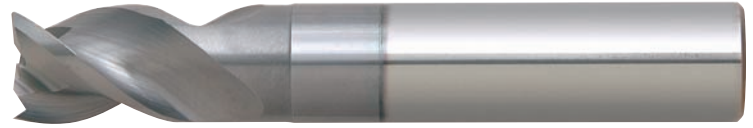


A340 / AN340

Solid Carbide End Mills for Aluminum Applications

- Cylindrical land to reduce chatter
- Both roughing and finishing capabilities
- 3 flute design for smoother/quieter milling operations
- Maximum 1XD axial depth of cut for HSM applications
- Wiper flat on end teeth for improved surface finish on the floor of part



Price Code E

Flute Dia	Shank Dia	Length of Cut	OAL	Reach Length	Neck Dia	Radius	Unc EDP	TiCN EDP
3/16	3/16	1/4	2	-	-	0.010	57880	57909
3/16	3/16	1/4	2	9/16	0.178	0.010	57881	57910
3/16	3/16	1/4	3	1-9/16	0.178	0.010	57882	57911
1/4	1/4	5/16	2 1/2	-	-	0.010	57883	57912
1/4	1/4	5/16	2-1/2	3/4	0.240	0.010	57884	57913
1/4	1/4	5/16	3-1/4	1-3/4	0.240	0.010	57885	57914
3/8	3/8	1/2	2 1/2	-	-	0.015	57886	57915
3/8	3/8	1/2	3	-	-	0.015	57887	57916
3/8	3/8	1/2	2-1/2	7/8	0.360	0.015	57888	57917
3/8	3/8	1/2	3	1-3/8	0.360	0.015	57889	57918
3/8	3/8	1/2	4	2-3/8	0.360	0.015	57890	57919
1/2	1/2	5/8	3	-	-	0.020	57891	57920
1/2	1/2	5/8	4	-	-	0.020	57892	57921
1/2	1/2	5/8	3	1-1/8	0.480	0.020	57893	57922
1/2	1/2	5/8	4	2-1/8	0.480	0.020	57894	57923
1/2	1/2	5/8	5	3-1/8	0.480	0.020	57895	57924
5/8	5/8	3/4	3 1/2	-	-	0.025	57896	57925
5/8	5/8	3/4	3-1/2	1-1/2	0.600	0.025	57897	57926
5/8	5/8	3/4	5	2-1/2	0.600	0.025	57898	57927
3/4	3/4	1	4	-	-	0.030	57899	57928
3/4	3/4	1	5	-	-	0.030	57900	57929
3/4	3/4	1	4	1-7/8	0.720	0.030	57901	57930
3/4	3/4	1	5	2-7/8	0.720	0.030	57902	57931
3/4	3/4	1	6	3-7/8	0.720	0.030	57903	57932
1	1	1 1/4	4	-	-	0.040	57904	57933
1	1	1 1/4	5	-	-	0.040	57905	57934
1	1	1 1/4	4	1-5/8	0.960	0.040	57906	57935
1	1	1 1/4	5	2-5/8	0.960	0.040	57907	57936
1	1	1 1/4	6	3-5/8	0.960	0.040	57908	57937

A340 TiCN Coated Recommended Starting Point Speeds and Feeds (Slotting 1XD)																
Material	SFPM	1/4" Diameter			3/8" Diameter			1/2" Diameter			3/4" Diameter			1" Diameter		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Aluminum Alloys																
6061-T6	1400	21,392	0.0060	385.1	14,261	0.0090	385.1	10,696	0.0120	385.1	7,131	0.0150	320.9	5,348	0.0180	288.8
7075-T6	1200	18,336	0.0060	330.0	12,224	0.0090	330.0	9,168	0.0120	330.0	6,112	0.0150	275.0	4,584	0.0180	247.5

A340 TiCN Coated Recommended Starting Point Speeds and Feeds (Profiling .25XD)																
Material	SFPM	1/4" Diameter			3/8" Diameter			1/2" Diameter			3/4" Diameter			1" Diameter		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Aluminum Alloys																
6061-T6	1400	21,392	0.0100	641.8	14,261	0.0150	641.8	10,696	0.0200	641.8	7,131	0.0250	534.8	5,348	0.0300	481.3
7075-T6	1200	18,336	0.0100	550.1	12,224	0.0150	550.1	9,168	0.0200	550.1	6,112	0.0250	458.4	4,584	0.0300	412.6



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A345R



- Full Radius Program
- Cylindrical land to reduce chatter
- Both roughing and finishing capabilities
- 3 Flute design for smoother/quieter milling operations
- Wiper flat on end teeth for improved surface finish on the floor of part

