



LOVEJOY Tool Company

Mold and Die Tooling

Metric Cavity Machining Group

—LOVEJOY—

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LOVEJOY Tool Company is pleased to announce the metric version of our Cavity Machining Group of products. This new family of high performance cutting tools has been designed specifically for the requirements encountered during the cavity machining applications associated with the mold and die industry. These particular applications frequently necessitate the use of cutting tools that exceed the normal, accepted length to diameter ratios of most modern tool builders. This particular requirement absolutely demands that the geometry of the tool be optimally suited for the workpiece material from which the mold or die cavity is being machined.

LOVEJOY Tool Company has chosen to build much of this product line by adapting geometries from our popular *Extended Range*[™] product group. This adaptation ensures that regardless of the material being machined, consumers are assured that the application has the highest degree of probable success.

For more information, please contact *LOVEJOY Technical Services* via any of the numbers listed above.

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Second Printing - 31-2004



Non-Ferrous

586XRm

Applications

Ferrous

606jRm

Applications



255 Series

Cavity Machining Group

Extended Range

Ramping Capability Configuration

Hardware Specification	
3605-0001-0023	

Metric 255 Series mm Dimensional Specifications

End Mill -Order Number	D	R	S	L	Insert Number	Teeth
255E050MARE6-W20MR	50	9.53	20	50	RECH-63	3
Face Mill -Order Number	D	R	B	H	Insert Number	Teeth
255F075MARE6-27MR	80	9.53	27	50	RECH-63	4
255F100MARE6-40MR	100	9.53	40	50	RECH-63	5

Cavity Machining Group

RECH-63 Type

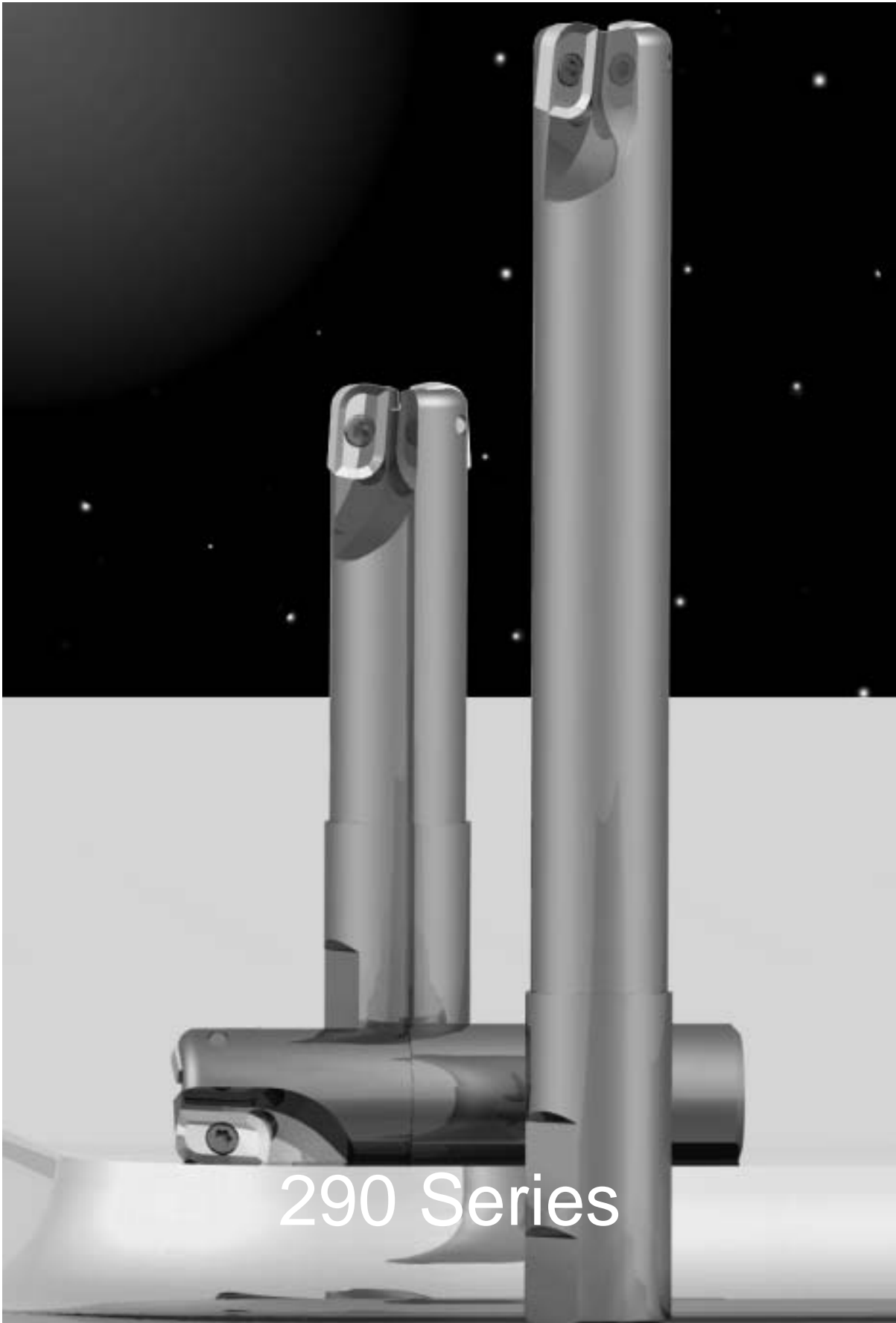
Flat

Dished

Flat and Dished Face Configuration

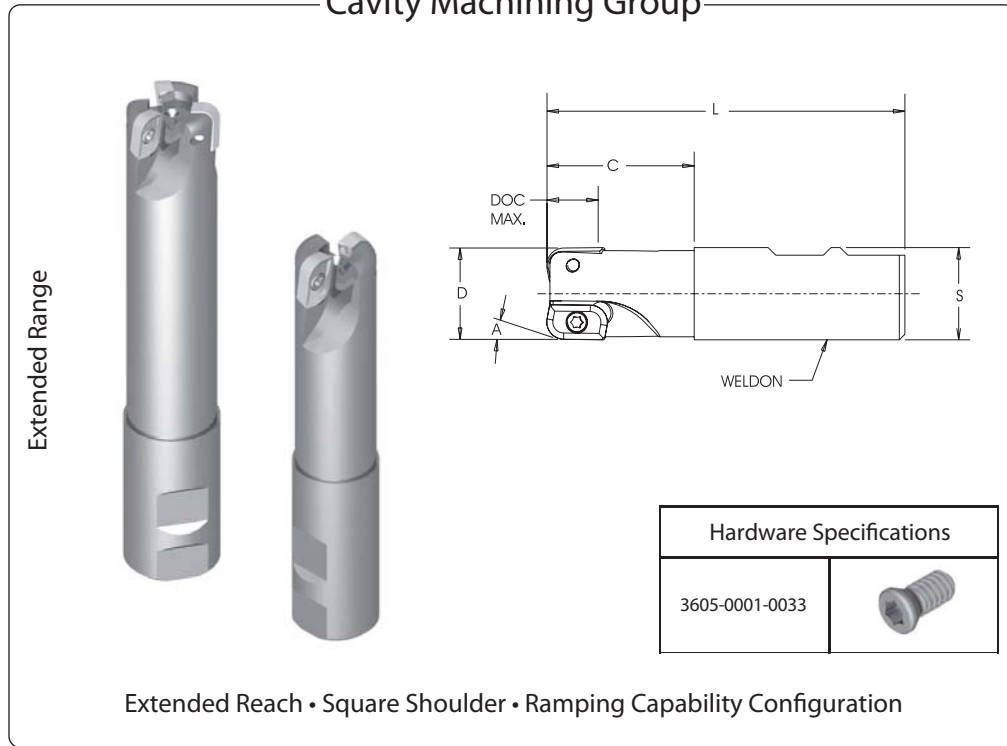
Metric RECH mm Dimensional and Grade Specifications

