

740 SERIES



P M K S H

Variable Indexed Design Provides Chatter Free Machining with the Highest Requirements for Surface Finish. Center Cutting.

7 Flute Endmill

- Variable Helix
- Primary and Secondary

Available Upon Request:

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



Sistral® Its nanostructure composition provides both high heat and oxidation resistance. Ideal for dry and high-speed cutting applications of materials below 54Rc.

P1	Low-Carbon Steel - 1000 Series (>25 HRc)	M1	Austenitic Stainless Steel - Inox, 200 Series, 300 Series
P2	Low-Carbon Steel - 1000 Series (<25 HRc)	M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
P3	Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)	M3	Duplex Steel (Austenitic & Ferritic) - 323, 329, F55, 2205
P4	Alloy Tool Steels - 1300, 2000, 3000 (36-48 HRc)	K1	Gray Cast Iron
P5	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (≤35 HRc)	K2	Ductile Iron (<28 HRc)
P6	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 HRc)	K3	Ductile Iron (<38 HRc)
		S4	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)

Slotting

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)						Profiling Radial		Slotting Axial	
		3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC	RDC
P1	300-450	.001	.001	.002	.002	.003	.004	N/A	N/A	.5xD	1xD
P2	300-450	.001	.001	.002	.002	.003	.004	N/A	N/A	.5xD	1xD
P3	300-400	.001	.001	.002	.002	.003	.004	N/A	N/A	.5xD	1xD
P4	275-400	.001	.001	.001	.002	.002	.003	N/A	N/A	.5xD	1xD
P5	300-450	.001	.001	.001	.002	.003	.004	N/A	N/A	.5xD	1xD
P6	300-450	.001	.001	.001	.002	.003	.004	N/A	N/A	.5xD	1xD
M1	250-400	.001	.001	.001	.002	.002	.003	N/A	N/A	.5xD	1xD
M2	250-400	.001	.001	.001	.002	.002	.003	N/A	N/A	.5xD	1xD
M3	250-360	.001	.001	.001	.002	.002	.003	N/A	N/A	.5xD	1xD
K1	300-450	.001	.001	.002	.002	.003	.003	N/A	N/A	.5xD	1xD
K2	275-400	.001	.001	.002	.002	.003	.003	N/A	N/A	.5xD	1xD
K3	250-350	.001	.001	.002	.002	.003	.003	N/A	N/A	.5xD	1xD
S4	250-330	.001	.001	.001	.001	.002	.002	N/A	N/A	.5xD	1xD

Heavy Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)						Profiling Radial		Slotting Axial	
		3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC	RDC
P1	300-450	.002	.002	.002	.003	.004	.005	1-1.25xD	.25-.45xD	N/A	N/A
P2	300-450	.002	.002	.002	.003	.003	.005	1-1.25xD	.25-.45xD	N/A	N/A
P3	300-400	.002	.002	.002	.003	.003	.005	1-1.25xD	.25-.45xD	N/A	N/A
P4	275-400	.001	.001	.002	.002	.003	.004	1-1.25xD	.25-.45xD	N/A	N/A
P5	300-450	.002	.002	.002	.003	.004	.005	1-1.25xD	.25-.45xD	N/A	N/A
P6	300-450	.002	.002	.002	.003	.004	.005	1-1.25xD	.25-.45xD	N/A	N/A
M1	250-400	.002	.002	.002	.003	.003	.005	1-1.25xD	.25-.45xD	N/A	N/A
M2	250-400	.002	.002	.002	.003	.003	.005	1-1.25xD	.25-.45xD	N/A	N/A
M3	250-360	.001	.001	.002	.002	.003	.004	1-1.25xD	.25-.45xD	N/A	N/A
K1	300-450	.002	.002	.002	.003	.003	.005	1-1.25xD	.25-.45xD	N/A	N/A
K2	275-400	.001	.001	.002	.002	.003	.004	1-1.25xD	.25-.45xD	N/A	N/A
K3	250-350	.001	.001	.002	.002	.003	.004	1-1.25xD	.25-.45xD	N/A	N/A
S4	250-330	.001	.001	.002	.002	.003	.003	1-1.25xD	.25-.45xD	N/A	N/A

Light Peripheral

	SFM (Vc)	Chipload Per Tooth Recommendations (CPT)						Profiling Radial		Slotting Axial	
		3/8"	7/16"	1/2"	5/8"	3/4"	1"	ADC	RDC	ADC	RDC
P1	300-450	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
P2	300-450	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
P3	300-400	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
P4	275-400	.001	.002	.002	.003	.003	.004	1-2xD	.015xD	N/A	N/A
P5	300-450	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
P6	300-450	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
M1	250-400	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
M2	250-400	.002	.002	.002	.003	.004	.005	1-2xD	.015xD	N/A	N/A
M3	250-360	.001	.001	.002	.002	.003	.004	1-2xD	.015xD	N/A	N/A
K1	300-450	.002	.002	.002	.003	.003	.005	1-2xD	.015xD	N/A	N/A
K2	275-400	.001	.001	.002	.002	.003	.004	1-2xD	.015xD	N/A	N/A
K3	250-350	.001	.001	.002	.002	.003	.004	1-2xD	.015xD	N/A	N/A
S4	250-330	.001	.001	.001	.002	.003	.003	1-2xD	.015xD	N/A	N/A