

CoroMill® Dura

- WhisperKut solid carbide endmills

A complete inch assortment of solid carbide end mills using WhisperKut technology



Milling

CoroMill® Dura

CoroMill® Dura, Solid carbide end mill in 3 flutes	
WhisperKut, Multimaterial	7-8
WhisperKut, Ball Nose, Multimaterial	9
CoroMill® Dura, Solid carbide end mill in 4 flutes	
WhisperKut, Multimaterial	10-13
WhisperKut, Ball Nose, Multimaterial	14
CoroMill® Dura, Solid carbide end mill in 5 flutes	
WhisperKut, Multimaterial	15-18
CoroMill® Dura, Solid carbide end mill in 7 flutes	
WhisperKut, Multimaterial	19-20
CoroMill® Dura, Solid carbide end mill in 3 flutes	
WhisperKut, For Aluminum	21-25
WhisperKut, Ball Nose, For Aluminum	26-27
Cutting data	28-31

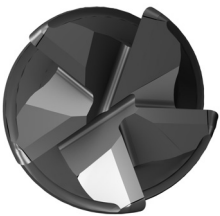
Patented WhisperKut technology

CoroMill® Dura is a complete range of inch solid carbide end mills that implement the patented WhisperKut technology.

WhisperKut is a technology able to significantly break up harmonics, reduce chatter and vibration.



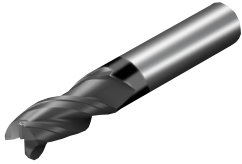
Each cutting flute is oriented at a different helix angle with respect to all remaining flutes, allowing good stability and effectiveness in eliminating harmful harmonics.



Each flute is unequally spaced from the others, reducing the constant harmonics typically produced with conventional end mills.

CoroMill® Dura overview

WhisperKut Multi-material



- 3-Flute design for heavy profile and slotting operations



- 4-Flute design suitable for plunging, pocketing and for 15°-45° ramping

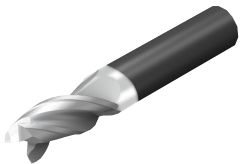


- 5-Flute design for roughing and finishing applications



- 7-Flute design for high feed milling and finishing applications

WhisperKut Aluminum

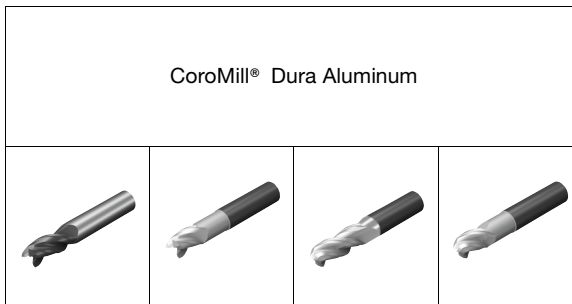


- 3-Flute design for aluminum, allowing for both heavy profile and slotting applications
- Advanced cutter geometry with wiper flats for improved floor finish
- Available coated and uncoated

Tool overview










Material	For multi-materials					
ISO application area	P M K S H	P M K S H	P M K S H	P M K S H	P M K S H	P M K S H
D_2 inch	.125 - 1.000	.125 - .500	.125 - 1.000	.125 - 1.000	.125 - 1.000	.375 - 1.000
APMX/DC	1.17 - 3.0xDC	1.25 - 3.0xDC	1.20 - 5.0xDC	1.20 - 5.0xDC	1.17 - 5.0xDC	1.20 - 4.0xDC
Face geometry	Straight	Ball nose	Straight	Ball nose	Straight	Straight
ZEFP	3	3	4	4	5	7
Shank	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical
FHA (ave.)	38°	38°	36.5°	36.5°	36°	36.5°
GAMF	9°	9°	9°	9°	9°	10°
Grade	X1BH	X1BH	X1BH	X1BH	X1BH	X1BH
Page	7-8	9	10-13	14	15-18	19-20



Material	For aluminum			
ISO application area	N	N	N	N
D_2 inch	.125 - 1.000	.188 - 1.000	.188 - 1.000	.188 - 1.000
APMX/DC	1.25 - 4.0xDC	1.20 - 1.5xDC	2.0 - 4.0xDC	1.20 - 1.5xDC
Face geometry	Straight	Straight, with neck	Ball nose	Ball nose, with neck
ZEFP	3	3	3	3
Shank	Cylindrical	Cylindrical	Cylindrical	Cylindrical
FHA (ave.)	35°	35°	35°	35°
GAMF	13°	11°	13°	11°
Grade	H10F, N1BZ	H10F, N1BZ	H10F, N1BZ	H10F, N1BZ
Page	21-23	26	24-23	27

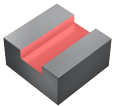


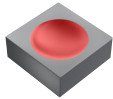




Application guide

Product family								P	M	K	N	S	H
WhisperKut 3 flutes	•	•	•	•	•	•	•	•	•	•	•	•	•
WhisperKut 4 flutes	•	•	•	•	•	•	•	•	•	•	•	•	•
WhisperKut 5 flutes	•	•		•	•			•	•	•		•	•
WhisperKut 7 flutes		•						•	•	•		•	•
WhisperKut Aluminum	•	•	•	•	•	•	•				•		

Grades for CoroMill® Dura

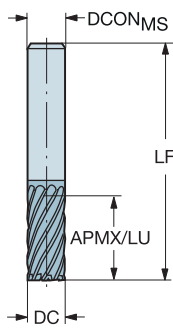
	P	M	K	N	S	H	Description
X1BH	+	+	+			+	Versatile grade for a wide variety of metal-cutting applications. Contains sub-micron substrate with excellent combination of strength, wear resistance, and toughness with universal AlTiN-based high performance coating.
N1BZ				+			Coated grade for machining ISO N materials. Contains sub-micron substrate and ZrN-based coating capable to effectively reduce the built-up edge formation when machining aluminum alloys.
H10F				+			Uncoated grade for machining ISO N materials.

Operation symbols

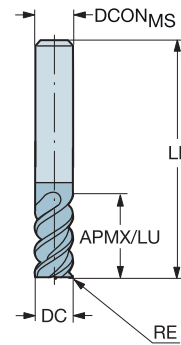
<p>Slot milling</p> 	<p>Shoulder milling</p> 	<p>Face milling</p> 	<p>Profile milling</p> 
<p>Helical interpolation</p> 	<p>Ramping</p> 	<p>Plunge milling</p> 	<p>Pocket milling</p> 

ISO definitions

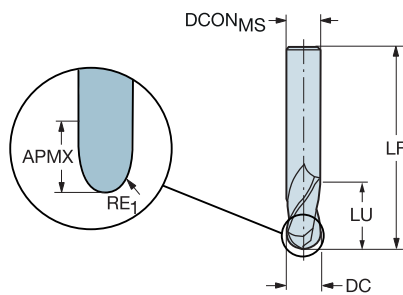
Straight



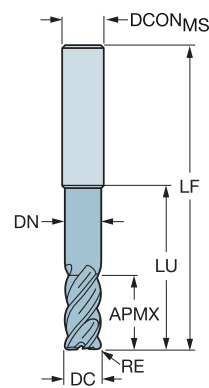
Straight - Corner radius



Ball Nose



Neck

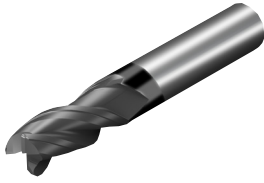


Short name	Preferred Name
APMX	Depth of cut maximum
CZC _{MS}	Connection size code machine side
DC	Cutting diameter
DCON _{MS}	Connection diameter machine side
DN	Neck diameter
FHA	Flute helix angle
GAMF	Radial rake angle
LF	Functional length
LU	Usable length (max. recommended)
RE	Corner radius
TCDCON	Connection diameter tolerance
ZAFP	Peripheral effective cutting edge count (ZAFP)

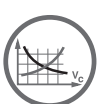
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, Multimaterial

3 Flute
TDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch							
							P	M	K	S	H	DCON _{MS}	LF	DN
							X BH	X BH	X BH	X BH	X BH			
.125	.125	.250		.250	3	WK-S-30125	*	*	*	*	*	.125	1.500	
	.125	.250	.013	.250	3	WK-S-30125-R013	*	*	*	*	*	.125	1.500	
	.125	.375		.375	3	WK-30125	*	*	*	*	*	.125	1.500	
	.125	.375	.013	.375	3	WK-30125-R013	*	*	*	*	*	.125	1.500	
.156	.188	.438		.438	3	WK-30156	*	*	*	*	*	.188	2.000	
	.188	.438	.013	.438	3	WK-30156-R013	*	*	*	*	*	.188	2.000	
.188	.188	.313		.313	3	WK-S-30188	*	*	*	*	*	.188	1.500	
	.188	.313	.013	.313	3	WK-S-30188-R013	*	*	*	*	*	.188	1.500	
	.188	.438		.438	3	WK-30188	*	*	*	*	*	.188	2.000	
	.188	.438	.013	.438	3	WK-30188-R013	*	*	*	*	*	.188	2.000	
.219	.250	.438		.438	3	WK-30219	*	*	*	*	*	.250	2.500	
	.250	.438	.018	.438	3	WK-30219-R018	*	*	*	*	*	.250	2.500	
.250	.250	.375		.375	3	WK-S-30250	*	*	*	*	*	.250	2.000	
	.250	.375	.018	.375	3	WK-S-30250-R018	*	*	*	*	*	.250	2.000	
	.250	.375	.018	.375	3	WK-ER-30250-R018	*	*	*	*	*	.250	4.000	
	.250	.375	.018	2.125	3	WK-ERN-30250-R018	*	*	*	*	*	.250	4.000	.235
	.250	.625		.625	3	WK-30250	*	*	*	*	*	.250	2.500	
	.250	.625	.018	.625	3	WK-30250-R018	*	*	*	*	*	.250	2.500	
.281	.313	.625	.018	.625	3	WK-30281-R018	*	*	*	*	*	.313	2.500	
.313	.313	.500		.500	3	WK-S-30313	*	*	*	*	*	.313	2.000	
	.313	.500	.018	.500	3	WK-S-30313-R018	*	*	*	*	*	.313	2.000	
	.313	.750		.750	3	WK-30313	*	*	*	*	*	.313	2.500	
	.313	.750	.018	.750	3	WK-30313-R018	*	*	*	*	*	.313	2.500	
.375	.375	.500		.500	3	WK-S-30375	*	*	*	*	*	.375	2.000	
	.375	.500	.018	.500	3	WK-S-30375-R018	*	*	*	*	*	.375	2.000	
	.375	.500	.018	.500	3	WK-ER-S-30375-R018	*	*	*	*	*	.375	4.000	
	.375	.500	.018	.500	3	WK-ER-30375-R018	*	*	*	*	*	.375	6.000	
	.375	.500	.018	2.125	3	WK-ERN-S-30375-R018	*	*	*	*	*	.375	4.000	.355
	.375	.500	.018	3.375	3	WK-ERN-30375-R018	*	*	*	*	*	.375	6.000	.355
	.375	1.000		1.000	3	WK-30375	*	*	*	*	*	.375	2.500	
	.375	1.000	.018	1.000	3	WK-30375-R018	*	*	*	*	*	.375	2.500	
.438	.438	1.000		1.000	3	WK-30438	*	*	*	*	*	.438	2.750	
	.438	1.000	.018	1.000	3	WK-30438-R018	*	*	*	*	*	.438	2.750	
.500	.500	.625		.625	3	WK-S-30500	*	*	*	*	*	.500	2.500	
	.500	.625	.028	.625	3	WK-S-30500-R028	*	*	*	*	*	.500	2.500	
	.500	.625	.028	.625	3	WK-ER-S-30500-R028	*	*	*	*	*	.500	4.000	
	.500	.625	.028	.625	3	WK-ER-30500-R028	*	*	*	*	*	.500	6.000	
	.500	.625	.028	2.125	3	WK-ERN-S-30500-R028	*	*	*	*	*	.500	4.000	.470
	.500	.625	.028	4.000	3	WK-ERN-30500-R028	*	*	*	*	*	.500	6.000	.470
	.500	1.000		1.000	3	WK-30500	*	*	*	*	*	.500	3.000	
	.500	1.000	.028	1.000	3	WK-30500-R028	*	*	*	*	*	.500	3.000	
	.500	1.250		1.250	3	WK-M-30500	*	*	*	*	*	.500	3.000	
	.500	1.250	.028	1.250	3	WK-M-30500-R028	*	*	*	*	*	.500	3.000	
.625	.625	.750		.750	3	WK-S-30625	*	*	*	*	*	.625	3.000	
	.625	.750	.033	.750	3	WK-S-30625-R033	*	*	*	*	*	.625	3.000	
	.625	.750	.033	.750	3	WK-ER-S-30625-R033	*	*	*	*	*	.625	5.000	
	.625	.750	.033	.750	3	WK-ER-30625-R033	*	*	*	*	*	.625	6.000	
	.625	.750	.033	2.125	3	WK-ERN-S-30625-R033	*	*	*	*	*	.625	5.000	.590
	.625	.750	.033	4.000	3	WK-ERN-30625-R033	*	*	*	*	*	.625	6.000	.590
	.625	1.250		1.250	3	WK-30625	*	*	*	*	*	.625	3.500	
	.625	1.250	.033	1.250	3	WK-30625-R033	*	*	*	*	*	.625	3.500	



28



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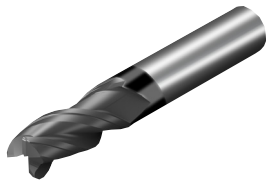
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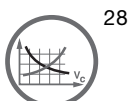
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, Multimaterial

