

**FACTooling**  
Made in U.S.A.

# **STAINLESS STEEL LESS THAN 28 HRC**

***FOR MAXIMUM HIGH  
PERFORMANCE  
MACHINING***

**6  
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 6-flute finishing end mills perform exceptionally well in most all types of steel. For MAXIMUM performance in **softer grades of stainless steel, Inconel, WaspAlloy and 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
- CENTER CUTTING
- COATED IN INOXACON™ (I)

# Speeds & Feeds

6  
FLUTE

ISO GROUP M

STAINLESS STEEL 28 HRC

| Material Group                       | ISO Material | Coolant preferred | Contour Milling |     |     |     |     |
|--------------------------------------|--------------|-------------------|-----------------|-----|-----|-----|-----|
|                                      |              |                   | 5%              | 10% | 20% | 30% | 50% |
|                                      |              |                   | 2.3             | 1.8 | 1.2 | 1   |     |
|                                      |              |                   | VC-SFM          |     |     |     |     |
| Stainless Steel easy to machine      | M            | Yes               | 1200            | 800 | 500 | 440 | 400 |
| Stainless steel austenitic           | M            | Yes               | 600             | 400 | 300 | 220 | 200 |
| Stainless steel difficult to machine | M            | Yes               | 600             | 400 | 300 | 220 | 200 |

|                 |        |        |        |            |            |            |            |        |      |
|-----------------|--------|--------|--------|------------|------------|------------|------------|--------|------|
| Diameter        | 1/8    | 3/16   | 1/4    | 5/16       | 3/8        | 1/2        | 5/8        | 3/4    | 1    |
| FZ=<br>in/tooth | 0.0007 | 0.0011 | 0.0026 | 0.003<br>2 | 0.003<br>7 | 0.00<br>53 | 0.006<br>3 | 0.0074 | 0.01 |

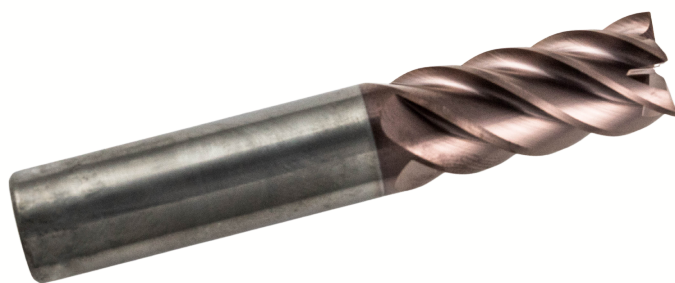
**PLEASE NOTE:** THE INFORMATION ABOVE SHOULD BE CONSIDERED AS ONLY A STARTING POINT. FINE TUNING MAY BE REQUIRED IN ORDER TO GET THE BEST PERFORMANCE OF THE TOOL. EVERY MACHINE , ENVIRONMENT AND FIXTURE CAN PLAY A CRUCIAL PART IN THE PERFORMANCE OF THE TOO

# Standard Length

**ISO GROUP M**

**STAINLESS STEEL 28 HRC**

| Part Number | # of Flutes | Shank Diameter |         | OAL   | Flute Length | Radius | Coating   |
|-------------|-------------|----------------|---------|-------|--------------|--------|-----------|
|             |             | Inch           | Decimal |       |              |        |           |
| FT6-187     | 6           | 3/16           | 0.1875  | 1-1/2 | 5/8          |        | Uncoated  |
| FT6-187-I   | 6           | 3/16           | 0.1875  | 1-1/2 | 5/8          |        | InoxaCon™ |
| FT6-250     | 6           | 1/4            | 0.25    | 2-1/2 | 3/4          |        | Uncoated  |
| FT6-250-I   | 6           | 1/4            | 0.25    | 2-1/2 | 3/4          |        | InoxaCon™ |
| FT6-312     | 6           | 5/16           | 0.312   | 2-1/2 | 3/4          |        | Uncoated  |
| FT6-312-I   | 6           | 5/16           | 0.312   | 2-1/2 | 3/4          |        | InoxaCon™ |
| FT6-375     | 6           | 3/8            | 0.375   | 2-1/2 | 7/8          |        | Uncoated  |
| FT6-375-I   | 6           | 3/8            | 0.375   | 2-1/2 | 7/8          |        | InoxaCon™ |
| FT6-500     | 6           | 1/2            | 0.5     | 3     | 1-1/4        |        | Uncoated  |
| FT6-500-I   | 6           | 1/2            | 0.5     | 3     | 1-1/4        |        | InoxaCon™ |
| FT6-625     | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        |        | Uncoated  |
| FT6-625-I   | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        |        | InoxaCon™ |
| FT6-750     | 6           | 3/4            | 0.75    | 4     | 1-1/2        |        | Uncoated  |
| FT6-750-I   | 6           | 3/4            | 0.75    | 4     | 1-1/2        |        | InoxaCon™ |
| FT6-1000    | 6           | 1              | 1       | 4     | 1-1/2        |        | Uncoated  |
| FT6-1000-I  | 6           | 1              | 1       | 4     | 1-1/2        |        | InoxaCon™ |





