



 **DATA FLUTE**™

New FeR_x Series

Designed for
Heavy Roughing Applications
in all Ferrous Alloys

FeR_x Variably Indexed Rougher

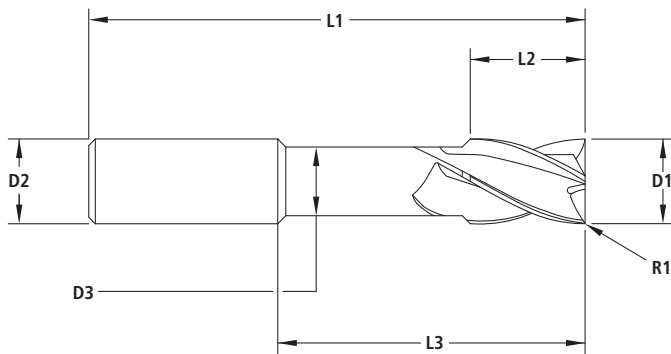


- Tool of Choice in all Ferrous Roughing Applications
- Additional Radii
- Additional Coatings
- Altered LBS Lengths Upon Request
- Freer Cutting and Better Chip and Form Control

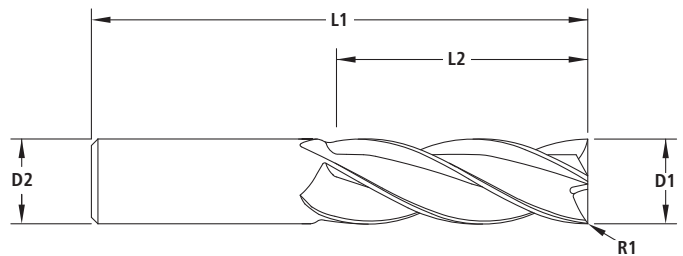
Part Number	Diameter D1	Shank D2	LOC L2	OAL L1	LBS* L3	Radius	Neck Dia. D3	No. of Flutes	Form	C14 EDP	C19 EDP
FeR _x ST40250-020	1/4	1/4	3/8	2		0.020		4	C	44925-14-D	44925-19-D
FeR _x 40250-020	1/4	1/4	3/4	2-1/2		0.020		4	C	44926-14-D	44926-19-D
FeR _x RN 40250-020	1/4	1/4	3/8	4	3/4	0.020	.235	4	B	44928-14-D	44928-19-D
FeR _x ST40375-020	3/8	3/8	1/2	2-1/2		0.020		4	C	44930-14-D	44930-19-D
FeR _x 40375-020	3/8	3/8	1	2-1/2		0.020		4	C	44931-14-D	44931-19-D
FeR _x RN 40375-020	3/8	3/8	1/2	4	1-1/8	0.020	.355	4	B	44932-14-D	44932-19-D
FeR _x ST40500-030	1/2	1/2	5/8	3		0.030		4	C	44933-14-D	44933-19-D
FeR _x 40500-030	1/2	1/2	1-1/4	3		0.030		4	C	44934-14-D	44934-19-D
FeR _x RN 40500-030	1/2	1/2	5/8	6	1-1/2	0.030	.475	4	B	44935-14-D	44935-19-D
FeR _x ST50625-030	5/8	5/8	3/4	3		0.030		5	C	44936-14-D	44936-19-D
FeR _x 50625-030	5/8	5/8	1-5/8	3-1/2		0.030		5	C	44937-14-D	44937-19-D
FeR _x RN 50625-030	5/8	5/8	3/4	6	1-5/8	0.030	0.590	5	B	44938-14-D	44938-19-D
FeR _x ST50750-030	3/4	3/4	1	3		0.030		5	C	44939-14-D	44939-19-D
FeR _x 50750-030	3/4	3/4	1-5/8	4		0.030		5	C	44940-14-D	44940-19-D
FeR _x RN 50750-030	3/4	3/4	1	6	2	0.030	.715	5	B	44941-14-D	44941-19-D
FeR _x ST51000-030	1	1	1-1/4	4		0.030		5	C	44942-14-D	44942-19-D
FeR _x 51000-030	1	1	2	5		0.030		5	C	44943-14-D	44943-19-D
FeR _x RN 51000-030	1	1	1-1/4	7	2-5/8	0.030	0.960	5	B	44944-14-D	44944-19-D

*LBS Length Below Shank

FORM B



FORM C

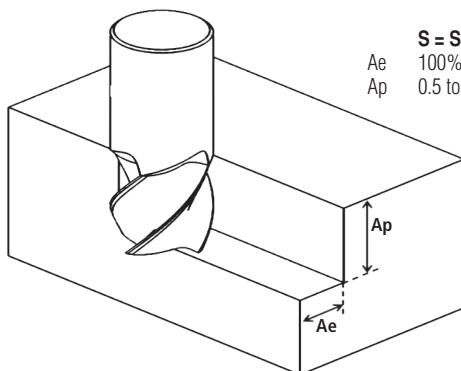


• Coolant Through & Coolant Holes Upon Request.