3 Flute
TCDCON h6
Asymmetrical Variable Helix



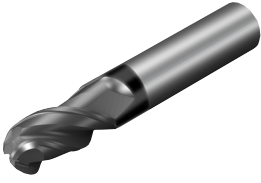
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	P M K S H					Dimensions, inch			
							X BH	X BH	X BH	X BH	X BH	DCON _{MS}	LF	DN	
.750	.750	.875		.875	3	WK-S-30750	*	*	*	*	*	.750	3.000		
	.750	.875	.033	.875	3	WK-S-30750-R033	*	*	*	*	*	.750	3.000		
	.750	.875	.033	.875	3	WK-ER-S-30750-R033	*	*	*	*	*	.750	5.000		
	.750	.875	.033	.875	3	WK-ER-30750-R033	*	*	*	*	*	.750	6.000		
	.750	.875	.033	3.000	3	WK-ERN-S-30750-R033	*	*	*	*	*	.750	5.000	.715	
	.750	.875	.033	4.000	3	WK-ERN-30750-R033	*	*	*	*	*	.750	6.000	.715	
	.750	1.500		1.500	3	WK-30750	*	*	*	*	*	.750	4.000		
	.750	1.500	.033	1.500	3	WK-30750-R033	*	*	*	*	*	.750	4.000		
	1.000	1.000	1.250	.033	1.250	3	WK-ER-S-31000-R033	*	*	*	*	*	1.000	5.000	
		1.000	1.250	.033	1.250	3	WK-ER-31000-R033	*	*	*	*	*	1.000	6.000	
1.000		1.250	.033	3.000	3	WK-ERN-S-31000-R033	*	*	*	*	*	1.000	5.000	.960	
1.000		1.250	.033	4.000	3	WK-ERN-31000-R033	*	*	*	*	*	1.000	6.000	.960	
1.000		1.500	.033	1.500	3	WK-31000-R033	*	*	*	*	*	1.000	4.000		



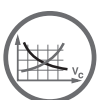
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WhisperKut, Ball Nose, Multimaterial

3 Flute
TCDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch							
							P	M	K	S	H	DCON _{MS}	LF	DN
							X	X	X	X	X			
							IBH	IBH	IBH	IBH	IBH			
.125	.125	.375	.063	.375	3	WK-BN-30125	*	*	*	*	*	.125	1.500	
.156	.188	.438	.078	.438	3	WK-BN-30156	*	*	*	*	*	.188	2.000	
.188	.188	.438	.094	.438	3	WK-BN-30188	*	*	*	*	*	.188	2.000	
.219	.250	.438	.109	.438	3	WK-BN-30219	*	*	*	*	*	.250	2.500	
.250	.250	.375	.125	.375	3	WK-ER-BN-30250	*	*	*	*	*	.250	4.000	
	.250	.375	.125	2.125	3	WK-ERN-BN-30250	*	*	*	*	*	.250	4.000	.235
	.250	.625	.125	.625	3	WK-BN-30250	*	*	*	*	*	.250	2.500	
.281	.313	.625	.141	.625	3	WK-BN-30281	*	*	*	*	*	.313	2.500	
.313	.313	.750	.156	.750	3	WK-BN-30313	*	*	*	*	*	.313	2.500	
.375	.375	.500	.188	.500	3	WK-ER-BN-30375	*	*	*	*	*	.375	6.000	
	.375	.500	.188	3.375	3	WK-ERN-BN-30375	*	*	*	*	*	.375	6.000	.355
	.375	1.000	.188	1.000	3	WK-BN-30375	*	*	*	*	*	.375	2.500	
.438	.438	1.000	.219	1.000	3	WK-BN-30438	*	*	*	*	*	.438	2.750	
.500	.500	.625	.250	.625	3	WK-ER-BN-30500	*	*	*	*	*	.500	6.000	
	.500	.625	.250	4.000	3	WK-ERN-BN-30500	*	*	*	*	*	.500	6.000	.470
	.500	1.000	.250	1.000	3	WK-BN-30500	*	*	*	*	*	.500	3.000	



28



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32

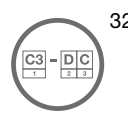
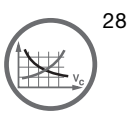
CoroMill® Dura, Solid carbide end mill in 4 flutes

WhisperKut, Multimaterial

4 Flute
TCD CON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch						
							P	M	K	S	H	DCON _{MS}	LF
							X B H	X B H	X B H	X B H	X B H		
.125	.125	.250		.250	4	WK-II-S-40125	*	*	*	*	*	.125	1.500
	.125	.250	.010	.250	4	WK-II-S-40125-R010	*	*	*	*	*	.125	1.500
	.125	.250	.015	.250	4	WK-II-S-40125-R015	*	*	*	*	*	.125	1.500
	.125	.500		.500	4	WK-II-40125	*	*	*	*	*	.125	2.000
	.125	.500	.010	.500	4	WK-II-40125-R010	*	*	*	*	*	.125	2.000
	.125	.500	.015	.500	4	WK-II-40125-R015	*	*	*	*	*	.125	2.000
.188	.188	.313		.313	4	WK-II-S-40188	*	*	*	*	*	.188	2.000
	.188	.313	.010	.313	4	WK-II-S-40188-R010	*	*	*	*	*	.188	2.000
	.188	.313	.015	.313	4	WK-II-S-40188-R015	*	*	*	*	*	.188	2.000
	.188	.625		.625	4	WK-II-40188	*	*	*	*	*	.188	2.000
	.188	.625	.010	.625	4	WK-II-40188-R010	*	*	*	*	*	.188	2.000
	.188	.625	.015	.625	4	WK-II-40188-R015	*	*	*	*	*	.188	2.000
.250	.250	.375		.375	4	WK-II-S-40250	*	*	*	*	*	.250	2.000
	.250	.375	.010	.375	4	WK-II-S-40250-R010	*	*	*	*	*	.250	2.000
	.250	.375	.015	.375	4	WK-II-S-40250-R015	*	*	*	*	*	.250	2.000
	.250	.375	.030	.375	4	WK-II-S-40250-R030	*	*	*	*	*	.250	2.000
	.250	.375	.060	.375	4	WK-II-S-40250-R060	*	*	*	*	*	.250	2.000
	.250	.625		.625	4	WK-II-40250	*	*	*	*	*	.250	2.500
	.250	.625	.010	.625	4	WK-II-40250-R010	*	*	*	*	*	.250	2.500
	.250	.625	.015	.625	4	WK-II-40250-R015	*	*	*	*	*	.250	2.500
	.250	.625	.030	.625	4	WK-II-40250-R030	*	*	*	*	*	.250	2.500
	.250	.625	.060	.625	4	WK-II-40250-R060	*	*	*	*	*	.250	2.500
	.250	1.000		1.000	4	WK-II-M-40250	*	*	*	*	*	.250	3.000
	.250	1.000	.010	1.000	4	WK-II-M-40250-R010	*	*	*	*	*	.250	3.000
	.250	1.000	.015	1.000	4	WK-II-M-40250-R015	*	*	*	*	*	.250	3.000
	.250	1.000	.030	1.000	4	WK-II-M-40250-R030	*	*	*	*	*	.250	3.000
	.250	1.000	.060	1.000	4	WK-II-M-40250-R060	*	*	*	*	*	.250	3.000
	.250	1.250		1.250	4	WK-II-L-40250	*	*	*	*	*	.250	3.000
	.250	1.250	.010	1.250	4	WK-II-L-40250-R010	*	*	*	*	*	.250	3.000
	.250	1.250	.015	1.250	4	WK-II-L-40250-R015	*	*	*	*	*	.250	3.000
	.250	1.250	.030	1.250	4	WK-II-L-40250-R030	*	*	*	*	*	.250	3.000
	.250	1.250	.060	1.250	4	WK-II-L-40250-R060	*	*	*	*	*	.250	3.000
.313	.313	.500		.500	4	WK-II-S-40313	*	*	*	*	*	.313	2.000
	.313	.500	.015	.500	4	WK-II-S-40313-R015	*	*	*	*	*	.313	2.000
	.313	.500	.030	.500	4	WK-II-S-40313-R030	*	*	*	*	*	.313	2.000
	.313	.500	.060	.500	4	WK-II-S-40313-R060	*	*	*	*	*	.313	2.000
	.313	.750		.750	4	WK-II-40313	*	*	*	*	*	.313	2.500
	.313	.750	.015	.750	4	WK-II-40313-R015	*	*	*	*	*	.313	2.500
	.313	.750	.030	.750	4	WK-II-40313-R030	*	*	*	*	*	.313	2.500
	.313	.750	.060	.750	4	WK-II-40313-R060	*	*	*	*	*	.313	2.500
	.313	1.250		1.250	4	WK-II-M-40313	*	*	*	*	*	.313	3.000
	.313	1.250	.015	1.250	4	WK-II-M-40313-R015	*	*	*	*	*	.313	3.000
	.313	1.250	.030	1.250	4	WK-II-M-40313-R030	*	*	*	*	*	.313	3.000
	.313	1.250	.060	1.250	4	WK-II-M-40313-R060	*	*	*	*	*	.313	3.000



CoroMill® Dura, Solid carbide end mill in 4 flutes

WhisperKut, Multimaterial

4 Flute
TDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch							
							P	M	K	S	H	DCON _{MS}	LF	
.375	.375	.500		.500	4	WK-II-S-40375	*	*	*	*	*	.375	2.000	
	.375	.500	.015	.500	4	WK-II-S-40375-R015	*	*	*	*	*	.375	2.000	
	.375	.500	.030	.500	4	WK-II-S-40375-R030	*	*	*	*	*	.375	2.000	
	.375	.500	.060	.500	4	WK-II-S-40375-R060	*	*	*	*	*	.375	2.000	
	.375	.500	.090	.500	4	WK-II-S-40375-R090	*	*	*	*	*	.375	2.000	
	.375	.500	.125	.500	4	WK-II-S-40375-R125	*	*	*	*	*	.375	2.000	
	.375	1.000		1.000	4	WK-II-40375	*	*	*	*	*	.375	2.500	
	.375	1.000	.015	1.000	4	WK-II-40375-R015	*	*	*	*	*	.375	2.500	
	.375	1.000	.030	1.000	4	WK-II-40375-R030	*	*	*	*	*	.375	2.500	
	.375	1.000	.060	1.000	4	WK-II-40375-R060	*	*	*	*	*	.375	2.500	
	.375	1.000	.090	1.000	4	WK-II-40375-R090	*	*	*	*	*	.375	2.500	
	.375	1.000	.125	1.000	4	WK-II-40375-R125	*	*	*	*	*	.375	2.500	
	.375	1.250		1.250	4	WK-II-M-40375	*	*	*	*	*	.375	3.000	
	.375	1.250	.015	1.250	4	WK-II-M-40375-R015	*	*	*	*	*	.375	3.000	
	.375	1.250	.030	1.250	4	WK-II-M-40375-R030	*	*	*	*	*	.375	3.000	
	.375	1.250	.060	1.250	4	WK-II-M-40375-R060	*	*	*	*	*	.375	3.000	
	.375	1.250	.090	1.250	4	WK-II-M-40375-R090	*	*	*	*	*	.375	3.000	
	.375	1.250	.125	1.250	4	WK-II-M-40375-R125	*	*	*	*	*	.375	3.000	
	.500	.500	.625		.625	4	WK-II-S-40500	*	*	*	*	*	.500	2.500
		.500	.625	.015	.625	4	WK-II-S-40500-R015	*	*	*	*	*	.500	2.500
.500		.625	.030	.625	4	WK-II-S-40500-R030	*	*	*	*	*	.500	2.500	
.500		.625	.060	.625	4	WK-II-S-40500-R060	*	*	*	*	*	.500	2.500	
.500		.625	.090	.625	4	WK-II-S-40500-R090	*	*	*	*	*	.500	2.500	
.500		.625	.125	.625	4	WK-II-S-40500-R125	*	*	*	*	*	.500	2.500	
.500		1.000		1.000	4	WK-II-40500	*	*	*	*	*	.500	3.000	
.500		1.000	.015	1.000	4	WK-II-40500-R015	*	*	*	*	*	.500	3.000	
.500		1.000	.030	1.000	4	WK-II-40500-R030	*	*	*	*	*	.500	3.000	
.500		1.000	.060	1.000	4	WK-II-40500-R060	*	*	*	*	*	.500	3.000	
.500		1.000	.090	1.000	4	WK-II-40500-R090	*	*	*	*	*	.500	3.000	
.500		1.000	.125	1.000	4	WK-II-40500-R125	*	*	*	*	*	.500	3.000	
.500		1.250		1.250	4	WK-II-M-40500	*	*	*	*	*	.500	3.000	
.500		1.250	.015	1.250	4	WK-II-M-40500-R015	*	*	*	*	*	.500	3.000	
.500		1.250	.030	1.250	4	WK-II-M-40500-R030	*	*	*	*	*	.500	3.000	
.500		1.250	.060	1.250	4	WK-II-M-40500-R060	*	*	*	*	*	.500	3.000	
.500		1.250	.090	1.250	4	WK-II-M-40500-R090	*	*	*	*	*	.500	3.000	
.500		1.250	.125	1.250	4	WK-II-M-40500-R125	*	*	*	*	*	.500	3.000	
.500		1.625		1.625	4	WK-II-ML-40500	*	*	*	*	*	.500	4.000	
.500		1.625	.030	1.625	4	WK-II-ML-40500-R030	*	*	*	*	*	.500	4.000	
.500	1.625	.060	1.625	4	WK-II-ML-40500-R060	*	*	*	*	*	.500	4.000		
.500	1.625	.090	1.625	4	WK-II-ML-40500-R090	*	*	*	*	*	.500	4.000		
.500	1.625	.125	1.625	4	WK-II-ML-40500-R125	*	*	*	*	*	.500	4.000		
.500	2.000		2.000	4	WK-II-L-40500	*	*	*	*	*	.500	4.000		
.500	2.000	.030	2.000	4	WK-II-L-40500-R030	*	*	*	*	*	.500	4.000		
.500	2.000	.060	2.000	4	WK-II-L-40500-R060	*	*	*	*	*	.500	4.000		
.500	2.000	.090	2.000	4	WK-II-L-40500-R090	*	*	*	*	*	.500	4.000		
.500	2.000	.125	2.000	4	WK-II-L-40500-R125	*	*	*	*	*	.500	4.000		



