










QUICK-FINDER - TECH-LINE and PRO-LINE end mill selection guide

Application			Slot drilling  1 x d	Roughing  0.3-0.8 x d	Finishing  > 0.1 x d	Super finishing  0.1 x d
Material/ Application group	Hardness tensile strength	Example material	Rigid conditions:  - good cooling - short-chipping	Unstable conditions:  - standard cooling - medium- to long-chipping	Finishing: 	
Steel 	up to 28 HRc	1045 / 5115	Uni-Pro Series #3153 Page 133	Rough-Tech 48 Series #3188 Page 99	Finish-Tech 50 Series #3179 Page 103	
	above 28 HRc	4140	Aero-Tech Series #3173 Page 85	Aero-Rough 48 Series #3097 Page 95		
Stainless steel 	up to 28 HRc	304 / 303	Uni-Pro Series #3153 Page 133	Aero-Rough 48 Series #3097 Page 95		
	above 28 HRc	316Ti	Aero-Tech Series #3173 Page 85	Aero-Rough 48 Series #3097 Page 95		
Cast iron 	up to 180 HB 30	Gray Cast	Uni-Pro Series #3153 Page 133	Aero-Rough 48 Series #3097 Page 95		
	above 180 HB 30	GGG / GGT / GGv ductile	Aero-Tech Series #3173 Page 85	Aero-Rough 56 Series #3098 Page 96		
Aluminium 	up to 3% Si	Wrought Alloys	Alumi-Tech Series #3174 Page 89	Rough-Tech ALU Series #3184 Page 93	Alumi-Tech Series #3177 Page 91	
	above 3% Si	Cast Alloys	Aero-Tech Series #3173 Page 85	Rough-Tech ALU Series #3184 Page 93	Uni-Pro Series #3153 Page 133	
Ti- special alloys 	Ti-basis	TiAl6V4 Inconel 625	Aero-Tech Series #3173 Page 85	Aero-Rough 56 Series #3098 Page 96	Finish-Tech 50 Series #3179 Page 103	
	Ni-basis	Inconel 728	Uni-Pro Series #3153 Page 133	Aero-Rough 48 Series #3097 Page 95		
Hardened steel H	up to 52 HRC	H11	Aero-Tech Series #3173 Page 85	Aero-Rough 56 Series #3098 Page 96		
	above 52 HRC	D2	—	Rough-Tech 56 Series #3189 Page 101	Finish-Tech 62 Series #3182 Page 107	