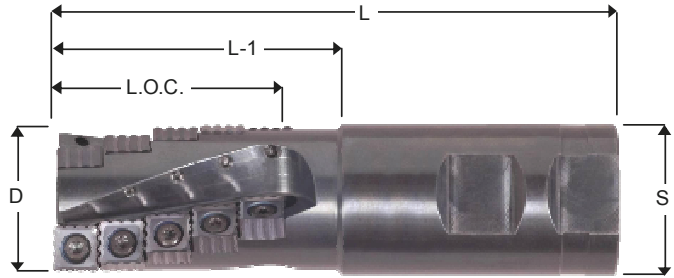


# SERATORS

## Long Edge Roughing Mills

**IMPORTANT**  
 SERATORS ARE TO BE RUN AS HALF  
 THE NUMBER OF FLUTES EFFECTIVE  
 HIGH PRESSURE FLOOD COOLANT OR AIR BLAST  
 REQUIRED TO DISPERSE CHIP AND COOL THE TOOL.  
 RECUTTING CHIPS WILL CAUSE EARLY INSERT FAILURE.

**.985 - 1.485 Diameter**



Tool #	D	Flutes	Inserts	L	L-1	L.O.C.	S	Screw	Wrench	Inserts
S-100S	.985	2-1 Eff.	4	3.125	1.130	.780	.750			
S-100M	.985	2-1 Eff.	6	3.625	1.380	1.125	1.000			
S-100	.985	2-1 Eff.	8	4.000	1.750	1.500	1.000			
S-125S	1.235	3-1.5 Eff.	9	3.750	1.500	1.125	1.000			SNMC-333B
S-125	1.235	3-1.5 Eff.	15	4.625	2.380	1.900	1.250	538T	T-10	SNGC-333H SNMC-332P
S-125L	1.235	2-1 Eff.	16	5.625	3.380	3.062	1.250			
S-150S	1.485	3-1.5 Eff.	9	3.875	1.630	1.125	1.000			
S-150	1.485	3-1.5 Eff.	18	4.875	2.500	2.250	1.250			
S-150L	1.485	3-1.5 Eff.	33	7.250	4.630	4.200	1.500			

### Speed and Feed Info.

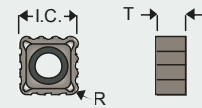
Material	S.F.M.	I.P.T.
<b>Mild &amp; Low Carbon Steel</b> Ex. 1018, 1020, 1117, 1141, 12L14	600-1200	.002-.006
<b>High Carbon &amp; Alloy Steel</b> Ex. 1045, 4140, 4340, 52100, 8620	500-800	.002-.004
<b>Lower Carbon Tool Steel</b> Ex. P-20, H-13, S-7	400-700	.002-.004
<b>Tool Steel</b> Ex. A-2, A-6, D-2, M-2	300-600	.002-.004
<b>Stainless Steel</b> Ex. 304, 316, 420, 15-5PH, 17-4PH	300-600	.002-.004
<b>Iron</b> Ex. Cast, Ductile, Nodular	600-1000	.003-.006
<b>Nickel &amp; Titanium Alloy</b> Ex. Inconel, Hastelloy, Ti-6AL-4V	100-180	.001-.003

Tool #	Price
S-100S	\$198.00
S-100M	\$275.00
S-100	\$343.00
S-125S	\$314.00
S-125	\$487.00
S-125L	\$530.00
S-150S	\$334.00
S-150	\$582.00
S-150L	\$850.00

**K-TOOL, INC.**

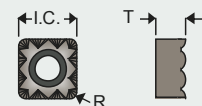
**Hemly**  
TOOL SUPPLY INC.

#### Positive Top Insert



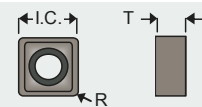
Insert #	I.C.	T	R	Grade
SNMC-333B	.375	.187	.047	X20

