



Power. Precision. Performance.

Put **POWER** back in
traditional tool paths

THE NEW
POW • R • FEED
M934

HIGHER FEEDS
FASTER CYCLES
BETTER PROFITS



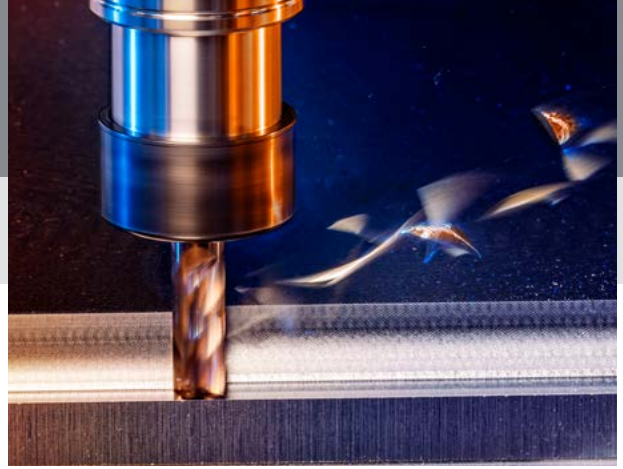
NEW from IMCO

POW • R • FEED M934

If you're cutting in traditional tool paths and looking for faster, better or longer end mill performance -- look no further than the POW-R-FEED M934.

The POW-R-FEED M934 is the latest extension of IMCO's POW-R-FEED M9 line. With a revolutionary breakthrough in cutting tool geometry, plus the reliability of IMCO's super-slippery AlTiSN coating – this tool provides the clog-free cutting needed to maximize your feed rates, reduce cycle times and increase your profits.

Whatever you operate – from low-horsepower equipment to five-axis machines and everything in between – these IMCO cutters are built to give you consistently peak production levels.



Available with

- Square end or a wide variety of radii options
- Fractional or metric sizes
- Cylindrical shank or Weldon flat
- Necked options (LBS)

MADE IN THE USA

POW • R • FEED M934 FEATURES

- 1 Proprietary end geometries allow for **extremely aggressive ramping and helical entry parameters, step-overs and depths**
- 2 Variable helix angle to help achieve **long tool life**
- 3 Variable index for reduced chatter, provides **superior balance, super-stable performance**
- 4 Extra-fine cutting edges for **prolonged life**
- 5 Wiper flat for **superior floor finishes**
- 6 Unique flute and core geometries for **amazing metal removal rates** and the free-est cutting action in the toughest materials
- 7 Ultra-modern AlTiSN coating for super lubricity and **great chip evacuation**
- 8 Super-tough carbide grade for **incredible tool life**



For use in:

P

STEELS

M

STAINLESS STEEL

K

CAST IRON

N

ALUMINUM

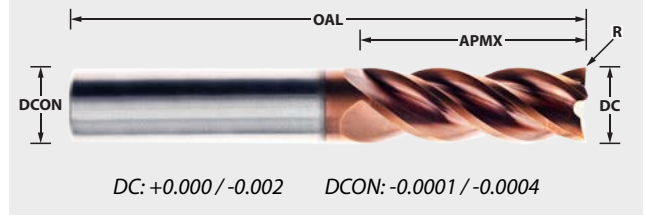
S

TITANIUM

H

HARDENED STEELS

POW•R•FEED M934



For high-performance machining in a wide variety of materials. A true workhorse end mill.

The POW-R-FEED M934 excels at helical entry, ramping, slotting and peripheral milling. It's incredibly versatile, excelling in roughing, slotting and finishing using traditional tool paths.

