

224 SERIES



Advanced Geometry; Wiper Flatt, E-cut Polish and Controlled Land, will Provide Better Chip Evacuation and a Superior Part Finish

2 Flute Endmill

- 45° Helix
- Primary and Secondary

Available Upon Request:

- Add Flats
- Radii
- Whistle Notch
- Firm Hold Shank

5 Exxtral Carbon® 3-4 times tool life compared to Z-Power.

N1	Wrought Aluminum Alloys
N2	Low-Silicon Aluminum Alloys Si <12.2% - 6061, 7075

Slotting

	Milling SFM (Vc)		Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
	Uncoated Min-Max	Coated Min-Max	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1500-6560	1400-6550	.001	.002	.002	.002	.003	.004	.005	.006	.007	.010	N/A	N/A	1xD
N2	1500-4920	1400-6550	.001	.001	.002	.002	.002	.003	.003	.004	.006	.007	N/A	N/A	1xD

Heavy Peripheral

	Milling SFM (Vc)		Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
	Uncoated Min-Max	Coated Min-Max	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1500-6560	1400-6550	.001	.002	.003	.003	.004	.005	.006	.007	.009	.012	1-2xD	.4-.6xD	N/A
N2	1500-4920	1400-6550	.001	.001	.002	.002	.003	.003	.004	.005	.006	.006	1-2xD	.4-.6xD	N/A

Light Peripheral

	Milling SFM (Vc)		Chipload Per Tooth Recommendations (CPT)										Profiling Radial		Slotting Axial
	Uncoated Min-Max	Coated Min-Max	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
N1	1500-6560	1400-6550	.001	.001	.002	.002	.003	.003	.004	.004	.006	.009	1xD	.05xD	N/A
N2	1500-4920	1400-6550	.001	.001	.001	.002	.002	.002	.003	.004	.004	.006	1xD	.05xD	N/A