

**NEW
SERIES**



TOLERANCES

d_1	+0.00" -0.02" (+.000mm -.050mm)
d_2	-.0001" -.0004" (-.0025 -.0100mm)
ball radius	+0.00" -.001" (+.000 -.025mm)

Variable Helix End Mill - Ball End - ALCRONA PRO Coated

Solid submicron grain carbide end mill - center cutting

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

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

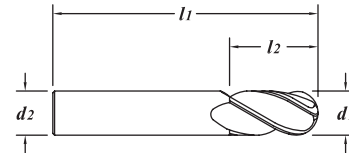
12mm and larger tools offered with weldon flat

Smaller diameters can be modified with a flat within 48 hours

V4 Corner Radius - page 129

V4 Square End - page 131

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



EDP#		d_1 †		d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100
(plain)	(weldon)	Decimal	Diameter Metric							
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
50254	-	.2500"	6.350	1/4"	2-1/2"	3/4"	24.75	23.67	22.60	21.52
50255	-	.3125"	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
50257	-	.3750"	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
50472	50473	.5000"	12.700	1/2"	3"	1"	66.80	63.90	60.99	58.09
50260	50292	.5000"	12.700	1/2"	3"	1-1/4"	66.80	63.90	60.99	58.09
50261	50293	.5000"	12.700	1/2"	4"	2-1/8"	78.96	75.53	72.09	68.66
50262	50294	.6250"	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"	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"	25.400	1"	4"	1-1/2"	260.38	249.06	237.74	226.42