

# 453 SERIES



Adapted from the 451 Series, the 453 Features an Advance Chipbreaker Design Which Provided Less Machine Load and Better Chip Control

## 4 Flute Endmill Chip Breaker

- Variable Helix

### Available Upon Request:

- Add Flats
- Radii
- Coolant Holes
- 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)		
P6	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 HRc)	S2	Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 (≤48hRc)
M1	Austenitic Stainless Steel - Inox, 200 Series, 300 Series	S4	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2SN-4Zr-2Mo (≤48 HRc)
M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)		
M3	Duplex Steel (Austenitic & Ferritic) - 323, 329, F55, 2205		

### Slotting

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)							Profiling Radial		Slotting Axial
		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	400	0.001	0.001	0.002	0.002	0.003	0.003	0.004	N/A	N/A	.6-1.25xD
P2	400	0.001	0.001	0.002	0.002	0.003	0.003	0.004	N/A	N/A	.6-1.25xD
P3	400	0.001	0.001	0.001	0.002	0.002	0.003	0.004	N/A	N/A	.6-1.25xD
P4	200	0.001	0.001	0.001	0.001	0.002	0.002	0.003	N/A	N/A	.6-1.25xD
P5	300	0.001	0.001	0.002	0.002	0.003	0.003	0.005	N/A	N/A	.6-1.25xD
P6	300	0.001	0.001	0.002	0.002	0.003	0.003	0.005	N/A	N/A	.6-1.25xD
M1	225	0.001	0.001	0.001	0.002	0.002	0.003	0.004	N/A	N/A	.6-1.25xD
M2	225	0.001	0.001	0.001	0.002	0.002	0.003	0.004	N/A	N/A	.6-1.25xD
M3	130-225	0.001	0.001	0.001	0.001	0.002	0.002	0.003	N/A	N/A	.6-1.25xD
K1	400-450	0.002	0.002	0.002	0.003	0.004	0.005	0.007	N/A	N/A	.6-1.25xD
K2	275	0.001	0.001	0.001	0.002	0.002	0.003	0.004	N/A	N/A	.6-1.25xD
K3	275	0.001	0.001	0.001	0.002	0.002	0.003	0.004	N/A	N/A	.6-1.25xD
S1	90-175	0.001	0.001	0.001	0.002	0.002	0.002	0.003	N/A	N/A	.6-1.25xD
S2	90-175	0.001	0.001	0.001	0.002	0.002	0.002	0.003	N/A	N/A	.6-1.25xD
S4	150-225	0.001	0.001	0.001	0.002	0.002	0.003	0.003	N/A	N/A	.6-1.25xD

### Heavy Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)							Profiling Radial		Slotting Axial
		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	400	0.001	0.002	0.002	0.003	0.003	0.004	0.006	.75-1.5xD	.25-.4xD	N/A
P2	400	0.001	0.002	0.002	0.003	0.003	0.004	0.006	.75-1.5xD	.25-.4xD	N/A
P3	400	0.001	0.001	0.002	0.003	0.003	0.004	0.005	.75-1.5xD	.25-.4xD	N/A
P4	200	0.001	0.001	0.001	0.002	0.002	0.003	0.004	.75-1.5xD	.25-.4xD	N/A
P5	300	0.001	0.001	0.002	0.003	0.003	0.004	0.006	.75-1.5xD	.25-.4xD	N/A
P6	300	0.001	0.001	0.002	0.003	0.003	0.004	0.006	.75-1.5xD	.25-.4xD	N/A
M1	225	0.001	0.001	0.002	0.002	0.003	0.004	0.005	.75-1.5xD	.25-.4xD	N/A
M2	225	0.001	0.001	0.002	0.002	0.003	0.004	0.005	.75-1.5xD	.25-.4xD	N/A
M3	130-225	0.001	0.001	0.001	0.002	0.002	0.003	0.004	.75-1.5xD	.25-.4xD	N/A
K1	400-450	0.002	0.003	0.003	0.004	0.006	0.007	0.009	.75-1.5xD	.25-.4xD	N/A
K2	275	0.001	0.001	0.002	0.003	0.003	0.004	0.005	.75-1.5xD	.25-.4xD	N/A
K3	275	0.001	0.001	0.002	0.003	0.003	0.004	0.005	.75-1.5xD	.25-.4xD	N/A
S1	90-175	0.001	0.001	0.002	0.002	0.003	0.003	0.004	.75-1.5xD	.25-.4xD	N/A
S2	90-175	0.001	0.001	0.002	0.002	0.003	0.003	0.004	.75-1.5xD	.25-.4xD	N/A
S4	150-225	0.001	0.001	0.002	0.002	0.003	0.003	0.005	.75-1.5xD	.25-.4xD	N/A

### Light Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)							Profiling Radial		Slotting Axial
		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	400	0.001	0.001	0.001	0.002	0.002	0.003	0.003	1xD	.05xD	N/A
P2	400	0.001	0.001	0.001	0.002	0.002	0.003	0.003	1xD	.05xD	N/A
P3	400	0.001	0.001	0.001	0.002	0.002	0.002	0.003	1xD	.05xD	N/A
P4	200	0.001	0.001	0.001	0.001	0.001	0.002	0.002	1xD	.05xD	N/A
P5	300	0.001	0.001	0.001	0.002	0.002	0.003	0.004	1xD	.05xD	N/A
P6	300	0.001	0.001	0.001	0.002	0.002	0.003	0.004	1xD	.05xD	N/A
M1	225	0.001	0.001	0.001	0.001	0.001	0.002	0.003	1xD	.05xD	N/A
M2	225	0.001	0.001	0.001	0.001	0.001	0.002	0.003	1xD	.05xD	N/A
M3	130-225	0.001	0.001	0.001	0.001	0.001	0.002	0.003	1xD	.05xD	N/A
K1	400-450	0.002	0.002	0.003	0.004	0.005	0.006	0.008	1xD	.05xD	N/A
K2	275	0.001	0.001	0.002	0.002	0.003	0.003	0.004	1xD	.05xD	N/A
K3	275	0.001	0.001	0.002	0.002	0.003	0.003	0.004	1xD	.05xD	N/A
S1	90-175	0.001	0.001	0.001	0.001	0.001	0.002	0.003	1xD	.05xD	N/A
S2	90-175	0.001	0.001	0.001	0.001	0.001	0.002	0.003	1xD	.05xD	N/A
S4	150-225	0.001	0.001	0.001	0.001	0.002	0.002	0.003	1xD	.05xD	N/A