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GRADE AND APPLICATION DETAILS



ALPHA SERIES - α **(45 HRC)**

RAW MATERIAL

YG10X with 10% Co content and 0.8 μ m grain size

COATING

AlTiN, High aluminium content provides excellent hot hardness and Oxidation Resistance

APPLICATION

Low/Medium Carbon Steel / Cast Iron / Aluminium Alloy steel- EN Series / Hardened steel upto 30-45 Hrc



BETA SERIES - β **(55 HRC)**

RAW MATERIAL

ZK30UF with 10% Co content and 0.6 μ m grain size

COATING

TiSN, Very high surface hardness and good wear resistance

APPLICATION

Hardened steel upto 55 Hrc, P20/STAVAX Hot Die Steel, D2 Materials. Aluminium



GAMA SERIES - Y

(65 HRC)

RAW MATERIAL

GU25UF with 12% Co content and 0.4µm grain size

COATING

ALTiSiN, with hardness upto 4000HV & thermal stability upto 1200°C

APPLICATION

*Hardened steel upto 65 Hrc / P20/STAVAX
Hot Die Steel / Stainless Steel*



SIGMA SERIES - Σ

(DLC COATED)

SIGMA SERIES DLC COATED

Special DLC- Diamond like carbon coating for Machining in Aluminium a

APPLICATION

Low/Medium Carbon Steel / Cast Iron / Aluminium Alloy steel- EN Series / Hardened steel upto 30-45 Hrc

4 FLUTE ALPHA SERIES 45 HRC - α

STANDARD LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	12	50
2	4	4	15	50
3	5	5	18	50
4	6	6	18	50
5	6	6	25	75
6	8	8	22	60
7	8	8	30	75
8	10	10	25	75
9	12	12	25	75
10	14	14	45	100
11	16	16	45	100
12	18	18	45	100
13	20	20	50	100



4 FLUTE ALPHA SERIES 45 HRC - α

LONG LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	4	4	28	75
2	5	5	30	100
3	6	6	30	100
4	8	8	40	100
5	10	10	40	100
6	12	12	45	100
7	14	14	60	150
8	16	16	60	150
9	18	18	70	150
10	20	20	60	150

EXTRA LONG

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	28	75
2	4	4	35	100
3	6	6	55	150
4	8	8	55	150
5	10	10	60	150
6	12	12	60	150

4 FLUTE 45 HRC ALPHA SERIES BALL NOSE - α

STANDARD LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	12	50
2	4	4	15	50
3	5	5	18	50
4	6	6	18	50
5	6	6	25	75
6	8	8	22	60
7	8	8	30	75
8	10	10	25	75
9	12	12	25	75

4 FLUTE 45 HRC ALPHA SERIES BALL NOSE - α

LONG LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	4	4	28	75
2	5	5	30	100
3	6	6	30	100
4	8	8	40	100
5	10	10	40	100
6	12	12	45	100

EXTRA LONG

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	28	75
2	4	4	35	100



4 FLUTE 55 HRC BETA SERIES - β

STANDARD LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	12	50
2	4	4	15	50
3	5	5	18	50
4	6	6	18	50
5	6	6	25	75
6	8	8	22	60
7	8	8	30	75
8	10	10	25	75
9	12	12	25	75
10	14	14	45	100
11	16	16	45	100
12	18	18	45	100
13	20	20	50	100



4 FLUTE 55 HRC BETA SERIES - β

LONG LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	4	4	28	75
2	5	5	30	100
3	6	6	30	100
4	8	8	40	100
5	10	10	40	100
6	12	12	45	100
7	14	14	60	150
8	16	16	60	150
9	18	18	70	150
10	20	20	60	150

EXTRA LONG

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	28	75
2	4	4	35	100
3	6	6	55	150
4	8	8	55	150
5	10	10	60	150
6	12	12	60	150

4 FLUTE 55 HRC BETA SERIES BALL NOSE - β

STANDARD LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	12	50
2	4	4	15	50
3	5	5	18	50
4	6	6	18	50
5	6	6	25	75
6	8	8	22	60
7	8	8	30	75
8	10	10	25	75
9	12	12	25	75



4 FLUTE 55 HRC BETA SERIES BALL NOSE - β

LONG LENGTH

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	4	4	28	75
2	5	5	30	100
3	6	6	30	100
4	8	8	40	100
5	10	10	40	100
6	12	12	45	100