CoroMill® Dura, Solid carbide end mill in 4 flutes

WhisperKut, Multimaterial

4 Flute
TCDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Material				Dimensions, inch	
							P	M	K	S	H	DCON _{MS}
							XIBH	XIBH	XIBH	XIBH		
.625	.625	.750		.750	4	WK-II-S-40625	*	*	*	*	.625	3.000
.625	.750	.030	.750	4	WK-II-S-40625-R030	*	*	*	*	.625	3.000	
.625	.750	.060	.750	4	WK-II-S-40625-R060	*	*	*	*	.625	3.000	
.625	.750	.090	.750	4	WK-II-S-40625-R090	*	*	*	*	.625	3.000	
.625	.750	.125	.750	4	WK-II-S-40625-R125	*	*	*	*	.625	3.000	
.625	1.250		1.250	4	WK-II-40625	*	*	*	*	.625	3.500	
.625	1.250	.030	1.250	4	WK-II-40625-R030	*	*	*	*	.625	3.500	
.625	1.250	.060	1.250	4	WK-II-40625-R060	*	*	*	*	.625	3.500	
.625	1.250	.090	1.250	4	WK-II-40625-R090	*	*	*	*	.625	3.500	
.625	1.250	.125	1.250	4	WK-II-40625-R125	*	*	*	*	.625	3.500	
.625	1.625		1.625	4	WK-II-M-40625	*	*	*	*	.625	4.000	
.625	1.625	.030	1.625	4	WK-II-M-40625-R030	*	*	*	*	.625	4.000	
.625	1.625	.060	1.625	4	WK-II-M-40625-R060	*	*	*	*	.625	4.000	
.625	1.625	.090	1.625	4	WK-II-M-40625-R090	*	*	*	*	.625	4.000	
.625	1.625	.125	1.625	4	WK-II-M-40625-R125	*	*	*	*	.625	4.000	
.625	2.250		2.250	4	WK-II-L-40625	*	*	*	*	.625	5.000	
.625	2.250	.030	2.250	4	WK-II-L-40625-R030	*	*	*	*	.625	5.000	
.625	2.250	.060	2.250	4	WK-II-L-40625-R060	*	*	*	*	.625	5.000	
.625	2.250	.090	2.250	4	WK-II-L-40625-R090	*	*	*	*	.625	5.000	
.625	2.250	.125	2.250	4	WK-II-L-40625-R125	*	*	*	*	.625	5.000	
.750	.750	1.000		1.000	4	WK-II-S-40750	*	*	*	.750	3.000	
.750	1.000	.030	1.000	4	WK-II-S-40750-R030	*	*	*	*	.750	3.000	
.750	1.000	.060	1.000	4	WK-II-S-40750-R060	*	*	*	*	.750	3.000	
.750	1.000	.090	1.000	4	WK-II-S-40750-R090	*	*	*	*	.750	3.000	
.750	1.000	.125	1.000	4	WK-II-S-40750-R125	*	*	*	*	.750	3.000	
.750	1.000	.190	1.000	4	WK-II-S-40750-R190	*	*	*	*	.750	3.000	
.750	1.000	.250	1.000	4	WK-II-S-40750-R250	*	*	*	*	.750	3.000	
.750	1.625		1.625	4	WK-II-40750	*	*	*	*	.750	4.000	
.750	1.625	.030	1.625	4	WK-II-40750-R030	*	*	*	*	.750	4.000	
.750	1.625	.060	1.625	4	WK-II-40750-R060	*	*	*	*	.750	4.000	
.750	1.625	.090	1.625	4	WK-II-40750-R090	*	*	*	*	.750	4.000	
.750	1.625	.125	1.625	4	WK-II-40750-R125	*	*	*	*	.750	4.000	
.750	1.625	.190	1.625	4	WK-II-40750-R190	*	*	*	*	.750	4.000	
.750	1.625	.250	1.625	4	WK-II-40750-R250	*	*	*	*	.750	4.000	
.750	2.250		2.250	4	WK-II-ML-40750	*	*	*	*	.750	5.000	
.750	2.250	.030	2.250	4	WK-II-ML-40750-R030	*	*	*	*	.750	5.000	
.750	2.250	.060	2.250	4	WK-II-ML-40750-R060	*	*	*	*	.750	5.000	
.750	2.250	.090	2.250	4	WK-II-ML-40750-R090	*	*	*	*	.750	5.000	
.750	2.250	.125	2.250	4	WK-II-ML-40750-R125	*	*	*	*	.750	5.000	
.750	2.250	.190	2.250	4	WK-II-ML-40750-R190	*	*	*	*	.750	5.000	
.750	2.250	.250	2.250	4	WK-II-ML-40750-R250	*	*	*	*	.750	5.000	
.750	3.250		3.250	4	WK-II-L-40750	*	*	*	*	.750	6.000	
.750	3.250	.030	3.250	4	WK-II-L-40750-R030	*	*	*	*	.750	6.000	
.750	3.250	.060	3.250	4	WK-II-L-40750-R060	*	*	*	*	.750	6.000	
.750	3.250	.090	3.250	4	WK-II-L-40750-R090	*	*	*	*	.750	6.000	
.750	3.250	.125	3.250	4	WK-II-L-40750-R125	*	*	*	*	.750	6.000	
.750	3.250	.190	3.250	4	WK-II-L-40750-R190	*	*	*	*	.750	6.000	
.750	3.250	.250	3.250	4	WK-II-L-40750-R250	*	*	*	*	.750	6.000	



28



5



6



32

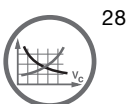
CoroMill® Dura, Solid carbide end mill in 4 flutes

WhisperKut, Multimaterial

4 Flute
TDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch						
							P	M	K	S	H	DCON _{MS}	LF
							X BH	X BH	X BH	X BH	X BH		
1.000	1.000	1.500		1.500	4	WK-II-41000	*	*	*	*	*	1.000	4.000
	1.000	1.500	.030	1.500	4	WK-II-41000-R030	*	*	*	*	*	1.000	4.000
	1.000	1.500	.060	1.500	4	WK-II-41000-R060	*	*	*	*	*	1.000	4.000
	1.000	1.500	.090	1.500	4	WK-II-41000-R090	*	*	*	*	*	1.000	4.000
	1.000	1.500	.125	1.500	4	WK-II-41000-R125	*	*	*	*	*	1.000	4.000
	1.000	1.500	.190	1.500	4	WK-II-41000-R190	*	*	*	*	*	1.000	4.000
	1.000	1.500	.250	1.500	4	WK-II-41000-R250	*	*	*	*	*	1.000	4.000
	1.000	2.000		2.000	4	WK-II-M-41000	*	*	*	*	*	1.000	4.500
	1.000	2.000	.030	2.000	4	WK-II-M-41000-R030	*	*	*	*	*	1.000	4.500
	1.000	2.000	.060	2.000	4	WK-II-M-41000-R060	*	*	*	*	*	1.000	4.500
	1.000	2.000	.090	2.000	4	WK-II-M-41000-R090	*	*	*	*	*	1.000	4.500
	1.000	2.000	.125	2.000	4	WK-II-M-41000-R125	*	*	*	*	*	1.000	4.500
	1.000	2.000	.190	2.000	4	WK-II-M-41000-R190	*	*	*	*	*	1.000	4.500
	1.000	2.000	.250	2.000	4	WK-II-M-41000-R250	*	*	*	*	*	1.000	4.500
	1.000	2.500		2.500	4	WK-II-ML-41000	*	*	*	*	*	1.000	5.000
	1.000	2.500	.030	2.500	4	WK-II-ML-41000-R030	*	*	*	*	*	1.000	5.000
	1.000	2.500	.060	2.500	4	WK-II-ML-41000-R060	*	*	*	*	*	1.000	5.000
	1.000	2.500	.090	2.500	4	WK-II-ML-41000-R090	*	*	*	*	*	1.000	5.000
	1.000	2.500	.125	2.500	4	WK-II-ML-41000-R125	*	*	*	*	*	1.000	5.000
	1.000	2.500	.190	2.500	4	WK-II-ML-41000-R190	*	*	*	*	*	1.000	5.000
	1.000	2.500	.250	2.500	4	WK-II-ML-41000-R250	*	*	*	*	*	1.000	5.000
	1.000	3.250		3.250	4	WK-II-L-41000	*	*	*	*	*	1.000	6.000
	1.000	3.250	.030	3.250	4	WK-II-L-41000-R030	*	*	*	*	*	1.000	6.000
	1.000	3.250	.060	3.250	4	WK-II-L-41000-R060	*	*	*	*	*	1.000	6.000
	1.000	3.250	.090	3.250	4	WK-II-L-41000-R090	*	*	*	*	*	1.000	6.000
	1.000	3.250	.125	3.250	4	WK-II-L-41000-R125	*	*	*	*	*	1.000	6.000
	1.000	3.250	.190	3.250	4	WK-II-L-41000-R190	*	*	*	*	*	1.000	6.000
	1.000	3.250	.250	3.250	4	WK-II-L-41000-R250	*	*	*	*	*	1.000	6.000



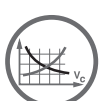
CoroMill® Dura, Solid carbide end mill in 4 flutes

WhisperKut, Ball Nose, Multimaterial

4 Flute
TCDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch				DCON _{MS}	LF
							P	M	K	S		
							X BH	X BH	X BH	X BH		
.125	.125	.250	.063	.250	4	WK-II-BN-S-40125	*	*	*	*	.125	1.500
	.125	.500	.063	.500	4	WK-II-BN-40125	*	*	*	*	.125	2.000
.188	.188	.313	.094	.313	4	WK-II-BN-S-40188	*	*	*	*	.188	2.000
	.188	.625	.094	.625	4	WK-II-BN-40188	*	*	*	*	.188	2.000
.250	.250	.375	.125	.375	4	WK-II-BN-S-40250	*	*	*	*	.250	2.000
	.250	.625	.125	.625	4	WK-II-BN-40250	*	*	*	*	.250	2.500
	.250	1.000	.125	1.000	4	WK-II-BN-M-40250	*	*	*	*	.250	3.000
	.250	1.250	.125	1.250	4	WK-II-BN-L-40250	*	*	*	*	.250	3.000
.313	.313	.500	.156	.500	4	WK-II-BN-S-40313	*	*	*	*	.313	2.000
	.313	.750	.156	.750	4	WK-II-BN-40313	*	*	*	*	.313	2.500
	.313	1.250	.156	1.250	4	WK-II-BN-M-40313	*	*	*	*	.313	3.000
.375	.375	.500	.188	.500	4	WK-II-BN-S-40375	*	*	*	*	.375	2.000
	.375	1.000	.188	1.000	4	WK-II-BN-40375	*	*	*	*	.375	2.500
	.375	1.250	.188	1.250	4	WK-II-BN-M-40375	*	*	*	*	.375	3.000
.500	.500	.625	.250	.625	4	WK-II-BN-S-40500	*	*	*	*	.500	2.500
	.500	1.000	.250	1.000	4	WK-II-BN-40500	*	*	*	*	.500	3.000
	.500	1.250	.250	1.250	4	WK-II-BN-M-40500	*	*	*	*	.500	3.000
	.500	1.625	.250	1.625	4	WK-II-BN-ML-40500	*	*	*	*	.500	4.000
	.500	2.000	.250	2.000	4	WK-II-BN-L-40500	*	*	*	*	.500	4.000
.625	.625	.750	.313	.750	4	WK-II-BN-S-40625	*	*	*	*	.625	3.000
	.625	1.250	.313	1.250	4	WK-II-BN-40625	*	*	*	*	.625	3.500
	.625	1.625	.313	1.625	4	WK-II-BN-M-40625	*	*	*	*	.625	4.000
	.625	2.250	.313	2.250	4	WK-II-BN-L-40625	*	*	*	*	.625	5.000
.750	.750	1.000	.375	1.000	4	WK-II-BN-S-40750	*	*	*	*	.750	3.000
	.750	1.625	.375	1.625	4	WK-II-BN-40750	*	*	*	*	.750	4.000
	.750	2.250	.375	2.250	4	WK-II-BN-ML-40750	*	*	*	*	.750	5.000
	.750	3.250	.375	3.250	4	WK-II-BN-L-40750	*	*	*	*	.750	6.000
1.000	1.000	1.500	.500	1.500	4	WK-II-BN-41000	*	*	*	*	1.000	4.000
	1.000	2.000	.500	2.000	4	WK-II-BN-M-41000	*	*	*	*	1.000	4.500
	1.000	2.500	.500	2.500	4	WK-II-BN-ML-41000	*	*	*	*	1.000	5.000
	1.000	3.250	.500	3.250	4	WK-II-BN-L-41000	*	*	*	*	1.000	6.000



28



5



6

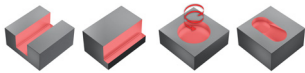
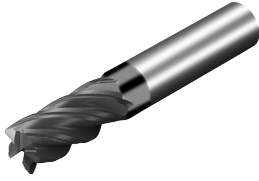


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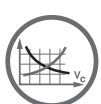
CoroMill® Dura, Solid carbide end mill in 5 flutes

