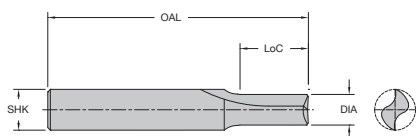


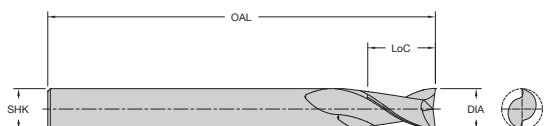
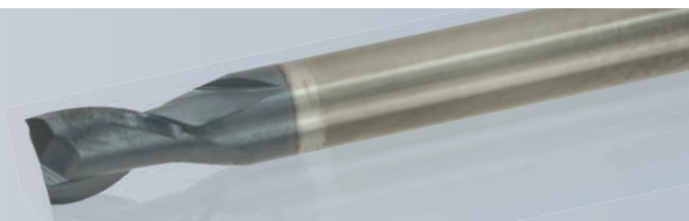
# 81-100 Series Spiral Extrusion Cutters



Designed for reduced vibration producing smoother finish cuts. Extended reach during side thinning and gage reduction. Longer tool life to reduce tool changes.

81-100 Series Two Flute - Solid Carbide Spiral Extrusion Cutters Product Offering										
Part Number	Cutting DIA (in)	LoC (in)	ERL	SHK DIA (in)	OAL (in)	Helix & DIR	CNR RAD Chamfer	Aluminum Condition	Machining Environment	Flutes
Tolerance	+ .002	±.03	-	+ .0000 - .0005	±.03	-	-	-	-	-
81-103	5/16	13/16	-	1/2	3	10°RH	.02 x 45°	C	Wet	2
81-104	3/8	13/16	-	1/2	3	10°RH	.02 x 45°	O	Wet	2

# 83-300 Series Stainless Steel



Special cutting geometry is required to cut stainless steel and achieve decent tool life. LMT Onsrud has developed a line of cutters which are capable of cutting stainless steel.

83-300 Series Two Flute - Solid Carbide Coated <b>Upcut</b> Spiral for Stainless Steel Product Offering					
Part Number	Cutting DIA (in)	LoC (in)	SHK DIA (in)	OAL (in)	Flutes
83-305AITiN	1/8	1/4	1/8	2	2
83-310AITiN	3/16	3/8	3/16	2-1/2	2
83-315AITiN	1/4	3/8	1/4	2-1/2	2
83-320AITiN	3/8	1/2	3/8	3	2

Cutting Parameters			
Part Number	RPM	Feedrate	Depth of Cut
83-305AITiN	18,000	18 IPM	.012
83-310AITiN	12,000	20 IPM	.020
83-315AITiN	9,000	25 IPM	.030
83-320AITiN	6,010	27 IPM	.045