FRACTIONAL/IN

| DC Cutter Dia | DCON Shank Dia | APMX Length of Cut | OAL Overall Length | Item Number | | | | | | | | |
|------------------|-------------------|-----------------------|-----------------------|-------------|---------|---------|---------|---------|---------|---------|---------|---------|
| | | | | SQ | .010 CR | .015 CR | .030 CR | .060 CR | .090 CR | .125 CR | .190 CR | .250 CR |
| 1/8 | 1/8 | 1/4 | 1-1/2 | 9176722 | 9176724 | 9176731 | 9176742 | - | - | - | - | - |
| | | 1/2 | 1-1/2 | 9176744 | 9176746 | 9176747 | 9176748 | - | - | - | - | - |
| 5/32 | 3/16 | 5/16 | 2 | 9176753 | 9176754 | 9176755 | 9176756 | - | - | - | - | - |
| | | 9/16 | 2 | 9176757 | 9176758 | 9176759 | 9176760 | - | - | - | - | - |
| 3/16 | 3/16 | 5/16 | 2 | 9176761 | 9176762 | 9176763 | 9176764 | - | - | - | - | - |
| | | 9/16 | 2 | 9176765 | 9176766 | 9176767 | 9176768 | - | - | - | - | - |
| | | 3/4 | 2-1/2 | 9176769 | 9176770 | 9176771 | 9176772 | - | - | - | - | - |
| 7/32 | 1/4 | 3/8 | 2 | 9176773 | 9176774 | 9176775 | - | - | - | - | - | - |
| | | 3/4 | 2-1/2 | 9176776 | 9176777 | 9176778 | - | - | - | - | - | - |
| 1/4 | 1/4 | 3/8 | 2 | 9176779 | 9176780 | 9176781 | 9176782 | 9176783 | - | - | - | - |
| | | 1/2 | 2-1/2 | 9176784 | 9176785 | 9176786 | 9176787 | 9176788 | - | - | - | - |
| | | 3/4 | 2-1/2 | 9176789 | 9176790 | 9176791 | 9176792 | 9176793 | - | - | - | - |
| | | 1 | 3 | 9176794 | 9176795 | 9176796 | 9176797 | 9176798 | - | - | - | - |
| 5/16 | 5/16 | 7/16 | 2 | 9176799 | - | 9176800 | 9176801 | - | - | - | - | - |
| | | 13/16 | 2-1/2 | 9176802 | - | 9176803 | 9176804 | 9176805 | - | - | - | - |
| | | 1-1/4 | 3 | 9176807 | - | 9176808 | 9176809 | 9176811 | - | - | - | - |
| 3/8 | 3/8 | 1/2 | 2 | 9176812 | 9176813 | 9176814 | 9176815 | 9176816 | 9176817 | 9176818 | - | - |
| | | 1 | 2-1/2 | 9176819 | 9176820 | 9176821 | 9176822 | 9176823 | 9176824 | 9176825 | - | - |
| | | 1-1/4 | 3 | 9176826 | 9176827 | 9176828 | 9176829 | 9176831 | 9176832 | 9176833 | - | - |
| | | 1-1/2 | 3-1/2 | 9176836 | 9176837 | 9176838 | 9176839 | 9176840 | 9176841 | 9176842 | - | - |
| 7/16 | 7/16 | 5/8 | 2-1/2 | 9176843 | - | 9176844 | 9176845 | - | - | - | - | - |
| | | 7/8 | 2-3/4 | 9176846 | - | 9176847 | 9176848 | - | - | - | - | - |
| | | 1-1/2 | 3-1/2 | 9179368 | - | 9179369 | - | - | - | - | - | - |
| 1/2 | 1/2 | 5/8 | 2-1/2 | 9176850 | 9176851 | 9176852 | 9176853 | 9176854 | 9176855 | 9176856 | - | - |
| | | 1 | 3 | 9176857 | 9176858 | 9176859 | 9176860 | 9176861 | 9176862 | 9176863 | - | - |
| | | 1-1/4 | 3 | 9176864 | 9176865 | 9176866 | 9176867 | 9176868 | 9176869 | 9176870 | 9176871 | - |
| | | 1-1/2 | 3-1/2 | 9176872 | 9176873 | 9176878 | 9176879 | 9176880 | 9176881 | 9176882 | 9176883 | - |
| | | 1-3/4 | 4 | 9176893 | 9176894 | 9176897 | 9176898 | 9176899 | 9176900 | 9176901 | - | - |
| | | 2 | 4 | 9176902 | 9176903 | 9176904 | 9176905 | 9176906 | 9176907 | 9176908 | 9176909 | - |
| 5/8 | 5/8 | 3/4 | 3 | 9176918 | - | 9176920 | 9176921 | 9176922 | - | 9176923 | - | - |
| | | 1-1/4 | 3-1/2 | 9176924 | - | 9176925 | 9176926 | 9176927 | 9176928 | 9176929 | - | - |
| | | 1-5/8 | 3-1/2 | 9176930 | - | 9176931 | 9176932 | 9176933 | 9176934 | 9176935 | 9176936 | - |
| | | 2-3/16 | 4 | 9176937 | - | 9176938 | 9176939 | 9176940 | - | - | - | - |
| 3/4 | 3/4 | 1 | 3 | 9176941 | - | 9176942 | 9176943 | 9176944 | 9176945 | 9176946 | 9176947 | 9176948 |
| | | 1-1/4 | 4 | 9179384 | - | 9179385 | 9179386 | 9179387 | 9179388 | 9179389 | 9179390 | 9179391 |
| | | 1-5/8 | 4 | 9176949 | - | 9176950 | 9176951 | 9176952 | 9176953 | 9176954 | 9176955 | 9176956 |
| | | 2-1/4 | 5 | 9176957 | - | 9176958 | 9176960 | 9176961 | 9176962 | 9176963 | 9176964 | 9176965 |
| | | 2-3/4 | 5 | 9176966 | - | 9176967 | 9176968 | 9176969 | 9176970 | 9176971 | - | - |
| 1 | 1 | 1-5/8 | 4 | 9176972 | - | 9176973 | 9176974 | 9176975 | - | 9176976 | - | 9176977 |
| | | 2 | 4-1/2 | 9176978 | - | 9176979 | 9176980 | 9176981 | - | 9176983 | - | 9176984 |
| | | 2-5/8 | 5 | 9176985 | - | 9176986 | 9176987 | 9176988 | - | 9176989 | - | 9176990 |
| | | 3-1/4 | 6 | 9179400 | - | - | 9179401 | - | - | - | - | - |

