

STAINLESS STEEL MORE THAN 28 HRC

**FOR MAXIMUM HIGH
PERFORMANCE
MACHINING**

**7
Flute**

- ◆ **STANDARD LENGTH**
- ◆ **STUB LENGTH**
- ◆ **LONG LENGTH**
- ◆ **RADIUS TOOL**
- ◆ **BALL NOSE**

607-331-4834



**ALL TOOLS CAN BE CUSTOMIZED
TO CHANGE LENGTH OF CUT,
OVERALL LENGTH, RADIUS,
CHIPBREAKER, WELDEN FLAT,
EDGE PREP AND MORE. CONTACT
US TO HELP MAKE THE TOOL THAT
WORKS BEST FOR YOU!**



Our 7-flute finishing end mills perform exceptionally well in all types of steel. For MAXIMUM performance in **hardened and tool steel applications**, we recommend coating the tools in the nano-coating, **STEELCON™**. This is an outstanding combination that allows your end mill to run at peak efficiency in hardened and tool steel varieties. The tool's geometry, identified in the box to the right, is designed to perform well with High-Speed Machining tool paths. If you are looking for an end mill for long life and maximum speed in hardened and tool steel, this is the choice.

For MAXIMUM performance in **harder grades of stainless steel**, we recommend coating the tools in the nano-coating, **STEELCON™**. This is an outstanding combination that allows your end mill to run at peak efficiency in hard stainless steel varieties. The tool's geometry, identified in the box to the right, is designed to perform well with High-Speed Machining tool paths. If you are looking for an end mill for long life and maximum speed in hard stainless steel, this is the choice.

STEELCON™ is applied with "HiPIMS" technology. This technology produces an TiAlSiN based nano-coating that is specifically designed to be extremely smooth, wear resistant and thermally stable with better adhesion to the carbide than ARC or CVD coatings. The application method makes a big difference in performance.

FEATURES OF FACTOOLING'S END MILLS

- MADE IN AMERICA
- VARIABLE INDEX
- ECCENTRIC RELIEF
- SOLID CARBIDE TOOLING THAT ALLOWS FOR RESHARPENING
- DESIGNED TO BE AGGRESSIVE TO ALLOW FOR INCREASED SPEEDS AND FEED
- HEAL GRIND TO IMPROVE CHIP CLEARANCE
- CENTER CUTTING
- COATED IN STEELCON™ (SC)

Speeds & Feeds

7
FLUTE

Material Group	ISO Material	Hardness	Coolant preferred	Contour Milling		
				5%	10%	25%
				2.3	1.67	1.15
				VC-SFM		
Hardened Steels	H	35-45 HrC	Yes	610	495	325
Hardened Steels		45-55 HrC	Yes	510	410	280
Hardened Steels		55-65 HrC	Yes	330	310	280
Stainless steel difficult to machine	M	over 28 HrC	Yes	410	330	295

ISO GROUP M & H

Material Group	Hardness	Diameter					
		1/4	3/8	1/2	5/8	3/4	1
		Fz					
Hardened Steels	35-45 HrC	0.0014	0.0024	0.003	0.004	0.0048	0.0064
Hardened Steels	45-55 HrC	0.0008	0.0016	0.0018	0.0024	0.0028	0.0038
Hardened Steels	55-65 HrC	0.0006	0.001	0.0015	0.0018	0.0021	0.0028
Stainless steel difficult to machine	over 28 HrC	0.0010-0.0015	0.0015-0.0020	0.0020-0.0031	0.0020-0.0033	0.0022-0.0035	0.0024-0.0039

STAINLESS STEEL &
HARDENED STEEL

PLEASE NOTE: THE INFORMATION ABOVE SHOULD BE CONSIDERED AS ONLY A STARTING POINT. FINE TUNING MAY BE REQUIRED IN ORDER TO GET THE BEST PERFORMANCE OF THE TOOL. EVERY MACHINE , ENVIRONMENT AND FIXTURE CAN PLAY A CRUCIAL PART IN THE PERFORMANCE OF THE TOO



Standard Length

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
FT7-250	7	1/4	0.25	2-1/2	3/4		Uncoated
FT7-250-SC	7	1/4	0.25	2-1/2	3/4		SteelCon™
FT7-312	7	5/16	0.312	2-1/2	3/4		Uncoated
FT7-312-SC	7	5/16	0.312	2-1/2	3/4		SteelCon™
FT7-375	7	3/8	0.375	2-1/2	7/8		Uncoated
FT7-375-SC	7	3/8	0.375	2-1/2	7/8		SteelCon™
FT7-500	7	1/2	0.5	3	1-1/4		Uncoated
FT7-500-SC	7	1/2	0.5	3	1-1/4		SteelCon™
FT7-625	7	5/8	0.625	3-1/2	1-1/4		Uncoated
FT7-625-SC	7	5/8	0.625	3-1/2	1-1/4		SteelCon™
FT7-750	7	3/4	0.75	4	1-1/2		Uncoated
FT7-750-SC	7	3/4	0.75	4	1-1/2		SteelCon™
FT7-1000	7	1	1	4	1-1/2		Uncoated
FT7-1000-SC	7	1	1	4	1-1/2		SteelCon™

