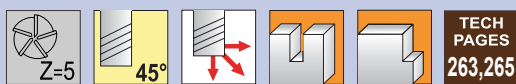


Series 255MC

.1875" - 1.000"
(4.763mm - 25.400mm)



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

Recommended for steels, stainless steel, and exotics

Square End

TiCN Coated

Solid submicron grain carbide end mill - center cutting

High performance milling

Rigid work holding, machine stability and part integrity are critical!

Improved abrasion resistance and lubricity

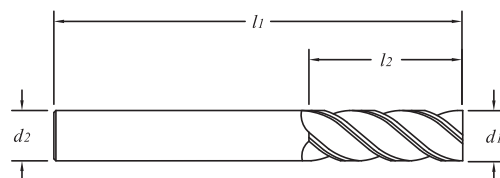
Improved finishes in titanium

Heavy core

Sharp corners

AlTiN Coating - page 134

Uncoated - page 136



MATERIAL HARDNESS (Rc)

70

35

0

| 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 | | | | | | | | |
| 52104 | .1875 | 3/16" | 4.763 | 3/16" | 2" | 5/16" | 14.42 | 13.79 | 13.17 | 12.54 |
| 52124 | .1875 | 3/16" | 4.763 | 3/16" | 2" | 9/16" | 14.42 | 13.79 | 13.17 | 12.54 |
| 52204 | .2500 | 1/4" | 6.350 | 1/4" | 2" | 3/8" | 16.73 | 16.01 | 15.28 | 14.55 |
| 52224 | .2500 | 1/4" | 6.350 | 1/4" | 2-1/2" | 3/4" | 19.19 | 18.36 | 17.52 | 16.69 |
| 52244 | .2500 | 1/4" | 6.350 | 1/4" | 4" | 1-1/4" | 31.45 | 30.09 | 28.72 | 27.35 |
| 52304 | .3125 | 5/16" | 7.938 | 5/16" | 2" | 7/16" | 23.47 | 22.45 | 21.43 | 20.41 |
| 52324 | .3125 | 5/16" | 7.938 | 5/16" | 2-1/2" | 13/16" | 26.61 | 25.45 | 24.30 | 23.14 |
| 52344 | .3125 | 5/16" | 7.938 | 5/16" | 4" | 1-1/4" | 42.15 | 40.32 | 38.48 | 36.65 |
| 52404 | .3750 | 3/8" | 9.525 | 3/8" | 2" | 1/2" | 27.88 | 26.66 | 25.45 | 24.24 |
| 52424 | .3750 | 3/8" | 9.525 | 3/8" | 2-1/2" | 7/8" | 31.71 | 30.33 | 28.95 | 27.57 |
| 52444 | .3750 | 3/8" | 9.525 | 3/8" | 3-1/2" | 1-1/2" | 45.86 | 43.87 | 41.87 | 39.88 |
| 52504 | .4375 | 7/16" | 11.113 | 7/16" | 2-1/2" | 9/16" | 38.58 | 36.91 | 35.23 | 33.55 |
| 52524 | .4375 | 7/16" | 11.113 | 7/16" | 2-3/4" | 1" | 38.58 | 36.91 | 35.23 | 33.55 |
| 52544 | .4375 | 7/16" | 11.113 | 7/16" | 4" | 2" | 61.87 | 59.18 | 56.49 | 53.80 |
| 52604 | .5000 | 1/2" | 12.700 | 1/2" | 2-1/2" | 5/8" | 45.20 | 43.23 | 41.27 | 39.30 |
| 52624 | .5000 | 1/2" | 12.700 | 1/2" | 3" | 1-1/4" | 48.40 | 46.30 | 44.19 | 42.09 |
| 52644 | .5000 | 1/2" | 12.700 | 1/2" | 4" | 2" | 65.26 | 62.43 | 59.59 | 56.75 |
| 52704 | .6250 | 5/8" | 15.875 | 5/8" | 3" | 3/4" | 82.40 | 78.82 | 75.23 | 71.65 |
| 52724 | .6250 | 5/8" | 15.875 | 5/8" | 3-1/2" | 1-5/8" | 90.72 | 86.78 | 82.83 | 78.89 |
| 52744 | .6250 | 5/8" | 15.875 | 5/8" | 6" | 2-1/2" | 131.73 | 126.01 | 120.28 | 114.55 |
| 52804 | .7500 | 3/4" | 19.050 | 3/4" | 3" | 7/8" | 116.52 | 111.45 | 106.39 | 101.32 |
| 52824 | .7500 | 3/4" | 19.050 | 3/4" | 4" | 1-5/8" | 129.49 | 123.86 | 118.23 | 112.60 |
| 52844 | .7500 | 3/4" | 19.050 | 3/4" | 6" | 3-1/4" | 202.88 | 194.06 | 185.24 | 176.42 |
| 52894 | 1.000 | 1" | 25.400 | 1" | 4" | 1-1/8" | 193.79 | 185.36 | 176.94 | 168.51 |
| 52924 | 1.000 | 1" | 25.400 | 1" | 4" | 2" | 193.79 | 185.36 | 176.94 | 168.51 |
| 52944 | 1.000 | 1" | 25.400 | 1" | 6" | 3-1/4" | 339.88 | 325.11 | 310.33 | 295.55 |