

STAINLESS STEEL LESS THAN 28 HRC

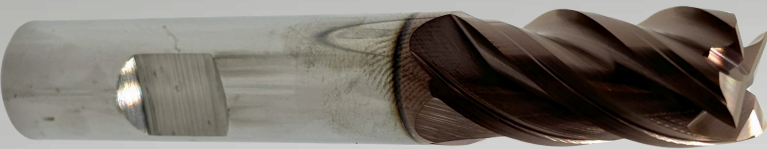
***FOR MAXIMUM HIGH
PERFORMANCE
MACHINING***

**4
Flute**

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



607-331-4834



**CONTACT US TO HELP MAKE
THE TOOL THAT WORKS BEST
FOR YOU!**

Our 4-flute end mills perform exceptionally well in most types of steel. For **MAXIMUM** performance in **softer grades of stainless steel**, we recommend coating the tools in the nano-coating, **InoxaCon™**. This is an outstanding combination that allows your end mill to run at peak efficiency in softer stainless steel varieties. The tool's geometry, identified in the box to the right, is designed to perform exceptionally well with High-Speed Machining tool paths. If you are looking for an end mill for long life and maximum speed in softer stainless steel, this is the choice.

InoxaCon™ is applied with "HiPIMS" technology. This technology produces a 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.

CUSTOMISE YOUR TOOL WITH..

- ☒ **LENGTH OF CUT**
- ☒ **OVERALL LENGTH**
- ☒ **CHIPBREAKER**
- ☒ **EDGE PREP**
- ☒ **RADIUS**
- ☒ **WELDEN FLAT**

FEATURES OF FACTOOLING'S END MILLS

- MADE IN AMERICA
- 40 DEGREE HELIX ANGLE
- VARIABLE INDEX
- ECCENTRIC RELIEF
- SOLID CARBIDE TOOLING THAT ALLOWS FOR RESHARPENING
- DESIGNED TO BE AGGRESSIVE TO ALLOW FOR INCREASED SPEEDS AND FEED
- COMES UNCOATED AND COATED IN INOXACON™ (I)

Speeds & Feeds

4
FLUTE

ISO GROUP M

STAINLESS STEEL 28 HRC

Material Group			ISO Groups		Coolant preferred		Contour Milling			
							5%	10%	25%	50%
							2.3	1.8	1.2	1
							vc-SFM			
Stainless Steel easy to machine			M	Yes	675	545	425	360		
Stainless steel austenitic			M	Yes	525	430	400	210		
Stainless steel difficult to machine			M	Yes	410	330	295	210		
Stainless difficult to machine 17-4 PH			M	Yes	525	430	395	110		
Diameter		1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
Fz		0.0012	0.002	0.0024	0.0031	0.0039	0.0047	0.006	0.0078	0.01

Material Group				ISO Group			Coolant preferred			Slotting		
										25%	50%	100%
										vc-SFM		
Stainless Steel easy to machine				M			Yes			385	360	350
Stainless steel austenitic				M			Yes			225	210	200
Stainless steel difficult to machine				M			Yes			225	200	
Stainless difficult to machine 17-4 PH				M			Yes			225	210	200
Diameter	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1			
Fz	0.04	0.001	0.0012	0.0016	0.002	0.0024	0.0031	0.004	0.005			

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

**40 °
HELIX**

**I
INOXACon™**

**4
FLUTE**

Standard Length

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
FT4-125	4	1/8	0.125	1-1/2	1/2		Uncoated
FT4-125-I	4	1/8	0.125	1-1/2	1/2		InoxaCon™
FT4-187	4	3/16	0.1875	1-1/2	5/8		Uncoated
FT4-187-I	4	3/16	0.1875	1-1/2	5/8		InoxaCon™
FT4-250	4	1/4	0.25	2-1/2	3/4		Uncoated
FT4-250-I	4	1/4	0.25	2-1/2	3/4		InoxaCon™
FT4-312	4	5/16	0.312	2-1/2	3/4		Uncoated
FT4-312-I	4	5/16	0.312	2-1/2	3/4		InoxaCon™
FT4-375	4	3/8	0.375	2-1/2	7/8		Uncoated
FT4-375-I	4	3/8	0.375	2-1/2	7/8		InoxaCon™
FT4-500	4	1/2	0.5	3	1-1/4		Uncoated
FT4-500-I	4	1/2	0.5	3	1-1/4		InoxaCon™
FT4-625	4	5/8	0.625	3-1/2	1-1/4		Uncoated
FT4-625-I	4	5/8	0.625	3-1/2	1-1/4		InoxaCon™
FT4-750	4	3/4	0.75	4	1-1/2		Uncoated
FT4-750-I	4	3/4	0.75	4	1-1/2		InoxaCon™
FT4-1000	4	1	1	4	1-1/2		Uncoated
FT4-1000-I	4	1	1	4	1-1/2		InoxaCon™