ISO GROUP M & H

STAINLESS STEEL &
HARDENED STEEL

Stub Length

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
S-FT7-250	7	1/4	0.25	2-1/2	3/8		Uncoated
S-FT7-250-SC	7	1/4	0.25	2-1/2	3/8		SteelCon™
S-FT7-312	7	5/16	0.312	2-1/2	3/8		Uncoated
S-FT7-312-SC	7	5/16	0.312	2-1/2	3/8		SteelCon™
S-FT7-375	7	3/8	0.375	2-1/2	1/2		Uncoated
S-FT7-375-SC	7	3/8	0.375	2-1/2	1/2		SteelCon™
S-FT7-500	7	1/2	0.5	3	5/8		Uncoated
S-FT7-500-SC	7	1/2	0.5	3	5/8		SteelCon™
S-FT7-625	7	5/8	0.625	3-1/2	3/4		Uncoated
S-FT7-625-SC	7	5/8	0.625	3-1/2	3/4		SteelCon™
S-FT7-750	7	3/4	0.75	4	3/4		Uncoated
S-FT7-750-SC	7	3/4	0.75	4	3/4		SteelCon™
S-FT7-1000	7	1	1	4	3/4		Uncoated
S-FT7-1000-SC	7	1	1	4	3/4		SteelCon™

**ISO GROUP M & H****STAINLESS STEEL &
HARDENED STEEL**



Long Length

ISO GROUP M & H

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
L-FT7-250	7	1/4	0.25	2-1/2	1-1/4		Uncoated
L-FT7-250-SC	7	1/4	0.25	2-1/2	1-1/4		SteelCon™
L-FT7-312	7	5/16	0.312	2-1/2	1-1/4		Uncoated
L-FT7-312-SC	7	5/16	0.312	2-1/2	1-1/4		SteelCon™
L-FT7-375	7	3/8	0.375	2-1/2	1-1/4		Uncoated
L-FT7-375-SC	7	3/8	0.375	2-1/2	1-1/4		SteelCon™
L-FT7-500	7	1/2	0.5	3	1-1/2		Uncoated
L-FT7-500-SC	7	1/2	0.5	3	1-1/2		SteelCon™
L-FT7-625	7	5/8	0.625	3-1/2	1-3/4		Uncoated
L-FT7-625-SC	7	5/8	0.625	3-1/2	1-3/4		SteelCon™
L-FT7-750	7	3/4	0.75	4	2		Uncoated
L-FT7-750-SC	7	3/4	0.75	4	2		SteelCon™
L-FT7-1000	7	1	1	4	2		Uncoated
L-FT7-1000-SC	7	1	1	4	2		SteelCon™

**STAINLESS STEEL &
HARDENED STEEL**



Radius Tool

ISO GROUP M & H

**STAINLESS STEEL &
HARDENED STEEL**

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
R-FT7-187-010	7	3/16	0.1875	1-1/2	5/8	0.01	Uncoated
R-FT7-187-SC-010	7	3/16	0.1875	1-1/2	5/8	0.01	SteelCon™
R-FT7-250-020	7	1/4	0.250	2-1/2	3/4	0.02	Uncoated
R-FT7-250-SC-020	7	1/4	0.250	2-1/2	3/4	0.02	SteelCon™
R-FT7-312-020	7	5/16	0.312	2-1/2	3/4	0.02	Uncoated
R-FT7-312-SC-020	7	5/16	0.312	2-1/2	3/4	0.02	SteelCon™
R-FT7-375-030	7	3/8	0.375	2-1/2	7/8	0.03	Unocated
R-FT7-375-SC-030	7	3/8	0.375	2-1/2	7/8	0.03	SteelCon™
R-FT7-500-030	7	1/2	0.500	3	1-1/4	0.03	Uncoated
R-FT7-500-SC-030	7	1/2	0.500	3	1-1/4	0.03	SteelCon™
R-FT7-500-060	7	1/2	0.500	3	1-1/4	0.06	Uncoated
R-FT7-500-SC-060	7	1/2	0.500	3	1-1/4	0.06	SteelCon™
R-FT7-625-030	7	5/8	0.625	3-1/2	1-1/4	0.03	Uncoated
R-FT7-625-SC-030	7	5/8	0.625	3-1/2	1-1/4	0.03	SteelCon™
R-FT7-625-060	7	5/8	0.625	3-1/2	1-1/4	0.06	Uncoated
R-FT7-625-SC-060	7	5/8	0.625	3-1/2	1-1/4	0.06	SteelCon™
R-FT7-750-030	7	3/4	0.750	4	1-1/2	0.03	Uncoated
R-FT7-750-SC-030	7	3/4	0.750	4	1-1/2	0.03	SteelCon™
R-FT7-750-060	7	3/4	0.750	4	1-1/2	0.06	Uncoated
R-FT7-750-SC-060	7	3/4	0.750	4	1-1/2	0.06	SteelCon™
R-FT7-1000-030	7	1	1	4	1-1/2	0.03	Uncoated
R-FT7-1000-SC-030	7	1	1	4	1-1/2	0.03	SteelCon™
R-FT7-1000-060	7	1	1	4	1-1/2	0.06	Uncoated
R-FT7-1000-SC-060	7	1	1	4	1-1/2	0.06	SteelCon™

SC
STEELCON™

7
FLUTE

BENEFITS TO 7 FLUTE

FINER FINISH
REDUCED CHATTER
HANDLE HIGHER FEED RATES
STRONG RIGIDTY
HEAT DISTRIBUTION

CALL US TODAY FOR MORE HELP

FACTooling

Morgan Brown and William Walter

607-331-4834

FACTooling@gmail.com

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**STAINLESS STEEL &
HARDENED STEEL**



**SCAN TO LEARN
MORE ABOUT
STEELCON™**



**SCAN TO TAKE
YOU TO
FACTOOLINGS
WEBSITE**

