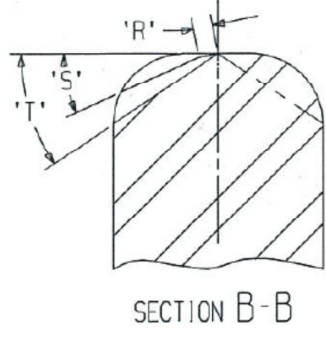
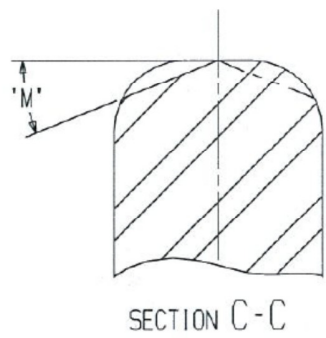
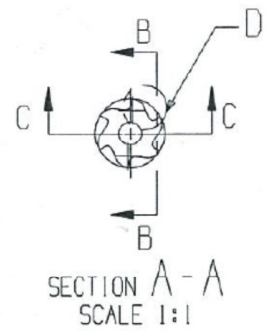
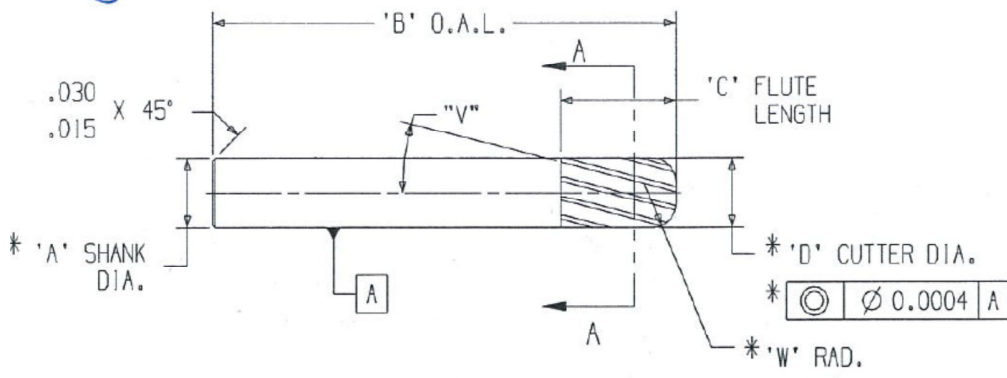
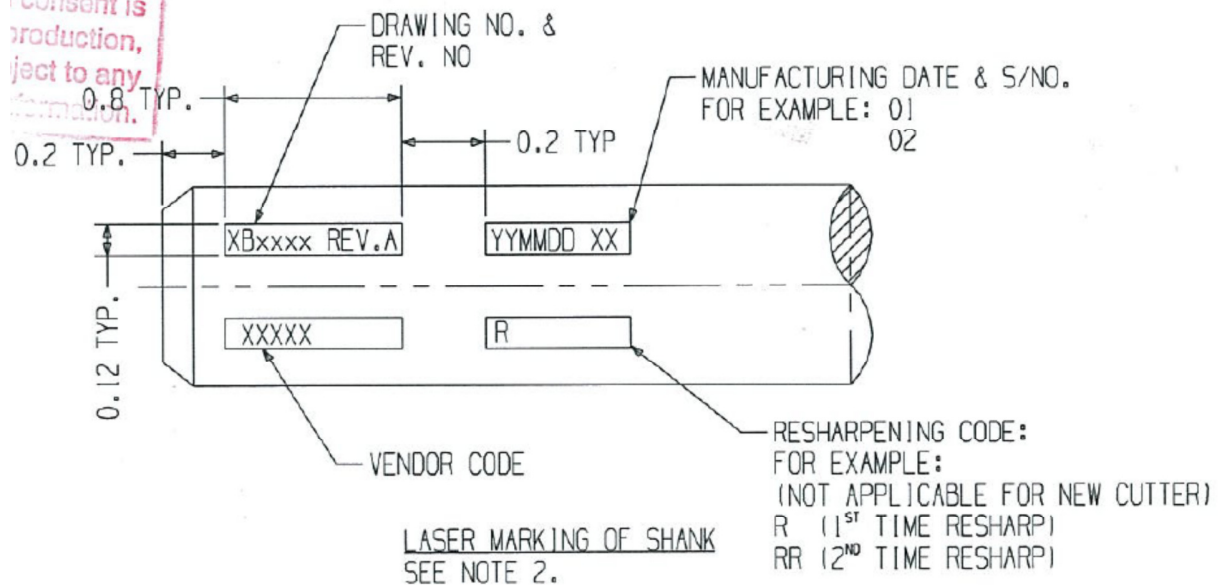
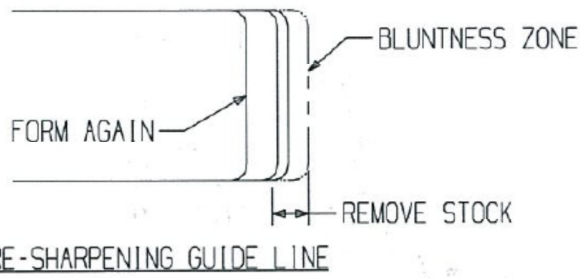
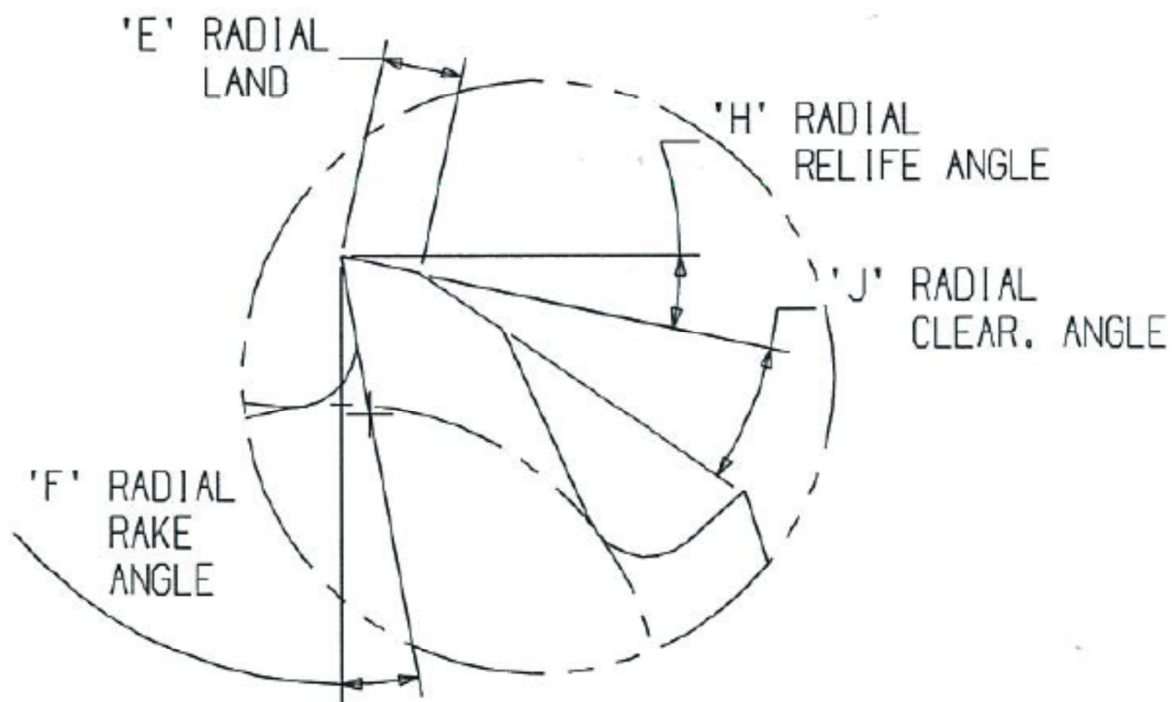


