



QUALITY CARBIDE TOOLS

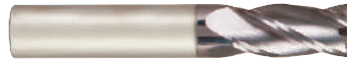
BY PROFESSIONALS
TO PROFESSIONALS

Solid Carbide End Mills

TRULine[®] 
For Milling Upto 40 HRC



FLAT



Std - Long - Extra Long

Z = 4



Z = 2



Cutter Dia	Cutting Length	Overall Length	Shank Dia	Series	Item Code	Item Code
1.0	4.0	38.0	3.0	Std	104SF-0100	102SF-0100
1.5	4.5	38.0	3.0	Std	104SF-0150	102SF-0150
2.0	6.3	38.0	3.0	Std	104SF-0200	102SF-0200
2.0	6.0	50.0	6.0	Std	104SF-0200-6SH	
2.5	9.5	38.0	3.0	Std	104SF-0250	102SF-0250
2.5	8.0	50.0	6.0	Std	104SF-0250-6SH	
3.0	12.0	38.0	3.0	Std	104SF-0300	102SF-0300
3.0	8.0	50.0	6.0	Std	104SF-0300-6SH	
3.0	19.0	57.0	3.0	Long	104LF-0300	102LF-0300
3.0	25.0	75.0	3.0	Ex-Long	104ELF-0300	102ELF-0300
3.5	14.0	50.0	4.0	Std	104SF-0350	102SF-0350
4.0	14.0	50.0	4.0	Std	104SF-0400	102SF-0400
4.0	10.0	50.0	6.0	Std	104SF-0400-6SH	
4.0	19.0	57.0	4.0	Long	104LF-0400	102LF-0400
4.0	25.0	75.0	4.0	Ex-Long	104ELF-0400	102ELF-0400
4.5	16.0	50.0	5.0	Std	104SF-0450	102SF-0450
5.0	16.0	50.0	5.0	Std	104SF-0500	102SF-0500
5.0	13.0	50.0	6.0	Std	104SF-0500-6SH	
5.0	25.0	63.0	5.0	Long	104LF-0500	102LF-0500
5.0	25.0	75.0	5.0	Ex-Long	104ELF-0500	102ELF-0500
5.5	19.0	50.0	6.0	Std	104SF-0550	102SF-0550
6.0	19.0	50.0	6.0	Std	104SF-0600	102SF-0600
6.0	28.0	76.0	6.0	Long	104LF-0600	102LF-0600
6.0	38.0	100.0	6.0	Ex-Long	104ELF-0600	102ELF-0600
6.5	19.0	63.0	8.0	Std	104SF-0650	102SF-0650
7.0	19.0	63.0	8.0	Std	104SF-0700	102SF-0700
7.5	20.0	63.0	8.0	Std	104SF-0750	102SF-0750
8.0	20.0	63.0	8.0	Std	104SF-0800	102SF-0800
8.0	29.0	76.0	8.0	Long	104LF-0800	102LF-0800
8.0	38.0	100.0	8.0	Ex-Long	104ELF-0800	102ELF-0800
8.5	22.0	75.0	10.0	Std	104SF-0850	102SF-0850
9.0	22.0	75.0	10.0	Std	104SF-0900	102SF-0900
9.5	22.0	75.0	10.0	Std	104SF-0950	102SF-0950
10.0	22.0	75.0	10.0	Std	104SF-1000	102SF-1000
10.0	32.0	76.0	10.0	Long	104LF-1000	102LF-1000
10.0	38.0	100.0	10.0	Ex-Long	104ELF-1000	102ELF-1000
10.5	25.0	75.0	12.0	Std	104SF-1050	102SF-1050
11.0	25.0	75.0	12.0	Std	104SF-1100	102SF-1100
11.5	25.0	75.0	12.0	Std	104SF-1150	102SF-1150
12.0	25.0	75.0	12.0	Std	104SF-1200	102SF-1200
12.0	51.0	100.0	12.0	Long	104LF-1200	102LF-1200
12.0	75.0	150.0	12.0	Ex-Long	104ELF-1200	102ELF-1200
14.0	32.0	89.0	14.0	Std	104SF-1400	102SF-1400
16.0	32.0	89.0	16.0	Std	104SF-1600	102SF-1600
16.0	57.0	127.0	16.0	Long	104LF-1600	102LF-1600
16.0	75.0	150.0	16.0	Ex-Long	104ELF-1600	102ELF-1600
18.0	38.0	100.0	18.0	Std	104SF-1800	102SF-1800
20.0	38.0	100.0	20.0	Std	104SF-2000	102SF-2000
20.0	57.0	127.0	20.0	Long	104LF-2000	102LF-2000
20.0	75.0	150.0	20.0	Ex-Long	104ELF-2000	102ELF-2000
25.0	38.0	100.0	25.0	Std	104SF-2500	102SF-2500
25.0	75.0	150.0	25.0	Ex-Long	104ELF-2500	102ELF-2500