Feeds and Speeds Chart for FeR_x Rougher

Materials		Carbon Steels	Alloy Steel	Stainless Steel 300 Series	Stainless Steel 400 Series	Precipitation Stainless Steels	Gray Cast Iron	Ductile Cast Iron	High Temp Alloys	Titanium Pure	Titanium Cast/Wrought
Diameter	Description	10XX, 11XX, 12XX, 13XX	40XX, 41XX, 42XX, 43XX, 44XX, 46XX, 86XX, Series	304, 304L, 316, 316L, 312	420, 420F, 416, 440C	15-5PH, 16-6PH, 17-4PH, AM-XX Series	Gray	Ductile	Inconel 625/718, A286, Haynes	Pure	Cast/Wrought 6AL4V, ASTM 1,2,3, Alpha-Beta
		SFM<32Rc SFM>32Rc	200-450 150-300	150-300 80-200	150-300 80-200	200-450 100-250	80-250 90-125	250-450 130-300	120-350 80-140	70-120 40-90	140-220 90-160
1/4"	S	0.0015	0.0014	0.0014	0.0014	0.0013	0.0013	0.0013	0.0010	0.0014	0.0013
	HP	0.0015	0.0014	0.0014	0.0014	0.0013	0.0013	0.0013	0.0010	0.0014	0.0013
	P	0.0017	0.0015	0.0015	0.0015	0.0014	0.0014	0.0014	0.0011	0.0015	0.0014
	LP	0.0021	0.0019	0.0019	0.0019	0.0018	0.0018	0.0018	0.0014	0.0019	0.0018
3/8"	S	0.0024	0.0022	0.0022	0.0022	0.0020	0.0020	0.0020	0.0016	0.0022	0.0020
	HP	0.0024	0.0022	0.0022	0.0022	0.0020	0.0020	0.0020	0.0016	0.0022	0.0020
	P	0.0026	0.0024	0.0024	0.0024	0.0022	0.0022	0.0022	0.0018	0.0024	0.0022
	LP	0.0033	0.0030	0.0030	0.0030	0.0028	0.0028	0.0028	0.0023	0.0030	0.0028
1/2"	S	0.0031	0.0029	0.0029	0.0029	0.0026	0.0026	0.0026	0.0021	0.0029	0.0026
	HP	0.0031	0.0029	0.0029	0.0029	0.0026	0.0026	0.0026	0.0021	0.0029	0.0026
	P	0.0034	0.0031	0.0031	0.0031	0.0029	0.0029	0.0029	0.0023	0.0031	0.0029
	LP	0.0044	0.0040	0.0040	0.0040	0.0037	0.0037	0.0037	0.0030	0.0040	0.0037
5/8"	S	0.0035	0.0032	0.0032	0.0032	0.0029	0.0029	0.0029	0.0022	0.0032	0.0029
	HP	0.0035	0.0032	0.0032	0.0032	0.0029	0.0029	0.0029	0.0022	0.0032	0.0029
	P	0.0038	0.0035	0.0035	0.0035	0.0031	0.0031	0.0031	0.0024	0.0035	0.0031
	LP	0.0049	0.0044	0.0044	0.0044	0.0040	0.0040	0.0040	0.0031	0.0044	0.0040
3/4"	S	0.0042	0.0039	0.0039	0.0039	0.0035	0.0035	0.0035	0.0027	0.0039	0.0035
	HP	0.0042	0.0039	0.0039	0.0039	0.0035	0.0035	0.0035	0.0027	0.0039	0.0035
	P	0.0046	0.0042	0.0042	0.0042	0.0038	0.0038	0.0038	0.0030	0.0042	0.0038
	LP	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0038	0.0054	0.0049
1"	S	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0039	0.0054	0.0049
	HP	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0039	0.0054	0.0049
	P	0.0065	0.0059	0.0059	0.0059	0.0054	0.0054	0.0054	0.0043	0.0059	0.0054
	LP	0.0083	0.0076	0.0076	0.0076	0.0069	0.0069	0.0069	0.0055	0.0076	0.0069

