
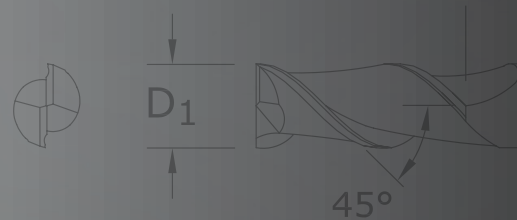
- High Helix (45 degree) increases effective rake for greater shearing ability without reducing edge strength.

Outstanding Rigidity

- Short Length increases rigidity.

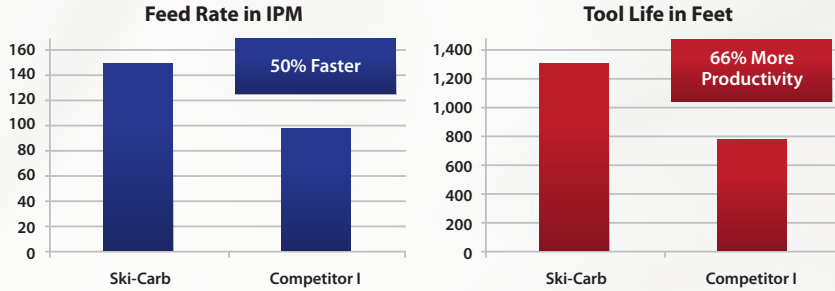
Maximum Chip Protection

- Available Corner Radii offer additional protection against chipping.

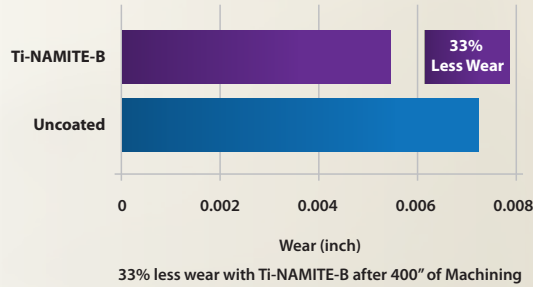


Tight control of the circular land width reduces edge aggressiveness, which allows for a wide variety of speed and feed rates. It also allows for milling into corners without chatter. Unique to the Ski-Carb is the primary-secondary flute wall construction, which reduces chip interference.

Slotting in 6061 - T6 Aluminum
 1/2" Diameter - .300" Ad
 8% Flood Coolant



Wear Comparison
 A390 Cast Aluminum
 10,000 rpm / 120 ipm
 .100 Rw x .300 Ad



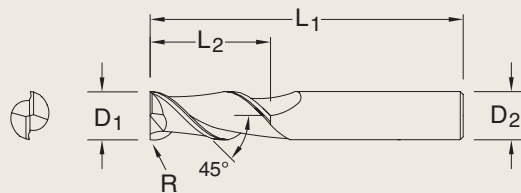
TI-NAMITE-B

Ti-NAMITE-B is an advanced coating developed specifically for the high performance machining of Aluminum and its alloys. Ti-NAMITE-B offers the following benefits:

- Low affinity to Aluminum helps to prevent edge build-up
- High level of hardness providing excellent wear protection
- Smooth surface structure drastically reducing friction to maximize chip flow
- Microhardness: 4000 HV
- Oxidation Temperature: 850°C / 1562°F
- Coefficient of Friction: 0.45
- Thickness: 1 – 2 Microns (based on tool diameter)

Coating

ADVANCED



TOLERANCES (inch)

DIAMETER	D ₁	D ₂
1/4 - 3/8	+0.0000 / -0.00035	h6
1/2 - 5/8	+0.0000 / -0.00043	h6
3/4 - 1	+0.0000 / -0.00051	h6

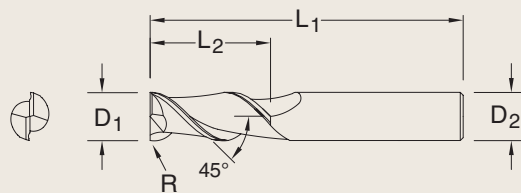
CORNER RADIUSTOLERANCES (inch)

