

# 253MA (853MA metric) - 3 Flute

Technical information:  
page 229, 231

**TOLERANCES**

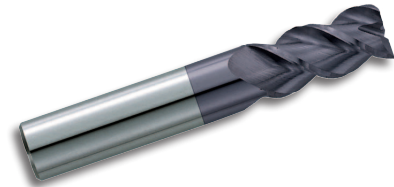
$d1$	+.000" -.002" (+.000 -.050mm)	
$d2$	3mm - 6mm	+0.000" -.0003" (+.0000 -.0075mm)
	1/4" - 1"	-.0001" -.0004" (-.0025 -.0100mm)

.1181" - .5625"  
(3.000mm - 14.288mm)

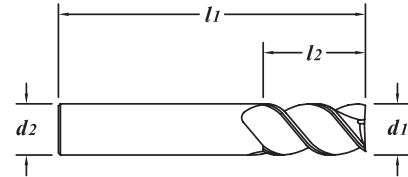


## Balinit® X.CEED Coated

Uncoated - page 116  
TiCN Coated - page 118



- Solid submicron grain carbide end mill - center cutting
- High performance machining
- Rigid work holding, machine stability and part integrity are critical!
- Dry or semi-dry machining
- Up to 40% faster than uncoated
- Slots stainless steel at an axial depth of 25% of diameter
- Recommended for stainless steel**
- Sharp corners (Can be modified with a corner radius)



EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
10347	.1181	3.000	3.0	38	8	13.56	12.97	12.38	11.79	
10357	.1181	3.000	3.0	50	12	16.34	15.63	14.92	14.21	
86137	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	12.88	12.32	11.76	11.20
86147	.1250	1/8"	3.175	1/8"	2"	1/2"	15.53	14.85	14.18	13.50
10387	.1575	4.000	6.0	50	8	21.92	20.97	20.01	19.06	
10397	.1575	4.000	6.0	50	12	21.92	20.97	20.01	19.06	
86157	.1875	3/16"	4.763	3/16"	2"	5/16"	14.72	14.08	13.44	12.80
86167	.1875	3/16"	4.763	3/16"	2"	9/16"	14.72	14.08	13.44	12.80
86187	.1875	3/16"	4.763	3/16"	3"	1"	25.67	24.55	23.44	22.32
10407	.1969	5.000	5.0	50	8	17.45	16.69	15.93	15.17	
10417	.1969	5.000	5.0	50	14	17.45	16.69	15.93	15.17	
10017	.2362	6.000	6.0	50	12	18.25	17.46	16.66	15.87	
10027	.2362	6.000	6.0	65	19	20.57	19.68	18.78	17.89	
10037	.2362	6.000	6.0	75	32	31.71	30.33	28.95	27.57	
86207	.2500	1/4"	6.350	1/4"	2"	1/2"	17.51	16.75	15.99	15.23
86227	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	19.86	19.00	18.13	17.27
86247	.2500	1/4"	6.350	1/4"	3"	1-1/4"	30.36	29.04	27.72	26.40
86267	.3125	5/16"	7.938	5/16"	2"	7/16"	24.21	23.16	22.10	21.05
86277	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	28.32	27.09	25.86	24.63
86287	.3125	5/16"	7.938	5/16"	4"	1-1/4"	44.49	42.56	40.62	38.69
10427	.3150	8.000	8.0	50	11	25.20	24.10	23.01	21.91	
10047	.3150	8.000	8.0	65	20	29.35	28.07	26.80	25.52	
10057	.3150	8.000	8.0	75	32	40.46	38.70	36.94	35.18	
86307	.3750	3/8"	9.525	3/8"	2"	1/2"	28.60	27.36	26.11	24.87
86327	.3750	3/8"	9.525	3/8"	2-1/2"	1"	33.42	31.97	30.51	29.06
86347	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	48.22	46.12	44.03	41.93
10067	.3937	10.000	10.0	50	12	33.10	31.66	30.22	28.78	
10077	.3937	10.000	10.0	75	25	46.75	44.72	42.68	40.65	
10087	.3937	10.000	10.0	88	38	59.19	56.62	54.04	51.47	
86367	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	40.17	38.42	36.68	34.93
86377	.4375	7/16"	11.113	7/16"	2-3/4"	1"	40.17	38.42	36.68	34.93
86387	.4375	7/16"	11.113	7/16"	4"	2"	64.24	61.45	58.65	55.86
10097	.4724	12.000	12.0	65	16	48.78	46.66	44.54	42.42	
10107	.4724	12.000	12.0	75	25	52.05	49.79	47.52	45.26	
10117	.4724	12.000	12.0	100	50	71.04	67.95	64.86	61.77	
86407	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	46.78	44.75	42.71	40.68
86427	.5000	1/2"	12.700	1/2"	3"	1"	49.98	47.81	45.63	43.46
86447	.5000	1/2"	12.700	1/2"	4"	2"	67.63	64.69	61.75	58.81
10437	.5512	14.000	14.0	65	16	72.84	69.67	66.51	63.34	
10447	.5512	14.000	14.0	75	25	77.99	74.60	71.21	67.82	
10457	.5512	14.000	14.0	100	50	94.66	90.54	86.43	82.31	
86467	.5625	9/16"	14.288	9/16"	3"	7/8"	78.21	74.81	71.41	68.01
86477	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"	83.11	79.50	75.88	72.27
86487	.5625	9/16"	14.288	9/16"	6"	2-1/2"	125.71	120.24	114.78	109.31

## 253MA (853MA metric) - 3 Flute (continued)

.6250" - 1.000"  
(15.875mm - 25.400mm)

HIGH PERFORMANCE  
END MILLS

EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric								
86507	.6250	5/8"	15.875	5/8"	3"	7/8"	82.93	79.32	75.72	72.11
86527	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	92.22	88.21	84.20	80.19
86547	.6250	5/8"	15.875	5/8"	6"	2-1/2"	134.87	129.01	123.14	117.28
10127	.6299		16.000	16.0	75	20	86.74	82.97	79.20	75.43
10137	.6299		16.000	16.0	88	32	96.21	92.03	87.84	83.66
10147	.6299		16.000	16.0	150	65	134.87	129.01	123.14	117.28
10167	.7087		18.000	18.0	100	38	137.47	131.49	125.52	119.54
10177	.7087		18.000	18.0	150	75	196.35	187.81	179.28	170.74
86607	.7500	3/4"	19.050	3/4"	3-1/2"	1"	131.64	125.92	120.19	114.47
86627	.7500	3/4"	19.050	3/4"	4"	1-1/2"	131.64	125.92	120.19	114.47
86647	.7500	3/4"	19.050	3/4"	6"	3"	206.77	197.78	188.79	179.80
10467	.7874		20.000	20.0	75	22	159.44	152.50	145.57	138.64
10187	.7874		20.000	20.0	100	38	177.85	170.12	162.38	154.65
10197	.7874		20.000	20.0	150	75	223.09	213.39	203.69	193.99
10217	.9843		25.000	25.0	100	28	203.10	194.27	185.44	176.61
10487	.9843		25.000	25.0	100	50	203.10	194.27	185.44	176.61
10497	.9843		25.000	25.0	150	82	328.66	314.37	300.08	285.79
86697	1.000	1"	25.400	1"	4"	1-1/8"	196.66	188.11	179.56	171.01
86727	1.000	1"	25.400	1"	4"	2"	196.66	188.11	179.56	171.01
86747	1.000	1"	25.400	1"	6"	3-1/4"	342.90	327.99	313.08	298.17