ISO GROUP M

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Stub Length

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
S-FT4-187	4	1/8	0.1875	1-1/2	1/4		Uncoated
S-FT4-187-I	4	1/8	0.1875	1-1/2	1/4		InoxaCon™
S-FT4-250	4	1/4	0.25	2-1/2	3/8		Uncoated
S-FT4-250-I	4	1/4	0.25	2-1/2	3/8		InoxaCon™
S-FT4-312	4	5/16	0.312	2-1/2	3/8		Uncoated
S-FT4-312-I	4	5/16	0.312	2-1/2	3/8		InoxaCon™
S-FT4-375	4	3/8	0.375	2-1/2	1/2		Uncoated
S-FT4-375-I	4	3/8	0.375	2-1/2	1/2		InoxaCon™
S-FT4-500	4	1/2	0.5	3	5/8		Uncoated
S-FT4-500-I	4	1/2	0.5	3	5/8		InoxaCon™
S-FT4-625	4	5/8	0.625	3-1/2	3/4		Uncoated
S-FT4-625-I	4	5/8	0.625	3-1/2	3/4		InoxaCon™
S-FT4-750	4	3/4	0.75	4	3/4		Unocated
S-FT4-750-I	4	3/4	0.75	4	3/4		InoxaCon™
S-FT4-1000	4	1	1	4	3/4		Uncoated
S-FT4-1000-I	4	1	1	4	3/4		InoxaCon™

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Long Length



Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
L-FT4-125	4	1/8	0.125	2	1		Uncoated
L-FT4-125-I	4	1/8	0.125	2	1		InoxaCon™
L-FT4-187	4	3/16	0.1875	2	1		Uncoated
L-FT4-187-I	4	3/16	0.1875	2	1		InoxaCon™
L-FT4-250	4	1/4	0.25	2-1/2	1-1/4		Uncoated
L-FT4-250-I	4	1/4	0.25	2-1/2	1-1/4		InoxaCon™
L-FT4-312	4	5/16	0.312	2-1/2	1-1/4		Uncoated
L-FT4-312-I	4	5/16	0.312	2-1/2	1-1/4		InoxaCon™
L-FT4-375	4	3/8	0.375	2-1/2	1-1/4		Uncoated
L-FT4-375-I	4	3/8	0.375	2-1/2	1-1/4		InoxaCon™
L-FT4-500	4	1/2	0.5	3	1-1/2		Uncoated
L-FT4-500-I	4	1/2	0.5	3	1-1/2		InoxaCon™
L-FT4-625	4	5/8	0.625	3-1/2	1-3/4		Uncoated
L-FT4-625-I	4	2/8	0.625	3-1/2	1-3/4		InoxaCon™
L-FT4-750	4	3/4	0.75	4	2		Uncoated
L-FT4-750-I	4	3/4	0.75	4	2		InoxaCon™
L-FT4-1000	4	1	1	4	2		Uncoated
L-FT4-1000-I	4	1	1	4	2		InoxaCon™

