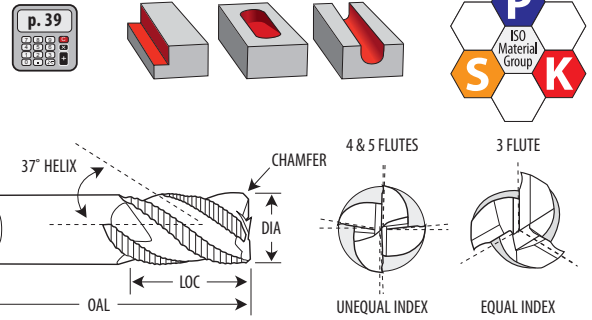
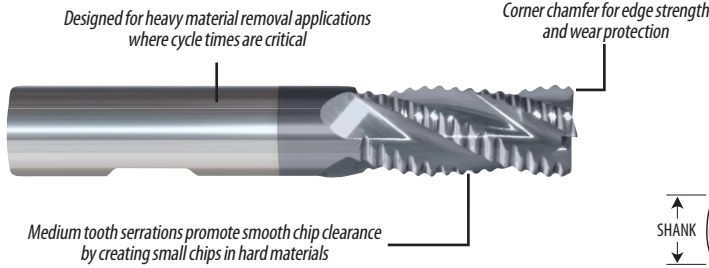


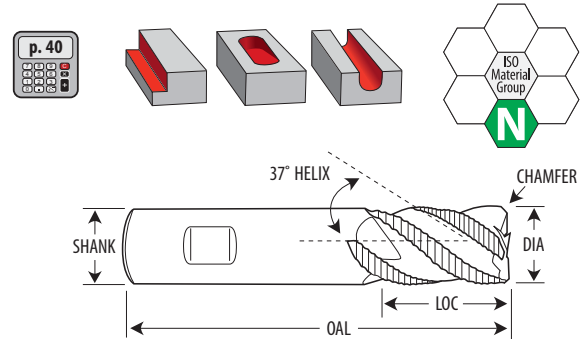
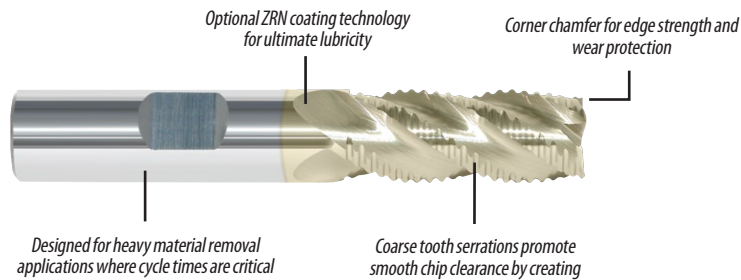
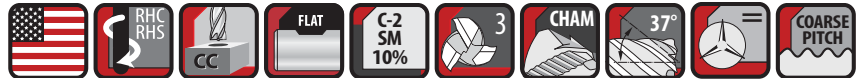
# AGGRESSOR<sup>M</sup>



DIA TOLERANCE: +0.000 / -0.002" SHANK TOLERANCE: +0.0000 / -0.0004"

DIA	DEC IN	FLUTES	LOC	SHANK	OAL	LENGTH	CHAMFER	BRIGHT	ALTiCrN
3/16	0.1875	3	5/8	3/16	2	Regular	.020	256-187625	256-187628
1/4	0.2500	4	3/4	1/4	2-1/2	Regular	.020	256-250750	256-250753
5/16	0.3125	4	3/4	5/16	2-1/2	Regular	.020	256-312812	256-312815
3/8	0.3750	4	7/8	3/8	2-1/2	Regular	.020	256-375875	256-375878
7/16	0.4375	4	1	7/16	2-3/4	Regular	.025	256-437100	256-437103
1/2	0.5000	4	1-1/4	1/2	3	Regular	.025	256-500100	256-500103
5/8	0.6250	4	1-1/4	5/8	3-1/2	Regular	.025	256-625114	256-625117
3/4	0.7500	4	1-5/8	3/4	4	Regular	.025	256-750112	256-750115
1	1.0000	5	1-3/4	1	4	Regular	.025	256-100112	256-100115

# AGGRESSOR<sup>C</sup>



DIA TOLERANCE: +0.000 / -0.002" SHANK TOLERANCE: +0.0000 / -0.0004"

DIA	DEC IN	FLUTES	LOC	SHANK	OAL	LENGTH	CHAMFER	BRIGHT	ZRN
3/16	0.1875	3	3/4	3/16	2	Regular	0.020	255-050187	255-050187D
1/4	0.2500	3	3/4	1/4	2-1/2	Regular	0.020	255-050250	255-050250D
5/16	0.3125	3	7/8	5/16	2-1/2	Regular	0.020	255-050312	255-050312D
3/8	0.3750	3	1	3/8	2-1/2	Regular	0.020	255-050375	255-050375D
1/2	0.5000	3	1-1/4	1/2	3	Regular	0.025	255-050500	255-050500D
5/8	0.6250	3	1-1/4	5/8	3-1/2	Regular	0.025	255-050625	255-050625D
3/4	0.7500	3	1-5/8	3/4	4	Regular	0.025	255-050750	255-050750D
1	1.0000	3	1-3/4	1	4	Regular	0.025	255-051000	255-051000D



**PROFILING**

*Surface Feet Per Minute (SFM)*  
*Radial Depth of Cut (RDOC)*


*Inches Per Tooth (IPT)*

Workpiece Material Group	SFM based on RDOC				IPT* (BASELINE)						
	Cutting Diameter Engaged				Cutting Diameter						
	10%	20%	30%	50%	3/16 <sup>†</sup>	1/4 <sup>†</sup>	5/16	3/8	1/2	5/8	3/4
Aluminum /Aluminum Alloys < 10% Si	2000	1800	1200	900	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
Aluminum /Aluminum Alloys > 10% Si	1500	1200	1000	800	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
<b>Non-Ferrous</b>  Brass	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
Cu/Cu Alloys / Magnesium	1000	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015
Plastics	900	800	600	500	0.0037	0.005	0.0062	0.0075	0.01	0.0125	0.015

**\*CHIP THINNING Adjustments**

RDOC	Increase IPT
50%	None
30%	2x
20%	3.1x
10%	3.8x


**†1/4" AND SMALLER DIAMETERS: Use caution when Profiling more than 50% or Slotting more than 25%**



**SLOTING**

*Surface Feet Per Minute (SFM)*  
*Radial Depth of Cut (RDOC)*

*Inches Per Tooth (IPT)*

Workpiece Material Group	SFM			IPT							
	Cutting Diameter Engaged			Cutting Diameter							
	25%	50%	100%	3/16 <sup>†</sup>	1/4 <sup>†</sup>	5/16	3/8	1/2	5/8	3/4	1
Aluminum /Aluminum Alloys < 10% Si	2000	1500	1000	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
Aluminum /Aluminum Alloys > 10% Si	1500	1200	800	0.0018	0.0025	0.0031	0.0037	0.0050	0.0065	0.0075	0.0100
<b>Non-Ferrous</b>  Brass	600	500	400	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
Cu/Cu Alloys / Magnesium	500	400	300	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120
Plastics	1200	1000	800	0.0025	0.0032	0.0040	0.0050	0.0065	0.0075	0.0100	0.0120