Insert Number	IC	T	R	C	Non-ferrous		Ferrous	
					LTC-10	586XRm	LTC-14	606jRm
RECH-63-10F	19.05	4.76	9.53	19°	•	•	•	•
RECH-63W520	19.05	4.76	9.53	19°	•	•	•	•



290 Series

Cavity Machining Group



Metric 290E Series mm Dimensional Specifications

Order Number	D	S	C	L	A	DOC	Insert Number	Teeth
290E025MACP3-W25MR	25	25	43	100	90°	16	CPEH-32.63-__-4W	2
290E025MBCP3-W25MR	25	25	75	135	90°	16	CPEH-32.63-__-4W	2
290E025MCCP3-W25MR	25	25	100	160	90°	16	CPEH-32.63-__-4W	2
290E025MDCP3-W32MR	25	32	125	185	90°	16	CPEH-32.63-__-4W	2
290E025MECP3-W32MR	25	32	155	210	90°	16	CPEH-32.63-__-4W	2
290E032MACP3-W25MR	32	25	49	110	90°	16	CPEH-32.63-__-4W	3
290E032MBCP3-W32MR	32	32	75	135	90°	16	CPEH-32.63-__-4W	3
290E032MDCP3-W32MR	32	32	125	185	90°	16	CPEH-32.63-__-4W	3
290E040MACP3-W25MR	40	25	49	110	90°	16	CPEH-32.63-__-4W	4
290E040MACP3-W32MR	40	32	49	110	90°	16	CPEH-32.63-__-4W	4
290E040MBCP3-W32MR	40	32	75	135	90°	16	CPEH-32.63-__-4W	4
290E040MDCP3-W32MR	40	32	125	185	90°	16	CPEH-32.63-__-4W	4
290E050MACP3-W32MR	50	32	49	110	90°	16	CPEH-32.63-__-4W	4
290E050MCCP3-W50MR	50	50	100	185	90°	16	CPEH-32.63-__-4W	5
290E050MECP3-W50MR	50	50	155	235	90°	16	CPEH-32.63-__-4W	5

Cavity Machining Group

Extended Range

Hardware Specifications	
3605-0001-0033	

Square Shoulder • Ramping Capability Configuration

Metric 290F Series mm Dimensional Specifications

Order Number	D	A	B	H	DOC	Insert Number	Teeth
290F050MACP3-22MR	50	90°	22	57	16	CPEH-32.63-__-4W	5
290F065MACP3-22MR	63	90°	22	57	16	CPEH-32.63-__-4W	6
290F075MACP3-27MR	75	90°	27	57	16	CPEH-32.63-__-4W	6
290F100MACP3-40MR	100	90°	40	57	16	CPEH-32.63-__-4W	8

Cavity Machining Group

CPEH Type


Metric CPEH Insert mm Dimensional and Grade Specifications

Insert Number	IC	L	T	R	C	Non-ferrous		Ferrous	
						LTC-10	586XRm	LTC-14	606jRm
CPEH-32.63-2-4W	9.53	16.76	4.78	.82	11°	•	•	•	•
CPEH-32.63-4-4W	9.53	16.76	4.78	1.60	11°	•	•	•	•
CPEH-32.63-6-4W	9.53	16.76	4.78	2.38	11°	•	•	•	•
CPEH-32.63-8-4W	9.53	16.76	4.78	3.18	11°	•	•	•	•
CPEH-32.63-12-4W	9.53	16.76	4.78	4.76	11°	•	•	•	•



291 Series

Cavity Machining Group

Hardware Specification	
3605-0001-0033	

Extended Reach • 7° Backdraft Configuration

Metric 290F Series mm Dimensional Specifications

Order Number	D	A	B	H	DOC	Insert Number	Teeth
290F050MACP3-22MR	50	90°	22	57	16	CPEH-32.63-__-4W	5
290F065MACP3-22MR	63	90°	22	57	16	CPEH-32.63-__-4W	6
290F075MACP3-27MR	75	90°	27	57	16	CPEH-32.63-__-4W	6
290F100MACP3-40MR	100	90°	40	57	16	CPEH-32.63-__-4W	8

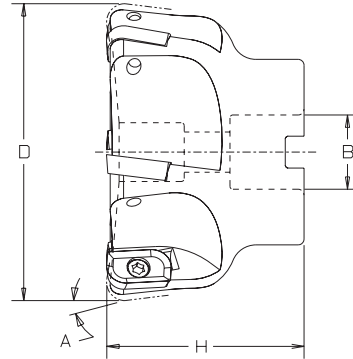
Note: The above specifications use insert CPEH-32.63-12-4W to generate dimensions shown. When using inserts with a smaller radius, add the MM dimensional changes shown below.

Metric 291 End Mill and Face Mill Insert Change mm Specifications

Product Series	Cutting Point	Corner Radius	D+	L+	H+	Insert Number
291	2	.787	1.168	.279	.279	CPEH-32.63-2-4W
291	4	1.575	.940	.229	.229	CPEH-32.63-4-4W
291	6	2.388	.686	.178	.178	CPEH-32.63-6-4W
291	8	3.175	.457	.127	.127	CPEH-32.63-8-4W
291	12	4.780	.000	.000	.000	CPEH-32.63-12-4W

Cavity Machining Group

Extended Range



7° Backdraft • Ramping Capability Configuration

Hardware Specification

3605-0001-0033

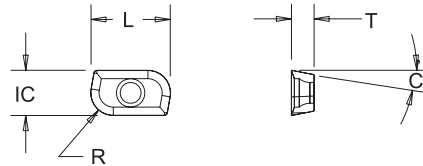


Metric 291F Series mm Dimensional Specifications

Order Number	D	A	B	H	Insert Number	Teeth
291F050MACP3-22MR	50	7°	22	50	CPEH-32.63-12-4W	4
291F075MACP3-22MR	80	7°	22	50	CPEH-32.63-12-4W	6

