



QUALITY CUTTING TOOLS

An ISO 9001:2015 Certified Company

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TO PROFESSIONALS

Hss-Co



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HSS-Co ENDMILL

M104FS - (4 Flute Flat STD Length) (DIN-844K)



Code	Cutter dia-k10	Cutter length	OAL	Shank dia-h6
M104FS-0600	6	13	57	6
M104FS-0700	7	16	66	10
M104FS-0800	8	19	69	10
M104FS-0900	9	19	69	10
M104FS-1000	10	22	72	10
M104FS-1100	11	22	79	12
M104FS-1200	12	26	83	12
M104FS-1300	13	26	83	12
M104FS-1400	14	26	83	12
M104FS-1500	15	26	83	12
M104FS-1600	16	32	92	16
M104FS-1800	18	32	92	16
M104FS-2000	20	38	104	20
M104FS-2200	22	38	104	20
M104FS-2400	24	45	121	25
M104FS-2500	25	45	121	25
M104FS-2600	26	45	121	25
M104FS-2800	28	45	121	25
M104FS-3000	30	45	121	25
M104FS-3200	32	53	133	32
M104FS-4000	40	63	155	40

HSS-Co ROUGHING ENDMILL

M124RCS-(4 Flute Flat STD Length Rough) (DIN 844K)



Code	Cutter dia-k12	Cutter length	OAL	Shank dia-h6
M124RCS-0600	6	13	57	6
M124RCS-0700	7	16	66	10
M124RCS-0800	8	19	69	10
M124RCS-0900	9	19	69	10
M124RCS-1000	10	22	72	10
M124RCS-1100	11	22	79	12
M124RCS-1200	12	26	83	12
M124RCS-1300	13	26	83	12
M124RCS-1400	14	26	83	12
M124RCS-1500	15	26	83	12
M124RCS-1600	16	32	92	16
M124RCS-1800	18	32	92	16
M124RCS-2000	20	38	104	20
M124RCS-2200	22	38	104	20
M124RCS-2400	24	45	121	25
M124RCS-2500	25	45	121	25
M124RCS-2600	26	45	121	25
M124RCS-2800	28	45	121	25
M124RCS-3000	30	45	121	25
M124RCS-3200	32	53	133	32
M124RCS-4000	40	63	155	40

HSS-Co ENDMILL

M104FL-(4 Flute Flat LONG Length) (DIN-844L)



Code	Cutter dia-k10	Cutter length	OAL	Shank dia-h6
M104FL-0600	6	24	68	6
M104FL-0700	7	30	80	10
M104FL-0800	8	38	88	10
M104FL-0900	9	38	88	10
M104FL-1000	10	45	95	10
M104FL-1200	12	53	110	12
M104FL-1400	14	53	110	12
M104FL-1600	16	63	123	16
M104FL-1800	18	63	123	16
M104FL-2000	20	75	141	20
M104FL-2200	22	75	141	20
M104FL-2500	25	90	166	25
M104FL-2800	28	90	166	25
M104FL-3200	32	106	186	32

HSS-Co ROUGHING ENDMILL

M124RCL-(4 Flute Flat LONG Length Rough) (DIN 844L)



Code	Cutter dia-k12	Cutter length	OAL	Shank dia-h6
M124RCL-0600	6	24	68	6
M124RCL-0700	7	30	80	10
M124RCL-0800	8	38	88	10
M124RCL-0900	9	38	88	10
M124RCL-1000	10	45	95	10
M124RCL-1200	12	53	110	12
M124RCL-1400	14	53	110	12
M124RCL-1600	16	63	123	16
M124RCL-1800	18	63	123	16
M124RCL-2000	20	75	141	20
M124RCL-2200	22	75	141	20
M124RCL-2500	25	90	166	25
M124RCL-2800	28	90	166	25
M124RCL-3200	32	106	186	32

HSS-E PARALLEL SHANK DRILL

Jobber Series (DIN-338)



