

STAINLESS STEEL LESS THAN 28 HRC

**FOR MAXIMUM HIGH
PERFORMANCE
MACHINING**

**9
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 9-flute finishing end mills perform exceptionally well in most all types of steel. For MAXIMUM performance in **softer grades of stainless steel, Inconel, WaspAlloy, Hastelloy** 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 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 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 INOXACON™ (I)

Speeds & Feeds

9
FLUTE

ISO GROUP M

STAINLESS STEEL 28 HRC

Material Group	ISO Materials	Coolant preferred	Contour Milling	
			5%	10%
			2.3	1.67
			VC-SFM	
Free Machining Stainless Steel	M	Yes	675	545
Austenitic Stainless Steel		Yes	525	430
Difficult Stainless Steel		Yes	410	330
PH Stainless Steel		Yes	525	430

Material Group	Diameter			
	3/8	1/2	5/8	3/4
	fz			
Free Machining Stainless Steel	0.0023	0.003	0.0038	0.0045
Austenitic Stainless Steel	0.0019	0.0025	0.0031	0.0038
Difficult Stainless Steel	0.0015	0.002	0.0025	0.003
PH Stainless Steel	0.0015	0.002	0.0025	0.003

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

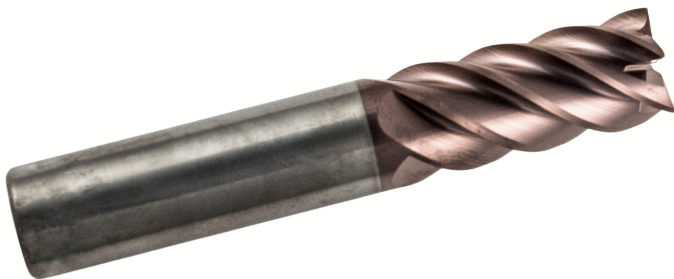


Standard Length

ISO GROUP M

STAINLESS STEEL 28 HRC

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
FT9-375	9	3/8	0.375	2-1/2	7/8		Uncoated
FT9-375-I	9	3/8	0.375	2-1/2	7/8		InoxaCon™
FT9-500	9	1/2	0.5	3	1-1/4		Uncoated
FT9-500-I	9	1/2	0.5	3	1-1/4		InoxaCon™
FT9-625	9	5/8	0.625	3-1/2	1-1/4		Uncoated
FT9-625-I	9	5/8	0.625	3-1/2	1-1/4		InoxaCon™
FT9-750	9	3/4	0.75	4	1-1/2		Uncoated
FT9-750-I	9	3/4	0.75	4	1-1/2		InoxaCon™
FT9-1000	9	1	1	4	1-1/2		Uncoated
FT9-1000-I	9	1	1	4	1-1/2		InoxaCon™





Stub Length

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
S-FT9-375	9	3/8	0.375	2-1/2	1/2		Uncoated
S-FT9-375-I	9	3/8	0.375	2-1/2	1/2		InoxaCon™
S-FT9-500	9	1/2	0.5	3	5/8		Uncoated
S-FT9-500-I	9	1/2	0.5	3	5/8		InoxaCon™
S-FT9-625	9	5/8	0.625	3-1/2	3/4		Uncoated
S-FT9-625-I	9	5/8	0.625	3-1/2	3/4		InoxaCon™
S-FT9-750	9	3/4	0.75	4	3/4		Uncoated
S-FT9-750-I	9	3/4	0.75	4	3/4		InoxaCon™
S-FT9-1000	9	1	1	4	3/4		Uncoated
S-FT9-1000-I	9	1	1	4	3/4		InoxaCon™

ISO GROUP M

STAINLESS STEEL 28 HRC



Long Length

ISO GROUP M
STAINLESS STEEL 28 HRC

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
L-FT9-375	9	3/8	0.375	2-1/2	1-1/4		Uncoated
L-FT9-375-I	9	3/8	0.375	2-1/2	1-1/4		InoxaCon™
L-FT9-500	9	1/2	0.5	3	1-1/2		Uncoated
L-FT9-500-I	9	1/2	0.5	3	1-1/2		InoxaCon™
L-FT9-625	9	5/8	0.625	3-1/2	1-3/4		Uncoated
L-FT9-625-I	9	5/8	0.625	3-1/2	1-3/4		InoxaCon™
L-FT9-750	9	3/4	0.75	4	2		Uncoated
L-FT9-750-I	9	3/4	0.75	4	2		InoxaCon™
L-FT9-1000	9	1	1	4	2		Uncoated
L-FT9-1000-I	9	1	1	4	2		InoxaCon™



Radius Tool

Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
R-FT9-375-030	9	3/8	0.375	2-1/2	7/8	0.03	Unocated
R-FT9-375-I-030	9	3/8	0.375	2-1/2	7/8	0.03	InoxaCon™
R-FT9-500-030	9	1/2	0.500	3	1-1/4	0.03	Uncoated
R-FT9-500-I-030	9	1/2	0.500	3	1-1/4	0.03	InoxaCon™
R-FT9-500-060	9	1/2	0.500	3	1-1/4	0.06	Uncoated
R-FT9-500-I-060	9	1/2	0.500	3	1-1/4	0.06	InoxaCon™
R-FT9-625-030	9	5/8	0.625	3-1/2	1-1/4	0.03	Uncoated
R-FT9-625-I-030	9	5/8	0.625	3-1/2	1-1/4	0.03	InoxaCon™
R-FT9-625-060	9	5/8	0.625	3-1/2	1-1/4	0.06	Uncoated
R-FT9-625-I-060	9	5/8	0.625	3-1/2	1-1/4	0.06	InoxaCon™
R-FT9-750-030	9	3/4	0.750	4	1-1/2	0.03	Uncoated
R-FT9-750-I-030	9	3/4	0.750	4	1-1/2	0.03	InoxaCon™
R-FT9-750-060	9	3/4	0.750	4	1-1/2	0.06	Uncoated
R-FT9-750-I-060	9	3/4	0.750	4	1-1/2	0.06	InoxaCon™
R-FT9-1000-030	9	1	1	4	1-1/2	0.03	Uncoated
R-FT9-1000-I-030	9	1	1	4	1-1/2	0.03	InoxaCon™
R-FT9-1000-060	9	1	1	4	1-1/2	0.06	Uncoated
R-FT9-1000-I-060	9	1	1	4	1-1/2	0.06	InoxaCon™

ISO GROUP M

STAINLESS STEEL 28 HRC



BENEFITS TO 9 FLUTE

- FINER FINISH**
- REDUCED CHATTER**
- HANDLES HIGHER FEED RATES**
- STRONG RIGIDITY**
- HEAT DISTRIBUTION**

CALL US TODAY FOR MORE HELP

FACTooling

Morgan Brown and William Walter

607-331-4834

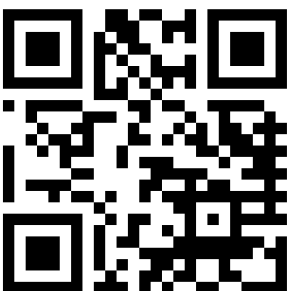
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ISO GROUP M

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*SCAN TO LEARN
MORE ABOUT
INOXACON™*



*SCAN TO TAKE YOU
TO
FACTOOLINGS
WEBSITE*

