



Power. Precision. Performance.

Put **POWER** back in
traditional tool paths

THE NEW **POW • R • FEED** M934

**HIGHER FEEDS
FASTER CYCLES
BETTER PROFITS**

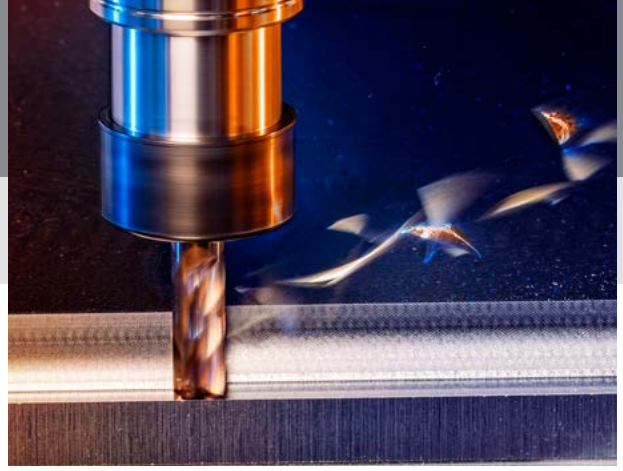
NEW from IMCO

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	-	-
		1-5/8	4	9176972	-	9176973	9176974	9176975	-	9176976	-	9176977
1	1	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

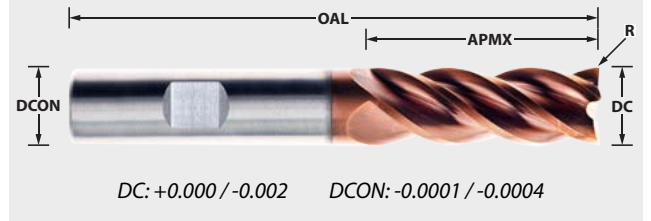


POW•R•FEED M934 W/WELDON FLAT



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
		2	4	9177076	9177078	9177079
5/8	5/8	1-5/8	3-1/2	9177101	-	9177104
		2-3/16	4	9177110	-	9177112
3/4	3/4	1-5/8	4	9177122	-	9177124
		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

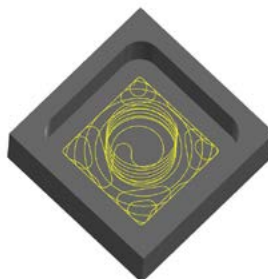
INCH



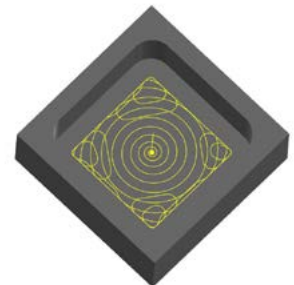
TECH TALK | HELICAL OR PLUNGE ENTRY?

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.



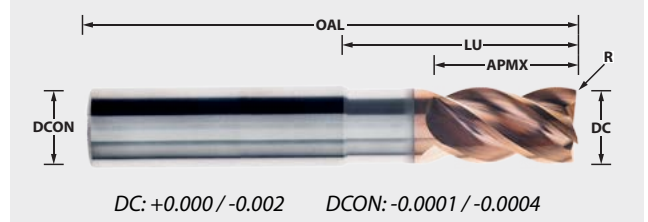
B. Plunge entry
Machining time = 46 sec.

POW•R•FEED M934N



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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.



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	IPT	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

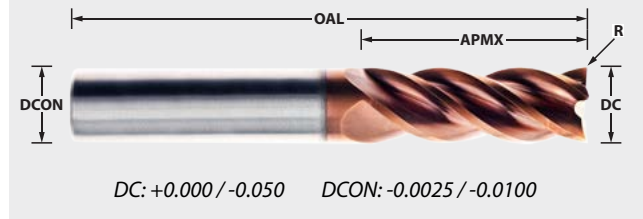


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METRIC

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



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METRIC

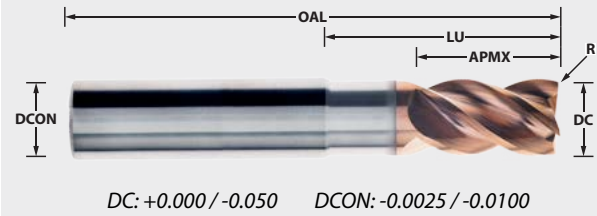
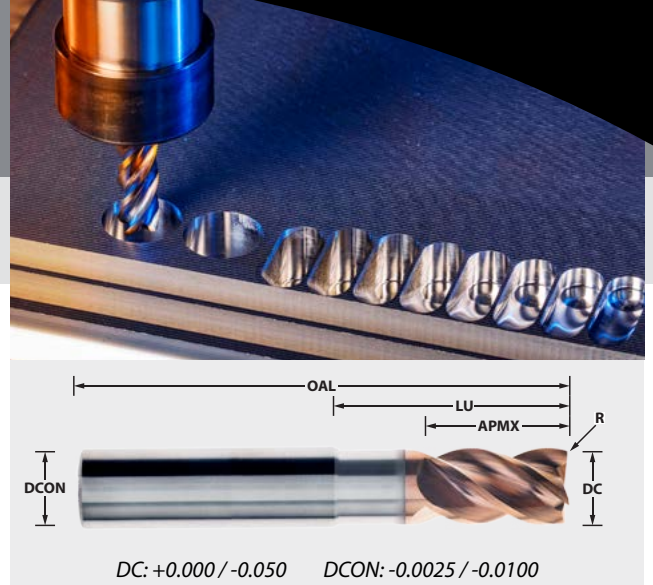


POW•R•FEED M934N



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METRIC

DC Cutter Dia	DCON Shank Dia	APMX Length of Cut	LU Reach	OAL Overall Length	Item Number			
					SQ	0.3 CR	0.5 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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Exclusively from IMCO

POW • R • FEED

M934

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Learn more at imcousa.com.

Contact your distributor today for pricing and availability.

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



Power. Precision. Performance.

IMCO Carbide Tool Inc.
28170 Cedar Park Blvd., Perrysburg, OH 43551

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