Cavity Machining Group

CPEH Type



Metric CPEH Insert mm Dimensional and Grade Specifications

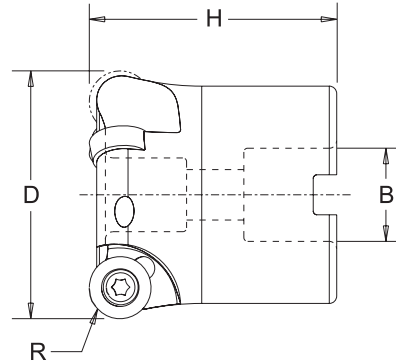
Insert Number	IC	L	T	R	C	Non-ferrous		Ferrous	
						LTC-10	586XRm	LTC-14	606jRm
CPEH-32.63-2-4W	9.53	16.76	4.78	.82	11°	•	•	•	•
CPEH-32.63-4-4W	9.53	16.76	4.78	1.60	11°	•	•	•	•
CPEH-32.63-6-4W	9.53	16.76	4.78	2.38	11°	•	•	•	•
CPEH-32.63-8-4W	9.53	16.76	4.78	3.18	11°	•	•	•	•
CPEH-32.63-12-4W	9.53	16.76	4.78	4.76	11°	•	•	•	•



355 Series

Cavity Machining Group

Extended Range



7° Backdraft • Ramping Capability Configuration

Hardware Specification	
3605-0001-0033	

Metric 355 Series mm Dimensional Specifications

Order Number	D	R	B	H	Insert Number	Teeth
355F050MARC4-22MR	50	6.35	22	50	RCCH-43	3

Cavity Machining Group

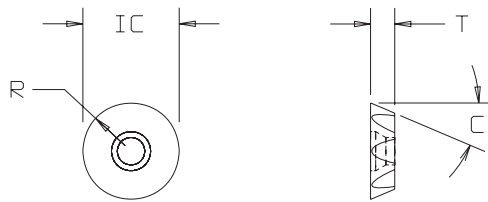
RCCH Type



Flat



Dished



Flat and Dished Face Configuration

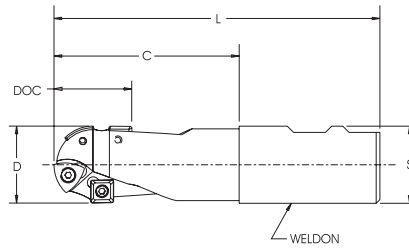
Metric RCCH mm Dimensional and Grade Specifications

Insert Number	IC	T	R	C	Non-ferrous		Ferrous	
					LTC-10	586XRm	LTC-14	606jRm
RCCH-43-10F	12.70	4.78	6.36	7°	•	•	•	•
RCCH-43W520	12.70	4.78	6.36	7°	•	•	•	•




540 Series

Cavity Machining Group



Extended Reach • Ball End Configuration

Hardware Specification	
Locking Screw	
Tool Designation	Screw Number
540E025M... Style	3605-0001-0022 3605-0001-0005
All Other 540 Series	3605-0001-0021 3605-0001-0004 3605-0001-0005

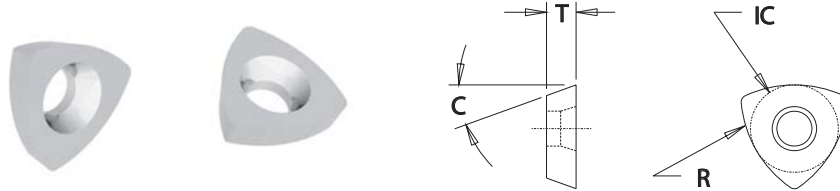
Note: 50mm diameter 540 series utilizes 3605-0001-0004 screw to lock CTPCB insert

Metric 540 Series mm Dimensional Specifications

Order Number	D	S	C	L	DOC	Insert Number	Screw	Teeth
540E025MBCP3-W25MR	25	25	73	135	21	CTPCB-1603-125	-0005	2
						SPEX-32.52	-0022	2
540E025MCCP3-W32MR	25	32	100	160	28	CTPCB-1603-125	-0005	2
						SPEX-32.52	-0022	2
540E025MECP3-W32MR	25	32	155	210	28	CTPCB-1603-125	-0005	2
						SPEX-32.52	-0022	2
540E025MGCP3-W32MR	25	32	204	260	28	CTPCB-1603-125	-0005	2
						SPEX-32.52	-0022	2
540E032MBCP3-W32MR	32	32	75	135	31	CTPCB-1603-160	-0005	3
						SPEX-32.52	-0021	2
540E032MCCP3-W32MR	32	32	99	160	31	CTPCB-1603-160	-0005	3
						SPEX-32.52	-0021	2
540E032MECP3-W32MR	32	32	155	210	31	CTPCB-1603-160	-0005	3
						SPEX-32.52	-0021	2
540E032MGCP3-W32MR	32	32	204	260	31	CTPCB-1603-160	-0005	3
						SPEX-32.52	-0021	2
540E050MBCP3-W50MR	50	50	75	160	41	CTPCB-2204-250	-0004	4
						SPEX-32.52	-0021	2
540E050MDCP3-W50MR	50	50	125	210	41	CTPCB-2204-250	-0004	4
						SPEX-32.52	-0021	2
540E050MFCP3-W50MR	50	50	178	260	41	CTPCB-2204-250	-0004	4
						SPEX-32.52	-0021	2

Cavity Machining Group

CTPCB Type

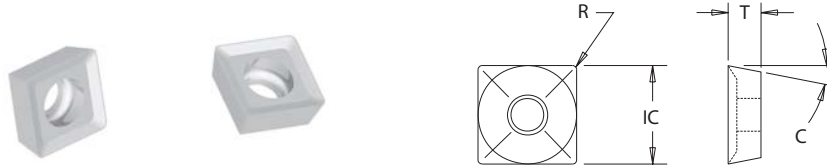


Metric CTPCB Insert mm Dimensional and Grade Specifications

Insert Number	IC	T	R	C	Non-ferrous		Ferrous	
					LTC-10	586XRm	LTC-14	606jRm
CTPCB-1603-125B	9.53	3.20	12.50	11°			•	•
CTPCB-1603-125J	9.53	3.20	12.50	11°	•	•		
CTPCB-1603-160B	9.53	3.20	16.00	11°			•	•
CTPCB-1603-160J	9.53	3.20	16.00	11°	•	•		
CTPCB-2204-250B	12.70	4.76	25.00	11°			•	•
CTPCB-2204-250J	12.70	4.76	25.00	11°	•	•		