Code	Dia MM	Dia Inch	Flute Length	OAL	Shank Dia
M231-0100	1.00		12.0	38.0	1.00
M231-0110	1.10		14.0	38.0	1.10
M231-0119	(1.19)	3/64	16.0	38.0	1.19
M231-0120	1.20		16.0	38.0	1.20
M231-0130	1.30		16.0	38.0	1.30
M231-0140	1.40		18.0	40.0	1.40
M231-0150	1.50		18.0	40.0	1.50
M231-0159	(1.59)	1/16	20.0	43.0	1.59
M231-0160	1.60		20.0	43.0	1.60
M231-0170	1.70		20.0	43.0	1.70
M231-0180	1.80		22.0	46.0	1.80
M231-0190	1.90		22.0	46.0	1.90
M231-0198	(1.98)	5/64	24.0	49.0	1.98
M231-0200	2.00		24.0	49.0	2.00
M231-0210	2.10		24.0	49.0	2.10
M231-0220	2.20		27.0	53.0	2.20
M231-0230	2.30		27.0	53.0	2.30
M231-0238	(2.38)	3/32	30.0	57.0	2.38
M231-0250	2.50		30.0	57.0	2.50
M231-0260	2.60		30.0	57.0	2.60
M231-0270	2.70		33.0	61.0	2.70
M231-0278	(2.78)	7/64	33.0	61.0	2.78
M231-0280	2.80		33.0	61.0	2.80
M231-0290	2.90		33.0	61.0	2.90
M231-0300	3.00		33.0	61.0	3.00
M231-0310	3.10		36.0	65.0	3.10
M231-0317	(3.17)	1/8	36.0	65.0	3.17
M231-0320	3.20		36.0	65.0	3.20
M231-0330	3.30		36.0	65.0	3.30
M231-0340	3.40		39.0	70.0	3.40
M231-0350	3.50		39.0	70.0	3.50
M231-0357	(3.57)	9/64	39.0	70.0	3.57
M231-0360	3.60		39.0	70.0	3.60
M231-0370	3.70		39.0	70.0	3.70
M231-0380	3.80		43.0	75.0	3.80
M231-0390	3.90		43.0	75.0	3.90
M231-0397	(3.97)	5/32	43.0	75.0	3.97
M231-0400	4.00		43.0	75.0	4.00
M231-0410	4.10		43.0	75.0	4.10
M231-0420	4.20		43.0	75.0	4.20
M231-0430	4.30		47.0	80.0	4.30
M231-0437	(4.37)	11/64	47.0	80.0	4.37
M231-0440	4.40		47.0	80.0	4.40
M231-0450	4.50		47.0	80.0	4.50
M231-0460	4.60		47.0	80.0	4.60
M231-0470	4.70		47.0	80.0	4.70
M231-0476	(4.76)	3/16	52.0	86.0	4.76
M231-0480	4.80		52.0	86.0	4.80
M231-0490	4.90		52.0	86.0	4.90
M231-0500	5.00		52.0	86.0	5.00
M231-0510	5.10		52.0	86.0	5.10
M231-0516	(5.16)	13/64	52.0	86.0	5.16
M231-0520	5.20		52.0	86.0	5.20
M231-0530	5.30		52.0	86.0	5.30
M231-0540	5.40		57.0	93.0	5.40
M231-0550	5.50		57.0	93.0	5.50
M231-0556	(5.56)	7/32	57.0	93.0	5.56
M231-0560	5.60		57.0	93.0	5.60
M231-0570	5.70		57.0	93.0	5.70
M231-0580	5.80		57.0	93.0	5.80
M231-0590	5.90		57.0	93.0	5.90
M231-0595	(5.95)	15/64	57.0	93.0	5.95

