

HOUGEN® CUTTER COMPARISON CHART

| Tool Series: |  |  |  |  |  |  |  |  |
|--------------------------------------|---|---|---|--|---|---|---|---|
| Diameter Range Min. / Max. | 1/4" to 1-1/2" (6mm - 25mm) | 3/8" to 9/16" | 11/16" to 3" | 11/16" to 3" | 1/2" to 1-1/16" (12mm - 27mm) | 1/2" to 1-3/8" (12mm - 35mm) | 7/16" to 3-1/16" (12mm - 77mm) | 9/16" to 2" (14mm - 60mm) |
| Max. Depth of Cut | 1/4" to 1/2" (6.4mm - 12.7mm) | 1/4" (6.4mm) | 1/8" (3.2mm) | 1/8" (3.2mm) | 3/4" - (19mm) Stack Geometry | 1" - (25mm) Stack Geometry | 1" to 6" (25mm to 152mm) | 1" to 4" (25mm to 102mm) |
| Mounting | 3/8" or 1/2" Triple Flat Shank | 3/8" Triple Flat Shank | 3/8" Triple Flat Shank | 3/8" or 1/2" Triple Flat Shank | Bayonet Style | Bayonet Style | 3/4" Double Flat or Fusion2™ Shank | 3/4" Fusion2™ Shank |
| Cutter Material(s) Available | M2 HSS | M2 HSS | M2 HSS | Carbide Tip | M42 HSS | M42 HSS | M2 HSS, M2 TIN Coat, or M42 TIN | Carbide Tip |
| Can be Resharpened | ===== Disposable ===== | | | | | | | |
| Available Grind Down (Within Limits) |  | | | |  |  |  | |
| Max. Application Hardness Rating | 275 BHN (28.5 HRC) | 275 BHN (28.5 HRC) | 275 BHN (28.5 HRC) | 450 BHN (47.2 HRC) | 350 BHN (37.7 HRC) | 350 BHN (37.7 HRC) | 275 BHN 325 BHN (TIN) | 450 BHN (47.2 HRC) |
| Recommended Lubrication | Slick-Stik™ | Slick-Stik™ | Slick-Stik™ | Slick-Stik™ | Slick-Stik™ | Slick-Stik™ | Rotamagic™ | Rotamagic™ |
| Aluminum | ===== High RPM & Fast Feed Rates Suggested ===== | | | | | | | |
| Mild Steel |  |  |  |  |  |  |  |  |
| Harder Steel | | Good | |  | Better | Better | Standard - Good TIN - Better |  |
| Stainless Steel | Good | | Recommend Speed Reducer |  | Good | | TIN Coat or Premium Recommended |  |