



Technical Information

Manchester....H1-H17
OTMH18-H30

MANCHESTER
LOWER COST PER CUT
CUTTING TOOLS

www.manchestertools.com

The technical section of this catalog is intended to provide sufficient basic information to apply indexable cutting tools, specifically OTM products. The majority of requests for technical support that OTM receives are for speeds and feeds. If you need technical help beyond what is contained in this section, contact our technical staff.

APPLICATION CONSIDERATIONS

Feed and Speeds

Proper cutting speeds and feeds are obviously important considerations. OTM has developed some recommended starting points through testing in our shop and in the field.

Rigid Setups

No tool will perform at maximum potential in a poor setup. Workpieces must be held securely, and tool

extension should be held to a minimum. Tombstones must be mounted properly, and workholding must be adequate. Worn jaws can introduce chatter, and possibly mis-locate parts, or even release parts during the cut. The machine itself must be in good condition, and **tool gage lengths should be as short as possible**. Shorter gage lengths result in higher feed capabilities with less deflection and chatter, and longer insert life.

Machine Horsepower vs. Spindle Horsepower

There can be a great difference between the spindle motor rating (machine horsepower) and the horsepower at the tool tip (spindle horsepower). Typically, spindle horsepower is around 75% of rated horsepower.



DRILLING BASICS

Proper drilling involves proper machine setup, coolant delivery, insert selection, and a basic understanding of the drilling process. Indexable drills are not the same as twist drills in application or performance.

BASIC DRILLING

Drilling a hole from solid stock is a tough job for a variety of reasons. Chip and heat evacuation are tough, the actual cutting action is hidden from view, and the surface footage varies from the programmed speed at the outer cutting edge to zero at the center of the tool. A drill doesn't actually cut at the center, it pushes the material out of the way. Cutting forces are high and other factors such as coolant delivery and machine alignment can combine to cause a drill to deflect and cut off-size, or fail catastrophically.

MACHINE SETUP

This is an important consideration when using indexable drills. In drilling, shorter is always better. Use the shortest drill and the shortest adapter possible. This will always improve performance. The machine spindle and bearings should be in good condition, and the fixturing must be adequate and rigid.

In lathes, *alignment is crucial*. The tool must run within 0.003" TIR to the spindle, or insert failure could occur. **If the center insert continually chips, check the alignment.** Chuck jaws should be in good condition as well and provide adequate

clamping pressure. The workpiece should not extend from the chuck excessively either.

COOLANT DELIVERY

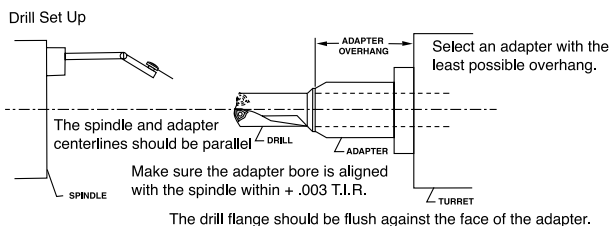
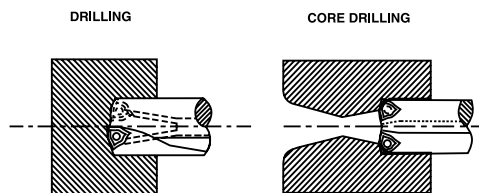
Coolant thru-the-spindle should be used wherever possible. Coolant improves tool life by lubricating the cut and removing heat and chips from the work area. Chip evacuation is very important when drilling.

INDEXABLE VS. TWIST DRILLS

Indexable drills are very different than twist drills. Replaceable inserts eliminate drill regrinding. Because of higher surface footages, indexable drills generally out-feed twist drills.

DRILLS VS. CORE DRILLS

OTM drills are designed to put holes in solid material. OTM core drills are used to open a pre-existing hole. Core drills, because of their design, can attain two times the feed rate of insert drills. As a result, core drills provide an excellent means enlarging an existing hole.



DRILL APPLICATION HOLESHOT® INDEXABLE DRILL

STATIONARY

For stationary (lathe) applications, the drill body should be mounted concentric with the spindle center line within +.003". Longitudinal alignment should be within .005" in six inches. Insert failure can result if alignment is too far above or below the centerline. Flats on the shank should be precisely aligned so that the cutting edges are parallel to the x-axis, which will help chip flow.

A disc is normally produced as the drill breaks through the hole. Although the disc is usually minimal with HOLESHOT®, adequate guarding should be provided for and in place.

HOLESHOT® drills can be slightly offset .004" - .006", on lathe applications, to drill other than nominal sizes from solid. Offset can only be performed for plus sizing in the axis which increases/decreases cutting diameter. Offset in the other axis changes above/below center cutting conditions, resulting in breakage. Select an adapter with the least possible overhang.

ROTATING

Make certain the spindle is rigid with minimal runout. Since both machine and fixture rigidity are key factors, make sure the workpiece is rigidly fixtured and secured. Mount drill for the least possible overhang and make sure the drill flange is flush against the face of the adapter.

Coolant - Chip removal and tool life are enhanced by feeding coolant through the drill. 30 P.S.I. minimum coolant pressure is recommended for horizontal applications. Vertical position requires a higher coolant pressure (40 to 60 P.S.I.) to flush chips properly. HOLESHOT® accepts standard coolant glands.

Through the tool coolant is preferred for HOLESHOT® drilling, but due to the unique flute design, coolant deficiencies can be overcome. Especially in smaller, lower horsepower machine tools, strong flood coolant can be utilized with excellent results. When flooding the cut, direct coolant directly into the drilling area.



FEED / SPEED CALCULATIONS

UNIT CONVERSIONS

Feed and speed calculations use the following abbreviations:

FPT = Feed Per Tooth (Drills have one effective tooth, coredrills have two effective teeth)

FR = Feed Rate

IPM = Inches Per Minute

IPR = Inches Per Revolution

RPM = Revolutions Per Minute

SFM = Surface Feet Per Minute

The formulas are:

$FPT = (IPR \times RPM) / \text{effective teeth}$

$IPM = IPR \times RPM \text{ or } FPT \times \text{effective teeth} \times RPM$

$IPR = FPT \times \text{effective teeth}$

$RPM = 3.82 \times (SFM / \text{drill diameter})$

$SFM = 0.262 \times \text{drill diameter} \times RPM$

Cutting cycle time = length of cut (inches) / IPM

SURFACE SPEED PER MINUTE

$$SFM = .262 \times DIA \times RPM$$

METAL REMOVAL RATE

$$3 \times Dia \times IPR \times SFM \text{ for Drilling}$$

$$12 \times WOC \times IPR \times SFM \text{ for Core Drilling}$$

REVOLUTIONS PER MINUTE

$$RPM = \frac{3.82 \times SFM}{DIA}$$

TIME IN CUT (seconds)

$$T = \frac{15.7 \times DIA \times LOC}{SFM \times IPR}$$

or

$$T = \frac{60 \times LOC}{IPM}$$

FEEDRATE (inches/minute)

$$IPM = IPR \times RPM$$

FEEDRATE (inches/revolution)

$$IPR = \frac{t_{chip}}{\cos \alpha}$$

DEFINITION OF TERMS

DIA = DIAMETER OF THE DRILL (INCHES)

DOC = DEPTH OF CUT (INCHES)

EFF = MACHINE EFFICIENCY

HPM = HORSEPOWER REQUIRED AT MOTOR

HPS = HORSEPOWER REQUIRED AT SPINDLE

IPM = FEEDRATE (INCHES PER MINUTE)

IPR = FEEDRATE (INCHES PER REVOLUTION)

FR = FEEDRATE (SEE IPM AND IPR)

LOC = LENGTH OF CUT (INCHES)

Q = METAL REMOVAL RATE (CU. INCHES PER MINUTE)

RPM = REVOLUTIONS PER MINUTE

SFM = SURFACE FEET PER MINUTE

T = TIME (IN SECONDS)

t_{chip} = CHIP THICKNESS (INCHES)

UHP = UNIT HORSEPOWER FACTOR

α = LEAD ANGLE



DRILLING SPEEDS AND FEEDS

HOLESHOT® DRILLS AND COREMASTER™ COREDRILLS

NOTE: Drills are one-flute effective tools. Coredrills are two flute effective tools. Feedrates should be calculated accordingly.

MACHINING RECOMMENDATIONS

Material	Condition	Insert Grade*	SFM	FPT	Comments
Aluminum	6061	6N	1800-2000	.008-.010	
Cast Iron, Gray	<=150 BHN	10, 90C	400-800	.005-.011	
Cast Iron, Nodular (ductile)	150-250 BHN (<=25 Rc)	10, 66C	300-500	.004-.010	
Cast Iron, Malleable	250-350 BHN (25-38Rc)	10, 66C	350-700	.004-.010	
Inconel	718	66C	150	.0010-.0015	
Stainless Steel	15-5	66C	200-300	.0025	
	17-4	66C	450	.003	
	200-300 Series	66C	250-500	.003-.005	
	304	66C	425-550	.0040-.0055	
	400 Series	66C	350-600	.003-.006	
	410	66C	340-600	.004-.006	
Steel	No/Low Alloy CRS, HRS	66C	800-900	.0015-.0035	"Pleated", or W-shaped chips can be catastrophic here. Reduce feedrate to create smooth chipping.
	Carbon, <=38 RC	66C 90C	400-800	.005-.009	
	Tool, Med Alloy, 12-38 Rc	66C 90C	250-750	.004-.010	
	High-Temp Alloy, 12-38 Rc	66C 90C	100-350	.003-.006	
Stellite L605		66C	150	.0025	
Titanium		66C	100-210	.0025-.0030	

*Unless noted, use the same grade insert in all pockets of the drill.



DRILLING SPEEDS AND FEEDS

STINGER™ SMALL DIAMETER DRILLS

NOTES: 1. Do not overtighten the insert screws in these drills. Over-tightening the screws will break the inserts.
2. Do not drill stacked plates with these drills.

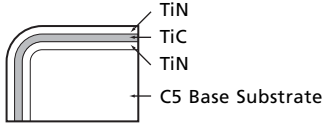
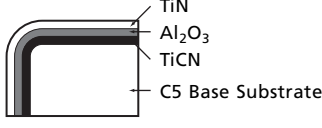
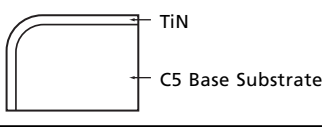
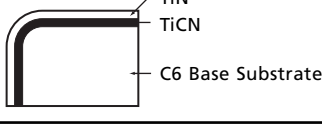
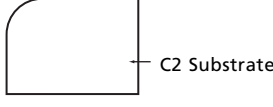
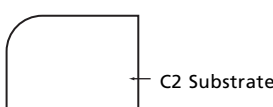
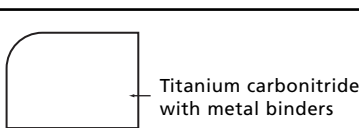
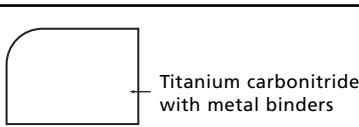
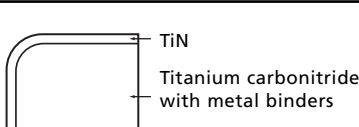
MACHINING RECOMMENDATIONS

Material	Condition	Insert Grade*	SFM	FPT
Copper		5N	900-2000	.001-.003
		13	800-1900	.001-.003
High Temp Alloys		13	100-175	.0005-.0008
Inconel	600	13	250	.0008-.0012
	718	13	150-250	.0015-.0025
	17-4	13	450	.0009-.0012
Stainless Steel	300 Series	23C	300-500	.0012-.0015
		40C	400-600	.0012-.0015
	304	23C	300-600	.0008-.0012
		40C	400-700	.0008-.0012
	400 Series	23C	400-600	.0012-.0015
		40C	500-700	.0012-.0015
Steel, Low Carbon	Annealed	5N	600-900	.0012-.0018
		40C	500-800	.0012-.0018
	Carburized, 35-50 Rc	5N	300-400	.0012-.0018
		40C	250-350	.0012-.0018
Steel, Medium Carbon	17-32 Rc	5N	500-700	.0012-.003
		40C	400-600	.0012-.003
Titanium Alloys		13	150-250	.0008-.0012
Tool Steel	Annealed	5N	350-450	.001-.0015
		5N	150-250	.0007-.0012
4130, 4140, 4150	Annealed	5N	500-700	.0012-.003
	35-50 Rc	40C	400-600	.0012-.003
6150	Annealed	5N	500-600	.0012-.0015
		40C	400-600	.0012-.0015
Aluminum		5N	1000+	.002-.006
		13	900-1800	.002-.006
Brass		5N	900-1500	.001-.003
		13	800-1400	.001-.003
Bronze		5N	500-900	.001-.003
		13	400-600	.001-.003
Cast Iron	Gray	5N	500-900	.001-.003
		13	300-500	.001-.003
		23C	300-500	.001-.003
	Nodular (Ductile)	5N	500-700	.001-.003
		13	300-500	.001-.003
		23C	350-450	.001-.0022
	Malleable	5N	400-800	.001-.003
		13	300-500	.001-.003
		23C	300-500	.001-.003

*Unless noted, use the same grade insert in all pockets of the drill.



INSERT GRADES FOR DRILLING

GRADES	COMPOSITION & COATINGS	APPLICATION RECOMMENDATIONS
COATED CARBIDE GRADES	23C 	Tough CVD coated carbide grade for demanding applications in steel, stainless steel and steel castings. Takes shock and interruptions well.
	40C 	CVD coated. Thick wear resistant coating layers over a cobalt enriched substrate provide high wear resistance with good edge security, drilling in most steels.
	66C 	Very tough PVD coated grade for drilling alloy steel, stainless and tougher materials.
	90C 	CVD coated grade for drilling applications in steel requiring toughness with good wear resistance.
UNCOATED CARBIDE	10 	Uncoated carbide grade for drilling in gray cast iron and non-ferrous materials.
	13 	Micrograin uncoated carbide for drilling heat resistant and titanium alloys.
CERMET GRADES	5N 	Tough cermet with good wear resistance for drilling in most steels. Not for center pocket. (Except for the Stinger Drills)
	6N 	Tough cermet with good wear resistance for drilling in most steels. Not for center pocket.
	9C 	PVD coated cermet for roughing to finishing of steels. Not recommended for center pocket.



CLASSIFICATION CHART FOR DRILLING GRADES

ISO	CLASS	UNCOATED CARBIDE	COATED CARBIDE	CERMET	
P01	C8				WEAR RESISTANCE ↗
P10	C7				WEAR RESISTANCE ↗
P20	C6		40C	5N & 6N	WEAR RESISTANCE ↗
P30			23C 66C 90C	9C	WEAR RESISTANCE ↗
P40	C5				TOUGHNESS ↘
P50					TOUGHNESS ↘
M01	C8				WEAR RESISTANCE ↗
M10	C7				WEAR RESISTANCE ↗
M20	C6		40C	5N & 6N	WEAR RESISTANCE ↗
M30			23C 66C	9C	TOUGHNESS ↘
M40	C5				TOUGHNESS ↘
K01	C4	10		5N & 6N	WEAR RESISTANCE ↗
K10	C3	13	23C		WEAR RESISTANCE ↗
K20	C2				TOUGHNESS ↘
K30					TOUGHNESS ↘
K40					TOUGHNESS ↘

ISO DESIGNATIONS	
P	STEELS, TOOL STEELS
M	STAINLESS STEELS
K	CAST IRON & NON-FERROUS METALS

C CLASSIFICATIONS	
C-1 through C-4	C-5 through C-8
Abrasion resistant grades. Machining cast iron & short chip materials.	Crater resistant grades. Machining steel & continuous chip materials.
C-1 Roughing	C-5 Roughing & General Purpose
C-2 General Purpose	C-6 Semi-Finishing
C-3 Semi-Finishing	C-7 Light Finishing
C-4 Finishing & Precision Boring	C-8 Finishing & Precision Boring



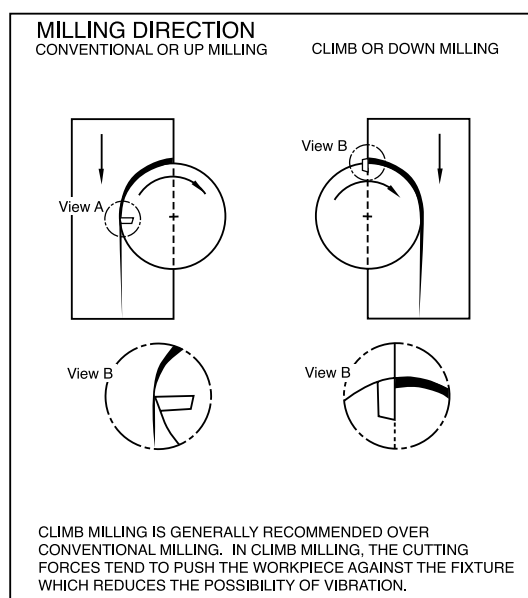
MILLING BASICS

BASIC MILLING

Most machining benefits from rigid set-ups. Milling applications benefit greatly. Short adapters and rigid fixturing will greatly increase tool life and feed capabilities.

