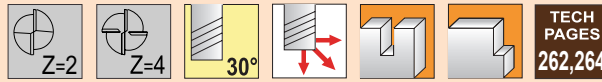


TOLERANCES

d_1	+0.01" -0.000" (+0.025 -0.000mm)
d_2	h6

Series 280M, 290M, 380M, 390M



END MILLS

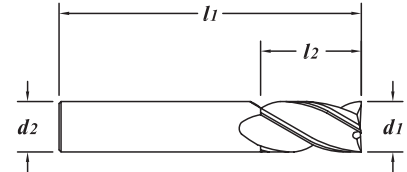
Standard Length - N/C Tolerance - Square End

Solid submicron grain carbide end mill - center cutting

Excellent for keyways

Tight tolerance for precision machining

For use when matching tools are necessary



(280M) 2 Flute EDP#	(290M) 4 Flute 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								
25010	26010	.0625	1/16"	1.588	1/8"	1-1/2"	1/4"	13.50	12.91	12.33	11.74
25020	26020	.0938	3/32"	2.383	1/8"	1-1/2"	5/16"	12.79	12.23	11.68	11.12
25030	26030	.1250	1/8"	3.175	1/8"	1-1/2"	1/2"	12.42	11.88	11.34	10.80
25040	26040	.1875	3/16"	4.763	3/16"	2"	9/16"	16.51	15.80	15.08	14.36
25050	26050	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	18.99	18.16	17.34	16.51
25060	26060	.3125	5/16"	7.938	5/16"	2-1/2"	7/8"	27.19	26.00	24.82	23.64
* 25070	* 26070	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	34.89	33.37	31.86	30.34
* 25080	* 26080	.4375	7/16"	11.113	7/16"	2-3/4"	1"	42.57	40.72	38.87	37.02
* 25090	* 26090	.5000	1/2"	12.700	1/2"	3"	1"	55.89	53.46	51.03	48.60
* 25100	* 26100	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	99.49	95.16	90.84	86.51
-	* 26110	.7500	3/4"	19.050	3/4"	4"	1-1/2"	148.79	142.32	135.85	129.38
* 25120	* 26120	1.000	1"	25.400	1"	4"	1-1/2"	252.68	241.69	230.71	219.72

70

Standard Length - N/C Tolerance - Ball End

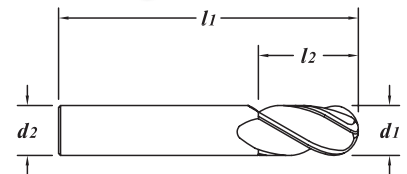
Solid submicron grain carbide end mill - center cutting

Excellent for keyways

Tight tolerance for precision machining

For use when matching tools are necessary

Ball radius tolerance +.0005" -0.0000" (+0.0127mm -0.0000mm)



35

(380M) 2 Flute EDP#	(390M) 4 Flute 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								
27010	28010	.0625	1/16"	1.588	1/8"	1-1/2"	1/4"	15.54	14.86	14.19	13.51
27020	28020	.0938	3/32"	2.383	1/8"	1-1/2"	5/16"	14.73	14.09	13.45	12.81
27030	28030	.1250	1/8"	3.175	1/8"	1-1/2"	1/2"	14.28	13.66	13.04	12.42
27040	28040	.1875	3/16"	4.763	3/16"	2"	9/16"	18.99	18.16	17.34	16.51
27050	28050	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	21.86	20.91	19.96	19.01
27060	28060	.3125	5/16"	7.938	5/16"	2-1/2"	7/8"	31.25	29.89	28.53	27.17
* 27070	* 28070	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	40.14	38.39	36.65	34.90
-	* 28080	.4375	7/16"	11.113	7/16"	2-3/4"	1"	48.93	46.81	44.68	42.55
* 27090	* 28090	.5000	1/2"	12.700	1/2"	3"	1"	64.29	61.49	58.70	55.90
-	* 28100	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	114.45	109.47	104.50	99.52
* 27110	* 28110	.7500	3/4"	19.050	3/4"	4"	1-1/2"	171.11	163.67	156.23	148.79
* 27120	* 28120	1.000	1"	25.400	1"	4"	1-1/2"	290.58	277.95	265.31	252.68

MATERIAL HARDNESS (Rc)

0

* - Tools with weldon flats