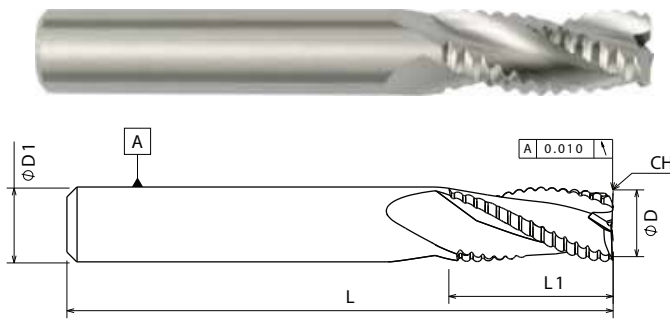


3 Flute

Centre cutting high performance chip breaker end mill for roughing of aluminium with corner chamfer



N1-N2



Unit : mm

ØD (mm)	L1 (mm)	L (mm)	ØD1 (mm)	CH (mm)	EDP Code
6	13	57	6	0.5	FBK0508672
8	16	63	8	1.00	FBK0508673
10	22	72	10	1.00	FBK0508674
12	26	83	12	1.00	FBK0508675
16	32	92	16	1.00	FBK0508676
20	38	104	20	1.00	FBK0508677
25	45	121	25	1.00	FBK0508678

Features

- 3 Flutes
- Center Cutting
- Coarse Pitch
- Roughing for Aluminium
- Uncoated

Functions

- High MRR
- Excellent for roughing and finishing of Aluminium

Benefits

- Superior Tool Life

3 Flute

Centre cutting high performance chip breaker end mill for roughing of aluminium with corner radius



END MILLS

N1-N4

Unit : mm

ØD (mm)	L1 (mm)	L (mm)	ØD1 (mm)	Cr (mm)	EDP Code
6	13	57	6	0.25	FBK0508701
8	16	63	8	0.25	FBK0508702
10	22	72	10	0.50	FBK0508703
12	26	83	12	0.50	FBK0508704
16	32	92	16	1.00	FBK0508705
20	38	104	20	1.00	FBK0508706
25	45	121	25	1.50	FBK0508707

Razor cut - NCBCH

ØD (mm)	L1 (mm)	Neck Length (mm)	Ø D2 (mm)	L (mm)	ØD1 (mm)	Cr (mm)	EDP Code
6	8	18	5	57	6	0.25	FBK0509069
8	10	24	7	63	8	0.25	FBK0509070
10	12	30	9	72	10	0.50	FBK0509071
12	15	36	11	83	12	0.50	FBK0509072
16	20	48	15	92	16	1.00	FBK0509073
20	24	60	19	104	20	1.00	FBK0509074

Features

- 3 Flutes
- Center Cutting
- Chamfered Pitch
- Roughing for Aluminium
- Uncoated

Functions

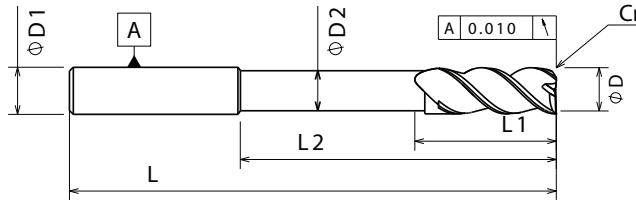
- High MRR
- Excellent for roughing and finishing of Aluminium

Benefits

- Superior Tool Life

3 Flute

Centre cutting high performance end mill for non ferrous materials with wiper technology



N1-N4

Unit : mm

ØD (mm)	L1 (mm)	ØD2 (mm)	L2 (mm)	L (mm)	ØD1 (mm)	Ø Cr (mm)	EDP Code
6	10	5.5	42	100	6	0.20	FBK0508679
8	13	7.3	48	100	8	0.20	FBK0508680
10	16	9.1	60	125	10	0.20	FBK0508681
12	20	11	73	125	12	0.20	FBK0508682
16	26	14.56	100	150	16	0.20	FBK0508683
20	32	18.20	100	150	20	0.20	FBK0508684

Features

- 3 Flutes
- Unequal flute Design
- Center Cutting
- Wiper technology for Excellent floor finish
- Uncoated

Functions

- High MRR
- Excellent for finishing of Aluminium

Benefits

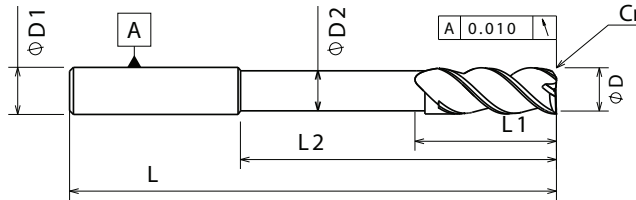
- Superior Tool Life
- Excellent floor finish

