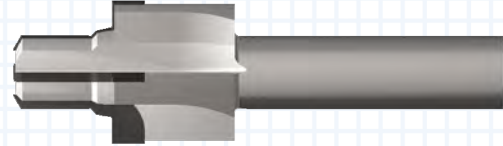
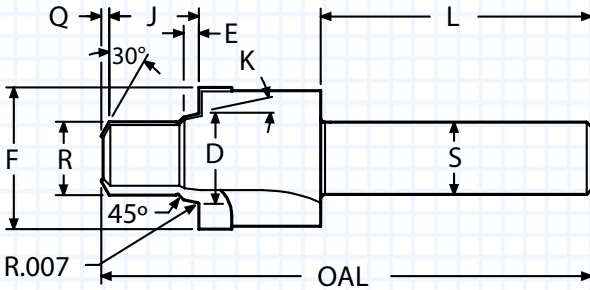


# ISO 6149/1 (SAEJ2244/1) METRIC PORT TOOL CARBIDE TIPPED



- Bodies are made with heat treated alloy steel
- Carbide inserts are made with premium submicron carbide
- Polished flute face for optimum performance
- ALTiN+ coated for improved surface finish

K (deg)	D (mm)	E (mm)	F (mm)	R (mm)	J (mm)	Q (inch)	L (inch)	S (inch)	OAL (inch)	FLUTES	THREAD	ORDER #		EDP #	
												UNCOATED	ALTiN+	UNCOATED	ALTiN+
12°	9.15	1.8	14.1	7.0	11.6	0.032	1.75	0.500	3.00	3	M8X1	6149-M8X1	6149-M8X1A	402137	402187
12°	11.15	1.8	16.1	9.0	11.6	0.045	1.75	0.500	3.00	3	M10X1	6149-M10X1	6149-M10X1A	402101	402151
15°	13.85	2.6	19.1	10.5	14.1	0.045	1.88	0.500	3.12	3	M12X1.5	6149-M12X1.5	6149-M12X1.5A	402104	402154
15°	15.85	2.6	21.1	12.5	14.1	0.055	1.88	0.500	3.38	4	M14X1.5	6149-M14X1.5	6149-M14X1.5A	402107	402157
15°	17.85	2.6	24.1	14.5	15.6	0.060	1.88	0.500	3.38	4	M16X1.5	6149-M16X1.5	6149-M16X1.5A	402110	402160
15°	19.85	2.6	26.1	16.5	17.1	0.070	2.12	0.750	3.70	4	M18X1.5	6149-M18X1.5	6149-M18X1.5A	402113	402163
15°	21.85	2.6	27.1	18.5	17.5	0.080	2.12	0.750	3.75	4	M20X1.5	6149-M20X1.5	6149-M20X1.5A	402116	402166
15°	23.85	2.6	29.1	20.5	18.1	0.080	2.12	0.750	3.80	4	M22X1.5	6149-M22X1.5	6149-M22X1.5A	402119	402169
15°	29.45	3.3	34.2	25.0	22.1	0.080	2.12	0.750	3.94	4	M27X2.0	6149-M27X2.0	6149-M27X2.0A	402122	402172
15°	35.45	3.3	43.1	31.0	22.1	0.090	2.25	1.000	4.25	4	M33X2.0	6149-M33X2.0	6149-M33X2.0A	402125	402175
15°	44.45	3.3	52.1	40.0	22.6	0.090	2.25	1.000	4.35	4	M42X2.0	6149-M42X2.0	6149-M42X2.0A	402128	402178
15°	50.45	3.3	57.1	46.0	25.1	0.095	2.25	1.000	4.35	4	M48X2.0	6149-M48X2.0	6149-M48X2.0A	402131	402181
15°	62.45	3.3	67.1	58.0	27.6	0.095	2.25	1.250	4.35	4	M60X2.0	6149-M60X2.0	6149-M60X2.0A	402134	402184

Thread mills are available. See pages 24-28.

# PORT & CAVITY TECHNICAL INFORMATION

MATERIAL	HB/Rc	SPEED (SFM)		CUTTING CONDITIONS	
		UNCOATED	ALTiN+	INFEEED PER FLUTE REAM	INFEEED PER FLUTE SPOT FACE
CAST IRON	130 HB	75-210	200-450	.001-.0025	.0008-.0020
CARBON STEEL	18 Rc	125-190	190-400	.001-.0030	.001-.0020
ALLOY STEEL	20 Rc	70-135	130-350	.001-.0030	.0008-.0020
TOOL STEEL	25 Rc	75-100	100-220	.001-.0025	.0005-.0020
300 STAINLESS STEEL	150 HB	90-100	100-230	.001-.0020	.0007-.0015
400 STAINLESS STEEL	195 HB	90-135	135-300	.001-.0020	.0005-.0015
HIGH TEMP ALLOY (NICKEL & COBALT BASE)	20 Rc	30-125	100-150	.0008-.0015	.0005-.0010
TITANIUM	25 Rc	50-100	100-140	.001-.0020	.0005-.0010
HEAT TREATED ALLOYS (38-45Rc)	40 Rc	50-75	75-130	.0008-.0015	.0005-.0010
ALUMINUM	100 HB	850-1000	800-1500	.002-.0040	.0010-.0030
BRASS, ZINC	80 HB	750-950	800-1200	.002-.0040	.0010-.0030

SFM = Surface Feet per Minute

RPM = SFM x 3.82 divided by tool diameter

Starting parameters only. Setup and machine rigidity may affect performance.

PROBLEM	CAUSE	SOLUTION
RAPID FLANK WEAR	CUTTING CONDITIONS	Check for excessive speed and feed - see chart.
	TOOL	Select a coated tool.
	PROGRAM	Remove dwell from program at end of cut.
BUILT-UP EDGE	TOOL	Select a coated tool. The coating will resist built-up edges.
	HEAT	Use coolant through port tool. If coolant is not available, use shop air and a coated tool.
SURFACE TORN	TOOL	Use a coated tool. On most carbon steels, an uncoated tool will not produce an acceptable finish.
CHATTER	TOOL	Hone cutting edge of spot face. Use Coated Tool. Increase chip load.
LIGHT CHATTER	PROGRAM	Increase speed by 15-20%. A faster speed reduces forces. A dwell typically will not remove chatter.
POOR TOOL LIFE	AMOUNT OF STOCK	Rough port to 0.97 inch of finish size.
	PART	Make sure prior operation did not work harden the material.

## SAMPLE PROGRAM FOR MAXIMUM PRODUCTIVITY

N51 (Sample Port Tool Program: MS33649-4RA (ALTiN+) cutting Carbon Steel

**T51 M06**

**Select Tool**

**S2916 M03**

**SFM = 300 ; RPM = 300 x 3.82 / Reamer Diameter**

**G00 G90 G54 X0. Y0.**

**RPM = 300 X 3.82 / 0.393**

**G43 H51 Z0.1 M08**

**RPM = 2916**

**G01 Z-0.6 F23.3**

**Feed Rate = RPM x 0.002 x 4 (Number of Flutes)**

**S1290 M03**

**RPM = 300 x 3.82 / 0.888 (Spot Face Diameter)**

**G04 P1.**

**Dwell to slow down spindle**

**G01 Z-.73 F10.3**

**Feed rate = RPM x 0.002 x 4 (Number of Flutes)**

**G00 Z5. M09**