#### Positive Top Insert



Insert #	I.C.	T	R	Grade
SNGC-333H	.375	.187	.047	X20

#### Positive Top Insert



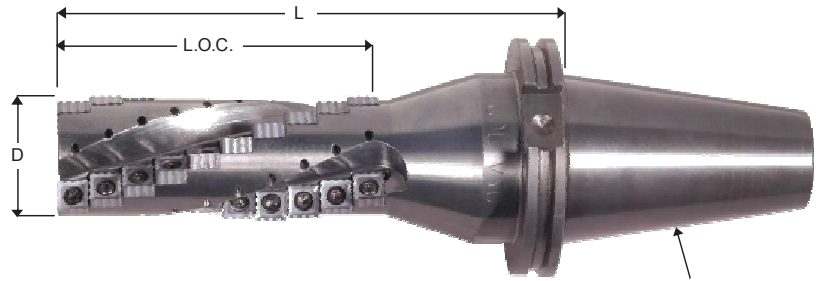
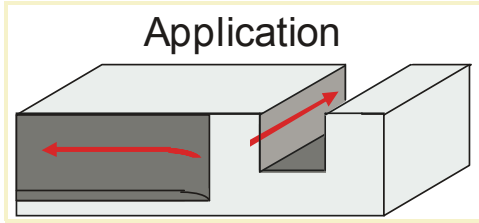
Insert #	I.C.	T	R	Grade
SNMC-332P	.375	.187	.031	X20

Insert #	Price
SNMC-333B	\$8.20
SNGC-333H	\$10.20
SNMC-332P	\$8.20

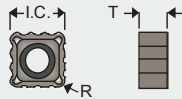
# INTEGRAL SERATORS

**1.980 - 2.980  
Diameter**

## Long Edge Roughing Mills

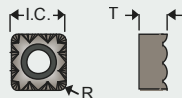


### Positive Top Insert



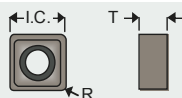
Insert #	I.C.	T	R	Grade
SNMC-444B	.500	.250	.062	X20

### Positive Top Insert



Insert #	I.C.	T	R	Grade
SNGC-444H	.500	.250	.062	X20

### Positive Top Insert



Insert #	I.C.	T	R	Grades
SNMC-443P	.500	.250	.047	A9M X20

Insert #	Price
SNMC-444B	\$11.00
SNGC-444H	\$11.20
SNMC-443P	\$11.00

### IMPORTANT

**SERATORS ARE TO BE RUN AS HALF THE NUMBER OF FLUTES EFFECTIVE**

HIGH PRESSURE FLOOD COOLANT OR AIR BLAST REQUIRED TO DISPERSE CHIP AND COOL THE TOOL.

RECUTTING CHIPS WILL CAUSE EARLY INSERT FAILURE.

Cat #50 Taper

## Speed and Feed Info.

Material	S.F.M.	I.P.T.
<b>Mild &amp; Low Carbon Steel</b> Ex. 1018, 1020, 1117, 1141, 12L14	600-1200	.002-.006
<b>High Carbon &amp; Alloy Steel</b> Ex. 1045, 4140, 4340, 52100, 8620	500-800	.002-.004
<b>Lower Carbon Tool Steel</b> Ex. P-20, H-13, S-7	400-700	.002-.004
<b>Tool Steel</b> Ex. A-2, A-6, D-2, M-2	300-600	.002-.004
<b>Stainless Steel</b> Ex. 304, 316, 420, 15-5PH, 17-4PH	300-600	.002-.004
<b>Iron</b> Ex. Cast, Ductile, Nodular	600-1000	.003-.006
<b>Nickel &amp; Titanium Alloy</b> Ex. Inconel, Hastelloy, Ti-6AL-4V	100-180	.001-.003

Tool #	D	Flutes	Inserts	L	L.O.C.	Screw	Wrench	Inserts
V50-203	1.980	4-2 Eff.	28	6.000	3.600			
V50-205	1.980	3-1.5 Eff.	30	8.000	5.100			
V50-253	2.480	4-2 Eff.	28	6.000	3.600	838T	T-20	SNMC-444B
V50-256	2.480	4-2 Eff.	48	8.000	6.100			SNGC-444H
V50-303	2.980	4-2 Eff.	28	6.000	3.600			SNMC-443P
V50-306	2.980	4-2 Eff.	48	8.000	6.100			

Tool #	Price
V50-203	\$857.00
V50-205	\$1,025.00
V50-253	\$1,041.00
V50-256	\$1,219.00
V50-303	\$1,292.00
V50-306	\$1,467.00

**Hemly**  
TOOL SUPPLY INC.

HEADQUARTERS  
HEMPLY TOOL SUPPLY INC.  
9700 Madison Road  
Montville, OH 44064  
1-800-445-1068  
Tel: 440-968-3228  
Fax: 440-968-3611

www.hemlytool.com  
e-mail: sales@hemlytool.com