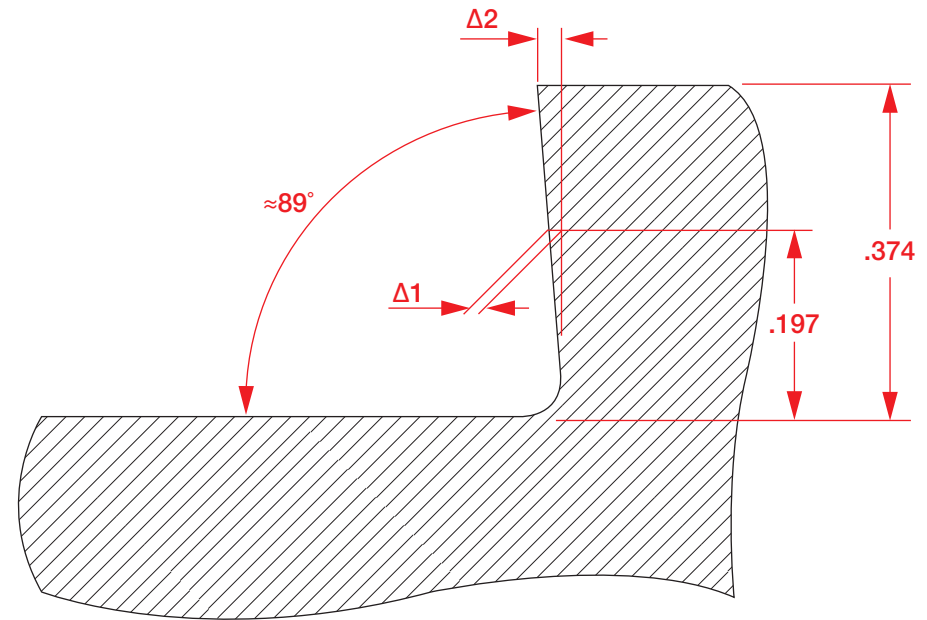


T890HT FLN-13 milling cutters are intended mainly for rough face milling near square shoulder, due to their 90° cutting-edge angle. The depth of cut should not exceed the maximum catalog depth of cut.

The deviation of a generated shoulder profile, which is a function of a cutter diameter and a depth of cut, may be estimated with the use of the following sketch and table:

Cutter Diameter, inch	$\Delta 1$, inch	$\Delta 2$, inch
1.5	.0023	.0047
2.0		
2.5		
3.0	.0031	.0063
4.0	.0035	.0070
5.0		
6.0		



The cutter in 1.5" diameter is not recommended for machining shoulders by stepdown milling.