# Stub Length



| Part Number  | # of Flutes | Shank Diameter |         | OAL   | Flute Length | Radius | Coating   |
|--------------|-------------|----------------|---------|-------|--------------|--------|-----------|
|              |             | Inch           | Decimal |       |              |        |           |
| S-FT6-187    | 6           | 1/8            | 0.1875  | 1-1/2 | 1/4          |        | Uncoated  |
| S-FT6-187-I  | 6           | 1/8            | 0.1875  | 1-1/2 | 1/4          |        | InoxaCon™ |
| S-FT6-250    | 6           | 1/4            | 0.25    | 2-1/2 | 3/8          |        | Uncoated  |
| S-FT6-250-I  | 6           | 1/4            | 0.25    | 2-1/2 | 3/8          |        | InoxaCon™ |
| S-FT6-312    | 6           | 5/16           | 0.312   | 2-1/2 | 3/8          |        | Uncoated  |
| S-FT6-312-I  | 6           | 5/16           | 0.312   | 2-1/2 | 3/8          |        | InoxaCon™ |
| S-FT6-375    | 6           | 3/8            | 0.375   | 2-1/2 | 1/2          |        | Uncoated  |
| S-FT6-375-I  | 6           | 3/8            | 0.375   | 2-1/2 | 1/2          |        | InoxaCon™ |
| S-FT6-500    | 6           | 1/2            | 0.5     | 3     | 5/8          |        | Uncoated  |
| S-FT6-500-I  | 6           | 1/2            | 0.5     | 3     | 5/8          |        | InoxaCon™ |
| S-FT6-625    | 6           | 5/8            | 0.625   | 3-1/2 | 3/4          |        | Uncoated  |
| S-FT6-625-I  | 6           | 5/8            | 0.625   | 3-1/2 | 3/4          |        | InoxaCon™ |
| S-FT6-750    | 6           | 3/4            | 0.75    | 4     | 3/4          |        | Uncoated  |
| S-FT6-750-I  | 6           | 3/4            | 0.75    | 4     | 3/4          |        | InoxaCon™ |
| S-FT6-1000   | 6           | 1              | 1       | 4     | 3/4          |        | Uncoated  |
| S-FT6-1000-I | 6           | 1              | 1       | 4     | 3/4          |        | InoxaCon™ |

ISO GROUP M

STAINLESS STEEL 28 HRC

I  
INOXACon™

6  
FLUTE

# Long Length



ISO GROUP M

STAINLESS STEEL 28 HRC

| Part Number  | # of Flutes | Shank Diameter |         | OAL   | Flute Length | Radius | Coating   |
|--------------|-------------|----------------|---------|-------|--------------|--------|-----------|
|              |             | Inch           | Decimal |       |              |        |           |
| L-FT6-187    | 6           | 3/16           | 0.1875  | 2     | 1            |        | Uncoated  |
| L-FT6-187-I  | 6           | 3/16           | 0.1875  | 2     | 1            |        | InoxaCon™ |
| L-FT6-250    | 6           | 1/4            | 0.25    | 2-1/2 | 1-1/4        |        | Uncoated  |
| L-FT6-250-I  | 6           | 1/4            | 0.25    | 2-1/2 | 1-1/4        |        | InoxaCon™ |
| L-FT6-312    | 6           | 5/16           | 0.312   | 2-1/2 | 1-1/4        |        | Uncoated  |
| L-FT6-312-I  | 6           | 5/16           | 0.312   | 2-1/2 | 1-1/4        |        | InoxaCon™ |
| L-FT6-375    | 6           | 3/8            | 0.375   | 2-1/2 | 1-1/4        |        | Uncoated  |
| L-FT6-375-I  | 6           | 3/8            | 0.375   | 2-1/2 | 1-1/4        |        | InoxaCon™ |
| L-FT6-500    | 6           | 1/2            | 0.5     | 3     | 1-1/2        |        | Uncoated  |
| L-FT6-500-I  | 6           | 1/2            | 0.5     | 3     | 1-1/2        |        | InoxaCon™ |
| L-FT6-625    | 6           | 5/8            | 0.625   | 3-1/2 | 1-3/4        |        | Uncoated  |
| L-FT6-625-I  | 6           | 5/8            | 0.625   | 3-1/2 | 1-3/4        |        | InoxaCon™ |
| L-FT6-750    | 6           | 3/4            | 0.75    | 4     | 2            |        | Uncoated  |
| L-FT6-750-I  | 6           | 3/4            | 0.75    | 4     | 2            |        | InoxaCon™ |
| L-FT6-1000   | 6           | 1              | 1       | 4     | 2            |        | Uncoated  |
| L-FT6-1000-I | 6           | 1              | 1       | 4     | 2            |        | InoxaCon™ |