R = +0.0000 / -0.0020

**SERIES 44
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius* R (Optional)	Uncoated EDP No. w/Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/Flat	Uncoated EDP No. w/o Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/o Flat
1/4	3/4	2-7/16	3/8	.015-.060	34501	34502	32033	32053
1/4	1-1/4	3-1/16	3/8	.015-.060	34503	34504	32034	32054
1/4	1-3/4	3-9/16	3/8	.015-.060	34505	34506	32035	32055
5/16	1-3/8	3-1/8	3/8	.015-.060	34507	34508	32036	32056
3/8	3/4	2-1/2	3/8	.015-.060	34509	34510	32037	32057
3/8	1-1/2	3-1/4	3/8	.015-.060	34511	34512	32038	32058
3/8	2-1/2	4-1/4	3/8	.015-.060	34513	34514	32039	32059
1/2	1-1/4	3-1/4	1/2	.015-.125	34515	34516	32040	32060
1/2	2	4	1/2	.015-.125	34517	34518	32041	32061
1/2	3	5	1/2	.015-.125	34519	34520	32042	32062
5/8	1-5/8	3-3/4	5/8	.015-.125	34521	34522	32043	32063
5/8	2-1/2	4-5/8	5/8	.015-.125	34523	34524	32044	32064
3/4	1-5/8	3-7/8	3/4	.015-.125	34525	34526	32045	32065
3/4	3	5-1/4	3/4	.015-.125	34527	34528	32046	32066
3/4	4	6-1/4	3/4	.015-.125	34529	34530	32047	32067
1	2	4-1/2	1	.015-.125	34531	34532	32048	32068
1	4	6-1/2	1	.015-.125	34533	34534	32049	32069

*Full range of Corner Radius options available.



TOLERANCES (mm)

DIAMETER	D ₁	D ₂
≤ 3	+0,000 / -0,006	h6
> 3 - 6	+0,000 / -0,008	h6
> 6 - 10	+0,000 / -0,009	h6
> 10 - 18	+0,000 / -0,011	h6
> 18 - 20	+0,000 / -0,013	h6

CORNER RADIUSTOLERANCES (mm)

R = +0,00 / -0,05

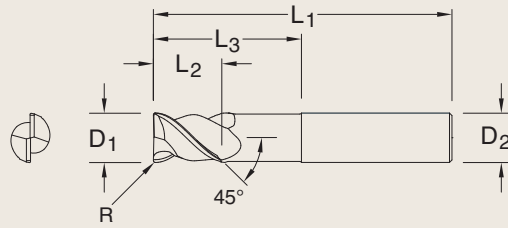
**SERIES 44M
(METRIC)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Shank Diameter D ₂	Corner Radius* R (Optional)	Uncoated EDP No. w/Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/Flat	Uncoated EDP No. w/o Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/o Flat
3,0	8,0	52,0	6,0	0,38-0,76	44505	44506	49663	49674
4,0	11,0	55,0	6,0	0,38-0,76	44509	44510	49664	49675
5,0	13,0	57,0	6,0	0,38-0,76	44513	44514	49665	49676
6,0	13,0	57,0	6,0	0,38-1,52	44517	44518	49666	49677
8,0	19,0	69,0	10,0	0,38-1,52	44521	44522	49667	49678
10,0	22,0	72,0	10,0	0,38-1,52	44525	44526	49668	49679
12,0	26,0	83,0	12,0	0,38-3,17	44529	44530	49669	49680
14,0	26,0	83,0	14,0	0,38-3,17	44533	44534	49670	49681
16,0	32,0	92,0	16,0	0,38-3,17	44537	44538	49671	49682
18,0	32,0	92,0	18,0	0,38-3,17	44541	44542	49672	49683
20,0	38,0	104,0	20,0	0,38-3,17	44545	44546	49673	49684

*Full range of Corner Radius options available.

DIAMETER	TOLERANCES (inch)	
	D ₁	D ₂
1/4 - 3/8	+0.00000 / -0.00035	h6
1/2 - 5/8	+0.00000 / -0.00043	h6
3/4 - 1	+0.00000 / -0.00051	h6

