

TOLERANCES

d_1	+0.000" - .002" (+.000mm - .050mm)
d_2	-.0001" - .0004" (-.0025 - .0100mm)

Technical information: page 234-235



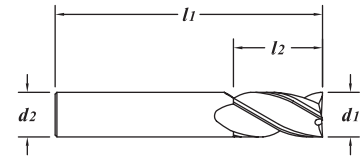
NEW SERIES

V4S - 4 Flute

**HIGH PERFORMANCE
END MILLS**

Variable Helix End Mill - Square 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 Corner Radius - page 130
- V4 Ball End - page 132
- 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 † Diameter		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100
(plain)	(weldon)	Decimal	Metric							
50236	-	.2362"	6.000	6.0	65	12	22.64	21.66	20.67	19.69
50237	-	.2362"	6.000	6.0	65	19	22.64	21.66	20.67	19.69
50238	-	.2500"	6.350	1/4"	2-1/2"	3/4"	21.85	20.90	19.95	19.00
50239	-	.3125"	7.937	5/16"	2-1/2"	13/16"	31.15	29.80	28.44	27.09
50240	-	.3150"	8.000	8.0	65	22	32.28	30.88	29.47	28.07
50241	-	.3750"	9.525	3/8"	2-1/2"	1"	36.77	35.17	33.57	31.97
50242	-	.3937"	10.000	10.0	70	22	44.07	42.15	40.24	38.32
50450	50449	.4724"	12.000	12.0	75	26	57.27	54.78	52.29	49.80
50243	50283	.4724"	12.000	12.0	75	32	57.27	54.78	52.29	49.80
50452	50453	.5000"	12.700	1/2"	3"	1"	54.98	52.59	50.20	47.81
50244	50284	.5000"	12.700	1/2"	3"	1-1/4"	54.98	52.59	50.20	47.81
50245	50285	.5000"	12.700	1/2"	4"	2-1/8"	74.39	71.16	67.92	64.69
50246	50286	.6250"	15.875	5/8"	3-1/2"	1-1/4"	101.44	97.03	92.62	88.21
50247	50287	.6299"	16.000	16.0	88	32	105.83	101.23	96.63	92.03
50248	50288	.7500"	19.050	3/4"	4"	1-1/2"	144.80	138.50	132.21	125.91
50249	50289	.7874"	20.000	20.0	100	38	195.64	187.13	178.63	170.12
50250	50290	1.000"	25.400	1"	4"	1-1/2"	216.33	206.92	197.52	188.11