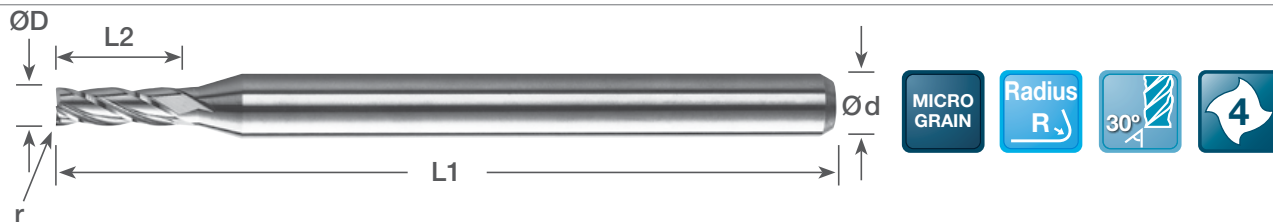


4 FLUTE

STANDARD LENGTH
LARGE / X-LARGE CORNER RADIUS END MILLS

0.0450" - 0.2500" DIAMETER

Mirror Surface Finishes
Sub Micron Grain Carbide



LARGE Corner Radius STANDARD Length (Inch Sizes)

Uncoated		AITIN Coating		DLC* Coating		Dimensions (in)				
Part Number	Stock	Part Number	Stock	Part Number	Stock	$\text{ØD}_{-0.0010}^{+0.0000}$	Ød	L1	L2	r
1814-0450.135CR	●	1814-0450L135CR	●	1814-0450D135CR	■	0.0450	1/8	1 1/2	0.135	0.015
1814-0469.071CR	●	1814-0469L071CR	●	1814-0469D071CR	■	0.0469 (3/64)	1/8	1 1/2	0.071	0.015
1814-0469.141CR	●	1814-0469L141CR	●	1814-0469D141CR	■	0.0469 (3/64)	1/8	1 1/2	0.141	0.015
1814-0550.165CR	●	1814-0550L165CR	●	1814-0550D165CR	■	0.0550	1/8	1 1/2	0.165	0.015
1814-0625.093CR	●	1814-0625L093CR	●	1814-0625D093CR	■	0.0625 (1/16)	1/8	1 1/2	0.093	0.015
1814-0625.186CR	●	1814-0625L186CR	●	1814-0625D186CR	■	0.0625 (1/16)	1/8	1 1/2	0.186	0.015
1814-0650.195CR	●	1814-0650L195CR	●	1814-0650D195CR	■	0.0650	1/8	1 1/2	0.195	0.015
1814-0750.225CR	●	1814-0750L225CR	●	1814-0750D225CR	■	0.0750	1/8	1 1/2	0.225	0.015
1814-0781.117CR	●	1814-0781L117CR	●	1814-0781D117CR	■	0.0781 (5/64)	1/8	1 1/2	0.117	0.015
1814-0781.234CR	●	1814-0781L234CR	●	1814-0781D234CR	■	0.0781 (5/64)	1/8	1 1/2	0.234	0.015
1814-0850.255CR	●	1814-0850L255CR	●	1814-0850D255CR	■	0.0850	1/8	1 1/2	0.255	0.015
1814-0938.140CR	●	1814-0938L140CR	●	1814-0938D140CR	■	0.0938 (3/32)	1/8	1 1/2	0.140	0.015
1814-0938.279CR	●	1814-0938L279CR	●	1814-0938D279CR	■	0.0938 (3/32)	1/8	1 1/2	0.279	0.015
1814-0950.285CR	●	1814-0950L285CR	●	1814-0950D285CR	■	0.0950	1/8	1 1/2	0.285	0.015
1814-1250.500CR	●	1814-1250L500CR	●	1814-1250D500CR	■	0.1250 (1/8)	1/8	1 1/2	0.500	0.015
1814-1875.625CR	●	1814-1875L625CR	●	1814-1875D625CR	■	0.1875 (3/16)	3/16	2	0.625	0.020
1814-2500.750CR	●	1814-2500L750CR	●	1814-2500D750CR	■	0.2500 (1/4)	1/4	2 1/2	0.750	0.020

*DLC is Amorphous Diamond

X-LARGE Corner Radius STANDARD Length (Inch Sizes)

Uncoated		AITIN Coating		DLC* Coating		Dimensions (in)				
Part Number	Stock	Part Number	Stock	Part Number	Stock	$\text{ØD}_{-0.0010}^{+0.0000}$	Ød	L1	L2	r
1816-0625.186CR	●	1816-0625L186CR	●	1816-0625D186CR	■	0.0625 (1/16)	1/8	1 1/2	0.186	0.020
1816-0781.234CR	●	1816-0781L234CR	●	1816-0781D234CR	■	0.0781 (5/64)	1/8	1 1/2	0.150	0.020
1816-0938.279CR	●	-	-	-	-	0.0938 (3/32)	1/8	1 1/2	0.279	0.020
1816-0938.140CR	●	1816-0938L140CR	●	1816-0938D140CR	■	0.0938 (3/32)	1/8	1 1/2	0.140	0.020
1816-1250.500CR	●	1816-1250L500CR	●	1816-1250D500CR	■	0.1250 (1/8)	1/8	1 1/2	0.500	0.020
1816-1875.625CR	●	1816-1875L625CR	●	1816-1875D625CR	■	0.1875 (3/16)	3/16	2	0.625	0.030
1816-2500.750CR	●	1816-2500L750CR	●	1816-2500D750CR	■	0.2500 (1/4)	1/4	2 1/2	0.750	0.030

*DLC is Amorphous Diamond

Corner Radius Tolerance

Diameter (D)	0.0450" - 0.0950"	0.1250" - 0.1875"	0.2500" - 0.5000"
+ / -	0.0015"	0.0020"	0.0030"

SERIES 1814 / 1816 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 Thermoset Plastic	N 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