CLIMB MILLING VS. CONVENTIONAL MILLING

Climb mill whenever possible. The inserts enter the cut at full feed per tooth, and exit as the chip thins to zero. Less heat is generated and work hardening is minimized. Today's inserts can easily take the forces generated, and free-cutting positive geometries won't shake the machine to pieces. Exceptions to this are manual machines and worn out CNC machines, where conventional milling is necessary because of backlash.



POSITIVE VS. NEGATIVE GEOMETRY

Traditional indexable mills have used negative inserts extensively. Today's mills use positive inserts. Positive inserts have only half, or less, usable edges than negative inserts, but the free cutting action of positives usually outweighs the effects of edges lost. Today's insert compositions and edge geometries make strong, free-cutting edges that hold up in the cut. Feedrates are higher than negative inserts, horsepower requirements are lower, and tool life is greater. In the end, the cost per part produced is generally lower using positive inserts cutting most materials.

FACE MILLING

Whenever possible, face with a 30-degree lead mill. This will cut more freely, lowering horsepower requirements, and increasing tool life. The only time face milling with a 90-degree lead mill is appropriate is when a square corner is required along a cut.

PROFILE MILLING

Profile milling is a common milling application. The speeds below apply to profile milling. The feedrates can be increased, in some cases dramatically. The reason is that when the width of cut is less than half the cutter diameter, chip thinning occurs. Higher feed rates are actually required to create the necessary feed per tooth.

SLOTTING

Slotting is the most difficult milling application. The cutter begins cutting a thin chip, continues into a thick chip, then exits the cut through a thin chip again. The chip has one-half revolution to get free of the flute. Chip evacuation is critical, and chips can pile up behind the cut until they fall back into the mill and get re-cut. Re-cut chips will destroy insert edges quickly, leading to possible catastrophic tool failure. Deeper slots are even more difficult. Compressed air should be used to move all chips out of the work area, and feedrates must be appropriate for the material but not excessive.

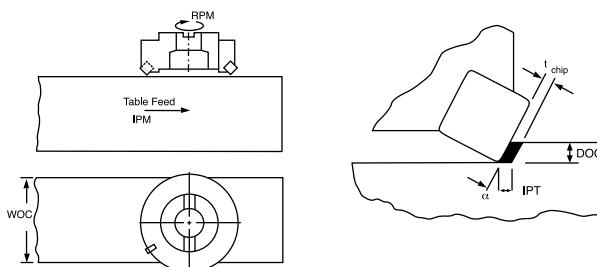
LEFT-HAND MILLS

OTM has a large selection of standard left-hand mills designed specifically to utilize the unused portions of the inserts from right-hand mills. Economy is the driving force of this design.

TIPS AND TRICKS

When milling around sharp corners, whenever possible interpolate the corner, using the corner as the center of the arc and the cutter radius as the arc radius. This will keep the cutter loaded through the corner, eliminate the exit and entrance cuts, and not leave a burr on the corner. Insert life will improve, and it's also a shorter distance to travel.

When making multiple passes to get to depth, don't divide the depth into equal increments. Instead, vary the DOC with each pass. This will increase insert life by reducing notch wear of the insert. (Notch wear occurs at the point the insert intersects the top edge of the cut.)



MILLING CHECKLIST

1. Properly identify the milling task process by reviewing part print parameters by dimension and material to be machined.
2. Identify the best machine tool and process for optimum performance.
3. Review the machine capabilities by:
 - a. Rigidity of set-up
 - b. Horsepower
 - c. Axis travel
 - d. Speed and feed limits
 - e. Overall condition
 - f. Spindle configuration
4. Select a cutter:
 - a. By style (facing, chamfering, etc.)
 - b. By task:
 - 1) Cut diameter
 - 2) Lead Angle
 - 3) Mounting method
 - 4) Hand
 - c. Select inserts by proper grade, geometry and top prep.
 - d. Select machining data:
 - 1) Recommended surface speed (ft/min)
 - 2) Calculate RPM
 - 3) Select feed rate per tooth (when radial depth of cut is less than 50% of the diameter, chip load should be increased accordingly)
 - 4) Check K factor (effective number of teeth in cut)
 - 5) Calculate table feed
 - 6) Calculate metal removal rate and power consumption

OTHER CONSIDERATIONS

Coolants

Coolants are **not recommended for milling with cermet and ceramic inserts**. Coolant exposes the inserts to damage from thermal shock caused by the intermittent heating and cooling cycles. Directed air pressure or sometimes an aerated mist can aid in chip flow.

Cutter Handling

A cutter should be maintained in good condition, making sure the cutter is properly cleaned and changing spare parts.

Insert Care, Mounting and Indexing

With the exception of single point cutters, each milling insert is dependent on the others in the cutter. Failure of one insert increases chip load on the others, usually resulting in severe breakage of the rest.

To insure proper chip load on all inserts, care must be taken to seat them properly into the pocket.

When mounting new inserts or indexing, the pockets and/or cartridges must be thoroughly cleaned of any loose material.

Milling inserts must be eventually replaced due to failure by wear or fracturing. Observation of insert condition during use, and the nature of it, will indicate satisfactory or unsatisfactory performance.

MOUNTING CONSIDERATIONS

Integral shank cutters offer the best rigidity. Use appropriate style end mill holder or collet chuck with non-pull collets. Special continuous clamping milling chucks usually result in the most rigid set-up. On shell mills, make sure arbor is proper size, type and in good repair. Run-out, chatter, poor surface finish and poor tool life can sometimes be traced to poor or improper mounting.

MILLING METHOD CONSIDERATIONS

Down milling (climb milling), or milling in the direction of the feed, should always be the first choice. In down milling, the insert enters through the un-milled surface, and produces a chip that becomes progressively thinner as the insert pushes through the part, which helps in materials that tend to work-harden. Down-milling also places downward pressure on the workpiece and forces the work in the direction of the feed. The thin chip exit helps insert edge security, better tool life and of considerable importance in milling heat resistant materials.



FEED / SPEED CALCULATIONS

UNIT CONVERSIONS

Feed and speed calculations use the following abbreviations:

DEFINITION OF TERMS

WOC = WIDTH OF CUT (INCHES)
 DIA = CUTTER DIAMETER (INCHES)
 DOC = DEPTH OF CUT (INCHES)
 EFF = MACHINE EFF
 f = FEEDRATE (SEE IPM, IPR, AND IPT)
 HPM = HORSEPOWER REQUIRED AT THE MOTOR (HP)
 HPS = HORSEPOWER REQUIRED AT THE SPINDLE (HP)
 IPM = FEEDRATE (INCHES PER MINUTE)
 IPR = FEEDRATE (INCHES PER REVOLUTION)
 IPT = FEEDRATE (INCHES PER TOOTH)

LOC = LENGTH OF CUT (INCHES)
 N = NUMBER OF EFFECTIVE TEETH IN CUTTER
 Q = METAL REMOVAL RATE (CUBIC INCHES PER MINUTE)
 RPM = REVOLUTIONS PER MINUTE
 SFM = SURFACE FEET PER MINUTE
 T = TIME (SECONDS)
 t_{chip} = CHIP THICKNESS (INCHES)
 UHP = UNIT HORSEPOWER FACTOR
 α = LEAD ANGLE

Cutting cycle time=length of cut (inches)/IPM
 Cubic inches removed per minute =IPM x WOC x DOC

SURFACE SPEED

$$SFM = .262 \times DIA \times RPM$$

REVOLUTIONS PER MINUTE

$$RPM = \frac{3.82 \times SFM}{DIA}$$

FEEDRATE (INCHES/REVOLUTION)

$$IPM = IPT \times N \times RPM$$

FEEDRATE (INCHES/REVOLUTION)

$$IPR = \frac{IPM}{RPM}$$

FEEDRATE (INCHES/TOOTH)

$$IPT = \frac{t_{chip}}{\cos \alpha}$$

METAL REMOVAL RATE

$$Q = WOC \times DOC \times IPM \text{ (in}^3\text{/min)}$$

TIME IN CUT (IN SECONDS)

$$T = \frac{15.7 \times DIA \times LOC}{SFM \times IPT \times N}$$

or

$$T = \frac{60 \times LOC}{IPM}$$

OPTIMUM FEED RATES

The following formula can be used to determine optimum feed rates when chip thinning occurs:

$$IPM = \frac{\text{desired FPT}}{\sqrt{\frac{(\text{cutter DIA} - \text{WOC}) \times \text{WOC}}{\text{cutter RADIUS}}}} \times \text{effective teeth} \times RPM$$

The **lead angle** of the cutter also affects chip thinning. Only when using a 90-degree lead mill is the chip thickness equal to the feed advance per tooth. When the lead

angle is 30 degrees, the chipload is actually only 87% of the feed advancement, resulting once again in less than optimum metal removal rates. Using the cosine of the lead angle the correct FPT can be determined.

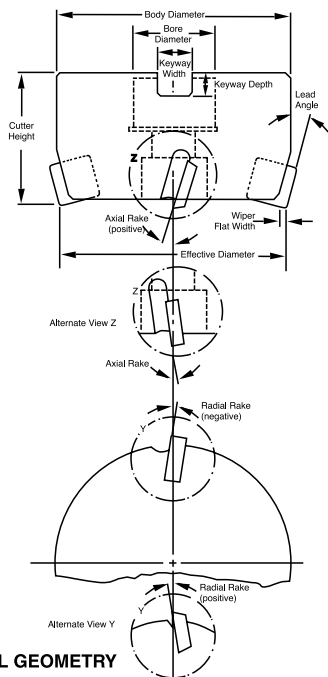
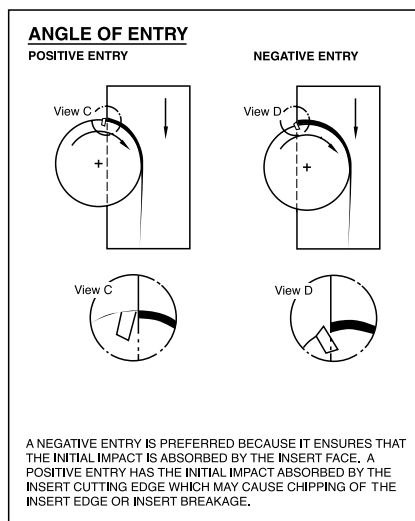
$$FPT = \text{desired FPT} / \cos(\text{lead angle})$$

These two formulas appear to be a lot of trouble over relatively small gains, but when proper feedrates are applied, tool life will increase, cycle time will drop, and better part quality will result.

CHIP THINNING

In milling, the feedrate is also affected by the width of cut (WOC). As long as the WOC equals or exceeds the radius of the cutter, the FPT will equal the chip thickness. Whenever the WOC is less than the radius of the cutter, chip thinning occurs, meaning the chip thickness is less than the FPT (feed advance per tooth).

This results in lower metal removal rates, less efficient machining, higher cutting temperatures, and early insert failure.



MILLING FEEDS AND SPEEDS

MACHINING RECOMMENDATIONS

Material	Condition	Insert Grade	SFM	FPT	Comments
Aluminum	Low Silicon (< 8%)	5, 6, 13	1500-1800	.005-.007	Use Coolant
		12	2000-4/5000 SFM or 10K RPM or so max	.005-.020	
Aluminum, Aluminum-Bronze	High Silicon (> 8%)	66C	800-1100	.005-.008	
Bronze		1, 5, 6	1000-1100	.005-.008	
Bronze	Malleable	1, 5, 6, 10	400-700	.003-.006	
	Gray	10, 23C, 93C	600-1200	.004-.016	
	Nodular (Ductile)	1, 5, 6, 10	600-850	.004-.008	
Copper		1, 5, 6	1200	.007	
CPM 9V	9% Vanadium, 5.25% Chromium	23C	310-400	.005-.006	Flood Coolant
D2	Annealed	1, 5, 6	400	.002	
Inconel		93C	100	.003	0.060 DOC Max
	718	10	100-200	.001-.002	0.100 DOC Max
Invar 36	30% Nickel	93C	100-250	.003-.004	
Stainless Steel	Ferritic Martensitic	5, 6, 23C, 66C, 93C	500-800	.002-.006	
	Cast	5, 6, 23C, 66C, 93C	500-800	.003-.006	
	304	5, 6, 23C, 66C, 93C	400	.003	
	316L	5, 6, 23C, 66C, 93C	300	.003-.004	
Steel, Unalloyed		1, 5, 6	800-1400	.003-.006	
Steel, Low Alloy	Annealed	1, 5, 6	600-1200	.003-.006	
	Hardened	1, 5, 6	400-700	.002-.005	
Steel, High Alloy	Annealed	1, 5, 6	400-700	.003-.006	
	Hardened Rc	1, 5, 6	250	.002	
Steel, Cast	Low Alloy	1, 5, 6	600-1200	.004-.008	
	High Alloy	1, 5, 6	400-700	.003-.006	
Titanium		93C, 23C, 13	100-210	.002-.003	
Tungsten		6	400	.002-.004	

NOTE: Do not use coolant on Grades 1, 5, or 6 unless specifically noted.

LONG EDGE MILLING

Slot milling with long edge mills is not recommended. When using long edge mills to circular interpolate inside diameters, allow sufficient room for chip clearance. Use of forced, directed air may be required in all cases. Depth of cut must be carefully considered relative to the machine horsepower.

Speeds and feeds shown above are suggested starting points. Actual speed and feeds may vary due to material, machine and operating conditions. Test cuts are recommended, checking machine and holding rigidity prior to cutting at the high range of recommended speed and feed. As depth of cut increases and/or full slotting, modify speed and feed downward accordingly. All speeds and feeds that apply to cermet should be reduced 10-20% when using carbide grades.



