

Series 255MA, 855MA

.1181" - .4724"
(3.000mm - 12.000mm)

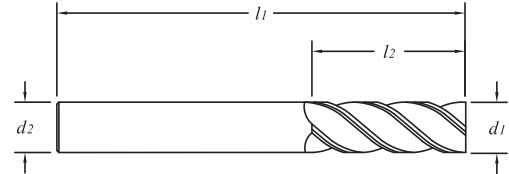


TOLERANCES	
d_1	+0.000" - .002" (+.000 - .050mm)
d_2	h6

Recommended for steels, stainless steel, and exotics

Square End
AlTiN Coating

- Solid submicron grain carbide end mill - center cutting
- High performance milling
- Rigid work holding, machine stability and part integrity are critical!
- Dry or semi-dry machining
- Improved finishes in titanium
- Heavy core, Sharp corners
- Uncoated - page 186
- TiCN Coated - page 188



MATERIAL HARDNESS (Rc)

70

35

0

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								
40047	.1181	3.000	3.0	38	8	14.81	14.17	13.52	12.88	
40057	.1181	3.000	3.0	50	12	17.85	17.07	16.30	15.52	
52087	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	14.06	13.45	12.84	12.23
52097	.1250	1/8"	3.175	1/8"	2"	1/2"	16.96	16.23	15.49	14.75
40087	.1575	4.000	6.0	50	8	23.93	22.89	21.85	20.81	
40097	.1575	4.000	6.0	50	12	23.93	22.89	21.85	20.81	
52107	.1875	3/16"	4.763	3/16"	2"	5/16"	16.08	15.38	14.68	13.98
52127	.1875	3/16"	4.763	3/16"	2"	9/16"	16.08	15.38	14.68	13.98
40107	.1969	5.000	5.0	50	8	19.06	18.23	17.40	16.57	
40127	.1969	5.000	5.0	50	14	19.06	18.23	17.40	16.57	
40117	.1969	5.000	6.0	50	8	23.44	22.42	21.40	20.38	
40137	.1969	5.000	6.0	65	16	25.60	24.49	23.37	22.26	
40207	.2362	6.000	6.0	50	10	19.93	19.06	18.20	17.33	
40227	.2362	6.000	6.0	65	20	22.46	21.48	20.51	19.53	
40247	.2362	6.000	6.0	100	32	37.18	35.56	33.95	32.33	
52207	.2500	1/4"	6.350	1/4"	2"	3/8"	19.12	18.29	17.46	16.63
52227	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	21.69	20.75	19.80	18.86
52237	.2500	1/4"	6.350	1/4"	3"	1-1/8"	33.15	31.71	30.27	28.83
52247	.2500	1/4"	6.350	1/4"	4"	1-1/4"	35.65	34.10	32.55	31.00
52307	.3125	5/16"	7.938	5/16"	2"	7/16"	26.43	25.28	24.13	22.98
52327	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	30.92	29.58	28.23	26.89
52347	.3125	5/16"	7.938	5/16"	4"	1-1/4"	48.58	46.46	44.35	42.24
40307	.3150	8.000	8.0	50	11	27.52	26.32	25.13	23.93	
40327	.3150	8.000	8.0	65	21	32.05	30.66	29.26	27.87	
40347	.3150	8.000	8.0	100	32	50.58	48.38	46.18	43.98	
40367	.3543	9.000	10.0	65	22	49.50	47.34	45.19	43.04	
52407	.3750	3/8"	9.525	3/8"	2"	1/2"	31.22	29.87	28.51	27.15
52427	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	36.49	34.90	33.32	31.73
52437	.3750	3/8"	9.525	3/8"	3"	1-1/4"	46.58	44.55	42.53	40.50
52447	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	52.66	50.37	48.08	45.79
40407	.3937	10.000	10.0	50	12	36.14	34.57	33.00	31.43	
40427	.3937	10.000	10.0	70	22	43.76	41.86	39.95	38.05	
40447	.3937	10.000	10.0	88	38	64.63	61.82	59.01	56.20	
52507	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	43.87	41.97	40.06	38.15
52527	.4375	7/16"	11.113	7/16"	2-3/4"	1"	43.87	41.97	40.06	38.15
52547	.4375	7/16"	11.113	7/16"	4"	2"	70.15	67.10	64.05	61.00
40507	.4724	12.000	12.0	65	16	53.27	50.95	48.64	46.32	
40527	.4724	12.000	12.0	75	32	56.83	54.36	51.89	49.42	
40547	.4724	12.000	12.0	100	50	77.57	74.20	70.82	67.45	

EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
52607	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	51.08	48.86	46.64	44.42
52627	.5000	1/2"	12.700	1/2"	3"	1-1/4"	54.58	52.21	49.83	47.46
52647	.5000	1/2"	12.700	1/2"	4"	2"	73.85	70.64	67.43	64.22
52707	.6250	5/8"	15.875	5/8"	3"	3/4"	90.56	86.63	82.69	78.75
52727	.6250	5/8"	15.875	5/8"	3-1/2"	1-5/8"	100.71	96.33	91.95	87.57
52747	.6250	5/8"	15.875	5/8"	6"	2-1/2"	147.28	140.88	134.47	128.07
40607	.6299		16.000	16.0	75	20	94.73	90.61	86.49	82.37
40627	.6299		16.000	16.0	88	41	105.05	100.49	95.92	91.35
40647	.6299		16.000	16.0	150	63	147.28	140.88	134.47	128.07
52807	.7500	3/4"	19.050	3/4"	3"	7/8"	127.59	122.05	116.50	110.95
52827	.7500	3/4"	19.050	3/4"	4"	1-5/8"	143.75	137.50	131.25	125.00
52837	.7500	3/4"	19.050	3/4"	5"	2"	192.94	184.55	176.16	167.77
52847	.7500	3/4"	19.050	3/4"	6"	3-1/4"	225.79	215.97	206.16	196.34
40727	.7874		20.000	20.0	100	41	194.21	185.77	177.32	168.88
40747	.7874		20.000	20.0	150	82	243.62	233.02	222.43	211.84
40787	.9843		25.000	25.0	100	28	221.79	212.15	202.50	192.86
40827	.9843		25.000	25.0	100	50	221.79	212.15	202.50	192.86
40847	.9843		25.000	25.0	150	82	358.89	343.29	327.68	312.08
52897	1.000	1"	25.400	1"	4"	1-1/8"	214.75	205.41	196.08	186.74
52927	1.000	1"	25.400	1"	4"	2"	214.75	205.41	196.08	186.74
52947	1.000	1"	25.400	1"	6"	3-1/4"	374.44	358.16	341.88	325.60

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MATERIAL HARDNESS (Rc)



End Mill Manufacturing