WhisperKut, Multimaterial

5 Flute
TDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch						
							P	M	K	S	H	DCON _{MS}	LF
							X BH	X BH	X BH	X BH	X BH		
.125	.125	.375	.015	.375	5	WK-II-50125	*	*	*	*	*	.125	1.500
						WK-II-50125-R015	*	*	*	*	*	.125	1.500
						WK-II-50125-R030	*	*	*	*	*	.125	1.500
.188	.188	.625	.015	.625	5	WK-II-50188	*	*	*	*	*	.188	2.000
						WK-II-50188-R015	*	*	*	*	*	.188	2.000
						WK-II-50188-R030	*	*	*	*	*	.188	2.000
.250	.250	.375	.015	.375	5	WK-II-S-50250	*	*	*	*	*	.250	2.000
						WK-II-S-50250-R015	*	*	*	*	*	.250	2.000
						WK-II-S-50250-R030	*	*	*	*	*	.250	2.000
						WK-II-S-50250-R060	*	*	*	*	*	.250	2.000
						WK-II-50250	*	*	*	*	*	.250	2.500
						WK-II-50250-R015	*	*	*	*	*	.250	2.500
						WK-II-50250-R030	*	*	*	*	*	.250	2.500
						WK-II-50250-R060	*	*	*	*	*	.250	2.500
						WK-II-M-50250	*	*	*	*	*	.250	2.500
						WK-II-M-50250-R015	*	*	*	*	*	.250	2.500
						WK-II-M-50250-R030	*	*	*	*	*	.250	2.500
						WK-II-M-50250-R060	*	*	*	*	*	.250	2.500
						WK-II-L-50250	*	*	*	*	*	.250	3.000
						WK-II-L-50250-R015	*	*	*	*	*	.250	3.000
						WK-II-L-50250-R030	*	*	*	*	*	.250	3.000
WK-II-L-50250-R060	*	*	*	*	*	.250	3.000						
WK-II-LR-50250-R015	*	*	*	*	*	.250	3.000						
.313	.313	.750	.015	.750	5	WK-II-50313	*	*	*	*	*	.313	2.500
						WK-II-50313-R015	*	*	*	*	*	.313	2.500
						WK-II-50313-R030	*	*	*	*	*	.313	2.500
						WK-II-50313-R060	*	*	*	*	*	.313	2.500
						WK-II-M-50313	*	*	*	*	*	.313	3.000
						WK-II-M-50313-R015	*	*	*	*	*	.313	3.000
						WK-II-M-50313-R030	*	*	*	*	*	.313	3.000
						WK-II-M-50313-R060	*	*	*	*	*	.313	3.000
						WK-II-S-50375	*	*	*	*	*	.375	2.000
.375	.375	.500	.015	.500	5	WK-II-S-50375-R015	*	*	*	*	*	.375	2.000
						WK-II-S-50375-R030	*	*	*	*	*	.375	2.000
						WK-II-S-50375-R060	*	*	*	*	*	.375	2.000
						WK-II-S-50375-R090	*	*	*	*	*	.375	2.000
						WK-II-50375	*	*	*	*	*	.375	2.500
						WK-II-50375-R015	*	*	*	*	*	.375	2.500
						WK-II-50375-R030	*	*	*	*	*	.375	2.500
						WK-II-50375-R060	*	*	*	*	*	.375	2.500
						WK-II-50375-R090	*	*	*	*	*	.375	2.500
						WK-II-L-50375	*	*	*	*	*	.375	3.000
						WK-II-L-50375-R015	*	*	*	*	*	.375	3.000
						WK-II-L-50375-R030	*	*	*	*	*	.375	3.000
						WK-II-L-50375-R060	*	*	*	*	*	.375	3.000
						WK-II-L-50375-R090	*	*	*	*	*	.375	3.000
						WK-II-LX-50375	*	*	*	*	*	.375	3.500
WK-II-LX-50375-R015	*	*	*	*	*	.375	3.500						
WK-II-LX-50375-R030	*	*	*	*	*	.375	3.500						
WK-II-LX-50375-R060	*	*	*	*	*	.375	3.500						
WK-II-LX-50375-R090	*	*	*	*	*	.375	3.500						
WK-II-LR-50375-R015	*	*	*	*	*	.375	4.000						



28



5



6



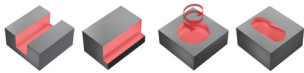
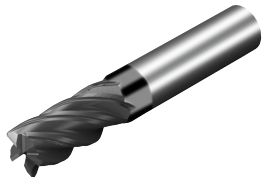
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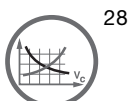
CoroMill® Dura, Solid carbide end mill in 5 flutes

WhisperKut, Multimaterial

5 Flute
TCDCON h6
Asymmetrical Variable Helix



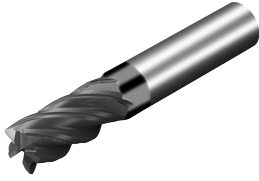
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch					DCON _{MS}	LF
							P	M	K	S	H		
							X BH	X BH	X BH	X BH	X BH		
.438	.438	1.000		1.000	5	WK-II-50438	*	*	*	*	*	.438	2.750
.438	.438	1.000	.015	1.000	5	WK-II-50438-R015	*	*	*	*	*	.438	2.750
.438	.438	1.000	.030	1.000	5	WK-II-50438-R030	*	*	*	*	*	.438	2.750
.438	.438	1.000	.060	1.000	5	WK-II-50438-R060	*	*	*	*	*	.438	2.750
.438	.438	1.000	.090	1.000	5	WK-II-50438-R090	*	*	*	*	*	.438	2.750
.500	.500	.625		.625	5	WK-II-S-50500	*	*	*	*	*	.500	2.500
.500	.500	.625	.015	.625	5	WK-II-S-50500-R015	*	*	*	*	*	.500	2.500
.500	.500	.625	.030	.625	5	WK-II-S-50500-R030	*	*	*	*	*	.500	2.500
.500	.500	.625	.060	.625	5	WK-II-S-50500-R060	*	*	*	*	*	.500	2.500
.500	.500	.625	.090	.625	5	WK-II-S-50500-R090	*	*	*	*	*	.500	2.500
.500	.500	.625	.125	.625	5	WK-II-S-50500-R125	*	*	*	*	*	.500	2.500
.500	.500	1.000		1.000	5	WK-II-50500	*	*	*	*	*	.500	3.000
.500	.500	1.000	.015	1.000	5	WK-II-50500-R015	*	*	*	*	*	.500	3.000
.500	.500	1.000	.030	1.000	5	WK-II-50500-R030	*	*	*	*	*	.500	3.000
.500	.500	1.000	.030	1.000	5	WK-II-LR-50500-R030	*	*	*	*	*	.500	6.000
.500	.500	1.000	.060	1.000	5	WK-II-50500-R060	*	*	*	*	*	.500	3.000
.500	.500	1.000	.090	1.000	5	WK-II-50500-R090	*	*	*	*	*	.500	3.000
.500	.500	1.000	.125	1.000	5	WK-II-50500-R125	*	*	*	*	*	.500	3.000
.500	.500	1.250		1.250	5	WK-II-M-50500	*	*	*	*	*	.500	3.000
.500	.500	1.250	.015	1.250	5	WK-II-M-50500-R015	*	*	*	*	*	.500	3.000
.500	.500	1.250	.030	1.250	5	WK-II-M-50500-R030	*	*	*	*	*	.500	3.000
.500	.500	1.250	.060	1.250	5	WK-II-M-50500-R060	*	*	*	*	*	.500	3.000
.500	.500	1.250	.090	1.250	5	WK-II-M-50500-R090	*	*	*	*	*	.500	3.000
.500	.500	1.250	.125	1.250	5	WK-II-M-50500-R125	*	*	*	*	*	.500	3.000
.500	.500	1.625		1.625	5	WK-II-ML-50500	*	*	*	*	*	.500	4.000
.500	.500	1.625	.015	1.625	5	WK-II-ML-50500-R015	*	*	*	*	*	.500	4.000
.500	.500	1.625	.030	1.625	5	WK-II-ML-50500-R030	*	*	*	*	*	.500	4.000
.500	.500	1.625	.060	1.625	5	WK-II-ML-50500-R060	*	*	*	*	*	.500	4.000
.500	.500	1.625	.090	1.625	5	WK-II-ML-50500-R090	*	*	*	*	*	.500	4.000
.500	.500	1.625	.125	1.625	5	WK-II-ML-50500-R125	*	*	*	*	*	.500	4.000
.500	.500	2.000		2.000	5	WK-II-L-50500	*	*	*	*	*	.500	4.000
.500	.500	2.000	.015	2.000	5	WK-II-L-50500-R015	*	*	*	*	*	.500	4.000
.500	.500	2.000	.030	2.000	5	WK-II-L-50500-R030	*	*	*	*	*	.500	4.000
.500	.500	2.000	.060	2.000	5	WK-II-L-50500-R060	*	*	*	*	*	.500	4.000
.500	.500	2.000	.090	2.000	5	WK-II-L-50500-R090	*	*	*	*	*	.500	4.000
.500	.500	2.000	.125	2.000	5	WK-II-L-50500-R125	*	*	*	*	*	.500	4.000



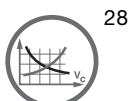
CoroMill® Dura, Solid carbide end mill in 5 flutes

WhisperKut, Multimaterial

5 Flute
TCDCON h6
Asymmetrical Variable Helix



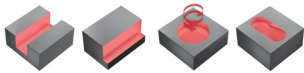
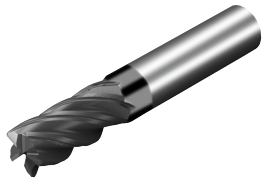
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch					DCON _{MS}	LF
							P	M	K	S	H		
							X BH	X BH	X BH	X BH	X BH		
.625	.625	.750	.750	.750	5	WK-II-S-50625	*	*	*	*	*	.625	3.000
	.625	.750	.030	.750	5	WK-II-S-50625-R030	*	*	*	*	*	.625	3.000
	.625	.750	.060	.750	5	WK-II-S-50625-R060	*	*	*	*	*	.625	3.000
	.625	.750	.090	.750	5	WK-II-S-50625-R090	*	*	*	*	*	.625	3.000
	.625	.750	.125	.750	5	WK-II-S-50625-R125	*	*	*	*	*	.625	3.000
	.625	1.250		1.250	5	WK-II-50625	*	*	*	*	*	.625	3.500
	.625	1.250	.030	1.250	5	WK-II-50625-R030	*	*	*	*	*	.625	3.500
	.625	1.250	.030	1.250	5	WK-II-LR-50625-R030	*	*	*	*	*	.625	6.000
	.625	1.250	.060	1.250	5	WK-II-50625-R060	*	*	*	*	*	.625	3.500
	.625	1.250	.090	1.250	5	WK-II-50625-R090	*	*	*	*	*	.625	3.500
	.625	1.250	.125	1.250	5	WK-II-50625-R125	*	*	*	*	*	.625	3.500
	.625	1.625		1.625	5	WK-II-M-50625	*	*	*	*	*	.625	4.000
	.625	1.625	.030	1.625	5	WK-II-M-50625-R030	*	*	*	*	*	.625	4.000
	.625	1.625	.060	1.625	5	WK-II-M-50625-R060	*	*	*	*	*	.625	4.000
	.625	1.625	.090	1.625	5	WK-II-M-50625-R090	*	*	*	*	*	.625	4.000
	.625	1.625	.125	1.625	5	WK-II-M-50625-R125	*	*	*	*	*	.625	4.000
	.625	2.250		2.250	5	WK-II-L-50625	*	*	*	*	*	.625	5.000
	.625	2.250	.030	2.250	5	WK-II-L-50625-R030	*	*	*	*	*	.625	5.000
	.625	2.250	.060	2.250	5	WK-II-L-50625-R060	*	*	*	*	*	.625	5.000
	.625	2.250	.090	2.250	5	WK-II-L-50625-R090	*	*	*	*	*	.625	5.000
	.625	2.250	.125	2.250	5	WK-II-L-50625-R125	*	*	*	*	*	.625	5.000
.750	.750	.875		.875	5	WK-II-S-50750	*	*	*	*	*	.750	3.000
	.750	.875	.030	.875	5	WK-II-S-50750-R030	*	*	*	*	*	.750	3.000
	.750	.875	.060	.875	5	WK-II-S-50750-R060	*	*	*	*	*	.750	3.000
	.750	.875	.090	.875	5	WK-II-S-50750-R090	*	*	*	*	*	.750	3.000
	.750	.875	.125	.875	5	WK-II-S-50750-R125	*	*	*	*	*	.750	3.000
	.750	.875	.190	.875	5	WK-II-S-50750-R190	*	*	*	*	*	.750	3.000
	.750	.875	.250	.875	5	WK-II-S-50750-R250	*	*	*	*	*	.750	3.000
	.750	1.500	.030	1.500	5	WK-II-LR-50750-R030	*	*	*	*	*	.750	6.000
	.750	1.625		1.625	5	WK-II-50750	*	*	*	*	*	.750	4.000
	.750	1.625	.030	1.625	5	WK-II-50750-R030	*	*	*	*	*	.750	4.000
	.750	1.625	.060	1.625	5	WK-II-50750-R060	*	*	*	*	*	.750	4.000
	.750	1.625	.090	1.625	5	WK-II-50750-R090	*	*	*	*	*	.750	4.000
	.750	1.625	.125	1.625	5	WK-II-50750-R125	*	*	*	*	*	.750	4.000
	.750	1.625	.190	1.625	5	WK-II-50750-R190	*	*	*	*	*	.750	4.000
	.750	1.625	.250	1.625	5	WK-II-50750-R250	*	*	*	*	*	.750	4.000
	.750	2.250		2.250	5	WK-II-L-50750	*	*	*	*	*	.750	5.000
	.750	2.250	.030	2.250	5	WK-II-L-50750-R030	*	*	*	*	*	.750	5.000
	.750	2.250	.060	2.250	5	WK-II-L-50750-R060	*	*	*	*	*	.750	5.000
	.750	2.250	.090	2.250	5	WK-II-L-50750-R090	*	*	*	*	*	.750	5.000
	.750	2.250	.125	2.250	5	WK-II-L-50750-R125	*	*	*	*	*	.750	5.000
	.750	2.250	.190	2.250	5	WK-II-L-50750-R190	*	*	*	*	*	.750	5.000
	.750	2.250	.250	2.250	5	WK-II-L-50750-R250	*	*	*	*	*	.750	5.000
	.750	3.250		3.250	5	WK-II-LX-50750	*	*	*	*	*	.750	6.000
	.750	3.250	.030	3.250	5	WK-II-LX-50750-R030	*	*	*	*	*	.750	6.000
	.750	3.250	.060	3.250	5	WK-II-LX-50750-R060	*	*	*	*	*	.750	6.000
	.750	3.250	.090	3.250	5	WK-II-LX-50750-R090	*	*	*	*	*	.750	6.000
	.750	3.250	.125	3.250	5	WK-II-LX-50750-R125	*	*	*	*	*	.750	6.000
	.750	3.250	.190	3.250	5	WK-II-LX-50750-R190	*	*	*	*	*	.750	6.000
	.750	3.250	.250	3.250	5	WK-II-LX-50750-R250	*	*	*	*	*	.750	6.000



