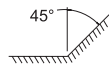
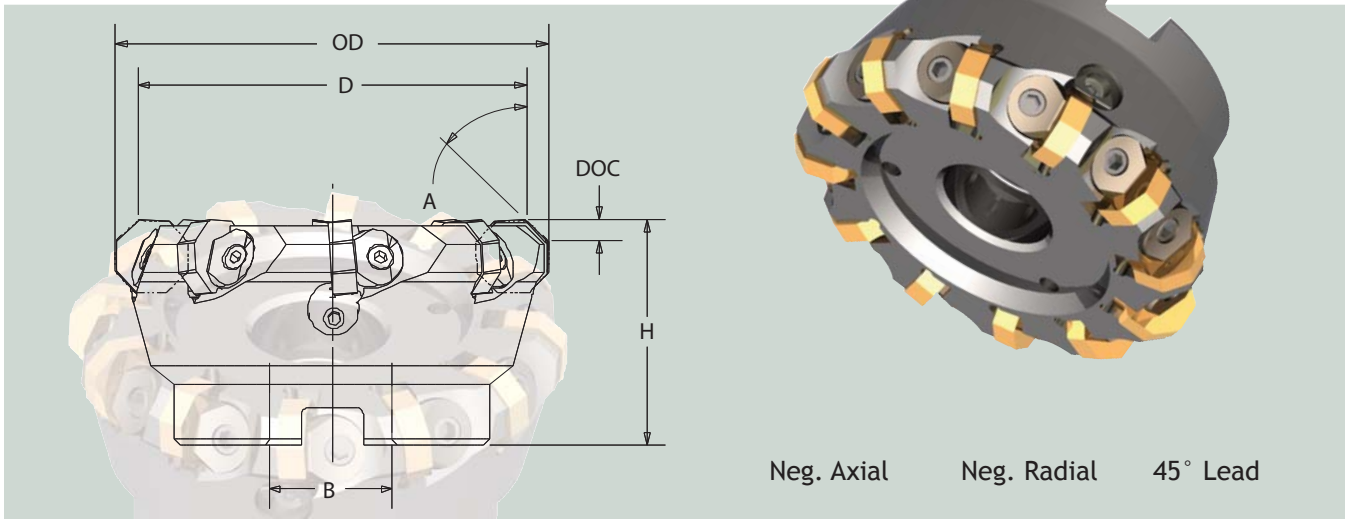
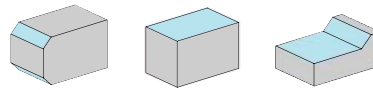


# Negative Face Mills - 45° Shoulder



## 650 Series

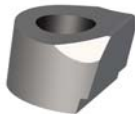
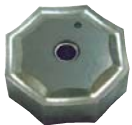


### 650 Series Face Mills - Dimensional Specifications

Product Number	D	OD	B	H	A	DOC	Insert	# Stations	# Wiper Sta.
650F0300AON6-125R	3.000	3.47	1.250	2.310	45°	.200	ONEG-64_-K1_	6	0
650F0300BON6-125R	3.000	3.47	1.250	2.310	45°	.200	ONEG-64_-K1_	9	0
650F0400AON6-150R	4.000	4.46	1.500	2.310	45°	.200	ONEG-64_-K1_	8	2
650F0400BON6-150R	4.000	4.46	1.500	2.310	45°	.200	ONEG-64_-K1_	12	3
650F0500AON6-150R	5.000	5.46	1.500	2.310	45°	.200	ONEG-64_-K1_	10	2
650F0500BON6-150R	5.000	5.46	1.500	2.310	45°	.200	ONEG-64_-K1_	15	3
650F0600AON6-200R	6.000	6.46	2.000	2.310	45°	.200	ONEG-64_-K1_	12	3
650F0600BON6-200R	6.000	6.46	2.000	2.310	45°	.200	ONEG-64_-K1_	18	3
650F0800AON6-UNVR	8.000	8.45	2.500	2.310	45°	.200	ONEG-64_-K1_	16	4
650F0800AON6-UNVR	8.000	8.45	2.500	2.310	45°	.200	ONEG-64_-K1_	24	6

ONEG inserts have 16 cutting edges

### Accessory Parts

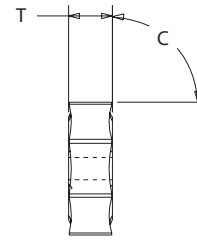
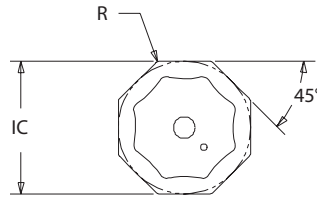


Insert	Lock	Lock Screw	Lock Screw	Adj. Pin	Screw	SSS Brass Tip
.75 IC x .25 Thick see page 28			650F0400BON6-150R (only)	Wiper Station	Wiper Station	Wiper Station
ONEG-64_-K1_	3502-1133-5002	1451	1452	3502-2350-0017	1484	1/4-28 x 1/2

# Inserts



## 650 Series



Insert Dimensional & Grade Specifications					
					Roughing
Insert Number	IC	T	R	C	LT-8473B
ONEG-642-K1	0.750	0.250	0.032	0°	

Insert Dimensional & Grade Specifications					
					Roughing
Insert Number	IC	T	R	C	LT-3081
ONEG-642-K1A	0.750	0.250	0.032	0°	

Insert Dimensional & Grade Specifications					
					Finishing
Insert Number	IC	T	R	C	LT-8473B
ONEG-64Z-K1	0.750	0.250	0.032	0°	

Insert Dimensional & Grade Specifications					
					Finishing
Insert Number	IC	T	R	C	LT-3081
ONEG-64Z-K1A	0.750	0.250	0.032	0°	

Machining Parameters					
Material	SFPM	FPT	Roughing	Finishing	
Gray Iron, Class 30	200 - 500	.005 - .015	ONEG-642-K1 GR LT-8473B	ONEG-64Z-K1 GR LT-8473B	
Stainless, 304, 316	300 - 500	.005 - .015	ONEG-642-K1 GR LT-8473B	ONEG-64Z-K1 GR LT-8473B	
Tool Steel, D2	250 - 350	.005 - .015	ONEG-642-K1A GR LT-3081	ONEG-64Z-K1A GR LT-3081	
Tool Steel, P20	300 - 700	.005 - .015	ONEG-642-K1A GR LT-3081	ONEG-64Z-K1A GR LT-3081	
Soft Alloy Steel	400 - 800	.005 - .015	ONEG-642-K1A GR LT-3081	ONEG-64Z-K1A GR LT-3081	
Medium Alloy Steel	300 - 700	.005 - .015	ONEG-642-K1A GR LT-3081	ONEG-64Z-K1A GR LT-3081	

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