

# Mil-Tec High Feed

- Steel
- Stainless
- Titanium



Feed rates of 150 to 300 IPM in Steels and Stainless Steels are possible. In Titanium, speeds up to 500 SFPM at 50 IPM.

Mil-Tec® **High Feed** Face Mills and End Mills bring a new level of milling performance to the metalworking industry. These High Feed cutters incorporate Mil-Tec's Positive Geometry and precision ground square inserts. High Feed cutters are free cutting making them ideal for steel, stainless steel and even exotics such as Titanium\*. The Mil-Tec **High Feed** mill is the perfect mill for smaller CNC's and 40 taper spindles.

## Shank Style High Feed

Part#	EDP#	Dia	Shank	OAL	# Inserts	List Price
HFC-1.5-2-8	02152	1-1/2"	1"	4"	2	\$210.00
HFC-1.5-2-10	02153	1-1/2"	1-1/4"	4"	2	\$210.00
HFC-2-3-8	02154	2"	1"	4"	3	\$310.00
HFC-2-3-10	02155	2"	1-1/4"	4"	3	\$310.00

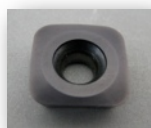


## Shell Mill Style High Feed

Part#	EDP#	Dia	Bore	Keyway	Inserts	List Price
HFC-2-4 ML	02165	2"	3/4	5/16	4	\$250.00
HFC-2.5-4 NS	02156	2-1/2"	1"	.380"	4	\$325.00
HFC-2.5-4 ML	02157	2-1/2"	1-1/4"	.500"	4	\$325.00
HFC-3-5 NS	02158	3"	1"	.380"	5	\$380.00
HFC-3-5 ML	02159	3"	1-1/4"	.500"	5	\$380.00
HFC-4-6 ML	02160	4"	1-1/2"	.625"	6	\$500.00

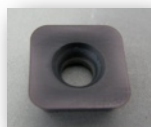


## Recommended High Feed Inserts



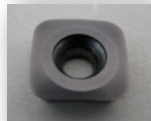
### **Steel and Stainless Steel Inserts: \$14.50 ea EDP# 72752AT**

S-NP-125-52-AT / 72752AT: Square insert with .125 radius with Premium AT / AlTiN coating. Ideal for roughing in steel, Stainless Steel and Cast Iron. Four cutting edges.



### **Titanium, High Temperature and Exotic Alloys: \$14.50 ea EDP# 63712AT**

Z-PS-125-12-AT / 63712AT: Square insert with .125 radius with Premium AT / AlTiN coating. Ideal for roughing in Stainless, Titanium, Inconel and high temperature alloys. Two cutting edges.



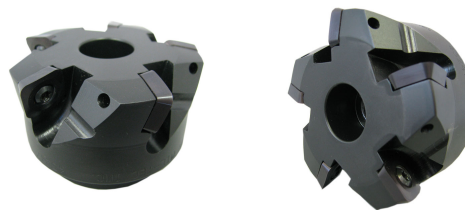
### **Steel and Stainless Steel Inserts: \$15.50 ea EDP# 72752A2**

S-NP-125-52-A2 Square insert with .125 radius with Premium Double thick AT / AlTiN coating. Ideal for roughing in steel, Stainless Steel and Cast Iron. The thicker AT coating provides the longest insert life in abrasive





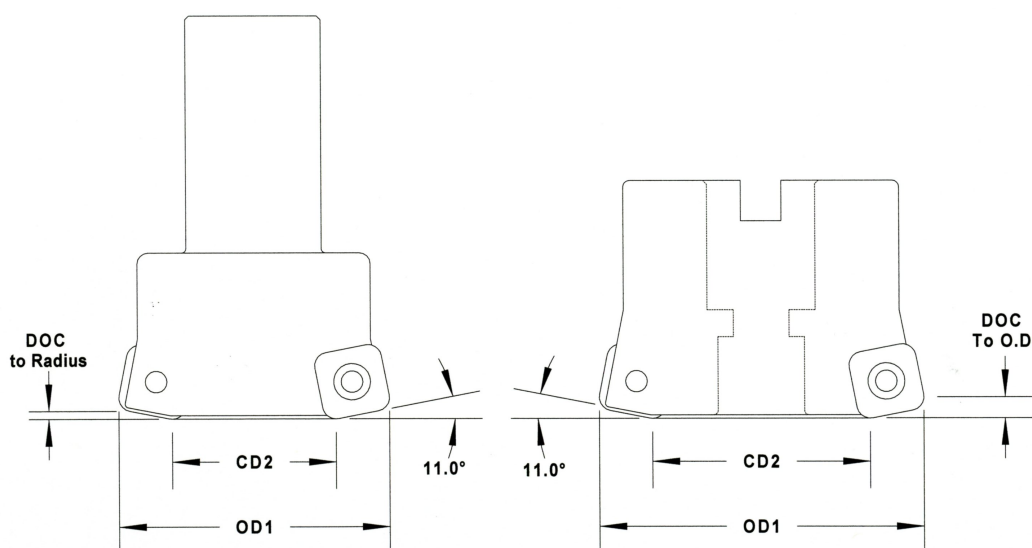
# Mil-Tec High Feed



## Freedom Cutter High Feed HFC Speeds and Feeds

Material	Alloy Grade	Speed SFPM	Feed per Tool
Steel	1018, 1020	900-1000	.020" - .050"
	4140, 4340, P20	700-800	.020" - .035"
Stainless Steel	A2, D2, H13	600-700	.015" - .025"
	13-8, 15-5, 17-4	600-800	.020" - .035"
	303, 304, 316	700-900	.020" - .035"
	420, 440C	700-900	.020" - .030"
Titanium *	6Al-4V	300-400	.010" - .020"

\* Must use PS90 insert # 63712AT



OD1	CD2	Radius	DOC to Radius	DOC To O.D.
1.5"	.620"	.125"	.070"	.182"
2.0"	1.070"	.125"	.070"	.182"
2.5"	1.560"	.125"	.070"	.182"
3.0"	2.050"	.125"	.070"	.182"
4.0"	3.040"	.125"	.070"	.182"

Visit the Tool  
Alliance YouTube  
site to view the  
Freedom High  
Feed in action.