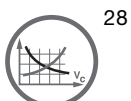
CoroMill® Dura, Solid carbide end mill in 5 flutes

WhisperKut, Multimaterial

5 Flute
TDCON h6
Asymmetrical Variable Helix



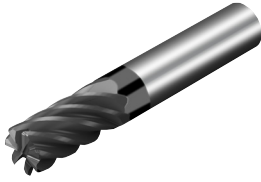
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch					DCON _{MS}	LF
							P	M	K	S	H		
							X BH	X BH	X BH	X BH	X BH		
1.000	1.000	1.500		1.500	5	WK-II-51000	*	*	*	*	*	1.000	4.000
	1.000	1.500	.030	1.500	5	WK-II-51000-R030	*	*	*	*	*	1.000	4.000
	1.000	1.500	.060	1.500	5	WK-II-51000-R060	*	*	*	*	*	1.000	4.000
	1.000	1.500	.090	1.500	5	WK-II-51000-R090	*	*	*	*	*	1.000	4.000
	1.000	1.500	.125	1.500	5	WK-II-51000-R125	*	*	*	*	*	1.000	4.000
	1.000	1.500	.190	1.500	5	WK-II-51000-R190	*	*	*	*	*	1.000	4.000
	1.000	1.500	.250	1.500	5	WK-II-51000-R250	*	*	*	*	*	1.000	4.000
	1.000	2.000		2.000	5	WK-II-M-51000	*	*	*	*	*	1.000	4.500
	1.000	2.000	.030	2.000	5	WK-II-M-51000-R030	*	*	*	*	*	1.000	4.500
	1.000	2.000	.060	2.000	5	WK-II-M-51000-R060	*	*	*	*	*	1.000	4.500
	1.000	2.000	.090	2.000	5	WK-II-M-51000-R090	*	*	*	*	*	1.000	4.500
	1.000	2.000	.125	2.000	5	WK-II-M-51000-R125	*	*	*	*	*	1.000	4.500
	1.000	2.000	.190	2.000	5	WK-II-M-51000-R190	*	*	*	*	*	1.000	4.500
	1.000	2.000	.250	2.000	5	WK-II-M-51000-R250	*	*	*	*	*	1.000	4.500
	1.000	2.500		2.500	5	WK-II-L-51000	*	*	*	*	*	1.000	5.000
	1.000	2.500	.030	2.500	5	WK-II-L-51000-R030	*	*	*	*	*	1.000	5.000
	1.000	2.500	.060	2.500	5	WK-II-L-51000-R060	*	*	*	*	*	1.000	5.000
	1.000	2.500	.090	2.500	5	WK-II-L-51000-R090	*	*	*	*	*	1.000	5.000
	1.000	2.500	.125	2.500	5	WK-II-L-51000-R125	*	*	*	*	*	1.000	5.000
	1.000	2.500	.190	2.500	5	WK-II-L-51000-R190	*	*	*	*	*	1.000	5.000
	1.000	2.500	.250	2.500	5	WK-II-L-51000-R250	*	*	*	*	*	1.000	5.000
	1.000	3.250		3.250	5	WK-II-LX-51000	*	*	*	*	*	1.000	6.000
	1.000	3.250	.030	3.250	5	WK-II-LX-51000-R030	*	*	*	*	*	1.000	6.000
	1.000	3.250	.060	3.250	5	WK-II-LX-51000-R060	*	*	*	*	*	1.000	6.000
	1.000	3.250	.090	3.250	5	WK-II-LX-51000-R090	*	*	*	*	*	1.000	6.000
	1.000	3.250	.125	3.250	5	WK-II-LX-51000-R125	*	*	*	*	*	1.000	6.000
	1.000	3.250	.190	3.250	5	WK-II-LX-51000-R190	*	*	*	*	*	1.000	6.000
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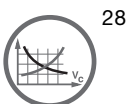
CoroMill® Dura, Solid carbide end mill in 7 flutes

WhisperKut, Multimaterial

7 Flute
TDCON h6
Asymmetrical Variable Helix



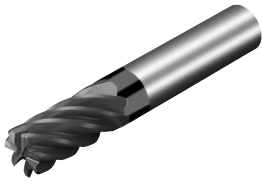
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch						
							P	M	K	S	H	DCON _{MS}	LF
							X BH	X BH	X BH	X BH	X BH		
.375	.375	.500		.500	7	WK-II-S-70375	*	*	*	*	*	.375	2.000
	.375	.500	.015	.500	7	WK-II-S-70375-R015	*	*	*	*	*	.375	2.000
	.375	.500	.030	.500	7	WK-II-S-70375-R030	*	*	*	*	*	.375	2.000
	.375	.500	.060	.500	7	WK-II-S-70375-R060	*	*	*	*	*	.375	2.000
	.375	1.000		1.000	7	WK-II-70375	*	*	*	*	*	.375	2.500
	.375	1.000	.015	1.000	7	WK-II-70375-R015	*	*	*	*	*	.375	2.500
	.375	1.000	.030	1.000	7	WK-II-70375-R030	*	*	*	*	*	.375	2.500
	.375	1.000	.060	1.000	7	WK-II-70375-R060	*	*	*	*	*	.375	2.500
	.375	1.250		1.250	7	WK-II-L-70375	*	*	*	*	*	.375	3.000
	.375	1.250	.015	1.250	7	WK-II-L-70375-R015	*	*	*	*	*	.375	3.000
	.375	1.250	.030	1.250	7	WK-II-L-70375-R030	*	*	*	*	*	.375	3.000
	.375	1.250	.060	1.250	7	WK-II-L-70375-R060	*	*	*	*	*	.375	3.000
.500	.500	.625		.625	7	WK-II-S-70500	*	*	*	*	*	.500	2.500
	.500	.625	.015	.625	7	WK-II-S-70500-R015	*	*	*	*	*	.500	2.500
	.500	.625	.030	.625	7	WK-II-S-70500-R030	*	*	*	*	*	.500	2.500
	.500	.625	.060	.625	7	WK-II-S-70500-R060	*	*	*	*	*	.500	2.500
	.500	.625	.090	.625	7	WK-II-S-70500-R090	*	*	*	*	*	.500	2.500
	.500	.625	.125	.625	7	WK-II-S-70500-R125	*	*	*	*	*	.500	2.500
	.500	1.000		1.000	7	WK-II-70500	*	*	*	*	*	.500	3.000
	.500	1.000	.015	1.000	7	WK-II-70500-R015	*	*	*	*	*	.500	3.000
	.500	1.000	.030	1.000	7	WK-II-70500-R030	*	*	*	*	*	.500	3.000
	.500	1.000	.060	1.000	7	WK-II-70500-R060	*	*	*	*	*	.500	3.000
	.500	1.000	.090	1.000	7	WK-II-70500-R090	*	*	*	*	*	.500	3.000
	.500	1.000	.125	1.000	7	WK-II-70500-R125	*	*	*	*	*	.500	3.000
	.500	1.250		1.250	7	WK-II-M-70500	*	*	*	*	*	.500	3.000
	.500	1.250	.015	1.250	7	WK-II-M-70500-R015	*	*	*	*	*	.500	3.000
	.500	1.250	.030	1.250	7	WK-II-M-70500-R030	*	*	*	*	*	.500	3.000
	.500	1.250	.060	1.250	7	WK-II-M-70500-R060	*	*	*	*	*	.500	3.000
	.500	1.250	.090	1.250	7	WK-II-M-70500-R090	*	*	*	*	*	.500	3.000
	.500	1.250	.125	1.250	7	WK-II-M-70500-R125	*	*	*	*	*	.500	3.000
	.500	2.000		2.000	7	WK-II-L-70500	*	*	*	*	*	.500	4.000
	.500	2.000	.015	2.000	7	WK-II-L-70500-R015	*	*	*	*	*	.500	4.000
	.500	2.000	.030	2.000	7	WK-II-L-70500-R030	*	*	*	*	*	.500	4.000
	.500	2.000	.060	2.000	7	WK-II-L-70500-R060	*	*	*	*	*	.500	4.000
.625	.625	.750		.750	7	WK-II-S-70625	*	*	*	*	*	.625	3.000
	.625	.750	.030	.750	7	WK-II-S-70625-R030	*	*	*	*	*	.625	3.000
	.625	.750	.060	.750	7	WK-II-S-70625-R060	*	*	*	*	*	.625	3.000
	.625	1.250		1.250	7	WK-II-70625	*	*	*	*	*	.625	3.500
	.625	1.250	.030	1.250	7	WK-II-70625-R030	*	*	*	*	*	.625	3.500
	.625	1.250	.060	1.250	7	WK-II-70625-R060	*	*	*	*	*	.625	3.500
	.625	1.625		1.625	7	WK-II-M-70625	*	*	*	*	*	.625	4.000
	.625	1.625	.030	1.625	7	WK-II-M-70625-R030	*	*	*	*	*	.625	4.000
	.625	1.625	.060	1.625	7	WK-II-M-70625-R060	*	*	*	*	*	.625	4.000



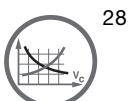
CoroMill® Dura, Solid carbide end mill in 7 flutes

WhisperKut, Multimaterial

7 Flute
TCDCON h6
Asymmetrical Variable Helix



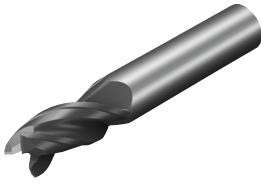
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	Dimensions, inch					DCON _{MS}	LF	
							P	M	K	S	H			
							X BH	X BH	X BH	X BH	X BH			
.750	.750	1.625		1.625	7	WK-II-70750	*	*	*	*	*	.750	4.000	
	.750	1.625	.030	1.625	7	WK-II-70750-R030	*	*	*	*	*	.750	4.000	
	.750	1.625	.060	1.625	7	WK-II-70750-R060	*	*	*	*	*	.750	4.000	
	.750	1.625	.090	1.625	7	WK-II-70750-R090	*	*	*	*	*	.750	4.000	
	.750	1.625	.125	1.625	7	WK-II-70750-R125	*	*	*	*	*	.750	4.000	
	.750	1.625	.190	1.625	7	WK-II-70750-R190	*	*	*	*	*	.750	4.000	
	.750	2.250		2.250	7	WK-II-L-70750	*	*	*	*	*	.750	5.000	
	.750	2.250	.030	2.250	7	WK-II-L-70750-R030	*	*	*	*	*	.750	5.000	
	.750	2.250	.060	2.250	7	WK-II-L-70750-R060	*	*	*	*	*	.750	5.000	
	.750	2.250	.090	2.250	7	WK-II-L-70750-R090	*	*	*	*	*	.750	5.000	
	.750	2.250	.125	2.250	7	WK-II-L-70750-R125	*	*	*	*	*	.750	5.000	
	.750	2.250	.190	2.250	7	WK-II-L-70750-R190	*	*	*	*	*	.750	5.000	
	1.000	1.000	2.000		2.000	7	WK-II-M-71000	*	*	*	*	*	1.000	4.500
		1.000	2.000	.030	2.000	7	WK-II-M-71000-R030	*	*	*	*	*	1.000	4.500
1.000		2.000	.060	2.000	7	WK-II-M-71000-R060	*	*	*	*	*	1.000	4.500	
1.000		2.000	.090	2.000	7	WK-II-M-71000-R090	*	*	*	*	*	1.000	4.500	
1.000		2.000	.125	2.000	7	WK-II-M-71000-R125	*	*	*	*	*	1.000	4.500	
1.000		2.000	.190	2.000	7	WK-II-M-71000-R190	*	*	*	*	*	1.000	4.500	
1.000		2.000	.250	2.000	7	WK-II-M-71000-R250	*	*	*	*	*	1.000	4.500	
1.000		2.500		2.500	7	WK-II-L-71000	*	*	*	*	*	1.000	5.000	
1.000		2.500	.030	2.500	7	WK-II-L-71000-R030	*	*	*	*	*	1.000	5.000	
1.000		2.500	.060	2.500	7	WK-II-L-71000-R060	*	*	*	*	*	1.000	5.000	
1.000		2.500	.090	2.500	7	WK-II-L-71000-R090	*	*	*	*	*	1.000	5.000	
1.000		2.500	.125	2.500	7	WK-II-L-71000-R125	*	*	*	*	*	1.000	5.000	
1.000		2.500	.190	2.500	7	WK-II-L-71000-R190	*	*	*	*	*	1.000	5.000	
1.000		2.500	.250	2.500	7	WK-II-L-71000-R250	*	*	*	*	*	1.000	5.000	



