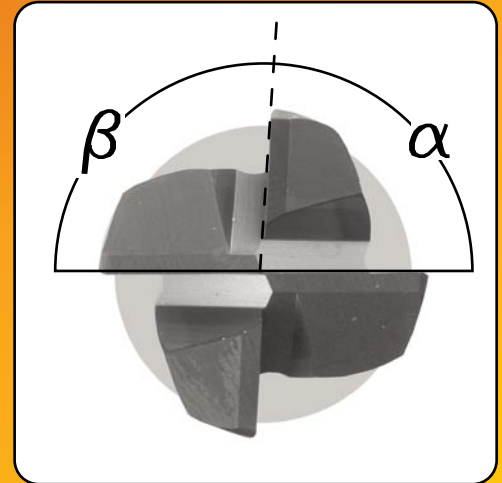


The Dragon



$$\beta \neq \alpha$$

The Dragon Features:

Different offset angles break up the harmonics and change the frequency of the cutting action. This provides you with chatter free milling during high speed machining applications.

Certified Tool and Grinding uses only the best sub-micron grade carbide, combined with a TiAlN coating. This allows the Dragon to withstand extreme pressure and heat associated with high material removal rates.

The Dragon's larger core diameter withstands the tangential forces applied during cutting, allowing large radial and axial depth of cut.

Fast, Efficient, and Accurate



4475 Infirmary Rd. Dayton, OH 45449

(937) 865-5934 | fax: (937) 865-9876 | (800) 466-6129

info@certifiedtoolandgrinding.com

The Dragon

<u>Profiling</u>		
Material	SFM	IPT*
Low carbon steels	500 - 600	.001 - .003
Med carbon steels	400 - 500	.001 - .003
Med carbon alloy steel	350 - 450	.001 - .003
High carbon alloy steel	200 - 300	.001 - .003
Tool steel	150 - 250	.001 - .003
Cast iron - gray	500 - 600	.001 - .003
Cast iron - ductile	250 - 350	.001 - .003
Cast iron - malleable	150 - 250	.001 - .003
Stainless - 400 series	350 - 450	.001 - .003
Stainless - PH series	220 - 300	.001 - .003
Stellite	40 - 70	.001 - .003
Tool steel - 55 - 60 Rc	100 - 200	.001 - .003

<u>Slotting</u>		
Material	SFM	IPT*
Low carbon steels	400 - 500	.001 - .003
Med carbon steels	300 - 400	.001 - .003
Med carbon alloy steel	250 - 350	.001 - .003
High carbon alloy steel	150 - 250	.001 - .003
Tool steel	100 - 200	.001 - .003
Cast iron - gray	450 - 550	.001 - .003
Cast iron - ductile	200 - 300	.001 - .003
Cast iron - malleable	100 - 200	.001 - .003
Stainless - 400 series	300 - 400	.001 - .003
Stainless - PH series	150 - 250	.001 - .003
Stellite	30 - 60	.001 - .003
Tool steel - 55 - 60 Rc	80 - 100	.001 - .003

* < .375 Diameter tool - .001 IPT .375 - .625 Diameter tool - .002 IPT > .625 Diameter tool - .003 IPT

Flute Diameter	Flute Length	Overall Length	Corner Radius	Part Number
¼	5/8	2-1/2	.015	54220
5/16	13/16	2-1/2	.015	54260
3/8	7/8	2-1/2	.020	54300
7/16	1	2-3/4	.020	54340
½	1	3	.025	54380
9/16	1-1/4	3	.020	54390
5/8	1-1/4	3-1/2	.030	54400
¾	1-1/2	4	.030	54420
7/8	1-1/2	4	.040	54430
1	1-1/2	4	.040	54440

****BASED ON OPTIMUM CONDITIONS**

Depending on rigidity of machine and fixture, coolant supply, machine power, free shank length etc. you would adjust to the low side of the SFM

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