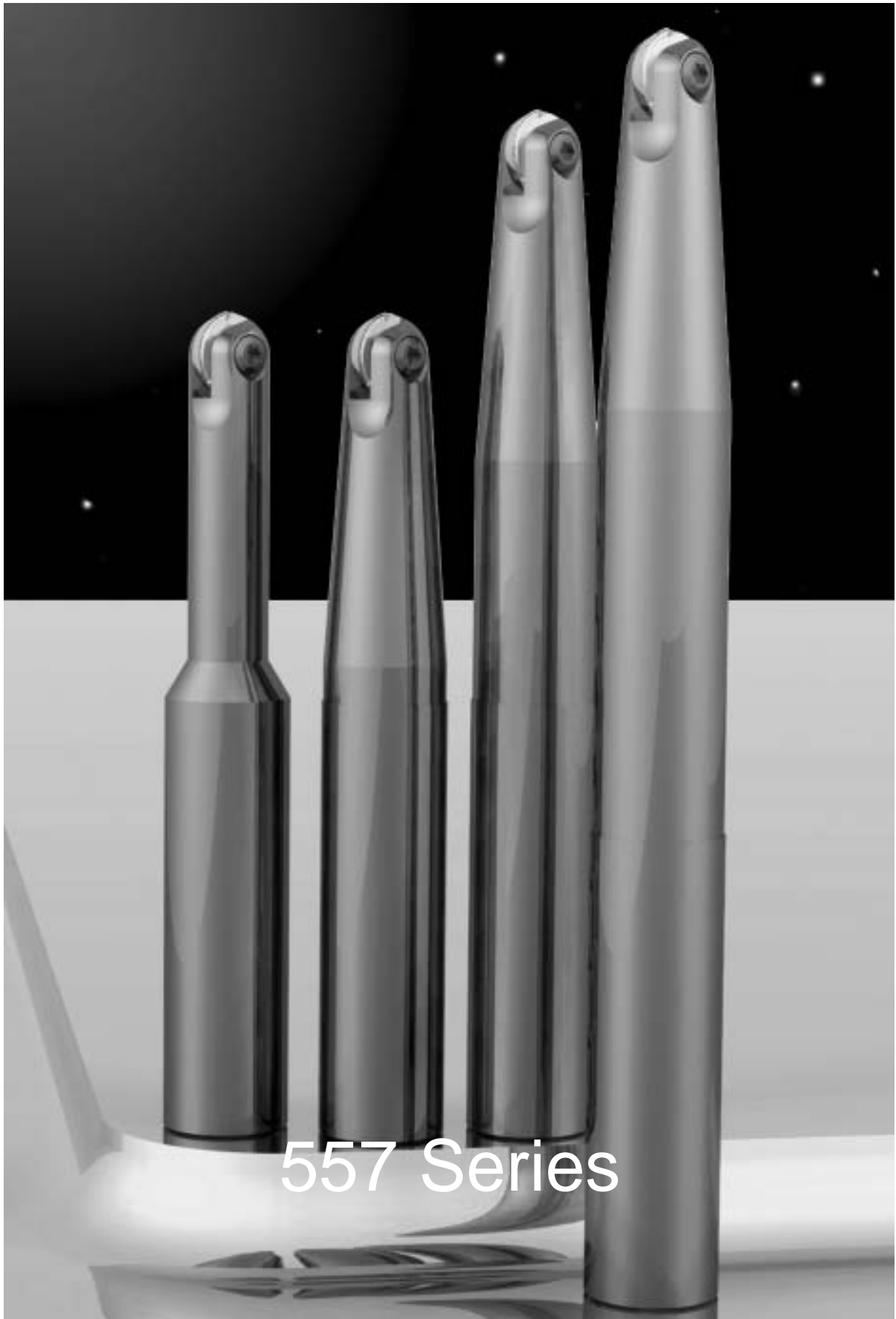
Cavity Machining Group

SPEX Type



Metric SPEX Insert mm Dimensional and Grade Specifications

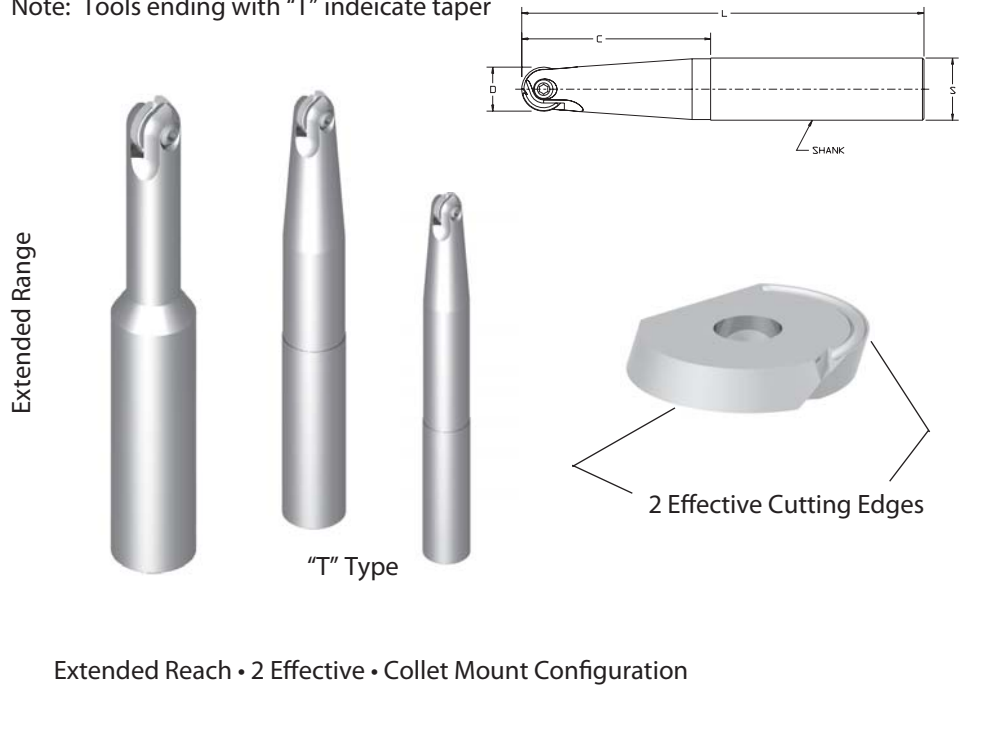
Insert Number	IC	T	R	C	Non-ferrous		Ferrous	
					LTC-10	586XRm	LTC-14	606jRm
SPEX-32.52	9.53	3.96	.81	11°	•	•	•	•



557 Series

Cavity Machining Group

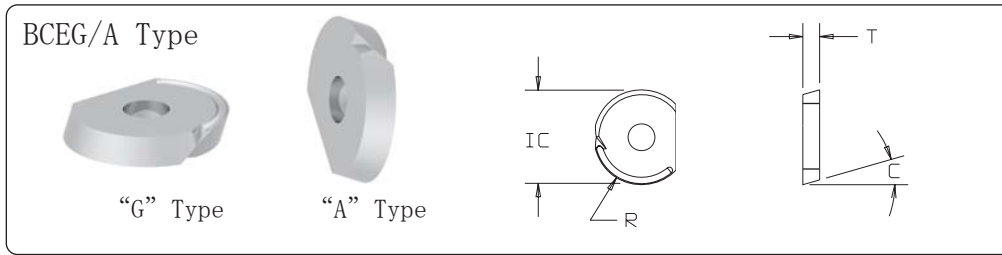
Note: Tools ending with "T" indicate taper



