






TECHNICAL INFORMATION

Material	Brinnell Hardness	SFM	Feed per Tooth	Grade	IN2505	IN2504	IN2540	IN2530	IN2035	IN7035	IN10K	Coolant
Aluminum	6061-T6, 7075-T6	1300-1650	.0075 - .047								1	Yes
Cast Iron	Gray	190-220	360 - 690		1			2				No
	Nodular	140-200	390 - 690		1			2				
Steel	Low Carbon 1018-8620	85-175	721 - 985		1			2				No
	High Carbon F-6180	175 - 225	490 - 820		1			2				
	Alloyed Steel 4140	275-325	325 - 590		1		3	2				
	Tool Steel P20-H13	200-320	275 - 775		1		3	2				
	Hardened Tool Steels	320-630	250 - 450		2	1	3					
Stainless Steel	300 Series, 304, 316	-	360 - 600		4			3	2	1		Optional
	400 Series 15-5 PH, 17-4 PH	-	360 - 720		4			3	2	1		
	13-8 PH	-	200 - 600					3	2	1		
Nickel Alloys	Inconel, Hastelloy, Nimonic, Monel	-	80 - 150					3	2	1		YES
Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	-	115 - 195					3	2	1		YES

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.

FACEMILL HARDWARE

Cutter Number	Insert Series					
		Screw	Driver	Driver Bit	Retention Bolt	(Optional) Coolant Bolt
1A7E-20R01	RJLT08	SM30-065-00	DS-T09W	-	SD06-46	SD-06-89
1A7G-20R01	RJLT10	SM35-087-70	DS-A00T	BLD T15/S7	SD06-46	SD-06-89
1A7H-20R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD06-46	SD-06-89
1A7H-25R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD06-46	SD-06-89
1A7H-30R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD08-46	SD-08-92
1A7H-40R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD-12-82	SD-12-99
1A7H-50R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD-12-82	-
1A7H-60R01	RJLT12	SM40-093-20	DS-A00T	BLD T15/S7	SD-12-82	-
1A7H-20RE50	RJLT13	SM40-093-20	DS-A00T	BLD T15/S7	SD06-46	SD-06-89
1A7H-30RE50	RJLT13	SM40-093-20	DS-A00T	BLD T15/S7	SD08-46	SD-08-92
1A7H-40RE50	RJLT13	SM40-093-20	DS-A00T	BLD T15/S7	SD08-46	SD-08-92
1A7K-20R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD06-46	SD-06-89
1A7K-25R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD06-46	SD-06-89
1A7K-30R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD08-46	SD-08-92
1A7K-40R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD-12-82	SD-12-99
1A7K-50R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD-12-82	-
1A7K-60R01	RJLT16	SM50-113-20	DS-A00T	BLD T20/S7	SD-12-82	-
1A7M-30RE75	RJLT19	SM60-135-R0	DS-A00T	BLD T25/S7	SD08-46	SD-08-92
1A7M-40RE75	RJLT19	SM60-135-R0	DS-A00T	BLD T25/S7	SD12-82	SD-12-99
1A7M-60RE75	RJLT19	SM60-135-R0	DS-A00T	BLD T25/S7	SD12-82	-
1A7M-25R01	RJLT20	SM60-135-R0	DS-A00T	BLD T25/S7	SD06-46	SD-06-89
1A7M-30R01	RJLT20	SM60-135-R0	DS-A00T	BLD T25/S7	SD08-46	SD-06-89
1A7M-40R01	RJLT20	SM60-135-R0	DS-A00T	BLD T25/S7	SD-12-82	SD-12-99
1A7M-50R01	RJLT20	SM60-135-R0	DS-A00T	BLD T25/S7	SD-12-82	-
1A7M-60R01	RJLT20	SM60-135-R0	DS-A00T	BLD T25/S7	SD-12-82	-