CLASSIFICATION CHART FOR MILLING GRADES

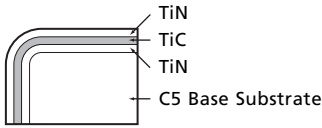
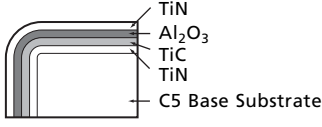
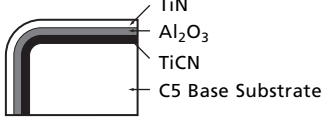
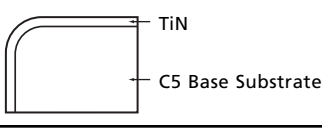
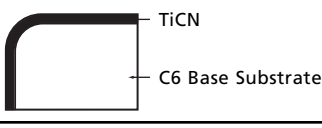
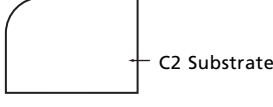
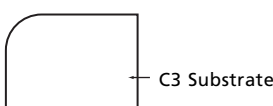
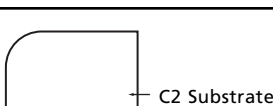
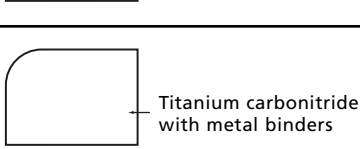
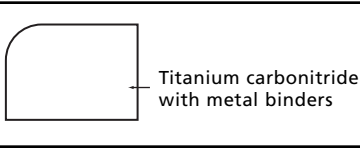
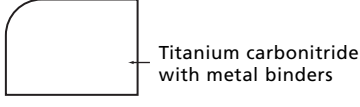
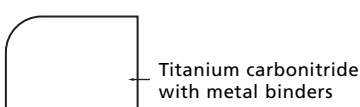
ISO	CLASS	UNCOATED CARBIDE	COATED CARBIDE	CERMET	
P01	C8				WEAR RESISTANCE ↗
P10	C7				
P20	C6				
P30					TOUGHNESS ↘
P40	C5				
P50					
M01	C8				WEAR RESISTANCE ↗
M10	C7				
M20	C6				
M30					TOUGHNESS ↘
M40	C5				
K01	C4				
K10	C3				WEAR RESISTANCE ↗
K20	C2				
K30					
K40					TOUGHNESS ↘

ISO DESIGNATIONS	
P	STEELS, TOOL STEELS
M	STAINLESS STEELS
K	CAST IRON & NON-FERROUS METALS

C CLASSIFICATIONS	
C-1 through C-4	C-5 through C-8
Abrasion resistant grades. Machining cast iron & short chip materials.	Crater resistant grades. Machining steel & continuous chip materials.
C-1 Roughing	C-5 Roughing & General Purpose
C-2 General Purpose	C-6 Semi-Finishing
C-3 Semi-Finishing	C-7 Light Finishing
C-4 Finishing & Precision Boring	C-8 Finishing & Precision Boring



INSERT GRADES FOR MILLING

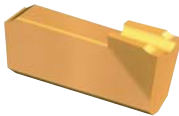
GRADES	COMPOSITION & COATINGS	APPLICATION RECOMMENDATIONS
COATED CARBIDE GRADES	23C 	Tough CVD coated carbide grade for demanding applications in steel, stainless steel and steel castings. Takes shock and interruptions well.
	35C 	CVD coated grade for milling steel, stainless steel and cast steel.
	60C 	Tough CVD coated grade for roughing and semi-roughing at low to medium speeds in steel.
	66C 	PVD coated grade as a first choice in milling tough to machine stainless steels and other tough materials.
	93C 	PVD coated micrograin carbide for sharp edge applications when wear resistance is required. Recommended for tough stainless steel, high temp and titanium alloys.
UNCOATED CARBIDE	10 	Micrograin uncoated carbide recommended as first choice in milling gray cast iron. Works well in most aluminum and non-ferrous materials, and as an alternate choice for high nickel/high temp alloy materials.
	12 	Micrograin uncoated carbide primarily for milling aluminum.
	13 	Micrograin uncoated carbide recommended first heat resistant and titanium alloys; also aluminum and non-ferrous materials.
CERMET GRADES	1 	A newly developed "super cermet" grade for rough milling of steel, tool steel and some stainless steels. Secondary application in cast iron, aluminum and other non-ferrous materials. Has toughness and shock resistance paralleling Grade 6, but with better wear resistance.
	5 	Tough cermet, but also exhibits good wear resistance. Recommended primarily for steel, tool steels and some stainless steels. Also shows some versatility in a variety of other materials.
	6 	Toughest cermet with good shock resistance for rough milling in a wide range of materials. Primarily recommended for tool steel applications
	6N 	Toughness combined with good wear resistance. Covers a wide range of applications and handles interruptions well.



CHOOSING THE APPROPRIATE SEPARATOR® CUTOFF INSERT

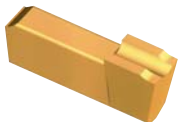
Separator® Classic

A good general purpose insert for carbon steels, alloy steels and most stainless steels. The Separator Classic chip breaker is designed to perform well at moderate to slow speeds and feeds. The Classic offers standard high lead angles and sharp corners making it the first choice when choosing an insert for nib free cutoff.



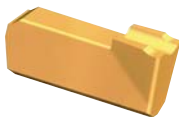
Separator® F²

This insert offers superior flatness and finish on a wide variety of materials. Ideal for thick wall parts or cutting off larger diameter parts to center. The Separator F² performs well at slow to moderate speeds and feeds.



Separator® G²

This insert has a corner radius and a slightly more open chip breaker. It's an ideal general purpose insert for CNC machine cutoff applications. Performs well at moderate speeds and feeds on carbon steels, alloy steels and most stainless steels.



Separator® D²

This insert has a high positive dish style chipbreaker. The chip breaker geometry has excellent edge strength for high feed rate applications. The neutral (0 degree lead) version can be used for grooving applications.



Separator® S²

This high positive rake with more open chip breaker allows for increased speeds and feeds for the moderate to high speed applications. The geometry also includes wipers and a corner radius that provides superior flatness and finish. This insert is also available with sharp corners. This geometry works well on a variety of materials although it's greatest strengths can be seen on Stainless Steels and soft gummy steels.



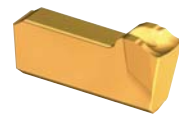
Separator® S²-Ultra

The S²-Ultra is an enhanced version of the S² and is ideal for 300 series stainless, Nickel Based alloys, Tool Steel, Inconel and Titanium at moderate to high speeds and feeds.



Separator® X²

This insert has the same geometry as the MTC-SX™. This chip control geometry offers the widest range of speed and feed capability and provides excellent flatness and finish. This chip breaker cuts with the least amount of tool pressure, extends tool life. The geometry also includes wipers and a corner radius. This geometry works well on a variety of materials.



Separator® X²-Ultra

This insert has the same geometry as the MTC-SX™. The X²-Ultra is an enhanced version of the X² and is ideal for stainless steels, Nickel Based alloys, Tool Steel, Inconel and Titanium.



The inserts listed thus far are single end inserts that go into standard componentized and integral shank holders with up to 3" bar capacity capability. Greater depths of cut and bar capacity can be achieved through customizing and/or special systems. If necessary these Separator inserts can be customized for a particular application.

Separator® PL

This insert is Pressure Locked into a blade style system that allows for varying depths of cut depending on the blade extension from the holder. This insert has a good general purpose chip breaker and is available in sharp corner or corner radius. Ideal for medium to slow speed conditions on a wide variety of materials.



MTC-SX™

This double ended insert is the latest Separator design. The chip control geometry offers the widest range of speed and feed capability and provides excellent flatness and finish. This chip breaker cuts with the least amount of tool pressure, extends tool life. The longer insert and double V offer maximum insert stability. Operator friendly insert indexing. This insert fits into standard and componentized holders capable of up to 25mm depth of cut.



MTC-SX™-Ultra

The SX-Ultra is an enhanced version of the SX and is ideal for 300 series stainless, Nickel Based alloys, Tool Steel, Inconel and Titanium at moderate speeds and feeds.



To improve chip control:

- ◆ Use an insert with aggressive chip control geometry. See Table 1, or call Tech. Support.
- ◆ Adjust feed rate up or down to accommodate chip formation.
- ◆ Use a 0° or smallest lead available.
- ◆ Use ample amounts of well-directed coolant. (See *Illustration A*.)
- ◆ Maintain sharp cutting edge and corners.

Table 1: Insert Selection For Aggressive Chip Control Requirements

Width	Insert No.	Grade
3/32"	507-207	M45
3mm	507-314	M45
1/8"	507-224	M45
4mm	507-225	M45
3/16"	507-226	M45

To improve flatness of cutoff surfaces:

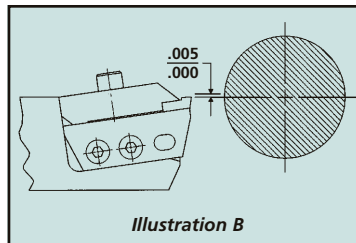
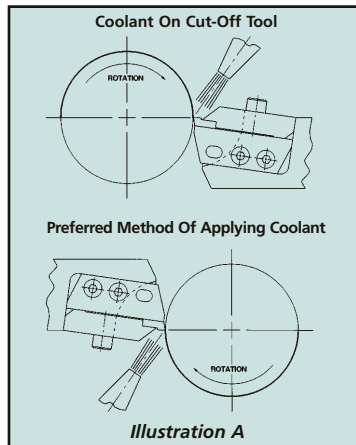
- ◆ Maintain 90° (perpendicular alignment) position between cutoff tool and work piece.
- ◆ For low to moderate speed (sfpm) use Separator F².
- ◆ For moderate to high-speed (sfpm) use Separator S² or SX.
- ◆ Use strongest tool holder system possible.
- ◆ Use 0° lead angle inserts when possible. If lead angle inserts are needed, reduce the feed rate.
- ◆ Check for minimum overhang of holder and blade.
- ◆ Set up for minimum work piece overhang (distance out of chuck).
- ◆ Reduce feed rate.
- ◆ Maintain sharp edge and corners on cutoff insert.
- ◆ Increase speed (rpm).
- ◆ Use ample amounts of well-directed coolant. (See *Illustration A*.)
- ◆ Maintain proper tool center height .000" to .005" above center. (See *Illustration B*.)

To improve surface finish:

- ◆ For low to moderate speed (sfpm) use Separator F².
- ◆ For moderate to high-speed (sfpm) use Separator S² or SX.
- ◆ Avoid overly aggressive chip control.
- ◆ Increase speed.
- ◆ Reduce lead angle.
- ◆ Decrease the feed rate.
- ◆ Corner radius too large or small.
- ◆ Use a coated grade.
- ◆ Use coolant. (See *Illustration A*.)

To minimize edge chipping:

- ◆ Check to see if tool is significantly above or below center.
- ◆ Reduce feed prior to part drop off.
- ◆ Use Separator S², SX or D².
- ◆ Choose the proper speed associated with the insert grade used.
- ◆ Call Tech. Support to see if a larger hone size is needed.
- ◆ Eliminate chatter.
- ◆ Avoid chip re-cutting.
- ◆ Check for these part and machine problems:
 - Slide is loose.
 - Slide travel is irregular.
 - Bar/tube I.D. and/or O.D. is out of round.
 - Bar/tube is bent.
 - Thin wall collapses (deforms) in the cut.
 - Part is unstable.
 - Cutoff through unturned stock.
 - Excessive tool overhang.
 - Bent or partly attached flash ring.

**To eliminate chatter:**

- ◆ Minimize tool blade and holder overhang.
- ◆ Minimize part overhang.
- ◆ Use strongest tool holder system.
- ◆ Use a narrower width of insert.
- ◆ Chip breaker might be too aggressive, call Tech. Support.
- ◆ Adjust speed up or down.
- ◆ Adjust feed rate up or down.
- ◆ Have work piece held rigidly.
- ◆ With a longer part, support with steady rest or live center.
- ◆ Avoid machine dwell.
- ◆ Use S² or SX to reduce cutting forces.

To reduce the cutoff nib on a solid bar or I.D. burr on tubing:

- ◆ Check tool height. Insert cutting edge should be on center to .002" above centerline of work piece.
- ◆ To reduce nib on part, use a high lead angle type insert. Lead angle on a cutoff insert reduces the nib, which remains on the work piece. *Caution: The higher the lead the more tool side deflection.*
- ◆ Use the narrowest possible cutoff insert. This will minimize the cutoff burr length.
- ◆ Reduce feed rate at the end of a cut.
- ◆ On most tubing type parts a 4° or 5° lead angle will be sufficient.
- ◆ Add support to a long slender type part.
- ◆ Maintain proper sub-spindle alignment.
- ◆ If nib or burr persist, call Tech. Support about reducing hone size.
- ◆ Use small or no corner radius.

To eliminate built-up edge:

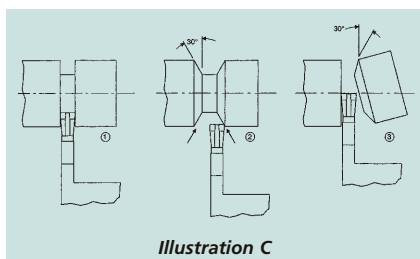
- ◆ Select proper grade for insert.
- ◆ Increase speed (rpm).
- ◆ Use ample amounts of well-directed coolant. (See Illustration A on H3.)

Chamfer and cutoff operations:

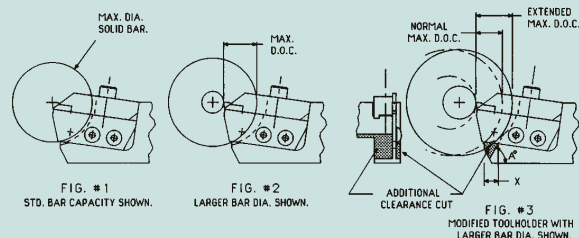
- ◆ Use Separator G², S², SX and D².
- ◆ Groove or breakdown work piece surface being machined.
- ◆ Machine the chamfer.

For jobs requiring a chamfer on both ends of the part, begin by plunging to a depth just beyond the depth of the chamfers. Then, return to the part O.D. and profile each chamfer individually. Finish the cut off after completion of the second chamfer.

- ◆ Cutoff the work piece. (See Illustration C.)



Modifications For Increased Depths Of Cut



CAPACITY CHART FOR 2-1/4" DIA. BAR CAPACITY TOOLING.

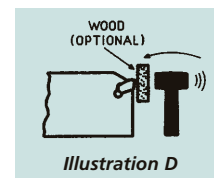
BAR DIA.	2.5	3.0	3.5	4.0	4.5	5.0	6.0	NOTE.
MAX. D.O.C.	0.94	0.75	0.62	0.56	0.50	0.47	0.44	WITH NO MODIFICATION ON TOOLHOLDER.
	1.12	1.03	0.97	0.91	0.87	0.84	0.78	WITH MODIFICATION X = 40° ON TOOLHOLDER. A = 60°

CAPACITY CHART FOR 3.0" DIA. BAR CAPACITY TOOLING.

BAR DIA.	3.5	4.0	4.5	5.0	6.0	NOTE.
MAX. D.O.C.	1.12	1.00	0.88	0.78	0.69	WITH NO MODIFICATION ON TOOLHOLDER.
	1.44	1.37	1.31	1.25	1.12	WITH MODIFICATION X = 38° ON TOOLHOLDER. A = 55°

Separator P/L

The Separator P/L insert should be placed in the blade finger tight, then properly seated by lightly tapping with either a rubber or plastic hammer. If none is available, a wood block should be placed over the cutting edge prior to seating with the hammer. (See Illustration D.)

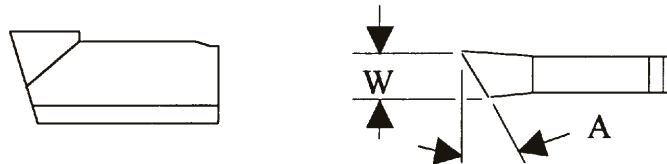


CUTOFF FLAT TOP SEPARATOR® INSERTS

Flat Top Separator® inserts have no chip breaker, no center channel and no corner radii. The flat top Separator® insert mounts into all standrd Manchester Separator® cutoff toolholders.

Advantages a Flat Top Separator® gives you:

- ◆ Less cutting tool pressure than a Separator® Classic. This helps when trying to obtain a nib free part.
- ◆ 507-189 and 507-122 can be used to produce OD grooves with a flat bottom.
- ◆ Flat top inserts provide better finishes on brass, bronze, and most non-ferrous materials than an insert with a chip breaker.



