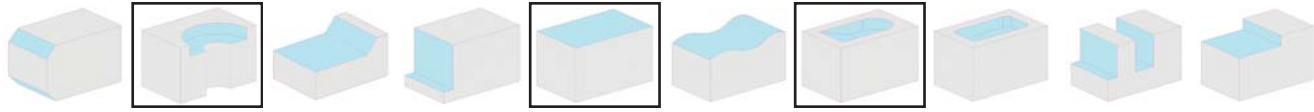


255 Series

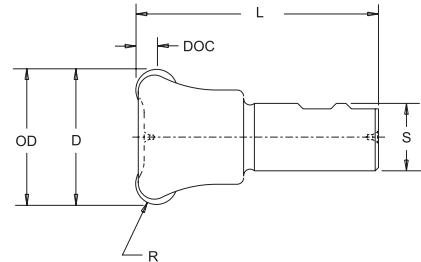
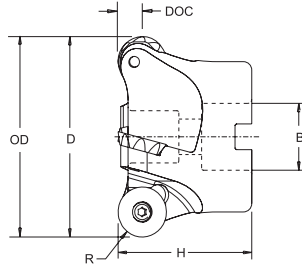
Round 



Face Mill

End Mill

15° Pos Axial
3° Neg Radial
1° Dish



• Ramp Capability Configuration

255 Series - Dimensional Specifications





Face Mills

Product Number	D	OD	B	H	R	DOC	Insert	Teeth	Weight
255F0300ARE6-100R	3.00	3.00	1.00	2.00	.375	.375	RECH-63__	4	3.50
255F0400ARE6-150R	4.00	4.00	1.50	2.00	.375	.375	RECH-63__	5	5.00

End Mills

Product Number	D	OD	S	L	R	DOC	Insert	Teeth	Weight
255E0200ARE6-W075R	2.00	2.00	0.75	4.25	.375	.375	RECH-63__	3	1.50

LEFT HAND cutters also available

Insert I.C. x Thickness				
.750 x .188	RECH-63-10F	RECH-63W520	3605-0001-0023	1557-TX20

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
PH Type Stainless Steel 17-4, 15-5, 13-8	500-1200	.003-.015	RECH-63-10F GR 606jRm	RECH-63W520 GR LTC-14
Austenitic Stainless Steel 302, 304, 316	400-1350	.003-.015	RECH-63-10F GR 586XRm	RECH-63W520 GR LTC-10
Titanium Alloy 3A1-2.5V, 5A16Sn-2Zr-1mo, 6A14V	120-325	.003-.015	RECH-63-10F GR 586XRm	RECH-63-10F GR LTC-10
Carbon Steel 1018, 1020, 1215	600-1500	.005-.020	RECH-63W520 GR 606jRm	RECH-63W520 GR LTC-14
Alloyed Steel 4130, 4340, 6150	400-1200	.005-.020	RECH-63W520 GR 606jRm	RECH-63W520 GR LTC-14
Tool Steel	350-1000	.005-.020	RECH-63W520 GR 606jRm	RECH-63W520 GR LTC-14
Nickel Based K-Monel, Inconel 625, A286	100-650	.003-.015	RECH-63-10F GR 586XRm	RECH-63W520 GR LTC-10
Aluminum 2024, 6061, 7072	900-4000	.003-.015	RECH-63-10F GR LTC-10	RECH-63-10F LTC-10

- Increased face clearance from standard XR series for increased ramp capability
- Multi-purpose positive/negative geometry optimizes horsepower utilization
- Diameter measured at maximum diameter for profile mold programming



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