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**4
FLUTE**

Radius Tool

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
R-FT4-125-010	4	1/8	0.125	1-1/2	1/2	0.01	Uncoated
R-FT4-125-I-010	4	1/8	0.125	1-1/2	1/2	0.01	InoxaCon™
R-FT4-187-010	4	3/16	0.1875	1-1/2	5/8	0.01	Uncoated
R-FT4-187-I-010	4	3/16	0.1875	1-1/2	5/8	0.01	InoxaCon™
R-FT4-250-020	4	1/4	0.250	2-1/2	3/4	0.02	Uncoated
R-FT4-250-I-020	4	1/4	0.250	2-1/2	3/4	0.02	InoxaCon™
R-FT4-312-020	4	5/16	0.312	2-1/2	3/4	0.02	Uncoated
R-FT4-312-I-020	4	5/16	0.312	2-1/2	3/4	0.02	InoxaCon™
R-FT4-375-.030	4	3/8	0.375	2-1/2	7/8	0.03	Unocated
R-FT4-375-I-030	4	3/8	0.375	2-1/2	7/8	0.03	InoxaCon™
R-FT4-500-030	4	1/2	0.500	3	1-14	0.03	Uncoated
R-FT4-500-I-030	4	1/2	0.500	3	1-1/4	0.03	InoxaCon™
R-FT4-500-060	4	1/2	0.500	3	1-1/4	0.06	Uncoated
R-FT4-500-I-060	4	1/2	0.500	3	1-1/4	0.06	InoxaCon™
R-FT4-625-030	4	5/8	0.625	3-1/2	1-1/4	0.03	Uncoated
R-FT4-625-I-030	4	5/8	0.625	3-1/2	1-1/4	0.03	InoxaCon™
R-FT4-625-060	4	5/8	0.625	3-1/2	1-1/4	0.06	Uncoated
R-FT4-625-I-060	4	5/8	0.625	3-1/2	1-1/4	0.06	InoxaCon™
R-FT4-750-030	4	3/4	0.750	4	1-1/2	0.03	Uncoated
R-FT4-750-I-030	4	3/4	0.750	4	1-1/2	0.03	InoxaCon™
R-FT4-750-060	4	3/4	0.750	4	1-1/2	0.06	Uncoated
R-FT4-750-I-060	4	3/4	0.750	4	1-1/2	0.06	InoxaCon™
R-FT4-1000-030	4	1	1	4	1-1/2	0.03	Uncoated
R-FT4-1000-I-030	4	1	1	4	1-1/2	0.03	InoxaCon™
R-FT4-1000-060	4	1	1	4	1-1/2	0.06	Uncoated
R-FT4-1000-I-060	4	1	1	4	1-1/2	0.06	InoxaCon™

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**4
FLUTE**

Ball Nose



Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
B-FT4-125	4	1/8	0.125	1-1/2	1/2		Uncoated
B-FT4-125-I	4	1/8	0.125	1-1/2	1/2		InoxaCon™
B-FT4-187	4	3/16	0.1875	1-1/2	5/8		Uncoated
B-FT4-187-I	4	3/16	0.1875	1-1/2	5/8		InoxaCon™
B-FT4-250	4	1/4	0.25	2-1/2	3/4		Uncoated
B-FT4-250-I	4	1/4	0.25	2-1/2	3/4		InoxaCon™
B-FT4-312	4	5/16	0.312	2-1/2	3/4		Uncoated
B-FT4-312-I	4	5/16	0.312	2-1/2	3/4		InoxaCon™
B-FT4-375	4	3/8	0.375	2-1/2	7/8		Uncoated
B-FT4-375-I	4	3/8	0.375	2-1/2	7/8		InoxaCon™
B-FT4-500	4	1/2	0.5	3	1-1/4		Uncoated
B-FT4-500-I	4	1/2	0.5	3	1-1/4		InoxaCon™
B-FT4-625	4	5/8	0.625	3-1/2	1-1/4		Uncoated
B-FT4-625-I	4	5/8	0.625	3-1/2	1-1/4		InoxaCon™
B-FT4-750	4	3/4	0.75	4	1-1/2		Uncoated
B-FT4-750-I	4	3/4	0.75	4	1-1/2		InoxaCon™
B-FT4-1000	4	1	1	4	1-1/2		Uncoated
B-FT4-1000-I	4	1	1	4	1-1/2		InoxaCon™

**USING A BALL NOSE ALLOWS FOR INCREASED LONGEVITY OF
TOOLS BY REMOVING THE SQUARE END OF THE END MILL
DECREASES THE WEAR OF THE TOOL**

ISO GROUP M

STAINLESS STEEL 28 HRC

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**I
INOXACON
TM**

**4
FLUTE**

BENEFITS TO 4 FLUTE

**STABLE CUTS
REDUCED CHATTER
COMMON END MILL EVERY MACHINIST HAS USED**

CALL US TODAY FOR MORE HELP

FACTooling

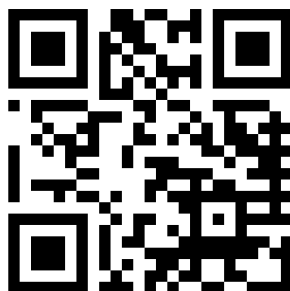
Morgan Brown and William Walter

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