NEW PREMIUM TOOL LINE!

XTERRA3™

ADVANCED VARIABLE GEOMETRY

AMERICAN MADE

GLOBALLY RENOWNED

HIGH PERFORMANCE END MILLS

FOR HIGH FEED SLOTTING & PROFILING

GLOBAL™ CUTTING TOOLS

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XTERRA3™

ADVANCED VARIABLE GEOMETRY

FOR SLOTTING & FINISHING

OF DIFFICULT TO MACHINE MATERIALS

FEATURES & BENEFITS

The 30-48 degree variable pitch helix of our Xterra3 end mill is "the" solution to impossible operations in difficult to machine materials. The industry's only variable pitch and tapered core design permits an exceptional material removal rate, making the Xterra3 perfect for maximum chip evacuation when ramping, pocketing or slotting. The odd numbers of flutes and advanced variable design minimize chatter creating smooth machining, a high shearing plane and controlled chip management.

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GLOBAL™
CUTTING TOOLS

SERIES: XT3

For high feed / material removal rate of difficult to machine materials to improve chip evacuation while ramping, pocketing or slotting; wet or dry; hardened steel, stainless steel, titanium and inconel.

Coated for heat resistance, wear resistance and increased lubricity

Three flute design improves chip formation and evacuation

Odd number of flutes reduce harmonics by staggering the entry and exit of the cutting edges

High helix angle reduces cutting forces by creating a higher shearing plane for better efficiencies, chip management and longer tool life

Corner radius option protects corners in roughing operations and difficult to machine materials by preventing corner chipping and tool failure

Eccentric relief for enhanced edge strength along the flutes

Large tapered core design for increased stability; higher speeds & feeds; and reduced tool deflection in heavy roughing operations

Premium micro-grain carbide substrate resists chipping, tool deflection, and has a high transverse rupture strength for greater feeds and speeds

Edge prep drag finishing increases tool life by improving the surface quality in the flute and radiusing the cutting edge of the tool, reducing the potential for premature failure

Post polishing is performed after the tools are coated to remove surface inconsistencies and increase lubricity. This also increases feed rates and allows for smoother operations. The tool runs cooler and performs longer

TIP & END **SHANK & LENGTH** **FLUTE CONFIGURATION** **MATERIAL** **COATING**

RESULTS

Through a focused engineering approach, the Xterra3 combines aggressive cutting with strength and stability for the most demanding operations in the most demanding materials. Operators historically had to choose between performance and tool life, but that was before the Xterra3.

Now, performance can be achieved without sacrificing tool life, part finish or machine time. The Xterra3 end mill creates opportunities to maximize productivity; where none had previously existed.

Series XT3: Micro-Grain Carbide, 3 Flute, Advanced Variable Geometry, AlTiN/Si3N4 Coated
Subseries: XT3CR
Configuration: Varying Diameters; Regular Lengths; 30-48° Variable Pitch Helix; Corner Radius

XTERRA3

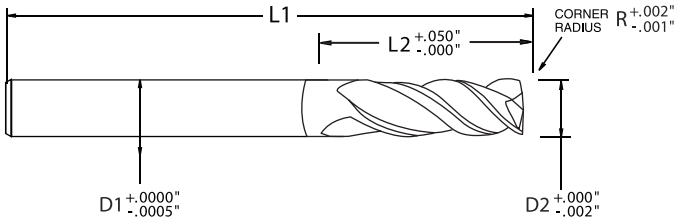
GLOBAL™

SERIES XT3 - *CARBIDE, 3 FLUTE, 30-48° VARIABLE PITCH HELIX*

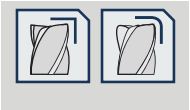
EXCEPTIONAL REMOVAL RATES

The industry's only variable pitch and tapered core design permits an exceptional material removal rate, making the Xterra3 perfect for maximum chip evacuation when ramping, pocketing or slotting.