CORNER RADIUS TOLERANCES (inch)	
R = +0.0000 / -0.0020	



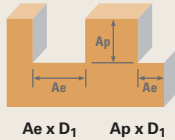
**SERIES 45
(FRACTIONAL)**

Cutting Diameter D ₁	Length of Cut L ₂	Overall Length L ₁	Reach* (Optional) L ₃	Shank Diameter D ₂	Corner Radius R	Uncoated EDP No. w/Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/Flat	Uncoated EDP No. w/o Flat	Ti-NAMITE-B (TiB ₂) EDP No. w/o Flat
1/4	3/8	2-1/2	1	3/8	.010	91257	91242	91250	91235
5/16	7/16	2-1/2	1-1/8	3/8	.012	91258	91243	91251	91236
3/8	9/16	2-1/2	1-1/8	3/8	.015	91259	91244	91252	91237
1/2	3/4	3	1-1/2	1/2	.020	91260	91245	91253	91238
5/8	7/8	3-1/2	1-3/4	5/8	.025	91261	91246	91254	91239
3/4	1	4	2	3/4	.030	91262	91247	91255	91240
1	1-1/4	4	2-1/8	1	.040	91263	91248	91256	91241

*Contact your SGS Sales Representative for more information on Reach options.



Series
44, 45, 43CR, 43CB,
43LC, 43, 43L, 43LCB,
43B, 43LB, 43ELB, 43EC,
47, 47B, 47L, 47LB
Fractional

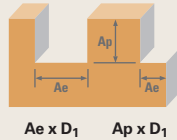


Diameter (D_1)
(inch)

	Slot	$A_e \times D_1$	$A_p \times D_1$	Vc (SFM)	Diameter (D_1) (inch)						
					1/8	1/4	3/8	1/2	3/4	1	
N ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6073, 7075	Slot	1	≤ 1	1600	RPM	48896	24448	16299	12224	8149	6112
				(1280-1920)	Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
					Feed 2 flutes (IPM)	88	122	147	147	114	104
					Feed 3 flutes (IPM)	132	183	220	220	171	156
				2000	RPM	61120	30560	20373	15280	10187	7640
				(1600-2400)	Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Feed 2 flutes (IPM)	110	153		183	183	143	130			
	Feed 3 flutes (IPM)	165	229		275	275	214	195			
	3300	RPM	100848	50424	33616	25212	16808	12606			
	(2640-3960)	Fz	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195			
		Feed 2 flutes (IPM)	424	555	706	706	555	492			
		Feed 3 flutes (IPM)	635	832	1059	1059	832	737			
N ALUMINUM DIE CAST ALLOYS (HIGH SILICONE) A-390, A-392, B-390	Slot	1	≤ 1	600	RPM	18336	9168	6112	4584	3056	2292
				(480-720)	Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
					Feed 2 flutes (IPM)	33	46	55	55	43	39
					Feed 3 flutes (IPM)	50	69	83	83	64	58
				750	RPM	22920	11460	7640	5730	3820	2865
				(600-900)	Fz	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Feed 2 flutes (IPM)	41	57		69	69	53	49			
	Feed 3 flutes (IPM)	62	86		103	103	80	73			
	1240	RPM	37894	18947	12631	9474	6316	4737			
	(992-1488)	Fz	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195			
		Feed 2 flutes (IPM)	159	208	265	265	208	185			
		Feed 3 flutes (IPM)	239	313	398	398	313	277			
N COPPER ALLOYS Aluminum Bronze Brass Naval Brass Red Brass	Slot	1	≤ 1	865	RPM	26434	13217	8811	6609	8149	6112
				(692-1038)	Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
					Feed 2 flutes (IPM)	42	53	70	66	98	86
					Feed 3 flutes (IPM)	63	79	106	99	147	128
				1080	RPM	33005	16502	11002	8251	5501	4126
				(864-1296)	Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Feed 2 flutes (IPM)	53	66		88	83	66	58			
	Feed 3 flutes (IPM)	79	99		132	124	99	87			
	1780	RPM	54397	27198	18132	13599	9066	6800			
	(1424-2136)	Fz	0.0017	0.0045	0.0085	0.0115	0.0140	0.0160			
		Feed 2 flutes (IPM)	185	245	308	313	254	218			
		Feed 3 flutes (IPM)	277	367	462	469	381	326			

continued on next page

Series
44, 45, 43CR, 43CB,
43LC, 43, 43L, 43LCB,
43B, 43LB, 43ELB, 43EC,
47, 47B, 47L, 47LB
Fractional



