

**NEW
SERIES**

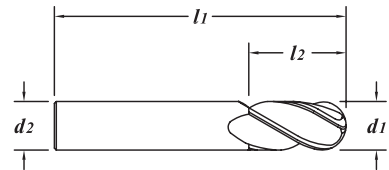


TOLERANCES

d_1	+0.00" -0.002" (+0.000mm -0.050mm)
d_2	-0.001" -0.004" (-0.025 -0.100mm)
ball radius	+0.00" -0.001" (+0.000 -0.025mm)

Variable Helix End Mill - Ball End - AlCrN-based Coated

- Solid submicron grain carbide end mill - center cutting
- Recommended for Titanium, Inconel, and Steels (< 40Rc)**
- PCT (Polish Carbide Treatment) enhances tool life by 20%
- Minimizes burr on part
- Helix geometry varies over length of flutes
- Variable flute design helps with chip evacuation in slots and pockets
- Variable rake aids in chip formation
- 12mm and larger tools offered with weldon flat
- Smaller diameters can be modified with a flat within 48 hours
- V4 Square End - page 129
- V4 Corner Radius - page 130



The combination of an extended flute length with a weldon flat may cause the flute washout to reach inside some end mill holders

EDP#		d_1 †		d_2	l_1	l_2	1-11	12-24	25-49	50-100
(plain)	(weldon)	Decimal	Diameter	Shank Diameter	Overall Length	Flute Length				
50252	-	.2362"	6.000	6.0	65	12	25.74	24.62	23.50	22.38
50253	-	.2362"	6.000	6.0	65	19	25.74	24.62	23.50	22.38
50254	-	.2500"	1/4"	6.350	1/4"	2-1/2"	24.75	23.67	22.60	21.52
50255	-	.3125"	5/16"	7.937	5/16"	2-1/2"	33.52	32.07	30.61	29.15
50256	-	.3150"	8.000	8.0	65	22	34.79	33.28	31.76	30.25
50257	-	.3750"	3/8"	9.525	3/8"	2-1/2"	39.16	37.46	35.75	34.05
50258	-	.3937"	10.000	10.0	70	22	47.28	45.22	43.17	41.11
50470	50469	.4724"	12.000	12.0	75	26	69.64	66.62	63.59	60.56
50259	50291	.4724"	12.000	12.0	75	32	69.64	66.62	63.59	60.56
50472	50473	.5000"	1/2"	12.700	1/2"	3"	66.80	63.90	60.99	58.09
50260	50292	.5000"	1/2"	12.700	1/2"	3"	66.80	63.90	60.99	58.09
50261	50293	.5000"	1/2"	12.700	1/2"	4"	78.96	75.53	72.09	68.66
50262	50294	.6250"	5/8"	15.875	5/8"	3-1/2"	106.35	101.73	97.10	92.48
50263	50295	.6299"	16.000	16.0	88	32	110.99	106.16	101.34	96.51
50264	50296	.7500"	3/4"	19.050	3/4"	4"	152.51	145.88	139.25	132.62
50265	50297	.7874"	20.000	20.0	100	38	215.86	206.47	197.09	187.70
50266	50298	1.000"	1"	25.400	1"	4"	260.38	249.06	237.74	226.42