



LOVEJOY Tool Company, Inc.

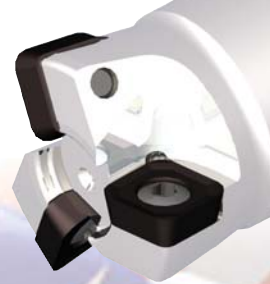
Since 1917

High Feed Milling

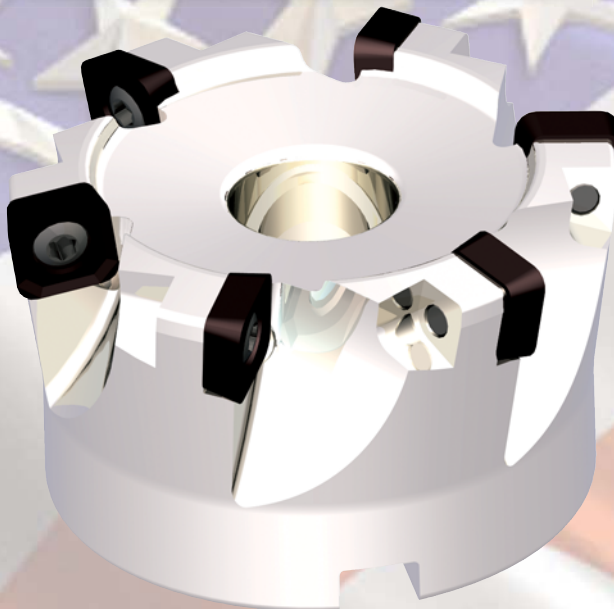
250 Series

Features:

- 8° Reverse Dish Angle
- .040 depth of cut
- Ramping capabilities
- 4 cutting edges
- High performance coated carbide to machine most materials
- Strong square insert geometry
- High performance silicon nitride inserts for gray cast iron
- Available in kits
- Cutter bodies are plated for chip erosion and corrosion resistance



End Mill Diameters Available from
1.25" to 1.50"

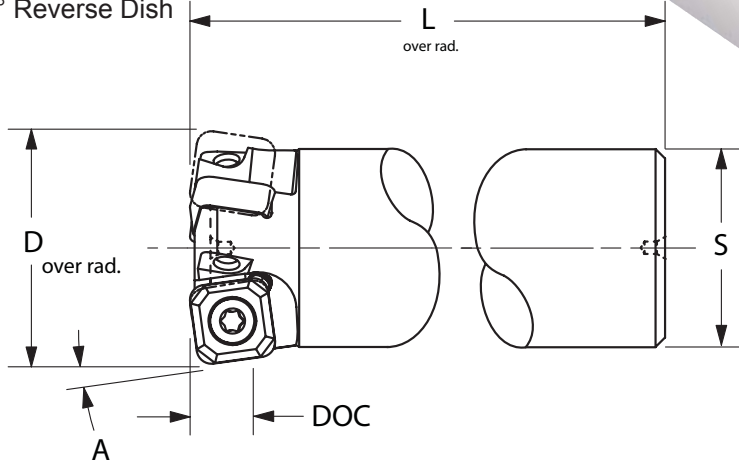


Face Mill Diameters Available from
2" to 4"



1-800-TheVermontMillPeople

5° Pos. Axial Rake
 Neg. Radial Rake
 8° Reverse Dish

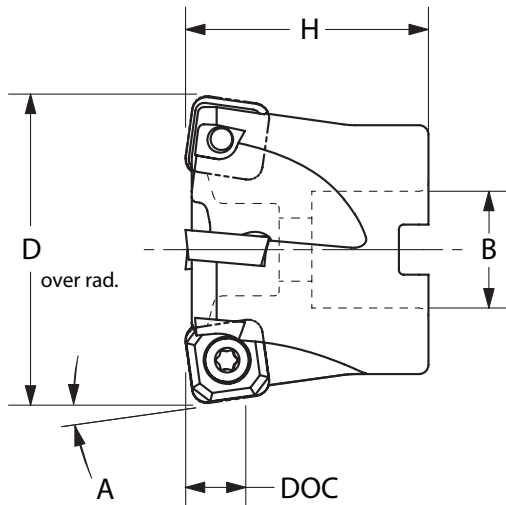


250E0150...

