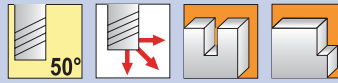


253M (853M metric) - 3 Flute

Technical information:
page 229, 231



TOLERANCES		
d_1	+.000"-.002" (+.000-.050mm)	
d_2	3mm - 6mm	+.0000"-.0003" (+.0000-.0075mm)
	1/4" - 1"	-.0001"-.0004" (-.0025-.0100mm)

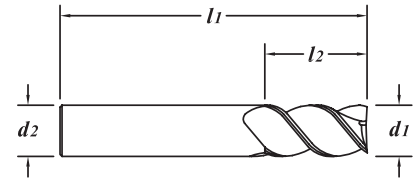
.1181" - .5625"
(3.000mm - 14.288mm)

X.CEED Coated - page 114
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!
- Slots aluminum at an axial depth of 25% of diameter

Recommended for aluminum and stainless steel

Sharp corners (Can be modified with a corner radius)



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								
10340	.1181	3.000	3.0	38	8	11.07	10.59	10.11	9.63	
10350	.1181	3.000	3.0	50	12	13.34	12.76	12.18	11.60	
86130	.1250	1/8"	3.175	1-1/2"	1/4"	10.40	9.94	9.49	9.04	
86140	.1250	1/8"	3.175	1/8"	1/2"	12.52	11.98	11.43	10.89	
10380	.1575	4.000	6.0	50	8	18.00	17.22	16.43	15.65	
10390	.1575	4.000	6.0	50	12	18.00	17.22	16.43	15.65	
86150	.1875	3/16"	4.763	3/16"	2"	5/16"	12.25	11.72	11.18	10.65
86160	.1875	3/16"	4.763	3/16"	2"	9/16"	12.25	11.72	11.18	10.65
86180	.1875	3/16"	4.763	3/16"	3"	1"	21.83	20.88	19.93	18.98
10400	.1969	5.000	5.0	50	8	13.60	13.01	12.42	11.83	
10410	.1969	5.000	5.0	50	14	13.60	13.01	12.42	11.83	
10010	.2362	6.000	6.0	50	12	14.42	13.79	13.17	12.54	
10020	.2362	6.000	6.0	65	19	15.50	14.83	14.15	13.48	
10030	.2362	6.000	6.0	75	32	26.61	25.45	24.30	23.14	
86200	.2500	1/4"	6.350	1/4"	2"	1/2"	13.67	13.08	12.48	11.89
86220	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	14.78	14.14	13.49	12.85
86240	.2500	1/4"	6.350	1/4"	3"	1-1/4"	25.30	24.20	23.10	22.00
86260	.3125	5/16"	7.938	5/16"	2"	7/16"	18.70	17.89	17.07	16.26
86270	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	20.72	19.82	18.92	18.02
86280	.3125	5/16"	7.938	5/16"	4"	1-1/4"	34.81	33.30	31.78	30.27
10420	.3150	8.000	8.0	50	11	19.71	18.85	18.00	17.14	
10040	.3150	8.000	8.0	65	20	21.76	20.81	19.87	18.92	
10050	.3150	8.000	8.0	75	32	32.87	31.44	30.01	28.58	
86300	.3750	3/8"	9.525	3/8"	2"	1/2"	23.10	22.10	21.09	20.09
86320	.3750	3/8"	9.525	3/8"	2-1/2"	1"	25.81	24.68	23.56	22.44
86340	.3750	3/8"	9.525	3/8"	3-1/2"	1-1/2"	38.55	36.87	35.20	33.52
10060	.3937	10.000	10.0	50	12	26.88	25.71	24.54	23.37	
10070	.3937	10.000	10.0	75	25	38.10	36.44	34.79	33.13	
10080	.3937	10.000	10.0	88	38	47.99	45.90	43.82	41.73	
86360	.4375	7/16"	11.113	7/16"	2-1/2"	9/16"	31.50	30.13	28.76	27.39
86370	.4375	7/16"	11.113	7/16"	2-3/4"	1"	31.50	30.13	28.76	27.39
86380	.4375	7/16"	11.113	7/16"	4"	2"	53.04	50.73	48.43	46.12
10090	.4724	12.000	12.0	65	16	40.14	38.39	36.65	34.90	
10100	.4724	12.000	12.0	75	25	43.40	41.51	39.63	37.74	
10110	.4724	12.000	12.0	100	50	59.80	57.20	54.60	52.00	
86400	.5000	1/2"	12.700	1/2"	2-1/2"	5/8"	38.12	36.47	34.81	33.15
86420	.5000	1/2"	12.700	1/2"	3"	1"	41.33	39.53	37.74	35.94
86440	.5000	1/2"	12.700	1/2"	4"	2"	56.42	53.97	51.51	49.06
10430	.5512	14.000	14.0	65	16	62.80	60.07	57.34	54.61	
10440	.5512	14.000	14.0	75	25	67.94	64.99	62.03	59.08	
10450	.5512	14.000	14.0	100	50	82.14	78.57	75.00	71.43	
86460	.5625	9/16"	14.288	9/16"	3"	7/8"	68.18	65.22	62.25	59.29
86470	.5625	9/16"	14.288	9/16"	3-1/2"	1-1/4"	70.59	67.52	64.45	61.38
86480	.5625	9/16"	14.288	9/16"	6"	2-1/2"	107.10	102.44	97.79	93.13

253M (853M 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								
86500	.6250	5/8"	15.875	5/8"	3"	7/8"	72.90	69.73	66.56	63.39
86520	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	79.71	76.24	72.78	69.31
86540	.6250	5/8"	15.875	5/8"	6"	2-1/2"	116.28	111.22	106.17	101.11
10120	.6299		16.000	16.0	75	20	76.72	73.38	70.05	66.71
10130	.6299		16.000	16.0	88	32	83.69	80.05	76.41	72.77
10140	.6299		16.000	16.0	150	65	116.28	111.22	106.17	101.11
10160	.7087		18.000	18.0	100	38	122.71	117.37	112.04	106.70
10170	.7087		18.000	18.0	150	75	174.82	167.22	159.62	152.02
86600	.7500	3/4"	19.050	3/4"	3-1/2"	1"	116.87	111.79	106.71	101.63
86620	.7500	3/4"	19.050	3/4"	4"	1-1/2"	116.87	111.79	106.71	101.63
86640	.7500	3/4"	19.050	3/4"	6"	3"	185.24	177.19	169.13	161.08
10460	.7874		20.000	20.0	75	22	142.17	135.99	129.81	123.63
10180	.7874		20.000	20.0	100	38	156.03	149.25	142.46	135.68
10190	.7874		20.000	20.0	150	75	195.14	186.66	178.17	169.69
10210	.9843		25.000	25.0	100	28	181.26	173.38	165.50	157.62
10480	.9843		25.000	25.0	100	50	181.26	173.38	165.50	157.62
10490	.9843		25.000	25.0	150	82	300.71	287.64	274.56	261.49
86690	1.000	1"	25.400	1"	4"	1-1/8"	174.82	167.22	159.62	152.02
86720	1.000	1"	25.400	1"	4"	2"	174.82	167.22	159.62	152.02
86740	1.000	1"	25.400	1"	6"	3-1/4"	314.94	301.25	287.55	273.86