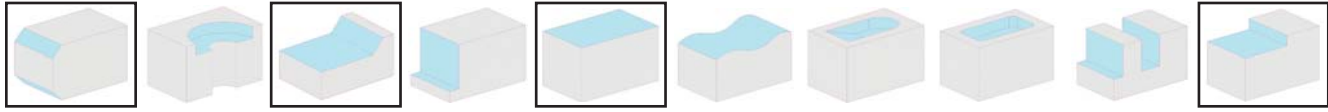
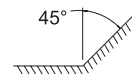
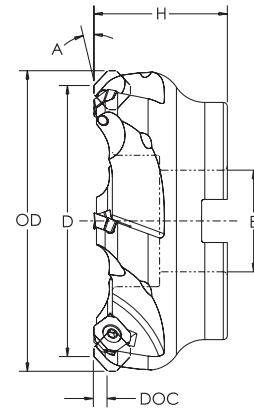


# 249 Series



20° Pos Axial  
Neg Radial  
45° Lead






• 45° lead angle allows smooth work entry & higher feed rates.

## 249 Series Face Mill - Dimensional Specifications

Product Number	D	OD	B	H	A	DOC	Insert	Teeth
249F0200ASE4-075R	2.000	2.43	0.750	1.970	0° - 0°15'	.250	SEHW-43A3M	4
249F0250ASE4-100R	2.500	2.93	1.000	1.970	0° - 0°15'	.250	SEHW-43A3M	5
249F0300ASE4-100R	3.000	3.43	1.000	1.970	0° - 0°15'	.250	SEHW-43A3M	6
249F0400ASE4-150R	4.000	4.43	1.500	1.970	0° - 0°15'	.250	SEHW-43A3M	6

LEFT HAND cutters also available

## Spare Parts

Insert I.C. x Thickness			
.500 x .188	Insert Pg. 42 SEHW-43A3M	Insert Screw 3605-0001-0023 Silicon Nitride Screw: SR-16-212	Insert Screw Wrench 1557-TX20

## 249 Series Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Low Carbon Steel	400 - 800	.005 - .012	SEHW-43A3M GR 606jRm	SEHW-43A3M GR 586XRm
Alloy Steel	350 - 700	.005 - .010	SEHW-43A3MW520 GR 606jRm	SEHW-43A3MW520B GR LT-5565
Forged Steel, Weldment	300 - 500	.005 - .010	SEHW-43A3MW520B GR LT-5565	SEHW-43A3MW520 GR 606jRm
Austenitic Stainless	350 - 700	.005 - .010	SEHW-43A3M GR 586XRm	SEHW-43A3M GR LTC-10
Aluminum	1000 & up	.005 - .010	SEHW-43A3M GR 586XRm	SEHW-43A3M GR LTC-10
Gray Cast Iron	2500 & 500	.005 - .010	SEHW-43A3MW820 GR LTC-1200	SEHW-43A3MA GR LT-2366
Ductile	500 - 1000	.005 - .010	SEHW-43A3MA GR LT-2366	SEHW-43A3M GR 606jRm

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

