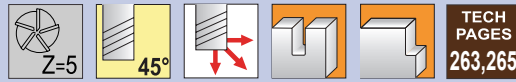


TOLERANCES

<i>d1</i>	+0.000" - .002" (+0.000 - .050mm)
<i>d2</i>	h6
<i>r</i>	+0.001" - .001" (+.025 - .025mm)



Series 255RA, 855RA

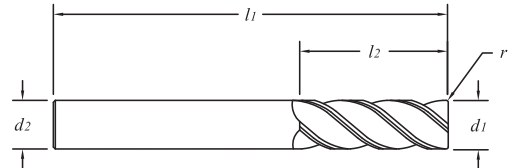
.1181" - .3125"
(3.000mm - 7.938mm)

Recommended for steels, stainless steel, and exotics

Corner Radius

AlTiN Coating

- Solid submicron grain carbide end mill - center cutting
- High performance milling
- Rigid work holding, machine stability and part integrity are critical!
- Dry or semi-dry machining
- Improved finishes in titanium
- Heavy core



EDP#	<i>d1</i> † Diameter		<i>d2</i> Shank Diameter	<i>l1</i> Overall Length	<i>l2</i> Flute Length	<i>r</i> Corner Radius	1-11	12-24	25-49	50-100	
	Decimal	Metric									
83527	.1181	3.000	3.0	38	8	0.20	14.81	14.17	13.52	12.88	
83537	.1181	3.000	3.0	38	8	0.50	14.81	14.17	13.52	12.88	
83547	.1181	3.000	3.0	50	12	0.20	17.74	16.97	16.20	15.43	
83550	.1181	3.000	3.0	50	12	0.30	17.74	16.97	16.20	15.43	
83557	.1181	3.000	3.0	50	12	0.50	17.74	16.97	16.20	15.43	
83567	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	.010"	14.08	13.46	12.85	12.24
83577	.1250	1/8"	3.175	1/8"	1-1/2"	1/4"	.020"	14.08	13.46	12.85	12.24
83587	.1250	1/8"	3.175	1/8"	2"	1/2"	.010"	17.30	16.54	15.79	15.04
83597	.1250	1/8"	3.175	1/8"	2"	1/2"	.020"	17.30	16.54	15.79	15.04
83600	.1250	1/8"	3.175	1/8"	2"	1/2"	.030"	17.30	16.54	15.79	15.04
83607	.1575		4.000	6.0	50	8	0.30	23.87	22.84	21.80	20.76
83617	.1575		4.000	6.0	50	8	0.50	23.87	22.84	21.80	20.76
83627	.1575		4.000	6.0	50	12	0.30	23.87	22.84	21.80	20.76
83637	.1575		4.000	6.0	50	12	0.50	23.87	22.84	21.80	20.76
83647	.1875	3/16"	4.763	3/16"	2"	5/16"	.010"	17.69	16.92	16.15	15.38
83657	.1875	3/16"	4.763	3/16"	2"	5/16"	.020"	17.69	16.92	16.15	15.38
83667	.1875	3/16"	4.763	3/16"	2"	9/16"	.010"	17.69	16.92	16.15	15.38
83677	.1875	3/16"	4.763	3/16"	2"	9/16"	.020"	17.69	16.92	16.15	15.38
83680	.1875	3/16"	4.763	3/16"	2"	9/16"	.030"	17.69	16.92	16.15	15.38
83707	.1969		5.000	6.0	65	15	0.30	26.04	24.90	23.77	22.64
83717	.1969		5.000	6.0	65	15	0.50	26.04	24.90	23.77	22.64
83767	.2362		6.000	6.0	50	12	0.30	22.46	21.48	20.51	19.53
83777	.2362		6.000	6.0	50	12	0.50	22.46	21.48	20.51	19.53
83780	.2362		6.000	6.0	65	19	0.20	25.22	24.12	23.03	21.93
83787	.2362		6.000	6.0	65	19	0.30	25.22	24.12	23.03	21.93
83797	.2362		6.000	6.0	65	19	0.50	25.22	24.12	23.03	21.93
83807	.2362		6.000	6.0	65	19	1.00	25.22	24.12	23.03	21.93
83827	.2500	1/4"	6.350	1/4"	2"	3/8"	.015"	21.62	20.68	19.74	18.80
83837	.2500	1/4"	6.350	1/4"	2"	3/8"	.030"	21.62	20.68	19.74	18.80
83845	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.010"	24.30	23.24	22.19	21.13
83847	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.015"	24.30	23.24	22.19	21.13
83857	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.030"	24.30	23.24	22.19	21.13
83877	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.060"	24.30	23.24	22.19	21.13
83927	.3125	5/16"	7.938	5/16"	2"	7/16"	.020"	29.52	28.24	26.95	25.67
83937	.3125	5/16"	7.938	5/16"	2"	7/16"	.030"	29.52	28.24	26.95	25.67
83940	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	.010"	32.90	31.47	30.04	28.61
83947	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	.020"	32.90	31.47	30.04	28.61
83957	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	.030"	32.90	31.47	30.04	28.61
83977	.3125	5/16"	7.938	5/16"	2-1/2"	13/16"	.060"	32.90	31.47	30.04	28.61

70
35
0
MATERIAL HARDNESS (Rc)

continued →

HIGH PERFORMANCE
END MILLS

Series 255RA, 855RA (continued)

.3150" - 1.000"
(8.000mm - 25.400mm)

EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	r Corner Radius	1-11	12-24	25-49	50-100	
	Decimal	Metric									
83987	.3150	8.000	8.0	50	12	0.50	30.60	29.27	27.94	26.61	
83997	.3150	8.000	8.0	50	12	1.00	30.60	29.27	27.94	26.61	
84000	.3150	8.000	8.0	65	22	0.30	34.13	32.65	31.16	29.68	
84007	.3150	8.000	8.0	65	22	0.50	34.13	32.65	31.16	29.68	
84017	.3150	8.000	8.0	65	22	1.00	34.13	32.65	31.16	29.68	
84027	.3150	8.000	8.0	65	22	1.50	34.13	32.65	31.16	29.68	
84087	.3750	3/8"	9.525	3/8"	2"	1/2"	.020"	34.80	33.29	31.77	30.26
84097	.3750	3/8"	9.525	3/8"	2"	1/2"	.030"	34.80	33.29	31.77	30.26
84100	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.010"	38.27	36.61	34.94	33.28
84107	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.020"	38.27	36.61	34.94	33.28
84117	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.030"	38.27	36.61	34.94	33.28
84137	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.060"	38.27	36.61	34.94	33.28
84167	.3937	10.000	10.0	70	22	0.50	46.26	44.25	42.24	40.23	
84177	.3937	10.000	10.0	70	22	1.00	46.26	44.25	42.24	40.23	
84257	.4724	12.000	12.0	75	32	0.30	67.65	64.71	61.77	58.83	
84267	.4724	12.000	12.0	75	32	0.50	67.65	64.71	61.77	58.83	
84277	.4724	12.000	12.0	75	32	1.00	67.65	64.71	61.77	58.83	
84287	.4724	12.000	12.0	75	32	1.50	67.65	64.71	61.77	58.83	
84307	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.010"	64.92	62.10	59.27	56.45
84317	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.020"	64.92	62.10	59.27	56.45
84327	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.030"	64.92	62.10	59.27	56.45
84337	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.060"	64.92	62.10	59.27	56.45
84357	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.120"	64.92	62.10	59.27	56.45
84367	.5000	1/2"	12.700	1/2"	4"	2"	.030"	76.90	73.56	70.21	66.87
84377	.5000	1/2"	12.700	1/2"	4"	2"	.060"	76.90	73.56	70.21	66.87
84397	.5000	1/2"	12.700	1/2"	4"	2"	.120"	76.90	73.56	70.21	66.87
84467	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	.015"	103.24	98.75	94.26	89.77
84487	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	.030"	103.24	98.75	94.26	89.77
84497	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	.060"	103.24	98.75	94.26	89.77
84507	.6250	5/8"	15.875	5/8"	3-1/2"	1-1/4"	.120"	103.24	98.75	94.26	89.77
84567	.6299	16.000	16.0	88	32	1.00	107.65	102.97	98.29	93.61	
84577	.6299	16.000	16.0	88	32	2.00	107.65	102.97	98.29	93.61	
84587	.6299	16.000	16.0	150	65	1.00	160.76	153.77	146.78	139.79	
84597	.6299	16.000	16.0	150	65	2.00	160.76	153.77	146.78	139.79	
84667	.7500	3/4"	19.050	3/4"	4"	1-1/2"	.015"	147.74	141.32	134.89	128.47
84687	.7500	3/4"	19.050	3/4"	4"	1-1/2"	.030"	147.74	141.32	134.89	128.47
84697	.7500	3/4"	19.050	3/4"	4"	1-1/2"	.060"	147.74	141.32	134.89	128.47
84700	.7500	3/4"	19.050	3/4"	4"	1-1/2"	.120"	147.74	141.32	134.89	128.47
84707	.7500	3/4"	19.050	3/4"	5"	2"	.030"	204.56	195.67	186.77	177.88
84717	.7500	3/4"	19.050	3/4"	5"	2"	.060"	204.56	195.67	186.77	177.88
84747	.7500	3/4"	19.050	3/4"	5"	2"	.120"	204.56	195.67	186.77	177.88
84757	.7500	3/4"	19.050	3/4"	5"	2"	.190"	204.56	195.67	186.77	177.88
84767	.7874	20.000	20.0	100	38	1.00	209.07	199.98	190.89	181.80	
84777	.7874	20.000	20.0	100	38	3.00	209.07	199.98	190.89	181.80	
84887	.9843	25.000	25.0	100	38	1.00	239.26	228.86	218.45	208.05	
84897	.9843	25.000	25.0	100	38	3.00	239.26	228.86	218.45	208.05	
84957	1.000	1"	25.400	1"	4"	1-1/2"	.015"	251.68	240.74	229.79	218.85
84967	1.000	1"	25.400	1"	4"	1-1/2"	.030"	251.68	240.74	229.79	218.85
84970	1.000	1"	25.400	1"	4"	1-1/2"	.060"	251.68	240.74	229.79	218.85
84977	1.000	1"	25.400	1"	4"	1-1/2"	.120"	251.68	240.74	229.79	218.85
84987	1.000	1"	25.400	1"	5"	2"	.030"	309.50	296.04	282.59	269.13
84990	1.000	1"	25.400	1"	5"	2"	.060"	309.50	296.04	282.59	269.13
84997	1.000	1"	25.400	1"	5"	2"	.120"	309.50	296.04	282.59	269.13
85007	1.000	1"	25.400	1"	5"	2"	.190"	309.50	296.04	282.59	269.13

