



Diameters:
6mm to 25mm

Cutting Edge Length:
12mm to 50mm

Overall Length:
57mm to 130mm

Number of Flutes:
3

Radius:
0.20mm

Helix Angle:
39° - 41°

Grade:
IN05S



COOLANT HOLES FOR MACHINING ALUMINUM

Ingersoll introduces the 46DRQ - 3 flute, solid carbide endmills with different helix for machining aluminum. The new endmills, designed for both roughing and finishing operations, feature excellent chatter dampening ability and coolant hole directed to each flute. They should be used with cooling fluid for full slot machining of aluminum up to 2XD.

Ingersoll's new StediRound endmills for machining aluminum are an excellent solution for low power machines with ISO40 or BT40 adaptations, improving their material removal rate and eliminates vibration. They maximize stock removal rate and reduce cycle time in most milling operations. Their unique ground and polished geometry provides excellent bottom and side surface finish with no mismatch.

The new 46DRQ StediRound solid carbide endmills are available in a diameter range of 6 to 25 mm with corner radii of 0.20 mm and milling depth to endmill diameter ratio of 2XD. Each tool diameter is available with 3xD and 5xD neck relief.

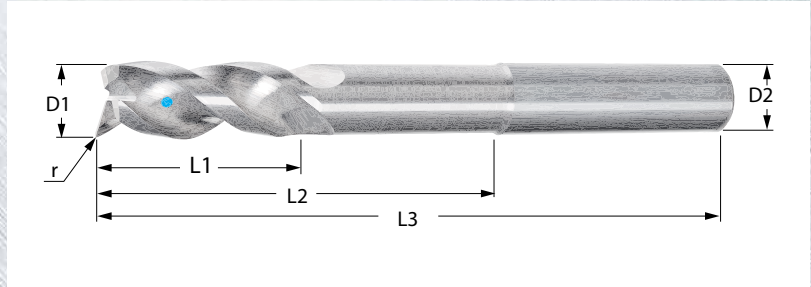
Features

- 3-flute, solid carbide endmills with different helix and coolant holes directed to each individual flute, for machining aluminum.
- Designed for both roughing and finishing operations, feature excellent chatter dampening and chip evacuation ability.
- Maximize stock removal rate and reduce cycle time in most milling operations.

**NEW
PRODUCT
ANNOUNCEMENT
•2014•**

46DRQ SERIES

3 FLUTE, SOLID CARBIDE ENDMILLS WITH SIDE COOLANT HOLES FOR MACHINING ALUMINUM



Designation	Dimension					Shank	# of Flutes	Corner	Ha°	Grade
	D1	D2	L1	L2	L3					
46D00612T7RQ057	6mm	6mm	12mm	18mm	57mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D00612T7RQ065	6mm	6mm	12mm	30mm	65mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D00816T0RQ063	8mm	8mm	16mm	24mm	63mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D00816T0RQ079	8mm	8mm	16mm	40mm	79mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01020T1RQ072	10mm	10mm	20mm	30mm	72mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01020T1RQ100	10mm	10mm	20mm	50mm	100mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01224T2RQ083	12mm	12mm	24mm	36mm	83mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01224T2RQ100	12mm	12mm	24mm	60mm	100mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01692T3RQ092	16mm	16mm	32mm	48mm	92mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D01612T3RQ128	16mm	16mm	32mm	80mm	128mm	Cylindrical	3	0.20mm	39-41°	IN05S
46D02513T5RQ130	25mm	25mm	50mm	75mm	130mm	Cylindrical	3	0.20mm	39-41°	IN05S

OPERATING GUIDELINES

Workpiece Material	Cutting speed vc in m/min		Feed rate per tooth fz in mm		Cutting Depth ap recomm. for End mill mm	Cutting Width ae % Recommended	
	End mill		End mill				
DC mm	Full slot	Shoulder	Full slot	Shoulder			
Aluminum N	2 - 6	250 - 800	250 - 800	0,02 - 0,04	0,03 - 0,08	0,3 x D	30%
	8 - 12	800 - 1000	1000 - 1500	0,09 - 0,12	0,1 - 0,18	0,3 x D	30%
	16 - 25	800 - 1000	1500 - 2000	0,15 - 0,18	0,18 - 0,25	0,3 x D	30%