is featured in
 international-
 to others or
 technologies
 services to
 consent is
 production,
 ject to any
 formation.





DETAIL D

No. OF FLUTES	"*A" SHANK DIA.	"B" O.A.L	"C"	"*D" CUTTER DIA.	HAND OF CUT	"E" RADIAL LAND	"F" RADIAL RAKE ANGLE	"*W" RAD
4	0.7495-0.7500	5.00	1.25	.748-.750	RIGHT	.023/.033	4° -8° POS	0.250 ± 0.002

"H" RADIAL RELIEF ANGLE	"J" RADIAL CLEAR. ANGLE	"M" GASH ANGLE	"R" PRIMARY AXIAL WIDTH	"S" ANGLE	"T" ANGLE	"V" ANGLE
8° -10°	17° -22°	30° -35°	0.062 ± 0.005	5° -8°	20° -25°	30°

AXIAL RAKE	CORE DIA.	MIN. FLUTE LENGTH BEFORE RE-FLUTING	MIN. OAL
1° -4°	0.465 ± 0.005	.60	3.50

NOTES :

1. FEATURES MARKED(*) ARE CRITICAL REQUIREMENT. COC MUST BE FURNISHED FOR ALL THESE FEATURES. COC MUST BE SUBMITTED IN THE BELOW FORMAT:

DRAWING NO. :		REV:		DATE:	
CUTTER ID (MANUFACTURING DATE & S/NO. AS MARKED ON CUTTER)	RESHARPENING CODE	FEATURE SPECIFICATION & ACTUAL DATA			
		"A" SHANK DIA.	"D" CUTTER DIA.	CONCENTRICITY	"W" RAD
		0.7495-0.7500	0.748-0.750	0.0004 MAX	0.248-0.252
		NA. FOR RESHARPENING	NA. FOR RESHARPENING		

2. LASER MARK DRAWING NO. & REV. NO. RESHARPENING CODE, VENDOR CODE, MANUFACTURING DATE AND SERIAL NO. ON THE TOOL SHANK AS SHOWN. LETTER MUST BE SEEN CLEARLY.
3. MATERIAL PER GE DRAWING 4013366-188
4. RE-SHARPENING:ALLOWED
ALL ASPECTS OF RESHARPENED TOOL REMAIN SAME AS NEW TOOL WITH THE FOLLOWING EXCEPTION
-OVERALL LENGTH=3.50-5.00
-MARKING OF RE-SHARPENING CODE