Long Reach

Z = 4



Z = 2



Cutter Dia	Cutting Length	Overall Length	Shank Dia	Series	Item Code	Item Code
6.0	30.0	105.0	6.0	X-Long	104XLF-0600	102XLF-0600
6.0	40.0	150.0	6.0	XX-Long	104XXLF-0600	102XXLF-0600
8.0	30.0	105.0	8.0	X-Long	104XLF-0800	102XLF-0800
8.0	40.0	150.0	8.0	XX-Long	104XXLF-0800	102XXLF-0800
10.0	30.0	105.0	10.0	X-Long	104XLF-1000	102XLF-1000
10.0	40.0	150.0	10.0	XX-Long	104XXLF-1000	102XXLF-1000
12.0	40.0	150.0	12.0	X-Long	104XLF-1200	102XLF-1200
12.0	50.0	200.0	12.0	XX-Long	104XXLF-1200	102XXLF-1200
16.0	40.0	150.0	16.0	X-Long	104XLF-1600	102XLF-1600
16.0	50.0	200.0	16.0	XX-Long	104XXLF-1600	102XXLF-1600



Std - Long - Extra Long

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Cutter Dia	Cutting Length	Overall Length	Shank Dia	Series	Item Code	Item Code
1.0	4.0	38.0	3.0	Std	104SB-0100	102SB-0100
1.5	4.5	38.0	3.0	Std	104SB-0150	102SB-0150
2.0	6.3	38.0	3.0	Std	104SB-0200	102SB-0200
2.0	6.0	50.0	6.0	Std	104SB-0200-6SH	
2.5	9.5	38.0	3.0	Std	104SB-0250	102SB-0250
2.5	8.0	50.0	6.0	Std	104SB-0250-6SH	
3.0	12.0	38.0	3.0	Std	104SB-0300	102SB-0300
3.0	8.0	50.0	6.0	Std	104SB-0300-6SH	
3.0	19.0	57.0	3.0	Long	104LB-0300	102LB-0300
3.0	25.0	75.0	3.0	Ex-Long	104ELB-0300	102ELB-0300
3.5	14.0	50.0	4.0	Std	104SB-0350	102SB-0350
4.0	14.0	50.0	4.0	Std	104SB-0400	102SB-0400
4.0	10.0	50.0	6.0	Std	104SB-0400-6SH	
4.0	19.0	57.0	4.0	Long	104LB-0400	102LB-0400
4.0	25.0	75.0	4.0	Ex-Long	104ELB-0400	102ELB-0400
4.5	16.0	50.0	5.0	Std	104SB-0450	102SB-0450
5.0	16.0	50.0	5.0	Std	104SB-0500	102SB-0500
5.0	13.0	50.0	6.0	Std	104SB-0500-6SH	
5.0	25.0	63.0	5.0	Long	104LB-0500	102LB-0500
5.0	25.0	75.0	5.0	Ex-Long	104ELB-0500	102ELB-0500
5.5	19.0	50.0	6.0	Std	104SB-0550	102SB-0550
6.0	19.0	50.0	6.0	Std	104SB-0600	102SB-0600
6.0	28.0	76.0	6.0	Long	104LB-0600	102LB-0600
6.0	38.0	100.0	6.0	Ex-Long	104ELB-0600	102ELB-0600
6.5	19.0	63.0	8.0	Std	104SB-0650	102SB-0650
7.0	19.0	63.0	8.0	Std	104SB-0700	102SB-0700