Metric 557 Series mm Dimensional Specifications

Order Number	D	S	C	L	Insert Number	Screw
557E008MABC08M-S12MRT	8	12	48.5	140	BCEG-0802	GWS 08
557E010MBBC10M-S12MRT	10	12	35	150	BCEG/A-10X2	GWS 10
557E012MABC12M-S12MR	12	12	32	130	BCEG/A-12X2	GWS 12
557E012MBBC12M-S12MR	12	12	46	150	BCEG/A-12X2	GWS 12
557E012MDBC12M-S16MRT	12	16	58.5	160	BCEG/A-12X2	GWS 12
557E016MABC16M-S16MR	16	16	36	140	BCEG/A-1603	GWS 16
557E016MBBC16M-S16MR	16	16	53	160	BCEG/A-1603	GWS 16
557E016MCBC16M-S20MRT	16	20	65	175	BCEG/A-1603	GWS 16
557E020MABC20M-S20MR	20	20	45	160	BCEG/A-2003	GWS 20
557E020MBBC20M-S20MR	20	20	61	175	BCEG/A-2003	GWS 20
557E020MDBC20M-S25MRT	20	25	76	190	BCEG/A-2003	GWS 20
557E025MABC25M-S25MR	25	25	45	160	BCEG/A-2504	GWS 25
557E025MBBC25M-S25MR	25	25	70	190	BCEG/A-2504	GWS 25
557E025MCBC25M-S32MRT	25	32	98	210	BCEG/A-2504	GWS 25
557E032MABC32M-S32MR	32	32	56	175	BCEG/A-3205	GWS 32
557E032MBBC32M-S32MR	32	32	80	210	BCEG/A-3205	GWS 32
557E032MCBC32M-S40MRT	32	40	121	240	BCEG/A-3205	GWS 32

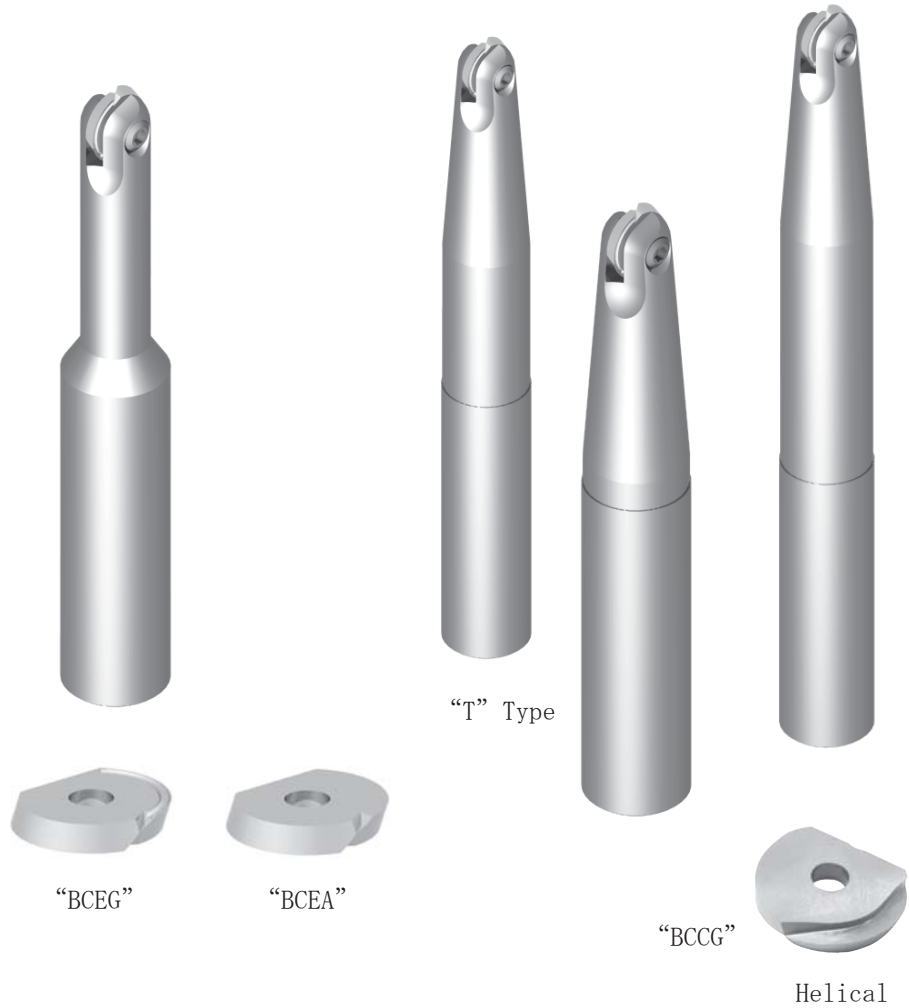
Cavity Machining Group



Metric BCEG/A Insert mm Dimensional and Grade Specifications

Insert Number	IC	T	R	C	Non-ferrous		Ferrous	
					LTC-10	586XRm	LTC-14	606jRm
BCEG-0802	8	2	4	7°	•	•	•	•
BCEA-10X2	10	2.5	5	7°	•	•	•	•
BCEG-10X2	10	2.5	5	7°	•	•	•	•
BCEA-12X2	12	2.5	6	7°	•	•	•	•
BCEG-12X2	12	2.5	6	7°	•	•	•	•
BCEA-1603	16	3	8	7°	•	•	•	•
BCEG-1603	16	3	8	7°	•	•	•	•
BCEA-2003	20	3	10	7°	•	•	•	•
BCEG-2003	20	3	10	7°	•	•	•	•
BCEA-2504	25	4	12.5	7°	•	•	•	•
BCEG-2504	25	4	12.5	7°	•	•	•	•
BCEA-3205	32	5	16	7°	•	•	•	•
BCEG-3205	32	5	16	7°	•	•	•	•

Application Information for 557 Ball
Nose Cutter, inserts and grades



557 Series Application Specifications

Type	Grade	Style	Application
"G"		Chip Breaker Insert	soft gummy materials ie: aluminum, brass, low carbon steels and stainless.
"A"		Flat Face Insert	high carbon and die and mold steel.
	586XRm	TiAlN-PVD coated	light roughing and finishing cuts in die and mold steels and any finishing cuts in hard steels and non-ferrous materials.
	606jRm	TiAlN-PVD coated	roughing low and high carbon steels, die mold steels and ferrous materials.
	LTC-10	Class C2 Uncoated	aluminum and non-ferrous materials.
	LTC-14	Class C5 Uncoated	carbon steels and die and mold steels.

