

**TOLERANCES**

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

**NEW ITEM**

**Series 246M, 246MC, 246MA, 846M, 846MA**

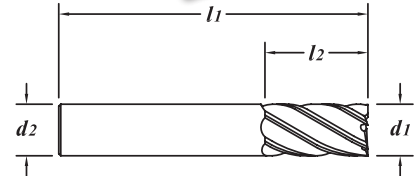


**TECH PAGES 263,265**

**Recommended for Steels**

**Square End**

Solid submicron grain carbide end mill - center cutting  
 High performance finishing in a variety of steels  
 Rigid work holding, machine stability and part integrity are critical!  
 Excellent durability



(246M/846M) UNCOATED EDP#	(246MC) TiCN EDP#	(246MA/846MA) AlTiN 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								
51110	-	-	.1875	3/16"	4.763	3/16"	2"	5/8"	12.25	11.72	11.18	10.65
51510	-	-	.1969		5.000	5.0	50	16	13.60	13.01	12.42	11.83
51520	-	-	.2362		6.000	6.0	65	20	15.50	14.83	14.15	13.48
51150	-	-	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	14.78	14.14	13.49	12.85
51190	-	-	.3125	5/16"	7.938	5/16"	2-1/2"	7/8"	20.72	19.82	18.92	18.02
51530	-	-	.3150		8.000	8.0	65	22	21.76	20.81	19.87	18.92
51230	-	-	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	25.81	24.68	23.56	22.44
51540	-	-	.3937		10.000	10.0	70	25	31.41	30.04	28.68	27.31
51270	-	-	.4375	7/16"	11.113	7/16"	2-3/4"	1"	31.50	30.13	28.76	27.39
51310	-	-	.5000	1/2"	12.700	1/2"	3"	1"	41.33	39.53	37.74	35.94
51330	-	-	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	79.71	76.24	72.78	69.31
51560	-	-	.6299		16.000	16.0	88	32	83.69	80.05	76.41	72.77
51350	-	-	.7500	3/4"	19.050	3/4"	4"	1-1/2"	116.87	111.79	106.71	101.63
51570	-	-	.7874		20.000	20.0	100	38	156.03	149.25	142.46	135.68
51370	-	-	1.000	1"	25.400	1"	4"	1-1/2"	174.82	167.22	159.62	152.02
51400	-	-	1.250	1-1/4"	31.750	1-1/4"	4-1/2"	2"	510.39	488.20	466.01	443.82
51430	-	-	1.250	1-1/4"	31.750	1-1/4"	6"	3"	668.12	639.07	610.02	580.97
-	51114	-	.1875	3/16"	4.763	3/16"	2"	5/8"	14.42	13.79	13.17	12.54
-	51154	-	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	19.19	18.36	17.52	16.69
-	51194	-	.3125	5/16"	7.938	5/16"	2-1/2"	7/8"	26.61	25.45	24.30	23.14
-	51234	-	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	31.71	30.33	28.95	27.57
-	51274	-	.4375	7/16"	11.113	7/16"	2-3/4"	1"	38.58	36.91	35.23	33.55
-	51314	-	.5000	1/2"	12.700	1/2"	3"	1"	48.40	46.30	44.19	42.09
-	51334	-	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	90.72	86.78	82.83	78.89
-	51354	-	.7500	3/4"	19.050	3/4"	4"	1-1/2"	129.49	123.86	118.23	112.60
-	51374	-	1.000	1"	25.400	1"	4"	1-1/2"	193.75	185.33	176.90	168.48
-	51404	-	1.250	1-1/4"	31.750	1-1/4"	4-1/2"	2"	540.98	517.46	493.94	470.42
-	51434	-	1.250	1-1/4"	31.750	1-1/4"	6"	3"	702.72	672.17	641.61	611.06
-	-	51117	.1875	3/16"	4.763	3/16"	2"	5/8"	14.72	14.08	13.44	12.80
-	-	51517	.1969		5.000	5.0	50	16	17.45	16.69	15.93	15.17
<b>NEW</b>	-	51597	.1969		5.000	6.0	65	16	23.44	22.42	21.40	20.38
-	-	51527	.2362		6.000	6.0	65	20	20.57	19.68	18.78	17.89
-	-	51157	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	19.86	19.00	18.13	17.27
-	-	51197	.3125	5/16"	7.938	5/16"	2-1/2"	7/8"	28.32	27.09	25.86	24.63
-	-	51537	.3150		8.000	8.0	65	22	29.35	28.07	26.80	25.52
-	-	51237	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	33.42	31.97	30.51	29.06
-	-	51547	.3937		10.000	10.0	70	25	40.08	38.34	36.59	34.85
-	-	51277	.4375	7/16"	11.113	7/16"	2-3/4"	1"	40.17	38.42	36.68	34.93
-	-	51557	.4724		12.000	12.0	75	26	52.05	49.79	47.52	45.26
-	-	51317	.5000	1/2"	12.700	1/2"	3"	1"	49.98	47.81	45.63	43.46
-	-	51337	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	92.22	88.21	84.20	80.19
-	-	51567	.6299		16.000	16.0	88	32	96.21	92.03	87.84	83.66
-	-	51357	.7500	3/4"	19.050	3/4"	4"	1-1/2"	131.64	125.92	120.19	114.47
-	-	51577	.7874		20.000	20.0	100	38	177.85	170.12	162.38	154.65
-	-	51587	.9843		25.000	25.0	100	38	203.10	194.27	185.44	176.61
-	-	51377	1.000	1"	25.400	1"	4"	1-1/2"	196.66	188.11	179.56	171.01
-	-	51407	1.250	1-1/4"	31.750	1-1/4"	4-1/2"	2"	546.19	522.45	498.70	474.95
-	-	51437	1.250	1-1/4"	31.750	1-1/4"	6"	3"	703.92	673.31	642.71	612.10

**HIGH PERFORMANCE  
END MILLS**

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**MATERIAL HARDNESS (Rc)**

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