

345 SERIES



Advanced Geometry; Wiper Flatt, E-cut Polish and Controlled Land, will Provide Better Chip Evacuation and a Superior Part Finish

3 Flute Endmill

- 45° Helix
- Primary and Secondary
- Radial Protect Land

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
N5	Copper & Copper Alloys

Slotting

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1600-1800	.001	.001	.002	.002	.003	.003	.004	.004	.006	.008	N/A	N/A	.75-1.5xD
N2	2200	.001	.001	.001	.001	.002	.002	.002	.003	.003	.005	N/A	N/A	.75-1.5xD
N5	450-650	.001	.001	.001	.002	.002	.002	.003	.004	.004	.005	N/A	N/A	.75-1.5xD

Heavy Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1600-1800	.001	.002	.002	.003	.004	.004	.005	.006	.008	.010	1-2xD	.5xD	N/A
N2	2200	.001	.001	.001	.002	.002	.002	.003	.003	.004	.006	1-2xD	.5xD	N/A
N5	450-650	.001	.001	.002	.002	.003	.003	.003	.004	.005	.007	1-2xD	.5xD	N/A

Light Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
		1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1600-1800	.001	.001	.002	.002	.003	.003	.003	.004	.005	.007	1xD	0.05xD	N/A
N2	2200	.001	.001	.001	.001	.001	.002	.002	.002	.003	.004	1xD	0.05xD	N/A
N5	450-650	.001	.001	.001	.001	.002	.002	.002	.003	.004	.005	1xD	0.05xD	N/A