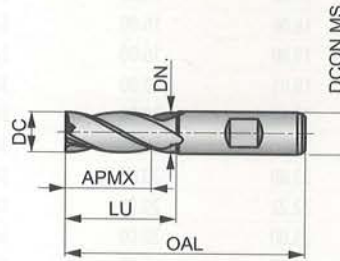


# C247



## Multi-Flute HSS-E-PM End Mill, Bright Finish

Short cut length, 4, 5, 6 or 8 flute design provides high rigidity for general profile and ramp milling applications in mild steels and non-ferrous materials.



HSS-E PM	N	NOF 4-8
	$\lambda$ 30°	$\gamma$ 12°
	Bright	DC k10
	DIN 844K	



Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 194.

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P4.1	M1.1	M1.2	M2.1	M2.2	K1.1	K1.2
53 D	59 D	61 D	45 D	40 D	36 D	29 C	22 C	34 D	29 D	31 D	25 C	30 D	22 D
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
17 D	55 D	45 D	36 C	49 D	37 D	30 B	45 C	34 C	25 C	22 B	18 B	51 C	39 C
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S2.1
30 C	95 F	71 E	48 E	48 D	43 D	31 D	50 D	29 D	15 D	50 D	30 C	25 C	20 B
S3.1	S4.1												
15 B	12 B												

MS tolerance h6.

Product	DC (inch)	DC (mm)	DCON MS (mm)	APMX (mm)	OAL (mm)	NOF	LU (mm)	DN (mm)
Q472.0	—	2.00	6.00	7.00	51.0	4	—	—
Q472.5	—	2.50	6.00	8.00	52.0	4	—	—
Q473.0	—	3.00	6.00	8.00	52.0	4	—	—
Q471/8 <sup>2)</sup>	1/8	3.18	6.00	10.00	54.0	4	—	—
Q473.5	—	3.50	6.00	10.00	54.0	4	—	—
Q474.0	—	4.00	6.00	11.00	55.0	4	—	—
Q474.5	—	4.50	6.00	11.00	55.0	4	—	—
Q473/16 <sup>2)</sup>	3/16	4.76	6.00	13.00	57.0	4	—	—
Q475.0	—	5.00	6.00	13.00	57.0	4	—	—
Q475.5	—	5.50	6.00	13.00	57.0	4	—	—
Q476.0	—	6.00	6.00	13.00	57.0	4	—	—
Q471/4 <sup>2)</sup>	1/4	6.35	10.00	16.00	66.0	4	—	—
Q476.5	—	6.50	10.00	16.00	66.0	4	—	—
Q477.0	—	7.00	10.00	16.00	66.0	4	—	—
Q477.5	—	7.50	10.00	16.00	66.0	4	—	—
Q475/16 <sup>2)</sup>	5/16	7.94	10.00	19.00	69.0	4	—	—
Q478.0	—	8.00	10.00	19.00	69.0	4	—	—
Q478.5	—	8.50	10.00	19.00	69.0	4	—	—
Q479.0	—	9.00	10.00	19.00	69.0	4	—	—
Q479.5	—	9.50	10.00	19.00	69.0	4	—	—
Q473/8 <sup>2)</sup>	3/8	9.52	10.00	22.00	72.0	4	31.50	9.50
Q4710.0	—	10.00	10.00	22.00	72.0	4	31.50	9.50
Q4711.0	—	11.00	12.00	22.00	79.0	4	—	—
Q4712.0	—	12.00	12.00	26.00	83.0	4	37.50	11.50
Q471/2 <sup>2)</sup>	1/2	12.70	12.00	26.00	83.0	4	37.50	11.50

Product	DC	DC	DCON MS	APMX	OAL	NOF	LU	DN
	(inch)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
C24713.0	—	13.00	12.00	26.00	83.0	4	37.50	11.50
C24714.0	—	14.00	12.00	26.00	83.0	4	37.50	11.50
C2479/16 <sup>2)</sup>	9/16	14.29	12.00	26.00	83.0	4	37.50	11.50
C24715.0	—	15.00	12.00	26.00	83.0	4	43.50	15.50
C2475/8 <sup>2)</sup>	5/8	15.88	16.00	32.00	92.0	4	43.50	15.50
C24716.0	—	16.00	16.00	32.00	92.0	4	43.50	15.50
C24717.0	—	17.00	16.00	32.00	92.0	4	43.50	15.50
C24718.0	—	18.00	16.00	32.00	92.0	4	43.50	15.50
C24719.0	—	19.00	16.00	32.00	92.0	4	43.50	15.50
C2473/4 <sup>2)</sup>	3/4	19.05	20.00	38.00	104.0	4	53.50	18.50
C24720.0	—	20.00	20.00	38.00	104.0	4	53.50	19.50
C24721.0	—	21.00	20.00	38.00	104.0	4	53.50	19.50
C24722.0	—	22.00	20.00	38.00	104.0	5	53.50	19.50
C2477/8 <sup>2)</sup>	7/8	22.22	20.00	38.00	104.0	5	53.50	19.50
C24723.0	—	23.00	20.00	38.00	104.0	5	53.50	19.50
C24724.0	—	24.00	25.00	45.00	121.0	5	64.50	23.50
C24725.0	—	25.00	25.00	45.00	121.0	5	64.50	24.50
C2471 <sup>2)</sup>	1"	25.40	25.00	45.00	121.0	5	64.50	24.50
C24726.0	—	26.00	25.00	45.00	121.0	6	64.50	24.50
C24728.0	—	28.00	25.00	45.00	121.0	6	64.50	24.50
C24730.0	—	30.00	25.00	45.00	121.0	6	64.50	24.50
C24732.0	—	32.00	32.00	53.00	133.0	6	72.50	31.50
C24736.0 <sup>1)</sup>	—	36.00	32.00	53.00	133.0	6	72.50	31.50
C24740.0 <sup>1)</sup>	—	40.00	40.00	63.00	155.0	6	84.50	39.00
C24750.0 <sup>1)</sup>	—	50.00	50.00	75.00	177.0	8	96.50	48.00

<sup>1)</sup> Available in HSS-E only; no centre cutting.  
<sup>2)</sup> DC tolerance +0.0025 inches/-0.0005 inches.