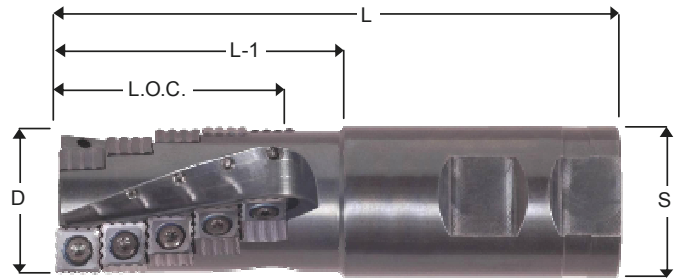


SERATORS

Long Edge Roughing Mills

.985 - 1.485 Diameter



IMPORTANT
SERATORS ARE TO BE RUN AS HALF THE NUMBER OF FLUTES EFFECTIVE
HIGH PRESSURE FLOOD COOLANT OR AIR BLAST REQUIRED TO DISPERSE CHIP AND COOL THE TOOL.
RECURTING CHIPS WILL CAUSE EARLY INSERT FAILURE.

Tool #	D	Flutes	Inserts	L	L-1	L.O.C.	S	Screw	Wrench	Inserts
S-100S	.985	2-1 Eff.	4	3.125	1.130	.780	.750			
S-100M	.985	2-1 Eff.	6	3.625	1.380	1.125	1.000			
S-100	.985	2-1 Eff.	8	4.000	1.750	1.500	1.000			
S-125S	1.235	3-1.5 Eff.	9	3.750	1.500	1.125	1.000			
S-125	1.235	3-1.5 Eff.	15	4.625	2.380	1.900	1.250	538T	T-10	SNMC-333B SNGC-333H SNMC-332P
S-125L	1.235	2-1 Eff.	16	5.625	3.380	3.062	1.250			
S-150S	1.485	3-1.5 Eff.	9	3.875	1.630	1.125	1.000			
S-150	1.485	3-1.5 Eff.	18	4.875	2.500	2.250	1.250			
S-150L	1.485	3-1.5 Eff.	33	7.250	4.630	4.200	1.500			

Speed and Feed Info.

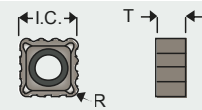
Material	S.F.M.	I.P.T.
Mild & Low Carbon Steel Ex. 1018, 1020, 1117, 1141, 12L14	600-1200	.002-.006
High Carbon & Alloy Steel Ex. 1045, 4140, 4340, 52100, 8620	500-800	.002-.004
Lower Carbon Tool Steel Ex. P-20, H-13, S-7	400-700	.002-.004
Tool Steel Ex. A-2, A-6, D-2, M-2	300-600	.002-.004
Stainless Steel Ex. 304, 316, 420, 15-5PH, 17-4PH	300-600	.002-.004
Iron Ex. Cast, Ductile, Nodular	600-1000	.003-.006
Nickel & Titanium Alloy Ex. Inconel, Hastelloy, Ti-6AL-4V	100-180	.001-.003

Tool #	Price
S-100S	\$198.00
S-100M	\$275.00
S-100	\$343.00
S-125S	\$314.00
S-125	\$487.00
S-125L	\$530.00
S-150S	\$334.00
S-150	\$582.00
S-150L	\$850.00

K-TOOL INC.

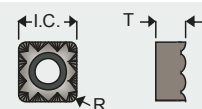
Hemly
TOOL SUPPLY INC.

Positive Top Insert



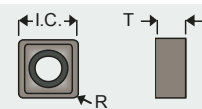
Insert #	I.C.	T	R	Grade
SNMC-333B	.375	.187	.047	X20