Scan for dynamic speed and feed information



Access POW•R•FEED M934 speed and feed charts by scanning this QR code

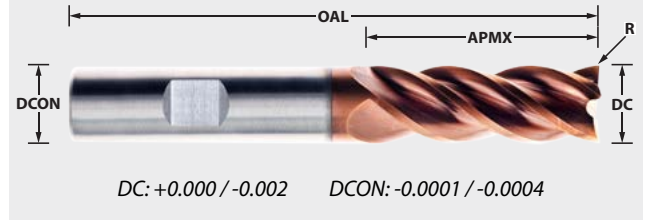


POW•R•FEED M934 W/WELDON FLAT



For high-performance machining in a wide variety of materials. A true workhorse end mill.

The Weldon flat on the POW-R-FEED M934 enhances stability in the tool holder, whether roughing, ramping, slotting or finishing. An added line of defense in resisting axial forces that cause pullout.



FRACTIONAL/IN

| DC Cutter Dia | DCON Shank Dia | APMX Length of Cut | OAL Overall Length | Item Number | | |
|------------------|-------------------|-----------------------|-----------------------|-------------|---------|---------|
| | | | | SQ | .015 CR | .030 CR |
| 1/4 | 1/4 | 3/8 | 2 | 9180244 | 9180245 | 9180246 |
| | | 1/2 | 2-1/2 | 9180247 | 9180248 | 9180249 |
| | | 3/4 | 2-1/2 | 9180250 | 9180251 | 9180252 |
| | | 1 | 3 | 9180253 | 9180254 | 9180255 |
| 3/8 | 3/8 | 1/2 | 2 | 9177008 | 9177010 | 9177011 |
| | | 1 | 2-1/2 | 9177015 | 9177017 | 9177018 |
| | | 1-1/4 | 3 | 9177022 | 9177024 | 9177025 |
| | | 1-1/2 | 3-1/2 | 9177029 | 9177031 | 9177032 |
| 1/2 | 1/2 | 1 | 3 | 9177044 | 9177047 | 9177048 |
| | | 1-1/4 | 3 | 9177052 | 9177054 | 9177055 |
| | | 1-1/2 | 3-1/2 | 9177060 | 9177062 | 9177063 |
| | | 1-3/4 | 4 | 9177068 | 9177071 | 9177072 |
| 5/8 | 5/8 | 2 | 4 | 9177076 | 9177078 | 9177079 |
| | | 1-5/8 | 3-1/2 | 9177101 | - | 9177104 |
| 3/4 | 3/4 | 2-3/16 | 4 | 9177110 | - | 9177112 |
| | | 1-5/8 | 4 | 9177122 | - | 9177124 |
| 1 | 1 | 2-1/4 | 5 | 9177130 | - | 9177132 |
| | | 2-3/4 | 5 | 9177138 | - | 9177140 |
| 1 | 1 | 1-5/8 | 4 | 9177145 | - | 9177147 |
| | | 2-5/8 | 5 | 9177158 | - | 9177160 |

Scan for dynamic speed and feed information



Access POW•R•FEED M934 speed and feed charts by scanning this QR code:

INCH



TECH TALK | HELICAL OR PLUNGE ENTRY?

