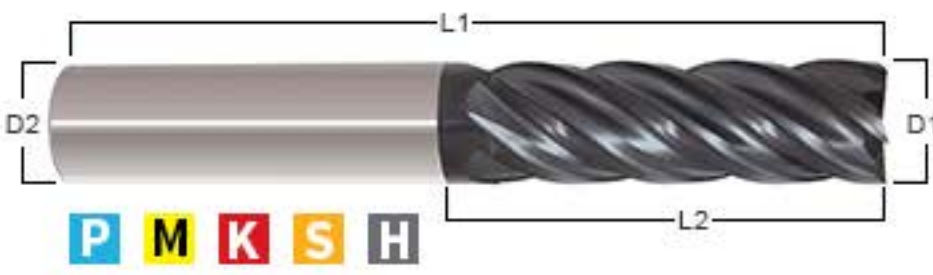


# 538 SERIES

## Variable Indexed and Special Core Design; Provides Chatter Free Machining Along with Maximum Metal Removal Rates



### 5 Flute Variable Endmill

- Primary and Secondary

#### 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)	S2	Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 (≤48hRc)
P6	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 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
		3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC
P1	490-660	.001	.002	.002	.003	.003	.004	.004	.005	1.25xD	.5xD	1xD
P2	460-620	.001	.002	.002	.003	.003	.004	.004	.005	1.25xD	.5xD	1xD
P3	390-520	.001	.002	.002	.002	.003	.003	.004	.004	1.25xD	.5xD	1xD
P4	300-490	.001	.001	.002	.002	.003	.003	.003	.003	1.25xD	.5xD	1xD
P5	200-330	.001	.001	.002	.002	.002	.003	.003	.004	1.25xD	.5xD	1xD
P6	160-250	.001	.001	.001	.001	.002	.002	.003	.003	1.25xD	.5xD	1xD
M1	300-380	.001	.002	.002	.002	.003	.003	.004	.004	1.25xD	.5xD	1xD
M2	200-260	.001	.001	.002	.002	.002	.003	.003	.004	1.25xD	.5xD	1xD
M3	200-230	.001	.001	.001	.001	.002	.002	.003	.003	1.25xD	.5xD	1xD
K1	390-490	.001	.002	.003	.003	.003	.004	.004	.005	1.25xD	.5xD	1xD
K2	360-460	.001	.002	.002	.002	.003	.003	.004	.005	1.25xD	.5xD	1xD
K3	360-430	.001	.002	.002	.002	.002	.003	.003	.004	1.25xD	.5xD	1xD
S1	160-300	.001	.002	.002	.003	.003	.003	.004	.005	1.25xD	.5xD	.4xD
S2	80-130	.001	.001	.001	.002	.002	.002	.002	.002	1.25xD	.5xD	.4xD
S4	160-200	.001	.001	.001	.002	.002	.003	.003	.003	1.25xD	.5xD	1xD
H1	260-460	.001	.001	.002	.002	.002	.003	.003	.004	1.25xD	.5xD	.8xD