



DATA FLUTE™

New HiTe_x/HiTe_x-C Series

Designed to Optimize Performance
in High Temp Alloys and
Other Hard to Machine Materials



HiTex Multi-Flute Finisher



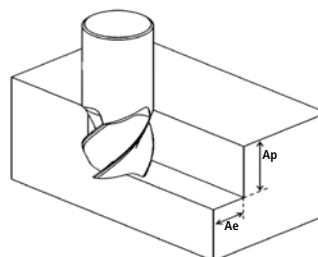
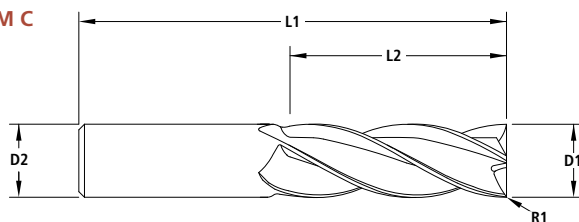
- Variably Indexed
- Number of Flutes Varies by Diameter
- High Temp Alloy Specific Geometry
- High Temp Alloy Specific Coatings

Part Number	Diameter D1	Shank D2	LOC L2	OAL L1	Form	Coating	No. of Flutes	SQ	Radius Offering			
									0.020	0.030	0.060	0.120
HiTex60250-	1/4	1/4	3/4	2-1/2	C	C11	6	44945-85-D	44834-85-D			
HiTexM60250-	1/4	1/4	1-1/4	3	C	C11	6	44946-85-D	44835-85-D			
HiTex60312-	5/16	5/16	13/16	2-1/2	C	C11	6	44947-85-D	44836-85-D			
HiTexM60312-	5/16	5/16	1-1/4	3	C	C11	6	44948-85-D	44837-85-D			
HiTex60375-	3/8	3/8	1	2-1/2	C	C11	6	44949-85-D	44838-85-D			
HiTexM60375-	3/8	3/8	1-1/4	3	C	C11	6	44950-85-D	44839-85-D			
HiTex60437-	7/16	7/16	1	3	C	C11	6	44951-85-D	44851-85-D			
HiTexM60437-	7/16	7/16	1-1/4	3-1/2	C	C11	6	44952-85-D	44853-85-D			
HiTex70500-	1/2	1/2	1-1/4	3	C	C11	7	44953-85-D		44861-85-D	44873-85-D	44881-85-D
HiTexM70500-	1/2	1/2	1-3/4	4	C	C11	7	44954-85-D		44862-85-D	44874-85-D	44882-85-D
HiTex70625-	5/8	5/8	1-5/8	3-1/2	C	C11	7	44955-85-D		44863-85-D	44875-85-D	44883-85-D
HiTexM70625-	5/8	5/8	2	4	C	C11	7	44956-85-D		44864-85-D	44876-85-D	44884-85-D
HiTex70750-	3/4	3/4	1-5/8	4	C	C11	7	44957-85-D		44865-85-D	44877-85-D	44885-85-D
HiTexM70750-	3/4	3/4	2-1/4	5	C	C11	7	44958-85-D		44866-85-D	44878-85-D	44886-85-D
HiTex71000-	1	1	2	5	C	C11	7	44959-85-D		44867-85-D	44879-85-D	44887-85-D
HiTexM71000-	1	1	2-5/8	6	C	C11	7	44960-85-D		44868-85-D	44880-85-D	44888-85-D

