

4 FLUTE APOLLO

0.1250" - 1.0000" DIAMETER

Variable Helix

Unequal Flutes to Reduce Chatter

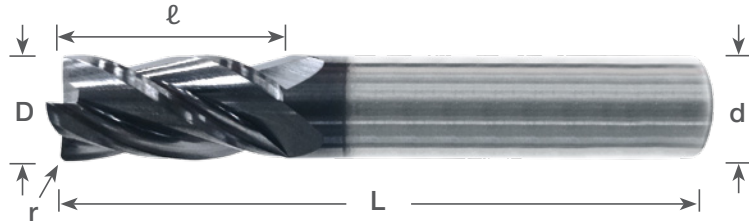
Can be used as a rougher or a finishing tool

VARIABLE HELIX END MILLS

Excellent for Alloy Steel, Nickel Inconel Alloys, Stainless Steel, and Carbon Steel

Excellent for Alloy Steel, Nickel Steel, Stainless Steel, and Carbon Steel

AlCrN Coating



Symbol Descriptions [Page 7](#)

STUB Length (Inch Sizes)

Dimensions (in)						AlCrN Coating	
D	d	ℓ	L	r	Part Number	Stock	
0.2500 (1/4)	1/4	1/2	2	0.015 - 0.020	AP4-2500.500	●	
0.3125 (5/16)	5/16	1/2	2	0.015 - 0.020	AP4-3125.500	●	
0.3750 (3/8)	3/8	5/8	2	0.015 - 0.020	AP4-3750.625	●	
0.2500 (1/2)	1/2	5/8	2-1/2	0.025 - 0.030	AP4-5000.625	●	
0.6250 (5/8)	5/8	3/4	3	0.030 - 0.035	AP4-6250.750	●	
0.7500 (3/4)	3/4	1	3	0.030 - 0.035	AP4-7500.1000	●	

STANDARD Length (Inch Sizes)

Dimensions (in)						AlCrN Coating	
D	d	ℓ	L	r	Part Number	Stock	
0.1250 (1/8)	1/8	1/2	1-1/2	0.010 - 0.015	AP4-1250.500	●	
0.1875 (3/16)	3/16	5/8	2	0.015 - 0.020	AP4-1875.625	●	
0.2500 (1/4)	1/4	3/4	2-1/2	0.015 - 0.020	AP4-2500.750	●	
0.3125 (5/16)	5/16	13/16	2-1/2	0.015 - 0.020	AP4-3125.813	●	
0.3750 (3/8)	3/8	1	2-1/2	0.015 - 0.020	AP4-3750.1000	●	
0.4375 (7/16)	7/16	1	2-3/4	0.015 - 0.020	AP4-4375.1000	●	
0.5000 (1/2)	1/2	1	3	0.025 - 0.030	AP4-5000.1000	●	
0.6250 (5/8)	5/8	1-1/4	3-1/2	0.030 - 0.035	AP4-6250.1250	●	
0.7500 (3/4)	3/4	1-1/2	4	0.030 - 0.035	AP4-7500.1500	●	
1.0000 (1)	1	1-1/2	4	0.030 - 0.035	AP4-10000.1500	●	

LONG Length (Inch Sizes)

Dimensions (in)						AlCrN Coating	
D	d	ℓ	L	r	Part Number	Stock	
0.2500 (1/4)	1/4	1-1/8	3	0.015 - 0.020	AP4-2500.1125	●	
0.3125 (5/16)	5/16	1-1/8	3	0.015 - 0.020	AP4-3125.1125	●	
0.3750 (3/8)	3/8	1-1/8	3	0.015 - 0.020	AP4-3750.1125	●	
0.5000 (1/2)	1/2	2	4	0.025 - 0.030	AP4-5000.2000	●	
0.6250 (5/8)	5/8	2-1/4	5	0.030 - 0.035	AP4-6250.2250	●	
0.7500 (3/4)	3/4	2-1/4	5	0.030 - 0.035	AP4-7500.2250	●	

Cutting Diameter Tolerances	Shank Diameter Tolerances	Corner Radius Tolerances
1/8 - 1/4 = +0.0000/-0.0012	1/8 - 3/8 = +0.0001/-0.0003	All = +0.0000/-0.0020
>1/4 - 3/8 = +0.0000/-0.0016	>3/8 - 1 = +0.0001/-0.0004	
>3/8 - 1 = +0.0000/-0.0020		

SERIES AP4 WORKPIECE MATERIAL															
Coating	P	P	H	H	M	K	N	N	N	N	N	S	S		
	Steel -30HRC	Steel 30-40HRC	Hardened Steel -55HRC	Hardened Steel -68HRC	Stainless Steel	Cast Iron	Aluminum	Graphite	Copper Alloy	CFRP	Plastic	Thermoset Plastic	High Density Plastic	Nickel / Cobalt	Titanium Alloy
AlCrN	☆	☆	★	★	★	☆			☆					★	★

★ : Priority ☆ : Applicable Materials

Symbol Descriptions [Page 7](#)