Standard Flat Top Separator® Inserts

INCH

Part Number	Width W	Lead Angle A	Hand	Grades			
				C2	C5	M20	M40
507-189	1/16	0°	N				•
507-141	3/32	4°	R	•	•		
507-179*	3/32	18°	R				•
507-122	1/8	0°	N	•			
507-180*	1/8	18°	R			•	

Standard Flat Top Separator® Inserts

METRIC

Part Number	Width W mm	Lead Angle A	Hand	Grades			
				M20			
507-338	2.4	0°	N				•
507-339	2.4	4°	R				•
507-340	2.4	4°	L				•
507-341	2.4	12°	R				•
507-342	2.4	12°	L				•
507-343	3	0°	N				•
507-344	3	4°	R				•
507-345	3	4°	L				•
507-346	3	12°	R				•
507-347	3	12°	L				•

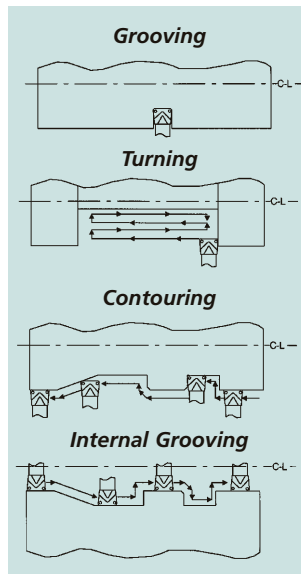
*Has no back taper clearance on lead side for improved flatness and finish.

•Indicates grade availability.



Application Information:

- ◆ Insure that the machine and the workpiece setups are as rigid as possible.
- ◆ The first choice for rigidity in toolholder selection is the use of integral shank holders.
- ◆ Use the holder with the shortest possible depth of cut for the application. This is extremely important in applications that involve significant amounts of turning.
- ◆ Toolholder overhang out of the block should be as short as possible.
- ◆ Inserts should cut as close to center as possible. They should never be more than .010" above center. If measurements are in doubt, a facing cut will corroborate center line position.
- ◆ For turning and profiling applications, use 1/2 the insert width as a starting point recommendation for depth of cut. Adjust based on material machinability and feed rate. Select a smaller corner radius to improve chip control.
- ◆ The MTC-PT™ offers the widest range of chip control in the Plunge and Turn operation.
- ◆ Chipmaker inserts are effective in the plunge mode up to .008 IPR and operate efficiently in the turning mode up to .012 IPR.
- ◆ Chipmaker 95 inserts are most effective in the plunge mode at heavier feed rates up to .015 IPR. CM-95 is capable of delivering chip control with corner radii of .060" and larger.
- ◆ Use cutoff guidelines, where applicable, for finish, chatter, and edge chipping related problems.
- ◆ When changing inserts, make sure the new insert locates securely against the positive stop.
- ◆ Plunge grooving with the MTC-PT™ system yields excellent chip control in most materials at productive speeds and feeds.
- ◆ The Manchester grooving system is sufficiently rigid to turn in both directions at the same feed rates. This allows continuous cutting when roughing a wide groove as shown.
- ◆ Manchester grooving system rigidity allows profiling cuts to be made at productive speeds and feeds along with excellent surface finishes. The MTC-PT™ and Chipmaker® permit chip control in all modes of operation.



Application Information:

- ◆ When changing inserts, be sure the new insert locates against the positive stop located on the clamp.
- ◆ Never tighten the insert clamping screw without an insert in the pocket. Permanent damage to the clamp could occur.
- ◆ Toolholder projection length out of the tool block should be as short as possible to maintain rigidity.
- ◆ Slower speeds and feeds are recommended compared to O.D. grooving

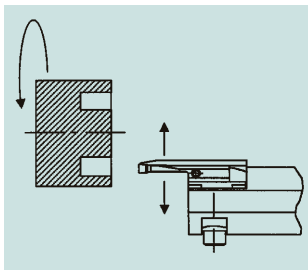
Face Grooving Ranges Per Setting

Given Diameter Setting	Plunge Range At Diameter Setting	
	Smallest O.D.	Largest O.D.
2-1/4	2-1/4	2-3/8
2-1/2	2-3/8	2-5/8
2-3/4	2-9/16	2-15/16
3.0	2-5/8	3-3/8
3-1/2	3-1/16	3-15/16
4.0	3-1/2	4-1/2
5.0	4-1/4	5-3/4
6.0	5.0	7.0
8.0	6-1/2	9-1/2
10.0	8.0	11.0
11.0-16.0	9.0	16.0

Note: This chart is a general guide for face groove entry at outside diameters both smaller and larger than each given OD setting on the tool.
Example: If the tool is adjusted for 4.0 inch OD, plunge cuts from 3-1/2 inch OD to 4-1/2 inch OD can be made without changing the 4.0 inch OD setting.

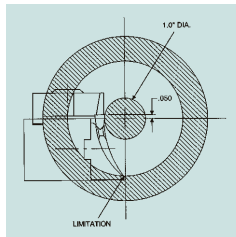
Widening A Face Groove

Additional clearance is generated on the workpiece after the first groove cut. Without further adjustment, the tool may then be used to widen the groove toward the center, or toward the O.D. of the workpiece.



Small Diameter Face Grooving Clearances

The cutting edge of the small diameter face grooving system is +.050" above center. This is done to improve cutting clearances. This tool should not be repositioned on center. When facing toward center, this system does not have sufficient clearance to cut at diameters of less than 1".

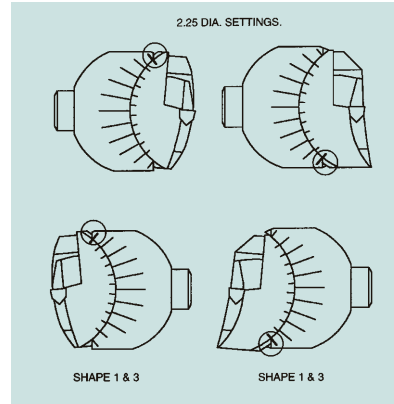


Adjusting Information for Ranger™ Tooling

The following instructions are for style 1 Ranger tools. Instructions for style 2 tools are in [brackets].

- ◆ Appropriate diameter range setting can be accomplished as follows:

Step 1 Loosen the support blade locking screw and rotate the support blade so that the 2.25 mark is above the top line on the toolholder. [Below the line on toolholder for style 2.]



Step 2:

Slowly rotate the support blade down until the 2.25 mark is aligned with the top line of the toolholder. [Rotate the support blade up until the 2.25 mark is aligned with the bottom line on the toolholder for style 2.] At this point, the support blade assembly is properly aligned to cut face grooves at 2.250 inch OD.

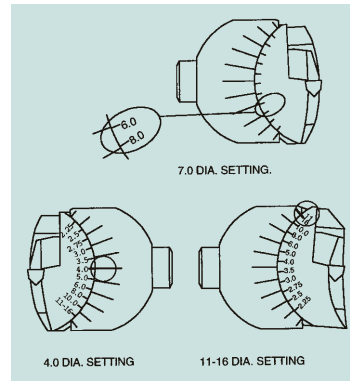
For diameters larger than 2.25 OD, continue to rotate the support blade in the same direction until the desired diameter range has been aligned.

Example: The 7.0 inch diameter setting falls between the 6.0 inch and the 8.0 inch diameter settings.

Step 3:

Tighten the support blade screw. Inspect the scale to ensure that the desired diameter range is aligned.

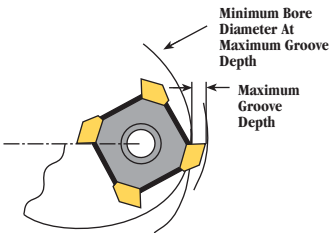
Note: It is important that these instructions are followed. Failure to do so may result in damage to the tool and the workpiece.



Limits With Standard Inserts

INTERNAL GROOVING

Internal Groove Depth vs. Insert Interference



NOTE: Internal grooving depth limits are a function of insert clearance versus bore diameters.

Left Hand	Max. Groove Depth	Min. Bore Diameter	Right Hand
571-122	0.050	0.950	571-131
571-194	0.125	1.050	571-138
571-128	0.125	1.050	571-141
571-130	0.125	1.050	571-143
571-147	0.125	1.450	571-170
571-153	0.180	1.750	571-177
571-154	0.180	1.750	571-183
571-163	0.180	1.750	571-185
571-164	0.190	1.750	571-188



Octicut®

Adjustable Helix Threading System

Use the chart to cross-reference the thread diameter and the Pitch/TPI being machined. Apply the appropriate helix angle to the Adjustable Helix Threading System shown on page E4.

Adjustable Helix Threading System — Helix Angle Chart

RH Bar, RH Neg. Helix

RH Bar, RH Pos. Helix

THREADING TECHNICAL RECOMMENDATIONS

Octicut®

Selection Guidelines

Adjustable Helix Threading System

3. SELECT APPROPRIATE THREADING INSERT

Full Profile Inserts

The advantage of full profile threading inserts is that they provide a perfect thread with a complete profile without burrs.

Partial Profile Inserts

The advantage of partial profile inserts is that single insert may be utilized to cover a variety of thread pitches and can be utilized for external and internal applications.

4. SELECT INSERT GRADE/CUTTING SPEED

To determine recommended cutting speed (SFM) and grade, refer to chart below.

AISI Material Designation	Recommended Cutting Speed Ft/Min			
	M40	M45	M50	M93
Low Carbon Steels 1010, 1015, 1018, 1022, 1025, 1140 12L13, 12L14, 1035, 1040, 1042	100-350	125-400	350-600	450-750
High Carbon Steels 1095, 4130, 4140, 6150, 8620	100-300	125-350	250-400	350-500
High Alloy Steels O1, S1, W1, 4340, H13 A2, D2, M2, M7, M35	100-225	100-250	250-350	300-450
Free Machining Stainless Steels 303, 410, 410S, 416, 430	100-300	125-350	300-400	300-400
Difficult Machining Stainless Steels 304, 348, 420, 440C, 15-5PH, 17-4PH 310, 316, 316L, 317, 318, 321, 660	100-200	125-250	—	200-400
Cast Iron, Grey Iron, Alloy Cast Iron A48-20B, A47-32510, A48-25B, 60/40/18 A48-50B, , A48-60B	250-400	250-400	400-600	400-700
Nickel, Cobalt and Iron Based Superalloys under 38 Rc	100-200	100-250	125-250	150-300
Brass	200-500	250-500	400-700	400-700
Bronze	200-500	250-500	300-400	350-500
Copper	200-500	250-500	—	225-300
Aluminum	200-500	500-900	350-500	500-900
Titanium	75-175	100-200	200-300	150-250

Preferred selection shown in shaded box. If two selections are shown, check for stock status.



Technical Support: 800.282.1331

Selection Guidelines

6. SELECT NUMBER OF PASSES/INFEEED PER PASS

The following tables provide basic recommendations for threading in free machining steels with a hardness of below 320 HB (32Rc). The total number of passes may be adjusted slightly higher or lower for optimum performance as refined by trial.

If insert breakage should occur, the number of passes should be increased. If flank wear is excessive, the number of passes should be reduced.

UN Threads, External

Pitch TPI	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
Tot. depth in.	0.130	0.107	0.092	0.082	0.072	0.065	0.060	0.055	0.051	0.047	0.041	0.037	0.033	0.028	0.024	0.021
Pass 1 inch	0.017	0.014	0.014	0.012	0.011	0.011	0.011	0.011	0.010	0.009	0.009	0.009	0.008	0.007	0.007	0.007
2	0.016	0.013	0.013	0.011	0.010	0.010	0.010	0.010	0.009	0.009	0.008	0.008	0.007	0.007	0.006	0.006
3	0.014	0.011	0.010	0.010	0.008	0.008	0.008	0.008	0.007	0.007	0.006	0.006	0.006	0.006	0.004	0.005
4	0.012	0.009	0.009	0.008	0.007	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.004
5	0.010	0.009	0.008	0.007	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.004	0.003	0.003	
6	0.009	0.008	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.004	0.004	0.003	0.003			
7	0.008	0.007	0.007	0.006	0.006	0.005	0.005	0.005	0.004	0.004	0.003					
8	0.008	0.006	0.006	0.005	0.005	0.005	0.004	0.003	0.003	0.003						
9	0.007	0.006	0.006	0.005	0.005	0.004	0.003									
10	0.007	0.006	0.005	0.005	0.004	0.003										
11	0.007	0.005	0.004	0.004	0.003											
12	0.006	0.005	0.003	0.003												
13	0.005	0.004														
14	0.004	0.004														

UN Threads, Internal

Pitch TPI	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
Tot. depth in.	0.118	0.097	0.084	0.074	0.065	0.059	0.054	0.049	0.045	0.042	0.037	0.033	0.030	0.025	0.022	0.019
Pass 1 inch	0.017	0.014	0.013	0.012	0.011	0.011	0.011	0.011	0.010	0.009	0.009	0.009	0.008	0.007	0.007	0.007
2	0.015	0.013	0.013	0.011	0.010	0.010	0.009	0.009	0.008	0.007	0.007	0.007	0.006	0.006	0.005	0.005
3	0.013	0.010	0.009	0.009	0.007	0.007	0.007	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.004	0.004
4	0.011	0.008	0.008	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.003	0.003
5	0.009	0.007	0.007	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.003	0.004	0.003	0.003	
6	0.008	0.006	0.006	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.003	0.003	0.003			
7	0.007	0.006	0.006	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.003					
8	0.007	0.006	0.005	0.004	0.004	0.004	0.004	0.003	0.003	0.003						
9	0.006	0.005	0.005	0.004	0.004	0.004	0.003									
10	0.006	0.005	0.005	0.004	0.004	0.003										
11	0.005	0.005	0.004	0.004	0.003											
12	0.005	0.004	0.003	0.003												
13	0.005	0.004														
14	0.004	0.004														



THREADING TECHNICAL RECOMMENDATIONS

Octicut®

Selection Guidelines

ISO Metric Threads, External

Pitch TPI	5.0	4.5	4.0	3.5	3.0	2.5	2.0	1.75	1.5	1.25	1.0	.75	.50
Tot. depth in.	0.126	0.113	0.100	0.088	0.076	0.063	0.049	0.044	0.037	0.032	0.026	0.019	0.014
Pass 1 inch	0.016	0.015	0.013	0.013	0.011	0.011	0.009	0.008	0.008	0.008	0.008	0.006	0.005
2	0.015	0.013	0.013	0.012	0.010	0.009	0.009	0.008	0.008	0.007	0.006	0.006	0.004
3	0.013	0.011	0.010	0.010	0.008	0.008	0.007	0.007	0.007	0.006	0.005	0.004	0.003
4	0.011	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.006	0.004	0.004	0.003	0.002
5	0.010	0.009	0.008	0.008	0.007	0.006	0.006	0.005	0.005	0.004	0.003		
6	0.009	0.008	0.007	0.007	0.006	0.006	0.005	0.004	0.003	0.003			
7	0.009	0.008	0.007	0.006	0.006	0.005	0.004	0.003					
8	0.008	0.007	0.006	0.006	0.005	0.004	0.003	0.003					
9	0.007	0.007	0.006	0.006	0.005	0.004							
10	0.007	0.006	0.005	0.005	0.004	0.003							
11	0.006	0.006	0.005	0.004	0.004								
12	0.006	0.005	0.004	0.003	0.003								
13	0.005	0.005	0.004										
14	0.004	0.004	0.003										

ISO Metric Threads, Internal

Pitch TPI	5.0	4.5	4.0	3.5	3.0	2.5	2.0	1.75	1.5	1.25	1.0	.75	.50
Tot. depth in.	0.117	0.104	0.092	0.081	0.070	0.058	0.045	0.041	0.033	0.030	0.024	0.018	0.012
Pass 1 inch	0.017	0.015	0.013	0.013	0.011	0.010	0.009	0.009	0.008	0.007	0.007	0.006	0.004
2	0.016	0.013	0.012	0.012	0.010	0.010	0.008	0.007	0.007	0.007	0.006	0.005	0.003
3	0.013	0.011	0.009	0.009	0.008	0.007	0.007	0.006	0.006	0.006	0.004	0.004	0.003
4	0.010	0.009	0.008	0.007	0.006	0.006	0.006	0.005	0.005	0.004	0.004	0.003	0.002
5	0.009	0.008	0.007	0.007	0.006	0.005	0.005	0.004	0.004	0.003	0.003		
6	0.008	0.007	0.007	0.006	0.005	0.005	0.004	0.004	0.003	0.003			
7	0.007	0.006	0.006	0.006	0.005	0.004	0.003	0.003					
8	0.006	0.006	0.005	0.005	0.004	0.004	0.003	0.003					
9	0.006	0.006	0.005	0.005	0.004	0.004							
10	0.006	0.005	0.005	0.004	0.004	0.003							
11	0.005	0.005	0.004	0.004	0.004								
12	0.005	0.005	0.004	0.003	0.003								
13	0.005	0.004	0.004										
14	0.004	0.004	0.003										



Technical Support: 800.282.1331

Selection Guidelines

7. SELECT INFEEED METHOD

In practice, always consider the workpiece material, the machine tool and the thread pitch in determining the preferred method of infeed.

