

RobbJack's got the Solution

for Your Next Machining Project

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Speed & Feeds/Formulas

Material	SFM <i>Surface Feet/Minute</i>	SMM <i>Surface Meters/Minute</i>	CLPT Factor
Aluminum / Non-Ferrous			
Ferrous			
2024	Max RPM	Max RPM	.0256
6061 (T1-T3)	Max RPM	Max RPM	.0128
6061 (T4-T6)	Max RPM	Max RPM	.0256
7075	Max RPM	Max RPM	.0256
Non-Ferrous			
Brass	750	230	.0128
Copper	600	190	.0128
Magnesium	Max RPM	Max RPM	.0256
Titanium, Steel and High-Temp Alloys			
Titanium			
Commercially Pure	350	100	.0048
6AL-4V	230	55	.0048
6AL-6V	180	35	.004
Steel			
1018-1020	350	110	.0064
4130	260	80	.0032
4140	220	70	.0032
4340	280	90	.0032
Tool Steel Annealed			
A2	350	110	.0032
D2	260	80	.0032
H13	230	70	.0032
P20	350	110	.00496
Stainless Steel			
303	500	150	.0048
304	225	70	.0032
316	240	75	.0032
15-5/17-4 PH	200	60	.0032
440C	200	60	.0032
Inconel			
625 / 718	100	30	.0036
Composites & Plastics			
G10 Fiberglass/Polyester	1000	300	.0136
Graphite	1000	300	.0256
Graphite Fiber/Epoxy	800	250	.008
Plastics	1300	400	.0256
Die/Mold			
<i>See Die/Mold section</i>			
Other Material Applications			
Cast Iron			
Ductile Iron	350	110	.0096
Gray Cast Iron	500	150	.0128

CLPT Factor

(Chip Load per Tooth = Tool Diameter × CLPT Factor)

STANDARD SIZES

$$\text{Surface Feet per Minute} = \text{RPM} \times .262 \times \text{Tool Diameter}$$

$$\text{RPM} = \frac{\text{Surface Feet per Minute} \times 3.82}{\text{Tool Diameter}}$$

$$\text{Feedrate (in./min.)} = \text{RPM} \times \text{CLPT Factor} \times \text{Tool Diameter} \times \text{Number of Flutes}$$

$$\text{Chip Load per Tooth (CLPT)} = \text{CLPT Factor} \times \text{Tool Diameter}$$

$$\text{in}^3/\text{min} = \text{Width} \times \text{Depth} \times \text{Inches per Minute}$$

$$\text{Horsepower} = 1.341 \times \text{kW}$$

$$\text{kW} = .7457 \times \text{Horsepower}$$

METRIC SIZES

$$\text{Surface Meters per Minute} = \text{RPM} \times .00314 \times \text{Tool Diameter}$$

$$\text{RPM} = \frac{\text{Surface Meters per Minute} \times 318.057}{\text{Tool Diameter}}$$

$$\text{Feedrate (mm/min.)} = \text{RPM} \times \text{CLPT Factor} \times \text{Tool Diameter} \times \text{Number of Flutes}$$

$$\text{Chip Load per Tooth (CLPT)} = \text{CLPT Factor} \times \text{Tool Diameter}$$

$$\text{cm}^3/\text{min} = \frac{\text{Width (mm)} \times \text{Depth (mm)} \times \text{Feedrate (mm/min)}}{1000}$$

$$\text{Horsepower} = 1.341 \times \text{kW}$$

$$\text{kW} = .7457 \times \text{Horsepower}$$

Examples on how to calculate the Chip Load per Tool (CLPT) from the CLPT Factor

STANDARD TOOLS

Multiply Tool Diameter by CLPT Factor – Use a Minimum Chip Load per Tooth of .0001"

Example 1:

5/8" diameter tool cutting 6061 T6 Aluminum:
 $.625 \times .0256 = .016"$ CLPT

Example 2:

3/16" Diameter tool cutting 304 stainless:
 $.1875" \times .0032 = .0006"$ CLPT

METRIC TOOLS

Multiply Tool Diameter by CLPT Factor – Use a Minimum Chip Load per Tooth of .0025 mm

Example 1:

3 mm diameter tool cutting 6061 T6 Aluminum: $.3 \text{ mm} \times .0256 = .0768 \text{ mm}$ CLPT

Example 2:

12 mm Diameter tool cutting 304 stainless: $12 \text{ mm} \times .0032 = .0384 \text{ mm}$ CLPT

RobbJack's iPhone Speed & Feed Application



Coming Soon!

RobbJack iPhone App

Calculates speeds, feeds, depth, and width of cut. It also calculates the amount of horsepower required to make your cut. All in an easy to use application.

