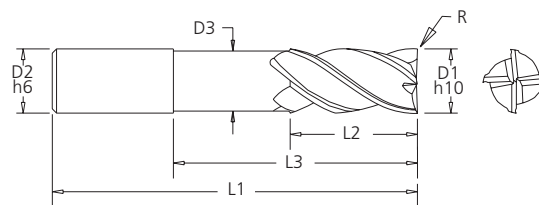
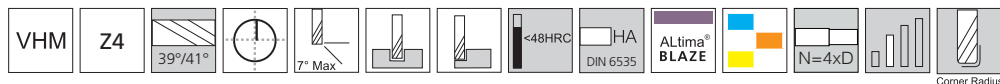




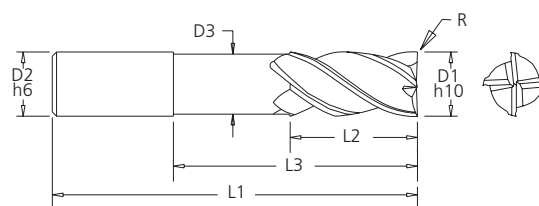
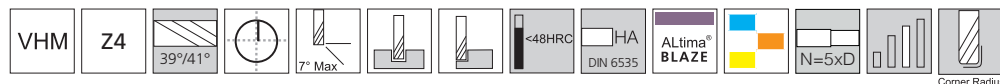
TuffCut® XT Series 277NR-4



Tool Number	D1	D2	D3	L1	L2	L3	R
277 06N4-0.5RB	6.0	6.0	5.8	64.0	13.0	26.0	0.5
277 08N4-0.5RB	8.0	8.0	7.6	75.0	19.0	34.0	0.5
277 10N4-0.5RB	10.0	10.0	9.6	82.0	22.0	42.0	0.5
277 12N4-0.5RB	12.0	12.0	11.4	100.0	26.0	50.0	0.5
277 12N4-3.0RB	12.0	12.0	11.4	100.0	26.0	50.0	3.0
277 16N4-0.5RB	16.0	16.0	15.2	120.0	32.0	66.0	0.5
277 16N4-3.0RB	16.0	16.0	15.2	120.0	32.0	66.0	3.0



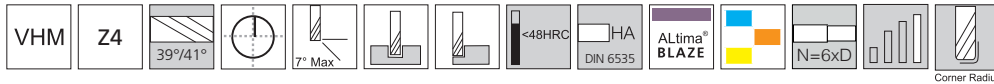
TuffCut® XT Series 277NR-5



Tool Number	D1	D2	D3	L1	L2	L3	R
277 06N5-0.5RB	6.0	6.0	5.8	70.0	13.0	32.0	0.5
277 08N5-0.5RB	8.0	8.0	7.6	80.0	19.0	42.0	0.5
277 10N5-0.5RB	10.0	10.0	9.6	92.0	22.0	52.0	0.5
277 12N5-0.5RB	12.0	12.0	11.4	110.0	26.0	62.0	0.5
277 12N5-3.0RB	12.0	12.0	11.4	110.0	26.0	62.0	3.0
277 16N5-0.5RB	16.0	16.0	15.2	130.0	32.0	82.0	0.5
277 16N5-3.0RB	16.0	16.0	15.2	130.0	32.0	82.0	3.0

NEW

TuffCut® XT Series 277NR-6



Tool Number	D1	D2	D3	L1	L2	L3	R
277 06N6-0.5RB	6.0	6.0	5.8	75.0	13.0	38.0	0.5
277 08N6-0.5RB	8.0	8.0	7.6	90.0	19.0	50.0	0.5
277 10N6-0.5RB	10.0	10.0	9.6	105.0	22.0	62.0	0.5
277 12N6-0.5RB	12.0	12.0	11.4	120.0	26.0	74.0	0.5
277 12N6-3.0RB	12.0	12.0	11.4	120.0	26.0	74.0	3.0
277 16N6-0.5RB	16.0	16.0	15.2	150.0	32.0	98.0	0.5
277 16N6-3.0RB	16.0	16.0	15.2	150.0	32.0	98.0	3.0

Recommended Cutting Data

Series 277NR - 4xD													
Workpiece Material Group	I S O	Coolant			Application	Depth of Cut Per Application		Vc- m/min	Tool Diameter (mm)				
		Emulsion	Air	MQL		6	8		10	12	16		
												fz - mm/tooth by Cutter Diameter	
Low Carbon Steels	P	•	•	•	Profiling	1xD	0.4xD	300	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	200	0.03	0.04	0.05	0.06	0.08
Medium Carbon Steels		•	•	•	Profiling	1xD	0.4xD	230	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	155	0.03	0.04	0.05	0.06	0.08
Alloy Steels		•	•	•	Profiling	1xD	0.4xD	205	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	135	0.03	0.04	0.05	0.06	0.08
Die / Tool Steels	M	•	•	•	Profiling	1xD	0.4xD	170	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	115	0.03	0.04	0.05	0.06	0.08
Stainless Steel		•	x	o	Profiling	1xD	0.4xD	120	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	80	0.03	0.04	0.05	0.06	0.08
Duplex		•	x	o	Profiling	1xD	0.4xD	80	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	55	0.03	0.04	0.05	0.06	0.08
Super Duplex	S	•	x	o	Profiling	1xD	0.4xD	50	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	35	0.03	0.04	0.05	0.06	0.08
Titanium Alloys		•	x	x	Profiling	1xD	0.4xD	60	0.06	0.08	0.1	0.12	0.16
					Slotting	0.5xD	-	40	0.03	0.04	0.05	0.06	0.08

