

V4B

TOLERANCES

d_1	+0.000" - .002" (+.000mm - .050mm)
d_2	h6
ball radius	+0.000" - .001" (+.000 - .025mm)



Recommended for Titanium, Inconel, and Steels (< 40Rc)



Variable Helix End Mill - 4 Flute - Ball End

AlCrN Coated

Solid submicron grain carbide end mill - center cutting

PCT (Polish Carbide Treatment) enhances tool life by 20%

Minimizes burr on part

Helix geometry varies over length of flutes

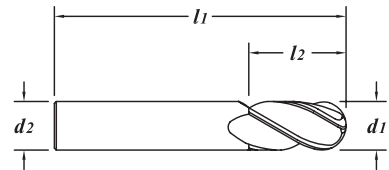
Variable flute design helps with chip evacuation in slots and pockets

Variable rake aids in chip formation

12mm and larger tools offered with weldon flat

Smaller diameters can be modified with a flat within 48 hours

The combination of an extended flute length with a weldon flat may cause the flute washout to reach inside some end mill holders



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MATERIAL HARDNESS (Rc)

0

EDP#		d_1 †		d_2	l_1	l_2	1-11	12-24	25-49	50-100	
(plain)	(weldon)	Decimal	Diameter	Shank Diameter	Overall Length	Flute Length					
50252	-	.2362"	6.000	6.0	65	12	25.74	24.62	23.50	22.38	
50253	-	.2362"	6.000	6.0	65	19	25.74	24.62	23.50	22.38	
NEW	50560	.2500"	1/4"	6.350	1/4"	2"	22.34	21.37	20.40	19.43	
50254	-	.2500"	1/4"	6.350	1/4"	2-1/2"	24.75	23.67	22.60	21.52	
NEW	50561	.3125"	5/16"	7.937	5/16"	2"	7/16"	30.51	29.18	27.86	26.53
50255	-	.3125"	5/16"	7.937	5/16"	2-1/2"	13/16"	33.52	32.07	30.61	29.15
50256	-	.3150"	8.000	8.0	65	22	34.79	33.28	31.76	30.25	
NEW	50562	.3750"	3/8"	9.525	3/8"	2"	1/2"	36.02	34.45	32.89	31.32
50257	-	.3750"	3/8"	9.525	3/8"	2-1/2"	1"	39.16	37.46	35.75	34.05
50258	-	.3937"	10.000	10.0	70	22	47.28	45.22	43.17	41.11	
50470	50469	.4724"	12.000	12.0	75	26	69.64	66.62	63.59	60.56	
50259	50291	.4724"	12.000	12.0	75	32	69.64	66.62	63.59	60.56	
NEW	50563	.5000"	1/2"	12.700	1/2"	2-1/2"	5/8"	59.85	57.25	54.65	52.04
50472	50473	.5000"	1/2"	12.700	1/2"	3"	1"	66.80	63.90	60.99	58.09
50260	50292	.5000"	1/2"	12.700	1/2"	3"	1-1/4"	66.80	63.90	60.99	58.09
50261	50293	.5000"	1/2"	12.700	1/2"	4"	2-1/8"	78.96	75.53	72.09	68.66
50262	50294	.6250"	5/8"	15.875	5/8"	3-1/2"	1-1/4"	106.35	101.73	97.10	92.48
50263	50295	.6299"	16.000	16.0	88	32	110.99	106.16	101.34	96.51	
50264	50296	.7500"	3/4"	19.050	3/4"	4"	1-1/2"	152.51	145.88	139.25	132.62
50265	50297	.7874"	20.000	20.0	100	38	215.86	206.47	197.09	187.70	
50266	50298	1.000"	1"	25.400	1"	4"	1-1/2"	260.38	249.06	237.74	226.42