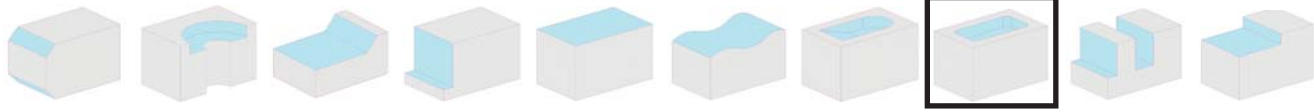


356 Series

Round 



Index

Specials

Inserts

General

Cavity Mold

Gray Iron

PCD / CBN

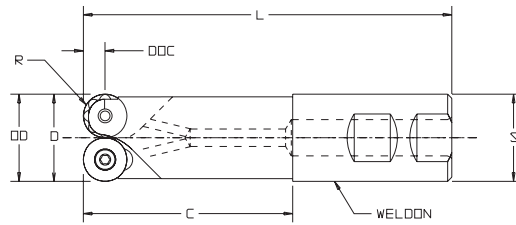
Slotters

Technical Data

HOLDERS



0° Axial 0° Radial







- Ramping and Profiling • Mold and Die Steels
- Light Roughing Applications • Plunge Milling Configuration • End Mills have Thru Coolant

356 Series End Mills - Dimensional Specifications

Product Number	OD	D	S	L	R	DOC	C	Insert	Teeth
356E0100ARC4-W100R	1.00	1.00	1.00	4.78	0.250	0.250	2.50	RSECH-43__ RECH-43__	2
356E0100BRC4-W100R	1.00	1.00	1.00	6.78	0.250	0.250	4.50	RSECH-43__ RECH-43__	2
356E0125BRD5-W125R	1.25	1.25	1.25	5.28	0.312	0.312	3.00	RECH-53__	2
356E0125DRD5-W125R	1.25	1.25	1.25	7.28	0.312	0.312	5.00	RECH-53__	2
356E0150BRD6-W150R	1.50	1.50	1.50	6.19	0.375	0.375	3.50	RECH-63__	2
356E0150DRD6-W150R	1.50	1.50	1.50	8.18	0.375	0.375	5.49	RECH-63__	2

LEFT HAND cutters also available

Insert I.C. x Thickness				
	Insert Pg. 40	Insert Pg. 40	Insert Screw	Insert Screw Wrench
.500 x .188	RSECH-43__	RSECH-43-10F	3605-0001-0033	1557-TX15
.625 x .188	RECH-53__	RECH-53-10F	3605-0001-0023	1557-TX20
.750 x .188	RECH-63__	RECH-63-10F	3605-0001-0023	1557-TX20

NOTE:

RSECH inserts have 4 indexing flats

RECH inserts have 8 indexing flats

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Tool Steel, D2, P20	300-700	.003-.012	RECH-__W520 GR 606jRm RSECH-43__W520 GR 606jRm	RECH-__W520 GR LTC-14 RSECH-43__W520 GR LTC-14
Stainless Steel 300 Series	250-500	.003-.012	RECH-__-10F GR 586XRm RSECH-43__-10F GR 586XRm	RECH-__-10F GR LTC-10 RSECH-43__-10F GR LTC-10
Aluminum	1200-1800	.003-.012	RECH-__-10F GR 586XRm RSECH-43__-10F GR 586XRm	RECH-__-10F GR LTC-10 RSECH-43__-10F GR LTC-10
Steel	400-600	.003-.012	RECH-__W520 GR 606jRm RSECH-43__W520 GR 606jRm	RECH-__W520 GR LTC-14 RSECH-43__W520 GR LTC-14
50 Rc	100	.003-.012	RECH-__W520 GR 586XRm RSECH-43__W520 GR 586XRm	RECH-__W520 GR LTC-10 RSECH-43__W520 GR LTC-10
Titanium	100	.003-.012	RECH-__-10F GR 586XRm RSECH-43__-10F GR 586XRm	RECH-__-10F GR LTC-10 RSECH-43__-10F GR LTC-10
Stainless	500	.003-.012	RECH-__-10F GR 586XRm RSECH-43__-10F GR 586XRm	RECH-__W520 GR 586XRm RSECH-43__W520 GR 586XRm

- Light roughing in mold and die steels
- Plunge rates to .015 FPT (.500 DOC before dwell)
- Large step over capacity (50% tool diameter)
- Good for Stainless Steel and Aluminum
- 1.25 and 1.50 diameter tools use the same RECH insert as XR45 Face & End Mill tooling
- Offered in multi-diameter standard & extended lengths
- Thru the shank coolant