



DIAMETER TOLERANCE: +0.000 / -0.002" SHANK TOLERANCE: +0.0000 / -0.0004"

DIA	DEC IN	LOC	SHANK	OAL	LENGTH	BRIGHT	ZRN
1/8	0.1250	1/2	1/8	1-1/2	Regular	273-125500	273-125500D
		1-1/8	1/8	3	X/Long	273-126112	273-126112D
3/16	0.1875	5/8	3/16	2	Regular	273-187625	273-187625D
		1-1/8	3/16	3	X/Long	273-188112	273-188112D
1/4	0.2500	3/4	1/4	2-1/2	Regular	273-250750	273-250750D
		1-1/4	1/4	3	Long	273-251500	273-251500D
		2	1/4	4	X/Long	273-252000	273-252000D
5/16	0.3125	13/16	5/16	2-1/2	Regular	273-312812	273-312812D
		1-3/8	5/16	3	Long	273-313375	273-313375D
		2	5/16	4	X/Long	273-314000	273-314000D
3/8	0.3750	1-1/8	3/8	2-1/2	Regular	273-371125	273-371125D
		1-3/8	3/8	3	Long	273-371375	273-371375D
		2	3/8	4	X/Long	273-372000	273-372000D
		3	3/8	6	X/Long	273-373000	273-373000D
7/16	0.4375	1-1/4	7/16	2-3/4	Regular	273-431250	273-431250D
		1-1/4	1/2	3	Regular	273-501250	273-501250D
1/2	0.5000	2	1/2	4	Long	273-502000	273-502000D
		3-1/8	1/2	6	X/Long	273-503125	273-503125D
5/8	0.6250	1-5/8	5/8	3-1/2	Regular	273-621625	273-621625D
		2-1/2	5/8	5	Long	273-622500	273-622500D
		3-1/8	5/8	6	X/Long	273-623125	273-623125D
3/4	0.7500	1-3/4	3/4	4	Regular	273-751750	273-751750D
		2-1/2	3/4	5	Long	273-752500	273-752500D
		3-1/4	3/4	6	X/Long	273-753250	273-753250D
1	1.0000	1-3/4	1	4	Regular	273-911750	273-911750D
		2-5/8	1	5	Long	273-912625	273-912625D
		3-1/4	1	6	X/Long	273-913250	273-913250D

MILLING RECOMMENDATIONS



Surface Feet Per Minute (SFM)  
Radial Depth of Cut (RDOC)

Inches Per Tooth (IPT)

PROFILING

Workpiece Material Group	SFM based on RDOC				IPT* (BASELINE)							
	Cutting Diameter Engaged				Cutting Diameter							
	10%	20%	30%	50%	3/16†	1/4†	5/16	3/8	1/2	5/8	3/4	1
Aluminum /Aluminum Alloys < 10% Si	2000	1800	1200	900	0.0018	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100
Aluminum /Aluminum Alloys > 10% Si	1500	1200	1000	800	0.0018	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100
<b>Non-Ferrous</b>												
Brass	900	800	600	500	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100	0.0120
Cu/Cu Alloys / Magnesium	1000	800	600	500	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100	0.0120
Plastics	900	800	600	500	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100	0.0120

*CHIP THINNING Adjustments	
RDOC	Increase IPT
50%	None
30%	2 x
20%	3.1 x
10%	3.8 x

†1/4" AND SMALLER DIAMETERS: Use caution when Profiling more than 50% or Slotting more than 25%



Surface Feet Per Minute (SFM)  
Radial Depth of Cut (RDOC)

Inches Per Tooth (IPT)

SLOTING

Workpiece Material Group	SFM			IPT* (BASELINE)							
	Cutting Diameter Engaged			Cutting Diameter							
	25%	50%	100%	3/16†	1/4†	5/16	3/8	1/2	5/8	3/4	1
Aluminum /Aluminum Alloys < 10% Si	2000	1500	1000	0.0040 - 0.0060	0.0040 - 0.0080	0.0060 - 0.0090	0.0070 - 0.0120	0.0100 - 0.0450	0.0150 - 0.0450	0.0150 - 0.0450	0.0150 - 0.040
Aluminum /Aluminum Alloys > 10% Si	1500	1200	800	0.0040 - 0.0060	0.0040 - 0.0080	0.0060 - 0.0090	0.0070 - 0.0120	0.0100 - 0.0450	0.0150 - 0.0450	0.0150 - 0.0450	0.0150 - 0.040
<b>Non-Ferrous</b>											
Brass	600	500	400	0.0040 - 0.0060	0.0040 - 0.0080	0.0060 - 0.0090	0.0070 - 0.0120	0.0100 - 0.0450	0.0150 - 0.0450	0.0150 - 0.0450	0.0150 - 0.040
Cu/Cu Alloys / Magnesium	500	400	300	0.0025	0.0032	0.0037	0.0050	0.0065	0.0075	0.0100	0.0120
Plastics	1200	1000	800	0.0040 - 0.0060	0.0040 - 0.0080	0.0060 - 0.0090	0.0070 - 0.0120	0.0100 - 0.0450	0.0150 - 0.0450	0.0150 - 0.0450	0.0150 - 0.040