Code	Dia MM	Dia Inch	Flute Length	OAL	Shank Dia
M231-0600	6.00		57.0	93.0	6.00
M231-0610	6.10		63.0	101.0	6.10
M231-0620	6.20		63.0	101.0	6.20
M231-0630	6.30		63.0	101.0	6.30
M231-0635	(6.35)	1/4	63.0	101.0	6.35
M231-0640	6.40		63.0	101.0	6.40
M231-0650	6.50		63.0	101.0	6.50
M231-0660	6.60		63.0	101.0	6.60
M231-0670	6.70		63.0	101.0	6.70
M231-0675	(6.75)	17/64	69.0	109.0	6.75
M231-0680	6.80		69.0	109.0	6.80
M231-0690	6.90		69.0	109.0	6.90
M231-0700	7.00		69.0	109.0	7.00
M231-0710	7.10		69.0	109.0	7.10
M231-0714	(7.14)	9/32	69.0	109.0	7.14
M231-0720	7.20		69.0	109.0	7.20
M231-0730	7.30		69.0	109.0	7.30
M231-0740	7.40		69.0	109.0	7.40
M231-0750	7.50		69.0	109.0	7.50
M231-0754	(7.54)	19/64	75.0	117.0	7.54
M231-0760	7.60		75.0	117.0	7.60
M231-0770	7.70		75.0	117.0	7.70
M231-0780	7.80		75.0	117.0	7.80
M231-0790	7.90		75.0	117.0	7.90
M231-0794	(7.94)	5/16	75.0	117.0	7.94
M231-0800	8.00		75.0	117.0	8.00
M231-0810	8.10		75.0	117.0	8.10
M231-0820	8.20		75.0	117.0	8.20
M231-0830	8.30		75.0	117.0	8.30
M231-0833	(8.33)	21/64	75.0	117.0	8.33
M231-0840	8.40		75.0	117.0	8.40
M231-0850	8.50		75.0	117.0	8.50
M231-0860	8.60		81.0	125.0	8.60
M231-0870	8.70		81.0	125.0	8.70
M231-0873	(8.73)	11/32	81.0	125.0	8.73
M231-0880	8.80		81.0	125.0	8.80
M231-0890	8.90		81.0	125.0	8.90
M231-0900	9.00		81.0	125.0	9.00
M231-0910	9.10		81.0	125.0	9.10
M231-0913	(9.13)	23/64	81.0	125.0	9.13
M231-0920	9.20		81.0	125.0	9.20
M231-0930	9.30		81.0	125.0	9.30
M231-0940	9.40		81.0	125.0	9.40
M231-0950	9.50		81.0	125.0	9.50
M231-0952	(9.52)	3/8	87.0	133.0	9.52
M231-0960	9.60		87.0	133.0	9.60
M231-0970	9.70		87.0	133.0	9.70
M231-0980	9.80		87.0	133.0	9.80
M231-0990	9.90		87.0	133.0	9.90
M231-0992	(9.92)	25/64	87.0	133.0	9.92
M231-1000	10.00		87.0	133.0	10.00
M231-1020	10.20		87.0	133.0	10.20
M231-1032	(10.32)	13/32	87.0	133.0	10.32
M231-1050	10.50		87.0	133.0	10.50
M231-1072	(10.72)	27/64	94.0	142.0	10.72
M231-1100	11.00		94.0	142.0	11.00
M231-1111	(11.11)	7/16	94.0	142.0	11.11
M231-1150	11.50		94.0	142.0	11.50
M231-1191	(11.91)	15/32	101.0	151.0	11.91
M231-1200	12.00		101.0	151.0	12.00
M231-1250	12.50		101.0	151.0	12.50
M231-1270	(12.70)	1/2	101.0	151.0	12.70
M231-1300	13.00		101.0	151.0	13.00