Positive Top Insert



Insert #	I.C.	T	R	Grade
SNGC-333H	.375	.187	.047	X20

Positive Top Insert



Insert #	I.C.	T	R	Grade
SNMC-332P	.375	.187	.031	X20

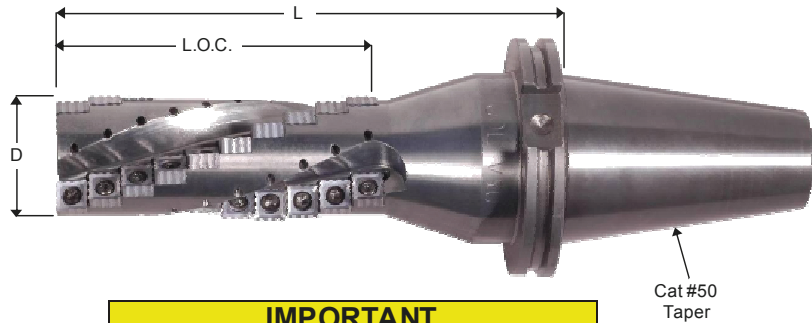
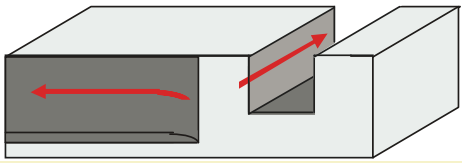
Insert #	Price
SNMC-333B	\$8.20
SNGC-333H	\$10.20
SNMC-332P	\$8.20

INTEGRAL SERATORS

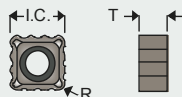
Long Edge Roughing Mills

**1.980 - 2.980
Diameter**

Application

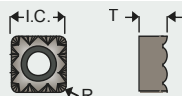


Positive Top Insert



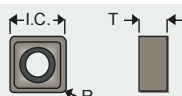
Insert #	I.C.	T	R	Grade
SNMC-444B	.500	.250	.062	X20

Positive Top Insert



Insert #	I.C.	T	R	Grade
SNGC-444H	.500	.250	.062	X20

Positive Top Insert



Insert #	I.C.	T	R	Grades
SNMC-443P	.500	.250	.047	A9M X20

Insert #	Price
SNMC-444B	\$11.00
SNGC-444H	\$11.20
SNMC-443P	\$11.00

IMPORTANT

**SERATORS ARE TO BE RUN AS HALF
THE NUMBER OF FLUTES EFFECTIVE**

HIGH PRESSURE FLOOD COOLANT OR AIR BLAST
REQUIRED TO DISPERSE CHIP AND COOL THE TOOL.

RECURTING CHIPS WILL CAUSE EARLY INSERT FAILURE.

Speed and Feed Info.

Material	S.F.M.	I.P.T.
Mild & Low Carbon Steel EX. 1018, 1020, 1117, 1141, 12L14	600-1200	.002-.006
High Carbon & Alloy Steel EX. 1045, 4140, 4340, 52100, 8620	500-800	.002-.004
Lower Carbon Tool Steel EX. P-20, H-13, S-7	400-700	.002-.004
Tool Steel EX. A-2, A-6, D-2, M-2	300-600	.002-.004
Stainless Steel EX. 304, 316, 420, 15-5PH, 17-4PH	300-600	.002-.004
Iron EX. Cast, Ductile, Nodular	600-1000	.003-.006
Nickel & Titanium Alloy EX. Inconel, Hastelloy, Ti-6AL-4V	100-180	.001-.003

Tool #	D	Flutes	Inserts	L	L.O.C.	Screw	Wrench	Inserts
V50-203	1.980	4-2 Eff.	28	6.000	3.600	838T	T-20	SNMC-444B SNGC-444H SNMC-443P
V50-205	1.980	3-1.5 Eff.	30	8.000	5.100			
V50-253	2.480	4-2 Eff.	28	6.000	3.600			
V50-256	2.480	4-2 Eff.	48	8.000	6.100			
V50-303	2.980	4-2 Eff.	28	6.000	3.600			
V50-306	2.980	4-2 Eff.	48	8.000	6.100			

Tool #	Price
V50-203	\$857.00
V50-205	\$1,025.00
V50-253	\$1,041.00
V50-256	\$1,219.00
V50-303	\$1,292.00
V50-306	\$1,467.00

Hemly
TOOL SUPPLY INC.

HEADQUARTERS
HEMILY TOOL SUPPLY INC.
9700 Madison Road
Montville, OH 44064
1-800-445-1068
Tel: 440-968-3228
Fax: 440-968-3611

CT BRANCH
HEMILY TOOL SUPPLY OF CT, LLC
111 Pane Road
Newington, CT 06111
1-888-474-1300
Tel: 860-436-4570
Fax: 860-436-4807

www.hemlytool.com
e-mail: sales@hemlytool.com