- ▶ **Recommends what tools to use.**
- ▶ **Stores your data for future reference.**
- ▶ **Email your results!**



Now Online!

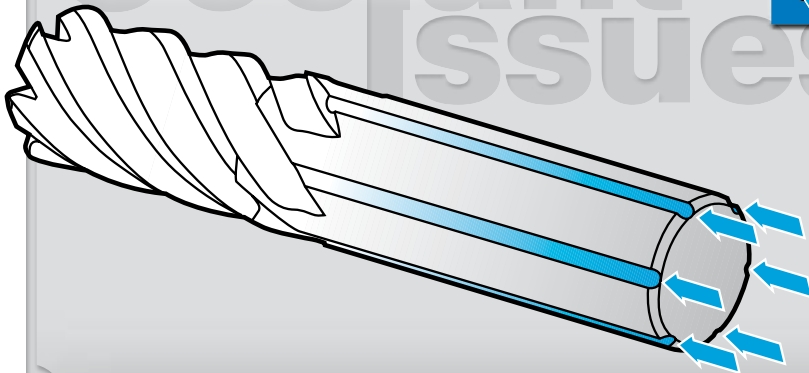
Speed & Feed Calculations now online at www.robjack.com

- ▶ **Quick, easy calculations, both metric and standard**
- ▶ **End mill speeds and feeds**
- ▶ **Slitting saw speeds and feeds**
- ▶ **Troubleshooting**
- ▶ **Printable results**
- ▶ **Simultaneous tool recommendations**



End Mill Modifications

Coolant Grooves



Coolant Grooves allow coolant to flow around the outside of the tool for through-spindle coolant applications. It is a lower-cost option to through-the-tool coolant holes.

To order a RobbJack tool with a **Coolant Grooves**, use the existing *Part Number*, and add **-CG**.

Example:

An A1-201-12 with coolant grooves is Part Number:

▶ **A1-201-12-CG**
See price sheet for pricing

Chatter Problems?

Mirror Edge™

Our edge preparation dampens vibration to help eliminate chatter.



Mirror Edge



Non-Mirror Edge

Applications

- Deep pocket and thin wall aluminum
- Long reaches more than 3:1 length-to-diameter ratio
- Plunging corners in titanium, steels, stainless, aluminum, etc.
- High end valves used with Feather Blend and T-Process

Must Use Coolant



Our patented Mirror Edge geometry helps to eliminate chatter. This geometry can be used in any application where chatter is a problem, usually for thin walls, valves, deep pockets or where the tool sticks out more than 3:1 length to diameter ratio.

To order RobbJack tools with **Mirror Edge**, use the existing *Part Number*, and add **-ME**.

Example:

An A1-201-12 with Mirror Edge is Part Number:

▶ **A1-201-12-ME**
See price sheet for pricing

Chipping?

T-Process



T-Process is a honed edge we put on an end mill to help eliminate chipping.

Pros: T-Process strengthens the edge, helps eliminate chipping and gives a smooth edge.

Cons: T-Process will bring up a burr in certain materials, and it is not for materials that like a sharp edge, such as aluminum and plastics.

To order a RobbJack tool with a **T-Process**, use the existing *Part Number*, and add **-TP**.

Example:

An XG-402-16 with a T-Process is Part Number:

▶ **XG-402-16-TP**
See price sheet for pricing



End Mill Modifications



Feather Blend™

A smooth transition from the cutting diameter to the neck diameter.



Feather Blend



Standard Neck

Applications

- Any necked tool
- Eliminates swirl lines during plunging
- Eliminates stress risers in parts



Reach

Modify any standard tool with a neck to get the job done quickly.

A neck will increase rigidity, reduce tool deflection and last longer than a long length of cut tool. Necking can be added to most standard tools in 1–2 days.

To order a RobbJack tool with a **Reach**, use the existing *Part Number*, and add *-N* and the desired length from the end of the tool.

Example:

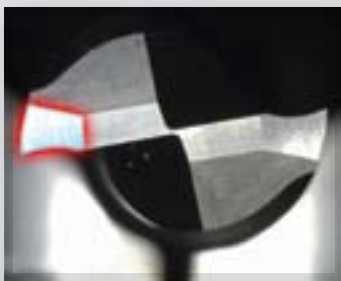
An A1-201-12 necked with 1.0" Reach is Part Number:

▶ **A1-201-12-N 1.0"**

See price sheet for pricing

A tool necked with Feather Blend is a reduction in the tool diameter after the cutting length so the tool can cut deeper than its cutting length. It features a smooth transition from the cutting diameter to the neck diameter. Feather Blend reduces staircase marks and stress risers in parts and helps to maintain the strongest tool possible.