Feeds and Speeds Chart for HiTex Finisher

Material	Iron Based				Iron-Nickel Based				Nickel-Iron Based				Cobalt Based							
	Description				A286, Dicalloy, Incoloy 801, ASTM A297				Hastelloy X, N-155, Inconel 718				Inconel 600/625, Rene Alloys, Waspaloy, Monel, Invar				Stellite, Haynes 188, Haynes 230, AiResist 13			
Diameter	SFM Rc < 32		SFM Rc > 32		70-120		40-90		70-120		40-90		60-110		40-90		60-110		40-90	
	1/4"	P			0.0009			0.0009					0.0007				0.0007			
LP				0.0011			0.0011					0.0009				0.0009				
F				0.0019			0.0019					0.0015				0.0015				
5/16"	P			0.0012			0.0012					0.0010				0.0010				
	LP			0.0016			0.0016					0.0012				0.0012				
	F			0.0025			0.0025					0.0020				0.0020				
3/8"	P			0.0016			0.0016					0.0013				0.0013				
	LP			0.0020			0.0020					0.0017				0.0017				
	F			0.0033			0.0033					0.0027				0.0027				
7/16"	P			0.0017			0.0017					0.0014				0.0014				
	LP			0.0022			0.0022					0.0018				0.0018				
	F			0.0036			0.0036					0.0029				0.0029				
1/2"	P			0.0018			0.0018					0.0014				0.0014				
	LP			0.0024			0.0024					0.0019				0.0019				
	F			0.0039			0.0039					0.0030				0.0030				
5/8"	P			0.0021			0.0021					0.0016				0.0016				
	LP			0.0026			0.0026					0.0020				0.0020				
	F			0.0043			0.0043					0.0033				0.0033				
3/4"	P			0.0028			0.0028					0.0023				0.0023				
	LP			0.0037			0.0037					0.0029				0.0029				
	F			0.0060			0.0060					0.0048				0.0048				
1"	P			0.0034			0.0034					0.0026				0.0026				
	LP			0.0044			0.0044					0.0034				0.0034				
	F			0.0071			0.0071					0.0055				0.0055				

FORM C



LP = LIGHT PERIPHERAL

Ae 5% to 25% x D
Ap 2 x D

F = FINISHING

Ae < 5% x D
Ap > 2 x D

HiTex-C 6 Flute Rougher

High Performance Carbide



- Increased Core for Strength and Stability in Cut
- Fine Pitch Serrations for Chip and Form Control

- High Temp Alloy Specific Geometry
- High Temp Alloy Specific Coatings

Part Number	Diameter D1	Shank D2	LOC L2	OAL L1	Form	Coating	No. of Flutes	Radius Offering	
								0.020	0.030
HiTexSTC60250-020C11	1/4	1/4	3/8	2	C	C11	6	44889-85-D	
HiTexC60250-020C11	1/4	1/4	3/4	2-1/2	C	C11	6	44890-85-D	
HiTexMC60250-020C11	1/4	1/4	1-1/4	3	C	C11	6	44891-85-D	
HiTexSTC60312-020C11	5/16	5/16	7/16	2-1/2	C	C11	6	44892-85-D	
HiTexC60312-020C11	5/16	5/16	13/16	2-1/2	C	C11	6	44893-85-D	
HiTexMC60312-020C11	5/16	5/16	1-1/4	3	C	C11	6	44894-85-D	
HiTexSTC60375-020C11	3/8	3/8	1/2	2-1/2	C	C11	6	44895-85-D	
HiTexC60375-020C11	3/8	3/8	1	2-1/2	C	C11	6	44896-85-D	
HiTexMC60375-020C11	3/8	3/8	1-1/4	3	C	C11	6	44897-85-D	
HiTexSTC60437-020C11	7/16	7/16	9/16	2-1/2	C	C11	6	44898-85-D	
HiTexC60437-020C11	7/16	7/16	1	3	C	C11	6	44899-85-D	
HiTexMC60437-020C11	7/16	7/16	1-1/4	3-1/2	C	C11	6	44900-85-D	
HiTexSTC60500-030C11	1/2	1/2	5/8	3	C	C11	6		44901-85-D
HiTexC60500-030C11	1/2	1/2	1-1/4	3	C	C11	6		44902-85-D
HiTexMC60500-030C11	1/2	1/2	1-3/4	4	C	C11	6		44903-85-D
HiTexSTC60625-030C11	5/8	5/8	3/4	3	C	C11	6		44904-85-D
HiTexC60625-030C11	5/8	5/8	1-5/8	3-1/2	C	C11	6		44905-85-D
HiTexMC60625-030C11	5/8	5/8	2	4	C	C11	6		44906-85-D
HiTexSTC60750-030C11	3/4	3/4	1	3	C	C11	6		44907-85-D
HiTexC60750-030C11	3/4	3/4	1-5/8	4	C	C11	6		44908-85-D
HiTexMC60750-030C11	3/4	3/4	2-1/4	5	C	C11	6		44909-85-D
HiTexSTC61000-030C11	1	1	1-1/4	4	C	C11	6		44919-85-D
HiTexC61000-030C11	1	1	2	5	C	C11	6		44921-85-D
HiTexMC61000-030C11	1	1	2-5/8	6	C	C11	6		44923-85-D

