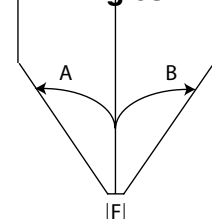


CUTTER REPLACEMENT GUIDE (Con't)

Ilico Number	Type	Material	Diameter		Thickness		Hole Diameter		Cutter Profile Angle				Used on Machines
			In.	mm	In.	mm	In.	mm	A°	B°	F In.	mm	
23RF	Fine Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	45	0	.031R	.787	Ilco 008, 008A, 008B, 2184CD, H2584CV, 2585DU, 190; DL 145, 145M, 147, 149M; HPC 9100, 9110; Taylor KD1, KD5, KD20; Keil 4-1/2, 12-1/2, 13-1/2, 15; Curtis 2000
X23MC	Milling	H.S.S.	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilco 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
P-X23MC*	Milling	H.S.S.	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilco 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
X23MC SPL	Milling	H.S.S. (AlTiN Coated)	2.375	60.32	.104	2.64	.5	12.7	0	45	.081F	2.457	Ilco 023, 025, 045; DL 143M, 145, 145M, 148M; Taylor 143MT, 145MT
25	Slotter	H.S.S.	2.5	63.50	.045	1.14	.5	12.7					Keil 10-1/2
27	Slotter	H.S.S.	2.25	57.15	.045	1.14	.5	12.7					Ilco 2184CD, 2584CV; DL 146, 146M; HPC 9100, 9110; Taylor KD1; Keil 4-1/2, 12-1/2
27-1	Slotter	H.S.S.	2.25	57.15	.03	.76	.5	12.7					Ilco 2184CD, 2584CV; DL 146, 146M; HPC 9100, 9110; Taylor KD1; Keil 4-1/2, 12-1/2
27-2	Slotter	H.S.S.	2.375	60.32	.03	.76	.5	12.7					Ilco 2585DU; Keil 15-1/2
28RF	Fine Milling	H.S.S.	2.063	52.39	.25	6.35	.5	12.7	0	45	.025R	.635	Ilco 2196K
CU29	Milling	H.S.S.	2.375	60.32	.27	6.86	.5	12.7	45	45	.064	1.626	Ilco 029A
SMS30	Side Milling Slotter	H.S.S.	2.375	60.32	.03	.76	.5	12.7					Ilco 2184CD, 2584CV, H2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S 15-1/2S
CU30-55	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.055	1.4	Ilco 030, 031; PPI Halftime
CU30-55	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.055	1.4	Ilco 030, 031; PPI Halftime
CU30-62	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.062	1.57	Ilco 030, 031; PPI Halftime
CU30-72	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.072	1.83	Ilco 030, 031; PPI Halftime
CU30-88	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.088	2.24	Ilco 030, 031
CU30-M	Slotter	Carbide	4	101.60	.055	1.4	1	25.4			.050	1.27	Ilco 030, 031; PPI Halftime
32	Slotter	H.S.S.	2.063	52.39	.03	.76	.5	12.7					Ilco 2196K; Keil 6-1/2
34MC	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.031R	.787	Ilco 2184CD, 2584CV, 2585DU; Keil 4-1/2, 12-1/2
P-34MC*	Milling	H.S.S.	2.25	57.15	.25	6.35	.5	12.7	0	45	.031R	.787	Ilco 2184CD, 2584CV, 2585DU; Keil 4-1/2, 12-1/2
36MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	45	45	.088F	2.24	Ilco 2178U, 2178UA, 2178UC, 178U
37MC	Milling	H.S.S.	2.25	57.15	.20	5.08	.5	12.7	45	45	.025F	.635	Ilco 2184CD, 2585DU; HPC 9100, 9110; DL 135, 135M, 145, 145M; Taylor KD5
CU45	Slotter	H.S.S.	2.48	63	.071	1.8	.63	16					Ilco KD45, KD46, KD83
SMS45	Side Milling Slotter	H.S.S.	2.375	60.32	.045	1.14	.5	12.7					Ilco 046, 046HD, 2584SMS, 2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S, 15-1/2S
P-45SMS*	Side Milling Slotter	H.S.S.	2.375	60.32	.045	1.14	.5	12.7	42	45	.045	1.143	Ilco 046, 046HD, 2584SMS, 2585SMS; HPC 9110; Keil 12S, 12-1/2S, 15S, 15-1/2S
TCW-47MC	Milling	H.S.S.	2.375	60.32	.375	9.52	.375	9.52	42	45	.035F	.889	Ilco Universal II; HPC 1200CM; Lagard LG1011
CU50A	Milling	Cobalt	3.15	80	.197	5	.63	16	40	40			Ilco KD50A, KD71A, KD50C; Silca Bravo II, Bravo III, Bravo III w/EZ Jaw
57MC	Milling	H.S.S.	2.75	69.85	.281	7.14	.5	12.7	0	30	.020	.508	Sagar SA500, SA500A
58MC	Milling	H.S.S.	2.75	69.85	.281	7.14	.5	12.7	0	30	.020	.508	Sagar SA500, SA500A

Cutter Profile Angles



Note: In the above drawing and chart to the left, 'F' refers to the width of the tip of the cutter, measured in thousandths of an inch. When this measurement is followed by 'R' (Example - .015R), it means that the tip of the cutter is .015" wide and it is rounded (or has a radius). When the measurement is followed by 'F' (Example - .010F), it means that the tip of the cutter is .010 wide and is flat.