Series 277NR - 5xD													
Workpiece Material Group	I S O	Coolant			Application	Depth of Cut Per Application		Vc- m/min	Tool Diameter (mm)				
		Emulsion	Air	MQL		Axial (Ap)	Radial (Ae)		6	8	10	12	16
									fz - mm/tooth by Cutter Diameter				
Low Carbon Steels	P	•	•	•	Profiling	1xD	0.25xD	270	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	180	0.03	0.04	0.05	0.06	0.08
Medium Carbon Steels		•	•	•	Profiling	1xD	0.25xD	205	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	135	0.03	0.04	0.05	0.06	0.08
Alloy Steels		•	•	•	Profiling	1xD	0.25xD	185	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	125	0.03	0.04	0.05	0.06	0.08
Die / Tool Steels	M	•	•	•	Profiling	1xD	0.25xD	153	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	105	0.03	0.04	0.05	0.06	0.08
Stainless Steel		•	x	o	Profiling	1xD	0.25xD	80	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	55	0.03	0.04	0.05	0.06	0.08
Duplex		•	x	o	Profiling	1xD	0.25xD	70	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	45	0.03	0.04	0.05	0.06	0.08
Super Duplex	S	•	x	o	Profiling	1xD	0.25xD	45	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	30	0.03	0.04	0.05	0.06	0.08
Titanium Alloys		•	x	x	Profiling	1xD	0.25xD	75	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	50	0.03	0.04	0.05	0.06	0.08

Series 277NR - 6xD													
Workpiece Material Group	I S O	Coolant			Application	Depth of Cut Per Application		Vc- m/min	Tool Diameter (mm)				
		Emulsion	Air	MQL		6	8		10	12	16		
												Axial (Ap)	Radial (Ae)
Low Carbon Steels	P	•	•	•	Profiling	1xD	0.25xD	240	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	160	0.03	0.04	0.05	0.06	0.08
Medium Carbon Steels		•	•	•	Profiling	1xD	0.25xD	184	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	125	0.03	0.04	0.05	0.06	0.08
Alloy Steels		•	•	•	Profiling	1xD	0.25xD	164	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	110	0.03	0.04	0.05	0.06	0.08
Die / Tool Steels	M	•	•	•	Profiling	1xD	0.25xD	136	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	90	0.03	0.04	0.05	0.06	0.08
Stainless Steel		•	x	o	Profiling	1xD	0.25xD	75	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	50	0.03	0.04	0.05	0.06	0.08
Duplex		•	x	o	Profiling	1xD	0.25xD	65	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	45	0.03	0.04	0.05	0.06	0.08
Super Duplex	S	•	x	o	Profiling	1xD	0.25xD	35	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	25	0.03	0.04	0.05	0.06	0.08
Titanium Alloys		•	x	x	Profiling	1xD	0.25xD	64	0.06	0.08	0.1	0.12	0.16
					Slotting	0.3xD	-	45	0.03	0.04	0.05	0.06	0.08

• Preferred o Possible x Not Possible

Also available:



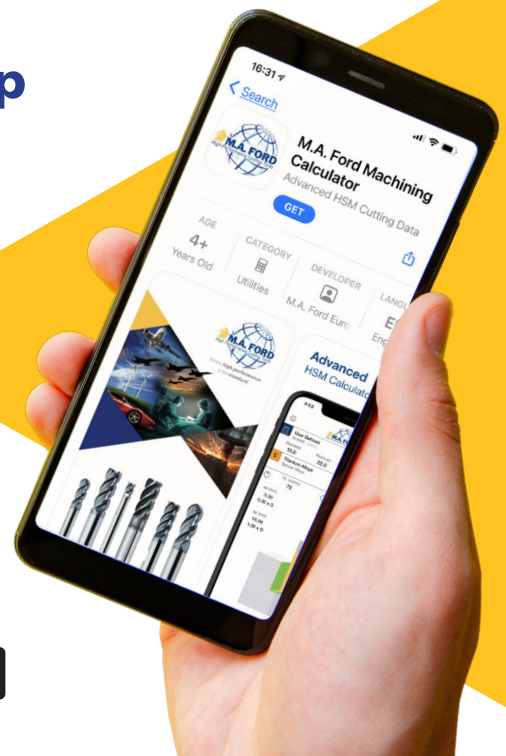
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M.A. Ford Europe Ltd.

650 City Gate
London Road, Derby
DE24 8WY
United Kingdom

Tel: +44(0) 1332 267960
Fax: +44(0) 1332 267969
e-mail: sales@mafordeurope.com
www.mafordeurope.com

M.A. Ford® Mfg. Co., Inc.

7737 Northwest Blvd.
Davenport
IA 52806
USA

Tel: 563-391-6220 or 800-553-8024
Fax: 563-386-7660 or 800-892-9522
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M.A. Ford® Asia-Pacific Limited

Room 1709, Level 17
Millennium City 2
378 Kwun Tong Road
Kowloon, Hong Kong

Tel: +852-2167-7150
Fax: +852-2167-8150
Email: sales@mafordap.com