Feeds and Speeds Chart for HiTex-C Rougher

Material	Iron Based		Iron-Nickel Based		Nickel-Iron Based		Cobalt Based	
	Description	A286, Discaloy, Incoloy 801, ASTM A297	Hastelloy X, N-155, Inconel 718	Inconel 600/625, Rene Alloys, Waspaloy, Monel, Invar	Stellite, Haynes 188, Haynes 230, AiResist 13			
Diameter	SFM Rc < 32	70-120	70-120	60-110	60-110			
	SFM Rc > 32	40-90	40-90	40-90	40-90			
1/4"	HP	0.0009	0.0009	0.0007	0.0007			
	P	0.0010	0.0010	0.0008	0.0008			
	LP	0.0012	0.0012	0.0010	0.0010			
5/16"	HP	0.0012	0.0012	0.0009	0.0009			
	P	0.0013	0.0013	0.0010	0.0010			
	LP	0.0016	0.0016	0.0013	0.0013			
3/8"	HP	0.0015	0.0015	0.0012	0.0012			
	P	0.0016	0.0016	0.0013	0.0013			
	LP	0.0021	0.0021	0.0017	0.0017			
7/16"	HP	0.0018	0.0018	0.0015	0.0015			
	P	0.0020	0.0020	0.0016	0.0016			
	LP	0.0025	0.0025	0.0021	0.0021			
1/2"	HP	0.0021	0.0021	0.0017	0.0017			
	P	0.0023	0.0023	0.0019	0.0019			
	LP	0.0029	0.0029	0.0024	0.0024			
5/8"	HP	0.0024	0.0024	0.0020	0.0020			
	P	0.0026	0.0026	0.0022	0.0022			
	LP	0.0034	0.0034	0.0028	0.0028			
3/4"	HP	0.0027	0.0027	0.0022	0.0022			
	P	0.0029	0.0029	0.0024	0.0024			
	LP	0.0038	0.0038	0.0030	0.0030			
1"	HP	0.0040	0.0040	0.0033	0.0033			
	P	0.0044	0.0044	0.0036	0.0036			
	LP	0.0056	0.0056	0.0046	0.0046			

P = PERIPHERAL
 Ae 25% to 40% x D
 Ap 1.0 to 1.5 x D
LP = LIGHT PERIPHERAL
 Ae 5% to 25% x D
 Ap 2 x D

The HiTex, HiTex-C series is designed for outstanding performance in nickel and cobalt based high temperature alloys, as well as other difficult to machine materials. The corrosion and heat resistance of the nickel and cobalt based metals give rise to corresponding machining challenges. Examples of frequently encountered nickel based alloys include Waspalloy, Hastelloy, Inconel 718, and Inconel 625. Cobalt based alloys include, but are not limited to, Stellite, Haynes 188 and Haynes 230.



Data Flute • 9 Betnr Industrial Drive • Pittsfield, MA 01201 • Phone: 800-447-1476
www.dataflute.com



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