Wiper Flats



A Wiper Flat is a small flat on the end of the tool where there is no concavity. It is used to minimize swirl marks on the floor of parts.



Pros: A Wiper Flat gives better floor finishes.

Cons: Wiper Flats will increase surface contact, not for use on thin floors.

To order a RobbJack tool with a **Wiper Flats**, use the existing *Part Number*, and add *-WF*.

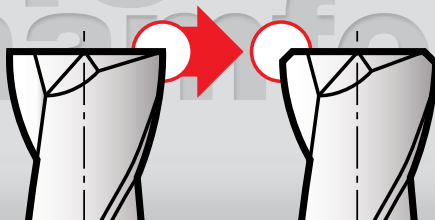
Example:

An A1-201-12 with wiper flats is Part Number:

▶ **A1-201-12-WF**

See price sheet for pricing

45° Chamfer



To order a RobbJack tool with a **45° Chamfer**, use the existing *Part Number*, add *-CH* and amount of *Chamfer*.

Example:

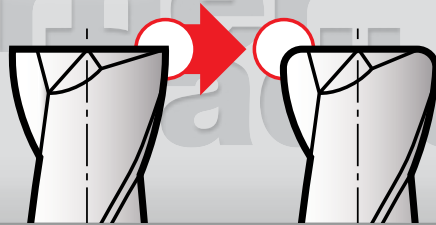
A1-201-12 with a .040" 45° chamfer is Part Number:

▶ **A1-201-12-CH .040"**

See price sheet for pricing

End Mill Modifications

Corner Radius



To order a RobbJack tool with a **Corner Radius**, use the existing *Part Number*, add **-CR** and desired *Radius Size*.

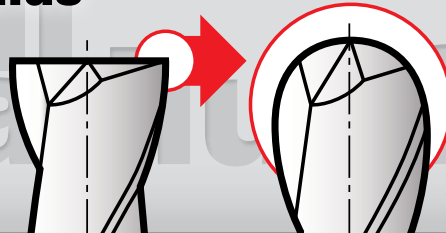
Example:

An A1-201-12 with a .005 corner radius is Part Number:

▶ **A1-201-12-CR .005**

See price sheet for pricing

Full Radius



To order a RobbJack tool with a **Full Radius** (or Ball End), use the existing *Part Number*, and add **-BN**.

Example:

An A1-201-12 with a Full Radius (Ball End) is Part Number:

▶ **A1-201-12-BN**

See price sheet for pricing

Weldon Flats



To order RobbJack tools with **Weldon Flats**, use the existing *Part Number*, and add **-FL**.

Example:

An A1-201-12 with a Weldon Flat is Part Number:

▶ **A1-201-12-FL**

No Charge

Regrinding

Let RobbJack recondition your used cutting tools and get RobbJack quality grinds and specifications on tools with any brand name!

Wouldn't it be nice if resharpened tools performed as well as new? Let us regrind yours the way we do ours and it can happen. We will add our grinds and finishes to any tools, regardless of manufacturer. Our prices are competitive, our delivery is usually the best in the industry, and we do our own, in-house PVD coatings and re-coatings.

GO GREEN

Try RobbJack's in-house carbide recycling program.

Many times the tools we receive for regrinding are too badly damaged to justify reconditioning. For all tools that we determine fall into this category, **we will either:**

▶ *Return the tools to you marked "No Work Done" (NWD)*

OR...

▶ *Put the tools, as scrap, into our recycling program and send you a certificate for a 10% discount on your next regrinding order.*

We will offer you this choice every time we receive tools that we determine are NWD. We recycle scrap tools to carbide re-manufacturers, who crush the tools and use the recycled shards and powder to make shredders or non-critical carbide grades.

YOUR OWN COATING

Get state-of-the art coating technology without delivery hassles.

RobbJack owns and operates their PVD coating facility in Lincoln, CA under the tenets of ISO9000 certification. Our factory-trained technicians take the same special care with your tools as with ours, assuring you of the best PVD coatings available. We do this as part of our process, reducing or eliminating delays in delivery.

Download our **Regrinding Order Form** at www.robbjack.com to get started. **Email or Call us!**

Phone: (916) 645-6045

Toll-Free: (800) 527-8882

Fax: (916) 645-0146

sales@robbjack.com

sherry@robbjack.com

steve@robbjack.com

TOOLS FOR

Aluminum Applications

Custom End Mills

DON'T SEE WHAT YOU NEED?

