

DISCOVER OUR

MILLING



Milling

NOMENCLATURE

CROMSON «ENDMILL»

- FLUTES

DIAMETER

CREM-Ti-5RC-0500-R010 Cr95

APPLICATIONS

AL- Aluminum
ALR- Aluminum Roughing
DM- Die & Mold
HD- Hard Material
HF- High Feed
SA (SAX)- Super Alloy
ST- Steel
SST- Stainless Steel
Ti- Titanium
TiX- Titanium HP
TP- Taper (NPT)

TOOL TYPE

S- Stub Length
M- Medium Length
R- Reg. Length
L- Long Length
E- Extended Length
N- Necking

C- Cylindrical Shank
W- Weldon Shank





















RADIUS/CHAMFER

BN- Ball Nose
C- Chamfer
R- Radius
SQ- Square

COATING

Cr20- Uncoated
Cr35- AlCrN
Cr55- TiAlN
Cr75- TiAlN+
Cr95- TiAlCN

Summary application chart-Milling




























































Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	RECORD ST	STAR SST	ALLIANCE TI
Low carbon steel <= 38HRc 1018, 12L14, 8620	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	350 425			
Medium carbon steels <= 38HRc 4140, 4340	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375			
Tool & die steels <= 38HRc A2, D2, O1, S7, P20, H13	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375			
Tool steel 39HRc to 48HRc	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	225 275			
Easy to machine stainless steel 416, 410, 302, 303	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	300 375			
Moderately difficult stainless steel 304, 316, invar, kovar	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	275 350			
Difficult to machine stainless steel 316L, 17-4PH, 15-5PH, 13-8Mo	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300			
Cast iron Grey	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	400 500			
Cast iron Ductile	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	300 400			
Cast iron Malleable	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D .75 x D	250 325			
Aluminum alloys 2024, 6061, 7075	Slotting	1 x D	1 x D 0.5 x D	800 1000			
Titanium alloys 6Al4V	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300			
High temperature alloys Inconel, haynes, stellite, hastelloy	Slotting	.25 x D 1 x D	1 x D .25 x D	70 95			



Highly recommended

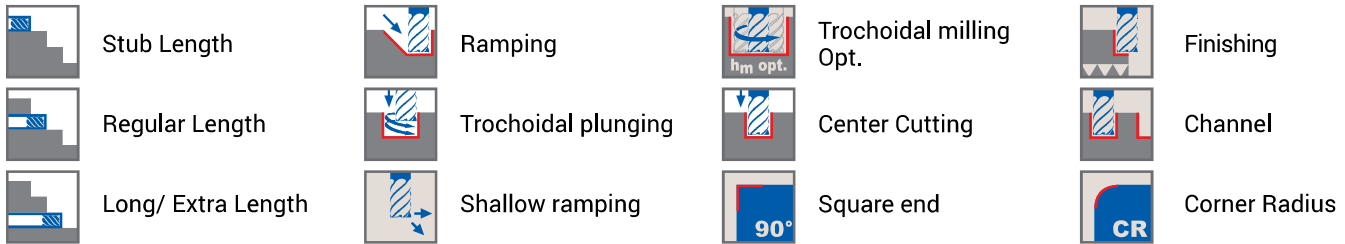


Suitable for some applications

PISTON HD	TURBINE SRGH	OXYGEN HF	TAPER-MILL TP	DRIVER DM	MOTION AL	BOSS ALR	MAGNAT STX	PERFOR-MANCE TIX	BOOSTER SA
									
									
									
									
									
									
									
									
									
									
									
									
									

** The machining values shown are guidelines.
The optimum data for a particular machining process should be determined in trials or during machining.

Explanation of Milling symbols



Grades chart & Milling application

CROMSON offers a variety of coating upon special request to meet the demands of every customer's needs and unique application demands. Through extensive testing, research and real world applications, CROMSON has worked to develop a full range of high performance coatings. These coating options allow us to address a multitude of situations with optimal results.

Please refer to the chart below for the various coatings available.

CROMSON GRADE	Cr20	Cr35	Cr55	Cr75	Cr95
Proprietary	Uncoated	AlCrN	TiAlN	TiAlN+	TiAlCN
Coating process		PVD	PVD	PVD	PVD
Layer structure		Nano structure	Nano structure	Nano structure	Nano structure
Hardness (HV)		3000	3300	3300	3060
Coefficient of friction (fetting)		0.25	0.30-0.35	0.25	0.35
Thermal stability (C)		1100	900	900	1000
General Information		New generation PVD coating providing a high level of wear and abrasion resistance in combination with a micro grain carbide substrate for use in all ferrous materials at elevated cutting speed.	A thick PVD coating on a balanced wear resistance/tough fine grain carbide substrate provides users with predictable consistent results in general purpose applications in all materials.	In combination with a tough submicron grain carbide substrate and advanced PVD coating technology a high level of security and wear resistance is seen in demanding applications in titanium and steel up to 52 HRC.	New generation PVD coating providing a high level of wear. lower coefficient of friction combination with a micro grain carbide substrate for use in stainless steel and nickel-based high temperature alloys.