For short chipping materials and when threading fine pitches, the infeed method selected is less critical.

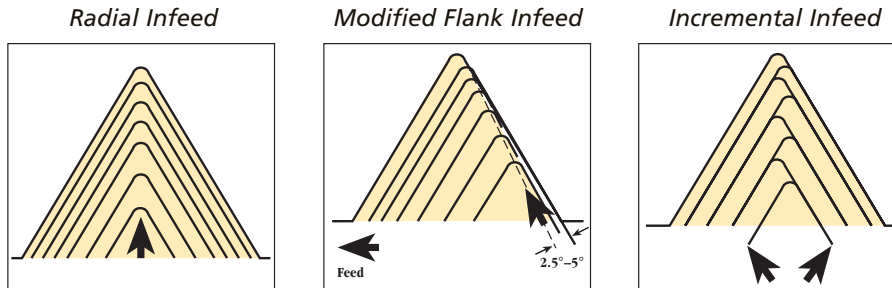
When threading long chipping materials and coarse pitches, the infeed method selected becomes more critical.

Following are shown three basic selections of infeed method.

Radial Infeed is the only method available on manual machines. It is the preferred method in work hardening materials.

Modified Flank Infeed is the preferred method on all CNC Turning Centers. If this method cannot be applied use Standard Flank Infeed.

Incremental Infeed is less common and requires a special CNC program. This method is most suitable for long part run applications.



HELIX SELECTION FOR COMMON EXTERNAL THREADS

The following charts may be used for Quick Reference in selecting the Correct External Threading Helix for Common External Threads when threading toward the chuck, using the "normal threading" method.

Helix Angle Chart For Standard External UN Threads

	PITCH (TPI)													
	32	28	24	20	18	16	14	13	12	11	10	9	8	7
1/4	P3.0	P3.0												
5/16	P1.5		P3.0			P3.0								
3/8	P1.5		P3.0			P3.0								
7/16		P1.5		P3.0			P3.0							
1/2		P1.5		P1.5				P3.0						
9/16			P1.5		P1.5				P3.0					
5/8			P1.5		P1.5					P3.0				
3/4				P1.5		P1.5					P3.0			
7/8				P1.5			P1.5					P3.0		
1				P1.5					P1.5				P3.0	
1-1/8					P1.5				P1.5					P3.0
1-1/4					P1.5				P1.5					P3.0

Helix Angle Chart For Standard External ISO Metric Threads

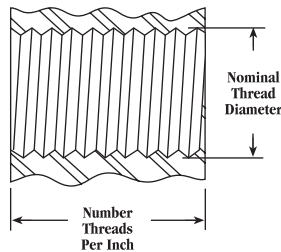
	PITCH (mm)							
	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5
6	P3.0							
7	P3.0							
8	P3.0	P3.0						
10		P3.0	P3.0					
12		P1.5		P3.0				
14			P1.5		P3.0			
16			P1.5		P3.0			
18			P1.5			P3.0		
20			P1.5			P3.0		
22			P1.5			P3.0		
24					P1.5		P3.0	
27					P1.5		P3.0	

Selection Guidelines

Limits With Standard Inserts

INTERNAL THREADING

Pitch Range vs. Internal Diameter



Unified "J" Series Thread

The controlled root radius thread form (MIL-S-8879A) is defined for the external thread only.

To machine the corresponding internal thread, choose any internal full profile UN threading insert (per desired pitch).

Refer to Tables II-VII in MIL-S-8879A for the correct "J" thread minor diameter values on internal thread.

** Requires insert and internal bar modification. A more coarse pitch per nominal thread size may be attained dependent on thread form and type of material.*

Nominal Thread Size	Insert Style 3/Range of TPI
1 "	32-24
1-1/16 "	32-18
1-1/8 "	32-14
1-1/4 "	32-12
1-5/16 "	32-10
1-3/8 "	32-10
1-7/16 "	32-10
1-1/2 "	32-8
1-9/16 "	32-8
1-5/8 "	32-8
1-3/4 "	32-8
1-7/8 "	32-8
2 "	32-8
2-1/4 "	32-8
2-1/2 "	32-8
2-3/4 "	32-8
3 "	32-8

SWISS TECHNICAL RECOMMENDATIONS

Swiss Style Tool Systems

The effective cutting edge length for backturning inserts is shown below.

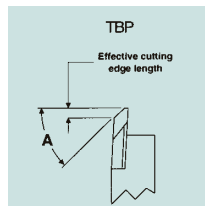
Effective Cutting Edge Length

TBP55 = 2.8mm

TBP60 = 3.5mm

TB32 = 2.5mm

TB43 = 3.5mm



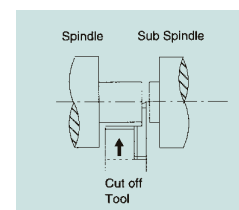
Recommended values for maximum depth of cut (mm) per pass for each insert design are listed below.

Work Material	TBP55	TBP60	TB32	TB43	Grades
Steels	1.96	2.45	1.75	2.45	M40
	N/A	N/A	1.25	1.75	Cermet
Stainless Steels	1.68	2.10	1.50	2.10	M40
	N/A	N/A	1.00	1.40	Cermet
Non-Ferrous	2.52	3.15	2.25	3.15	M40
	N/A	N/A	2.00	2.80	Cermet
Non-Metal	2.52	3.15	2.25	3.15	M40
	N/A	N/A	2.25	3.15	Cermet

Sub-Spindle Swiss CTP Cutoff

Part transfer to sub-spindle for machining and final cutoff, use CTP-K, CTPA-K cutoff inserts.

These inserts provide opposite hand lead angle for the hand of tool.



APPLICATIONS

Material	Grade	Cutoff (Separator)		Grooving		Face Grooving	
		SFM	IPR	SFM	IPR	SFM	IPR
Carbon Steels	M40	100-350	.001-.004	100-350	.002-.004*	100-350	.001-.004
Low Carbon (less than .30% C)	M43	250-700	.001-.004	250-700	.002-.007		
AISI 1000, 1100 and 1200 Series	M45	125-400	.001-.004	125-400	.002-.004		
	M50	250-700	.001-.004	250-700	.002-.004	250-400	.001-.004
	M53			250-700	.004-.010*		
	M74			700-900	.001-.004		
	M93	300-800	.001-.004	300-900	.002-.007		
	C5	250-500	.001-.004	250-500	.002-.004	250-400	.001-.004
	GC	350-700	.001-.004	350-700	.002-.004	350-400	.001-.004
Carbon Steels	M40	100-350	.002-.005	100-350	.002-.005*	100-350	.002-.005
High Carbon (Greater than .30%C)	M43	250-700	.003-.007	250-700	.002-.005		
AISI 1000, 1100 and 1200 Series	M45	125-400	.002-.005	125-400	.002-.005		
	M50	250-700	.003-.007	250-500	.003-.006	250-400	.003-.006
	M53			250-600	.004-.012*		
	M74			700-900	.001-.004		
	M93	300-800	.003-.007	300-800	.003-.008		
	C5	250-450	.003-.006	250-450	.003-.006	250-400	.003-.006
	GC	350-700	.003-.005	250-550	.003-.006	350-400	.003-.005
Alloy Steels	M40	100-350	.001-.005	100-350	.002-.005*	100-350	.001-.005
Low Carbon (Less than .30%C)	M43	250-700	.002-.007	250-700	.003-.007		
AISI 1300, 4000, 5000, 6000, 8000 and 9000 Series	M45	125-400	.001-.005	125-400	.002-.005		
	M50	250-600	.002-.007	250-600	.002-.007	250-400	.002-.006
	M53			250-600	.004-.012*		
	M74			700-900	.001-.004		
	M93	300-800	.002-.007	300-900	.003-.007		
	C5	250-500	.002-.006	250-500	.002-.006	250-400	.002-.006
	GC	350-600	.002-.005	300-600	.002-.005	300-400	.002-.005
Alloy Steels	M40	100-300	.002-.005	100-300	.002-.005*	100-300	.002-.005
High Carbon (Greater than .30%C)	M43	250-600	.003-.006	250-600	.003-.008		
AISI 1300, 4000, 5000, 6000, 8000 and 9000 Series	M45	125-400	.002-.005	125-400	.002-.005		
	M50	250-600	.003-.006	250-500	.003-.005	250-400	.003-.006
	M53			250-600	.004-.012*		
	M74			700-900	.001-.004		
	M93	300-800	.003-.006	300-800	.003-.008		
	C5	250-450	.003-.005	250-450	.003-.006	250-400	.003-.005
	GC	350-600	.003-.005	250-550	.003-.005	350-400	.003-.005
Tool Steels	M40	100-200	.002-.005	100-200	.002-.005*	100-200	.002-.005
Example A-2, D-2, M-2, H-13	M43	150-300	.003-.006	150-350	.003-.007		
	M45	125-250	.002-.005	125-250	.002-.005		
	M50	150-300	.003-.006	150-300	.003-.005	150-300	.003-.006
	M53			250-350	.004-.008*		
	M74			400-600	.002-.004		
	M93	200-370	.003-.006	250-450	.003-.007		
	C5	180-250	.003-.006	180-250	.003-.005	180-250	.003-.006
	GC	220-300	.003-.005	220-300	.003-.005	220-300	.003-.005



APPLICATIONS

Material	Grade	Cutoff (Separator)		Grooving		Face Grooving	
		SFM	IPR	SFM	IPR	SFM	IPR
Martensitic Stainless Steels 400 Series	M40	100-300	.001-.004	100-300	.002-.004*	100-300	.001-.004
	M43	250-450	.002-.007	250-450	.003-.007		
	M45	125-350	.002-.004	125-350	.002-.004		
	M50	250-500	.002-.007	250-500	.002-.007	250-400	.002-.006
	M53			350-500	.004-.012*		
	M74			400-600	.002-.004		
	M93	300-500	.002-.007				
	C5	250-400	.002-.006	250-400	.002-.006	250-400	.002-.006
	GC	350-500	.002-.006	350-500	.002-.005	350-400	.002-.006
Austenitic Stainless Steels 300 Series	M40	100-200	.001-.005	100-200	.002-.005*	100-200	.001-.005
	M43	150-300	.002-.005	150-300	.003-.006		
	M45	125-250	.001-.005	125-250	.002-.005		
	M53			200-350	.004-.007		
	M74			300-500	.001-.003		
	M93			200-350	.002-.005		
	C2	200-250	.0025-.004	200-250	.0025-.004	200-250	.0025-.004
Low Machinability Alloys Iron, Nickel and Cobalt based Example: Inconel™, Hastelloy™	M40	50-125	.002-.005	50-125	.002-.005	50-125	.002-.005
	M43	70-200	.002-.005				
	M45	70-150	.002-.005	70-125	.002-.005		
	M93	90-240	.002-.004				
	C2	70-175	.003-.004	70-175	.003-.004	70-175	.003-.004
Non Ferrous Free Machining Materials—Aluminum., Copper And Zinc Based	M40	400+	.002-.010	400+	.002-.010	400+	.002-.010
	M43	450+	.002-.010	450+	.002-.010		
	M45	400+	.002-.010	400+	.002-.010		
	M93	500+	.002-.010				
	C2	500+	.002-.010	500+	.002-.010	500+	.002-.010
Titanium	M40	100-150	.002-.005	100-150	.002-.005	100-150	.002-.005
	M43	150-225	.002-.005				
	M45	125-175	.002-.005	125-175	.002-.005		
	M93	170-250	.002-.004				
	C2	150-250	.002-.004	150-250	.002-.004	150-250	.002-.004
Cast Irons Grey, Soft (20-30 Rc)	M40	400-500	.002-.010	400-600	.002-.010	400-500	.002-.010
	M43	400-600	.002-.010	500-800	.002-.010		
	M45	400-500	.002-.010	450-700	.002-.010		
	M93	800-1000	.002-.008				
	C2	500-600	.002-.008	500-800	.002-.008	500-600	.002-.008
	AlOx			800-1200	.002-.010	800-1200	.002-.008

*Feed rates higher for Chipmaker® 95

Inconel is a trademark of Huntington Alloys.

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Technical Support: 800.282.1331

SWISS APPLICATIONS

Material	Grade	SFM	IPR (Cutoff)	IPR (Turning)
Carbon, Alloy, and	M40	150-300	.001-.003	.002-.010
Free Cutting Steels	M74	150-600	.001-.002	.002-.005
Austenitic Stainless Steel	M40	150-250	.001-.0025	.002-.008
	M74	150-450	.001-.0025	.002-.005
Non Ferrous Metals	M40	150-700	.002-.006	.005-.010

CBN GROOVING APPLICATIONS

Material	Grade	SFM	IPR
Gray Cast Iron (180-270 Bhn)	CBN-CI	1500-3000	.002-.010
Hard Cast Iron (>400 Bhn)	CBN-CI	250-500	.002-.010
Hardened Steel (>450 Bhn)	CBN-HT	300-450	.002-.006
Superalloys (>350 Bhn)	CBN-CI	550-800	.002-.010
Sintered Iron	CBN-CI	300-600	.002-.010

CERAMIC GROOVING APPLICATIONS

Material	Grade	SFM	IPR
Gray Cast Iron (180-270 Bhn)	M70	500-2000	.002-.008
Hard Cast Iron (>400 Bhn)	M70	100-800	.002-.008
Hardened Steel	M70	100-400	.002-.005
Superalloys	M70	400-800	.002-.007



