

558 SERIES

Variable Indexed with Eccentric OD; Provides a Tougher Cutting Edge for Chatter Free Machining and Maximum Metal Removal Rates



5 Flute Variable Endmill

• 35° Helix

Available Upon Request:

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



Exxtral Silver® is ideal for machining abrasive and gummy materials.

P1	Low-Carbon Steel - 1000 Series (>25 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
M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
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)

Finishing

	SFM		Chipload Per Tooth Recommendations (CPT)									Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.002	.003	.002	.003	.005	.007	.009	.014	.011	2.5xD	.015xD	NA
P5	200-450	100-250	.002	.003	.003	.003	.004	.005	.007	.011	.009	2.5xD	.015xD	NA
P6	200-450	100-250	.002	.003	.003	.003	.004	.005	.007	.011	.009	2.5xD	.015xD	NA
M1	150-350	80-200	.002	.003	.004	.003	.005	.006	.009	.014	.011	2.5xD	.015xD	NA
M2	150-350	80-200	.002	.003	.004	.003	.005	.006	.009	.014	.011	2.5xD	.015xD	NA
K1	250-450	130-300	.002	.002	.002	.003	.004	.004	.006	.009	.007	2.5xD	.015xD	NA
K3	120-350	80-140	.002	.002	.003	.003	.005	.006	.009	.014	.011	2.5xD	.015xD	NA
S2	70-120	40-90	.003	.002	.003	.003	.005	.005	.008	.011	.009	2.5xD	.015xD	NA
S4	140-200	90-160	.003	.003	.003	.003	.005	.006	.009	.014	.011	2.5xD	.015xD	NA

Slotting

	SFM		Chipload Per Tooth Recommendations (CPT)									Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.001	.001	.001	.001	.002	.003	.003	.004	.005	NA	NA	1xD
P5	200-450	100-250	.001	.001	.001	.001	.002	.003	.003	.003	.004	NA	NA	1xD
P6	200-450	100-250	.001	.001	.001	.001	.002	.003	.003	.003	.004	NA	NA	1xD
M1	150-350	80-200	.001	.001	.001	.001	.002	.003	.003	.004	.005	NA	NA	1xD
M2	150-350	80-200	.001	.001	.001	.001	.002	.003	.003	.004	.005	NA	NA	1xD
K1	250-450	130-300	.001	.001	.001	.001	.001	.002	.002	.002	.003	NA	NA	1xD
K3	120-350	80-140	.001	.001	.001	.001	.002	.003	.003	.004	.005	NA	NA	1xD
S2	70-120	40-90	.001	.001	.001	.001	.002	.002	.003	.003	.004	NA	NA	1xD
S4	140-200	90-160	.001	.001	.001	.001	.002	.002	.003	.004	.005	NA	NA	1xD

Light Peripheral

	SFM		Chipload Per Tooth Recommendations (CPT)									Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.001	.001	.002	.002	.003	.004	.006	.008	.007	1.5xD	.15xD	NA
P5	200-450	100-250	.001	.001	.002	.002	.003	.003	.005	.008	.007	1.5xD	.15xD	NA
P6	200-450	100-250	.001	.001	.002	.002	.003	.003	.005	.008	.007	1.5xD	.15xD	NA
M1	150-350	80-200	.001	.001	.002	.002	.003	.003	.005	.008	.007	1.5xD	.15xD	NA
M2	150-350	80-200	.001	.001	.002	.002	.003	.003	.005	.008	.007	1.5xD	.15xD	NA
K1	250-450	130-300	.001	.001	.001	.002	.002	.002	.004	.005	.004	1.5xD	.15xD	NA
K3	120-350	80-140	.001	.001	.002	.002	.003	.003	.005	.008	.007	1.5xD	.15xD	NA
S2	70-120	40-90	.001	.001	.001	.002	.003	.003	.005	.006	.005	1.5xD	.15xD	NA
S4	140-200	90-160	.002	.002	.002	.002	.003	.004	.005	.008	.007	1.5xD	.15xD	NA

Heavy Peripheral

	SFM		Chipload Per Tooth Recommendations (CPT)									Profiling Radial		Slotting Axial
	SFM <32 HRc	SFM >32 HRc	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	200-450	100-250	.001	.001	.001	.002	.002	.003	.005	.005	.006	1.5xD	.25xD	NA
P5	200-450	100-250	.001	.001	.001	.002	.002	.003	.005	.005	.005	1.5xD	.25xD	NA
P6	200-450	100-250	.001	.001	.001	.002	.002	.003	.005	.005	.005	1.5xD	.25xD	NA
M1	150-350	80-200	.001	.001	.001	.002	.002	.003	.005	.005	.005	1.5xD	.25xD	NA
M2	150-350	80-200	.001	.001	.001	.002	.002	.003	.005	.005	.005	1.5xD	.25xD	NA
K1	250-450	130-300	.001	.001	.001	.002	.002	.002	.003	.003	.003	1.5xD	.25xD	NA
K3	120-350	80-140	.001	.001	.001	.002	.002	.003	.005	.005	.006	1.5xD	.25xD	NA
S2	70-120	40-90	.001	.001	.001	.002	.002	.002	.004	.004	.004	1.5xD	.25xD	NA
S4	140-200	90-160	.001	.001	.001	.002	.002	.003	.005	.005	.006	1.5xD	.25xD	NA