

253MC - 3 Flute

Technical information: page 229, 231

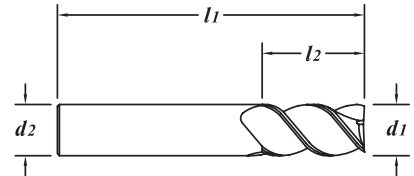


TOLERANCES		
$d1$	+.000" -.002" (+.000 -.050mm)	
$d2$	3mm - 6mm	+.0000" -.0003" (+.0000 -.0075mm)
	1/4" - 1"	-.0001" -.0004" (-.0025 -.0100mm)

TiCN Coated

X.CEED Coated - page 114
Uncoated - page 116

- Solid submicron grain carbide end mill - center cutting
- High performance machining
- Rigid work holding, machine stability and part integrity are critical!
- Improved abrasion resistance and lubricity
- Up to 25% faster than uncoated
- Slots aluminum and stainless steel at an axial depth of 25% of diameter
- Recommended for aluminum and 303 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								
86154	.1875	3/16"	4.763	3/16"	2"	5/16"	14.42	13.79	13.17	12.54
86164	.1875	3/16"	4.763	3/16"	2"	9/16"	14.42	13.79	13.17	12.54
86184	.1875	3/16"	4.763	3/16"	3"	1"	24.87	23.79	22.71	21.63
86204	.2500	1/4"	6.350	1/4"	2"	1/2"	16.73	16.01	15.28	14.55
86224	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	19.19	18.36	17.52	16.69
86244	.2500	1/4"	6.350	1/4"	3"	1-1/4"	29.69	28.40	27.11	25.82
86264	.3125	5/16"	7.938	5/16"	2"	7/16"	23.47	22.45	21.43	20.41
86274	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	26.61	25.45	24.30	23.14
86284	.3125	5/16"	7.938	5/16"	4"	1-1/4"	42.15	40.32	38.48	36.65
86304	.3750	3/8"	9.525	3/8"	2"	1/2"	27.88	26.66	25.45	24.24
86324	.3750	3/8"	9.525	3/8"	2-1/2"	1"	30.58	29.25	27.92	26.59
86344	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	45.86	43.87	41.87	39.88
86364	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	38.58	36.91	35.23	33.55
86374	.4375	7/16"	11.113	7/16"	2-3/4"	1"	38.58	36.91	35.23	33.55
86384	.4375	7/16"	11.113	7/16"	4"	2"	61.87	59.18	56.49	53.80
86404	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	45.20	43.23	41.27	39.30
86424	.5000	1/2"	12.700	1/2"	3"	1"	48.40	46.30	44.19	42.09
86444	.5000	1/2"	12.700	1/2"	4"	2"	65.26	62.43	59.59	56.75
86464	.5625	9/16"	14.288	9/16"	3"	7/8"	77.68	74.31	70.93	67.55
86474	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"	81.62	78.07	74.52	70.97
86484	.5625	9/16"	14.288	9/16"	6"	2-1/2"	122.54	117.22	111.89	106.56
86504	.6250	5/8"	15.875	5/8"	3"	7/8"	82.40	78.82	75.23	71.65
86524	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	90.72	86.78	82.83	78.89
86544	.6250	5/8"	15.875	5/8"	6"	2-1/2"	131.73	126.01	120.28	114.55
86604	.7500	3/4"	19.050	3/4"	3-1/2"	1"	129.49	123.86	118.23	112.60
86624	.7500	3/4"	19.050	3/4"	4"	1-1/2"	129.49	123.86	118.23	112.60
86644	.7500	3/4"	19.050	3/4"	6"	3"	202.88	194.06	185.24	176.42
86694	1.000	1"	25.400	1"	4"	1-1/8"	193.79	185.36	176.94	168.51
86724	1.000	1"	25.400	1"	4"	2"	193.79	185.36	176.94	168.51
86744	1.000	1"	25.400	1"	6"	3-1/4"	339.88	325.11	310.33	295.55