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
203-112	C10, D13	204-264	C16, C17, C19	206-264	B14	206-372	B20, B23	206-518	B16
203-219	C8	204-265	C16, C18	206-265	B14	206-375	B20, B23	206-519	B16
203-223	C8	204-266	D6	206-266	B14	206-376	B20, B23	206-522	B16
203-231	C10, D13	204-267	D6	206-272	B14	206-377	B20, B23	206-523	B16
203-232	C10, D13	204-268	D6	206-273	B14	206-378	B20, B23	218-119	C23, E6
203-233	C10, D13	204-269	C12, D15	206-274	B14	206-379	B20, B23	218-121	C23, E6
203-234	C8	204-270	C12, D15	206-275	B14	206-380	B20, B23	218-122	C23, E6
203-235	C8	204-271	C13, D15	206-276	B14	206-381	B21, B23	218-123	C23, E6
203-245	C10, D13	204-272	C13, D15	206-277	B14	206-382	B21, B23	218-124	C23, E6
203-250	C8	204-273	C13, D15	206-278	B14	206-383	B21, B23	218-125	D9
203-271	C10, D13	204-274	C13, D15	206-279	B14	206-384	B21, B23	218-126	D9
203-275	C8	206-108	B18	206-280	B14	206-388	B20, B23	218-134	C23, E6
203-277	C8	206-110	B19	206-281	B14	206-408	B18	218-142	C23, E6
203-281	C8	206-113	B18	206-282	B14	206-410	B18	218-143	C23, E6
203-285	C8	206-114	B18	206-283	B14	206-411	B19	226-250	C16, C18
203-287	C10, D13	206-115	B19	206-284	B14	206-412	B19	226-252	C16, C19
203-308	C8	206-116	B19	206-285	B14	206-417	B15	226-255	C16, C21
203-331	C8	206-118	B18	206-310	B20, B22	206-418	B15	226-261	C16, C19
203-332	C8	206-119	B19	206-311	B20, B22	206-419	B15	226-262	C16, C19
203-333	C8	206-120	B19	206-312	B20, B22	206-420	B15	226-265	C16, 21
203-334	C8	206-121	B19	206-313	B20, B22	206-421	B15	235-101	D3
203-335	D17	206-122	B19	206-314	B20, B22	206-422	B15	235-103	D3
203-336	D17	206-123	B18	206-315	B20, B22	206-423	B15	235-104	D3
203-340	D17	206-124	B19	206-316	B20, B22	206-424	B15	235-105	D3
203-341	D17	206-128	B18	206-317	B20, B22	206-439	B17	235-106	D3
203-343	C8	206-136	B18	206-318	B20, B22	206-440	B17	235-107	D3
203-344	C8	206-139	B14	206-319	B20, B23	206-441	B18	235-108	D3
203-345	C8	206-140	B14	206-320	B20, B23	206-442	B18	235-109	D3
203-346	C8	206-141	B17	206-321	B20, B23	206-443	B19	235-110	D3
203-347	D6	206-142	B17	206-322	B20, B23	206-444	B19	235-201	D4
203-348	D6	206-143	B17	206-323	B20, B23	206-445	B14	235-202	D4
203-349	D6	206-144	B17	206-324	B20, B23	206-446	B14	235-203	D4
203-350	D6	206-145	B14, B20, B22	206-325	B20, B23	206-447	B14	235-204	D4
203-351	D6	206-146	B14	206-326	B20, B23	206-448	B14	235-205	D4
203-352	C10, D13	206-158	B25	206-329	B20, B22	206-449	B14	235-206	D4
203-353	C11, D14	206-166	B25	206-330	B20, B23	206-450	B14	235-207	D4
203-354	C11, D14	206-167	B14	206-331	B20, B22	206-451	B14	235-208	D4
203-355	C11, D14	206-168	B14	206-332	B20, B22	206-452	B14	235-209	D4
203-356	C11, D14	206-169	B14	206-345	B21, B22	206-453	B14	236-101	C7
204-101	C9	206-170	B14	206-346	B21, B22	206-454	B14	236-102	C7
204-109	C9	206-171	B14	206-347	B21, B22	206-455	B14	236-103	C7
204-110	C9	206-172	B14	206-348	B21, B22	206-456	B14	236-104	C7
204-111	C9	206-173	B14	206-350	B21, B23	206-500	B29	236-105	C7
204-214	C12, D15	206-174	B14	206-351	B21, B23	206-501	B29	236-106	C7
204-215	C12, D15	206-175	B14, B20, B22	206-352	B21, B23	206-502	B29	236-107	C7
204-217	C16, C17, C20	206-176	B14	206-353	B21, B23	206-503	B29	236-108	C7
204-218	C16, C17, C21	206-178	B16	206-354	B21, B23	206-504	B29	236-109	C7
204-256	C16, C17, C21	206-179	B16	206-364	B22	206-505	B29	236-110	C7
204-258	C12, D15	206-180	B16	206-365	B22	206-506	B29	236-111	C7
204-259	C12, D15	206-186	B25	206-366	B22	206-507	B29	236-112	C7
204-261	C16, C17, C21	206-188	B24	206-367	B22, B23	206-508	B29	236-125	C7
204-262	C16, C17, C19	206-262	B17	206-368	B22, B23	206-509	B29	236-126	C7
204-263	C16, C17, C19	206-271	B17	206-369	B22, B23	206-510	B29	236-127	C7
		206-263	B14	206-370	B22	206-511	B29	236-128	C7



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
236-201	C7	239-151	F11	245-108	E3	245-334	C26, D12	250-142	A4
236-202	C7	239-152	F11	245-109	E3	245-431	B24	250-143	A4
236-203	C7	239-154	F11	245-110	E3	245-432	B13	250-144	A4
236-204	C7	239-155	F11	245-111	E3	245-433	B13	250-145	A4
236-205	C7	240-101	F9	245-112	E3	245-434	B13	250-146	A4
236-206	C7	240-108	F9	245-201	C26, D11	245-435	B13	250-147	A4
236-207	C7	240-111	F9	245-202	C26, D11	245-436	B13	250-148	A4
236-208	C7	240-120	F9	245-203	C26, D11	245-437	B13	250-149	A4
236-209	C7	240-121	F9	245-204	C26, D11	245-438	B13	250-150	A4
236-210	C7	240-122	F9	245-205	C26, D11	245-439	B13	250-151	A4
236-211	C7	240-123	F9	245-206	C26, D11	245-440	B13	250-152	A4
236-212	C7	240-124	F9	245-207	C26, D11	245-441	B13	250-153	A4
236-213	C7	240-127	F9	245-208	C26, D11	245-442	B13	250-154	A4
236-214	C7	240-128	F9	245-209	C26, D11	245-443	B13	250-181	A4
236-215	C7	240-129	F9	245-210	C26, D11	245-444	B13	250-182	A4
236-216	C7	240-131	F7	245-213	C26, D11	245-445	B13	250-183	A4
237-101	C14	240-132	F7	245-214	C26, D11	245-446	B13	250-184	A4
237-102	C14	240-135	F7	245-215	C26, D11	245-447	B13	250-189	A4
237-103	C14	240-136	F7	245-216	C26, D11	245-448	B24	250-190	A4
237-104	C14	240-139	F7	245-217	C26, D11	248-103	E4	250-191	A4
237-105	C14	240-140	F7	245-218	C26, D11	248-104	E4	250-192	A4
237-106	C14	240-145	F7	245-221	C27, D12	248-105	E4	250-193	A4
237-107	C14	240-146	F7	245-222	C27, D12	248-106	E4	250-194	A4
237-108	C14	240-147	F7	245-223	C27, D12	248-203	E4	250-201	A5
237-201	C14	240-148	F7	245-224	C27, D12	248-204	E4	250-202	A5
237-202	C14	240-150	F8	245-225	C27, D12	248-205	E4	250-203	A5
237-203	C14	240-151	F8	245-226	C27, D12	248-206	E4	250-204	A5
237-204	C14	240-154	F8	245-229	C27, D12	250-109	A4	250-205	A5
237-205	C14	240-156	F6	245-230	C27, D12	250-110	A4	250-206	A5
237-206	C14	240-157	F6	245-231	C27, D12	250-111	A4	250-207	A5
237-207	C14	240-158	F6	245-232	C27, D12	250-112	A4	205-208	A5
237-208	C14	240-160	F6	245-233	C27, D12	250-113	A4	250-209	A5
239-101	F3	240-162	F6	245-234	C27, D12	250-114	A4	250-210	A5
239-102	F3	240-163	F6	245-301	C26, D11	250-115	A4	250-211	A5
239-106	F3	240-164	F6	245-302	C26, D11	250-116	A4	250-212	A5
239-107	F3	240-165	F6	245-303	C26, D11	250-117	A4	250-213	A5
239-111	F3	241-101	F2	245-304	C26, D11	250-118	A4	250-214	A5
239-112	F3	241-102	F2	245-305	C26, D11	250-119	A4	250-215	A5
239-114	F3	241-103	F2	245-306	C26, D11	250-120	A4	250-216	A5
239-115	F3	241-104	F2	245-307	C26, D11	250-123	A4	250-217	A5
239-120	F5	241-105	F2	245-308	C26, D11	250-124	A4	250-218	A5
239-121	F5	241-106	F2	245-309	C26, D11	250-125	A4	250-219	A5
239-122	F5	241-108	F2	245-310	C26, D11	250-126	A4	250-220	A5
239-125	F5	244-104	E5	245-315	C26, D11	250-127	A4	250-221	A5
239-128	F5	244-105	E5	245-316	C26, D11	250-128	A4	250-222	A5
239-130	F5	244-106	E5	245-317	C26, D11	250-129	A4	250-223	A5
239-131	F5	244-107	E5	245-318	C26, D11	250-130	A4	250-224	A5
239-133	F5	244-221	C28	245-323	C26, D12	250-133	A4	250-227	A5
239-134	F5	244-222	C28	245-324	C26, D12	250-134	A4	250-228	A5
239-136	F4	244-223	C28	245-325	C26, D12	250-135	A4	250-229	A5
239-137	F4	244-224	C28	245-326	C26, D12	250-136	A4	250-230	A5
239-140	F4	244-227	C28	245-331	C26, D12	250-137	A4	250-233	A5
239-141	F4	244-228	C28	245-332	C26, D12	250-138	A4	250-234	A5
239-150	F11	245-107	E3	245-333	C26, D12	250-141	A4	250-235	A5



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
250-236	A5	250-403	A8	251-239	A6	308-123	C8, C9	327-148	D13, D14, D15,
250-237	A5	250-404	A8	251-240	A6	308-124	C8, C9		D16, D17
250-238	A5	250-405	A8	251-249	A6	308-125	C8, C9	327-149	D13, D14, D15,
250-241	A5	250-406	A8	251-250	A6	308-126	C8, C9		D16, D17
250-242	A5	250-407	A8	251-251	A6	308-127	C8, C9	327-150	D13, D14, D15,
250-243	A5	250-408	A8	251-252	A6	308-128	C8, C9		D16, D17
250-244	A5	250-409	A5	251-253	A6	308-130	C8, C9	327-151	D13, D14, D15,
250-245	A5	250-410	A5	251-254	A6	308-131	C8, C9		D16, D17
250-246	A5	250-411	A8	251-255	A6	308-132	C8, C9	327-152	D13, D14, D15,
250-247	A5	250-412	A8	251-256	A6	308-137	C8, C9		D16, D17
250-248	A5	250-413	A8	252-109	A7	308-143	C8, C9	327-153	D13, D14, D15,
250-249	A5	250-414	A8	252-110	A7	308-145	C8, C9		D16, D17
250-250	A5	250-415	A8	252-111	A7	308-146	C10, C11, C12,	327-154	D13, D14, D15,
250-251	A5	250-416	A8	252-112	A7		C13		D16, D17
250-252	A5	250-417	A8	252-117	A7	308-147	C10, C11, C12,	327-155	D13, D14, D15,
250-253	A5	250-418	A8	252-118	A7		C13		D16, D17
250-254	A5	251-117	A6	252-119	A7	308-148	C10, C11, C12,	327-160	D13, D14, D15,
250-281	A5	251-118	A6	252-120	A7		C13		D16, D17
250-282	A5	251-119	A6	252-125	A7	308-149	C10, C11, C12,	327-161	D13, D14, D15,
250-283	A5	251-120	A6	252-126	A7		C13		D16, D17
250-284	A5	251-121	A6	252-127	A7	308-150	C10, C11, C12,	327-162	D13, D14, D15,
250-293	A5	251-122	A6	252-128	A7		C13		D16, D17
250-294	A5	251-123	A6	252-209	A7	308-151	C10, C11, C12,	327-163	D13, D14, D15,
250-295	A5	251-124	A6	252-210	A7		C13		D16, D17
250-296	A5	251-133	A6	252-211	A7	308-152	C10, C11, C12,	327-164	D13, D14, D15,
250-301	A4	251-134	A6	252-212	A7		C13		D16, D17
250-302	A4	251-135	A6	252-217	A7	308-153	C10, C11, C12,	327-165	D13, D14, D15,
250-303	A4	251-136	A6	252-218	A7		C13		D16, D17
250-304	A4	251-137	A6	252-219	A7	308-154	C20	327-166	D13, D14, D15,
250-305	A4	251-138	A6	252-220	A7	308-155	C20		D16, D17
250-306	A4	251-139	A6	252-225	A7	308-156	C20	327-167	D13, D14, D15,
250-307	A4	251-140	A6	252-226	A7	308-157	C21		D16, D17
250-308	A4	251-149	A6	252-227	A7	308-159	C21	327-208	D13, D14, D15,
250-309	A4	251-150	A6	252-228	A7	308-160	C21		D16, D17
250-310	A4	251-151	A6	308-106	C8, C9	308-180	C20	327-209	D13, D14, D15,
250-311	A8	251-152	A6	308-107	C8, C9	308-181	C20		D16, D17
250-312	A8	251-153	A6	308-108	C8, C9	308-182	C20	331-101	B17, B22
250-313	A8	251-154	A6	308-109	C8, C9	308-183	C21	331-102	B17
250-314	A8	251-155	A6	308-110	C8, C9	308-184	C21	331-103	B17, B22
250-315	A8	251-156	A6	308-111	C8, C9	308-188	C21	331-104	B17
250-316	A8	251-217	A6	308-113	C8, C9	308-193	C19	331-109	B17, B22
250-317	A8	251-218	A6	308-114	C8, C9	308-194	C19	331-110	B17
250-318	A8	251-219	A6	308-115	C8, C9	308-199	C19	331-117	B17, B22
250-319	A4	251-220	A6	308-116	C8, C9	308-200	C19	331-118	B17
250-320	A4	251-221	A6	308-117	C8, C9	308-202	C18	331-123	B17
250-321	A8	251-222	A6	308-118	C8, C9	308-216	C18	331-124	B17
250-322	A8	251-223	A6	308-119	C10, C11, C12,	309-105	B19, B23, B25	331-119	B24
250-324	A8	251-224	A6		C13	309-106	B19	331-120	B24
250-325	A8	251-233	A6	308-120	C10, C11, C12,	309-111	B19, B23, B25	331-125	B24
250-326	A8	251-234	A6		C13	310-102	B18, B23, B25	333-101	B16
250-327	A8	251-235	A6	308-121	C10, C11, C12,	310-108	B18, B23, B25	333-102	B16
250-328	A8	251-236	A6		C13	310-109	B18, B23, B25	333-103	B16
250-401	A8	251-237	A6	308-122	C10, C11, C12,	311-104	B23	333-104	B16
250-402	A8	251-238	A6		C13	311-108	B23	333-111	B16



