

338 SERIES

Coarse Pitch Design for Heavy Roughing Applications. Featured with Standard Corner Radius.



3 Flute Rougher

• 37° Helix

Available Upon Request:

- Add Flats
- Radii
- Whistle Notch
- Firm Hold Shank

5 Exxtral Carbon® 3-4 times tool life compared to Z-Power.

| | |
|----|---|
| N1 | Wrought Aluminum Alloys |
| N2 | Low-Silicon Aluminum Alloys Si <12.2% - 6061, 7075 |
| N3 | High-Silicon Aluminum Alloys Si >12.2% - 6061, 7075 |
| N5 | Copper & Copper Alloys |

Slotting

| | Milling SFM (Vc) Coated Min-Max | Chipload Per Tooth Recommendations (CPT) | | | | | | | | Slotting Axial ADC |
|----|------------------------------------|--|-------|------|-------|------|------|------|------|-----------------------|
| | | 1/4" | 5/16" | 3/8" | 7/16" | 1/2" | 5/8" | 3/4" | 1" | |
| N1 | 1800 | .003 | .003 | .004 | .006 | .007 | .009 | .010 | .012 | .75-1.5xD |
| N2 | 2200 | .002 | .002 | .002 | .003 | .003 | .004 | .004 | .005 | .75-1.5xD |
| N3 | 2200 | .002 | .002 | .003 | .004 | .005 | .006 | .007 | .008 | .75-1.5xD |
| N5 | 500-650 | .002 | .002 | .002 | .003 | .004 | .005 | .006 | .007 | .75-1.5xD |

Heavy Peripheral

| | Milling SFM (Vc) Coated Min-Max | Chipload Per Tooth Recommendations (CPT) | | | | | | | | Profiling Radial | |
|----|------------------------------------|--|-------|------|-------|------|------|------|------|------------------|----------|
| | | 1/4" | 5/16" | 3/8" | 7/16" | 1/2" | 5/8" | 3/4" | 1" | ADC | RDC |
| N1 | 1800 | .003 | .004 | .005 | .007 | .009 | .011 | .013 | .015 | 1-2xD | .35-.5xD |
| N2 | 2200 | .002 | .002 | .002 | .003 | .004 | .005 | .005 | .006 | 1-2xD | .35-.5xD |
| N3 | 2200 | .002 | .002 | .003 | .005 | .006 | .007 | .008 | .010 | 1-2xD | .35-.5xD |
| N5 | 500-650 | .002 | .003 | .003 | .004 | .005 | .006 | .008 | .009 | 1-2xD | .35-.5xD |

Light Peripheral

| | Milling SFM (Vc) Coated Min-Max | Chipload Per Tooth Recommendations (CPT) | | | | | | | | Profiling Radial | |
|----|------------------------------------|--|-------|------|-------|------|------|------|------|------------------|-------|
| | | 1/4" | 5/16" | 3/8" | 7/16" | 1/2" | 5/8" | 3/4" | 1" | ADC | RDC |
| N1 | 1800 | .002 | .002 | .003 | .004 | .006 | .007 | .008 | .009 | 1-2xD | .05xD |
| N2 | 2200 | .001 | .001 | .001 | .002 | .003 | .003 | .005 | .007 | 1-2xD | .05xD |
| N3 | 2200 | .001 | .001 | .002 | .003 | .004 | .005 | .005 | .006 | 1-2xD | .05xD |
| N5 | 500-650 | .001 | .001 | .002 | .003 | .004 | .004 | .004 | .005 | 1-2xD | .05xD |