

5 FLUTE APOLLO

VARIABLE HELIX END MILLS

0.2500" - 1.0000" DIAMETER

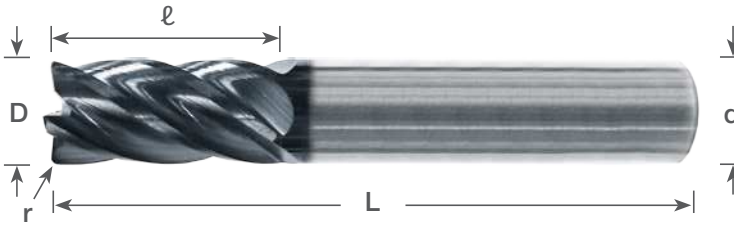
Variable Helix

Unequal Flutes to Reduce Chatter

Can be used as a rougher or a finishing tool

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

AICrN Coating



Symbol Descriptions [Page 7](#)

STANDARD Length (Inch Sizes)

Dimensions (in)						AICrN Coating	
D	d	ℓ	L	r	Part Number	Stock	
0.2500 (1/4)	1/4	3/4	2-1/2	.015 - .020	AP5-2500.750	●	
0.3750 (3/8)	3/8	1	2-1/2	.015 - .020	AP5-3750.1000	●	
0.5000 (1/2)	1/2	1	3	.025 - .030	AP5-5000.1000	●	
0.6250 (5/8)	5/8	1-1/4	3-1/2	.030 - .035	AP5-6250.1250	●	
0.7500 (3/4)	3/4	1-1/2	4	.030 - .035	AP5-7500.1500	●	
1.0000 (1)	1	1-1/2	4	.030 - .035	AP5-10000.1500	●	

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 AP5 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 CFRP	N Plastic	N Thermoset Plastic	N High Density Plastic	S Nickel / Cobalt	S Titanium Alloy
AICrN	☆	☆	★	★	★	☆			☆					☆	☆

★ : Priority ☆ : Applicable Materials

Symbol Descriptions [Page 7](#)

- : U.S. Stock Standard
- : NOT STOCKED - Call for Delivery
- ▲ : Coming Soon

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