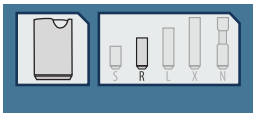
- Three flute design improves chip formation and evacuation
- High helix angle reduces cutting forces by creating a higher shearing plane for better efficiencies, chip management and longer tool life
- Corner radius option protects corners in roughing operations and difficult to machine materials by preventing corner chipping and tool failure



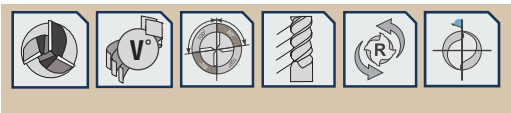
TIP & END



SHANK & LENGTH



FLUTE CONFIGURATION



MATERIAL

COATING

SERIES XT3CR - *CORNER RADIUS, REGULAR LENGTH*

SHANK DIAMETER (D1)		CUTTER DIAMETER (D2)		FLUTE LENGTH (L2)		OVERALL LENGTH (L1)		CORNER RADIUS (R)	PLAIN SHANK PART #	EDP #
1/8	0.125	1/8	0.125	3/8	0.375	2 1/2	2.500	0.015	XT3-0206-R1	X2011
3/16	0.188	3/16	0.188	5/8	0.625	2 1/2	2.500	0.015	XT3-0310-R1	X2021
1/4	0.250	1/4	0.250	7/8	0.875	2 1/2	2.500	0.020	XT3-0414-R2	X2032
5/16	0.313	5/16	0.313	7/8	0.875	2 1/2	2.500	0.030	XT3-0514-R3	X2043
3/8	0.375	3/8	0.375	1 1/8	1.125	3	3.000	0.030	XT3-0618-R3	X2053
7/16	0.438	7/16	0.438	1 1/8	1.125	3	3.000	0.030	XT3-0718-R3	X2063
1/2	0.500	1/2	0.500	1 3/8	1.375	3 1/2	3.500	0.030	XT3-0822-R3	X2073
5/8	0.625	5/8	0.625	1 5/8	1.625	3 1/2	3.500	0.040	XT3-1026-R4	X2084
3/4	0.750	3/4	0.750	1 7/8	1.875	4	4.000	0.050	XT3-1230-R5	X2095
1	1.000	1	1.000	2 3/8	2.375	5	5.000	0.060	XT3-1638-R6	X2106

SURFACE TREATMENTS & COATINGS

SELECT ADVANCED SPECIALTY COATING

SELECTING YOUR COATING

Certain applications, materials or performances simply require the enhancement of a specialty coating and knowledge of the properties of the coatings available. Temperature, friction resistance, hardness, lubricity, toughness and cohesion of the resulting process must be examined prior to the selection.

UNC	TiN	TiCN	TiAlN-X	AlTiN-X	AlTiN Si3N4	AlCrN Si3N4	ZrN	TiB2	DIA
UNCOATED	TITANIUM NITRIDE	TITANIUM CARBON NITRIDE	TITANIUM ALUMINUM NITRIDE NANO	ALUMINUM TITANIUM NITRIDE NANO	ALUMINUM TITANIUM NITRIDE/ SILICON NITRIDE	ALUMINUM CHROMIUM NITRIDE NANO	ZIRCONIUM NITRIDE	TITANIUM DIBORIDE	AMORPHOUS DIAMOND & CVD