Cavity Machining Group

Grade Classification and Recommendation

ISO	ANSI	Application	LOVEJOY Primary	LOVEJOY Secondary
Ferrous Metals Applications				
P01	C8	High Speed finishing, light DOC and feed rates	606jRm	LTC-14
P05	C7	Semi-finishing, light to moderate DOC and feeds	606jRm	LTC-14
P10	C7	Semi-finishing, light to moderate DOC and feeds	606jRm	LTC-14
P15	C6	General purpose, moderate speeds and feeds	606jRm	LTC-14
P20	C6	General purpose, moderate speeds and feeds	606jRm	LTC-14
P25	C6	General purpose, moderate speeds and feeds	606jRm	LTC-14
P30	C5	Heavy duty machining, slower speeds and heavy feeds	606jRm	LTC-14
P40	C5	Heavy duty machining, slower speeds and heavy feeds	LTC-14	606jRm
P50	-	Heavy duty machining, slower speeds and heavy feeds	LTC-14	606jRm
Multi-purpose Applications				
M10	-	High Speed finishing, light DOC and feed rates	606jRm	LTC-14
M20	-	Semi-finishing, light to moderate DOC and feeds	606jRm	LTC-14
M30	-	General purpose, moderate speeds and feeds	606jRm	LTC-14
M40	-	Heavy duty machining, slower speeds and heavy feeds	LTC-14	586XRm
Non-ferrous and Non-metals Applications				
K01	C4	High Speed finishing, light DOC and feed rates	586XRm	LTC-10
K05	C4	High Speed finishing, light DOC and feed rates	586XRm	LTC-10
K10	C3	Semi-finishing, light to moderate DOC and feeds	586XRm	LTC-10
K20	C2	General purpose, moderate speeds and feeds	586XRm	LTC-10
K30	C1	Heavy duty machining, slower speeds and heavy feeds	LTC-10	586XRm
K40	C1	Heavy duty machining, slower speeds and heavy feeds	LTC-10	586XRm

Insert Indexing & Screw Torque Specifications

- Always ensure that insert pockets are clean & free of debris or burrs
- Utilize holders that are stable and in good condition
- Clean & recoat screw with anti-seize lubricant during each index
- For optimum results, replace locking screw after 10 inserts
- For optimum results, replace holders after 100 inserts
- Utilize the proper driver to tighten locking screw
- Hold the insert in place during the tightening process
- Never force the locking process – check for interference or damage
- Do not use piper or other extensions to tighten the locking screw
- Generally speaking, drivers supplied with the tools provide proper torque
- If a torque wrench is available, follow the specifications below

Screw Torque Specifications			
Series	Insert Type	Screw Designation	Torque (Nm)
255 Series	RECH-63	3605-0001-0023	813.49
290 Series	CPEH-32.63	3605-0001-0033	406.75
291 Series	CPEH-32.63	3605-0001-0033	406.75
355 Series	RCCH-43	3605-0001-0033	406.75
540 Series	SPEX-32.52	3605-0001-0021	276.59
540 Series	CTPCB-2204	3605-0001-0004	650.79
540 Series	CTPCB-1603	3605-0001-0005	195.24

Performance Evaluation & Trouble Shooting Guide		
Tool Life		
Built Up Edge	Buildup or workpiece material on the cutting edge of the insert. Typically produced by soft or gummy materials. BUE will damage the insert.	1.) Increase spindle velocity 2.) Adjust coolant flow 3.) Utilize sharp cutting edge
Chipping	Generally speaking, chipping of the insert typically occurs on the cutting edge. Chipping will ultimately lead to catastrophic failure.	1.) Change speed &/or feed 2.) Change to tougher grade 3.) Apply light hone
Crater Wear	Crater phenomenon is normally associated with the machining of carbon steels. Cratering will lead to premature and catastrophic failure.	1.) Change speed &/or feed 2.) Utilize coated grades 3.) Apply coolant
Notching	Depth of cut notching typically occurs while machining nickel based materials or materials with hard or rough skin.	1.) Apply hone at DOC area 2.) Reduce speed 3.) Vary DOC
Deformation	Heat deformation of the cutting edge radically increases cutting pressures and will lead to insert failure.	1.) Reduce speed &/or feed 2.) Change to harder grade 3.) Apply coolant
Breakage	Insert breakage that is not associated with any other trauma is normally the result of cutting pressures beyond the mechanical properties of the grade or geometry.	1.) Increase speed 2.) Decrease feed &/or DOC 3.) Change to stronger grade 4.) Check set up rigidity
Flank Wear	Excessive flank wear is produced by either abrasive materials or machining parameters out of the range in which the tool is designed to operate.	1.) Verify correct speed 2.) Verify correct geometry 3.) Improve coolant flow
Thermal Cracking	Thermal cracking appears as a geometric pattern of cracks along the cutting edge. This trauma is associated with rapid expansion and shrinkage of the insert.	1.) Improve coolant flow 2.) Do not use coolant 3.) Verify correct speed
Surface Finish		
Out of Tolerance	Finish does not comply with the RMS specifications of the part print.	1.) Check insert run out 2.) Vary speeds and feeds 3.) Check set up rigidity
Chip Formation		
Poor Formation	Chips that deviate from normal “C”, “6” or “9” shape may indicate a performance problem.	1.) Verify speeds and feeds 2.) Verify correct geometry 3.) Check set up rigidity
Poor Evacuation	Chip evacuation should be in the form of a constant and well directed flow.	1.) Verify speeds and feeds 2.) Verify correct geometry 3.) Check set up rigidity

Mathematical Milling Formulae

Cutting speed (m/min):

$$V_c = \frac{\pi}{1000} \times D_m \times \text{RPM}$$

Revolutions per minute (RPM):

$$\text{RPM} = \frac{1000 \times V_c}{\pi \times D_m}$$

Feed rate (mm/min):

$$F = \text{FPT} \times N \times \text{RPM}$$

Feed per tooth (FPT- mm):

$$\text{FPT} = \frac{F(\text{mm/min})}{(N \times \text{RPM})}$$

Cutting time (minutes):

$$T = \frac{\text{LOC}}{F}$$

Metal removal rate (mm³/minute):

$$Q = \frac{\text{WOC} \times \text{DOC} \times F}{1000}$$

Horsepower at spindle (kW):

$$\text{kW}_s = Q \times P$$

Horsepower at motor (kW):

$$\text{kW}_m = \frac{Q \times P}{E}$$

Machining Term Abbreviations

D _m :	Diameter (mm)
DOC:	Depth of cut
E:	Machine efficiency
F:	Feed rate (mm/min)
FPT:	Feed per tooth (mm/tooth)
kW _m :	power at motor, kW
kW _s :	power at spindle, kW
LOC:	Length of cut
N:	Number of teeth
P:	Power factor (kW/cm ³ /min)
Q:	Metal removal rate cm ³ /minute
RPM:	Revolutions per minute
T:	Cutting time
V _c :	Cutting speed
WOC:	Width of cut

Millimeters	Decimal	Fraction
0.3969	.0156	1/64
0.7938	.0312	1/32
1.1906	.0469	3/64
1.5875	.0625	1/16
1.9844	.0781	5/64
2.3813	.0937	3/32
2.7781	.1094	7/64
3.1750	.1250	1/8
3.5719	.1406	9/64
3.9688	.1562	5/32
4.3656	.1719	11/64
4.7625	.1875	3/16
5.1594	.2031	13/64
5.5563	.2187	7/32
5.9531	.2344	15/64
6.3500	.2500	1/4
6.7469	.2656	17/64
7.1438	.2812	9/32
7.5406	.2969	19/64
7.9375	.3125	5/16
8.3344	.3281	21/64
8.7313	.3437	11/32
9.1281	.3594	23/64
9.5250	.3750	3/8
9.9219	.3906	25/64
10.3188	.4062	13/32
10.7156	.4219	27/64
11.1125	.4375	7/16
11.5094	.4531	29/64
11.9063	.4687	15/32
12.3031	.4844	31/64
12.7000	.5000	1/2
13.0969	.5156	33/64
13.4938	.5312	17/32
13.8906	.5469	35/64
14.2875	.5625	9/16
14.6844	.5781	37/64
15.0813	.5937	19/32
15.4782	.6094	39/64
15.8750	.6250	5/8
16.2719	.6406	41/64
16.6688	.6562	21/32
17.0657	.6719	43/64
17.4625	.6875	11/16
17.8594	.7031	45/64
18.2563	.7187	23/32
18.6532	.7344	47/64
19.0500	.7500	3/4
19.4469	.7645	49/64
19.8438	.7812	25/32
20.2407	.7969	51/64
20.6375	.8125	13/16
21.0344	.8281	53/64
21.4313	.8437	27/32
21.8282	.8594	55/64
22.2250	.8750	7/8
22.6219	.8906	57/64
23.0188	.9062	29/32
23.4157	.9219	59/64
23.8125	.9375	15/16
24.2094	.9531	61/64
24.6063	.9687	31/32
25.0032	.9844	63/64
25.4000	1.000	1