# Radius Tool

| Part Number      | # of Flutes | Shank Diameter |         | OAL   | Flute Length | Radius | Coating   |
|------------------|-------------|----------------|---------|-------|--------------|--------|-----------|
|                  |             | Inch           | Decimal |       |              |        |           |
| R-FT6-187-010    | 6           | 3/16           | 0.1875  | 1-1/2 | 5/8          | 0.01   | Uncoated  |
| R-FT6-187-I-010  | 6           | 3/16           | 0.1875  | 1-1/2 | 5/8          | 0.01   | InoxaCon™ |
| R-FT6-250-020    | 6           | 1/4            | 0.250   | 2-1/2 | 3/4          | 0.02   | Uncoated  |
| R-FT6-250-I-020  | 6           | 1/4            | 0.250   | 2-1/2 | 3/4          | 0.02   | InoxaCon™ |
| R-FT6-312-020    | 6           | 5/16           | 0.312   | 2-1/2 | 3/4          | 0.02   | Uncoated  |
| R-FT6-312-I-020  | 6           | 5/16           | 0.312   | 2-1/2 | 3/4          | 0.02   | InoxaCon™ |
| R-FT6-375-.030   | 6           | 3/8            | 0.375   | 2-1/2 | 7/8          | 0.03   | Unocated  |
| R-FT6-375-I -030 | 6           | 3/8            | 0.375   | 2-1/2 | 7/8          | 0.03   | InoxaCon™ |
| R-FT6-500-030    | 6           | 1/2            | 0.500   | 3     | 1-1/4        | 0.03   | Uncoated  |
| R-FT6-500-I-030  | 6           | 1/2            | 0.500   | 3     | 1-1/4        | 0.03   | InoxaCon™ |
| R-FT6-500-060    | 6           | 1/2            | 0.500   | 3     | 1-1/4        | 0.06   | Uncoated  |
| R-FT6-500-I-060  | 6           | 1/2            | 0.500   | 3     | 1-1/4        | 0.06   | InoxaCon™ |
| R-FT6-625-030    | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        | 0.03   | Uncoated  |
| R-FT6-625-I-030  | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        | 0.03   | InoxaCon™ |
| R-FT6-625-060    | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        | 0.06   | Uncoated  |
| R-FT6-625-I-060  | 6           | 5/8            | 0.625   | 3-1/2 | 1-1/4        | 0.06   | InoxaCon™ |
| R-FT6-750-030    | 6           | 3/4            | 0.750   | 4     | 1-1/2        | 0.03   | Uncoated  |
| R-FT6-750-I-030  | 6           | 3/4            | 0.750   | 4     | 1-1/2        | 0.03   | InoxaCon™ |
| R-FT6-750-060    | 6           | 3/4            | 0.750   | 4     | 1-1/2        | 0.06   | Uncoated  |
| R-FT6-750-I-060  | 6           | 3/4            | 0.750   | 4     | 1-1/2        | 0.06   | InoxaCon™ |
| R-FT6-1000-030   | 6           | 1              | 1       | 4     | 1-1/2        | 0.03   | Uncoated  |
| R-FT6-1000-I-030 | 6           | 1              | 1       | 4     | 1-1/2        | 0.03   | InoxaCon™ |
| R-FT6-1000-060   | 6           | 1              | 1       | 4     | 1-1/2        | 0.06   | Uncoated  |
| R-FT6-1000-I-060 | 6           | 1              | 1       | 4     | 1-1/2        | 0.06   | InoxaCon™ |

ISO GROUP M

STAINLESS STEEL 28 HRC



## **BENEFITS TO 6 FLUTE**

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

**CALL US TODAY FOR MORE HELP**

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**ISO GROUP M**

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