

Medium Pitch Rougher - Ideal for a Variety of Ferrous Material. Featured with Standard Corner Radius



P M K S H

5,7 Flute Rougher

- 45° Helix
- Primary and Secondary

Available Upon Request:

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



Varianta® Supral Provides a low coefficient of friction, reducing tool wear and resulting in a longer tool life. Ideal for materials below 45Rc.

P1	Low-Carbon Steel - 1000 Series (>25 HRc)
P2	Low-Carbon Steel - 1000 Series (<25 HRc)
P3	Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)
P5	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (≤35 HRc)
P6	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 HRc)
M1	Austenitic Stainless Steel - Inox, 200 Series, 300 Series
K1	Gray Cast Iron
K3	Ductile Iron (<38 HRc)
S2	Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 (≤48hRc)
S4	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2SN-4Zr-2Mo (≤48 HRc)

Slotting

	Milling SFM (Vc)		Chipload Per Tooth (CPT)						Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.002	.002	.003	.004	.004	.006	N/A	N/A	1xD
P2	200-450	100-250	.002	.002	.003	.004	.004	.006	N/A	N/A	1xD
P3	200-450	100-250	.002	.002	.003	.004	.004	.006	N/A	N/A	1xD
P5	200-450	100-250	.002	.002	.003	.003	.004	.005	N/A	N/A	1xD
P6	200-450	100-250	.002	.002	.003	.003	.004	.005	N/A	N/A	1xD
M1	150-350	80-200	.002	.002	.003	.003	.004	.005	N/A	N/A	1xD
K1	250-450	130-300	.002	.002	.002	.003	.004	.005	N/A	N/A	1xD
K3	120-350	80-140	.002	.002	.002	.003	.004	.005	N/A	N/A	1xD
S2	70-120	40-90	.001	.001	.002	.002	.003	.004	N/A	N/A	1xD
S4	140-200	90-160	.002	.002	.002	.003	.004	.005	N/A	N/A	1xD

Heavy Peripheral

	Milling SFM (Vc)		Chipload Per Tooth (CPT)						Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A
P2	200-450	100-250	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A
P3	200-450	100-250	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A
P5	200-450	100-250	.002	.003	.003	.004	.005	.006	1xD	.5xD	N/A
P6	200-450	100-250	.002	.003	.003	.004	.005	.006	1xD	.5xD	N/A
M1	150-350	80-200	.002	.002	.003	.003	.004	.005	1xD	.5xD	N/A
K1	250-450	130-300	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A
K3	120-350	80-140	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A
S2	70-120	40-90	.002	.002	.002	.003	.004	.005	1xD	.5xD	N/A
S4	140-200	90-160	.002	.002	.003	.004	.004	.006	1xD	.5xD	N/A

Light Peripheral

	Milling SFM (Vc)		Chipload Per Tooth (CPT)						Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.003	.003	.004	.005	.006	.008	1.5xD	.2xD	N/A
P2	200-450	100-250	.003	.003	.004	.005	.006	.008	1.5xD	.2xD	N/A
P3	200-450	100-250	.003	.003	.004	.005	.006	.008	1.5xD	.2xD	N/A
P5	200-450	100-250	.003	.003	.004	.005	.006	.007	1.5xD	.2xD	N/A
P6	200-450	100-250	.003	.003	.004	.005	.006	.007	1.5xD	.2xD	N/A
M1	150-350	80-200	.003	.003	.004	.005	.006	.007	1.5xD	.2xD	N/A
K1	250-450	130-300	.002	.003	.003	.004	.005	.007	1.5xD	.2xD	N/A
K3	120-350	80-140	.002	.003	.003	.004	.005	.007	1.5xD	.2xD	N/A
S2	70-120	40-90	.002	.002	.003	.004	.004	.006	1.5xD	.2xD	N/A
S4	140-200	90-160	.002	.003	.003	.004	.005	.007	1.5xD	.2xD	N/A