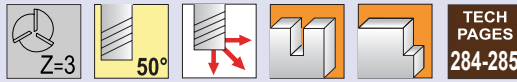


Series 253M, 853M

.1181" - .5512"
(3.000mm - 14.000mm)

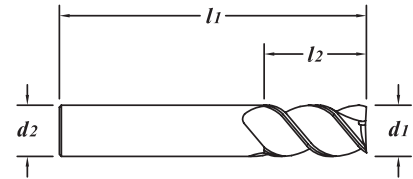
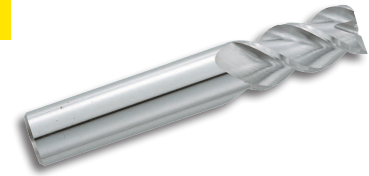


TOLERANCES	
d_1	+0.000" - .002" (+.000 - .050mm)
d_2	h6

Recommended for aluminum and stainless steel

Square End

- Solid submicron grain carbide end mill - center cutting
- High performance machining
- Rigid work holding, machine stability and part integrity are critical!
- Slots aluminum at an axial depth of 25% of diameter
- Sharp corners (Can be modified with a corner radius)
- AlTiN Coating - page 178
- TiCN Coated - page 182



MATERIAL HARDNESS (Rc)

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EDP#	d_1 † Diameter		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
10340	.1181	3.000	3.0	38	8	12.09	11.56	11.04	10.51	
10350	.1181	3.000	3.0	50	12	14.57	13.94	13.30	12.67	
86130	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	11.35	10.86	10.36	9.87
86140	.1250	1/8"	3.175	1/8"	2"	1/2"	13.67	13.08	12.48	11.89
10380	.1575	4.000	6.0	50	8	19.65	18.80	17.94	17.09	
10390	.1575	4.000	6.0	50	12	19.65	18.80	17.94	17.09	
86150	.1875	3/16"	4.763	3/16"	2"	5/16"	13.37	12.79	12.21	11.63
86160	.1875	3/16"	4.763	3/16"	2"	9/16"	13.37	12.79	12.21	11.63
86180	.1875	3/16"	4.763	3/16"	3"	1"	23.84	22.80	21.77	20.73
10400	.1969	5.000	5.0	50	8	14.86	14.21	13.57	12.92	
10410	.1969	5.000	5.0	50	14	14.86	14.21	13.57	12.92	
10010	.2362	6.000	6.0	50	12	15.76	15.07	14.39	13.70	
10020	.2362	6.000	6.0	65	19	16.93	16.19	15.46	14.72	
10030	.2362	6.000	6.0	75	32	29.06	27.80	26.53	25.27	
86200	.2500	1/4"	6.350	1/4"	2"	1/2"	14.93	14.28	13.63	12.98
86220	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	16.13	15.43	14.73	14.03
86240	.2500	1/4"	6.350	1/4"	3"	1-1/4"	27.62	26.42	25.22	24.02
86260	.3125	5/16"	7.938	5/16"	2"	7/16"	20.41	19.53	18.64	17.75
86270	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	22.63	21.65	20.66	19.68
86280	.3125	5/16"	7.938	5/16"	4"	1-1/4"	38.01	36.36	34.70	33.05
10420	.3150	8.000	8.0	50	11	21.53	20.59	19.66	18.72	
10040	.3150	8.000	8.0	65	20	23.76	22.73	21.69	20.66	
10050	.3150	8.000	8.0	75	32	35.89	34.33	32.77	31.21	
86300	.3750	3/8"	9.525	3/8"	2"	1/2"	25.22	24.12	23.03	21.93
86320	.3750	3/8"	9.525	3/8"	2-1/2"	1"	28.18	26.95	25.73	24.50
86340	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	42.10	40.27	38.44	36.61
10060	.3937	10.000	10.0	50	12	29.35	28.07	26.80	25.52	
10070	.3937	10.000	10.0	75	25	41.61	39.80	37.99	36.18	
10080	.3937	10.000	10.0	88	38	52.41	50.13	47.85	45.57	
86360	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	34.40	32.90	31.41	29.91
86370	.4375	7/16"	11.113	7/16"	2-3/4"	1"	34.40	32.90	31.41	29.91
86380	.4375	7/16"	11.113	7/16"	4"	2"	57.93	55.41	52.89	50.37
10090	.4724	12.000	12.0	65	16	43.84	41.93	40.03	38.12	
10100	.4724	12.000	12.0	75	26	47.40	45.34	43.28	41.22	
10110	.4724	12.000	12.0	100	50	65.30	62.46	59.62	56.78	
86400	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	41.63	39.82	38.01	36.20
86420	.5000	1/2"	12.700	1/2"	3"	1"	45.14	43.18	41.21	39.25
86440	.5000	1/2"	12.700	1/2"	4"	2"	61.61	58.93	56.25	53.57
10430	.5512	14.000	14.0	65	16	68.57	65.59	62.61	59.63	
10440	.5512	14.000	14.0	75	25	74.19	70.96	67.74	64.51	
10450	.5512	14.000	14.0	100	50	89.70	85.80	81.90	78.00	

EDP#	<i>d1</i> † Diameter		<i>d2</i> Shank Diameter	<i>l1</i> Overall Length	<i>l2</i> Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
86460	.5625	9/16"	14.288	9/16"	3"	7/8"	74.45	71.21	67.98	64.74
86470	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"	77.08	73.73	70.38	67.03
86480	.5625	9/16"	14.288	9/16"	6"	2-1/2"	116.96	111.87	106.79	101.70
86500	.6250	5/8"	15.875	5/8"	3"	7/8"	79.60	76.14	72.68	69.22
86520	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	87.04	83.26	79.47	75.69
86540	.6250	5/8"	15.875	5/8"	6"	2-1/2"	126.98	121.46	115.94	110.42
10120	.6299		16.000	16.0	75	20	83.78	80.14	76.49	72.85
10130	.6299		16.000	16.0	88	32	91.39	87.42	83.44	79.47
10140	.6299		16.000	16.0	150	65	126.98	121.46	115.94	110.42
10160	.7087		18.000	18.0	100	38	134.00	128.17	122.35	116.52
10170	.7087		18.000	18.0	150	75	190.90	182.60	174.30	166.00
86600	.7500	3/4"	19.050	3/4"	3-1/2"	1"	127.63	122.08	116.53	110.98
86620	.7500	3/4"	19.050	3/4"	4"	1-1/2"	127.63	122.08	116.53	110.98
86640	.7500	3/4"	19.050	3/4"	6"	3"	202.29	193.49	184.70	175.90
10460	.7874		20.000	20.0	75	22	155.25	148.50	141.75	135.00
10180	.7874		20.000	20.0	100	38	170.38	162.98	155.57	148.16
10190	.7874		20.000	20.0	150	75	213.10	203.83	194.57	185.30
10480	.9843		25.000	25.0	100	50	197.94	189.33	180.73	172.12
10490	.9843		25.000	25.0	150	82	328.37	314.09	299.82	285.54
86690	1.000	1"	25.400	1"	4"	1-1/8"	190.90	182.60	174.30	166.00
86720	1.000	1"	25.400	1"	4"	2"	190.90	182.60	174.30	166.00
86740	1.000	1"	25.400	1"	6"	3-1/4"	343.91	328.96	314.00	299.05

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MATERIAL HARDNESS (Rc)