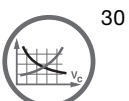
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, For Aluminum

3 Flute
TDCON h6
Asymmetrical Variable Helix



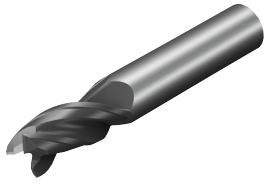
						N		Dimensions, inch		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	INBZ	HTOF	DCON _{MS}	LF
.125	.125	.375		.375	3	WK-AL-30125	*	*	.125	2.000
	.125	.375	.015	.375	3	WK-AL-30125-R015	*	*	.125	2.000
	.125	.500		.500	3	WK-AL-M-30125	*	*	.125	2.000
	.125	.500	.015	.500	3	WK-AL-M-30125-R015	*	*	.125	2.000
.188	.188	.563		.563	3	WK-AL-M-30188	*	*	.188	2.000
	.188	.563	.015	.563	3	WK-AL-M-30188-R015	*	*	.188	2.000
.250	.250	.375		.375	3	WK-AL-S-30250	*	*	.250	2.000
	.250	.375	.015	.375	3	WK-AL-S-30250-R015	*	*	.250	2.000
	.250	.375	.030	.375	3	WK-AL-S-30250-R030	*	*	.250	2.000
	.250	.375	.060	.375	3	WK-AL-S-30250-R060	*	*	.250	2.000
	.250	.750		.750	3	WK-AL-30250	*	*	.250	2.500
	.250	.750	.015	.750	3	WK-AL-30250-R015	*	*	.250	2.500
	.250	.750	.030	.750	3	WK-AL-30250-R030	*	*	.250	2.500
	.250	.750	.060	.750	3	WK-AL-30250-R060	*	*	.250	2.500
	.250	1.000		1.000	3	WK-AL-M-30250	*	*	.250	3.000
	.250	1.000	.015	1.000	3	WK-AL-M-30250-R015	*	*	.250	3.000
	.250	1.000	.030	1.000	3	WK-AL-M-30250-R030	*	*	.250	3.000
	.250	1.000	.060	1.000	3	WK-AL-M-30250-R060	*	*	.250	3.000
.375	.375	.500		.500	3	WK-AL-S-30375	*	*	.375	2.000
	.375	.500	.015	.500	3	WK-AL-S-30375-R015	*	*	.375	2.000
	.375	.500	.030	.500	3	WK-AL-S-30375-R030	*	*	.375	2.000
	.375	.500	.060	.500	3	WK-AL-S-30375-R060	*	*	.375	2.000
	.375	.500	.090	.500	3	WK-AL-S-30375-R090	*	*	.375	2.000
	.375	.500	.125	.500	3	WK-AL-S-30375-R125	*	*	.375	2.000
	.375	1.000		1.000	3	WK-AL-30375	*	*	.375	2.500
	.375	1.000	.015	1.000	3	WK-AL-30375-R015	*	*	.375	2.500
	.375	1.000	.030	1.000	3	WK-AL-30375-R030	*	*	.375	2.500
	.375	1.000	.060	1.000	3	WK-AL-30375-R060	*	*	.375	2.500
	.375	1.000	.090	1.000	3	WK-AL-30375-R090	*	*	.375	2.500
	.375	1.000	.125	1.000	3	WK-AL-30375-R125	*	*	.375	2.500
	.375	1.500		1.500	3	WK-AL-L-30375	*	*	.375	3.500
	.375	1.500	.015	1.500	3	WK-AL-L-30375-R015	*	*	.375	3.500
	.375	1.500	.030	1.500	3	WK-AL-L-30375-R030	*	*	.375	3.500
	.375	1.500	.060	1.500	3	WK-AL-L-30375-R060	*	*	.375	3.500
	.375	1.500	.090	1.500	3	WK-AL-L-30375-R090	*	*	.375	3.500
	.375	1.500	.125	1.500	3	WK-AL-L-30375-R125	*	*	.375	3.500



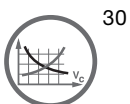
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, For Aluminum

3 Flute
TDCON h6
Asymmetrical Variable Helix



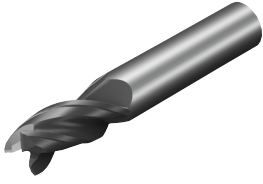
						N		Dimensions, inch		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	INIBZ	HTOF	DCON _{MS}	LF
.500	.500	.625		.625	3	WK-AL-S-30500	★	★	.500	2.500
	.500	.625	.015	.625	3	WK-AL-S-30500-R015	★	★	.500	2.500
	.500	.625	.030	.625	3	WK-AL-S-30500-R030	★	★	.500	2.500
	.500	.625	.060	.625	3	WK-AL-S-30500-R060	★	★	.500	2.500
	.500	.625	.090	.625	3	WK-AL-S-30500-R090	★	★	.500	2.500
	.500	.625	.125	.625	3	WK-AL-S-30500-R125	★	★	.500	2.500
	.500	1.250		1.250	3	WK-AL-30500	★	★	.500	3.000
	.500	1.250	.015	1.250	3	WK-AL-30500-R015	★	★	.500	3.000
	.500	1.250	.030	1.250	3	WK-AL-30500-R030	★	★	.500	3.000
	.500	1.250	.060	1.250	3	WK-AL-30500-R060	★	★	.500	3.000
	.500	1.250	.090	1.250	3	WK-AL-30500-R090	★	★	.500	3.000
	.500	1.250	.125	1.250	3	WK-AL-30500-R125	★	★	.500	3.000
	.500	1.625		1.625	3	WK-AL-M-30500	★	★	.500	4.000
	.500	1.625	.015	1.625	3	WK-AL-M-30500-R015	★	★	.500	4.000
	.500	1.625	.030	1.625	3	WK-AL-M-30500-R030	★	★	.500	4.000
	.500	1.625	.060	1.625	3	WK-AL-M-30500-R060	★	★	.500	4.000
	.500	1.625	.090	1.625	3	WK-AL-M-30500-R090	★	★	.500	4.000
	.500	1.625	.125	1.625	3	WK-AL-M-30500-R125	★	★	.500	4.000
	.500	2.000		2.000	3	WK-AL-L-30500	★	★	.500	4.000
	.500	2.000	.015	2.000	3	WK-AL-L-30500-R015	★	★	.500	4.000
	.500	2.000	.030	2.000	3	WK-AL-L-30500-R030	★	★	.500	4.000
	.500	2.000	.060	2.000	3	WK-AL-L-30500-R060	★	★	.500	4.000
	.500	2.000	.090	2.000	3	WK-AL-L-30500-R090	★	★	.500	4.000
	.500	2.000	.125	2.000	3	WK-AL-L-30500-R125	★	★	.500	4.000
.625	.625	1.625		1.625	3	WK-AL-30625	★	★	.625	4.000
	.625	1.625	.030	1.625	3	WK-AL-30625-R030	★	★	.625	4.000
	.625	1.625	.060	1.625	3	WK-AL-30625-R060	★	★	.625	4.000
	.625	1.625	.090	1.625	3	WK-AL-30625-R090	★	★	.625	4.000
	.625	1.625	.125	1.625	3	WK-AL-30625-R125	★	★	.625	4.000
.750	.750	1.000		1.000	3	WK-AL-S-30750	★	★	.750	3.000
	.750	1.000	.030	1.000	3	WK-AL-S-30750-R030	★	★	.750	3.000
	.750	1.000	.060	1.000	3	WK-AL-S-30750-R060	★	★	.750	3.000
	.750	1.000	.090	1.000	3	WK-AL-S-30750-R090	★	★	.750	3.000
	.750	1.000	.125	1.000	3	WK-AL-S-30750-R125	★	★	.750	3.000
	.750	1.000	.190	1.000	3	WK-AL-S-30750-R190	★	★	.750	3.000
	.750	1.000	.250	1.000	3	WK-AL-S-30750-R250	★	★	.750	3.000
	.750	1.625		1.625	3	WK-AL-30750	★	★	.750	4.000
	.750	1.625	.030	1.625	3	WK-AL-30750-R030	★	★	.750	4.000
	.750	1.625	.060	1.625	3	WK-AL-30750-R060	★	★	.750	4.000
	.750	1.625	.090	1.625	3	WK-AL-30750-R090	★	★	.750	4.000
	.750	1.625	.125	1.625	3	WK-AL-30750-R125	★	★	.750	4.000
	.750	1.625	.190	1.625	3	WK-AL-30750-R190	★	★	.750	4.000
	.750	1.625	.250	1.625	3	WK-AL-30750-R250	★	★	.750	4.000
	.750	2.250		2.250	3	WK-AL-M-30750	★	★	.750	5.000
	.750	2.250	.030	2.250	3	WK-AL-M-30750-R030	★	★	.750	5.000
	.750	2.250	.060	2.250	3	WK-AL-M-30750-R060	★	★	.750	5.000
	.750	2.250	.090	2.250	3	WK-AL-M-30750-R090	★	★	.750	5.000
	.750	2.250	.125	2.250	3	WK-AL-M-30750-R125	★	★	.750	5.000
	.750	2.250	.190	2.250	3	WK-AL-M-30750-R190	★	★	.750	5.000
	.750	2.250	.250	2.250	3	WK-AL-M-30750-R250	★	★	.750	5.000



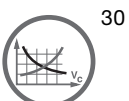
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, For Aluminum

3 Flute
TDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	N		Dimensions, inch	
							IN	HTOF	DCON _{MS}	LF
1.000	1.000	1.250		1.250	3	WK-AL-S-31000	*	*	1.000	4.000
	1.000	1.250	.030	1.250	3	WK-AL-S-31000-R030	*	*	1.000	4.000
	1.000	1.250	.060	1.250	3	WK-AL-S-31000-R060	*	*	1.000	4.000
	1.000	1.250	.090	1.250	3	WK-AL-S-31000-R090	*	*	1.000	4.000
	1.000	1.250	.125	1.250	3	WK-AL-S-31000-R125	*	*	1.000	4.000
	1.000	1.250	.190	1.250	3	WK-AL-S-31000-R190	*	*	1.000	4.000
	1.000	1.250	.250	1.250	3	WK-AL-S-31000-R250	*	*	1.000	4.000
	1.000	2.000		2.000	3	WK-AL-31000	*	*	1.000	5.000
	1.000	2.000	.030	2.000	3	WK-AL-31000-R030	*	*	1.000	5.000
	1.000	2.000	.060	2.000	3	WK-AL-31000-R060	*	*	1.000	5.000
	1.000	2.000	.090	2.000	3	WK-AL-31000-R090	*	*	1.000	5.000
	1.000	2.000	.125	2.000	3	WK-AL-31000-R125	*	*	1.000	5.000
	1.000	2.000	.190	2.000	3	WK-AL-31000-R190	*	*	1.000	5.000
	1.000	2.000	.250	2.000	3	WK-AL-31000-R250	*	*	1.000	5.000
	1.000	3.250		3.250	3	WK-AL-L-31000	*	*	1.000	6.000
	1.000	3.250	.030	3.250	3	WK-AL-L-31000-R030	*	*	1.000	6.000
	1.000	3.250	.060	3.250	3	WK-AL-L-31000-R060	*	*	1.000	6.000
	1.000	3.250	.090	3.250	3	WK-AL-L-31000-R090	*	*	1.000	6.000
	1.000	3.250	.125	3.250	3	WK-AL-L-31000-R125	*	*	1.000	6.000
	1.000	3.250	.190	3.250	3	WK-AL-L-31000-R190	*	*	1.000	6.000
	1.000	3.250	.250	3.250	3	WK-AL-L-31000-R250	*	*	1.000	6.000



30



5



6

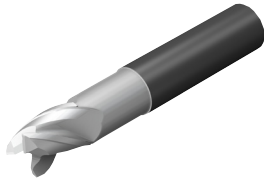


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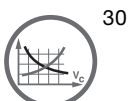
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, For Aluminum