3 Flute

Centre cutting high performance end mill for non ferrous materials with wiper technology



END MILLS



N1-N2

Unit : mm

ØD (mm)	L1 (mm)	ØD2 (mm)	L2 (mm)	L (mm)	ØD1 (mm)	Ø Cr (mm)	EDP Code
6	9	5.4	18	63	6	0.20	FBK0508685
6	9	5.4	18	63	6	0.50	FBK0508686
6	9	5.4	18	63	6	1.00	FBK0508687
8	12	7.2	24	76	8	0.20	FBK0508688
8	12	7.2	24	76	8	0.50	FBK0508689
8	12	7.2	24	76	8	1.00	FBK0508690
10	15	9.0	30	89	10	0.20	FBK0508691
10	15	9.0	30	89	10	0.50	FBK0508692
10	15	9.0	30	89	10	1.00	FBK0508693
12	18	10.8	36	100	12	0.20	FBK0508694
12	18	10.8	36	100	12	0.50	FBK0508695
12	18	10.8	36	100	12	1.00	FBK0508696
16	24	14.4	48	110	16	0.20	FBK0508697
16	24	14.4	48	110	16	0.50	FBK0508698
16	24	14.4	48	110	16	1.00	FBK0508699
16	24	14.4	48	110	16	2.00	FBK0508700

Features

- 3 Flutes
- Unequal flute Design
- Center Cutting
- Wiper technology for Excellent floor finish
- Uncoated

Functions

- High MRR
- Excellent for finishing of Aluminium

Benefits

- Superior Tool Life
- Excellent floor finish



Solid Carbide End Mills

Razor cut - 3FWF Series

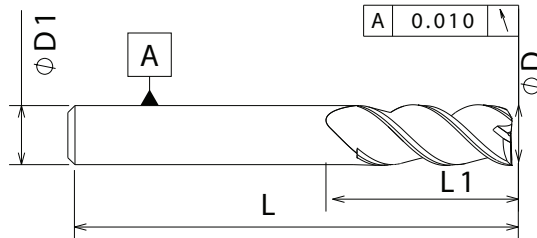
END MILLS

3 Flute

Centre cutting high performance end mill for non ferrous materials with wiper technology



N1-N2



Unit : mm

ØD (mm)	L1 (mm)	L (mm)	ØD1 (mm)	EDP Code
3.00	12.00	38.00	3.00	FBK0508708
4.00	12.00	51.00	4.00	FBK0508709
5.00	14.00	51.00	5.00	FBK0508710
6.00	16.00	50.00	6.00	FBK0508711
8.00	20.00	63.00	8.00	FBK0508712
10.00	22.00	76.00	10.00	FBK0508713
12.00	25.00	76.00	12.00	FBK0508714
16.00	32.00	89.00	16.00	FBK0508715
20.00	38.00	104.00	20.00	FBK0508716

Features

- 3 Flutes
- Unequal flute Design
- Center Cutting
- Wiper technology for Excellent floor finish
- Uncoated

Functions

- High MRR
- Excellent for finishing of Aluminium

Benefits

- Superior Tool Life
- Excellent floor finish



Solid Carbide End Mills

Razor cut - 2FWF Series

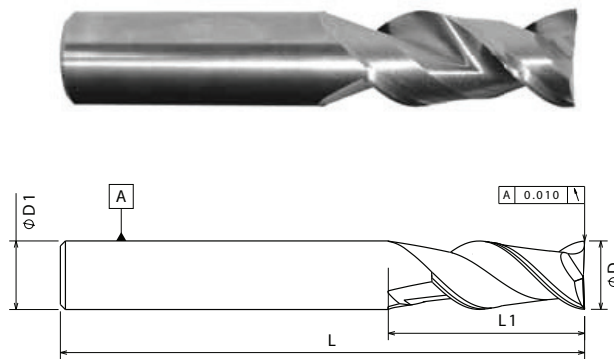
2 Flute

Centre cutting high performance end mill for non ferrous materials with wiper technology



END MILLS

N1-N2



Unit : mm

ØD (mm)	L1 (mm)	L (mm)	ØD1 (mm)	EDP Code
1.5	6	38	6	FBK0508795
2.0	8	38	8	FBK0508796
2.5	9	38	9	FBK0508797
3.0	12	38	12	FBK0508798
4.0	12	50	12	FBK0508799
5.0	14	50	14	FBK0508800
5.0	14	50	14	FBK0508801
6.0	16	50	16	FBK0508802
8.0	20	63	20	FBK0508803
10.0	22	76	22	FBK0508804
12.0	25	76	25	FBK0508805
16.0	32	89	32	FBK0508806
20.0	38	104	38	FBK0508807

