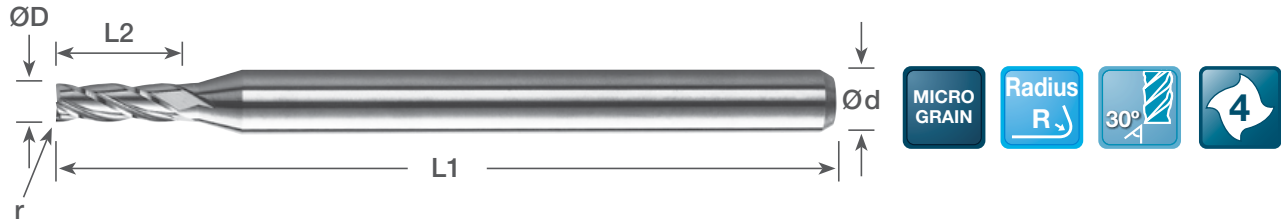


4 FLUTE

STANDARD LENGTH
STANDARD CORNER RADIUS END MILLS

0.0156" - 0.2500" DIAMETER

Mirror Surface Finishes
Sub Micron Grain Carbide



STANDARD Corner Radius STANDARD Length (Inch Sizes)

Uncoated		AITIN Coating		DLC* Coating		Dimensions (in)				
Part Number	Stock	Part Number	Stock	Part Number	Stock	ØD ^{+0.0000} _{-0.0010}	Ød	L1	L2	r
1813-0156.045CR	●	1813-0156L045CR	●	1813-0156D045CR	■	0.0156 (1/64)	1/8	1 1/2	0.045	0.005
1813-0300.090CR	●	1813-0300L090CR	●	1813-0300D090CR	■	0.0300	1/8	1 1/2	0.090	0.010
1813-0312.093CR	●	1813-0312L093CR	●	1813-0312D093CR	■	0.0312 (1/32)	1/8	1 1/2	0.093	0.010
1813-0350.105CR	●	1813-0350L105CR	●	1813-0350D105CR	■	0.0350	1/8	1 1/2	0.105	0.010
1813-0400.120CR	●	1813-0400L120CR	●	1813-0400D120CR	■	0.0400	1/8	1 1/2	0.120	0.010
1813-0450.135CR	●	1813-0450L135CR	●	1813-0450D135CR	■	0.0450	1/8	1 1/2	0.135	0.010
1813-0469.071CR	●	1813-0469L071CR	●	1813-0469D071CR	■	0.0469 (3/64)	1/8	1 1/2	0.071	0.010
1813-0469.141CR	●	1813-0469L141CR	●	1813-0469D141CR	■	0.0469 (3/64)	1/8	1 1/2	0.141	0.010
1813-0500.150CR	●	1813-0500L150CR	●	1813-0500D150CR	■	0.0500	1/8	1 1/2	0.150	0.015
1813-0550.165CR	●	1813-0550L165CR	●	1813-0550D165CR	■	0.0550	1/8	1 1/2	0.165	0.010
1813-0600.180CR	●	1813-0600L180CR	●	1813-0600D180CR	■	0.0600	1/8	1 1/2	0.180	0.015
1813-0625.093CR	●	1813-0625L093CR	●	1813-0625D093CR	■	0.0625 (1/16)	1/8	1 1/2	0.093	0.010
1813-0625.186CR	●	1813-0625L186CR	●	1813-0625D186CR	■	0.0625 (1/16)	1/8	1 1/2	0.186	0.010
1813-0650.195CR	●	1813-0650L195CR	●	1813-0650D195CR	■	0.0650	1/8	1 1/2	0.195	0.010
1813-0700.210CR	●	1813-0700L210CR	●	1813-0700D210CR	■	0.0700	1/8	1 1/2	0.210	0.015
1813-0750.225CR	●	1813-0750L225CR	●	1813-0750D225CR	■	0.0750	1/8	1 1/2	0.225	0.010
1813-0781.117CR	●	1813-0781L117CR	●	1813-0781D117CR	■	0.0781 (5/64)	1/8	1 1/2	0.117	0.010
1813-0781.234CR	●	1813-0781L234CR	●	1813-0781D234CR	■	0.0781 (5/64)	1/8	1 1/2	0.234	0.010
1813-0800.240CR	●	1813-0800L240CR	●	1813-0800D240CR	■	0.0800	1/8	1 1/2	0.240	0.015
1813-0850.255CR	●	1813-0850L255CR	●	1813-0850D255CR	■	0.0850	1/8	1 1/2	0.255	0.010
1813-0900.270CR	●	1813-0900L270CR	●	1813-0900D270CR	■	0.0900	1/8	1 1/2	0.270	0.015
1813-0938.140CR	●	1813-0938L140CR	●	1813-0938D140CR	■	0.0938 (3/32)	1/8	1 1/2	0.140	0.010
1813-0938.279CR	●	1813-0938L279CR	●	1813-0938D279CR	■	0.0938 (3/32)	1/8	1 1/2	0.279	0.010
1813-0950.285CR	●	1813-0950L285CR	●	1813-0950D285CR	■	0.0950	1/8	1 1/2	0.285	0.010
1813-1000.300CR	●	1813-1000L300CR	●	1813-1000D300CR	■	0.1000	1/8	1 1/2	0.300	0.015
1813-1250.500CR	●	1813-1250L500CR	●	1813-1250D500CR	■	0.1250 (1/8)	1/8	1 1/2	0.500	0.010
1813-1562.562CR	●	1813-1562L562CR	●	1813-1562D562CR	■	0.1562 (5/32)	3/16	2	0.562	0.015
1813-1875.625CR	●	1813-1875L625CR	●	1813-1875D625CR	■	0.1875 (3/16)	3/16	2	0.625	0.015
1813-2500.750CR	●	1813-2500L750CR	●	1813-2500D750CR	■	0.2500 (1/4)	1/4	2 1/2	0.750	0.015

Corner Radius Tolerance

*DLC is Amorphous Diamond

Diameter (D)	0.0150" - 0.0350"	0.0400" - 0.1000"	0.1250" - 0.1875"	0.2500"
+ / -	0.0010"	0.0015"	0.0020"	0.0030"

SERIES 1813 WORKPIECE MATERIAL																
Coating	P Steel ~30HRC	P Steel 30-40HRC	H Hardened Steel ~55HRC	H Hardened Steel ~68HRC	M Stainless Steel	K Cast Iron	N Aluminum	N Graphite	N Copper Alloy	N Brass	N CFRP	N Plastic	N Thermcoat Plastic	S High Density Plastic	S Nickel / Cobalt	S Titanium Alloy
AITIN	★	★	★	☆	☆	☆									☆	☆
DLC							☆	★	☆	☆	★	★	★			
Uncoated							☆	☆	☆	★	☆	☆	☆	☆		☆

★ : Priority ☆ : Applicable Materials

Recommended Cutting Conditions Page L221, L223

Symbol Descriptions Page L3

● : U.S. Stock Standard
■ : NOT STOCKED - Call for Delivery

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