

ALUMINUM

DEXCO
Tools

ALUMINUM

HIGH PERFORMANCE 2 FLUTES



DIA.	L.O.C.	O.A.L.	EDP	Square	R.015	R.031	R.063	R.093	R.125	R.187	R.250	FULL
1/4"	1/2	3	OP23-	21R000	21R015	21R030	21R060	21R090	-	-	-	21R125
	3/4	3	OP23-	22R000	22R015	22R030	22R060	22R090	-	-	-	22R125
	1	3	OP23-	23R000	23R015	23R030	23R060	23R090	-	-	-	23R125
3/8"	1/2	3	OP23-	31R000	31R015	31R030	31R060	31R090	31R125	-	-	31R190
	3/4	3	OP23-	32R000	32R015	32R030	32R060	32R090	32R125	-	-	32R190
	1	3	OP23-	33R000	33R015	33R030	33R060	33R090	33R125	-	-	33R190
1/2"	1/2	3	OP23-	51R000	51R015	51R030	51R060	51R090	51R125	51R190	-	51R250
	3/4	3	OP23-	52R000	52R015	52R030	52R060	52R090	52R125	52R190	-	52R250
	1	3	OP23-	53R000	53R015	53R030	53R060	53R090	53R125	53R190	-	53R250
	1-1/2	4	OP23-	54R000	54R015	54R030	54R060	54R090	54R125	54R190	-	54R250
	2	4	OP23-	55R000	55R015	55R030	55R060	55R090	55R125	55R190	-	55R250
5/8"	3/4	4	OP23-	61R000	61R015	61R030	61R060	61R090	61R125	61R190	61R250	61R312
	1	4	OP23-	62R000	62R015	62R030	62R060	62R090	62R125	62R190	62R250	62R312
3/4"	3/4	4	OP23-	71R000	71R015	71R030	71R060	71R090	71R125	71R190	71R250	71R375
	1	4	OP23-	72R000	72R015	72R030	72R060	72R090	72R125	72R190	72R250	72R375
	1-1/2	4	OP23-	73R000	73R015	73R030	73R060	73R090	73R125	73R190	73R250	73R375
1"	1	4	OP23-	91R000	91R015	91R030	91R060	91R090	91R125	91R190	91R250	91R500
	1-1/2	4	OP23-	92R000	92R015	92R030	92R060	92R090	92R125	92R190	92R250	92R500
	2	5	OP23-	93R000	93R015	93R030	93R060	93R090	93R125	93R190	93R250	93R500

**To make an order, please use EDP number and add the model number
EX: OP23-21R030**

ALUMINUM

HIGH PERFORMANCE 3 FLUTES



DIA.	L.O.C.	O.A.L.	EDP	Square	R.015	R.031	R.063	R.093	R.125	R.187	R.250	FULL
1/4"	1/2	3	OP25-	21R000	21R015	21R030	21R060	21R090	-	-	-	21R125
	3/4	3	OP25-	22R000	22R015	22R030	22R060	22R090	-	-	-	22R125
	1	3	OP25-	23R000	23R015	23R030	23R060	23R090	-	-	-	23R125
3/8"	1/2	3	OP25-	31R000	31R015	31R030	31R060	31R090	31R125	-	-	31R190
	3/4	3	OP25-	32R000	32R015	32R030	32R060	32R090	32R125	-	-	32R190
	1	3	OP25-	33R000	33R015	33R030	33R060	33R090	33R125	-	-	33R190
1/2"	1/2	3	OP25-	51R000	51R015	51R030	51R060	51R090	51R125	51R190	-	51R250
	3/4	3	OP25-	52R000	52R015	52R030	52R060	52R090	52R125	52R190	-	52R250
	1	3	OP25-	53R000	53R015	53R030	53R060	53R090	53R125	53R190	-	53R250
	1-1/2	4	OP25-	54R000	54R015	54R030	54R060	54R090	54R125	54R190	-	54R250
	2	4	OP25-	55R000	55R015	55R030	55R060	55R090	55R125	55R190	-	55R250
5/8"	3/4	4	OP25-	61R000	61R015	61R030	61R060	61R090	61R125	61R190	61R250	61R312
	1	4	OP25-	62R000	62R015	62R030	62R060	62R090	62R125	62R190	62R250	62R312
3/4"	3/4	4	OP25-	71R000	71R015	71R030	71R060	71R090	71R125	71R190	71R250	71R375
	1	4	OP25-	72R000	72R015	72R030	72R060	72R090	72R125	72R190	72R250	72R375
	1-1/2	4	OP25-	73R000	73R015	73R030	73R060	73R090	73R125	73R190	73R250	73R375
1"	1	4	OP25-	91R000	91R015	91R030	91R060	91R090	91R125	91R190	91R250	91R500
	1-1/2	4	OP25-	92R000	92R015	92R030	92R060	92R090	92R125	92R190	92R250	92R500
	2	5	OP25-	93R000	93R015	93R030	93R060	93R090	93R125	93R190	93R250	93R500