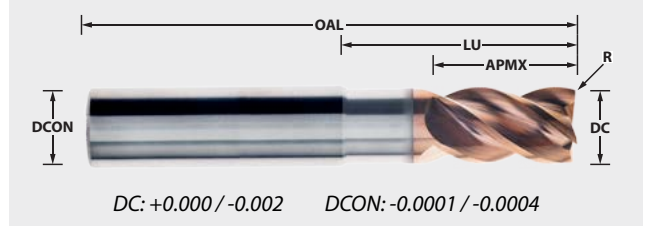
These 2" x 2" pockets were machined using the same strategy and RDOC value, but a different entry method. Pocket A was machined with a helical entry ramping at 2.5 deg., a common ramp angle for our M924 mills and many competitors' high-performance end mills. Pocket B was made by plunging straight into the center of the pocket at 90 deg. and then machining outward.

The time savings (41%) with being able to enter a closed pocket is significant. Parts often have many closed pockets to machine, and the entry method affects cycle time in a **big way**.

A. Helical entry
Machining time = 1 min., 18 sec.

B. Plunge entry
Machining time = 46 sec.

POW•R•FEED M934N



For high-performance machining in a wide variety of materials. A true workhorse end mill.

Adding a neck to the POW-R-FEED M934 shank provides a longer reach and extra room to move in tight spaces when slotting or pocketing.

FRACTIONAL/IN

| DC Cutter Dia | DCON Shank Dia | APMX Length of Cut | LU Reach | OAL Overall Length | Item Number | | |
|------------------|-------------------|-----------------------|-------------|-----------------------|-------------|---------|---------|
| | | | | | SQ | .015 CR | .030 CR |
| 1/8 | 1/8 | 1/4 | 1-1/8 | 2-1/2 | 9180348 | 9180349 | - |
| 3/16 | 3/16 | 3/8 | 1-3/8 | 3 | 9180350 | 9180351 | - |
| 1/4 | 1/4 | 1/2 | 1-3/8 | 3 | 9180352 | 9180353 | 9180354 |
| | | 1/2 | 2-3/8 | 4 | 9180355 | 9180356 | 9180357 |
| 3/8 | 3/8 | 1/2 | 1-3/8 | 3 | 9180358 | 9180359 | 9180360 |
| | | 1/2 | 2-3/8 | 4 | 9180361 | 9180362 | 9180363 |
| | | 1/2 | 3-3/8 | 5 | 9180364 | 9180365 | 9180366 |
| | | 3/4 | 2-3/8 | 4 | 9180367 | 9180368 | 9180369 |
| | | 3/4 | 3-3/8 | 5 | 9180370 | 9180371 | 9180372 |
| | | 3/4 | 4-3/8 | 6 | 9180373 | 9180374 | 9180375 |
| | | 5/8 | 1-3/8 | 3 | 9180376 | 9180377 | 9180378 |
| | | 5/8 | 2-1/4 | 4 | 9180379 | 9180380 | 9180381 |
| 1/2 | 1/2 | 5/8 | 3-1/4 | 5 | 9180382 | 9180383 | 9180384 |
| | | 1 | 2-1/4 | 4 | 9180385 | 9180386 | 9180387 |
| | | 1 | 3-1/4 | 5 | 9180388 | 9180389 | 9180390 |
| | | 1 | 4-1/4 | 6 | 9180391 | 9180392 | 9180393 |
| | | 3/4 | 2-1/8 | 4 | 9180394 | - | 9180395 |
| 5/8 | 5/8 | 3/4 | 3-1/8 | 5 | 9180396 | - | 9180397 |
| | | 1-1/4 | 3-1/8 | 5 | 9180398 | - | 9180399 |
| | | 1-1/4 | 4-1/8 | 6 | 9180443 | - | 9180444 |
| | | 1 | 2-7/8 | 5 | 9180445 | - | 9180446 |
| 3/4 | 3/4 | 1 | 3-7/8 | 6 | 9180447 | - | 9180448 |
| | | 1-1/2 | 2-7/8 | 5 | 9180449 | - | 9180450 |
| | | 1-1/2 | 3-7/8 | 6 | 9180451 | - | 9180452 |
| | | 1-1/2 | 4-7/8 | 7 | 9180453 | - | 9180454 |