250 Series - End Mill Dimensional Specifications

Product Number	D	S	L	A	DOC	Insert	Screw	Teeth
250E0125ASP4-S100R	1.250	1.000	6.00	8°	.040	SPEX-436	3605-0001-0023	2
						SPCW-436W820	SR-16-212	
250E0150ASP4-S125R	1.500	1.250	6.00	8°	.040	SPEX-436	3605-0001-0023	3
						SPCW-436W820	SR-16-212	

5° Pos. Axial Rake
 Neg. Radial Rake
 8° Reverse Dish



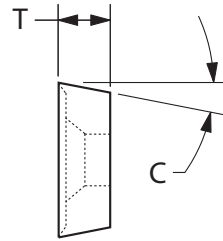
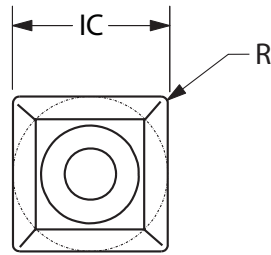
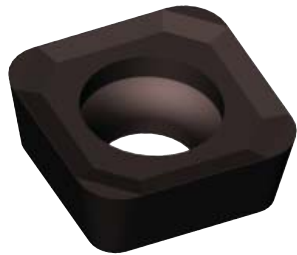
250F0300...



250 Series - Face Mill Dimensional Specifications

Product Number	D	B	H	A	DOC	Insert	Screw	Teeth
250F0200ASP4-075R	2.000	0.750	1.56	8°	.040	SPEX-436	3605-0001-0023	4
						SPCW-436W820	SR-16-212	
250F0300ASP4-100R	3.000	1.000	1.75	8°	.040	SPEX-436	3605-0001-0023	6
						SPCW-436W820	SR-16-212	
250F0400ASP4-150R	4.000	1.500	2.00	8°	.040	SPEX-436	3605-0001-0023	7
						SPCW-436W820	SR-16-212	

SPEX...



SPCW...



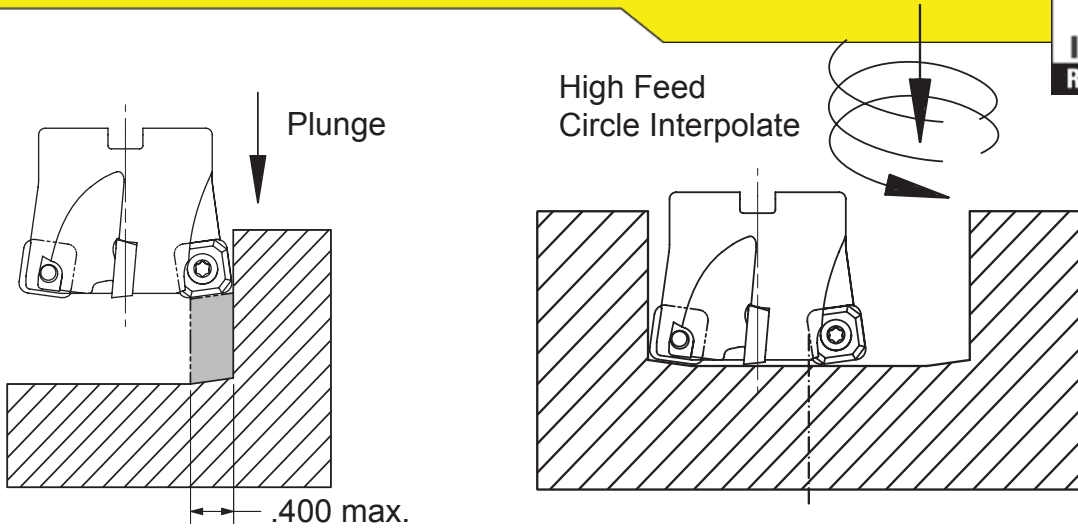
Insert Dimensional & Grade Specifications