	Ae x D ₁	Ap x D ₁	Vc (SFM)	Diameter (D ₁) (inch)										
				1/8	1/4	3/8	1/2	3/4	1					
COPPER ALLOYS Beryllium Copper C110, Maganese Bronze, Tin Bronze	Slot 	1	≤ 1	345	RPM	10543	5272	3514	2636	1757	1318			
				(276-414)	Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070			
					Feed 2 flutes (IPM)	17	21	28	26	21	18			
					Feed 3 flutes (IPM)	25	32	42	40	32	28			
				Profile 	≤ 0.5	≤ 1.5	430	RPM	13141	6570	4380	3285	2190	1643
							(344-516)	Fz	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Feed 2 flutes (IPM)	21	26					35	33	26	23			
	Feed 3 flutes (IPM)	32	39					53	49	39	34			
	HSM 	≤ 0.05	≤ 2				710	RPM	21698	10849	7233	5424	3616	2712
							(568-852)	Fz	0.0017	0.0045	0.0085	0.0115	0.0140	0.0160
				Feed 2 flutes (IPM)	74	98		123	125	101	87			
				Feed 3 flutes (IPM)	111	146		184	187	152	130			
PLASTICS ABS, Polycarbonate, PVC, Polypropylene				Slot 	1	≤ 1	1600	RPM	48896	24448	16299	12224	8149	6112
							(1280-1920)	Fz	0.0015	0.0040	0.0075	0.0100	0.0120	0.0140
	Feed 2 flutes (IPM)	147	196					244	244	196	171			
	Feed 3 flutes (IPM)	220	293					367	367	293	257			
	Profile 	≤ 0.5	≤ 1.5				2000	RPM	61120	30560	20373	15280	10187	7640
							(1600-2400)	Fz	0.0015	0.0040	0.0075	0.0100	0.0120	0.0140
				Feed 2 flutes (IPM)	183	244		306	306	244	214			
				Feed 3 flutes (IPM)	275	367		458	458	367	321			
				HSM 	≤ 0.05	≤ 2	3300	RPM	100848	50424	33616	25212	16808	12606
							(2640-3960)	Fz	0.0034	0.0090	0.0170	0.0230	0.0275	0.0320
	Feed 2 flutes (IPM)	686	908					1143	1160	924	807			
	Feed 3 flutes (IPM)	1029	1361					1714	1740	1387	1210			

Note:

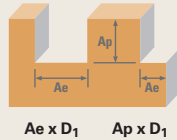
- rpm = sfm x 3.82 / D₁
- ipm = (inch / flute) x number of flutes x rpm
- HSM (high speed machining)
- reduce speed and feed for materials harder than listed
- reduce cut depth and feed by 50% for long flute or long reach tools
- reduce feed and Ae when finish milling (.02 x D₁ maximum)
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)



Tool Wizard
CALCULATE APPLICATION PARAMETERS

www.sgstool.com

Series
44M, 43MCR, 43MCB,
43M, 47M, 47MB,
47ML, 47MLB
Metric



	Ae x D ₁	Ap x D ₁	Vc (m/min)	Diameter (D ₁) (mm)										
				3	6	10	12	20	25					
COPPER ALLOYS Beryllium Copper C110, Maganese Bronze, Tin Bronze	Slot 	1	≤ 1	105	RPM	11148	5574	3344	2787	1672	1338			
				(84-126)	Fz	0.019	0.048	0.107	0.120	0.160	0.175			
					Feed 2 flutes (mm/min)	428	535	713	669	535	468			
					Feed 3 flutes (mm/min)	642	803	1070	1003	803	702			
				Profile 	≤ 0.5	≤ 1.5	130	RPM	13802	6901	4141	3450	2070	1656
							(104-156)	Fz	0.019	0.048	0.107	0.120	0.160	0.175
	Feed 2 flutes (mm/min)	530	662					883	828	662	580			
	Feed 3 flutes (mm/min)	795	994					1325	1242	994	870			
	HSM 	≤ 0.05	≤ 2				215	RPM	22826	11413	6848	5706	3424	2739
							(172-258)	Fz	0.041	0.108	0.227	0.276	0.373	0.400
				Feed 2 flutes (mm/min)	1862	2465		3104	3150	2556	2191			
				Feed 3 flutes (mm/min)	2794	3697		4656	4725	3835	3287			
PLASTICS ABS, Polycarbonate, PVC, Polypropylene				Slot 	1	≤ 1	490	RPM	52022	26011	15607	13005	7803	6243
							(392-588)	Fz	0.036	0.096	0.200	0.240	0.320	0.350
	Feed 2 flutes (mm/min)	3745	4994					6243	6242	4994	4370			
	Feed 3 flutes (mm/min)	5618	7490					9364	9363	7491	6555			
	Profile 	≤ 0.5	≤ 1.5				610	RPM	64762	32381	19429	16190	9714	7771
							(488-732)	Fz	0.036	0.096	0.200	0.240	0.320	0.350
				Feed 2 flutes (mm/min)	4662	6217		7771	7771	6217	5440			
				Feed 3 flutes (mm/min)	6994	9325		11657	11656	9326	8160			
				HSM 	≤ 0.05	≤ 2	1005	RPM	106698	53349	32009	26674	16005	12804
							(804-1206)	Fz	0.082	0.216	0.453	0.552	0.733	0.800
	Feed 2 flutes (mm/min)	17412	23045					29022	29446	23473	20487			
	Feed 3 flutes (mm/min)	26117	34567					43532	44169	35210	30730			