SEE PAGES 42 - 44 FOR DETAILS

XT3 APPLICATION GUIDE • SPEED & FEED

	WORK MATERIAL	TYPE OF CUT	AXIAL DOC	RADIAL DOC	NO. OF FLUTES	SPEED (SFM)	FEED (INCHES PER TOOTH) 1/8" (3 FL)	1/4" (3 FL)	3/8" (3 FL)	1/2" (3 FL)	5/8" (3 FL)	3/4" (3 FL)	1" (3 FL)
CARBON STEEL	LOW CARBON STEELS ≤ 38 HRc 10xx; 11xx; 12xx; 12Lxx, 15xx	Slotting	1 x D	1 x D	3	410 - 490	0.0004 - 0.0006	0.0007 - 0.0011	0.0011 - 0.0017	0.0015 - 0.0023	0.0017 - 0.0027	0.0022 - 0.0034	0.0029 - 0.0045
		Roughing	1.5 x D	.5 x D	3	505 - 580	0.0005 - 0.0009	0.0008 - 0.0013	0.0012 - 0.0020	0.0016 - 0.0026	0.0020 - 0.0033	0.0024 - 0.0039	0.0031 - 0.0052
		High Effeciency (HEM)	2 x D	.2 x D	3	635 - 710	0.0007 - 0.0010	0.0013 - 0.0019	0.0019 - 0.0029	0.0024 - 0.0037	0.0030 - 0.0047	0.0037 - 0.0056	0.0049 - 0.0076
		Finishing	1.5 x D	.015 x D	3	455 - 500	0.0005 - 0.0009	0.0008 - 0.0013	0.0012 - 0.0019	0.0016 - 0.0025	0.0021 - 0.0032	0.0025 - 0.0039	0.0032 - 0.0051
	MEDIUM CARBON STEELS ≤ 38 HRc 13xx; 41xx; 43xx; 86xx, 92xx; 93xx; Chromoly	Slotting	1 x D	1 x D	3	340 - 405	0.0003 - 0.0005	0.0005 - 0.0009	0.0008 - 0.0014	0.0010 - 0.0018	0.0012 - 0.0022	0.0015 - 0.0027	0.0020 - 0.0036
		Roughing	1.5 x D	.5 x D	3	420 - 480	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0016	0.0012 - 0.0022	0.0014 - 0.0027	0.0017 - 0.0032	0.0022 - 0.0043
		High Effeciency (HEM)	2 x D	.2 x D	3	530 - 590	0.0005 - 0.0008	0.0009 - 0.0015	0.0013 - 0.0023	0.0017 - 0.0030	0.0021 - 0.0038	0.0026 - 0.0045	0.0034 - 0.0061
		Finishing	1.5 x D	.015 x D	3	305 - 335	0.0003 - 0.0007	0.0005 - 0.0010	0.0009 - 0.0016	0.0011 - 0.0020	0.0015 - 0.0026	0.0017 - 0.0031	0.0023 - 0.0042
TOOL STEEL	TOOL & DIE STEELS ≤ 38 HRc A2; A3; D2; H11; H13; M1; O-1; S-7; NAK 55	Slotting	1 x D	1 x D	3	220 - 260	0.0003 - 0.0005	0.0005 - 0.0009	0.0008 - 0.0014	0.0010 - 0.0018	0.0012 - 0.0022	0.0015 - 0.0027	0.0020 - 0.0036
		Roughing	1.5 x D	.5 x D	3	270 - 310	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0016	0.0012 - 0.0022	0.0014 - 0.0027	0.0017 - 0.0032	0.0022 - 0.0043
		High Effeciency (HEM)	2 x D	.2 x D	3	340 - 380	0.0005 - 0.0008	0.0009 - 0.0015	0.0013 - 0.0023	0.0017 - 0.0030	0.0021 - 0.0038	0.0026 - 0.0045	0.0034 - 0.0061
		Finishing	1.5 x D	.015 x D	3	225 - 245	0.0003 - 0.0007	0.0005 - 0.0010	0.0009 - 0.0016	0.0011 - 0.0020	0.0015 - 0.0026	0.0017 - 0.0031	0.0023 - 0.0042
	TOOL & DIE STEELS 39 to 48 HRc P20; P21; S-136; PX-5; NAK 80	Slotting	.75 x D	1 x D	3	205 - 245	0.0003 - 0.0005	0.0004 - 0.0008	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0013 - 0.0025	0.0018 - 0.0034
		Roughing	1.5 x D	.3 x D	3	255 - 290	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	2 x D	.15 x D	3	320 - 358	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0018 - 0.0035	0.0023 - 0.0042	0.0030 - 0.0057
		Finishing	1.5 x D	.015 x D	3	210 - 230	0.0004 - 0.0008	0.0006 - 0.0011	0.0010 - 0.0017	0.0012 - 0.0021	0.0016 - 0.0027	0.0019 - 0.0033	0.0025 - 0.0044
HARDENED STEEL	HARDENED STEELS 48 to 57 HRc	Slotting	1 x D	1 x D	3	195 - 230	0.0003 - 0.0005	0.0004 - 0.0008	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0013 - 0.0025	0.0018 - 0.0034
