

# 430 SERIES



## Medium Pitch Negative Rake Rougher - Ideal for a Titanium and Hard Materials. Featured with Standard Corner Radius for Added Strength.

### 4-6 Flute Rougher

- Negative Rake Angle
- Radii available: .030, .040, .050

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

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)						Profiling Radial		Slotting Axial
		Coated Min-Max	1/4"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC
P3	380-530	.001	.002	.003	.003	.004	.004	1xD	.5xD	.75xD
P4	370-500	.001	.002	.002	.003	.003	.004	1xD	.3xD	.75xD
P5	200-320	.001	.002	.002	.003	.003	.003	1xD	.5xD	.75xD
P6	160-250	.001	.001	.002	.002	.002	.003	1xD	.3xD	.3xD
M1	260-330	.001	.002	.003	.003	.004	.004	1xD	.5xD	.75xD
M2	200-260	.001	.002	.002	.003	.003	.003	1xD	.5xD	.75xD
M3	200-260	.001	.001	.002	.002	.002	.003	1xD	.5xD	.75xD
K1	390-520	.002	.003	.003	.004	.004	.005	1xD	.5xD	1xD
K2	360-460	.001	.002	.003	.003	.004	.004	1xD	.5xD	1xD
K3	330-430	.001	.002	.002	.003	.003	.003	1xD	.5xD	1xD
S1	160-300	.001	.002	.003	.003	.004	.004	1xD	.3xD	.75xD
S2	70-130	.001	.001	.001	.002	.002	.002	1xD	.3xD	.3xD
S4	150-210	.001	.002	.002	.002	.003	.003	1xD	.4xD	.75xD
H1	260-460	.001	.002	.002	.003	.003	.004	1xD	.3xD	.3xD
H2	230-390	.001	.001	.002	.002	.002	.003	1xD	.2xD	.2xD
H3	200-300	.001	.001	.001	.002	.002	.002	1xD	.2xD	.2xD