

423 SERIES



Fine Pitch Rougher - Ideal for Nickel Based Material. Featured with Standard Corner Radius.

4 Flute

- 20° Helix

Available Upon Request:

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



Varianta® Supral Provides a low coefficient of friction, reducing tool wear and resulting in a longer tool life. Ideal for materials below 45Rc.

P1	Low-Carbon Steel - 1000 Series (>25 HRc)
P2	Low-Carbon Steel - 1000 Series (<25 HRc)
P3	Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)
P4	Alloy Tool Steels - 1300, 2000, 3000 (36-48 HRc)
P5	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (≤35 HRc)
M1	Austenitic Stainless Steel - Inox, 200 Series, 300 Series
M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
M3	Duplex Steel (Austenitic & Ferritic) - 323, 329, F55, 2205
K1	Gray Cast Iron
K2	Ductile Iron (<28 HRc)
K3	Ductile Iron (<38 HRc)
S1	Iron-Based, Heat-Resistant Alloys - Incoloy 800-802, A-286, N-155
S4	Titanium Alloys - Commercially Pure, 6Al-AV, ASTM 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)
H1	Hardened Tool Steels - H10, H11, H13, D2, D3, 4320, P20 (≤48 HRc)

	SFM (Vc)		Chipload Per Tooth Recommendations (CPT)						Profiling Radial		Slotting Axial
	Coated Min-Max	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	490-660	.002	.002	.002	.003	.003	.003	.004	1xD	.5xD	.5xD
P2	490-660	.002	.002	.002	.003	.003	.003	.004	1xD	.5xD	.5xD
P3	460-620	.002	.002	.002	.002	.003	.003	.004	1xD	.4xD	.5xD
P4	390-520	.001	.002	.002	.002	.002	.003	.003	1xD	.3xD	.4xD
P5	200-330	.001	.001	.002	.002	.002	.002	.003	1xD	.4xD	.5xD
M1	300-380	.001	.001	.002	.002	.003	.003	.003	1xD	.4xD	.5xD
M2	200-260	.001	.001	.002	.002	.002	.003	.003	1xD	.4xD	.5xD
M3	200-230	.001	.001	.002	.002	.002	.002	.002	1xD	.5xD	.5xD
K1	390-490	.002	.002	.002	.003	.003	.003	.004	1xD	.4xD	.5xD
K2	360-460	.001	.001	.002	.003	.003	.003	.003	1xD	.4xD	.5xD
K3	360-430	.001	.001	.002	.002	.002	.002	.003	1xD	.4xD	.5xD
S1	160-300	.001	.001	.002	.002	.002	.003	.003	1xD	.4xD	.5xD
S4	200-260	.001	.001	.002	.002	.002	.002	.003	1xD	.4xD	.5xD
H1	260-460	.001	.001	.002	.002	.002	.003	.003	1xD	.4xD	.5xD