



FEATURES/DESCRIPTION	APPLICATION	FEATURES																																							
PYSTL Equal Index End Mill - Premium sub-micron grade carbide substrate for wear resistance - Ideal tool for Titanium, stainless and other gummy materials - Well suited for slotting and profiling milling operations - Specialized edge honing - SafeLock® shank available upon request		<table border="1"> <tr> <td>CARBIDE</td> <td>38°</td> </tr> <tr> <td>7FL</td> <td>RAD</td> </tr> <tr> <td>SQ</td> <td>h6</td> </tr> <tr> <td>P187</td> <td>FX3</td> </tr> </table>	CARBIDE	38°	7FL	RAD	SQ	h6	P187	FX3																															
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STEEL			STAINLESS		CAST IRON		NON-FERROUS		HRS		HARDENED STEEL																														
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2																													
●	●	○	○	●	○	○				●																															

Series 2215 738 | 7FL | Square and Radius | PYSTL

Diameter(D ₁)	LOC(L ₁)	OAL(L)	Shank(D)	Radius(R)	EDP
3/8	1/2	2	3/8	-	312575
3/8	1/2	2	3/8	0.030	312577
3/8	1/2	2	3/8	0.060	312581
3/8	1	2-1/2	3/8	-	312585
3/8	1	2-1/2	3/8	0.030	312589
3/8	1	2-1/2	3/8	0.060	312591
3/8	1-1/4	3	3/8	-	312595
3/8	1-1/4	3	3/8	0.030	312597
3/8	1-1/4	3	3/8	0.060	312599
3/8	1-1/2	4	3/8	-	312603
3/8	1-1/2	4	3/8	0.030	312606
3/8	1-1/2	4	3/8	0.060	312608
3/8	2-1/2	6	3/8	-	312610
3/8	2-1/2	6	3/8	0.030	312612
3/8	2-1/2	6	3/8	0.060	312614
1/2	3/4	2-1/2	1/2	-	312616
1/2	3/4	2-1/2	1/2	0.030	312620
1/2	3/4	2-1/2	1/2	0.060	312624
1/2	3/4	2-1/2	1/2	0.090	312628
1/2	1-1/4	3	1/2	-	312632
1/2	1-1/4	3	1/2	0.030	312636
1/2	1-1/4	3	1/2	0.060	312638
1/2	1-1/4	3	1/2	0.090	312642
1/2	2	4	1/2	-	312645
1/2	2	4	1/2	0.030	312649
1/2	2	4	1/2	0.060	312652
1/2	2	4	1/2	0.090	312654
1/2	3-1/4	6	1/2	-	312657
1/2	3-1/4	6	1/2	0.030	312659
1/2	3-1/4	6	1/2	0.060	312662
1/2	3-1/4	6	1/2	0.090	312664
5/8	3/4	3	5/8	-	312666
5/8	3/4	3	5/8	0.030	312669
5/8	3/4	3	5/8	0.060	312672
5/8	3/4	3	5/8	0.090	312674
5/8	3/4	3	5/8	0.120	312676
5/8	1-5/8	3-1/2	5/8	-	312679
5/8	1-5/8	3-1/2	5/8	0.030	312681
5/8	1-5/8	3-1/2	5/8	0.060	312684
5/8	1-5/8	3-1/2	5/8	0.090	312688
5/8	1-5/8	3-1/2	5/8	0.120	312692
5/8	2	5	5/8	-	312695
5/8	2	5	5/8	0.030	312697
5/8	2	5	5/8	0.060	312699
5/8	2	5	5/8	0.090	312701