**To make an order, please use EDP number and add the model number
EX: OP25-21R060**

ALUMINUM

HIGH PERFORMANCE ROUGHER 3 FLUTES



DIA.	L.O.C.	O.A.L.	EDP	Square	R.015	R.031	R.063	R.093	R.125	R.187	R.250	FULL
1/4"	1/2	3	OP27-	21R000	21R015	21R030	21R060	21R090	-	-	-	21R125
	3/4	3	OP27-	22R000	22R015	22R030	22R060	22R090	-	-	-	22R125
	1	3	OP27-	23R000	23R015	23R030	23R060	23R090	-	-	-	23R125
3/8"	1/2	3	OP27-	31R000	31R015	31R030	31R060	31R090	31R125	-	-	31R190
	3/4	3	OP27-	32R000	32R015	32R030	32R060	32R090	32R125	-	-	32R190
	1	3	OP27-	33R000	33R015	33R030	33R060	33R090	33R125	-	-	33R190
1/2"	1/2	3	OP27-	51R000	51R015	51R030	51R060	51R090	51R125	51R190	-	51R250
	3/4	3	OP27-	52R000	52R015	52R030	52R060	52R090	52R125	52R190	-	52R250
	1	3	OP27-	53R000	53R015	53R030	53R060	53R090	53R125	53R190	-	53R250
	1-1/2	4	OP27-	54R000	54R015	54R030	54R060	54R090	54R125	54R190	-	54R250
	2	4	OP27-	55R000	55R015	55R030	55R060	55R090	55R125	55R190	-	55R250
5/8"	3/4	4	OP27-	61R000	61R015	61R030	61R060	61R090	61R125	61R190	61R250	61R312
	1	4	OP27-	62R000	62R015	62R030	62R060	62R090	62R125	62R190	62R250	62R312
3/4"	3/4	4	OP27-	71R000	71R015	71R030	71R060	71R090	71R125	71R190	71R250	71R375
	1	4	OP27-	72R000	72R015	72R030	72R060	72R090	72R125	72R190	72R250	72R375
	1-1/2	4	OP27-	73R000	73R015	73R030	73R060	73R090	73R125	73R190	73R250	73R375
1"	1	4	OP27-	91R000	91R015	91R030	91R060	91R090	91R125	91R190	91R250	91R500
	1-1/2	4	OP27-	92R000	92R015	92R030	92R060	92R090	92R125	92R190	92R250	92R500
	2	5	OP27-	93R000	93R015	93R030	93R060	93R090	93R125	93R190	93R250	93R500

**To make an order, please use EDP number and add the model number
EX: OP27-23R030**

FEED AND SPEED CHART

SKI-CARB (FRACTIONAL)	Cut		Feed (inch/flute)					
	Type	sfm	1/8	1/4	3/8	1/2	3/4	1
ALUMINUM ALLOY 2024, 5052, 5086, 6061, 6063, 7075	Slot	1600	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Profile	2000	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Light	3300	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195
ALUMINUM DIE CAST ALLOY High Silicon A-390, A-392, B-390	Slot	600	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Profile	750	0.0009	0.0025	0.0045	0.0060	0.0070	0.0085
	Light	1240	0.0021	0.0055	0.0105	0.0140	0.0165	0.0195
COPPER ALLOY Aluminum Bronze, Muntz Brass, Naval Brass, Red Brass	Slot	865	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Profile	1080	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Light	1780	0.0017	0.0045	0.0085	0.0115	0.0140	0.0160
COPPER ALLOY Beryllium Copper, C110, Manganese Bronze, Tin Bronze	Slot	345	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Profile	430	0.0008	0.0020	0.0040	0.0050	0.0060	0.0070
	Light	710	0.0017	0.0045	0.0085	0.0115	0.0140	0.0160
PLASTIC ABS, Polycarbonate, PVC, Polypropylene	Slot	1600	0.0015	0.0040	0.0075	0.0100	0.0120	0.0140
	Profile	2000	0.0015	0.0040	0.0075	0.0100	0.0120	0.0140
	Light	3300	0.0034	0.0090	0.0170	0.0230	0.0275	0.0320



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