* Available with Titanium Nitride coating (add prefix "P") • H. S. S. - High Speed Steel

CUTTER REPLACEMENT BY MODEL GUIDE

Machine	Original	Optional
ILCO		
006	19MC	P-19MC
008, 008A, 008B	23RF	27 (Slotter)
009,	16CT	
009A, 009B	16TW	
010	19MC	P-19MC
016, 017, 018	P-9MC	9MC
020, 024A, 024B	CU20	P-CU20
022	CU1	
023, 025	P-X23MC	X23MC
045, 045HD	P-X23MC	X23MC
024	11MC	
026	P-45SMS	45SMS, 30SMS
027, 027A	CU1	
029A	CU29	
030	CU30-55	CU30-62, -72, -88, -M
031	CU30-88	CU30-55, -62, -72, -M
040, 040HD	P-CU20	CU20
044, 044HD	P-CU20	CU20
046, 046HD	P-45SMS	SMS45
057 HS	F22	F44SPL
ECM 100	P-CU100A	
ILCO EZ®-Code	AT-U01/U01 (AL-TiN)	D705933ZB Carbide
Universal II	T14MC	TCW-20FM,
	TCW-1011MC	TCW-47MC, TCW-90MC, TCW1011, SACW1012, SACW1013, SACW1014
2175-IA	9RF or 3FS-HS	7FS-HS, 10FS, 15FS-HS
2177-ID	9RF or 3FS-HS	7FS-HS, 10FS, 15FS-HS
2178U	8UC	20MC, 21MC, 22MC, 36MC
2179-IM	9RF,	7FS-HS, 10FS
	3FS-HS	11FS-24, 15FS-HS
2183DM, 2183HM	19MC	P-19MC
2184CD	23RF	27, 27-1, 34MC, P-34MC, SMS30, 37MC, P-45SMS

Machine	Original	Optional
ILCO (Con't)		
2196K	12, 13, 17, or 32	11, 28RF
2584CV	34MC	27, 27-1, P-34MC, 37MC, SMS30, SMS45
H2584CV	34MC	P-34MC, 37MC, 45SMS,
2584SMS	SMS45	P-45SMS, 27
H2584SMS	27	SMS30, P-45SMS
2585DU	34MC, 37MC, 45SMS	27-2, P-34MC, 37MC
2585SMS	30SMS, SMS45	P-45SMS
SILCA		
AY 100-C	D701652ZB	
Bravo	D700875ZB	
Bravo Master	D700875ZB	
Bravo USA	D700875ZB	
Bravo II	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Bravo III	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Bravo III (w/EZ-Jaw)	D717898	CU50A, D700875ZB D704861ZB Requires Carbide Pulley Set
Cadet	D706766ZB	
Club, Club Jr	D705488ZB (F22)	Various types
Crown	D700077ZB	D705407ZB D704541ZB
Delta A/M/S	D911868ZR	
Delta Multicopy	D714448ZB	SG19
Delta 2000 FO	D913645ZR	SG18
Delta Flat Steel	D712505ZB (.045)	
	D412506ZZ (.030)	
Delta Plus	D911868ZR	
Doge	D701089ZB (F11)	Various types

Machine	Original	Optional
SILCA (Con't)		
Futura	D742607ZB (01F)	
	D742606ZB (01L)	D743671ZB (02L) D743672ZB (03L)
	D742267ZB (01D)	D743673 (02D)
GT40	D700080ZB	
GT 40-C	D301744ZZ	
Larus	D706766ZB	
Lancer, Lancer Plus	D705374ZB	D711119ZB (Ward Cutter), D700204ZB
Matrix II	D739973ZB (F22)	Various types
Matrix S, SX, SLX	D705488ZB (F22)	Various types
Poker Plus	D700875ZB	
Prima Laser	D709696ZB	
Quattrocode	D709238ZB (W101)	Various types
Rekord 2000, Rekord Plus	D700875ZB	
Scout	D401866ZZ	
Special Master	D700875ZB	
Speed	D935282ZR	
Sprint	D401647ZA	
Super Special	D700875ZB	
Targa 2000	D300080ZB	
Tech 3 Europa	D700080ZB	
Triax	D708742ZB (H101)	AL/TIN-H101 Cutter Various types
Triax e.code	D708742ZB (H101)	AL/TIN-H101 Cutter
		Various types
Tri-Code HS	D708742ZB) (H101)	AL/TIN-H101 Cutter, D709238ZB W101, D709482ZB W114, D737688ZB W302
Ultracode/ Unocode	D716549ZB (U01)	D705933ZB Carbide, various slotters
UC199	D734910ZB (Carbide)	