7.5	20.0	63.0	8.0	Std	104SB-0750	102SB-0750
8.0	20.0	63.0	8.0	Std	104SB-0800	102SB-0800
8.0	29.0	76.0	8.0	Long	104LB-0800	102LB-0800
8.0	38.0	100.0	8.0	Ex-Long	104ELB-0800	102ELB-0800
8.5	22.0	75.0	10.0	Std	104SB-0850	102SB-0850
9.0	22.0	75.0	10.0	Std	104SB-0900	102SB-0900
9.5	22.0	75.0	10.0	Std	104SB-0950	102SB-0950
10.0	22.0	75.0	10.0	Std	104SB-1000	102SB-1000
10.0	32.0	76.0	10.0	Long	104LB-1000	102LB-1000
10.0	38.0	100.0	10.0	Ex-Long	104ELB-1000	102ELB-1000
10.5	25.0	75.0	12.0	Std	104SB-1050	102SB-1050
11.0	25.0	75.0	12.0	Std	104SB-1100	102SB-1100
11.5	25.0	75.0	12.0	Std	104SB-1150	102SB-1150
12.0	25.0	75.0	12.0	Std	104SB-1200	102SB-1200
12.0	51.0	100.0	12.0	Long	104LB-1200	102LB-1200
12.0	75.0	150.0	12.0	Ex-Long	104ELB-1200	102ELB-1200
14.0	32.0	89.0	14.0	Std	104SB-1400	102SB-1400
16.0	32.0	89.0	16.0	Std	104SB-1600	102SB-1600
16.0	57.0	127.0	16.0	Long	104LB-1600	102LB-1600
16.0	75.0	150.0	16.0	Ex-Long	104ELB-1600	102ELB-1600
18.0	38.0	100.0	18.0	Std	104SB-1800	102SB-1800
20.0	38.0	100.0	20.0	Std	104SB-2000	102SB-2000
20.0	57.0	127.0	20.0	Long	104LB-2000	102LB-2000
20.0	75.0	150.0	20.0	Ex-Long	104ELB-2000	102ELB-2000
25.0	38.0	100.0	25.0	Std	104SB-2500	102SB-2500
25.0	75.0	150.0	25.0	Ex-Long	104ELB-2500	102ELB-2500



Long Reach

Z = 4



Z = 2



Cutter Dia	Cutting Length	Overall Length	Shank Dia	Series	Item Code	Item Code
6.0	30.0	105.0	6.0	X-Long	104XLB-0600	102XLB-0600
6.0	40.0	150.0	6.0	XX-Long	104XXLB-0600	102XXLB-0600
8.0	30.0	105.0	8.0	X-Long	104XLB-0800	102XLB-0800
8.0	40.0	150.0	8.0	XX-Long	104XXLB-0800	102XXLB-0800
10.0	30.0	105.0	10.0	X-Long	104XLB-1000	102XLB-1000
10.0	40.0	150.0	10.0	XX-Long	104XXLB-1000	102XXLB-1000
12.0	40.0	150.0	12.0	X-Long	104XLB-1200	102XLB-1200
12.0	50.0	200.0	12.0	XX-Long	104XXLB-1200	102XXLB-1200
16.0	40.0	150.0	16.0	X-Long	104XLB-1600	102XLB-1600
16.0	50.0	200.0	16.0	XX-Long	104XXLB-1600	102XXLB-1600

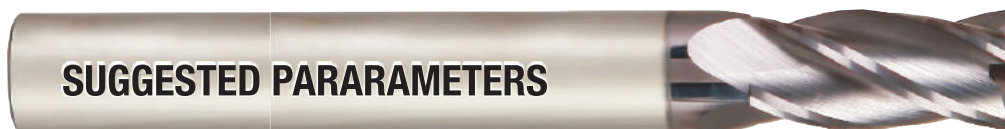
BALL



Other Product

Range :