Insert Number	IC	T	R	C	LT-4073B	LT-2373B	908XRm	LTC-1200
SPEX-436	0.500	0.188	0.094	11°				
SPCW-436W820	0.500	0.188	0.094	11°				

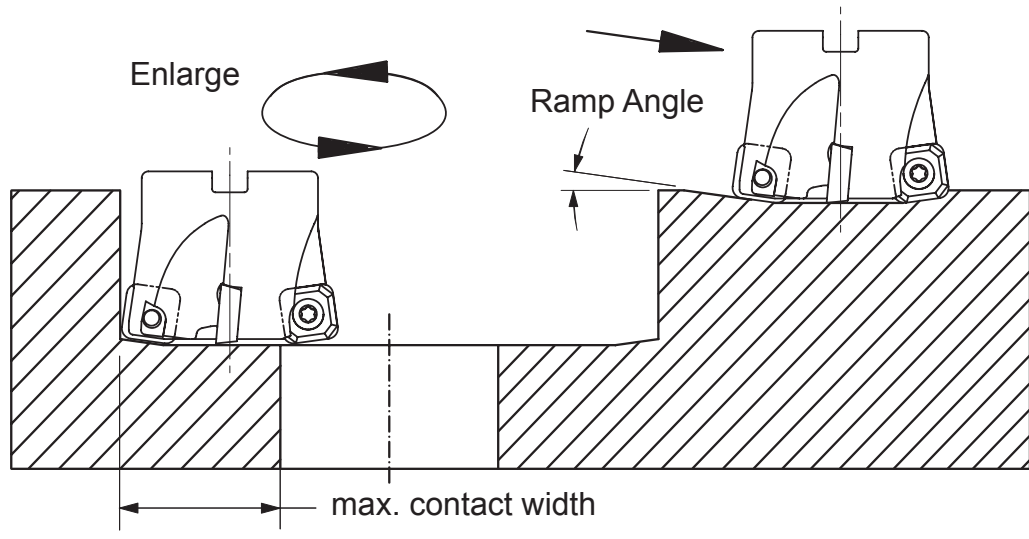
250 Series High Feed Cutter - Speeds and Feeds Machining Parameters

Material	SFM	Feed / Tooth	Max. Depth
Low Carbon Steel	650 - 750	.020 - .060	0.040
Alloy Steel	500 - 600	.020 - .060	0.040
Austenitic Stainless	550 - 650	.020 - .060	0.040
Martensitic Stainless	500 - 550	.020 - .060	0.040
Aluminum	1000 +	.020 - .060	0.040
▼ Gray Iron	2500 - 2800	.020 - .060	0.040
■ Gray & Ductile Iron	750 - 850	.020 - .060	0.040
Titanium / Supper Alloys	80 - 150	.020 - .060	0.040

P = Steel **M** = Stainless **K** = Cast Iron **N** = Non-Ferrous **S** = High Temp Alloy



250 Series - Min. Max. Bores for Circle Interpolation				
Tool Dia.	Min. Bore	Max. Bore	Ramp Depth	Ramp Angle
1.25	1.470	2.338	0.040	6°
1.50	1.720	2.838	0.040	3° 30'
2.00	2.220	3.838	0.040	2°
3.00	3.220	5.838	0.040	1°
4.00	4.220	7.838	0.040	0° 30'



250 Series - Parameters			
Tool Dia.	Contact Width	Ramp Depth	Ramp Angle
1.25	0.840	0.040	6°
1.50	1.090	0.040	3° 30'
2.00	1.590	0.040	2°
3.00	2.590	0.040	1°
4.00	3.590	0.040	0° 30'