For this bracket, plunging straight into the piece for three slot features and then slot milling each to length cut cycle time significantly. The round bore in the standing boss was machined by plunging straight in, then opening it to the print diameter. Using a competitor's tool (all other parameters being equal), cycle time was 20 min. and 10 sec. This same part made with the new M934 took just **16 min., 8 sec.**, cutting cycle time nearly 25%.

| Tool | Operation | End Mill Dia. | SFM | RPM | IPR | IPM | Axial | Radial |
|------|--------------|---------------|-----|------|--------|-------|-------|--------|
| M934 | Perip. Rough | 0.5 | 325 | 2483 | 0.003 | 29.8 | 0.625 | 0.24 |
| M934 | Finish | 0.5 | 410 | 3132 | 0.0033 | 41.3 | 1 | 0.0075 |
| M934 | Slot | 0.5 | 290 | 2216 | 0.0021 | 18.6 | 0.625 | 0.5 |
| M934 | Plunge Entry | 0.5 | 290 | 2216 | 0.0014 | 25.6 | 0.5 | 0.5 |
| A108 | Corner Break | 0.5 | 580 | 4431 | 0.004 | 141.8 | 0.03 | 0.03 |



With competitor's tool
Cycle time = 20 min., 10 sec.

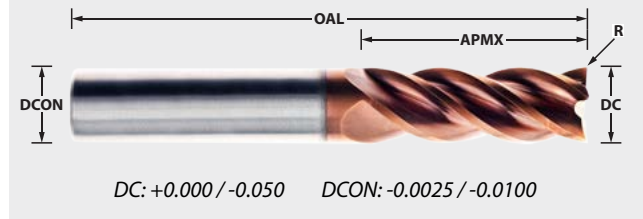
With POW-R-FEED M934
Cycle time = 16 min. 8 sec.