- Drills
- Step Drills
- Rotary Burrs



END MILLS - GENERAL APPLICATION SERIES - 102 / 103 / 104

Material	Speed(M / Min)	Feed (MM - Tooth)		
		Dia<= 6MM	Dia<= 12MM	Dia<= 25MM
CARBON & ALLOY STEEL UPTO 30 HRC	50 ~ 190	0.005 - 0.040	0.025 - 0.076	0.076 - 0.179
CARBON & ALLOY STEEL < 38 ~ 40 HRC	20 ~ 60	0.005 - 0.013	0.005 - 0.025	0.025 - 0.076
DIE STEEL UPTO - 40 HRC	20 ~ 80	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
STAINLESS STEELS - 300 SERIES	40 ~ 80	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
STAINLESS STEELS - 400 SERIES	30 ~ 60	0.005 - 0.013	0.013 - 0.025	0.025 - 0.130
GREY CAST IRON	50 ~ 180	0.005 - 0.040	0.040 - 0.076	0.076 - 0.203
DUCTILE CAST IRON	30 ~ 120	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
MALLEABLE CAST IRON	40 ~ 150	0.005 - 0.025	0.025 - 0.076	0.076 - 0.178
NICKEL BASED ALLOYS	5 ~ 40	0.008 - 0.020	0.020 - 0.025	0.025 - 0.050
TITANIUM ALLOYS	10 ~ 60	0.005 - 0.020	0.020 - 0.050	0.050 - 0.102
COBALT BASED ALLOYS	5 ~ 30	0.005 - 0.020	0.020 - 0.025	0.025 - 0.050
ALUMINIUM	180 ~ 400	0.005 - 0.050	0.050 - 0.102	0.102 - 0.203
MAGNESIUM	300 ~ 400	0.013 - 0.050	0.050 - 0.102	0.102 - 0.254
COPPER / BRASS	80 ~ 280	0.013 - 0.050	0.050 - 0.076	0.076 - 0.152
PLASTIC	180 ~ 400	0.015 - 0.076	0.076 - 0.152	0.152 - 0.381
FIBREGLASS	90 ~ 240	0.015 - 0.076	0.076 - 0.102	0.102 - 0.254
GRAPHITE	180 ~ 300	0.076 - 0.130	0.130 - 0.203	0.203 - 0.254
WOOD*	15,000 - 25,000 RPM*	0.038 - 0.076	0.076 - 0.130	0.130 - 0.179

CONVERSION FORMULAS

Cutting Speed : RPM (To) M/Min (3.14 X Tool Dia)X RPM/1000

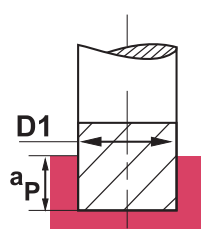
Cutting Speed : M/Min (To) RPM 1000 X M/Min / (3.14 X Tool Dia)

Feed : RPM X No's Of Tooth

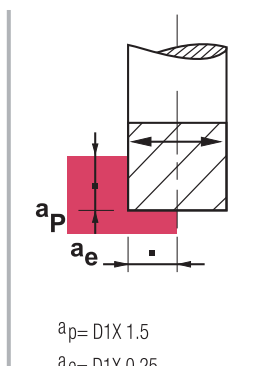
D1 = Cutter Dia

a_p = Axial Depth Of Cut

a_e = Radial Depth Of Cut

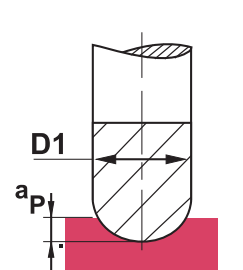


$$a_p = D1 \times 0.40$$

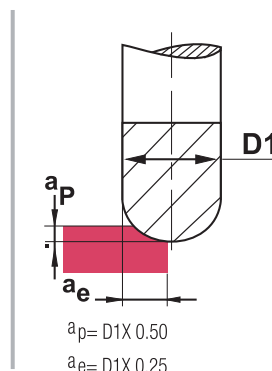


$$a_p = D1 \times 1.5$$

$$a_e = D1 \times 0.25$$



$$a_p = D1 \times 0.50$$



$$a_p = D1 \times 0.50$$

$$a_e = D1 \times 0.25$$

All suggested parameter should be considered as starting point with possible variations to achieve optimum results.

Dealer :

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