

Carbide End Mills

Severance solid micro grain carbide end mills are stocked in four-flute design, and are available in two and three-flute designs to order. Indicate the number of flutes desired at the end of the Tool Number' EM-250-W-3, for example. Experiment within the speed ranges listed at the right to produce the best chip on a given machine, workpiece, depth of cut, etc.

MATERIAL	S.F.P.M.
Cast Iron	75-200
Malleable Iron	75-200
Nickel Chrome	75-250
Stainless Steel	75-250
Carbon Steel	100-250
Nickel	100-250
Monel Metal	100-250
Free Cutting Steel	125-300
Brass Bronze	125-300
Aluminum and Aluminum Alloys	125-375
Copper	125-375
Hard Rubber	150-450
Zinc Alloys	200-400
Fibre	200-400
Plastics	200-500

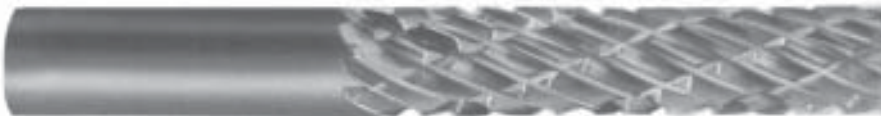
NOTE: S.F.P.M. = Surface Feet Per Minute

Standard Spiral

Head Dia.	Cutting Length	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1-1/2"	EM-125-W	36180
3/16"	5/8"	2"	EM-1875-W	36181
1/4"	3/4"	2"	EM-250-W	36182
5/16"	3/4"	2-1/2"	EM-3125-W	36183
3/8"	7/8"	2-1/2"	EM-375-W	36184
1/2"	1"	3"	EM-500-W	36185
5/8"	1-1/4"	3-1/2"	EM-625-W	36186
3/4"	1-1/2"	4"	EM-750-W	36187

Slow Spiral

Head Dia.	Cutting Length	Overall Length	Severance Tool Name	EDP Order Number
1/8"	3/8"	1-1/2"	EMS-2-W	36188
3/16"	1/2"	1-1/2"	EMS-3-W	36189
1/4"	5/8"	2"	EMS-4-W	36190
5/16"	11/16"	2"	EMS-5-W	36191
3/8"	3/4"	2"	EMS-6-W	36192
1/2"	15/16"	2"	EMS-8-W	36193
5/8"	1-1/8"	2-1/2"	EMS10-W	36194
3/4"	1-1/4"	2-5/8"	EMS-12-W	36195



Carbide Carbo-Routs™

These solid carbide, multi-tooth routing mills will produce good finishes over a wide range of speeds. Fluting and tooth arrangements are designed to provide fast stock removal on many different materials.

Plain End

Cutting Dia.	Flute Length	Shank Dia.	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1/8"	1-1/2"	R-1	28685
3/16"	5/8"	1/4"	2"	R-2	28687
1/4"	1-1/4"	1/4"	3"	R-3	28691
3/8"	1-3/8"	3/8"	2-1/2"	R-4	28694
1/2"	1-1/2"	1/2"	3"	R-5	28696

Drill Style, End Cut

Cutting Dia.	Flute Length	Shank Dia.	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1/8"	1-1/2"	R-1-DP	28745
3/16"	1"	1/4"	2"	R-2-DP	28747
1/4"	1-1/4"	1/4"	3"	R-3-DP	28751
3/8"	1-3/8"	3/8"	2-1/2"	R-4-DP	28754
1/2"	1-1/2"	1/2"	3"	R-5-DP	28756