Metric Conversion Table

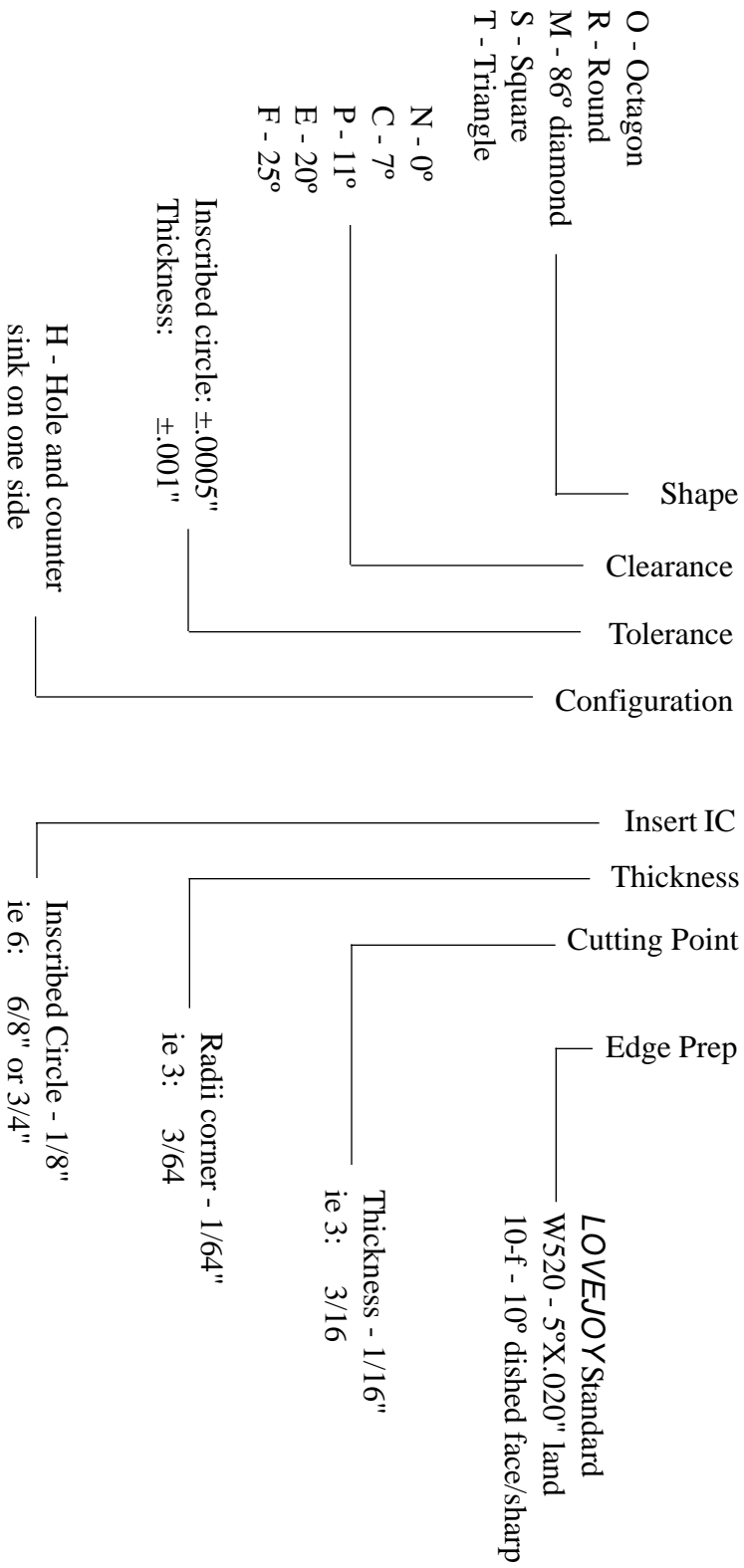
Multiply	By	To Obtain
centimeter	0.0328	foot
centimeter	0.3937	inch
foot	0.30848	meter
foot	304.8	millimeter
inch	0.0254	meter
inch	2.54	centimeter
inch	25.4	millimeter
meter	39.37008	inch
meter	0.54681	fathom
meter	3.28084	foot
meter	1.0936	yard
meter	0.0006214	mile
millimeter	0.00328	foot
millimeter	0.03937	inch
centimeter ²	0.155	inch ²
centimeter ²	0.00107	foot ²
inch ²	645.16	millimeter ²
inch ²	6.4516	centimeter ²
inch ²	0.0064516	meter ²
millimeter ²	0.0000107	foot ²
millimeter ²	0.00155	inch ²
centimeter per second	1.9685	foot per minute
centimeter per second	0.032808	foot per second
foot per minute	0.508	centimeter per second
foot per minute	0.3084	meter per minute
meter per second	196.8504	foot per minute
meter per second	3.2808	foot per second
gram	0.001	kilogram
gram	0.03215	ounce (troy)
kilogram	2.2046	pound
ounce	31.1034	gram
newton	0.22481	pound-force
newton per meter	0.00571	pound per inch
newton per meter ²	1.0	pascal (PA)
newton per mm ²	145.0377	pound per inch ²
pascal	0.000145	pound per inch ²
horsepower	746	watt (W)
kilowatt	1.341	horsepower (550 ft lb)

LOVEJOY Tool Company

Milling Insert Nomenclature

ANSI B212.5-1986 - INCH (shown in Inches)