EXTRA LONG

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	28	75
2	4	4	35	100



4 FLUTE 55 HRC BETA SERIES CORNER RADIUS - β

STANDARD LENGTH

Sr. No	Flute Dia (mm)	CR (mm)	Shank Dia (mm)	Flute Length (mm)	Total length (mm)
1	1	0.2	4	3	50
2	1.5	0.2	4	4	50
3	2	0.2	4	5	50
4	2	0.5	4	5	50
5	3	0.5	3	8	50
6	3	0.2	4	8	50
7	3	0.5	4	8	50
8	3	1	4	8	50
9	4	0.2	4	10	50
10	4	0.5	4	10	50
11	4	1	4	10	50
12	6	0.2	6	15	50
13	6	0.5	6	15	50
14	6	1	6	15	50
15	8	0.5	8	20	60
16	8	1	8	20	60
17	8	2	8	20	60
18	10	0.5	10	25	75
19	10	1	10	25	75
20	10	2	10	25	75
21	12	0.5	12	30	75
22	12	1	12	30	75
23	4	0.5	4	16	75

to be continued...

Sr. No	Flute Dia (mm)	CR (mm)	Shank Dia (mm)	Flute Length (mm)	Total length (mm)
24	4	1	4	16	75
25	6	0.5	6	25	75
26	6	1	6	25	75
27	8	0.5	8	28	75
28	8	1	8	28	75
29	4	0.5	4	20	100
30	4	1	4	20	100
31	6	0.5	6	30	100
32	6	1	6	30	100
33	8	0.5	8	35	100
34	8	1	8	35	100
35	10	0.5	10	40	100
36	10	1	10	40	100
37	12	0.5	12	45	100
38	12	1	12	45	100
39	6	0.5	6	40	150
40	6	1	6	40	150
41	8	0.5	8	50	150
42	8	1	8	50	150
43	10	0.5	10	50	150
44	10	1	10	50	150
45	12	0.5	12	60	150
46	12	1	12	60	150

4 FLUTE GAMA SERIES 65 HRC - Y

STANDARD

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	1.0	4	3	50
2	1.5	4	4	50
3	2.0	4	5	50
4	2.5	4	6	50
5	3.0	3	8	50
6	3.0	4	8	50
7	3.5	4	9	50
8	4.0	4	10	50
9	5.0	5	12	50
10	5.0	6	12	50
11	6.0	6	15	50
12	8.0	8	20	60
13	10.0	10	25	75
14	12.0	12	30	75
15	14.0	14	40	100
16	16.0	16	40	100
17	18.0	18	40	100
18	20.0	20	40	100

4 FLUTE GAMA SERIES 65 HRC - Y

LONG SERIES

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3.0	3	12	75
2	4.0	4	16	75
3	6.0	6	22	75
4	8.0	8	25	75
5	10.0	10	40	100
6	12.0	12	45	100

EXTRA LONG SERIES

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	12	100
2	4	4	16	100
3	5	5	20	100
4	6	6	24	100
5	8	8	32	100
6	6	6	40	150
7	8	8	50	150
8	10	10	50	150
9	12	12	55	150
10	14	14	60	150
11	16	16	70	150
12	20	20	70	150

3 FLUTE SIGMA SERIES DLC COATED -Σ

STANDARD SERIES

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	1.0	4	3	50
2	1.5	4	5	50
3	2.0	4	6	50
4	2.5	4	8	50
5	3.0	3	9	50
6	3.0	4	9	50
7	3.5	4	12	50
8	4.0	4	12	50
9	5.0	5	15	50
10	5.0	6	15	50
11	6.0	6	18	50
12	8.0	8	24	60
13	10.0	10	30	75
14	12.0	12	36	75
15	14.0	14	45	100
16	16.0	16	45	100
17	18.0	18	45	100
18	20.0	20	45	100



3 FLUTE SIGMA SERIES DLC COATED -Σ

LONG SERIES

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	15	100
2	4	4	25	100
3	5	5	25	100
4	6	6	30	100
5	6	6	40	150
6	8	8	40	100
7	8	8	50	150
8	10	10	50	150
9	12	12	60	150

EXTRA LONG SERIES

Sr. No	Flute Dia _(mm)	Shank Dia _(mm)	Flute Length _(mm)	Total length _(mm)
1	3	3	15	100
2	4	4	25	100
3	5	5	25	100
4	6	6	30	100
5	8	8	40	150
6	6	6	40	150
7	8	8	50	150
8	10	10	50	150
9	12	12	60	150





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