		Roughing	1.5 x D	.5 x D	3	240 - 275	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	2 x D	.2 x D	3	300 - 336	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0018 - 0.0035	0.0023 - 0.0042	0.0030 - 0.0057
		Finishing	1.5 x D	.015 x D	3	195 - 210	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0015	0.0010 - 0.0019	0.0013 - 0.0024	0.0015 - 0.0029	0.0020 - 0.0039
	HARDENED STEELS 58 to 65HRc	Slotting	.75 x D	1 x D	3	180 - 215	0.0002 - 0.0004	0.0004 - 0.0008	0.0006 - 0.0012	0.0007 - 0.0015	0.0008 - 0.0018	0.0011 - 0.0023	0.0014 - 0.0030
		Roughing	1.5 x D	.3 x D	3	220 - 250	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0014	0.0008 - 0.0018	0.0009 - 0.0022	0.0012 - 0.0027	0.0015 - 0.0036
		High Effeciency (HEM)	2 x D	.15 x D	3	280 - 314	0.0004 - 0.0007	0.0007 - 0.0013	0.0009 - 0.0019	0.0012 - 0.0025	0.0014 - 0.0031	0.0018 - 0.0037	0.0024 - 0.0051
		Finishing	1.5 x D	.015 x D	3	180 - 195	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0013	0.0008 - 0.0017	0.0010 - 0.0021	0.0012 - 0.0026	0.0016 - 0.0035
STAINLESS STEEL	EASY TO MACHINE 72 - 85 HRb 410; 416; 420; 430F; 440C; 302; 303	Slotting	.75 x D	1 x D	3	315 - 375	0.0003 - 0.0005	0.0006 - 0.0010	0.0009 - 0.0015	0.0011 - 0.0019	0.0013 - 0.0023	0.0017 - 0.0029	0.0023 - 0.0039
		Roughing	1.25 x D	.3 x D	3	390 - 445	0.0004 - 0.0008	0.0006 - 0.0011	0.0009 - 0.0017	0.0013 - 0.0023	0.0015 - 0.0028	0.0019 - 0.0034	0.0024 - 0.0045
		High Effeciency (HEM)	2 x D	.15 x D	3	490 - 545	0.0006 - 0.0009	0.0010 - 0.0016	0.0015 - 0.0025	0.0019 - 0.0032	0.0023 - 0.0040	0.0029 - 0.0048	0.0038 - 0.0065
		Finishing	1.5 x D	.015 x D	3	340 - 370	0.0004 - 0.0008	0.0006 - 0.0011	0.0010 - 0.0017	0.0012 - 0.0021	0.0016 - 0.0027	0.0019 - 0.0033	0.0025 - 0.0044
	MODERATELY DIFFICULT 79 - 85 HRb; 25 - 41 HRc 304; 304L; 316; 316L; 320; 321; 347; Invar 36; Kovar	Slotting	.75 x D	1 x D	3	285 - 340	0.0003 - 0.0005	0.0004 - 0.0008	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0013 - 0.0025	0.0018 - 0.0034
		Roughing	1.25 x D	.3 x D	3	350 - 400	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	2 x D	.1 x D	3	440 - 490	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0018 - 0.0035	0.0023 - 0.0042	0.0030 - 0.0057
		Finishing	1.5 x D	.01 x D	3	305 - 335	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0015	0.0010 - 0.0019	0.0013 - 0.0024	0.0015 - 0.0029	0.0020 - 0.0039
	DIFFICULT TO MACHINE 31 - 50 HRc 13-8 PH; 15-5 PH; 17-4 PH; Carpenter; Custo 465; Invar	Slotting	.5 x D	1 x D	3	225 - 270	0.0003 - 0.0005	0.0004 - 0.0008	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0013 - 0.0025	0.0018 - 0.0034
		Roughing	1.25 x D	.3 x D	3	280 - 320	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	1.5 x D	.1 x D	3	350 - 391	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0018 - 0.0035	0.0023 - 0.0042	0.0030 - 0.0057
		Finishing	1.5 x D	.01 x D	3	235 - 255	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0015	0.0010 - 0.0019	0.0013 - 0.0024	0.0015 - 0.0029	0.0020 - 0.0039
CAST IRON	GRAY 100 - 200 HRb	Slotting	1 x D	1 x D	3	315 - 360	0.0003 - 0.0005	0.0005 - 0.0009	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0014 - 0.0026	0.0018 - 0.0034