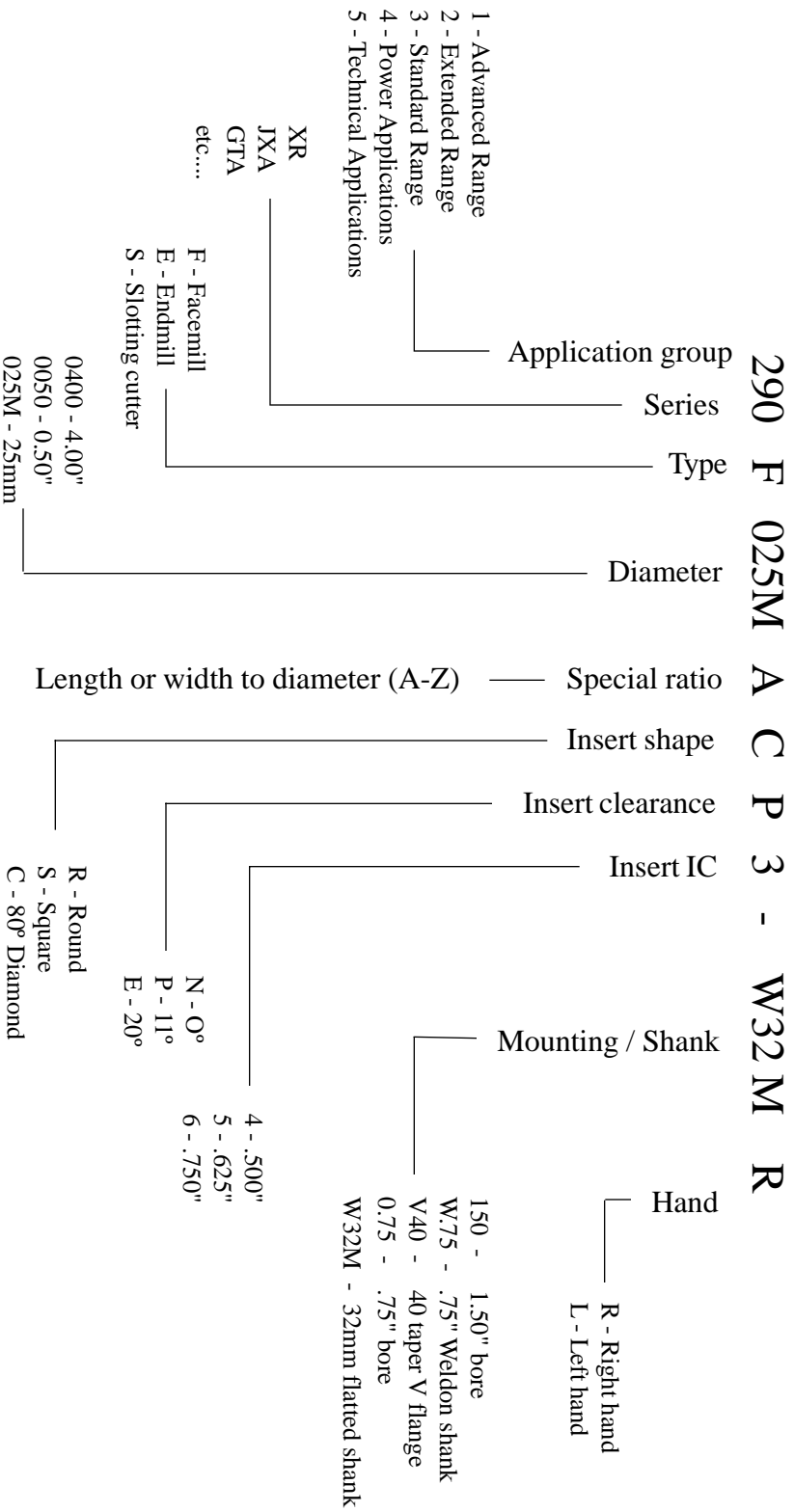
R E C H - 6 3 - W520



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Milling Cutter Nomenclature

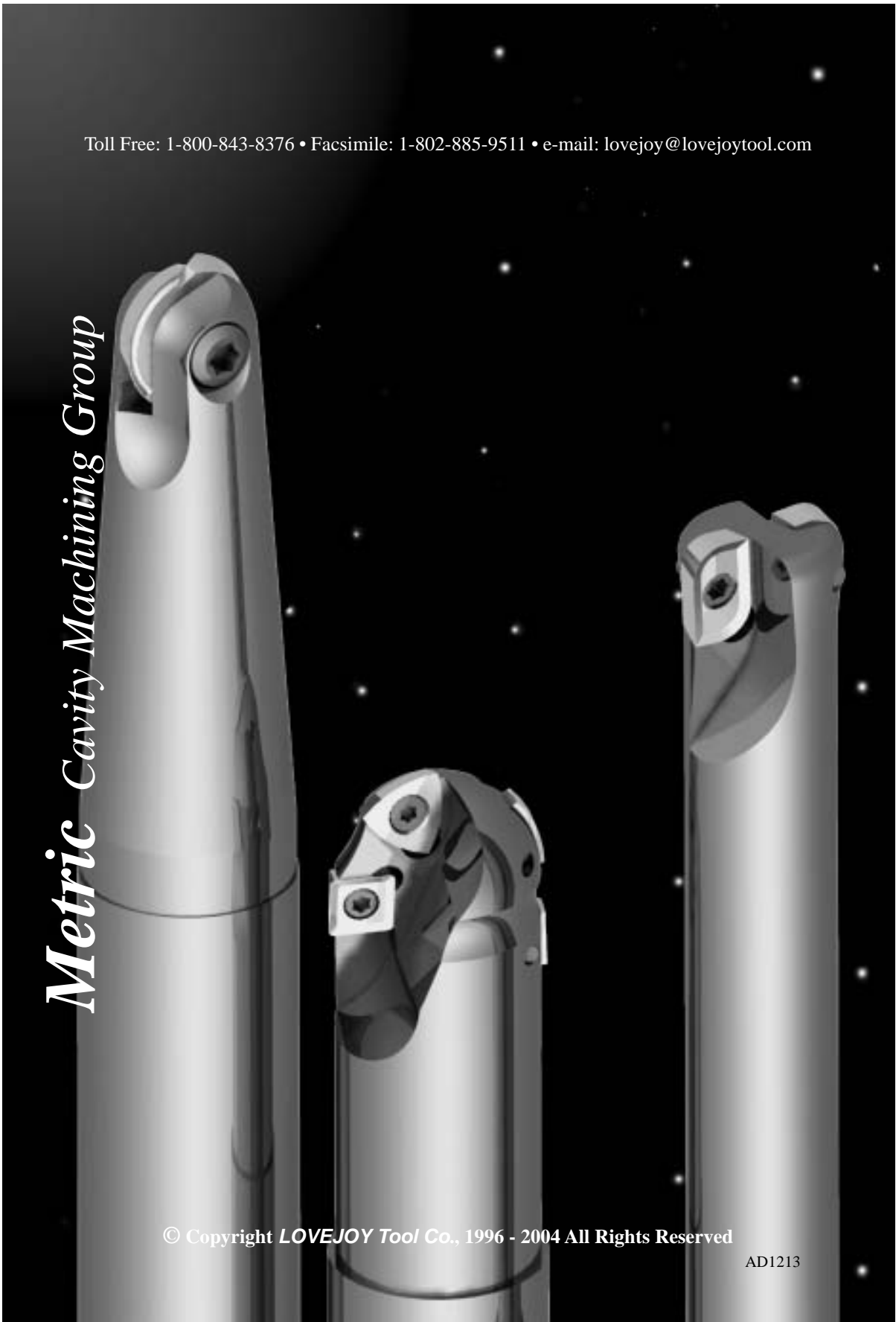
290F025MACP3-W32MR





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Metric Cavity Machining Group



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