

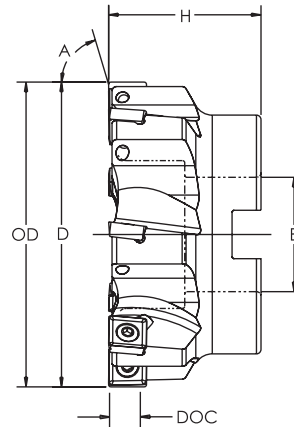
245 Series



Index

Specials

Inserts



7° Pos Axial
Neg Radial
90° Shoulder

• Square shoulder design for close area machining.

General

Cavity Mold

Gray Iron

PCD / CBN

Slotters

Technical
Data

Holders

245 Series Face Mill - Dimensional Specifications

Product Number	D	OD	B	H	A	DOC	Insert	Teeth
245F0200ASP4-075R	2.000	2.00	0.750	1.750	90°	.250	SPEX-432	4
245F0250ASP4-100R	2.500	2.50	1.000	1.750	90°	.250	SPEX-432	5
245F0300ASP4-100R	3.000	3.00	1.000	1.750	90°	.250	SPEX-432	6
245F0400ASP4-150R	4.000	4.00	1.500	2.000	90°	.250	SPEX-432	7

LEFT HAND cutters also available

Spare Parts

Insert I.C. x Thickness			
	Insert Pg. 45	Insert Screw	Insert Screw Wrench
.500 x .188	SPEX-432	3605-0001-0023 Silicon Nitride Screw: SR-16-212	1557-TX20

245 Series Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Low Carbon Steel	400 - 800	.005 - .010	SPEX-432 GR 606jRm	SPEX-432 GR 586XRm
Alloy Steel	350 - 700	.005 - .010	SPEX-432B GR 606jRm	SPEX-432F515 GR LT-5565
Forged Steel, Weldment	350 - 500	.005 - .010	SPEX-432F515 GR LT-5565	SPEX-432B GR 606jRm
Austenitic Stainless	350 - 700	.005 - .010	SPEX-432 GR 586XRm	SPEX-432 GR LTC-10
Aluminum	1000 & up	.005 - .010	SPEX-432 GR 586XRm	SPEX-432 GR LTC-10
Gray Cast Iron	2500 & 500	.005 - .010	SPEX-432W515 GR LTC-1200	SPEX-432FA GR LT-2366
Ductile	500 - 1000	.005 - .010	SPEX-432FA GR LT-2366	SPEX-432 GR 606jRm

- Simple hardware design for minimum cost
- Positive Chip Control insert geometries for free cutting action in many materials
- Improved Horsepower Utilization
- Designed Edge Preparation geometries for a wide range of materials