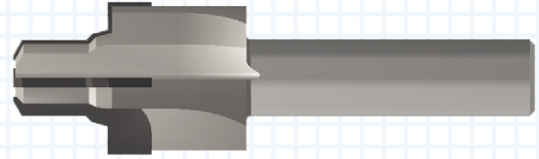
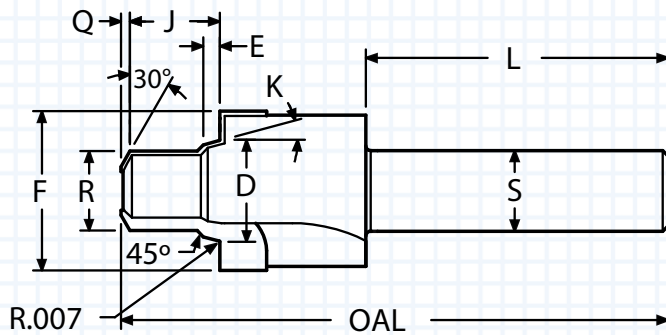


# ISO6149/1 (SAEJ2244/1) METRIC PORT TOOL WITH LARGE SPOTFACE - CARBIDE TIPPED



- Metric port without identification notch
- Polished flute face for optimum performance
- Precision ground for maximum concentricity
- ALTiN+ coating extends tool life

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	17.1	7.0	11.6	0.032	1.75	0.500	3.00	3	M8X1	6149-M8X1-F17	6149-M8X1-F17A	402228	402278
12°	11.15	1.8	20.1	9.0	11.6	0.045	1.75	0.500	3.00	3	M10X1	6149-M10X1-F20	6149-M10X1-F20A	402201	402251
15°	13.85	2.6	23.1	10.5	14.1	0.045	1.88	0.500	3.12	3	M12X1.5	6149-M12X1.5-F23	6149-M12X1.5-F23A	402204	402254
15°	15.85	2.6	25.1	12.5	14.1	0.055	1.88	0.500	3.38	4	M14X1.5	6149-M14X1.5-F25	6149-M14X1.5-F25A	402207	402257
15°	17.85	2.6	28.1	14.5	15.6	0.060	1.88	0.500	3.38	4	M16X1.5	6149-M16X1.5-F28	6149-M16X1.5-F28A	402210	402260
15°	19.85	2.6	30.1	16.5	17.1	0.070	2.12	0.750	3.70	4	M18X1.5	6149-M18X1.5-F30	6149-M18X1.5-F30A	402213	402263
15°	21.85	2.6	32.1	18.5	17.5	0.080	2.12	0.750	3.75	4	M20X1.5	6149-M20X1.5-F32	6149-M20X1.5-F32A	402216	402266
15°	23.85	2.6	34.1	20.5	18.1	0.080	2.12	0.750	3.80	4	M22X1.5	6149-M22X1.5-F34	6149-M22X1.5-F34A	402219	402269
15°	29.45	3.3	40.1	25.0	22.1	0.080	2.12	0.750	3.94	4	M27X2.0	6149-M27X2.0-F40	6149-M27X2.0-F40A	402222	402272
15°	35.45	3.3	49.1	31.0	22.1	0.090	2.25	1.000	4.25	4	M33X2.0	6149-M33X2.0-F49	6149-M33X2.0-F49A	402225	402275

Thread mills are available. See pages 24-28.

Larger sizes are available upon request. It will be quoted as a special order.

# 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**