		Roughing	1.5 x D	.5 x D	3	390 - 445	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	2 x D	.2 x D	3	490 - 545	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0019 - 0.0036	0.0023 - 0.0042	0.0031 - 0.0058
		Finishing	1.5 x D	.015 x D	3	380 - 415	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0015	0.0010 - 0.0019	0.0013 - 0.0024	0.0016 - 0.0030	0.0020 - 0.0039
	DUCTILE 150 - 300 HRb	Slotting	1 x D	1 x D	3	300 - 345	0.0002 - 0.0004	0.0004 - 0.0008	0.0006 - 0.0012	0.0007 - 0.0015	0.0008 - 0.0018	0.0011 - 0.0023	0.0014 - 0.0030
		Roughing	1.5 x D	.5 x D	3	370 - 425	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0014	0.0008 - 0.0018	0.0009 - 0.0022	0.0012 - 0.0027	0.0015 - 0.0036
		High Effeciency (HEM)	2 x D	.2 x D	3	465 - 520	0.0004 - 0.0007	0.0007 - 0.0013	0.0009 - 0.0019	0.0012 - 0.0025	0.0014 - 0.0031	0.0018 - 0.0037	0.0024 - 0.0051
		Finishing	1.5 x D	.015 x D	3	360 - 395	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0013	0.0008 - 0.0017	0.0010 - 0.0021	0.0012 - 0.0026	0.0016 - 0.0035
	MALLEABLE 150 - 310 HRb	Slotting	.75 x D	1 x D	3	220 - 260	0.0002 - 0.0004	0.0004 - 0.0008	0.0006 - 0.0012	0.0007 - 0.0015	0.0008 - 0.0018	0.0011 - 0.0023	0.0014 - 0.0030
		Roughing	1.5 x D	.5 x D	3	270 - 310	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0014	0.0008 - 0.0018	0.0009 - 0.0022	0.0012 - 0.0027	0.0015 - 0.0036
		High Effeciency (HEM)	2 x D	.2 x D	3	340 - 380	0.0004 - 0.0007	0.0007 - 0.0013	0.0009 - 0.0019	0.0012 - 0.0025	0.0014 - 0.0031	0.0018 - 0.0037	0.0024 - 0.0051
		Finishing	1.5 x D	.015 x D	3	225 - 245	0.0003 - 0.0007	0.0004 - 0.0009	0.0006 - 0.0013	0.0008 - 0.0017	0.0010 - 0.0021	0.0012 - 0.0026	0.0016 - 0.0035
ALLOYS	TITANIUM ALLOYS 70 - 100 HRb; 25 - 36 HRc Ti61AL4V; Grades 5-38	Slotting	.5 x D	1 x D	3	120 - 160	0.0003 - 0.0005	0.0004 - 0.0008	0.0007 - 0.0013	0.0009 - 0.0017	0.0010 - 0.0020	0.0013 - 0.0025	0.0018 - 0.0034
		Roughing	1.25 x D	.3 x D	3	205 - 275	0.0003 - 0.0007	0.0005 - 0.0010	0.0007 - 0.0015	0.0010 - 0.0020	0.0012 - 0.0025	0.0015 - 0.0030	0.0019 - 0.0040
		High Effeciency (HEM)	1.5 x D	.1 x D	3	275 - 310	0.0005 - 0.0008	0.0008 - 0.0014	0.0012 - 0.0022	0.0015 - 0.0028	0.0018 - 0.0035	0.0023 - 0.0042	0.0030 - 0.0057
		Finishing	1.5 x D	.01 x D	3	200 - 240	0.0003 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0015	0.0010 - 0.0019	0.0013 - 0.0024	0.0015 - 0.0029	0.0020 - 0.0039
	HIGH TEMP ALLOYS 83 - 99 HRb; 30 - 52 HRc Inconel; Monel; A286; Rene; Stelite; Haynes; Waspalloy; Hastalloy; etc	Slotting	.25 x D	1 x D	3	50 - 65	0.0002 - 0.0004	0.0003 - 0.0007	0.0004 - 0.0010	0.0005 - 0.0013	0.0006 - 0.0016	0.0008 - 0.0020	0.0010 - 0.0026
		Roughing	1.25 x D	.25 x D	3	80 - 105	0.0002 - 0.0006	0.0003 - 0.0008	0.0004 - 0.0012	0.0006 - 0.0016	0.0007 - 0.0020	0.0009 - 0.0024	0.0011 - 0.0032
		High Effeciency (HEM)	1.5 x D	.1 x D	3	120 - 135	0.0003 - 0.0006	0.0005 - 0.0011	0.0007 - 0.0017	0.0009 - 0.0022	0.0011 - 0.0028	0.0014 - 0.0033	0.0018 - 0.0045
		Finishing	1.5 x D	.01 x D	3	60 - 70	0.0002 - 0.0006	0.0003 - 0.0008	0.0005 - 0.0012	0.0006 - 0.0015	0.0008 - 0.0019	0.0009 - 0.0023	0.0012 - 0.0031

