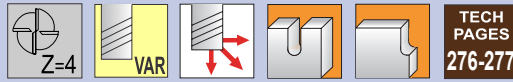


TOLERANCES

d_1	+0.000" -0.002" (+.000mm -0.050mm)
d_2	h6
ball radius	+0.000" -0.001" (+.000 -0.25mm)



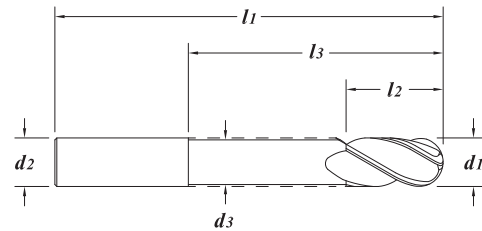
Recommended for Titanium, Inconel, and Steels

Variable Helix End Mill - Ball End

AlCrN Coating

- Solid submicron grain carbide end mill - center cutting
- Helix geometry varies over length of flutes
- Variable flute design helps with chip evacuation in slots and pockets
- Variable rake aids in chip formation
- PCT (Polish Carbide Treatment) enhances tool life by 20%
- Minimizes burr on part
- Can be modified with a flat within 48 hours
- V4 Square End - page 149
- V4 Corner Radius - page 150

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	l_3 Reach Length	d_3 Neck Diameter				
							1-11	12-24	25-49	50-100
50252	-	6.000	65	12	-	-	25.74	24.62	23.50	22.38
50253	-	6.000	65	19	-	-	25.74	24.62	23.50	22.38
50560	1/4"	6.350	2"	3/8"	-	-	22.34	21.37	20.40	19.43
50254	1/4"	6.350	2-1/2"	3/4"	-	-	24.75	23.67	22.60	21.52
50561	5/16"	7.937	2"	7/16"	-	-	30.51	29.18	27.86	26.53
50255	5/16"	7.937	2-1/2"	13/16"	-	-	33.52	32.07	30.61	29.15
50256	-	8.000	65	22	-	-	34.79	33.28	31.76	30.25
50562	3/8"	9.525	2"	1/2"	-	-	36.02	34.45	32.89	31.32
50257	3/8"	9.525	2-1/2"	1"	-	-	39.16	37.46	35.75	34.05
50258	-	10.000	70	22	-	-	47.28	45.22	43.17	41.11
50470	50469	12.000	75	26	-	-	69.64	66.62	63.59	60.56
50259	50291	12.000	75	32	-	-	69.64	66.62	63.59	60.56
50576	-	12.000	100	42	-	-	81.05	77.53	74.00	70.48
50563	1/2"	12.700	2-1/2"	5/8"	-	-	59.85	57.25	54.65	52.04
50472	50473	12.700	3"	1"	-	-	66.80	63.90	60.99	58.09
50260	50292	12.700	3"	1-1/4"	-	-	66.80	63.90	60.99	58.09
50592	50593	12.700	4"	1-5/8"	-	-	78.96	75.53	72.09	68.66
50261	50293	12.700	4"	2-1/8"	-	-	78.96	75.53	72.09	68.66
50598	-	12.700	6"	5/8"	4-1/8"	.470"	122.84	117.50	112.16	106.82
50262	50294	15.875	3-1/2"	1-1/4"	-	-	106.35	101.73	97.10	92.48
50263	50295	16.000	88	32	-	-	110.99	106.16	101.34	96.51
50264	50296	19.050	4"	1-1/2"	-	-	152.51	145.88	139.25	132.62
50265	50297	20.000	100	38	-	-	215.86	206.47	197.09	187.70
50266	50298	25.400	4"	1-1/2"	-	-	260.38	249.06	237.74	226.42

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MATERIAL HARDNESS (Rc)

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