

FACTooling
Made in U.S.A.

STAINLESS STEEL LESS THAN 28 HRC

*FOR MAXIMUM HIGH
PERFORMANCE
MACHINING*

**7
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!**

CUSTOMISE YOUR TOOL WITH..

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

Our 7-flute finishing end mills perform exceptionally well in 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

7
FLUTE

ISO GROUP M

STAINLESS STEEL 28 HRC

Material Group	ISO Material	Hardness	Coolant preferred	Contour Milling		
				5%	10%	25%
				2.3	1.67	1.15
				VC-SFM		
Easy to Machine Stainless	M	Up to 28 Hrc	Yes	675	545	425
Austenitic Stainless	M	Up to 28 Hrc	Yes	525	430	400
Difficult to machine Stainless	M	Up to 28 Hrc	Yes	410	330	295

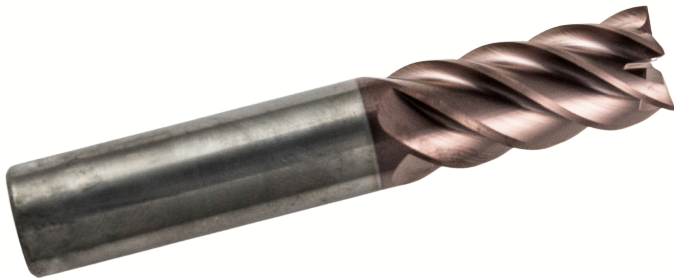
Diameter	1/4	3/8	1/2	5/8	3/4	1
FZ= in/tooth	0.0010-.0015	0.0015-0.0020	0.0020-0.0031	0.0020-.0033	.0022-.0035	.0024-.0039

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-I	7	1/4	0.25	2-1/2	3/4		InoxaCon™
FT7-312	7	5/16	0.312	2-1/2	3/4		Uncoated
FT7-312-I	7	5/16	0.312	2-1/2	3/4		InoxaCon™
FT7-375	7	3/8	0.375	2-1/2	7/8		Uncoated
FT7-375-I	7	3/8	0.375	2-1/2	7/8		InoxaCon™
FT7-500	7	1/2	0.5	3	1-1/4		Uncoated
FT7-500-I	7	1/2	0.5	3	1-1/4		InoxaCon™
FT7-625	7	5/8	0.625	3-1/2	1-1/4		Uncoated
FT7-625-I	7	5/8	0.625	3-1/2	1-1/4		InoxaCon™
FT7-750	7	3/4	0.75	4	1-1/2		Uncoated
FT7-750-I	7	3/4	0.75	4	1-1/2		InoxaCon™
FT7-1000	7	1	1	4	1-1/2		Uncoated
FT7-1000-I	7	1	1	4	1-1/2		InoxaCon™



ISO GROUP M
STAINLESS STEEL 28 HRC



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-I	7	1/4	0.25	2-1/2	3/8		InoxaCon™
S-FT7-312	7	5/16	0.312	2-1/2	3/8		Uncoated
S-FT7-312-I	7	5/16	0.312	2-1/2	3/8		InoxaCon™
S-FT7-375	7	3/8	0.375	2-1/2	1/2		Uncoated
S-FT7-375-I	7	3/8	0.375	2-1/2	1/2		InoxaCon™
S-FT7-500	7	1/2	0.5	3	5/8		Uncoated
S-FT7-500-I	7	1/2	0.5	3	5/8		InoxaCon™
S-FT7-625	7	5/8	0.625	3-1/2	3/4		Uncoated
S-FT7-625-I	7	5/8	0.625	3-1/2	3/4		InoxaCon™
S-FT7-750	7	3/4	0.75	4	3/4		Uncoated
S-FT7-750-I	7	3/4	0.75	4	3/4		InoxaCon™
S-FT7-1000	7	1	1	4	3/4		Uncoated
S-FT7-1000-I	7	1	1	4	3/4		InoxaCon™