Features

- 2 Flutes
- 45 Degree Helix
- Center Cutting
- Wiper technology for Excellent floor finish
- Uncoated

Functions

- High MRR
- Stable cutting at high cutting speeds

Benefits

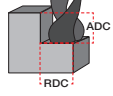
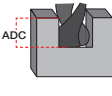
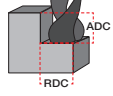
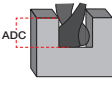
- Superior Tool Life

Application data on page no 2.148

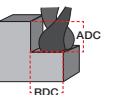
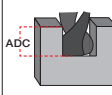
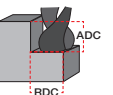
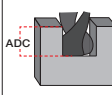
www.totem-forbes.com

Cutting parameters for Razor cut

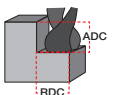
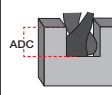
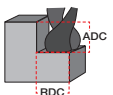
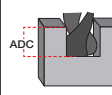
RAZORCUT- CBC

Material	Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/th) for side milling & For slotting, reduce fz by 20%.								
															
		Diameter in mm													
		ap	ae	ap	min	max	mm	6.0	8.0	10.0	12.0	16.0	20.0	25.0	
Non-Ferrous	N	1	1.5xD	0.5xD	1xD	500	2000	fz	0.066	0.088	0.11	0.132	0.176	0.22	0.275
		2	1.5xD	0.5xD	1xD	500	1500	fz	0.059	0.079	0.099	0.119	0.158	0.198	0.248

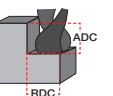
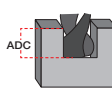
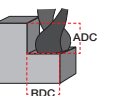
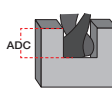
RAZORCUT- CBCH/NCBCH

Material	Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/th) for side milling & For slotting, reduce fz by 20%.								
															
		Diameter in mm													
		ap	ae	ap	min	max	mm	6.0	8.0	10.0	12.0	16.0	20.0	25.0	
Non-Ferrous	N	1	1.5xD	0.5xD	1xD	500	2000	fz	0.072	0.096	0.12	0.144	0.192	0.24	0.26
		2	1.5xD	0.5xD	1xD	500	1500	fz	0.065	0.086	0.108	0.13	0.173	0.216	0.24
		3	1.5xD	0.5xD	1xD	500	1500	fz	0.05	0.067	0.084	0.101	0.134	0.168	0.18
		4	1.5xD	0.5xD	1xD	400	750	fz	0.058	0.077	0.096	0.115	0.154	0.192	0.205
		5	1.5xD	0.5xD	1xD	250	1000	fz	0.065	0.086	0.108	0.13	0.173	0.216	0.234

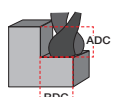
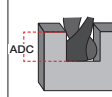
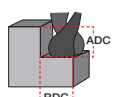
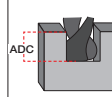
RAZORCUT- 3FWFXL/RAZOR CUT 3FWFCR

Material	Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/th) for side milling & For slotting, reduce fz by 20%.							
														
		Diameter in mm												
		ap	ae	ap	min	max	mm	6.0	8.0	10.0	12.0	16.0	20.0	
Non-Ferrous	N	1	1.0xD	0.5xD	1xD	500	2000	fz	0.060	0.080	0.100	0.120	0.160	0.200
		2	1.0xD	0.5xD	1xD	500	1500	fz	0.054	0.072	0.090	0.108	0.144	0.180

RAZORCUT- 3FWF

Material	Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/th) for side milling & For slotting, reduce fz by 20%.								
															
		Diameter in mm													
		ap	ae	ap	min	max	mm	3.0	6.0	8.0	10.0	12.0	16.0	20.0	
Non-Ferrous	N	1	1.5xD	0.5xD	1xD	500	2000	fz	0.027	0.054	0.072	0.090	0.108	0.144	0.180
		2	1.5xD	0.5xD	1xD	500	1500	fz	0.024	0.049	0.065	0.081	0.097	0.130	0.162

RAZORCUT- 2FWF

Material	Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/th) for side milling & For slotting, reduce fz by 20%.										
																	
		Diameter in mm															
		ap	ae	ap	min	max	mm	1.5	2.0	4.0	6.0	8.0	10.0	12.0	16	20	
Non-Ferrous	N	1	1.5xD	0.5xD	1xD	500	2000	fz	0.014	0.018	0.036	0.054	0.072	0.09	0.108	0.144	0.18
		2	1.5xD	0.5xD	1xD	500	1500	fz	0.012	0.016	0.032	0.049	0.065	0.081	0.097	0.13	0.162