HSS Co8 END MILL - CUTTING PARAMETERS

Material	Carbon Steels		Carbon Steels		Carbon Steels		Carbon Steels		Aluminium	
	~500N/m		~ HRC 20 500~800N/m		HRC20~ HRC30 800~1000N/m		HRC30~HRC40 1000~1300N/m			
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	1800	180	1600	145	1200	90	800	60	5600	470
10	1100	200	900	160	800	120	450	65	3100	600
12	900	220	800	180	630	120	400	75	2500	570
16	700	220	560	160	450	105	280	65	2000	530
19	630	200	500	160	400	105	250	65	1800	530
20	500	200	450	160	350	105	220	65	1400	450
24	500	200	450	160	350	105	220	65	1400	450
25	450	180	400	145	310	90	180	50	1200	420
38	310	120	250	90	200	60	120	35	900	330
42	280	120	220	90	150	60	110	35	800	300
50	280	120	190	90	110	45	80	25	630	300

HSS Co8 ROUGHING END MILL - CUTTING PARAMETERS

Material	Carbon Steels Alloy Steels Tool Steels		Carbon Steels Alloy Steels Tool Steels		Carbon Steels Alloy Steels Tool Steels		Carbon Steels Alloy Steels Tool Steels		Aluminium Aluminium Alloys	
	~500N/m		~ HRC 20 500~800N/m		HRC20~ HRC30 800~1000N/m		HRC30~HRC40 1000~1300N/m			
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6	1800	80	1600	60	1200	55	800	30	4500	195
8	1400	105	1100	75	900	65	560	35	3100	225
10	1100	150	900	120	800	105	450	60	2500	340
12	900	180	800	140	630	105	400	70	2000	390
16	700	180	560	140	450	105	280	70	1600	435
20	630	180	500	140	400	105	250	70	1400	455
22	500	220	450	170	350	135	220	85	1100	455
25	450	220	400	170	310	135	180	85	1000	435
28	400	205	350	160	280	125	160	85	900	490
32	350	205	280	160	220	125	140	85	800	480
36	310	205	250	160	200	125	120	85	700	455
42	280	200	220	150	180	115	110	75	630	435
50	220	200	180	170	160	135	90	75	500	360

* Reduce Feed by 40 % to 50% for Long & Extra Long Cutters

™ RPM - REVOLUTION PER MIN ™ FEED -MM/MIN

HSS-E DRILLS - CUTTING PARAMETERS

Material	Hardness	Strength	Tool Diameter -MM									
			1 to 2.5		3 to 4		5 to 7		8 to 10		11 to 13	
			N	S	N	S	N	S	N	S	N	S
CARBON STEELS		~570 N/mm	3380	0.025	2700	0.05	1700	0.06	1050	0.13	750	0.15
CARBON STEELS	~HRC 23	~830 N/mm	2550	0.025	2000	0.05	1280	0.06	780	0.13	560	0.15
CARBON STEELS	HRC 23~28	830~950 N/mm	1900	0.015	1500	0.03	960	0.04	590	0.08	425	0.08
ALLOY STEELS	HRC 23~34	830 ~1110 N/mm	2380	0.020	1880	0.05	1190	0.06	730	0.13	520	0.18
ALLOY STEELS	HRC 34~38	1110 ~ 1260 N/mm	1400	0.015	1100	0.02	700	0.03	430	0.04	310	0.05
STAINLESS STEELS	HRC 23	830 N/mm	2550	0.025	2000	0.05	1280	0.06	780	0.13	560	0.15
TITANIUM ALLOYS		410 N/mm	1400	0.020	1100	0.03	700	0.04	430	0.08	430	0.08
TOOL STEELS		270 N/mm	3180	0.042	2500	0.05	1590	0.06	970	0.13	700	0.18
CAST IRON	HRC 21	800 N/mm	2250	0.025	2000	0.05	1280	0.06	780	0.13	560	0.15
ALUMINIUM ALLOYS			6400	0.038	5000	0.06	3200	0.08	2000	0.18	1400	0.20

™ N = R.P.M ™ S= Feed per Revolution(mm/rev)

Dealer :

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