

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

TOLERANCES

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

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



TECH PAGES
292-293

Recommended for stainless steel

Square End

Bright Finish, TiCN or AlTiN Coating

Solid submicron grain carbide end mill - center cutting

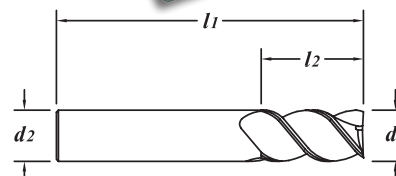
High performance machining

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)



70

35

MATERIAL HARDNESS (Rc)

0

(253M/853M) BRIGHT EDP#	(253MC) TiCN EDP#	(253MA/853MA) AlTiN EDP#	d_1 †		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	(253M/853M) BRIGHT LIST PRICE	(253MC) TiCN LIST PRICE	(253MA/853MA) AlTiN LIST PRICE
			Decimal	Diameter						
10340	-	10347	.1181	3.000	3.0	38	8	11.46	-	14.04
10350	-	10357	.1181	3.000	3.0	50	12	13.81	-	16.92
86134	-	86137	.1250	1/8"	3.175	1/8"	1-1/2"	10.76	-	13.33
86140	-	86147	.1250	1/8"	3.175	1/8"	2"	12.96	-	16.08
10380	-	10387	.1575	4.000	6.0	50	8	18.63	-	22.68
10390	-	10397	.1575	4.000	6.0	50	12	18.63	-	22.68
86150	86154	86157	.1875	3/16"	4.763	3/16"	2"	12.68	14.93	15.24
86160	86164	86167	.1875	3/16"	4.763	3/16"	2"	12.68	14.93	15.24
86180	86184	86187	.1875	3/16"	4.763	3/16"	3"	22.60	25.75	26.57
10400	-	10407	.1969	5.000	5.0	50	8	14.08	-	18.06
10410	-	10417	.1969	5.000	5.0	50	14	14.08	-	18.06
-	-	10507	.1969	5.000	6.0	50	8	-	-	22.21
-	-	10517	.1969	5.000	6.0	65	16	-	-	24.26
10010	-	10017	.2362	6.000	6.0	50	12	14.93	-	18.89
10020	-	10027	.2362	6.000	6.0	65	19	16.04	-	21.29
10030	-	10037	.2362	6.000	6.0	75	32	27.54	-	32.82
86200	86204	86207	.2500	1/4"	6.350	1/4"	2"	14.15	17.32	18.13
86220	86224	86227	.2500	1/4"	6.350	1/4"	2-1/2"	15.29	19.86	20.56
86240	86244	86247	.2500	1/4"	6.350	1/4"	3"	26.18	30.73	31.42
86260	86264	86267	.3125	5/16"	7.938	5/16"	2"	19.35	24.30	25.05
86270	86274	86277	.3125	5/16"	7.938	5/16"	2-1/2"	21.45	27.54	29.31
86280	86284	86287	.3125	5/16"	7.938	5/16"	4"	36.02	43.62	46.04
10420	-	10427	.3150	8.000	8.0	50	11	20.40	-	26.08
10040	-	10047	.3150	8.000	8.0	65	20	22.52	-	30.38
10050	-	10057	.3150	8.000	8.0	75	32	34.02	-	41.88
86300	86304	86307	.3750	3/8"	9.525	3/8"	2"	23.90	28.85	29.59
86320	86324	86327	.3750	3/8"	9.525	3/8"	2-1/2"	26.71	31.65	34.59
86340	86344	86347	.3750	3/8"	9.525	3/8"	3-1/2"	39.90	47.46	49.91
10060	-	10067	.3937	10.000	10.0	50	12	27.82	-	34.26
10070	-	10077	.3937	10.000	10.0	75	25	39.44	-	48.39
10080	-	10087	.3937	10.000	10.0	88	38	49.87	-	61.26
86360	86364	86367	.4375	7/16"	11.113	7/16"	2-1/2"	32.60	39.94	41.58
86370	86374	86377	.4375	7/16"	11.113	7/16"	2-3/4"	32.60	39.94	41.58
86380	86384	86387	.4375	7/16"	11.113	7/16"	4"	54.90	64.04	66.49
10090	-	10097	.4724	12.000	12.0	65	16	41.55	-	50.49
10100	-	10107	.4724	12.000	12.0	75	26	44.93	-	53.87
10110	-	10117	.4724	12.000	12.0	100	50	61.89	-	73.52
86400	86404	86407	.5000	1/2"	12.700	1/2"	2-1/2"	39.46	46.78	48.42
86420	86424	86427	.5000	1/2"	12.700	1/2"	3"	42.78	50.10	51.73
86440	86444	86447	.5000	1/2"	12.700	1/2"	4"	58.39	67.55	70.00
10430	-	10437	.5512	14.000	14.0	65	16	65.00	-	75.40
10440	-	10447	.5512	14.000	14.0	75	25	70.32	-	80.73
10450	-	10457	.5512	14.000	14.0	100	50	85.02	-	97.98

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#	d_1 †		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	(253M/853M) BRIGHT LIST PRICE	(253MC) TiCN LIST PRICE	(253MA/853MA) AlTiN LIST PRICE	
			Decimal	Diameter Metric							
86460	86464	86467	.5625	9/16"	14.288	9/16"	3"	7/8"	70.57	80.41	80.95
86470	-	86477	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"	73.06	-	86.02
86480	86484	-	.5625	9/16"	14.288	9/16"	6"	2-1/2"	110.85	126.84	-
86500	86504	86507	.6250	5/8"	15.875	5/8"	3"	7/8"	75.45	85.28	85.84
86520	86524	86527	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	82.50	93.89	95.45
86540	86544	86547	.6250	5/8"	15.875	5/8"	6"	2-1/2"	120.36	136.35	139.60
10120	-	-	.6299		16.000	16.0	75	20	79.41	-	-
10130	-	10137	.6299		16.000	16.0	88	32	86.62	-	57.64
10140	-	10147	.6299		16.000	16.0	150	65	120.36	-	139.60
10160	-	10167	.7087		18.000	18.0	100	38	127.01	-	142.29
10170	-	-	.7087		18.000	18.0	150	75	180.94	-	-
86600	86604	86607	.7500	3/4"	19.050	3/4"	3-1/2"	1"	120.97	134.03	136.25
86620	86624	86627	.7500	3/4"	19.050	3/4"	4"	1-1/2"	120.97	134.03	136.25
86640	86644	86647	.7500	3/4"	19.050	3/4"	6"	3"	191.73	209.99	214.01
10460	-	-	.7874		20.000	20.0	75	22	147.15	-	-
10180	-	10187	.7874		20.000	20.0	100	38	161.49	-	184.08
10190	-	10197	.7874		20.000	20.0	150	75	201.98	-	230.91
10480	-	-	.9843		25.000	25.0	100	50	187.61	-	-
10490	-	-	.9843		25.000	25.0	150	82	311.24	-	-
86690	86694	86697	1.000	1"	25.400	1"	4"	1-1/8"	180.94	200.58	203.55
86720	86724	86727	1.000	1"	25.400	1"	4"	2"	180.94	200.58	203.55
86740	86744	86747	1.000	1"	25.400	1"	6"	3-1/4"	325.96	351.79	354.90

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