Price Code E

Flute Dia	Shank Dia	LOC	OAL	0.010 Radius	0.015 Radius	0.020 Radius	0.030 Radius	0.045 Radius	0.060 Radius	0.090 Radius	0.125 Radius	0.190 Radius
				TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP	TiCN EDP
1/8	1/8	3/8	1 1/2	61627-010	61627-015	61627-020	61627-030	-	-	-	-	-
5/32	3/16	1/2	2	61629-010	61629-015	61629-020	61629-030	-	-	-	-	-
3/16	3/16	9/16	2	61631-010	61631-015	61631-020	61631-030	-	-	-	-	-
7/32	1/4	3/4	2 1/2	61633-010	61633-015	61633-020	61633-030	-	-	-	-	-
1/4	1/4	3/4	2 1/2	61635-010	61635-015	61635-020	61635-030	61635-045	61635-060	-	-	-
9/32	5/16	13/16	2 1/2	61638-010	61638-015	61638-020	61638-030	61638-045	61638-060	-	-	-
5/16	5/16	13/16	2 1/2	61640-010	61640-015	61640-020	61640-030	61640-045	61640-060	-	-	-
5/16	5/16	2 1/4	4	61642-010	61642-015	61642-020	61642-030	61642-045	61642-060	-	-	-
11/32	3/8	1	2 1/2	61644-010	61644-015	61644-020	61644-030	61644-045	61644-060	-	-	-
3/8	3/8	1	2 1/2	61646-010	61646-015	61646-020	61646-030	61646-045	61646-060	-	-	-
13/32	7/16	1	2 3/4	61649-010	61649-015	61649-020	61649-030	61649-045	61649-060	-	-	-
7/16	7/16	1	2 3/4	61651-010	61651-015	61651-020	61651-030	61651-045	61651-060	61651-090	61651-125	-
15/32	1/2	1 1/4	3	61653-010	61653-015	61653-020	61653-030	61653-045	61653-060	61653-090	61653-125	-
1/2	1/2	5/8	3	61654-010	61654-015	61654-020	61654-030	61654-045	61654-060	61654-090	61654-125	-
1/2	1/2	1 1/4	3	61655-010	61655-015	61655-020	61655-030	61655-045	61655-060	61655-090	61655-125	-
1/2	1/2	2	4	61656-010	61655-015	61656-020	61656-030	61656-045	61656-060	61656-090	61656-125	-
1/2	1/2	3 1/8	6	61657-010	61657-015	61657-020	61657-030	61657-045	61657-060	61657-090	61657-125	-
5/8	5/8	1 5/8	3 1/2	61659-010	61659-015	61659-020	61659-030	61659-045	61659-060	61659-090	61659-125	-
5/8	5/8	3 3/4	6	61661-010	61661-015	61661-020	61661-030	61661-045	61661-060	61661-090	61661-125	-
3/4	3/4	1	3	61662-010	61666-015	61662-020	61662-030	61662-045	61662-060	61662-090	61662-125	61662-190
3/4	3/4	2 1/4	5	61664-010	61662-015	61664-020	61664-030	61664-045	61664-060	61664-090	61664-125	61664-190
3/4	3/4	4	6 1/2	61666-010	61664-015	61666-020	61666-030	61666-045	61666-060	61666-090	61666-125	61666-190
1	1	2 5/8	6	61669-010	61669-015	61669-020	61669-030	61669-045	61669-060	61669-090	61669-125	61669-190
1	1	4 1/8	7	61671-010	61671-015	61671-020	61671-030	61671-045	61671-060	61671-090	61671-125	61671-190

A345R TiCN Coated Recommended Starting Point Speeds and Feeds (Slotting 1XD)

Material	SFPM	1/4" Diameter				3/8" Diameter				1/2" Diameter			3/4" Diameter			1" Diameter			
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Aluminum Alloys																			
6061-T6	1400	21,392	0.0045	288.8	14,261	0.0068	288.8	10,696	0.0090	288.8	7,131	0.0113	240.7	5,348	0.0135	216.6			
7075-T6	1200	18,336	0.0045	247.5	12,224	0.0068	247.5	9,168	0.0090	247.5	6,112	0.0113	206.3	4,584	0.0135	185.7			

A345R TiCN Coated Recommended Starting Point Speeds and Feeds (Profiling .25XD)

Material	SFPM	1/4" Diameter				3/8" Diameter				1/2" Diameter			3/4" Diameter			1" Diameter			
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Aluminum Alloys																			
6061-T6	1400	21,392	0.0075	481.3	14,261	0.0113	481.3	10,696	0.0150	481.3	7,131	0.0188	401.1	5,348	0.0225	361.0			
7075-T6	1200	18,336	0.0075	412.6	12,224	0.0113	412.6	9,168	0.0150	412.6	6,112	0.0188	343.8	4,584	0.0225	309.4			