Edge of Arlington Saw & Tool, Inc.

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Item #4230L, Vortex Series 4200 Two Flute 1/4 x 3/8 Low Helix Finisher
$36.21

Thank you for shopping with us!

Our double edge low helix spirals are recommended for cutting hard plastics, such as acrylics and phenolics. The lower helix angle produces less " lifting" and " fluttering" on plastic materials. Tools are extremely sharp, producing very clean edges that require little secondary work. These bits also provide great finishes in hardwoods and are recommended for " open cell" foam applications.



Upcut Spirals

- The upcut spiral is a right hand spiral with a right hand rotation of cut. An upcut spiral will cause the chips to be "augered" upwards during cutting. This can be particularly useful in slotting cuts or where chip removal is a problem. Upcut spiral bits have a tendency to "lift" the part in some cases. Additional holding power or stepped cutting may be required.
- Upcut spiral bits will leave a smooth cut on the bottom of a thru cut and tend to leave some fuzzing on the top edge in certain materials.
- Upcut spirals straight plunge/drill and have good end cutting geometry.



Downcut Spirals

- A downcut spiral (right hand cut, left hand spiral) causes the chip flow to be directed downward. It also helps hold down the part being cut. The edge quality on the part is smooth on the top and tends to be fuzzy on the bottom in certain materials.
- The downward chip flow can sometimes cause clogging problems particularly in a blind slotting situation. Downcut bits tend to preload the routing system and can substantially improve part hold down in a marginal routing setup.
- Downcut tools CAN NOT be used to plunge straight into wood and should be ramped into the part.



Compression Spirals

- A compression spiral is designed with both upcut and downcut flutes. The upcut and downcut flutes compress the material being cut preventing chipping or fuzzing on the top and bottom of the cut.
- Compression spirals are used extensively for cutting double sided laminates, and can be used on natural woods where edge fuzzing is a problem.

SPECIFICATIONS	
Diameter	1/4 in

SPECIFICATIONS	
Carbide H, or Cut H/L/W	
Flute Geometry	Upcut
Flute	2
Overall Length	3 in
Shank	1/4 in
Manufacturer	Vortex Tool