

# COOLANT THRU HIGH FEED MILL



## COOLANT THRU

Part #	Cutting	Shank	Reach	OAL	# FL	Price
FMXCT316A	.177	1/4	1/2	2 1/2	3	\$71.45
FMXCT316B	.177	1/4	1	2 1/2	3	\$77.44
FMXCT014A	.240	1/4	5/8	2 1/2	3	\$96.21
FMXCT014B	.240	1/4	1	3	3	\$109.37
FMXCT014C	.240	1/4	1 1/2	3	3	\$117.45
FMXCT516A	.300	5/16	1	2 1/2	3	\$114.33
FMXCT516B	.300	5/16	2	4	3	\$139.75
FMXCT038A	.360	3/8	1	2 1/2	3	\$147.94
FMXCT038B	.360	3/8	1 1/2	3	3	\$166.06
FMXCT038C	.360	3/8	2	4	3	\$200.90
FMXCT012A	.485	1/2	1 1/2	4	3	\$260.41
FMXCT012B	.485	1/2	2 3/8	4	3	\$267.00
FMXCT012C	.485	1/2	3 1/8	5	3	\$297.21

## Feed-Max Feedrate Calculator (inches/tooth)

MATERIAL	Steel	Tool Steel	Soft Cast Iron	Hard Cast Iron	Stainless Steel	Super Alloy	Titanium Alloy
SFM	800/1100	450/650	250/450	450/650	300/450	50/175	300/400
Slotting feed per tooth	0.030xD	0.027xD	.024xD	0.024xD	0.018xD	0.018xD	0.021xD
Side milling feed p/tooth	0.055xD	0.045xD	0.040xD	0.040xD	0.024xD	0.024xD	0.035xD
Side milling depth of cut - Z	1 x DOC	1 x DOC	0.8 x DOC	1 x DOC	1 x DOC	0.5 x DOC	0.5 x DOC
Side milling step over	0.5 x D	0.5 x D	0.5 x D	0.5 x D	0.5 x D	0.5 x D	0.5 x D
SFM	400/800	350/400	150/325	350/450	200/350	50/125	200/300
Plunge milling feed p/tooth	0.010xD	0.010xD	0.007xD	0.007xD	0.006xD	0.006xD	0.007xD
Linear Depth of Cut	0.3 x D	0.3 x D	0.3 x D	0.3 x D	0.3 x D	0.3 x D	0.3 x D
<b>DEPTH OF CUT IN "Z"</b>							
D=MAJOR DIAMETER OF TOOL				MAJOR DIA.	DOC	MAJOR DIA.	DOC
RAMPING ANGLE: 1-1.5°				.120	0.006	.300	0.02
REDUCE DOC -20% AND FEED PER TOOTH - 15% FOR B-Length				.177	0.01	.360	0.02
REDUCE DOC -40% AND FEED PER TOOTH - 30% FOR C-Length				.240	0.015	.485	0.025