3 Flute
TCDCON h6
Asymmetrical Variable Helix



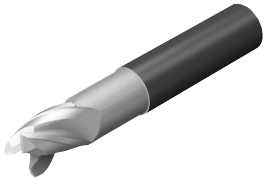
DC	CZC _{MIS}	APMX	RE	LU	ZEFP	Ordering code	N		Dimensions, inch		
							INIBZ	HTOF	DCON _{MIS}	LF	DN
.188	.188	.250		.563	3	WK-AL-E-30188	★	★	.188	2.000	.175
	.188	.250	.015	.563	3	WK-AL-E-30188-R015	★	★	.188	2.000	.175
.250	.250	.375		.750	3	WK-AL-E-30250	★	★	.250	2.500	.237
	.250	.375		1.125	3	WK-AL-E-L-30250	★	★	.250	3.000	.237
	.250	.375	.015	.750	3	WK-AL-E-30250-R015	★	★	.250	2.500	.237
	.250	.375	.015	1.125	3	WK-AL-E-L-30250-R015	★	★	.250	3.000	.237
	.250	.375	.030	.750	3	WK-AL-E-30250-R030	★	★	.250	2.500	.237
	.250	.375	.030	1.125	3	WK-AL-E-L-30250-R030	★	★	.250	3.000	.237
	.250	.375	.060	.750	3	WK-AL-E-30250-R060	★	★	.250	2.500	.237
	.250	.375	.060	1.125	3	WK-AL-E-L-30250-R060	★	★	.250	3.000	.237
.375	.375	.500		1.125	3	WK-AL-E-30375	★	★	.375	3.000	.356
	.375	.500		2.125	3	WK-AL-E-L-30375	★	★	.375	4.000	.356
	.375	.500	.015	1.125	3	WK-AL-E-30375-R015	★	★	.375	3.000	.356
	.375	.500	.015	2.125	3	WK-AL-E-L-30375-R015	★	★	.375	4.000	.356
	.375	.500	.030	1.125	3	WK-AL-E-30375-R030	★	★	.375	3.000	.356
	.375	.500	.030	2.125	3	WK-AL-E-L-30375-R030	★	★	.375	4.000	.356
	.375	.500	.060	1.125	3	WK-AL-E-30375-R060	★	★	.375	3.000	.356
	.375	.500	.060	2.125	3	WK-AL-E-L-30375-R060	★	★	.375	4.000	.356
	.375	.500	.090	1.125	3	WK-AL-E-30375-R090	★	★	.375	3.000	.356
	.375	.500	.090	2.125	3	WK-AL-E-L-30375-R090	★	★	.375	4.000	.356
	.375	.500	.125	1.125	3	WK-AL-E-30375-R125	★	★	.375	3.000	.356
	.375	.500	.125	2.125	3	WK-AL-E-L-30375-R125	★	★	.375	4.000	.356
.500	.500	.625		1.375	3	WK-AL-E-30500	★	★	.500	3.000	.476
	.500	.625		2.250	3	WK-AL-E-M-30500	★	★	.500	4.000	.476
	.500	.625		3.375	3	WK-AL-E-L-30500	★	★	.500	5.000	.476
	.500	.625		4.250	3	WK-AL-E-X-30500	★	★	.500	6.000	.476
	.500	.625	.015	1.375	3	WK-AL-E-30500-R015	★	★	.500	3.000	.476
	.500	.625	.015	2.250	3	WK-AL-E-M-30500-R015	★	★	.500	4.000	.476
	.500	.625	.015	3.375	3	WK-AL-E-L-30500-R015	★	★	.500	5.000	.476
	.500	.625	.015	4.250	3	WK-AL-E-X-30500-R015	★	★	.500	6.000	.476
	.500	.625	.030	1.375	3	WK-AL-E-30500-R030	★	★	.500	3.000	.476
	.500	.625	.030	2.250	3	WK-AL-E-M-30500-R030	★	★	.500	4.000	.476
	.500	.625	.030	3.375	3	WK-AL-E-L-30500-R030	★	★	.500	5.000	.476
	.500	.625	.030	4.250	3	WK-AL-E-X-30500-R030	★	★	.500	6.000	.476
	.500	.625	.060	1.375	3	WK-AL-E-30500-R060	★	★	.500	3.000	.476
	.500	.625	.060	2.250	3	WK-AL-E-M-30500-R060	★	★	.500	4.000	.476
	.500	.625	.060	3.375	3	WK-AL-E-L-30500-R060	★	★	.500	5.000	.476
	.500	.625	.060	4.250	3	WK-AL-E-X-30500-R060	★	★	.500	6.000	.476
	.500	.625	.090	1.375	3	WK-AL-E-30500-R090	★	★	.500	3.000	.476
	.500	.625	.090	2.250	3	WK-AL-E-M-30500-R090	★	★	.500	4.000	.476
	.500	.625	.090	3.375	3	WK-AL-E-L-30500-R090	★	★	.500	5.000	.476
	.500	.625	.090	4.250	3	WK-AL-E-X-30500-R090	★	★	.500	6.000	.476
.500	.625	.125	1.375	3	WK-AL-E-30500-R125	★	★	.500	3.000	.476	
.500	.625	.125	2.250	3	WK-AL-E-M-30500-R125	★	★	.500	4.000	.476	
.500	.625	.125	3.375	3	WK-AL-E-L-30500-R125	★	★	.500	5.000	.476	
.500	.625	.125	4.250	3	WK-AL-E-X-30500-R125	★	★	.500	6.000	.476	
.625	.625	.750		1.625	3	WK-AL-E-30625	★	★	.625	4.000	.596
	.625	.750	.030	1.625	3	WK-AL-E-30625-R030	★	★	.625	4.000	.596
	.625	.750	.060	1.625	3	WK-AL-E-30625-R060	★	★	.625	4.000	.596
	.625	.750	.090	1.625	3	WK-AL-E-30625-R090	★	★	.625	4.000	.596
	.625	.750	.125	1.625	3	WK-AL-E-30625-R125	★	★	.625	4.000	.596



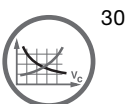
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, For Aluminum

3 Flute
TDCON h6
Asymmetrical Variable Helix



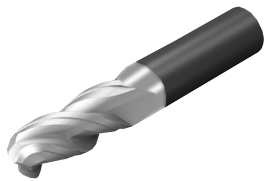
						N		Dimensions, inch			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	INBZ	HTOF	DCON _{MS}	LF	DN
.750	.750	1.000		2.000	3	WK-AL-E-30750	★	★	.750	4.000	.716
	.750	1.000		3.375	3	WK-AL-E-L-30750	★	★	.750	6.000	.716
.750	1.000	.030	2.000	3	WK-AL-E-30750-R030	★	★	.750	4.000	.716	
	.750	1.000	.030	3.375	3	WK-AL-E-L-30750-R030	★	★	.750	6.000	.716
.750	1.000	.060	2.000	3	WK-AL-E-30750-R060	★	★	.750	4.000	.716	
	.750	1.000	.060	3.375	3	WK-AL-E-L-30750-R060	★	★	.750	6.000	.716
.750	1.000	.090	2.000	3	WK-AL-E-30750-R090	★	★	.750	4.000	.716	
	.750	1.000	.090	3.375	3	WK-AL-E-L-30750-R090	★	★	.750	6.000	.716
.750	1.000	.125	2.000	3	WK-AL-E-30750-R125	★	★	.750	4.000	.716	
	.750	1.000	.125	3.375	3	WK-AL-E-L-30750-R125	★	★	.750	6.000	.716
.750	1.000	.190	2.000	3	WK-AL-E-30750-R190	★	★	.750	4.000	.716	
	.750	1.000	.190	3.375	3	WK-AL-E-L-30750-R190	★	★	.750	6.000	.716
.750	1.000	.250	2.000	3	WK-AL-E-30750-R250	★	★	.750	4.000	.716	
	.750	1.000	.250	3.375	3	WK-AL-E-L-30750-R250	★	★	.750	6.000	.716
1.000	1.000	1.250		2.625	3	WK-AL-E-S-31000	★	★	1.000	5.000	.956
	1.000	1.250		3.375	3	WK-AL-E-31000	★	★	1.000	6.000	.956
1.000	1.250		4.375	3	WK-AL-E-L-31000	★	★	1.000	7.000	.956	
1.000	1.250	.030	2.625	3	WK-AL-E-S-31000-R030	★	★	1.000	5.000	.956	
	1.000	1.250	.030	3.375	3	WK-AL-E-31000-R030	★	★	1.000	6.000	.956
1.000	1.250	.030	4.375	3	WK-AL-E-L-31000-R030	★	★	1.000	7.000	.956	
1.000	1.250	.060	2.625	3	WK-AL-E-S-31000-R060	★	★	1.000	5.000	.956	
	1.000	1.250	.060	3.375	3	WK-AL-E-31000-R060	★	★	1.000	6.000	.956
1.000	1.250	.060	4.375	3	WK-AL-E-L-31000-R060	★	★	1.000	7.000	.956	
1.000	1.250	.090	2.625	3	WK-AL-E-S-31000-R090	★	★	1.000	5.000	.956	
	1.000	1.250	.090	3.375	3	WK-AL-E-31000-R090	★	★	1.000	6.000	.956
1.000	1.250	.090	4.375	3	WK-AL-E-L-31000-R090	★	★	1.000	7.000	.956	
1.000	1.250	.125	2.625	3	WK-AL-E-S-31000-R125	★	★	1.000	5.000	.956	
	1.000	1.250	.125	3.375	3	WK-AL-E-31000-R125	★	★	1.000	6.000	.956
1.000	1.250	.125	4.375	3	WK-AL-E-L-31000-R125	★	★	1.000	7.000	.956	
1.000	1.250	.190	2.625	3	WK-AL-E-S-31000-R190	★	★	1.000	5.000	.956	
	1.000	1.250	.190	3.375	3	WK-AL-E-31000-R190	★	★	1.000	6.000	.956
1.000	1.250	.190	4.375	3	WK-AL-E-L-31000-R190	★	★	1.000	7.000	.956	
1.000	1.250	.250	2.625	3	WK-AL-E-S-31000-R250	★	★	1.000	5.000	.956	
	1.000	1.250	.250	3.375	3	WK-AL-E-31000-R250	★	★	1.000	6.000	.956
1.000	1.250	.250	4.375	3	WK-AL-E-L-31000-R250	★	★	1.000	7.000	.956	



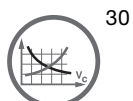
CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, Ball Nose, For Aluminum

3 Flute
TCDCON h6
Asymmetrical Variable Helix



DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	N		Dimensions, inch	
							INIBZ	HTOF	DCON _{MS}	LF
.188	.188	.563	.094	.563	3	WK-AL-BN-M-30188	★	★	.188	2.000
250	.250	.750	.125	.750	3	WK-AL-BN-30250	★	★	.250	2.500
	.250	1.000	.125	1.000	3	WK-AL-BN-M-30250	★	★	.250	3.000
.375	.375	1.000	.188	1.000	3	WK-AL-BN-30375	★	★	.375	2.500
	.375	1.500	.188	1.500	3	WK-AL-BN-L-30375	★	★	.375	3.500
.500	.500	1.250	.250	1.250	3	WK-AL-BN-30500	★	★	.500	3.000
	.500	1.625	.250	1.625	3	WK-AL-BN-M-30500	★	★	.500	4.000
.625	.625	1.625	.313	1.625	3	WK-AL-BN-30625	★	★	.625	4.000
.750	.750	1.625	.375	1.625	3	WK-AL-BN-30750	★	★	.750	4.000
	.750	2.250	.375	2.250	3	WK-AL-BN-M-30750	★	★	.750	5.000
1.000	1.000	2.000	.500	2.000	3	WK-AL-BN-31000	★	★	1.000	5.000



CoroMill® Dura, Solid carbide end mill in 3 flutes

WhisperKut, Ball Nose, For Aluminum

3 Flute
TCDCON h6
Asymmetrical Variable Helix



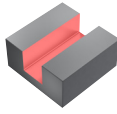
DC	CZCMS	APMX	RE	LU	ZEFP	Ordering code	N		Dimensions, inch		
							IN	HTOF	DCONM S	LF	DN
.188	.188	.250	.094	.563	3	WK-AL-EBN-30188	*	*	.188	2.000	.175
.250	.250	.375	.125	.750	3	WK-AL-EBN-30250	*	*	.250	2.500	.237
	.250	.375	.125	1.125	3	WK-AL-EBN-L-30250	*	*	.250	3.000	.237
.375	.375	.500	.188	1.125	3	WK-AL-EBN-30375	*	*	.375	3.000	.356
	.375	.500	.188	2.125	3	WK-AL-EBN-L-30375	*	*	.375	4.000	.356
.500	.500	.625	.250	1.375	3	WK-AL-EBN-30500	*	*	.500	3.000	.476
	.500	.625	.250	2.250	3	WK-AL-EBN-M-30500	*	*	.500	4.000	.476
	.500	.625	.250	3.375	3	WK-AL-EBN-L-30500	*	*	.500	5.000	.476
	.500	.625	.250	4.250	3	WK-AL-EBN-X-30500	*	*	.500	6.000	.476
.625	.625	.750	.313	1.625	3	WK-AL-EBN-30625	*	*	.625	4.000	.596
.750	.750	1.000	.375	2.000	3	WK-AL-EBN-30750	*	*	.750	4.000	.716
	.750	1.000	.375	3.375	3	WK-AL-EBN-L-30750	*	*	.750	6.000	.716
1.000	1.000	1.250	.500	3.375	3	WK-AL-EBN-31000	*	*	1.000	6.000	.956
	1.000	1.250	.500	4.375	3	WK-AL-EBN-L-31000	*	*	1.000	7.000	.956



Cutting data recommendations

For CoroMill® Dura multi-material


Slotting



$a_e = 1 \times DC$
 $a_p = \text{up to } 0.5 \times DC$

Material Group	Material Hardness	Cutting Speed SFM	Tool diameter								
			1/8" .125	3/16" .188	1/4" .250	5/16" .313	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000
			Recommended feed per tooth, f_t inch								
P1	≤ 175 BHN	450	.0006	.0011	.0014	.0018	.0022	.0028	.0031	.0034	.004
P2		425	.0006	.0011	.0014	.0018	.0022	.0028	.0031	.0034	.004
P3	≤ 35 HRc	340	.0005	.0009	.0012	.0016	.0018	.0023	.0027	.003	.0037
P4	≤ 35-48 HRc	255	.0005	.0008	.0011	.0014	.0016	.002	.0024	.0026	.0031
P5	≤ 35 HRc	240	.0005	.0007	.001	.0013	.0014	.0018	.0022	.0024	.0029
P6	> 35 HRc	180	.0004	.0006	.0008	.001	.0012	.0015	.0018	.0019	.0022
M1	≤ 28 HRc	260	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.003	.0037
M2	≥ 28 HRc	190	.0005	.0007	.001	.0013	.0014	.0018	.0022	.0024	.0029
M3	≤ 28 HRc	180	.0004	.0006	.0008	.001	.0012	.0015	.0018	.0019	.0022
K1	≤ 250 BHN	330	.0007	.0011	.0014	.0018	.0022	.0028	.0031	.0034	.004
K2	≤ 250 BHN	295	.0005	.0009	.0012	.0016	.0018	.0023	.0027	.003	.0037
S1		120	.0003	.0004	.0006	.0007	.001	.0012	.0016	.002	.0024
S2		100	.0003	.0004	.0006	.0007	.001	.0012	.0016	.002	.0024
S3		80	.0003	.0004	.0006	.0007	.001	.0012	.0016	.002	.0024
S4		170	.0004	.0006	.0009	.0011	.0014	.0018	.002	.0024	.0028
H2	48-55HRc	160	.0001	.0002	.0003	.0005	.0008	.001	.0014	.0016	.002