ISO GROUP M

STAINLESS STEEL 28 HRC

I
INOXACon™

7
FLUTE

Long Length



Part Number	# of Flutes	Shank Diameter		OAL	Flute Length	Radius	Coating
		Inch	Decimal				
L-FT7-187	7	3/16	0.1875	2	1		Uncoated
L-FT7-187-I	7	3/16	0.1875	2	1		InoxaCon™
L-FT7-250	7	1/4	0.25	2-1/2	1-1/4		Uncoated
L-FT7-250-I	7	1/4	0.25	2-1/2	1-1/4		InoxaCon™
L-FT7-312	7	5/16	0.312	2-1/2	1-1/4		Uncoated
L-FT7-312-I	7	5/16	0.312	2-1/2	1-1/4		InoxaCon™
L-FT7-375	7	3/8	0.375	2-1/2	1-1/4		Uncoated
L-FT7-375-I	7	3/8	0.375	2-1/2	1-1/4		InoxaCon™
L-FT7-500	7	1/2	0.5	3	1-1/2		Uncoated
L-FT7-500-I	7	1/2	0.5	3	1-1/2		InoxaCon™
L-FT7-625	7	5/8	0.625	3-1/2	1-3/4		Uncoated
L-FT7-625-I	7	5/8	0.625	3-1/2	1-3/4		InoxaCon™
L-FT7-750	7	3/4	0.75	4	2		Uncoated
L-FT7-750-I	7	3/4	0.75	4	2		InoxaCon™
L-FT7-1000	7	1	1	4	2		Uncoated
L-FT7-1000-I	7	1	1	4	2		InoxaCon™

ISO GROUP M
STAINLESS STEEL 28 HRC



Radius Tool

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-I-010	7	3/16	0.1875	1-1/2	5/8	0.01	InoxaCon™
R-FT7-250-020	7	1/4	0.250	2-1/2	3/4	0.02	Uncoated
R-FT7-250-I-020	7	1/4	0.250	2-1/2	3/4	0.02	InoxaCon™
R-FT7-312-020	7	5/16	0.312	2-1/2	3/4	0.02	Uncoated
R-FT7-312-I-020	7	5/16	0.312	2-1/2	3/4	0.02	InoxaCon™
R-FT7-375-030	7	3/8	0.375	2-1/2	7/8	0.03	Unocated
R-FT7-375-I-030	7	3/8	0.375	2-1/2	7/8	0.03	InoxaCon™
R-FT7-500-030	7	1/2	0.500	3	1-1/4	0.03	Uncoated
R-FT7-500-I-030	7	1/2	0.500	3	1-1/4	0.03	InoxaCon™
R-FT7-500-060	7	1/2	0.500	3	1-1/4	0.06	Uncoated
R-FT7-500-I-060	7	1/2	0.500	3	1-1/4	0.06	InoxaCon™
R-FT7-625-030	7	5/8	0.625	3-1/2	1-1/4	0.03	Uncoated
R-FT7-625-I-030	7	5/8	0.625	3-1/2	1-1/4	0.03	InoxaCon™
R-FT7-625-060	7	5/8	0.625	3-1/2	1-1/4	0.06	Uncoated
R-FT7-625-I-060	7	5/8	0.625	3-1/2	1-1/4	0.06	InoxaCon™
R-FT7-750-030	7	3/4	0.750	4	1-1/2	0.03	Uncoated
R-FT7-750-I-030	7	3/4	0.750	4	1-1/2	0.03	InoxaCon™
R-FT7-750-060	7	3/4	0.750	4	1-1/2	0.06	Uncoated
R-FT7-750-I-060	7	3/4	0.750	4	1-1/2	0.06	InoxaCon™
R-FT7-1000-030	7	1	1	4	1-1/2	0.03	Uncoated
R-FT7-1000-I-030	7	1	1	4	1-1/2	0.03	InoxaCon™
R-FT7-1000-060	7	1	1	4	1-1/2	0.06	Uncoated
R-FT7-1000-I-060	7	1	1	4	1-1/2	0.06	InoxaCon™

ISO GROUP M

STAINLESS STEEL 28 HRC



BENEFITS TO 7 FLUTE

**FINER FINISH
REDUCED CHATTER
HANDLES HIGHER FEED RATES
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FACTooling

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