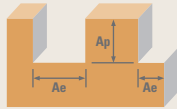
Note:

- rpm = (1000 x m/min) / (3.14 x D₁)
- mm / min = (mm / flute) x number of flutes x rpm
- HSM (high speed machining)
- reduce speed and feed for materials harder than listed
- reduce cut depth and feed by 50% for long flute or long reach tools
- reduce feed and Ae when finish milling (.02 x D₁ maximum)
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)



Tool Wizard
CALCULATE APPLICATION PARAMETERS

www.sgstool.com

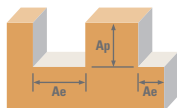


Series	S-Carb APR	Fractional	Ae x D ₁	Ap x D ₁	Vc (sfm)	Diameter (D ₁) (inch)		
						3/4	1	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	Slot <40hp 	1	≤ 1	3280	RPM	16706	12530
					(2624-3936)	Fz	0.0060	0.0070
						Feed (IPM)	301	263
		Slot >67hp 	1	≤ 1	4920	RPM	25059	18794
					(3936-5904)	Fz	0.0090	0.0110
						Feed (IPM)	677	620
Profile 	≤ 0.5	≤ 1.5	6560	RPM	33412	25059		
			(5248-7872)	Fz	0.0090	0.0110		
				Feed (IPM)	902	827		
N	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	Slot <40hp 	1	≤ 1	2620	RPM	13345	10008
					(2096-3144)	Fz	0.0060	0.0070
						Feed (IPM)	240	210
		Slot >67hp 	1	≤ 1	3940	RPM	20068	15051
					(3152-4728)	Fz	0.0090	0.0110
						Feed (IPM)	542	497
Profile 	≤ 0.5	≤ 1.5	4920	RPM	25059	18794		
			(3936-5904)	Fz	0.0090	0.0110		
				Feed (IPM)	677	620		

Note:

- surface speed is dependent on machine spindle & fixturing*
- balancing is recommended at ultra high surface speeds
- tool life may be reduced when machining Lithium Alloys
- rpm = sfm x 3.82 / D₁
- ipm = (inch / flute) x number of flutes x rpm

- maximum recommended depths shown
- reduce speed and feed for materials harder than listed
- ramp angle = 15° (feed rate = 30%)
- maximum ramp depth = 1 x D₁
- plunge depth = 1 x D₁ (feed rate = 30%)
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)

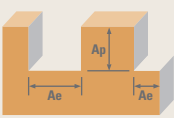






Series	S-Carb APR	Metric	Ae x D ₁	Ap x D ₁	Vc (m/min)	Diameter (D ₁) (mm)				
						12	16	20	25	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	Slot <30 kW 	1	1	1000	RPM	26525	19894	15915	12732
					(800-1200)	Fz	0.080	0.110	0.150	0.180
						Feed (mm/min)	6366	6565	7162	6875
		Slot >50kW 	1	≤ 1	1500	RPM	39788	29841	23873	19098
					(1200-1800)	Fz	0.120	0.160	0.220	0.270
						Feed (mm/min)	14324	14324	15756	15469
Profile 	≤ 0.5	≤ 1.5	2000	RPM	53050	39788	31830	25464		
			(1600-2400)	Fz	0.120	0.160	0.220	0.270		
				Feed (mm/min)	19098	19098	21008	20626		
N	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	Slot <30 kW 	1	≤ 1	800	RPM	21220	15915	12732	10186
					(640-960)	Fz	0.080	0.110	0.150	0.180
						Feed (mm/min)	5093	5252	5729	5500
		Slot >50kW 	1	≤ 1	1200	RPM	31830	23873	19098	15278
					(960-1440)	Fz	0.120	0.160	0.220	0.270
						Feed (mm/min)	11459	11459	12605	12375
Profile 	≤ 0.5	≤ 1.5	1500	RPM	39788	29841	23873	19098		
			(1200-1800)	Fz	0.120	0.160	0.220	0.270		
				Feed (mm/min)	14324	14324	15756	15469		