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
333-112	B16	340-105	B27	407-134	C10, C11, C12, C13	435-127	B14	437-139	C10, C11, C12, C13
334-101	D7	340-106	B27	407-135	C10, C11, C12, C13, C21	435-128	B17, B22	437-140	C10, C11, C12, C13
334-102	D7	340-107	B27	407-137	C10, C11, C12, C13	435-129	B17	437-143	C10, C11, C12, C13
334-103	D7	340-109	B27	407-138	C10, C11, C12, C13	435-130	B14, B22	437-144	C10, C11, C12, C13
334-104	D7	340-110	B27	407-143	C10, C11, C12, C13, C21	435-131	B14	437-147	C7
334-107	D7	340-111	B27	407-144	C10, C11, C12, C13, C21	435-136	B19, B23, B25	437-148	C7
334-108	D7	340-112	B27	407-177	C19	435-137	B19	437-149	C7
334-111	D7	341-101	B28, C15	407-178	C19	435-148	B18, B23, B25	437-150	C7
334-112	D7	341-102	B28, C15	407-180	C8	435-149	B18	441-101	C7
334-113	D7	345-150	E4	407-181	C8	435-150	B18	441-102	C7
334-114	D7	345-151	E4	407-182	C8	435-151	B18	441-103	C7
334-117	D7	346-103	A9	407-183	C8	435-152	B14, B22	441-104	C7
334-118	D7	346-104	A9	407-186	C19	435-153	B14	442-101	B28, C14, C15
338-121	D3	346-105	A9	407-187	C19	435-154	B16	442-102	B28, C14, C15
338-122	D3	346-106	A9	407-189	C18	435-155	B16	444-103	C27, E3, E5
338-123	D3	346-107	A9	407-196	C18	435-156	B16	445-103	A9
338-124	D3	346-108	A9	409-168	B23	435-157	B16	445-104	A9
338-125	D3	346-109	A9	409-169	B24	435-170	B14	445-105	A9
338-126	D3	346-110	A9	409-170	B23	435-171	B14	445-106	A9
338-127	D3	407-101	C8, C9	409-182	B29	435-180	B15	445-107	A9
338-128	D3	407-102	C8, C9	409-183	B29	435-181	B15	445-108	A9
338-129	D3	407-103	C8, C9	409-184	B29	435-194	B16	445-109	A9
338-130	D3	407-104	C8, C9	409-185	B29	435-195	B16	445-110	A9
308-131	D3	407-105	C8, C9	409-186	B29	435-196	B17	446-101	A7
338-132	D3	407-106	C8, C9	409-187	B29	435-197	B17	446-102	A7
338-221	D4	407-107	C8, C9, C20	415-101	F12	435-200	B14	446-103	A7
338-222	D4	407-108	C8, C9	415-102	F12	435-201	B14	446-104	A7
338-223	D4	407-109	C8, C9, C20	430-108	D13, D14, D15, D16, D17	435-202	B14	505-110	C6
338-224	D4	407-110	C8, C9, C20	430-109	D13, D14, D15, D16, D17	435-203	B14	505-116	C6
338-225	D4	407-111	C8, C9	430-111	D13, D14, D15, D16, D17	435-204	B14	505-119	C6
338-226	D4	407-112	C8, C9	430-112	D13, D14, D15, D16, D17	435-205	B14	505-238	C6
338-227	D4	407-113	C10, C11, C12, C13, C21	435-101	B18, B23, B25	436-101	D7	505-239	C6
338-228	D4	407-115	C10, C11, C12, C13	435-102	B18, B23, B25	436-102	D7	505-240	C6
338-229	D4	407-116	C10, C11, C12, C13	435-103	B19, B23, B25	436-103	D7	505-241	C6
338-230	D4	407-118	C8, C9	435-104	B18	436-104	D7	505-244	C6
338-231	D4	407-119	C8, C9	435-105	B18	437-123	C8, C9	505-245	C6
338-232	D4	407-120	C8, C9	435-106	B19	437-124	C8, C9	505-246	C6
339-102	B26	407-121	C8, C9	435-107	B19	437-125	C8, C9	505-247	C6
339-103	B26	407-122	C8, C9	435-108	B19	437-126	C8, C9	505-256	C6
339-107	B26	407-123	C8, C9	435-109	B18	437-129	C8, C9	506-101	D5, D8
339-108	B26	407-124	C8, C9, C20	435-110	B18	437-130	C8, C9	506-102	D5, D8
339-111	B26	407-125	C8, C9, C20	435-111	B18	437-131	C8, C9	506-103	D5, D8
339-112	B26	407-126	C8, C9	435-116	B18	437-132	C8, C9	506-104	D5, D8
339-117	B26	407-127	C8, C9, C20	435-117	B18	437-135	C10, C11, C12, C13	506-105	D5, D8
339-118	B26	407-129	C8, C9	435-126	B14	437-136	C10, C11, C12, C13	506-106	D5, D8
339-119	B26	407-132	C10, C11, C12, C13, C21			437-137	C10, C11, C12, C13	506-107	D5
339-123	B26	407-133	C10, C11, C12, C13, C21			437-138	C10, C11, C12, C13	506-108	D5
339-128	B26							507-116	B2
339-129	B26							507-117	B2
339-130	B26							507-118	B2
339-138	B26								
339-139	B26								
339-140	B26								
340-104	B27								



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
507-119	B2	507-232	B4	507-298	B5	507-374	B7	508-308	C3
507-120	B2	507-233	B4	507-301	B5	507-378	B5	508-308	C5
507-122	H5	507-234	B4	507-305	B7	507-379	B5	508-309	C3, C17
507-124	B2	507-235	B4	507-306	B7	507-380	B5	508-310	C3, C17, D19
507-125	B2	507-236	B4	507-307	B7	507-382	B8	508-311	C3, D19
507-126	B2	507-237	B4	507-308	B7	507-383	B8	508-312	C3
507-127	B2	507-238	B4	507-309	B7	507-384	B8	508-313	C3, C17
507-128	B2	507-239	B4	507-310	B7	507-386	C5, C15	508-314	C3
507-129	B2	507-240	B3	507-314	H3	507-387	C5, C15	508-315	C3, C17
507-131	B2	507-241	B3	507-316	B2	507-388	C5, C15	508-316	C3, C8, D19
507-132	B2	507-242	B3	507-317	B2	507-389	C5, C15	508-317	C3, D19
507-133	B2	507-243	B3	507-318	B2	507-393	B9	508-318	C3
507-134	B2	507-244	B3	507-319	B2	507-394	B9	508-319	C4, C17
507-140	B2	507-245	B3	507-320	B2	507-395	B9	508-320	C4
507-141	H5	507-246	B3	507-321	B2	507-396	B9	508-321	C4, C17
507-143	B2	507-247	B3	507-329	B6	507-397	B9	508-322	C4, C17, D19
507-144	B2	507-248	B3	507-330	B6	507-398	B9	508-323	C4, D19
507-146	B2	507-249	B3	507-331	B6	507-399	B9	508-324	C4
507-148	B2	507-250	B3	507-332	B6	507-400	B9	508-325	C4, C17
507-149	B2	507-251	B3	507-333	B6	508-208	C2, D18	508-326	C4
507-150	B2	507-252	B3	507-334	B6	508-238	C2, C16	508-327	C4, C17
507-151	B2	507-253	B3	507-338	H5	508-239	C2, C16	508-328	C4, C17, D19
507-152	B2	507-254	B3	507-339	H5	508-240	C2, C16, D18	508-329	C4, D19
507-154	B2	507-255	B3	507-340	H5	508-241	C2	508-330	C4
507-155	B2	507-256	B3	507-341	H5	508-242	C2, D18	508-331	C4, C17
507-161	B2	507-257	B3	507-342	H5	508-243	C2	508-332	C4
507-172	C16	507-258	B3	507-343	H5	508-244	C2, C16	508-333	C4, C17
507-176	B2	507-259	B3	507-344	H5	508-245	C2	508-334	C4, C17, D19
507-179	H5	507-260	B3	507-345	H5	508-246	C2, C16	508-335	C4, D19
507-180	H5	507-261	B3	507-346	H5	508-247	C2, C16, D18	508-336	C4
507-182	B28, C5, C15	507-262	B3	507-347	H5	508-248	C2, D18	508-337	C17
507-183	B28, C5, C15	507-263	B3	507-348	B6	508-249	C2	508-338	C17
507-185	B28, C5, C15	507-267	B4	507-349	B6	508-250	C16	508-339	C17
507-186	B28, C5, C15	507-268	B4	507-350	B6	508-251	C16	508-340	C3, D19
507-189	H5	507-269	B4	507-351	B6	508-252	C16	508-341	C3, D19
507-196	B2	507-275	B5	507-352	B6	508-256	C2, C16	508-403	C5
507-197	B2	507-276	B5	507-353	B6	508-257	C2, C16	508-404	C5
507-200	C16	507-277	B5	507-354	B8	508-258	C2	508-405	C5
507-201	B2	507-278	B5	507-355	B8	508-259	C2	508-412	C5
507-202	B2	507-279	B5	507-356	B8	508-260	C2, C16	508-413	C5
507-203	B2	507-280	B5	507-357	B8	508-261	C2, C16	508-422	C5, D18
507-204	B2	507-281	B5	507-358	B8	508-262	C2, C16, D18	508-423	C5, D18
507-205	B2	507-282	B5	507-359	B8	508-263	C2, C16, D18	508-424	C5, D18
507-206	B2	507-283	B5	507-363	B7	508-264	C16	508-435	C5, D18
507-207	H3	507-288	B3	507-364	B7	508-265	C16	508-436	C5, D18
507-213	B2	507-289	B3	507-365	B7	508-276	C16	508-446	C3
507-214	B2	507-290	B3	507-366	B8	508-279	C2, D18	508-447	C3
507-224	H3	507-291	B3	507-367	B8	508-301	C3, C17	508-448	C3
507-225	H3	507-292	B3	507-368	B8	508-302	C3	508-449	C3
507-226	H3	507-293	B3	507-369	B8	508-303	C3, C17	508-450	C3
507-227	B4	507-294	B3	507-370	B8	508-304	C3, C17	508-451	C3
507-228	B4	507-295	B5	507-371	B8	508-305	C3, D19	508-452	C3
507-229	B4	507-296	B5	507-372	B7	508-306	C3	508-453	C3
507-231	B4	507-297	B5	507-373	B7	508-307	C3, C17	508-454	C3



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
508-456	C3, D19	512-117	B10	538-113	F3	539-147	F6	571-176	D10
508-457	C3, D19	512-129	B10	538-114	F3	539-148	F6	571-177	C24
508-458	C3, D19	512-130	B10	538-115	F3	539-149	F6	571-183	C24
508-461	C4	512-157	B11	538-116	F3	539-150	F6	571-185	C24
508-462	C4	512-158	B11	538-117	F3	570-142	E2	571-188	C24
508-463	C4	512-161	B11	538-118	F3	570-143	E2	571-194	C24
508-464	C4	512-164	B11	538-120	F3	570-144	E2	571-198	D10
508-465	C4	512-165	B11	538-121	F3	570-145	E2	571-204	D10
508-466	C4	512-168	B11	538-122	F3	570-152	E2	571-206	D10
508-467	C4	512-171	B11	538-123	F5	570-154	E2	571-284	C24
508-468	C4	512-172	B11	538-124	F5	570-157	E2	571-285	C24
508-469	C4	512-175	B11	538-125	F5	570-160	E2	571-286	C24
508-470	C4, D19	512-178	B11	538-126	F5	570-163	E2	571-287	C24
508-471	C4, D19	512-179	B11	538-128	F5	570-166	E2	571-288	C24
508-472	C4, D19	512-182	B11	538-129	F5	570-168	E2	571-289	C24
510-101	C22	512-192	B11	538-130	F5	570-170	E2	571-290	C24
510-102	C22	512-193	B11	538-131	F5	570-180	E2	571-291	C24
510-103	E6	512-196	B11	538-133	F4	570-182	E2	571-292	C24
510-104	C22	512-199	B11	538-134	F4	570-226	E2	571-293	C24
510-105	C22	512-200	B11	538-137	F4	570-228	E2	571-294	C24
510-106	E6	512-203	B11	538-138	F4	570-280	E2	571-295	C24
510-107	D9	512-206	B11	538-145	F11	570-288	E2	571-296	C24
510-108	D9	512-207	B11	538-146	F11	570-290	E2	571-297	C24
510-113	C22	512-210	B11	538-147	F11	571-122	C24	571-420	B12
510-114	C22	512-213	B10	538-148	F11	571-123	C25	571-421	B12
510-115	C22	512-214	B10	538-152	F11	571-124	C25	571-422	B12
510-116	C22	512-215	B10	538-153	F11	571-125	D10	571-423	B12
510-117	C22	512-216	B10	539-101	F10	571-126	C25	571-424	B12
510-118	C22	512-217	B10	539-102	F10	571-127	D10	571-425	B12
510-119	C22	512-218	B10	539-103	F10	571-128	C24	571-426	B12
510-120	C22	512-122	B10	539-104	F10	571-129	D10	571-427	B12
510-121	C22	512-123	B10	539-105	F10	571-130	C24	571-442	B12
510-122	C22	524-101	B9	539-106	F10	571-131	C24	571-443	B12
510-123	C22	524-102	B9	539-107	F10	571-132	C25	571-444	B12
510-124	C22	524-103	B9	539-108	F10	571-135	C25	571-445	B12
510-125	C22	526-101	D5, D8	539-109	F10	571-137	D10	571-446	B12
510-126	C22	526-102	D5, D8	539-116	F10	571-138	C24	571-447	B12
510-127	C22	526-103	D5, D8	539-118	F10	571-139	C25	571-448	B12
510-128	C22	526-104	D5, D8	539-119	F10	571-140	D10	571-449	B12
510-129	C22	526-105	D5, D8	539-120	F10	571-141	C24	571-450	B12
510-130	C22	526-106	D5, D8	539-122	F10	571-142	D10	571-451	B12
510-131	C22	528-301	C6	539-129	F7	571-143	C24	571-452	B12
510-132	C22	528-303	C6	539-130	F7	571-146	C25	571-453	B12
510-133	C22	528-304	C6	539-131	F7	571-147	C24	571-454	B12
510-134	C22	538-101	F3	539-132	F7	571-148	C25	571-455	B12
510-135	D9	538-102	F3	539-134	F8	571-153	C24	571-456	B12
510-136	D9	538-103	F3	539-135	F8	571-158	D10	571-457	B12
510-137	D9	538-104	F3	539-136	F8	571-159	C24	571-458	B12
510-138	D9	538-105	F3	539-134	F8	571-163	C24	571-459	B12
512-108	B10	538-106	F3	539-139	F7	571-164	C24	571-461	B12
512-109	B10	538-107	F3	539-140	F7	571-165	D10	571-462	B12
512-110	B10	538-109	F3	539-144	F8	571-169	C25	571-464	B12
512-115	B10	538-110	F3	539-145	F6	571-170	C24	571-465	B12
512-116	B10	538-112	F3	539-146	F6	571-171	C25	571-467	B12