POW•R•FEED M934



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METRIC

| DC Cutter Dia | DCON Shank Dia | APMX Length of Cut | OAL Overall Length | Item Number | | | | | | | | | |
|------------------|-------------------|-----------------------|-----------------------|-------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| | | | | SQ | 0.3 CR | 0.5 CR | 0.75 CR | 1.0 CR | 1.5 CR | 2.0 CR | 2.5 CR | 3.0 CR | 4.0 CR |
| 3 | 6 | 8 | 57 | 9179778 | 9179779 | 9180457 | - | - | - | - | - | - | - |
| | | 11 | 57 | 9179780 | 9179781 | 9180458 | - | - | - | - | - | - | - |
| | | 14 | 57 | 9179782 | 9179783 | 9180459 | - | - | - | - | - | - | - |
| 4 | 6 | 10 | 57 | 9179784 | 9179785 | 9179786 | - | - | - | - | - | - | - |
| | | 14 | 57 | 9179787 | 9179788 | 9179789 | - | - | - | - | - | - | - |
| | | 18 | 57 | 9179790 | 9179791 | 9179792 | - | - | - | - | - | - | - |
| 5 | 6 | 12 | 57 | 9179793 | 9179794 | 9179795 | - | - | - | - | - | - | - |
| | | 17 | 57 | 9179796 | 9179797 | 9179798 | - | - | - | - | - | - | - |
| | | 22 | 57 | 9179799 | 9179800 | 9179801 | - | - | - | - | - | - | - |
| 6 | 6 | 14 | 57 | 9179802 | 9179803 | 9179804 | - | 9179805 | 9179806 | - | - | - | - |
| | | 20 | 57 | 9179807 | 9179808 | 9179809 | - | 9179810 | 9179811 | - | - | - | - |
| | | 26 | 63 | 9179812 | 9179813 | 9179814 | - | 9179815 | 9179816 | - | - | - | - |
| 8 | 8 | 18 | 63 | 9179817 | 9179819 | 9179820 | - | 9179821 | 9179822 | 9179823 | - | - | - |
| | | 26 | 63 | 9179824 | 9179825 | 9179826 | 9179914 | 9179827 | 9179828 | 9179829 | - | - | - |
| | | 34 | 75 | 9179830 | - | 9179831 | - | 9179832 | 9179833 | 9179834 | - | - | - |
| 10 | 10 | 22 | 72 | 9179835 | 9179836 | 9179837 | 9179915 | 9179838 | 9179839 | 9179840 | - | - | - |
| | | 32 | 75 | 9179841 | - | 9179842 | - | 9179843 | 9179844 | 9179845 | - | - | - |
| | | 42 | 88 | 9179846 | - | 9179847 | - | 9179848 | 9179849 | 9179850 | - | - | - |
| 12 | 12 | 26 | 83 | 9179851 | 9179852 | 9179853 | 9179916 | 9179854 | 9179855 | 9179856 | 9179857 | 9179858 | 9179859 |
| | | 38 | 93 | 9179860 | - | 9179861 | - | 9179862 | 9179863 | 9179864 | 9179865 | 9179866 | 9179867 |
| | | 50 | 100 | 9179868 | - | 9179869 | - | 9179870 | 9179871 | 9179872 | 9179873 | 9179874 | 9179875 |
| 16 | 16 | 34 | 92 | 9179876 | - | 9179877 | - | 9179878 | 9179879 | 9179880 | 9179881 | 9179882 | 9179883 |
| | | 50 | 110 | 9179884 | - | 9179885 | - | 9179886 | 9179887 | 9179888 | 9179889 | 9179890 | 9179891 |
| | | 66 | 125 | 9179892 | - | 9179893 | - | 9179894 | 9179895 | 9179896 | 9179897 | 9179898 | 9179899 |
| 20 | 20 | 42 | 104 | 9179900 | - | - | - | 9179901 | 9179902 | 9179903 | 9179904 | 9179905 | 9179906 |
| | | 62 | 125 | 9179907 | - | - | - | 9179908 | 9179909 | 9179910 | 9179911 | 9179912 | 9179913 |

Weldon flat available upon request.

TOOL TIP | SAVE ON TOOL INVENTORY



POW-R-FEED M934 four-flute end mills are very versatile, doing the easy legacy tasks most four-flute cutters can perform, in addition to extremely aggressive cuts that legacy tools can't. M934 excels at ramping and helical entry, performing far better than competitors' four-flute lines. This multifaceted "pyramid" piece in titanium 6AL 4V was cut with a POW-R-FEED M934 four-flute end mill. The M934 did it all: helical entry, peripheral roughing, facing and milling.

Scan for dynamic speed and feed information

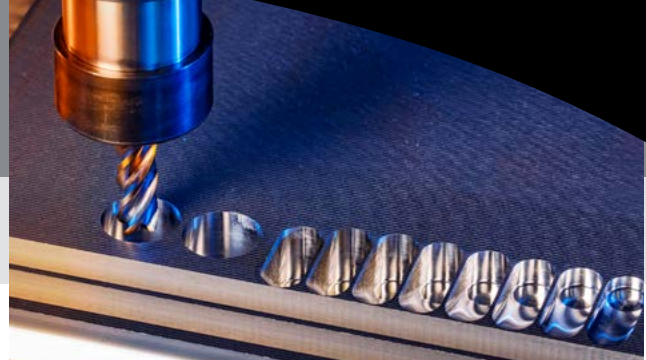


Access POW-R-FEED M934 speed and feed charts by scanning this QR code

METRIC

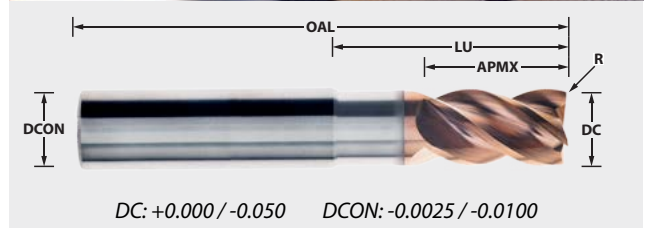


POW•R•FEED M934N



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Adding a neck to the POW-R-FEED M934 shank provides a longer reach and extra room to move in tight spaces when slotting or pocketing.