Note:

- surface speed is dependent on machine spindle & fixturing*
- balancing is recommended at ultra high surface speeds
- tool life may be reduced when machining Lithium Alloys
- rpm = (1000 x m/min) / (3.14 x D₁)
- mm/min = (mm / flute) x rpm

- maximum recommended depths shown
- reduce speed and feed for materials harder than listed
- ramp angle = 15° (feed rate = 30%)
- maximum ramp depth = 1 x D₁
- plunge depth = 1 x D₁ (feed rate = 30%)
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)



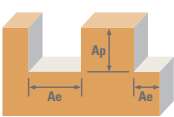
Series	S-Carb APF	Fractional	Ae x D ₁	Ap x D ₁	Vc (sfm)	Diameter (D ₁) (inch)		
						1/2	3/4	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	Profile 	≤ 0.1	≤ 2.5	2625	RPM	20055	13370
					(2100-3150)	Fz	0.0030	0.0050
						Feed (IPM)	241	267
		Profile 	≤ 0.1	≤ 4	2625	RPM	20055	13370
					(2100-3150)	Fz	0.0020	0.0040
						Feed (IPM)	160	214
N	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	Profile 	≤ 0.1	≤ 2.5	1970	RPM	15051	10034
					(1576-2364)	Fz	0.0030	0.0050
						Feed (IPM)	181	201
		Profile 	≤ 0.1	≤ 4	1970	RPM	15051	10034
					(1576-2364)	Fz	0.0020	0.0040
						Feed (IPM)	120	161





Note:

- surface speed is dependent on machine spindle & fixturing*
- balancing is recommended at ultra high surface speeds
- tool life may be reduced when machining Lithium Alloys
- rpm = sfm x 3.82 / D₁
- ipm = (inch / flute) x number of flutes x rpm
- maximum recommended depths shown
- reduce speed and feed for materials harder than listed
- finish cuts typically require reduced feed and cutting depths of 0.02 x D₁ maximum
- ramp angle = 6° (feed rate = 30%)
- maximum ramp depth = .25 x D₁
- plunging not recommended
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)



www.sgstool.com



Series	S-Carb APF	Metric	Ae x D ₁	Ap x D ₁	Vc (m/min)	Diameter (D ₁) (mm)							
						6	8	10	12	16	20	25	
N	ALUMINUM ALLOYS 2024, 5052, 5086, 6061, 6063, 7075	Profile 	≤ 0.1	≤ 2.5	800	RPM	42440	31830	25464	21220	15915	12732	10186
					(640-960)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
						Feed (mm/min)	8488	7003	6111	5942	6366	7130	6926
		Profile 	≤ 0.1	≤ 4	800	RPM	42440	31830	25464	21220	15915	12732	10186
					(640-960)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
						Feed (mm/min)	6790	5729	5093	4244	4456	5093	4889
N	ALUMINUM ALLOYS (LITHIUM)* 2090, 2091, 2099, 2195, 2199, 2297, 8090	Profile 	≤ 0.1	≤ 2.5	600	RPM	31830	23873	19098	15915	11936	9549	7639
					(480-720)	Fz	0.050	0.055	0.060	0.070	0.100	0.140	0.170
						Feed (mm/min)	6366	5252	4584	4456	4774	5347	5195
		Profile 	≤ 0.1	≤ 4	600	RPM	31830	23873	19098	15915	11936	9549	7639
					(480-720)	Fz	0.040	0.045	0.050	0.050	0.070	0.100	0.120
						Feed (mm/min)	5093	4297	3820	3183	3342	3820	3667

Note:

- surface speed is dependent on machine spindle & fixturing*
- balancing is recommended at ultra high surface speeds
- tool life may be reduced when machining Lithium Alloys
- rpm = (1000 x m/min) / (3.14 x D₁)
- mm/min = (mm / flute) x rpm
- maximum recommended depths shown
- reduce speed and feed for materials harder than listed
- finish cuts typically require reduced feed and cutting depths of 0.02 x D₁ maximum
- ramp angle = 6° (feed rate = 30%)
- maximum ramp depth = .25 x D₁
- plunging not recommended
- refer to the SGS Tool Wizard for complete technical information (www.sgstool.com)



www.sgstool.com



Solid Carbide Tools

Solutions Around The Globe

SGS Tool Company is a privately-held, ISO-certified leader of round solid carbide cutting tool technology for the aerospace, metalworking, and automotive industries with manufacturing sites in the United States and United Kingdom. Our global network of Sales Representatives, Industrial Distributors, and Agents blanket the world selling into more than 60 countries.

Leaders in Solid Carbide Tool Technology

Brand names such as Z-Carb, S-Carb, V-Carb, Hi-PerCarb, Multi-Carb have become synonymous with high performance tooling in the machining and metalworking industry.

We're proud to have pioneered some of the world's most advanced cutting technology right here in our Northeast Ohio manufacturing campus. SGS high performance end mills, drills and routers are increasing productivity and reducing cost around the world.

Exceeding Customer Expectations

In addition to our substantial R&D facilities, we offer a portfolio of products and services that have an unparalleled track record in manufacture, supply and value at the spindle.

- Incredible batch-to-batch consistency
- Metallurgical lab dedicated to testing and rigorous quality control
- ISO-certified quality procedures
- Patented geometries that extend tool life, reduce chatter, cut cycle times, and improve part quality—even at extreme parameters
- Specialists in extreme and demanding product applications
- West Coast Service Center
- Experienced Field Sales Engineers who work to optimize a tool for your particular application
- Dedicated multi-lingual customer service representatives

SGS Products are distributed by:



VALUE AT THE SPINDLE

UNITED STATES OF AMERICA

SGS TOOL COMPANY

World Headquarters
P.O. Box 187
55 South Main Street
Munroe Falls, Ohio 44262 U.S.A.
customer service -
US and Canada: (330) 686-5700
fax - US & Canada: (800) 447-4017
international fax: (330) 686-2146
e-mail: webmaster@sgstool.com

UNITED KINGDOM

SGSTOOL EUROPE LTD.

10 Ashville Way
Wokingham, Berkshire
RG41 2PL England
phone: (44) 1189-795-200
fax: (44) 1189-795-295
e-mail: sales@sgstool.eu

FRANCE

SGS FRANCE

8, Avenue Gutenberg
78310 Maurepas
France
phone: +33 (0) 1 82 88 49 14
fax: +33 (0) 1 82 88 49 39
e-mail: sgsfrance@sgstool.eu

GERMANY

SGS TOOL GmbH

Oberhaaner Str. 41
42653 Solingen
Germany
phone: +49 (0) 2173-9100-91
fax: +49 (0) 212 / 38089693
e-mail: info@sgstool.eu

POLAND

SGS TOOL POLAND

phone: +48 530 432 002
e-mail: infopolska@sgstool.pl

SPAIN

SGS TOOL IBERICA

phone: +34 (0) 91 362 40 95
fax: +34 (0) 91 633 15 28
e-mail: sgsiberica@sgstool.es

CANADA

SGS TOOL CANADA

171 Northport Road, Unit #3
Port Perry, ON L9L 1B2
phone: 905/982-0888
fax: 905/982-0488
e-mail: sgstool@powergate.ca

EASTERN EUROPE

SINTCOM

Sintcom Tools
95 Arsenalski Blvd.
1421 Sofia, Bulgaria
phone: (359) 283-64421
fax: (359) 286-52493
e-mail: sintcom@sintcomtools.com

RUSSIA

HALTEC

phone: (7) 495-252-05-00
e-mail: info@haltec.ru
web: www.haltec.ru

CHINA

SGS TOOL DIVISION

Jergens (Shanghai)
Commercial Co., Ltd.
Unit 301, Building A, No.200,
Jin Su Road
Jinqiao Export Processing Zone,
Pudong New Area
Shanghai 201206
China
phone: (86) 21-50589822
fax: (86) 21-50817160
e-mail: china@sgstool.com
web: www.sgstool.com/china

sgstool.com