D = tool diameter • Reduce feed rates by 20% when using long length tools • Use reduced neck tooling for long reach slotting • Starting parameters shown

CONICAL™ CUTTING TOOLS

GLOBAL™ CUTTING TOOLS

70 YEARS OF INNOVATION

XTERRA3™
ADVANCED VARIABLE GEOMETRY

EXCEPTIONALLY POWERFUL

Global delivers an exceptionally powerful, solution-in-a-tool for difficult operations, with the Xterra3. The Xterra3 features the industry's only variable pitch and tapered core design, for unimaginable chip evacuation, when ramping, pocketing, or slotting. There is no room for errors and no second chances, so do it right the first time, with Xterra3 end mills. It's the right tool for setup time spent with confidence high.

If difficult to machine materials are required, the Xterra3 will do the work; demonstrating precision and meeting new deadlines. Durability, strength and a focus on research and development; have equipped the Xterra3 with the endurance to excel at any job. The odd number of flutes and advanced variable design command minimal chatter and maximize a smooth finish, even in the most difficult to machine materials.

PROGRESS WITH THE RESULTS TO PROVE IT

Global cutting tools have 7 decades of innovation, persistence and dedication and we know our progress is only measured by the results of our customers. Each Xterra3 end mill brings something to our customer that represents our company's intelligent design and genuine devotion to the industry. We strive for a mastery of end mill development, with each new tool we offer, while reaching for every corner of the market. Contact us today for pricing on your next order.

Global Cutting Tools
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