

# 4 FLUTE APOLLO

**0.1250" - 1.0000" DIAMETER**

*Variable Helix*

*Unequal Flutes to Reduce Chatter*

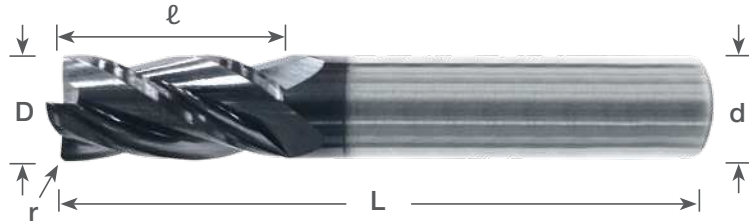
*Can be used as a rougher or a finishing tool*

### 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*



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### 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

1/8 - 1/4 = +0.0000/-0.0012  
 >1/4 - 3/8 = +0.0000/-0.0016  
 >3/8 - 1 = +0.0000/-0.0020

#### Shank Diameter Tolerances

1/8 - 3/8 = +0.0001/-0.0003  
 >3/8 - 1 = +0.0001/-0.0004

#### Corner Radius Tolerances

All = +0.0000/-0.0020

### SERIES AP4 WORKPIECE MATERIAL

Coating	P	P	H	H	M	K	N	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

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