

ROUGHFIN•ROUNDS™

Series 47C...RU 4-Flute 45° Rough-Fin Variable Pitch Endmill

Ingersoll Series 47C...RU variable pitch endmills combine roughing and finishing endmills in a single tool. This unique tool design is equipped with two serrated flutes for roughing and two continuous flutes for finishing. This design results in a cutter that is capable of running at rough machining parameters and produces a finished quality surface.

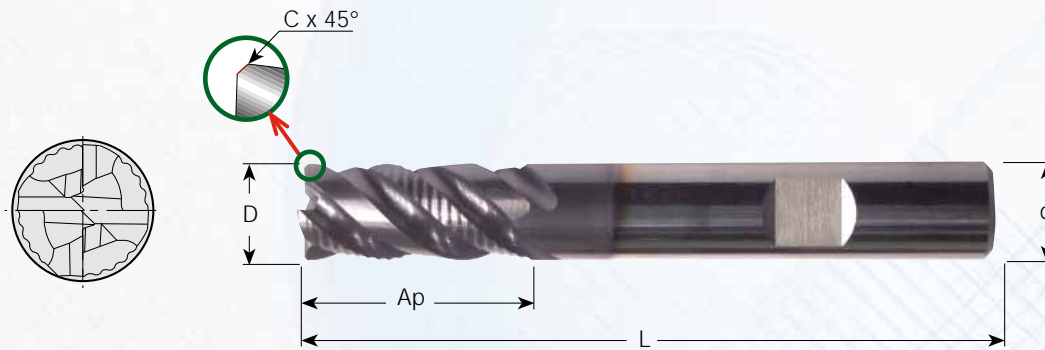
Features and Benefits:

- 4 flutes with a 45° helix - two serrated flutes and two continuous flutes
- Excellent design to combat chatter and vibration
- All-effective flutes enable running at rough machining parameters, yet resulting in finish surface quality
- Reduces power consumption by 25-30%
- Suitable for all types of steel and high temperature alloys

Tool Diameter Range: 0.250" – 1.00"
Number of Flutes: 4
Overall Length Range: 2.50" – 5.00"
Cut Length Range: 0.500" – 2.00"

Helix Angle: 45°
Corner: 0.010" x 45° – 0.024" x 45°
Grade: IN2005

Series 47C...RU 4-Flute 45° Rough-Fin Variable Pitch Endmill



Part Number	Helix	(D) Diameter	(Z) Flutes	(C) Chamfer	(L) Overall	(Ap) Cut Length	Shank	(d) Shank Dia.	Stock
47C-2550R6RU01	45°	0.250	4	0.010x45°	2.500	0.500	C	0.250	■
47C-3162R7RU01	45°	0.312	4	0.012x45°	2.500	0.625	C	0.312	■
47C-3775R8RU01	45°	0.375	4	0.012x45°	3.000	0.750	C	0.375	■
47C-377577RU01	45°	0.375	4	0.012x45°	3.000	0.750	W	0.375	■
47C-5010S4RU01	45°	0.500	4	0.016x45°	3.000	1.000	C	0.500	■
47C-501078RU01	45°	0.500	4	0.016x45°	3.000	1.000	W	0.500	■
47C-6212S6RU02	45°	0.625	4	0.024x45°	3.500	1.250	C	0.625	■
47C-621279RU02	45°	0.625	4	0.024x45°	3.500	1.250	W	0.625	■
47C-7515S7RU02	45°	0.750	4	0.024x45°	4.000	1.500	C	0.750	■
47C-751584RU02	45°	0.750	4	0.024x45°	4.000	1.500	W	0.750	■
47C-1020S1RU02	45°	1.000	4	0.024x45°	5.000	2.000	C	1.000	
47C-102080RU02	45°	1.000	4	0.024x45°	5.000	2.000	W	1.000	■

ROUGHFIN ROUNDS™

Machining Recommendations
RECOMMENDED SPEEDS

ISO	Material	Condition	Brinell	Hardness	SPEED (inch/min)		
				No.	V min	V max	
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	125	1	850	925
		>= 0.25 %C	Annealed	190	2	650	750
		< 0.55 %C	Quenched and tempered	250	3	525	725
		>= 0.55 %C	Annealed	220	4	525	725
			Quenched and tempered	300	5	450	600
	Low alloy steel and cast steel (less than 5% all element)	Annealed		200	6	525	600
				275	7	400	600
		Quenched and tempered		300	8	425	600
				350	9	450	600
	High alloyed steel, cast steel and tool steel.	Annealed	200	10	425	600	
		Quenched and tempered	325	11	225	400	
M	Stainless steel and cast steel	ferritic/martens.	200	12	250	525	
		martensitic	240	13	200	500	
		austenitic	180	14	200	400	
K	Cast iron nodular (GGG)	ferritic/pearlitic	180	15	275	850	
		pearlitic	260	16	425	800	
	Grey cast iron (GG)	ferritic	160	17	500	925	
		pearlitic	250	18	300	925	
	Malleable cast iron	ferritic	130	19	500	925	
		pearlitic	230	20	475	800	
N	Aluminum-wrought alloy	Not cureable	60	21	2650	2755	
		cured	100	22	2400	2755	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	75	23	2625	2755
		cured	90	24	2400	2755	
	Copper alloys	>12% Si	High temp.	130	25	1050	1125
		>1% Pb	Free cutting	110	26	1325	1425
			Brass	90	27	1325	1425
			Electrolitic copper	100	28	890	1000
	Non metallic	Duroplastics, fiber plastics		29	0	0	
		hard rubber		30	0	0	
S	High temp. alloys	Fe based	Annealed	200	31	70	125
			Cured	280	32	70	100
	Super alloys	Ni or Co based	Annealed	250	33	70	100
			Cured	350	34	70	100
		Cast	320	35	100	225	
	Titanium			36	100	225	
	Ti alloys	Alpha+beta alloys cured		37	100	225	
H	Hardened steel	Hardened	55 HRC	38	100	175	
		Hardened	60 HRC	39	100	125	
	Chilled cast iron	Cast	400	40	200	275	
	Cast iron	Hardened	55 HRC	41	100	175	