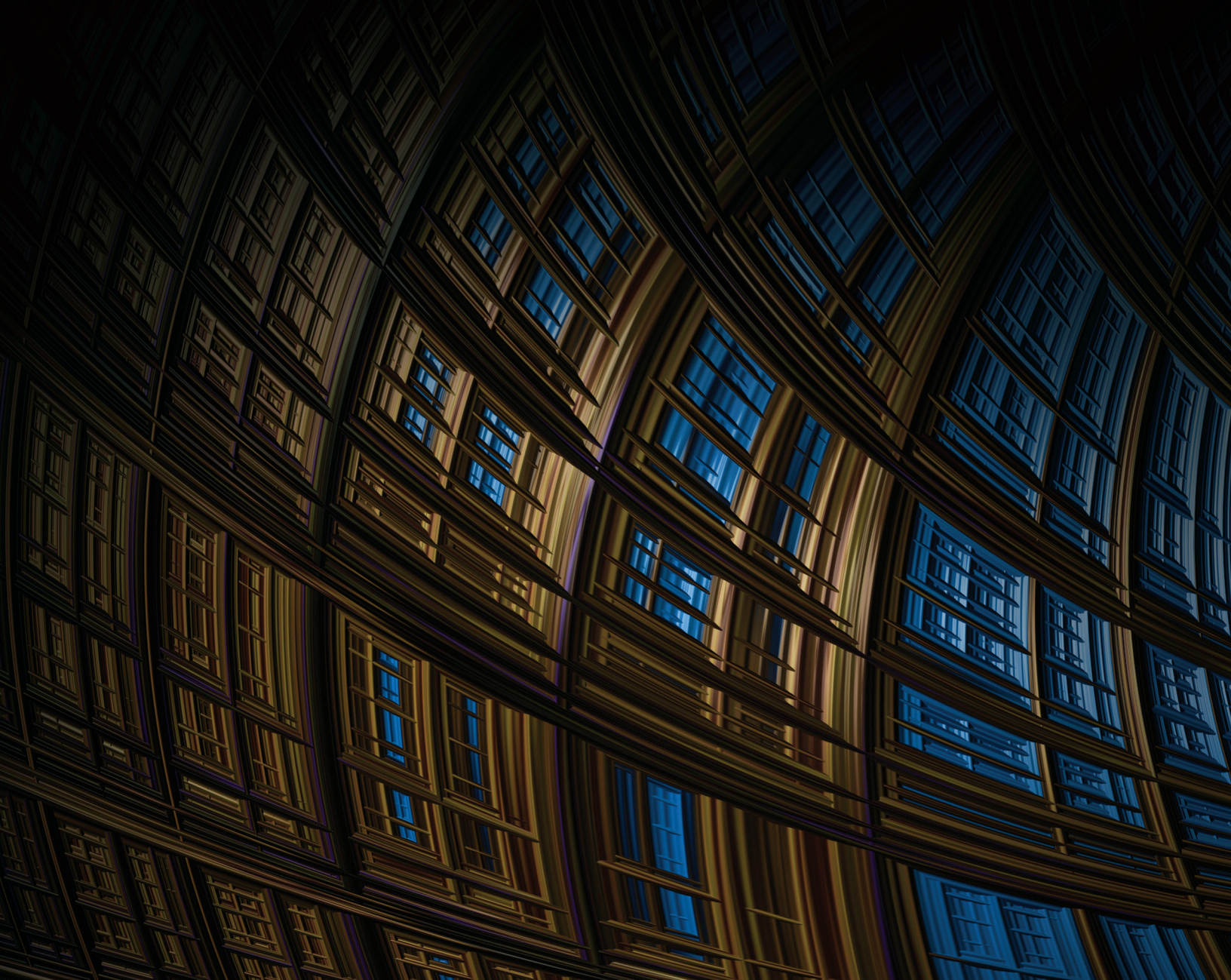


S = SLOTTING
Ae 100% x D
Ap 0.5 to 1.0 x D

HP = HEAVY PERIPHERAL
> 40% x D
0.5 to 1.0 x D

P = PERIPHERAL
25% to 40% x D
1.0 to 1.5 x D

LP = LIGHT PERIPHERAL
5% to 25% x D
2 x D



 **DATA FLUTE**™

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