

# EXTREME HELIX M60




## 3 High Helix Flutes

For increased metal removal rates  
in highly machinable materials

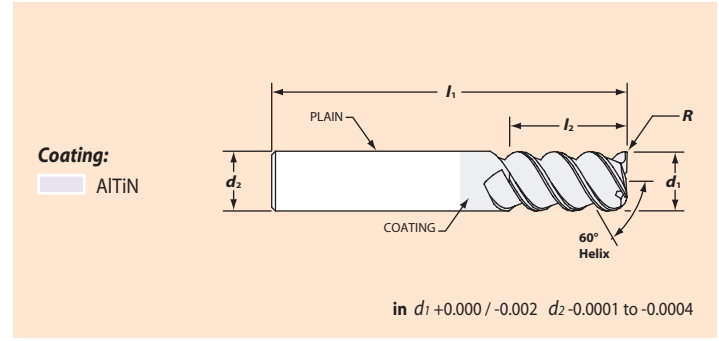
## M603



Extreme helix angle increases cutting edge engagement and prolongs tool life.

	Carbon & tool steels ≤ 48 HRC	✓✓
	Stainless steels	✓
	Cast irons	✓

✓ Good ✓✓ Very Good ✓✓✓ Excellent



- Excellent for profiling operations
- Heat resistant **AlTiN** coating
- High shear geometry with greater edge strength

### Inch

$d_1$ Cutter Dia	$d_2$ Shank Dia	$L_2$ Length of Cut	$L_1$ Overall Length	$R$ Corner Radius	Shank Style	Style Code	AlTiN EDP Number	List Price
1/8	1/8	1/2	1-1/2	Square	Plain	RR	39599	27.82
3/16	3/16	5/8	2	Square	Plain	RR	39128	26.46
1/4	1/4	3/4	2-1/2	Square	Plain	RR	37527	25.25
3/8	3/8	7/8	2-1/2	Square	Plain	RR	37535	41.58
1/2	1/2	1	3	Square	Plain	RR	37539	65.26
5/8	5/8	1-1/4	3-1/2	Square	Plain	RR	37531	124.74
3/4	3/4	1-1/2	4	Square	Plain	RR	97139	179.50

Style Code Reference  
RR—Regular LOC, Regular OAL

### Application Guide • Speed & Feed

Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)			Feed (Inches Per Tooth)					
					AlTiN	TiCN	MG	1/8	1/4	3/8	1/2	5/8	3/4
Cast Iron Gray and Ductile	Slot	.5 x D	1 x D	3	275	275	225	.0012	.0018	.0025	.0030	.0040	.0040
	Rough	1 x D	.5 x D	3	325	325	275	.0014	.0021	.0028	.0035	.0042	.0042
	Finish	1.5 x D	.01 x D	3	375	375	300	.0014	.0021	.0028	.0035	.0042	.0042
Low Carbon Steels ≤ 32 HRc 1018, 12L14, 8620	Slot	.5 x D	1 x D	3	275	250	225	.0012	.0018	.0025	.0030	.0040	.0040
	Rough	1 x D	.5 x D	3	325	300	275	.0014	.0021	.0028	.0035	.0042	.0042
	Finish	1.5 x D	.01 x D	3	375	350	325	.0014	.0021	.0028	.0035	.0042	.0042
Medium Carbon and Tool Steels ≤ 38 HRc	Slot	.5 x D	1 x D	3	275	250	225	.0010	.0015	.0020	.0025	.0030	.0030
	Rough	1 x D	.5 x D	3	325	300	275	.0012	.0018	.0023	.0029	.0035	.0035
	Finish	1.5 x D	.01 x D	3	375	350	325	.0012	.0018	.0025	.0031	.0037	.0037
Carbon and Tool Steels 39 HRc to 48 HRc	Slot	.5 x D	1 x D	3	225	200	175	.0007	.0011	.0015	.0019	.0023	.0023
	Rough	1 x D	.5 x D	3	275	250	225	.0008	.0013	.0018	.0023	.0028	.0028
	Finish	1.5 x D	.01 x D	3	325	300	275	.0008	.0013	.0018	.0023	.0028	.0028
Easy to Machine Stainless Steels 416, 410, 302, 303	Slot	.5 x D	1 x D	3	250	225	200	.0010	.0015	.0020	.0025	.0030	.0030
	Rough	1 x D	.5 x D	3	300	275	250	.0013	.0019	.0025	.0028	.0038	.0038
	Finish	1.5 x D	.01 x D	3	350	325	300	.0014	.0021	.0028	.0035	.0042	.0042
Moderately Difficult Stainless Steels 304, 316, Invar, Kovar	Slot	.5 x D	1 x D	3	250	225	200	.0007	.0011	.0015	.0019	.0023	.0023
	Rough	1 x D	.5 x D	3	275	250	225	.0011	.0017	.0022	.0028	.0035	.0035
	Finish	1.5 x D	.01 x D	3	325	300	275	.0012	.0018	.0025	.0031	.0037	.0037
Difficult to Machine Stainless Steels 316L, 17-4 PH, 15-5 PH, 13-8 PH	Slot	.5 x D	1 x D	3	225	200	175	.0006	.0009	.0012	.0015	.0018	.0018
	Rough	1 x D	.5 x D	3	275	250	225	.0007	.0011	.0015	.0019	.0023	.0023
	Finish	1.5 x D	.01 x D	3	325	300	275	.0011	.0017	.0022	.0028	.0033	.0033

D = tool diameter    Reduce feed rates by 20% when using long length tools    Starting parameters shown