



## Carbide End Mills

Severance solid micro grain carbide end mills are stocked in four-flute design, and are available in two and three-flute designs to order. Indicate the number of flutes desired at the end of the Tool Number' EM-250-W-3, for example. Experiment within the speed ranges listed at the right to produce the best chip on a given machine, workpiece, depth of cut, etc.

MATERIAL	S.F.P.M.
Cast Iron	75-200
Malleable Iron	75-200
Nickel Chrome	75-250
Stainless Steel	75-250
Carbon Steel	100-250
Nickel	100-250
Monel Metal	100-250
Free Cutting Steel	125-300
Brass Bronze	125-300
Aluminum and Aluminum Alloys	125-375
Copper	125-375
Hard Rubber	150-450
Zinc Alloys	200-400
Fibre	200-400
Plastics	200-500

NOTE: S.F.P.M. = Surface Feet Per Minute

### Standard Spiral

Head Dia.	Cutting Length	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1-1/2"	EM-125-W	36180
3/16"	5/8"	2"	EM-1875-W	36181
1/4"	3/4"	2"	EM-250-W	36182
5/16"	3/4"	2-1/2"	EM-3125-W	36183
3/8"	7/8"	2-1/2"	EM-375-W	36184
1/2"	1"	3"	EM-500-W	36185
5/8"	1-1/4"	3-1/2"	EM-625-W	36186
3/4"	1-1/2"	4"	EM-750-W	36187

### Slow Spiral

Head Dia.	Cutting Length	Overall Length	Severance Tool Name	EDP Order Number
1/8"	3/8"	1-1/2"	EMS-2-W	36188
3/16"	1/2"	1-1/2"	EMS-3-W	36189
1/4"	5/8"	2"	EMS-4-W	36190
5/16"	11/16"	2"	EMS-5-W	36191
3/8"	3/4"	2"	EMS-6-W	36192
1/2"	15/16"	2"	EMS-8-W	36193
5/8"	1-1/8"	2-1/2"	EMS10-W	36194
3/4"	1-1/4"	2-5/8"	EMS-12-W	36195



## Carbide Carbo-Routs™

These solid carbide, multi-tooth routing mills will produce good finishes over a wide range of speeds. Fluting and tooth arrangements are designed to provide fast stock removal on many different materials.

### Plain End

Cutting Dia.	Flute Length	Shank Dia.	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1/8"	1-1/2"	R-1	28685
3/16"	5/8"	1/4"	2"	R-2	28687
1/4"	1-1/4"	1/4"	3"	R-3	28691
3/8"	1-3/8"	3/8"	2-1/2"	R-4	28694
1/2"	1-1/2"	1/2"	3"	R-5	28696

### Drill Style, End Cut

Cutting Dia.	Flute Length	Shank Dia.	Overall Length	Severance Tool Name	EDP Order Number
1/8"	1/2"	1/8"	1-1/2"	R-1-DP	28745
3/16"	1"	1/4"	2"	R-2-DP	28747
1/4"	1-1/4"	1/4"	3"	R-3-DP	28751
3/8"	1-3/8"	3/8"	2-1/2"	R-4-DP	28754
1/2"	1-1/2"	1/2"	3"	R-5-DP	28756