RobbJack manufactures a wide variety of end mills in addition to those listed in our catalog. We can make tools for your specific needs by modifying standard tools or through custom manufacture. We can work directly from your prints to design and build the exact tool for your requirements. Contact us if you need:

- **Special Cutting and/or Shank Diameters**
- **Special Cutting Length and/or Overall Lengths**
- **Corner Radii, Full Ball or Corner Chamfer Configurations**
- **Chip Breakers or Roughing Cutters**
- **Special Tolerances**
- **Tapered End Mills, Constant Helix or Constant Lead.**
- **Special Coatings Available.**

To get a quote or more information about a custom tool, fax or call us with your specifications and any other pertinent information (photocopy the form below). If you are not sure of the best configuration for your application, we will be glad to help you.

Remember, to obtain the best performance in all end mill applications:

- Use the largest diameter possible.
- Use the shortest flute length possible.
- Use the correct number of flutes for your application.
- Use recommended speed and feed rates.

Copy this form and fax it to us at (916) 645-0146 or (916) 645-1668

RobbJack Custom End Mill Request for Quote/Information

Description of Application:

Order Quantity:

Cutting Diameter:

Tolerance:

Cutting Length:

Shank Diameter:

Overall Length:

Number of Flutes:

Special Configurations (Radii, Chamfers, Set Screw Flats, Chip Breakers, Coatings, etc.):

For Tapered Tools:

Major Diameter:

Tip Diameter:

Per Side/Included Angle:

Tolerance:

End Configuration (Full Ball, Corner Radii, Square End):

(Note: RobbJack recommends 3 flutes for all tapered applications)



Questions?

Call us:

at (916) 645-6045
or (800) 527-8883

Fax us:

at (916) 645-0146
or (916) 645-1668

Visit us:

at www.robjack.com



Custom Carbide Saws

SPECIAL SAWS TO MEET YOUR SPECIFIC NEEDS

In addition to the broad line of standard saws listed in this catalog, RobbJack is capable of manufacturing a wide variety of special saws. If our standard offerings do not meet your needs, call or fax your specifications to us for quotation. Contact us if you need:



- **Special Cutting Diameters**
- **Special Thicknesses**
- **Special Arbor Hole Sizes and Keyways**
- **Special Chamfers, Angles or Radii**
- **Special Tooth Configurations and Pitches**
- **Special Coatings Available.**
- **Gang Saws** – If your requirements call for the use of more than one saw at a time, contact us for a complete, ready-to-use package, including saws, arbors and spacers. We are experts in ganging saws, which generally requires flat and parallel hubs, made to our exacting specifications.

**Copy this form and fax it to us at
(916) 645-0146 or (916) 645-1668**

We are frequently able to combine saws and spacers into an integral saw with offset hub, which reduces tolerances buildup by one-half.

Many of these features can be achieved by modifying standard saws. Others require that we start from scratch. We will work directly from your prints or help you design

the saws you need from the following information. Simply photocopy the bottom of this page, fill it out and fax it to us along with any other pertinent data. And remember, to obtain the best performance in all saw applications:

- Use the smallest diameter and the greatest thickness possible.
- Choose the number of teeth (tooth count) to meet your specific application (if you are not sure of the best configuration for your application, call us and we'll advise you).
- Ask for feed and speed recommendations to get started right.

RobbJack Custom Saw Request for Quote/Information

Outside Diameter: _____

Saw Thickness: _____

Inside Diameter: _____

Number of Teeth: _____

Keyway on I.D.: _____

For Gang Use: _____

Special Configurations (such as
Chamfers, Angles, Radii or Forms): _____

Order Quantity: _____



Questions?

Call us:
at (916) 645-6045
or (800) 527-8883

Fax us:
at (916) 645-0146
or (916) 645-1668

Visit us:
at www.robjack.com



Terms & Conditions

Terms

1% Ten Days, Net 30 Days. Minimum Invoice, \$25.00.

Shipping

F.O.B. Lincoln, California. All shipments via **2nd Day Air**, unless otherwise specified.

Claims

Goods are considered sold and our responsibility ceases when delivery is made to the transportation company. In the event of goods being lost in transit, we will make every effort on behalf of customers to have lost goods found or to have the transportation company make proper restitution for loss.

Damage claims must be made against carrier.

Specials

Orders for special tools, non-catalog or modified tools are accepted on a no-cancellation basis and tools are not returnable. A confirming purchase order is required before any work begins on special tools.

A 10% over or under shipment on a special is acceptable based on industry practices unless no overshipment is stated at time of quoting.

Return Policy

No merchandise may be returned without prior authorization from the factory. Credit will not be issued for merchandise returned without a return authorization number.

All merchandise returned for credit will be subject to a 15% restocking charge.

Errors

RobbJack Corporation can not be held responsible for incorrect parts made with our products due to mislabeling or defect. We assume all tools used by our customers are inspected before use and that first part inspections in customer's plant is the rule. We will replace or credit tools in those situations.

Prices

Prices subject to change without notice.



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