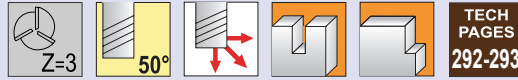


# Series 253M, 253MC, 253MA, 853M, 853MA

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



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

Recommended for stainless steel

## Square End

Bright Finish, TiCN or AlTiN Coating

Solid submicron grain carbide end mill - center cutting

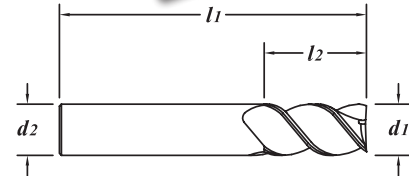
High performance machining

Rigid work holding, machine stability and part integrity are critical!

Dry or semi-dry machining

Slots stainless steel at an axial depth of 25% of diameter

Sharp corners (Can be modified with a corner radius)



(253M/853M) BRIGHT EDP#	(253MC) TiCN EDP#	(253MA/853MA) AlTiN EDP#	$d_1$ † Diameter		$d_2$ Shank Diameter	$l_1$ Overall Length	$l_2$ Flute Length	
			Decimal	Metric				
10340	-	10347	.1181	3.000	3.0	38	8	
10350	-	10357	.1181	3.000	3.0	50	12	
86134	-	86137	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"
86140	-	86147	.1250	1/8"	3.175	1/8"	2"	1/2"
10380	-	10387	.1575	4.000	6.0	50	8	
10390	-	10397	.1575	4.000	6.0	50	12	
86150	86154	86157	.1875	3/16"	4.763	3/16"	2"	5/16"
86160	86164	86167	.1875	3/16"	4.763	3/16"	2"	9/16"
86180	86184	86187	.1875	3/16"	4.763	3/16"	3"	1"
10400	-	10407	.1969	5.000	5.0	50	8	
10410	-	10417	.1969	5.000	5.0	50	14	
-	-	10507	.1969	5.000	6.0	50	8	
-	-	10517	.1969	5.000	6.0	65	16	
10010	-	10017	.2362	6.000	6.0	50	12	
10020	-	10027	.2362	6.000	6.0	65	19	
10030	-	10037	.2362	6.000	6.0	75	32	
86200	86204	86207	.2500	1/4"	6.350	1/4"	2"	1/2"
86220	86224	86227	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"
86240	86244	86247	.2500	1/4"	6.350	1/4"	3"	1-1/4"
86260	86264	86267	.3125	5/16"	7.938	5/16"	2"	7/16"
86270	86274	86277	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"
86280	86284	86287	.3125	5/16"	7.938	5/16"	4"	1-1/4"
10420	-	10427	.3150	8.000	8.0	50	11	
10040	-	10047	.3150	8.000	8.0	65	20	
10050	-	10057	.3150	8.000	8.0	75	32	
86300	86304	86307	.3750	3/8"	9.525	3/8"	2"	1/2"
86320	86324	86327	.3750	3/8"	9.525	3/8"	2-1/2"	1"
86340	86344	86347	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"
10060	-	10067	.3937	10.000	10.0	50	12	
10070	-	10077	.3937	10.000	10.0	75	25	
10080	-	10087	.3937	10.000	10.0	88	38	
86360	86364	86367	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"
86370	86374	86377	.4375	7/16"	11.113	7/16"	2-3/4"	1"
86380	86384	86387	.4375	7/16"	11.113	7/16"	4"	2"
10090	-	10097	.4724	12.000	12.0	65	16	
10100	-	10107	.4724	12.000	12.0	75	26	
10110	-	10117	.4724	12.000	12.0	100	50	
86400	86404	86407	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"
86420	86424	86427	.5000	1/2"	12.700	1/2"	3"	1"
86440	86444	86447	.5000	1/2"	12.700	1/2"	4"	2"
10430	-	10437	.5512	14.000	14.0	65	16	
10440	-	10447	.5512	14.000	14.0	75	25	
10450	-	10457	.5512	14.000	14.0	100	50	

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MATERIAL HARDNESS (Rc)

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# Series 253M, 253MC, 253MA, 853M, 853MA (continued)

.5625" - 1.000"  
(14.288mm - 25.400mm)

HIGH PERFORMANCE  
END MILLS

(253M/853M) BRIGHT EDP#	(253MC) TiCN EDP#	(253MA/853MA) AlTiN EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	
			Decimal	Metric				
86460	86464	86467	.5625	9/16"	14.288	9/16"	3"	7/8"
86470	-	86477	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"
86480	86484	-	.5625	9/16"	14.288	9/16"	6"	2-1/2"
86500	86504	86507	.6250	5/8"	15.875	5/8"	3"	7/8"
86520	86524	86527	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"
86540	86544	86547	.6250	5/8"	15.875	5/8"	6"	2-1/2"
10120	-	-	.6299		16.000	16.0	75	20
10130	-	10137	.6299		16.000	16.0	88	32
10140	-	10147	.6299		16.000	16.0	150	65
10160	-	10167	.7087		18.000	18.0	100	38
10170	-	-	.7087		18.000	18.0	150	75
86600	86604	86607	.7500	3/4"	19.050	3/4"	3-1/2"	1"
86620	86624	86627	.7500	3/4"	19.050	3/4"	4"	1-1/2"
86640	86644	86647	.7500	3/4"	19.050	3/4"	6"	3"
10460	-	-	.7874		20.000	20.0	75	22
10180	-	10187	.7874		20.000	20.0	100	38
10190	-	10197	.7874		20.000	20.0	150	75
10480	-	-	.9843		25.000	25.0	100	50
10490	-	-	.9843		25.000	25.0	150	82
86690	86694	86697	1.000	1"	25.400	1"	4"	1-1/8"
86720	86724	86727	1.000	1"	25.400	1"	4"	2"
86740	86744	86747	1.000	1"	25.400	1"	6"	3-1/4"

