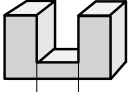













# QUICK-FINDER - TECH-LINE end mill selection guide

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	Aero-Tech Series #3713 <b>Page 85</b>	Rough-Tech 48 Series #3188 <b>Page 99</b>	Finish-Tech 50 Series #3179 <b>Page 103</b>	
	above 28 HRc	4140	Aero-Tech Series #3173 <b>Page 85</b>	Aero-Rough 48 Series #3097 <b>Page 95</b>		
Stainless steel 	up to 28 HRc	304 / 303	Aero-Tech Series #3713 <b>Page 85</b>	Aero-Rough 48 Series #3097 <b>Page 95</b>		
	above 28 HRc	316Ti	Aero-Tech Series #3173 <b>Page 85</b>	Aero-Rough 48 Series #3097 <b>Page 95</b>		
Cast iron 	up to 180 HB 30	Gray Cast	Aero-Tech Series #3713 <b>Page 85</b>	Aero-Rough 48 Series #3097 <b>Page 95</b>		
	above 180 HB 30	GGG / GGT / GGv ductile	Aero-Tech Series #3173 <b>Page 85</b>	Aero-Rough 56 Series #3098 <b>Page 96</b>		
Aluminium 	up to 3% Si	Wrought Alloys	Alumi-Tech Series #3174 <b>Page 89</b>	Rough-Tech ALU Series #3184 <b>Page 93</b>	Alumi-Tech Series #3177 <b>Page 91</b>	
	above 3% Si	Cast Alloys	Aero-Tech Series #3713 <b>Page 85</b>	Rough-Tech ALU Series #3184 <b>Page 93</b>	Alumi-Tech Series #3177 <b>Page 91</b>	
Ti- special alloys 	Ti-basis	TiAl6V4 Inconel 625	Aero-Tech Series #3713 <b>Page 85</b>	Aero-Rough 56 Series #3098 <b>Page 96</b>	Finish-Tech 50 Series #3179 <b>Page 103</b>	
	Ni-basis	Inconel 728	Aero-Tech Series #3713 <b>Page 85</b>	Aero-Rough 48 Series #3098 <b>Page 96</b>		
Hardened steel <b>H</b>	up to 52 HRC	H11	Aero-Tech Series #3713 <b>Page 85</b>	Aero-Rough 56 Series #3098 <b>Page 96</b>		
	above 52 HRC	D2	—	Rough-Tech 56 Series #3189 <b>Page 101</b>		