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
571-468	B12	583-126	A2	583-180	A2	608-101	C9	644-107	C26, C27, C28, D11, D12, E3, E5
580-101	F2	583-127	A2	583-181	A2	608-105	F12	644-108	B13, C26, C27, D11, D12
580-102	F2	583-128	A2	583-182	A2	608-107	F12	644-110	C26, C27, C28, D11, D12, E3, E5
580-103	F2	583-129	A2	583-183	A2	613-135	D3, D4	644-111	B13, B24, C26, C27, D11, D12
580-105	F2	583-130	A2	583-184	A2	613-137	D3, D4	644-120	B24
580-108	F2	583-131	A2	601-101	C8, C9	613-139	B29	700-101	C19
580-109	F2	583-132	A2	601-102	C8, C9	614-122	B25	700-103	F12
580-111	F2	583-133	A2	601-103	C8, C9	614-123	B25	1/4-SHCS-CB	G13
580-112	F2	583-134	A2	601-104	C8, C9	615-139	E4	5/16-SHCS-CB	G13
580-113	F2	583-135	A2	601-105	C8, C9	619-101	C10, C12, C21, D13, D15, D17	3/8-SHCS-CB	G13
580-114	F2	583-136	A2	601-106	C8, C9	619-102	C8, C9	7/16-SHCS-CB	G13
580-115	F2	583-137	A2	601-107	C10, C11, C12, C13, C21	619-103	C9	1/2-SHCS-CB	G13
580-116	F2	583-138	A2	601-108	C10, C11, C12, C13	619-110	C10, C12, C21, D13, D15, D17	5/8-SHCS-CB	G13
581-101	A3	583-139	A2	601-112	C10, C11, C12, C13, C21	619-111	C8, C9	3/4-SHCS-CB	G13
581-102	A3	583-140	A2	601-116	C20	619-112	B18, B19, B23, B25	01-01	G9, G10
581-103	A3	583-141	A2	601-117	C20	619-120	B14	01-02	G9, G10
581-104	A3	583-142	A2	601-129	D13, D14, D15, D16, D17	619-121	B17, B22, C8, C20	02-03	G9, G10
581-107	A3	583-143	A2	601-130	D13, D14, D15, D16, D17	619-122	B14, B22, C18	APET 0803PDFR	G22, G25
581-108	A3	583-144	A2	601-136	A9	619-124	B16, B23	APET 1604PDFR	G22, G23, G24, G25
581-109	A3	583-145	A2	601-137	A9	619-130	B23	APET 160416	G22, G23, G24, G25
581-110	A3	583-146	A2	606-103	B24	619-139	B25	APET 160431	G22, G23, G24, G25
582-101	A3	583-147	A2	606-160	C10, C12, C21, D13, D15, D17	619-145	C20	CD-0825	G9
582-102	A3	583-148	A2	606-164	B17, B22	619-147	D7	CD-0865	G9
582-103	A3	583-149	A2	606-167	B16, D7	619-151	C18	CD-0938	G9
582-104	A3	583-150	A2	606-171	B18, B19, B23, B25	619-152	B14, C19	CD-0990	G9
582-105	A3	583-151	A2	606-174	C20	619-154	B14	CD-1052	G9
582-106	A3	583-152	A2	606-190	C23, D9, E6	619-155	B18, B19, D3, D4	CD-1115	G9
582-107	A3	583-153	A2	606-192	C19	619-161	B17, C11, C13, C21, D14, D16	CD-1178	G9
582-108	A3	583-154	A2	606-193	C23, E6	619-162	C11, C13, C21, D14, D16	CD-1240	G9
582-113	A3	583-155	A2	606-197	C18	619-163	B18, B19	CD-1303	G9
582-114	A3	583-156	A2	606-200	B17	619-164	B15	CD-1360-C	G9
582-115	A3	583-157	A2	606-205	B24	619-168	A4, A5, A7, B15	CD-1460-C	G9
582-116	A3	583-158	A2	606-209	C19	619-170	C14, C15	CD-1560-C	G9
582-117	A3	583-159	A2	606-217	C7	619-173	B28, C15	CD-1660-C	G9
582-118	A3	583-160	A2	606-218	D3, D4	619-174	B29	CD-1760-C	G9
582-119	A3	583-161	A2	606-219	D3, D4	619-175	B29	CD-1860-C	G9
582-120	A3	583-162	A2	606-222	C11, C13, C21, D14, D16	619-176	B29	CD-1960-C	G9
582-125	A3	583-163	A2	606-223	C18	619-177	B29	CD-2060-C	G9
582-126	A3	583-164	A2	606-225	C19	619-178	B29	CD-2160-C	G9
582-127	A3	583-165	A2	606-228	F12	619-205	A4, A5, A7	CD-2260-C	G9
582-128	A3	583-166	A2	606-230	F12	619-382	B29	CD-2360-C	G9
582-129	A3	583-167	A2	606-231	F12	619-383	B29	CD-2460-C	G9
582-130	A3	583-168	A2	606-232	F12	619-384	B29	CD-2560-C	G9
583-106	A2	583-169	A2	606-240	F12	619-390	B16	CD-2660-C	G9
583-107	A2	583-170	A2	606-247	B16	644-101	C28, E3, E5	CD-2760-C	G9
583-108	A2	583-171	A2	606-249	A4, A5, A8			CD-2860-C	G9
583-109	A2	583-172	A2					CD-2960-C	G9
583-110	A2	583-173	A2						
583-111	A2	583-174	A2						
583-112	A2	583-175	A2						
583-113	A2	583-176	A2						
583-114	A2	583-177	A2						
583-115	A2	583-178	A2						
583-125	A2	583-179	A2						



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
CD-1350-LC	G10	DR-0515-X3N	G3	DR-1219	G4	DR-1732	G5	DR-2187-X3N	G7
CD-1500-LC	G10	DR-0531-X3N	G3	DR-1219-X3N	G4	DR-1732-X3N	G5	DR-2205	G7
CD-1650-LC	G10	DR-0551-X3N	G3	DR-1250	G4	DR-1750	G5	DR-2205-X3N	G7
CD-1800-LC	G10	DR-0563-X3N	G3	DR-1250-X3N	G4	DR-1750-X3N	G5	DR-2219	G7
CD-1950-LC	G10	DR-0591-X3N	G3	DR-1260	G4	DR-1772	G5	DR-2219-X1	G7
CD-2100-LC	G10	DR-0594-X3N	G3	DR-1260-X3N	G4	DR-1772-X3N	G5	DR-2219-X3N	G7
CD-2250-LC	G10	DR-0625-X3N	G3	DR-1281	G4	DR-1781	G5	DR-2244	G7
CD-2400-LC	G10	DR-0630-X3N	G3	DR-1281-X3N	G4	DR-1781-X3N	G5	DR-2244-X3N	G7
CD-2550-LC	G10	DR-0656-X3N	G3	DR-1299	G4	DR-1812	G5	DR-2250	G7
CD-2700-LC	G10	DR-0669-X3N	G3	DR-1299-X3N	G4	DR-1812-X3N	G5	DR-2250-X1	G7
CD-2850-LC	G10	DR-0688-X3N	G3	DR-1312	G4	DR-1844	G5	DR-2250-X3N	G7
CD-3000-LC	G10	DR-0709-X3N	G3	DR-1312-X3N	G4	DR-1844-X3N	G5	DR-2281	G7
CD-0825-XL	G10	DR-0719-X3N	G3	DR-1339	G4	DR-1850	G5	DR-2281-X1	G7
CD-0865-XL	G10	DR-0750-X3N	G3	DR-1339-X3N	G4	DR-1850-X3N	G5	DR-2281-X3N	G7
CD-0938-XL	G10	DR-0781-X3N	G3	DR-1344	G4	DR-1875	G6	DR-2312	G7
CD-0990-XL	G10	DR-0787-X3N	G3	DR-1344-X3N	G4	DR-1875-X3N	G6	DR-2312-X1	G7
CD-1052-XL	G10	DR-0813-X3N	G3	DR-1375	G4	DR-1890	G6	DR-2312-X3N	G7
CD-1115-XL	G10	DR-0827-X3N	G3	DR-1375-X3N	G4	DR-1890-X3N	G6	DR-2323	G7
CD-1178-XL	G10	DR-0844-X3N	G3	DR-1406	G4	DR-1906	G6	DR-2323-X3N	G7
CD-1240-XL	G10	DR-0866-X3N	G3	DR-1406-X3N	G4	DR-1906-X3N	G6	DR-2344	G7
CD-1303-XL	G10	DR-0875	G3	DR-1417	G4	DR-1929	G6	DR-2344-X1	G7
CM-0563-15-09	G19	DR-0875-X3N	G3	DR-1417-X3N	G4	DR-1929-X3N	G6	DR-2344-X3N	G7
CM-0563-20-09	G19	DR-0906	G3	DR-1437	G4	DR-1937	G6	DR-2362	G7
CM-0563-25-09	G19	DR-0906-X3N	G3	DR-1437X3N	G4	DR-1937-X3N	G6	DR-2362-X3N	G7
CM-0563-30-09	G19	DR-0937	G3	DR-1457	G4	DR-1969	G6	DR-2375	G7
CM-0563-35-09	G19	DR-0937-X3N	G3	DR-1457-X3N	G4	DR-1969-X3N	G6	DR-2375-X1	G7
CM-0563-45-09	G19	DR-0945	G3	DR-1469	G5	DR-2000	G6	DR-2375-X3N	G7
CM-0563-60-09	G19	DR-0945-X3N	G3	DR-1469-X3N	G5	DR-2000-X1	G6	DR-2402	G7
CM-0563-75-09	G19	DR-0969	G3	DR-1496	G5	DR-2000-X3N	G6	DR-2402-X3N	G7
CM-1000-03	G19	DR-0969-X3N	G3	DR-1496-X3N	G5	DR-2008	G6	DR-2406	G7
CM-1000-05	G19	DR-0984	G3	DR-1500	G5	DR-2008-X3N	G6	DR-2406-X1	G7
CM-1000-10	G19	DR-0984-X3N	G3	DR-1500-X3N	G5	DR-2031	G6	DR-2406-X3N	G7
CM-1000-15	G19	DR-1000	G3	DR-1531	G5	DR-2031-X1	G6	DR-2437	G7
CM-1000-20	G19	DR-1000-X3N	G3	DR-1531-X3N	G5	DR-2031-X3N	G6	DR-2437-X1	G7
CM-1000-25	G19	DR-1024	G3	DR-1535	G5	DR-2047	G6	DR-2437-X3N	G7
CM-1000-30	G19	DR-1024-X3N	G3	DR-1535-X3N	G5	DR-2047-X3N	G6	DR-2441	G7
CM-1000-35	G19	DR-1031	G3	DR-1562	G5	DR-2062	G6	DR-2441-X3N	G7
CM-1000-37.5	G19	DR-1031-X3N	G3	DR-1562-X3N	G5	DR-2062-X1	G5	DR-2469	G7
CM-1000-41	G19	DR-1062	G3	DR-1575	G5	DR-2062-X3N	G6	DR-2469-X1	G7
CM-1000-45	G19	DR-1062-X3N	G4	DR-1575-X3N	G5	DR-2087	G6	DR-2469-X3N	G7
CM-1000-50	G19	DR-1094	G4	DR-1594	G5	DR-2087-X3N	G6	DR-2480	G8
CM-1000-55	G19	DR-1094-X3N	G4	DR-1594-X3N	G5	DR-2094	G6	DR-2480-X3N	G8
CM-1000-60	G19	DR-1102	G4	DR-1614	G5	DR-2094-X1	G6	DR-2500	G8
CM-1000-70	G19	DR-1102-X3N	G4	DR-1614-X3N	G5	DR-2094-X3N	G6	DR-2500-X1	G8
CM-1000-75	G19	DR-1125	G4	DR-1625	G5	DR-2125	G6	DR-2500-X3N	G8
CM-1000-15-AL	G23	DR-1125-X3N	G4	DR-1625-X3N	G5	DR-2125-X1	G6	DR-2625	G8
CM-1000-20-AL	G23	DR-1142	G4	DR-1656	G5	DR-2125-X3N	G6	DR-2625-X1	G8
CM-1000-30-AL	G23	DR-1142-X3N	G4	DR-1656-X3N	G5	DR-2156	G6	DR-2750	G8
CM-1000-45-AL	G23	DR-1156	G4	DR-1687	G5	DR-2156-X1	G6	DR-2750-X1	G8
CM-1000-60-AL	G23	DR-1156-X3N	G4	DR-1687-X3N	G5	DR-2156-X3N	G6	DR-2875	G8
CM-1000-75-AL	G23	DR-1181	G4	DR-1693	G5	DR-2163	G6	DR-2875-X1	G8
CS-82-177	G14	DR-1181-X3N	G4	DR-1693-X3N	G5	DR-2165-X3N	G6	DR-3000	G8
CS-82-362	G14	DR-1187	G4	DR-1719	G5	DR-2187	G6	DR-3000-X1	G8
CS-82-612	G14	DR-1187-X3N	G4	DR-1719-X3N	G5	DR-2187-X1	G6	DR-3125	G8



PRODUCT/PAGE INDEX

Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number	Part Number	Page Number
DR-3125-X1	G8	EM 1500	G17	SCR-01	G3, G14, G16, G17, G19, G22	SDR-0719	G12	WCMX 040204-M1A	G3, G11
DR-3250	G8	EM 1500-3F	G17			SDR-0734	G12	WCMX 050308-M1	G3, G4, G5, G6, G9, G10, G11
DR-3250-X1	G8	EM 1000-2.5	G18	SCR-02	G14, G22, G23, G24	SDR-0748	G12	WCMX 050308-M1A	G3, G4, G5, G6, G9, G10, G11
DR-3375	G8	EM 1000-3.5	G18			SDR-0750	G12		
DR-3375-X1	G8	EM 1250-2.5	G18	SCR-03	G3, G4, G5, G6, G9, G10	SDR-0766	G12		
DR-3500	G8	EM 1250-1500-LE	G18			SDR-0781	G12	WCMX 06T308-M1	G4, G5, G6, G7, G8, G9, G10, G11
DR-3500-X1	G8	EM 1500-2000-LE	G18	SCR-04	G16, G19	SDR-0787	G12		
DR-3625	G8	EM 2000-2775-LE	G18	SCR-05	G12, G13	SDR-0797	G12	WCMX 06T308-M1A	G4, G5, G6, G7, G8, G9, G10, G11
DR-3625-X1	G8	EM-0750-AL	G22	SCR-07	G3, G12	SDR-0813	G12		
DR-3750	G8	EM-0875-AL	G22	SCR-16	G17, G18, G19	SDR-0828	G12	XPMT 090204	G16, G17, G19, G21
DR-3750-X1	G8	EM-1000-AL	G22	SCR-30	G4, G5, G6, G7, G8, G9, G10, G17, G18, G19, G20	SDR-0844	G12		
DR-3875	G8	EM-1250-AL	G22			T6	G3, G12	XPMT 090208	G16, G17, G19, G21
DR-3875-X1	G8	EM-1500-AL	G22			T7	G3, G12, G13, G14, G16, G17, G19, G22	XPMT 090216	G16, G17, G19, G21
DR-4000	G8	EM-2000-AL	G22	SDR-0484	G12				
DR-4000-X1	G8	EM-1000-2.75-AL	G22	SDR-0492	G12				
EM 0437-09	G16	EM-1000-3.75-AL	G22	SDR-0500	G12	T9	G3, G4, G5, G6, G9, G10	XPMT 090224	G16, G17, G19, G21
EM 0500-09	G16	EM-1250-2.125-AL	G22	SDR-0512	G12				
EM 0562-09	G16	FM 1500-6 RH	G20	SDR-0516	G12	T10	G4, G5, G6, G7, G8, G9, G10, G17, G18, G19, G20	XPMT 090231	G16, G17, G19, G21
EM 0625-09	G16	FM 2000-30 RH	G20	SDR-0531	G12				
EM 0688-09	G16	FM 2000-30 LH	G20	SDR-0547	G12			XPMT 15T304	G17, G18, G19, G20, G21
EM 0750-09	G16	FM 2000-90 RH	G20	SDR-0551	G12	T15	G14, G22, G23, G24	XPMT 15T308	G17, G18, G19, G20, G21
EM 0875-09	G16	FM 3000-30 RH	G20	SDR-0563	G12				
EM 0625	G17	FM 3000-30 LH	G20	SDR-0578	G12	TCMT 1.2(1.2)1	G15		
EM 0688	G17	FM 3000-90 RH	G20	SDR-0591	G12	TCMT 1.2(1.2)2	G12, G15	XPMT 15T316	G17, G18, G19, G20, G21
EM 0750	G17	FM-AL-2500-90-3	G24	SDR-0594	G12	TCMT 1.8(1.5)1	G13, G15		
EM 0813	G17	FM-3000-90-AL	G24	SDR-0609	G12	TCMT 1.8(1.5)2	G12, G15	XPMT 15T324	G17, G18, G19, G20, G21
EM 0875	G17	FM-4000-90-AL	G24	SDR-0625	G12	TCMT 2(1.5)1	G14, G15		
EM 0938	G17	FM-4000-90-AL-125	G24	SDR-0630	G12	TCMT 2(1.5)2	G14, G15	XPMT 15T331	G17, G18, G19, G20, G21
EM 1000	G17	FM-AL-4000-90-5	G24	SDR-0641	G12	TCMT 3(2.5)1	G14, G15		
EM 1000-09-3F	G17	FM-5000-90-AL	G24	SDR-0656	G12	TCMT 3(2.5)2	G14, G15	XPMT 15T348	G17, G18, G19, G20, G21
EM 1000-1005	G17	M6-SHCS-CB	G13	SDR-0669	G12	WCGT 050308-M1	G3, G4, G5, G6, G9, G10, G11	XPMT 15T364	G17, G18, G19, G20, G21
EM 1125	G17	M8-SHCS-CB	G13	SDR-0672	G12				
EM 1250	G17	M10-SHCS-CB	G13	SDR-0688	G12	WCGT 06T308-M1	G4, G5, G6, G7, G8, G9, G10, G11		
EM 1250-3F	G17	M12-SHCS-CB	G13	SDR-0703	G12				
EM 1375	G17	M16-SHCS-CB	G13	SDR-0709	G12	WCMX S30204-M1A	G3, G11		



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