Heavy roughing



$a_e = 0.5 \times DC$
 $a_p = 1.25 \times DC$

Material Group	Material Hardness	Cutting Speed SFM	Tool diameter								
			1/8" .125	3/16" .188	1/4" .250	5/16" .313	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000
			Recommended feed per tooth, f_t inch								
P1	≤ 175 BHN	560	.0009	.0014	.0018	.0023	.0027	.0035	.0039	.0043	.005
P2		530	.0009	.0014	.0018	.0023	.0027	.0035	.0039	.0043	.005
P3	≤ 35 HRc	425	.0007	.0011	.0015	.002	.0023	.0029	.0034	.0038	.0046
P4	≤ 35-48 HRc	320	.0006	.001	.0014	.0018	.002	.0026	.003	.0033	.0039
P5	≤ 35 HRc	300	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.003	.0036
P6	> 35 HRc	225	.0005	.0008	.001	.0013	.0015	.0019	.0022	.0024	.0028
M1	≤ 28 HRc	325	.0007	.0011	.0015	.002	.0023	.0029	.0034	.0038	.0046
M2	≥ 28 HRc	235	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.003	.0036
M3	≤ 28 HRc	225	.0005	.0008	.001	.0013	.0015	.0019	.0022	.0024	.0028
K1	≤ 250 BHN	415	.0009	.0014	.0018	.0023	.0027	.0035	.0039	.0043	.005
K2	≤ 250 BHN	370	.0006	.001	.0014	.0018	.002	.0026	.003	.0035	.0042
S1		150	.0004	.0005	.0007	.0009	.0012	.0015	.002	.0025	.003
S2		125	.0004	.0005	.0007	.0009	.0012	.0015	.002	.0025	.003
S3		100	.0004	.0005	.0007	.0009	.0012	.0015	.002	.0025	.003
S4		215	.0005	.0008	.0011	.0014	.0017	.0022	.0025	.003	.0035
H2	48-55HRc	200	.0002	.0003	.0004	.0006	.001	.0012	.0017	.002	.0025

For ramping operations, a ramping angle of 3-5° is recommended. Feed rate remains unchanged.

Seven flute end mills should be used for Finishing applications only

When using extended reach tools, reduce the recommended feed rates by 20%


When exceeding recommended axial direction of cut on finishing applications, reduce the recommended feed rate by 20%. Cutting speed remains unchanged.

When exceeding recommended axial direction of cut for both heavy roughing and light roughing applications, the following adjustments to feed rates should be considered. Axial direction of cut 2xD = reduce feed rate by 50%. Axial direction of cut 3xD = reduce feed rate by 75%. Cutting Speed remains unchanged.


Cutting data recommendations

For CoroMill® Dura multi-material

Light roughing

			 $a_e = 0.2 \times DC$ $a_p = 1.25 \times DC$								
Material Group	Material Hardness	Cutting Speed SFM	Tool diameter								
			1/8" .125	3/16" .188	1/4" .250	5/16" .313	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000
			Recommended feed per tooth, f_z inch								
P1	≤ 175 BHN	730	.0011	.0017	.0022	.0028	.0032	.0042	.0047	.0052	.006
P2		690	.0011	.0017	.0022	.0028	.0032	.0042	.0047	.0052	.006
P3	≤ 35 HRc	550	.0008	.0013	.0018	.0024	.0028	.0035	.0041	.0046	.0055
P4	≤ 35-48 HRc	415	.0007	.0012	.0017	.0022	.0024	.0031	.0036	.004	.0047
P5	≤ 35 HRc	390	.0007	.0011	.0014	.0019	.0022	.0028	.0032	.0036	.0043
P6	> 35 HRc	295	.0006	.001	.0012	.0016	.0018	.0023	.0026	.0029	.0034
M1	≤ 28 HRc	420	.0008	.0013	.0018	.0024	.0028	.0035	.0041	.0046	.0055
M2	≥ 28 HRc	305	.0007	.0011	.0014	.0019	.0022	.0028	.0032	.0036	.0043
M3	≤ 28 HRc	295	.0006	.001	.0012	.0016	.0018	.0023	.0026	.0029	.0034
K1	≤ 250 BHN	540	.0011	.0017	.0022	.0028	.0032	.0042	.0047	.0052	.006
K2	≤ 250 BHN	480	.0007	.0012	.0017	.0022	.0024	.0031	.0036	.0042	.005
S1		195	.0005	.0006	.0008	.0011	.0014	.0018	.0024	.003	.0036
S2		165	.0005	.0006	.0008	.0011	.0014	.0018	.0024	.003	.0036
S3		130	.0005	.0006	.0008	.0011	.0014	.0018	.0024	.003	.0036
S4		280	.0006	.001	.0013	.0017	.002	.0026	.003	.0036	.0042
H2	48-55HRc	260	.0002	.0004	.0005	.0007	.0012	.0014	.002	.0024	.003

Finishing

			 $a_e = 0.05 \times DC$ $a_p = \text{up to } 2 \times DC$								
Material Group	Material Hardness	Cutting Speed SFM	Tool diameter								
			1/8" .125	3/16" .188	1/4" .250	5/16" .313	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000
			Recommended feed per tooth, f_z inch								
P1	≤ 175 BHN	925	.002	.0032	.0041	.0052	.0061	.008	.0089	.0098	.0114
P2		875	.002	.0032	.0041	.0052	.0061	.008	.0089	.0098	.0114
P3	≤ 35 HRc	700	.0016	.0025	.0034	.0045	.0052	.0066	.0077	.0086	.0105
P4	≤ 35-48 HRc	530	.0014	.0023	.0032	.0041	.0045	.0059	.0068	.0075	.0089
P5	≤ 35 HRc	495	.0014	.002	.0027	.0036	.0041	.0052	.0061	.0068	.0082
P6	> 35 HRc	370	.0011	.0018	.0023	.003	.0034	.0043	.005	.0055	.0064
M1	≤ 28 HRc	535	.0016	.0025	.0034	.0045	.0052	.0066	.0077	.0086	.0105
M2	≥ 28 HRc	390	.0014	.002	.0027	.0036	.0041	.0052	.0061	.0068	.0082
M3	≤ 28 HRc	370	.0011	.0018	.0023	.003	.0034	.0043	.005	.0055	.0064
K1	≤ 250 BHN	685	.002	.0032	.0041	.0052	.0061	.008	.0089	.0098	.0114
K2	≤ 250 BHN	610	.0014	.0023	.0032	.0041	.0045	.0059	.0068	.008	.0095
S1		245	.0009	.0011	.0016	.002	.0027	.0034	.0045	.0057	.0068
S2		200	.0009	.0011	.0016	.002	.0027	.0034	.0045	.0057	.0068
S3		165	.0009	.0011	.0016	.002	.0027	.0034	.0045	.0057	.0068
S4		355	.0011	.0018	.0025	.0032	.0039	.005	.0057	.0068	.008
H2	48-55HRc	330	.0005	.0007	.0009	.0014	.0023	.0027	.0039	.0045	.0057

For ramping operations, a ramping angle of 3-5° is recommended. Feed rate remains unchanged.

Seven flute end mills should be used for Finishing applications only

When using extended reach tools, reduce the recommended feed rates by 20%

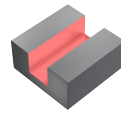
When exceeding recommended axial direction of cut on finishing applications, reduce the recommended feed rate by 20%. Cutting speed remains unchanged.

When exceeding recommended axial direction of cut for both heavy roughing and light roughing applications, the following adjustments to feed rates should be considered. Axial direction of cut 2xD = reduce feed rate by 50%. Axial direction of cut 3xD = reduce feed rate by 75%. Cutting Speed remains unchanged.

Cutting data recommendations

For CoroMill® Dura Aluminum

Slotting

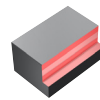


$a_e = 1 \times DC$
 $a_p = \text{up to } 1 \times DC$

Material Group	Cutting Speed SFM	Tool diameter								
		1/8" .125	3/16" .188	1/4" .250	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000	
		Recommended feed per tooth, f_z inch								
N1	1500 - 2500	.0009-.0012	.0014-.0018	.0018-.0024	.0026-.0036	.0035-.0047	.004-.0059	.0053-.0071	.007-.0095	
N2	700 - 1100	.0007-.001	.001-.0014	.0014-.0019	.0022-.0029	.0029-.0039	.0036-.0049	.0043-.0058	.0057-.0078	

When slotting 1 x D deep, use 70% of maximum machine RPM

Heavy roughing



$a_e = 0.5 \times DC$
 $a_p = \text{up to } 1.25 \times DC$

Material Group	Cutting Speed SFM	Tool diameter								
		1/8" .125	3/16" .188	1/4" .250	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000	
		Recommended feed per tooth, f_z inch								
N1	1500 - 2500	.0012-.0016	.0018-.0023	.0023-.0032	.0035-.0047	.0047-.0063	.0058-.0079	.007-.0095	.0094-.0127	
N2	700 - 1100	.001-.0013	.0014-.0018	.0019-.0026	.0029-.0039	.0038-.0052	.0048-.0065	.0057-.0078	.0077-.0104	

When recommended cutting speed cannot be achieved, use the maximum machine RPM and the suggested feed per tooth as shown in the table

Flood coolant recommended for all applications

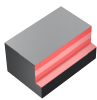
Reduce cutting speed values by 40% when using uncoated tools

When using extended neck relief tools, it may require a reduction of axial direction of cut and radial direction of cut values based upon your specific part and fixture


Cutting data recommendations

For CoroMill® Dura Aluminum

Light roughing

		 $a_e = 0.25 \times DC$ $a_p = \text{Length of cut}$								
Material Group	Cutting Speed SFM	Tool diameter								
		1/8" .125	3/16" .188	1/4" .250	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000	
		Recommended feed per tooth, f_t inch								
N1	1500 - 2500	.0015-.002	.0023-.0035	.0029-.004	.0044-.0059	.0058-.0079	.0073-.0099	.0088-.0119	.0117-.0158	
N2	700 - 1100	.0011-.0014	.0018-.0023	.0021-.0029	.0032-.0043	.0043-.0058	.0053-.0072	.0064-.0086	.0085-.0115	

Finishing

		 $a_e = 3 - 5\% \text{ of DC}$ $a_p = \text{Length of cut}$								
Material Group	Cutting Speed SFM	Tool diameter								
		1/8" .125	3/16" .188	1/4" .250	3/8" .375	1/2" .500	5/8" .625	3/4" .750	1" 1.000	
		Recommended feed per tooth, f_t inch								
N1	1500 - 2500	.0015-.002	.003-.004	.005-.006	.007-.010	.012-.014	.014-.016	.015-.017	.016-.018	
N2	700 - 1100	.0012-.0017	.0025-.0034	.0042-.0051	.0059-.0085	.0102-.0119	.0119-.0136	.0127-.0144	.0136-.0153	

When recommended cutting speed cannot be achieved, use the maximum machine RPM and the suggested feed per tooth as shown in the table

Standard finishing feed rates may require adjustments

Flood coolant recommended for all applications

Reduce cutting speed values by 40% when using uncoated tools

When using extended neck relief tools, it may require a reduction of axial direction of cut and radial direction of cut values based upon your specific part and fixture

Code key for CoroMill® Dura Multi-material

W K	-	I I	-	B N	-	L R	-	5 0 5 0 0	-	R 0 3 0		X 1 B H
1		2		3		4		5	6	7		8

1	Tool style
WK:	WhisperKut
2	Running number
II:	4, 5, 7 Flute
N/A:	3 Flute
3	Face geometry
BN:	Ball nose
N/A:	Straight
4	Length
S:	Stub
M:	Medium
L:	Long
ML:	Medium Long
LX:	Xtra Long
LR:	Long Reach
ER:	Extended Reach
ERN:	Extended Reach with Neck
N/A:	Regular

5	Number of teeth
3, 4, 5, 6, 7	
6	Cutting diameter (DC)
Cutting diameter, DC in 0.000" E.g. 0500 = 0.5 inch	
7	Corner radius (RE)
R:	Corner radius, RE in 0.000 inch e.g. R030 = corner radius 0.030 inch
N/A:	Square end
8	Grade
X1BH	

Code key for CoroMill® Dura Aluminum

W K	-	A L	-		-	E - S	-	3 1 0 0 0	-	R 2 5 0		N 1 B Z
1		2		3		4		5	6	7		8

1	Tool style
WK:	WhisperKut
2	Series
AL	Aluminum
3	Face geometry
BN:	Ball nose
EBN:	Ball nose with Extended Reach
N/A:	Straight
4	Length
S:	Stub
M:	Medium
L:	Long
X:	Xtra Long
E:	Extended Reach with Neck
N/A:	Regular

5	Number of teeth
3	
6	Cutting diameter (DC)
Cutting diameter, DC in 0.000" E.g. 0500 = 0.5 inch	
7	Corner radius (RE)
R:	Corner radius, RE in 0.000 inch e.g. R030 = corner radius 0.030 inch
N/A:	Square end
8	Grade
H10F	
N1BZ	