

Series 255MA, 855MA

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

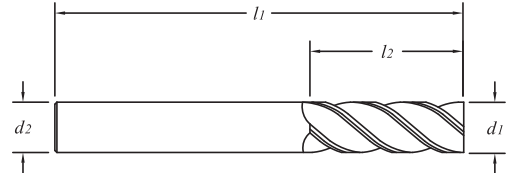


TOLERANCES	
d_1	+0.000" - .002" (+.000 - .050mm)
d_2	h6

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 136
- TiCN Coated - page 138



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35
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MATERIAL HARDNESS (Rc)

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	14.24	13.62	13.00	12.38	
40057	.1181	3.000	3.0	50	12	17.16	16.41	15.67	14.92	
52087	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	13.52	12.94	12.35	11.76
52097	.1250	1/8"	3.175	1/8"	2"	1/2"	16.31	15.60	14.89	14.18
40087	.1575	4.000	6.0	50	8	23.01	22.01	21.01	20.01	
40097	.1575	4.000	6.0	50	12	23.01	22.01	21.01	20.01	
52107	.1875	3/16"	4.763	3/16"	2"	5/16"	15.46	14.78	14.11	13.44
52127	.1875	3/16"	4.763	3/16"	2"	9/16"	15.46	14.78	14.11	13.44
40107	.1969	5.000	5.0	50	8	18.32	17.52	16.73	15.93	
40127	.1969	5.000	5.0	50	14	18.32	17.52	16.73	15.93	
40117	.1969	5.000	6.0	50	8	22.54	21.56	20.58	19.60	
40137	.1969	5.000	6.0	65	16	24.61	23.54	22.47	21.40	
40207	.2362	6.000	6.0	50	10	19.16	18.33	17.49	16.66	
40227	.2362	6.000	6.0	65	20	21.60	20.66	19.72	18.78	
40247	.2362	6.000	6.0	100	32	35.75	34.20	32.64	31.09	
52207	.2500	1/4"	6.350	1/4"	2"	3/8"	18.39	17.59	16.79	15.99
52227	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	20.85	19.94	19.04	18.13
52247	.2500	1/4"	6.350	1/4"	4"	1-1/4"	34.28	32.79	31.30	29.81
52307	.3125	5/16"	7.938	5/16"	2"	7/16"	25.42	24.31	23.21	22.10
52327	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	29.74	28.45	27.15	25.86
52347	.3125	5/16"	7.938	5/16"	4"	1-1/4"	46.71	44.68	42.65	40.62
40307	.3150	8.000	8.0	50	11	26.46	25.31	24.16	23.01	
40327	.3150	8.000	8.0	65	21	30.82	29.48	28.14	26.80	
40347	.3150	8.000	8.0	100	32	48.63	46.52	44.40	42.29	
40367	.3543	9.000	10.0	65	22	47.59	45.52	43.45	41.38	
52407	.3750	3/8"	9.525	3/8"	2"	1/2"	30.03	28.72	27.42	26.11
52427	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	35.09	33.56	32.04	30.51
52447	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	50.63	48.43	46.23	44.03
40407	.3937	10.000	10.0	50	12	34.75	33.24	31.73	30.22	
40427	.3937	10.000	10.0	70	22	42.08	40.25	38.42	36.59	
40447	.3937	10.000	10.0	88	38	62.15	59.44	56.74	54.04	
52507	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	42.18	40.35	38.51	36.68
52527	.4375	7/16"	11.113	7/16"	2-3/4"	1"	42.18	40.35	38.51	36.68
52547	.4375	7/16"	11.113	7/16"	4"	2"	67.45	64.52	61.58	58.65
40507	.4724	12.000	12.0	65	16	51.22	48.99	46.77	44.54	
40527	.4724	12.000	12.0	75	32	54.65	52.27	49.90	47.52	
40547	.4724	12.000	12.0	100	50	74.59	71.35	68.10	64.86	

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"	49.12	46.98	44.85	42.71
52627	.5000	1/2"	12.700	1/2"	3"	1-1/4"	52.47	50.19	47.91	45.63
52647	.5000	1/2"	12.700	1/2"	4"	2"	71.01	67.93	64.84	61.75
52707	.6250	5/8"	15.875	5/8"	3"	3/4"	87.08	83.29	79.51	75.72
52727	.6250	5/8"	15.875	5/8"	3-1/2"	1-5/8"	96.83	92.62	88.41	84.20
52747	.6250	5/8"	15.875	5/8"	6"	2-1/2"	141.61	135.45	129.30	123.14
40607	.6299		16.000	16.0	75	20	91.08	87.12	83.16	79.20
40627	.6299		16.000	16.0	88	41	101.02	96.62	92.23	87.84
40647	.6299		16.000	16.0	150	63	141.61	135.45	129.30	123.14
52807	.7500	3/4"	19.050	3/4"	3"	7/8"	122.68	117.35	112.01	106.68
52827	.7500	3/4"	19.050	3/4"	4"	1-5/8"	138.22	132.21	126.20	120.19
52837	.7500	3/4"	19.050	3/4"	5"	2"	185.52	177.45	169.39	161.32
52847	.7500	3/4"	19.050	3/4"	6"	3-1/4"	217.11	207.67	198.23	188.79
40727	.7874		20.000	20.0	100	41	186.74	178.62	170.50	162.38
40747	.7874		20.000	20.0	150	82	234.24	224.06	213.87	203.69
40787	.9843		25.000	25.0	100	28	213.26	203.98	194.71	185.44
40827	.9843		25.000	25.0	100	50	213.26	203.98	194.71	185.44
40847	.9843		25.000	25.0	150	82	345.09	330.09	315.08	300.08
52897	1.000	1"	25.400	1"	4"	1-1/8"	206.49	197.52	188.54	179.56
52927	1.000	1"	25.400	1"	4"	2"	206.49	197.52	188.54	179.56
52947	1.000	1"	25.400	1"	6"	3-1/4"	360.04	344.39	328.73	313.08

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MATERIAL HARDNESS (Rc)

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End Mill Manufacturing