*bold numbers are EDPs for ordering

ADVANCED PERFORMANCE

Solid Carbide End Mills For Stainless, Titanium, Steel And Other Ferrous Alloys



Series 2215 738 | 7FL | Square and Radius | PYSTL

Diameter(D ₁)	LOC(L ₁)	OAL(L)	Shank(D)	Radius(R)	EDP
5/8	2	5	5/8	0.120	312705
5/8	3-1/4	6	5/8	-	312708
5/8	3-1/4	6	5/8	0.030	312710
5/8	3-1/4	6	5/8	0.060	312714
5/8	3-1/4	6	5/8	0.090	312718
5/8	3-1/4	6	5/8	0.120	312720
3/4	1	3	3/4	-	312724
3/4	1	3	3/4	0.030	312726
3/4	1	3	3/4	0.060	312728
3/4	1	3	3/4	0.090	312730
3/4	1	3	3/4	0.120	312732
3/4	1-5/8	4	3/4	-	312736
3/4	1-5/8	4	3/4	0.030	312739
3/4	1-5/8	4	3/4	0.060	312742
3/4	1-5/8	4	3/4	0.090	312744
3/4	1-5/8	4	3/4	0.120	312746
3/4	2-1/4	5	3/4	-	312749
3/4	2-1/4	5	3/4	0.030	312753
3/4	2-1/4	5	3/4	0.060	312757
3/4	2-1/4	5	3/4	0.090	312759
3/4	2-1/4	5	3/4	0.120	312761
3/4	3-1/4	6	3/4	-	312764
3/4	3-1/4	6	3/4	0.030	312766
3/4	3-1/4	6	3/4	0.060	312770
3/4	3-1/4	6	3/4	0.090	312773
3/4	3-1/4	6	3/4	0.120	312777
1	1-1/4	4	1	-	312781
1	1-1/4	4	1	0.030	312783
1	1-1/4	4	1	0.060	312787
1	1-1/4	4	1	0.090	312791
1	1-1/4	4	1	0.120	312793
1	2	5	1	-	312795
1	2	5	1	0.030	312798
1	2	5	1	0.060	312800
1	2	5	1	0.090	312802
1	2	5	1	0.120	312804
1	3-1/4	6	1	-	312807
1	3-1/4	6	1	0.030	312809
1	3-1/4	6	1	0.060	312811
1	3-1/4	6	1	0.090	312815
1	3-1/4	6	1	0.120	312818
1	4-1/8	7	1	-	312821
1	4-1/8	7	1	0.030	312824
1	4-1/8	7	1	0.060	312828
1	4-1/8	7	1	0.090	312830
1	4-1/8	7	1	0.120	312834
1-1/4	2	4-1/2	1-1/4	-	312836
1-1/4	2	4-1/2	1-1/4	0.030	312839
1-1/4	2	4-1/2	1-1/4	0.060	312842
1-1/4	2	4-1/2	1-1/4	0.090	312846
1-1/4	2	4-1/2	1-1/4	0.120	312848
1-1/4	2-5/8	6	1-1/4	-	312851
1-1/4	2-5/8	6	1-1/4	0.030	312855
1-1/4	2-5/8	6	1-1/4	0.060	312858
1-1/4	2-5/8	6	1-1/4	0.090	312861
1-1/4	2-5/8	6	1-1/4	0.120	312863
1-1/4	3-1/4	6	1-1/4	-	312867
1-1/4	3-1/4	6	1-1/4	0.030	312869
1-1/4	3-1/4	6	1-1/4	0.060	312871
1-1/4	3-1/4	6	1-1/4	0.090	312874
1-1/4	3-1/4	6	1-1/4	0.120	312877
1-1/4	4-1/8	7-1/2	1-1/4	-	312880
1-1/4	4-1/8	7-1/2	1-1/4	0.030	312884
1-1/4	4-1/8	7-1/2	1-1/4	0.060	312887
1-1/4	4-1/8	7-1/2	1-1/4	0.090	312889
1-1/4	4-1/8	7-1/2	1-1/4	0.120	312893

*bold numbers are EDPs for ordering

INTRO

MILLING

SPECIALTY

HOLEMAKING

THREADING

INSERTS

Series 2215

738 | 7 FL | Square & Radius | PYSTL

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4	
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	220	6723 24	3362 24		2241 28		1681 30		1345 28		1121 26	
		1.25 x D	.3 x D	264	8068 34	4034 34		2689 41		2017 43		1614 41		1345 38	
		1.5 X D	.1 x D	343	10488 73	5244 73		3496 88		2622 93		2098 89		1748 81	
	Alloy Steel 4140, 8620	1 x D	1 x D	180	5501 37	2750 27		1834 22		1375 23		1100 22		917 20	
		1.25 x D	.3 x D	225	6876 55	3438 41		2292 33		1719 35		1375 33		1146 30	
		1.5 X D	.1 x D	270	8251 110	4126 82		2750 66		2063 69		1650 66		1375 61	
	Tool Steel A2 ,A3, D2, H11, H13	1 x D	.5 x D	180	5501 18	2750 18		1834 22		1375 23		1100 22		917 20	
		1.25 x D	.3 x D	225	6876 27	3438 27		2292 33		1719 35		1375 33		1146 30	
		1.5 X D	.1 x D	270	8251 55	4126 55		2750 66		2063 69		1650 66		1375 61	
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	140	4278 12	2139 12		1426 15		1070 15		856 15		713 14	
		1.25 x D	.3 x D	185	5654 19	2827 19		1885 23		1413 24		1131 23		942 21	
		1.5 x D	.1 x D	230	7039 40	3519 40		2346 48		1760 51		1408 49		1173 44	
	Precipitation SS 15-5, 16-6, 17-4, 17-5	0.5	1 x D	115	3514 10	1757 10		1171 11		879 12		703 12		586 11	
		1.25 x D	.3 x D	180	5501 18	2750 18		1834 21		1375 23		1100 22		917 20	
		1.5 x D	.1 x D	250	7640 41	3820 41		2547 50		1910 52		1528 50		1273 46	
K	Cast Iron - Grey, GG-10 to GG-40	1 x D	1 x D	100	3056 10	1528 10		1019 12		764 12		611 12		509 11	
		1.25 x D	.3 x D	125	3820 14	1910 14		1273 17		955 18		764 18		637 16	
		1.5 X D	.1 x D	163	4966 31	2483 31		1655 38		1242 40		993 38		828 35	
	Cast Iron - Ductile GGG-40, to GGG-70	.75 x D	1 x D	155	4737 14	2368 14		1579 17		1184 18		947 17		789 16	
		1.25 x D	.3 x D	180	5501 20	2750 20		1834 24		1375 25		1100 24		917 22	
		1.5 x D	.1 x D	216	6601 40	3300 40		2200 48		1650 50		1320 48		1100 44	
S	High Temp Alloys Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.25 x D	.4 x D	70	2139 6	1070 6		713 7		535 7		428 7		357 6	
		1.25 x D	.2 x D	80	2445 8	1222 8		815 9		611 10		489 9		407 8	
		1.5 x D	.07 x D	125	3820 20	1910 20		1273 24		955 25		764 24		637 22	
	Titanium Alloy Ti-6Al4V Grades (5-38)	0.5	1 x D	180	5501 13	2750 13		1834 16		1375 17		1100 16		917 15	
		1.25 x D	.3 x D	225	6876 20	3438 20		2292 24		1719 25		1375 24		1146 22	
		1.5 x D	.1 x D	360	11002 54	5501 54		3667 65		2750 68		2200 65		1834 60	