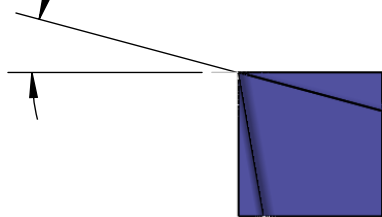


MATERIAL	NOSE R	SIDE RELIEF	END RELIEF	SIDE RAKE
ALUMINUM	.030	12	8	15
BRASS	.030	10	8	5
MILD STEEL	.015	10	8	15
TOOL STEEL	.015	10	8	12-18
STAINLESS	.015	10	8	15-20
CAST IRON	.015	10	8	12

NOSE RADIUS



SIDE RAKE ANGLE



SIDE RELIEF ANGLE



END RELIEF ANGLE

Tom's Techniques
COMMON SENSE MACHINING

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL $\pm 1/32$
ANGULAR: MACH $\pm 1/2^\circ$ BEND $\pm 1^\circ$
TWO PLACE DECIMAL $\pm .015$
THREE PLACE DECIMAL $\pm .005$

DRAWN
REVISED
MATERIAL
FINISH
QUANTITY

NAME

TG

DATE

3/23/14

PART NAME

FLY CUTTING TOOL

SIZE
A

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SCALE: 2:1

SHEET 1 OF 1

REV
A