

CARBIDE ROUGHERS

VARIABLE HELIX

Variable Helix. Increase production without the chatter from harmonics



Part #	Flute Dia	Tooth Pitch	LOC	OAL	# Flutes	Price
170RF31HD	3/16	.040	.625	2.0	3	\$23.98
170RF14HD	1/4	.040	.750	2.5	4	\$32.60
170RF51HD	5/16	.040	.875	2.5	4	\$42.05
170RF38HD	3/8	.040	.875	2.5	4	\$52.75
170RF12HD	1/2	.060	1.0	3.0	4	\$70.21
170RF58HD	5/8	.060	1.25	3.5	4	\$132.41
170RF34HD	3/4	.060	1.5	4.0	4	\$173.56
170RF10HD	1	.060	1.5	4.0	4	\$307.11

"THE FIREPLUG"

STUB VARIABLE HELIX



Part #	Flute Dia	Tooth Pitch	LOC	OAL	# Flutes	Price
170RF31HDST	3/16	.040	.312	2.0	3	\$20.63
170RF14HDST	1/4	.040	.375	2.0	4	\$29.46
170RF51HDST	5/16	.040	.500	2.0	4	\$36.06
170RF38HDST	3/8	.040	.560	2.0	4	\$45.19
170RF12HDST	1/2	.060	.625	2.5	4	\$62.06

Starting Speeds And Feeds. Strong Coolant Blast Recommended

Material	Carbon Steel	Tool Steel	Titanium	Stainless Steel	Nickel Based Alloy	Cobalt Alloy
Diameter	225-550 SFM	210-450 SFM	125-215 SFM	225-475 SFM	55-120 SFM	40-75 SFM
3/16	.0007-.002	.0005-.0015	.0007-.0013	.0008-.0015	.0005-.0012	.0005-.0012
1/4	.0007-.002	.0005-.0015	.0007-.0013	.0008-.0015	.0005-.0012	.0005-.0012
5/16	.001-.0025	.0007-.002	.0009-.0015	.001-.002	.0007-.0014	.0007-.0014
3/8	.0015-.003	.001-.0025	.0009-.0015	.001-.002	.0009-.0016	.0009-.0016
1/2	.0015-.0035	.001-.003	.0010-.0018	.0012-.0025	.0009-.0018	.0009-.0018
5/8	.002-.004	.0015-.0035	.0012-.0022	.002-.0037	.0012-.0023	.0012-.0023
3/4	.002-.004	.0015-.004	.0015-.0025	.002-.0037	.0015-.0025	.0015-.0025
1	.002-.005	.002-.0045	.0018-.0027	.0025-.0042	.0018-.0027	.0018-.0018