CARBIDE END MILL

TURBINE SRGH SERIES

- ⊙ High Performance ROUGHING end mills feature differential flute spacing to achieve virtually chatter free machining in a wide range of materials
- ⊙ Excellent results can be achieved on all steels from carbon to alloy as well as stainless and even exotic materials
- ⊙ With this Superior Cr35 AlCrN (PVD) coating you can expect excellent wear and abrasion resistance in your general roughing applications
- ⊙ Available in cylindrical or Weldon style shank
- ⊙ Several radius sizes complete this product range which is offered in standard and long lengths
- ⊙ h6 tolerance for conventional and shrink fit applications

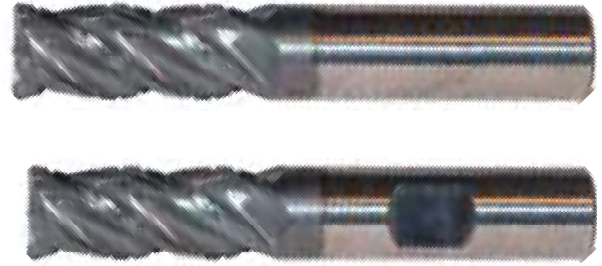
Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)
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Medium carbon steel <= 38HRc 4140, 4340	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375
Tool & die steel <= 38HRc A2, D2, O1, S7, P20, H13	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375
Tool steel 39HRc to 48HRc	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	225 275
Easy to machine stainless steel 416, 410, 302, 303	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	300 375
Moderately difficult stainless steel 304, 316, invar, kovar	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	275 350
Difficult to machine stainless steel 316L, 17-4PH, 15-5PH, 13-8Mo	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300
Titanium alloy 6Al4V	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300



CARBIDE END MILL - CHAMFER

TECHNICAL DETAILS

Tool Diameter Range	0.250-1.000 in
Shank tolerance	h6
Cutter tolerance	(+0.00-0.002 in) +0.00-0.05 mm
Number of flutes	4
Coating	AlCrN (PVD)
Variable pitch	Yes
Variable pitch	Variable
Variable helix	Standard
Helix angle	38°



70
135
0 HARDNESS (HRC)



EDP Cromson	Cromson Description	Diam.	Length of cut	Overall length	Chamfer	Cromson Grade	# Flutes
72001880	CREM-SRGH-4-0250-C10- Cr35	1/4	3/4	2.1/2	.010	Cr35	4
72001885	CREM-SRGH-4-0375-C10- Cr35	3/8	7/8	2.1/2	.010	Cr35	4
72001890	CREM-SRGH-4EC-0500-C20- Cr35	1/2	1.1/4	3	.020	Cr35	4
72001895	CREM-SRGH-4-0625-C30- Cr35	5/8	1.1/4	3.1/2	.030	Cr35	4
72001900	CREM-SRGH-4-0750-C30- Cr35	3/4	1.1/2	4	.030	Cr35	4
72001905	CREM-SRGH-4-1000-C30- Cr35	1	1.1/2	4	.030	Cr35	4
72001910	CREM-SRGH-4EW-0500-C20- Cr35	1/2	1.1/4	3	.020	Cr35	4
72001915	CREM-SRGH-4RW-0625-C30- Cr35	5/8	1.1/4	3.1/2	.030	Cr35	4
72001920	CREM-SRGH-4RW-0750-C30- Cr35	3/4	1.1/2	4	.030	Cr35	4
72001925	CREM-SRGH-4RW-1000-C30- Cr35	1	1.1/2	4	.030	Cr35	4

Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed (inches Per Tooth)					
					1/4	3/8	1/2	5/8	3/4	1
Low carbon steel <= 38HRc 1018, 12L14, 8620	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	350 425	.0016	.0024	.0032	.0040	.0048	.0064
					.0020	.0030	.0040	.0050	.0060	.0080
Medium carbon steel <= 38HRc 4140, 4340	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375	.0013	.0020	.0027	.0034	.0040	.0054
					.0017	.0026	.0035	.0044	.0053	.0070
Tool & die steel <= 38HRc A2, D2, O1, S7, P20, H13	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	325 375	.0013	.0020	.0027	.0034	.0040	.0054
					.0017	.0026	.0035	.0044	.0053	.0070
Tool steel 39HRc to 48HRc	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	225 275	.0010	.0015	.0020	.0025	.0030	.0040
					.0012	.0017	.0023	.0029	.0035	.0046
Easy to machine stainless steel 416, 410, 302, 303	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D	300 375	.0012	.0018	.0025	.0031	.0037	.0050
					.0016	.0024	.0032	.0040	.0048	.0064
Moderately difficult stainless steel 304, 316, invar, kovar	Slotting Peripheral - Rough	.75 x D 1 x D	1 x D 0.5 x D	275 350	.0011	.0016	.0022	.0027	.0033	.0044
					.0015	.0023	.0032	.0037	.0045	.0064
Difficult to machine stainless steel 316L, 17-4PH, 15-5PH, 13-8Mo	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300	.0009	.0012	.0018	.0022	.0027	.0036
					.0011	.0016	.0022	.0028	.0033	.0044
Cast iron Grey	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D							
Cast iron Ductile	Slotting Peripheral - Rough	1 x D 1.5 x D	1 x D 0.5 x D							
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Aluminum alloy 2024, 6061, 7075	Slotting	1 x D	1 x D 0.5 x D							
Titanium alloy 6Al4V	Slotting Peripheral - Rough	0.5 x D 1 x D	1 x D 0.5 x D	250 300	.0010	.0015	.0020	.0025	.0030	.0040
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