

# Special Offer from Colmar and IMCO

(847) 291-9800



Offer Available  
Thru June 30, 2005



**Pow•R•Feed's cutting edge design and unique substrate and coating combination will give you the maximum in ...**

4 Flute Standard Length  
With Corner Radius

**Regular Price**  
Single Tool



**Buy 3 Get 1 FREE!**  
4 Piece Tool Kit

Mill Dia	Shank Dia	Flute Length	OAL	Radius	Order Code	Your Price	Order Code	Your Price
1/8	1/8	1/2	1-1/2	.015	IM-63064	\$9.21	IM-63064K	\$27.63
5/32	3/16	9/16	2	.015	IM-63118	13.50	IM-63118K	40.05
3/16	3/16	5/8	2	.015	IM-63065	12.81	IM-63065K	38.43
7/32	1/4	5/8	2-1/2	.020	IM-63119	17.79	IM-63119K	53.37
1/4	1/4	3/4	2-1/2	.020	IM-63066	16.32	IM-63066K	48.96
5/16	5/16	13/16	2-1/2	.020	IM-63067	20.49	IM-63067K	61.47
3/8	3/8	7/8	2-1/2	.020	IM-63068	24.66	IM-63068K	73.98
7/16	7/16	1	2-3/4	.020	IM-63069	31.05	IM-63069K	93.15
1/2	1/2	1	3	.030	IM-63070	38.34	IM-63070K	115.02
1/2	1/2	1-1/4	3	.030	IM-63098	38.58	IM-63098K	115.74
5/8	5/8	1-1/4	3-1/2	.030	IM-63071	81.78	IM-63071K	245.34
3/4	3/4	1-1/2	4	.030	IM-63072	105.90	IM-63072K	317.70
1	1	1-1/2	4	.030	IM-63073	169.11	IM-63073K	507.33

4 Flute Standard Length  
Square Corner

**Regular Price**  
Single Tool



**Buy 3 Get 1 FREE!**  
4 Piece Tool Kit

Mill Dia	Shank Dia	Flute Length	OAL	Radius	Order Code	Your Price	Order Code	Your Price
1/8	1/8	1/2	1-1/2	None	IM-63010	\$9.00	IM-63010K	\$27.00
5/32	3/16	9/16	2	None	IM-63011	13.14	IM-63011K	39.42
3/16	3/16	5/8	2	None	IM-63012	12.45	IM-63012K	37.35
7/32	1/4	5/8	2-1/2	None	IM-63013	17.04	IM-63013K	51.12
1/4	1/4	3/4	2-1/2	None	IM-63014	15.63	IM-63014K	46.89
5/16	5/16	13/16	2-1/2	None	IM-63016	19.56	IM-63016K	58.68
3/8	3/8	7/8	2-1/2	None	IM-63018	23.55	IM-63018K	70.65
7/16	7/16	1	2-3/4	None	IM-63020	29.64	IM-63020K	88.92
1/2	1/2	1	3	None	IM-63022	36.63	IM-63022K	109.89
1/2	1/2	1-1/4	3	None	IM-63100	36.87	IM-63100K	110.61
5/8	5/8	1-1/4	3-1/2	None	IM-63024	78.15	IM-63024K	234.45
3/4	3/4	1-1/2	4	None	IM-63025	101.25	IM-63025K	303.75
1	1	1-1/2	4	None	IM-63026	161.73	IM-63026K	485.19

## Aaron's Advice

If you are using the Z-Carb or Vari-Mill End Mills, you already know how well the unequal flute spacing (UFS) on the Pow-R-Feed can work. The variation in geometry reduces harmonics, which makes this style cutter quieter. It can handle larger chip loads than conventional 4-Flute end mills. Imco uses a premium micrograin carbide and new second-generation multi-layer Ti-Al coating for extended life.

Pow-R-Feed End Mills really work well in Stainless Steels, Exotic Materials, Tool Steels and Hardened materials. They work well in Carbon Steels and Cast Irons also. They will allow you to feed more aggressively, and finish the job faster with lower overall tool costs.

The big difference between the Pow-R-Feed and the competitor's end mill is the price. These prices are good through the end of June, when they will go up 15% and the Buy-3-get-1-Free deal will expire.

**Stock up now and save!**

Purchase three of the same size Pow-R-Feed end mills and get the fourth **FREE!** That's an additional 25% savings over the regular price.



### ● DURABILITY

Unique design reduces chatter and enhances tool life. Multi-layer coating gives maximum heat resistance

### ● PRODUCTIVITY

Runs at higher feed rates even on deeper depths of cuts, saving cycle time and increasing productivity

### ● VERSATILITY

One tool for slotting, pocketing, roughing and finishing in a wide range of materials- from low carbon steels to titanium



# Testimonials...

- One customer was able to double the chip load and increase the spindle speed, when running dry in 4140 material at 1x diameter axial cut and .5x diameter cut. This was a 4x increase in the metal removal rate.
- One customer was able to increase his feed rate by 52% to 55ipm in a 3/4" slot 1/2" deep in 11L17 material.
- One customer was able to double his tool life from 19 parts per tool to 39 parts per tool in titanium, while maintaining feed rates and depths of cut.



## Pow•R•Feed Speed & Feeds

STARTING PARAMETERS										
Application Material	Speed (SFM)	Feed (Inches Per Tooth)					Maximum Depth of Cut			
		1/8	1/4	1/2	3/4	1	Slotting Axial	Profiling Axial	Profiling Radial	Profiling Feed Adj.
Cast Iron - Gray	450 - 550	0.0010	0.0025	0.0035	0.0045	0.0060	1 x D	.5 x D	1 x D	+20%
Cast Iron - Ductile	300 - 400	0.0007	0.0012	0.0025	0.0040	0.0055	1 x D	.5 x D	1 x D	+20%
Cast Iron - Malleable	250 - 325	0.0005	0.0010	0.0020	0.0030	0.0040	1 x D	.5 x D	1 x D	+15%
Steel - Low Carbon	400 - 500	0.0010	0.0020	0.0040	0.0050	0.0060	1 x D	.5 x D	1 x D	+20%
Steel - Medium Carbon	275 - 400	0.0007	0.0015	0.0035	0.0045	0.0060	1 x D	.5 x D	1 x D	+20%
Tool Steels (<38 Rc)	250 - 350	0.0005	0.0012	0.0030	0.0040	0.0055	1 x D	.5 x D	1 x D	+15%
300 Series Stainless Steel	275 - 375	0.0005	0.0012	0.0025	0.0033	0.0050	1 x D	.5 x D	1 x D	+15%
400 Series Stainless Steel	250 - 350	0.0005	0.0012	0.0025	0.0033	0.0050	1 x D	.5 x D	1 x D	+15%
PH Series Stainless Steel	225 - 325	0.0004	0.0009	0.0018	0.0027	0.0032	1 x D	.5 x D	1 x D	+15%
Titanium	200 - 300	0.0004	0.0010	0.0020	0.0025	0.0030	1 x D	.5 x D	1 x D	+15%
High Temp Alloys	60 - 90	0.0005	0.0010	0.0018	0.0025	0.0030	1 x D	.25 x D	1 x D	+10%

Not recommended for use in Aluminum

D = Tool Diameter



**Can run under flood coolant or dry in most applications**



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