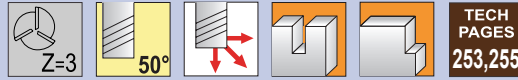


Series 253MA, 853MA

.1181" - .5512"  
(3.000mm - 14.000mm)

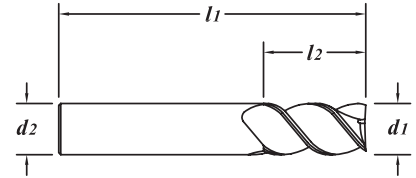


TOLERANCES	
$d_1$	+0.000" - .002" (+.000 - .050mm)
$d_2$	h6

Recommended for stainless steel

Square End  
AlTiN Coating

- 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
- Slots stainless steel at an axial depth of 25% of diameter
- Sharp corners (Can be modified with a corner radius)
- Uncoated - page 132
- TiCN Coated - page 134



70  
35  
0  
MATERIAL HARDNESS (Rc)

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								
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	

EDP#	$d1$ †		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Diameter								Metric
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
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

70

35

MATERIAL HARDNESS (Rc)

0



*1180 Series  
High Performance Drill in aluminum  
reference (pg. 17)*