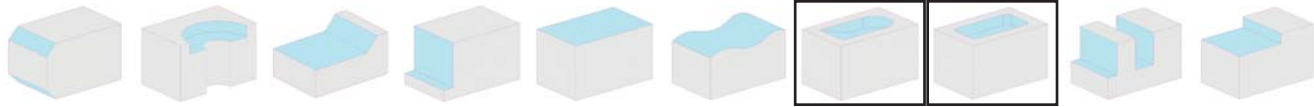
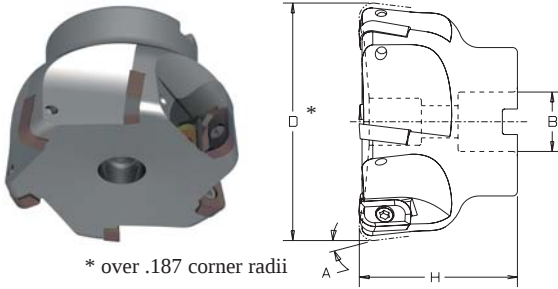


291 Series



7° Axial Neg Radial 7° Back Taper - Face Mill
7° Axial -8°20' Radial 7° Back Taper - End Mill

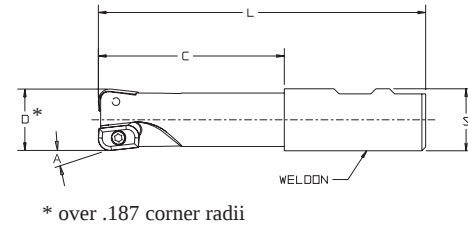


* over .187 corner radii

7° Backdraft • Ramping Capability Configuration



Extended Reach • 7° Backdraft Configuration



* over .187 corner radii



291 Series - Dimensional Specifications

Face Mills

Product Number	D *	B	H	A	Insert	Teeth	Weight
291F0200ACP3-075R	2.00	0.75	2.00	7°	CPEH-32.63-___4W	4	1.50
291F0300ACP3-075R	3.00	0.75	2.00	7°	CPEH-32.63-___4W	6	2.38

End Mills

Product Number	D *	S	C	L	A	Insert	Teeth	Weight
291E0100BCP3-W100R	1.00	1.00	3.00	5.28	7°	CPEH-32.63-___4W	2	1.13
291E0100CCP3-W100R	1.00	1.00	4.00	6.28	7°	CPEH-32.63-___4W	2	1.38
291E0100DCP3-W125R	1.00	1.25	5.00	7.28	7°	CPEH-32.63-___4W	2	1.88
291E0100ECP3-W125R	1.00	1.25	6.00	8.28	7°	CPEH-32.63-___4W	2	2.00

Note: When using a corner radius other than the 12 (CPEH-32.63-12-4W) that the cutter was designed over, use the chart below to determine the correct Dimensional Specifications for your cutter.

291 Series - End Mill and Face Mill *Insert Change* Specifications

Product Series	Cutting Point	Corner Radius	D+	L+	H+	Insert Number
291	2	.031	.046	.011	.011	CPEH-32.63-2-4W
291	4	.062	.037	.009	.009	CPEH-32.63-4-4W
291	6	.094	.027	.007	.007	CPEH-32.63-6-4W
291	8	.125	.018	.005	.005	CPEH-32.63-8-4W
291	12	.188	.000	.000	.000	CPEH-32.63-12-4W

Insert I.C. x Thickness	Insert Pg. 31	Insert Screw	Insert Screw Wrench
.375 x .188	CPEH-32.63-2-4W	3605-0001-0033	1557-TX15
	CPEH-32.63-4-4W		
	CPEH-32.63-6-4W		
	CPEH-32.63-8-4W		
	CPEH-32.63-12-4W		

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Tool Steel, D2, P20	300-700	.002-.006	CPEH-32.63-___4W GR 606jRm	CPEH-32.63-___4W GR LTC-14
Stainless Steel 300 Series	250-600	.002-.006	CPEH-32.63-___4W GR 586XRm	CPEH-32.63-___4W GR LTC-10

- Chip control insert for optimum tool performance
- Large offering of insert corner radii
- Back taper design to allow reach in tight corners
- Extended length tool for long reach applications
- Accepts same insert as 290 series



LOVEJOY Tool Co., Inc. 1-800-843-8376

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