

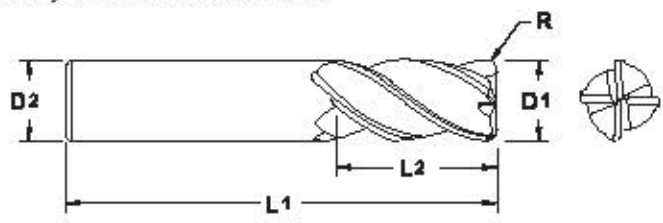
4
Flute

TuffCut® XR
Series 177 / 177W

Z4

Designed for EXTREME Productivity. Unique flute geometry reduces harmonics at increased feeds and speeds.

New-Standard Offering with Weldon Shank Flats.



- Variable helix.

ALtima®		ALtima® Weldon Flat		Diameter			Shank		OAL		Flute Length		Corner Radius	
Tool No.	EDP	Tool No.	EDP	D1			D2 (h6)		L1		L2		R	
				Inch	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm
1770900A	17680				1.5	.0591		3.0		38		3.0		
17706250A	17692			1/16		.0625	1/8		1-1/2		1/8			
17707810A	17694			5/64		.0781	1/8		1-1/2		5/32			
17707870A	17682				2.0	.0787		3.0		38		4.0		
17709370A	17696			3/32		.0937	1/8		1-1/2		3/16			
17709840A	17684				2.5	.0984		3.0		38		5.0		
17711800A	17928				3.0	.1181		6.0		57		8.0		
17711801A	17783				3.0	.1181		6.0		57		8.0		0.50
17711803A	17686				3.0	.1181		3.0		38		6.0		
17711808A	17929				3.0	.1181		6.0		57		8.0		0.25
17712500A	17700			1/8		.1250	1/8		1-1/2		1/8			
17712502A	17729			1/8		.1250	1/8		1-1/2		1/8			0.015
17712510A	17701			1/8		.1250	1/8		1-1/2		3/8			
17712512A	17730			1/8		.1250	1/8		1-1/2		3/8			0.015
17713700A	17688				3.5	.1378		6.0		57		7.0		
17715600A	17702			5/32		.1562	3/16		2		3/16			
17715602A	17731			5/32		.1562	3/16		2		3/16			0.015
17715610A	17703			5/32		.1562	3/16		2		7/16			
17715612A	17732			5/32		.1562	3/16		2		7/16			0.015
17715700A	17930				4.0	.1575		6.0		57		11.0		
17715701A	17784				4.0	.1575		6.0		57		11.0		0.50
17715708A	17931				4.0	.1575		6.0		57		11.0		0.25
17717700A	17690				4.5	.1772		6.0		57		9.0		
17718700A	17704			3/16		.1875	3/16		2		3/16			



Inch	
D1	Tolerance
1/16 - 1/4	+0.00/-0.002
> 1/4 - 1.0	+0.00/-0.003

Metric (mm)	
D1	Tolerance (h10)
1.50 - 3.00	+0.00/-0.040
>3.00 - 6.00	+0.00/-0.048
>6.00 - 10.00	+0.00/-0.058
>10.00 - 18.00	+0.00/-0.070
>18.00 - 25.00	+0.00/-0.084

Inch	
D2	Tolerance (h6)
.1182 - .2362	+0/-0.00031
.2363 - .3937	+0/-0.00035
.3938 - .7087	+0/-0.00043
.7088 - 1.000	+0/-0.00051

Metric (mm)	
D2	Tolerance (h6)
3.0	+0/-0.006
3.01 - 6.0	+0/-0.008
6.01 - 10.0	+0/-0.009
10.01 - 18.0	+0/-0.011
18.01 - 25.0	+0/-0.013

Inch	
R	Tolerance
1/8 - 1	+0.000/-0.0016

Metric (mm)	
R	Tolerance
3.0 - 25.0	+0.0/-0.04