METRIC

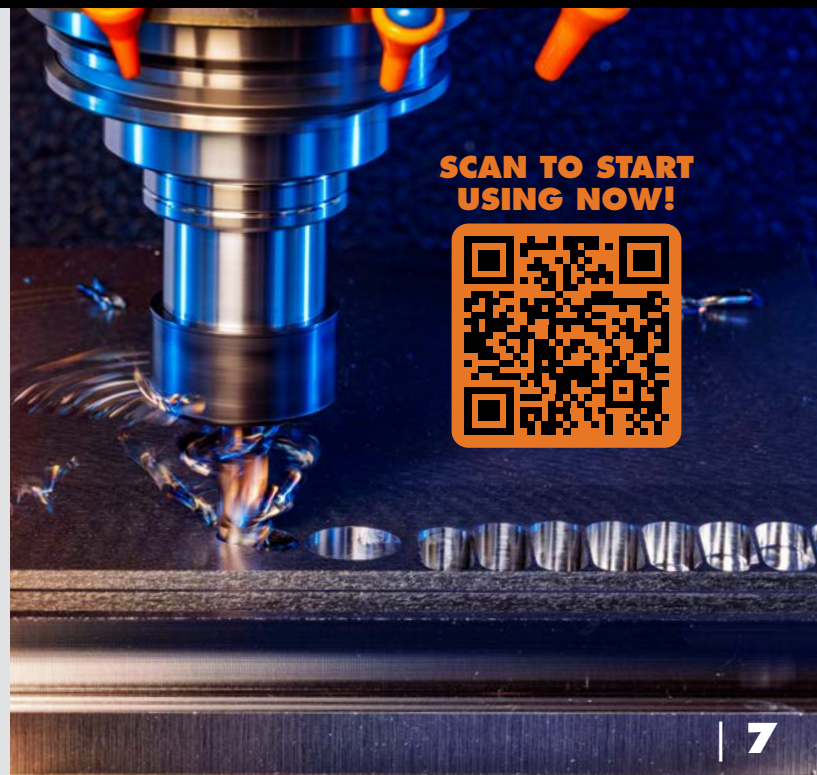
| DC Cutter Dia | DCON Shank Dia | APMX Length of Cut | LU Reach | OAL Overall Length | Item Number | | | |
|------------------|-------------------|-----------------------|-------------|-----------------------|-------------|---------|---------|---------|
| | | | | | SQ | .3 CR | .5 CR | 1.0 CR |
| 3 | 6 | 8 | 12 | 57 | 9180487 | 9180488 | - | - |
| | | 8 | 18 | 57 | 9180489 | 9180490 | - | - |
| 4 | 6 | 10 | 14 | 57 | 9180491 | 9180492 | - | - |
| | | 10 | 24 | 63 | 9180493 | 9180494 | - | - |
| 5 | 6 | 12 | 18 | 57 | 9180495 | 9180496 | 9180497 | 9180498 |
| | | 12 | 25 | 63 | 9180499 | 9180501 | 9180502 | 9180503 |
| 6 | 6 | 10 | 21 | 63 | 9180504 | - | 9180505 | 9180506 |
| | | 14 | 30 | 75 | 9180507 | - | 9180508 | 9180509 |
| 8 | 8 | 13 | 28 | 75 | 9180510 | - | 9180511 | 9180512 |
| | | 18 | 40 | 75 | 9180513 | - | 9180514 | 9180515 |
| 10 | 10 | 16 | 35 | 75 | 9180516 | - | 9180517 | 9180518 |
| | | 22 | 50 | 100 | 9180519 | - | 9180520 | 9180521 |
| 12 | 12 | 19 | 42 | 83 | 9180522 | - | 9180523 | 9180524 |
| | | 26 | 60 | 100 | 9180525 | - | 9180526 | 9180527 |
| 16 | 16 | 25 | 56 | 110 | 9180528 | - | 9180529 | 9180530 |
| | | 34 | 80 | 125 | 9180531 | - | 9180532 | 9180533 |



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| | |
|---------------|---|
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| International | 419-661-6313 |
| Fax | 419-661-6314 |
| Email | CustomerService@imcousa.com |



Power. Precision. Performance.

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