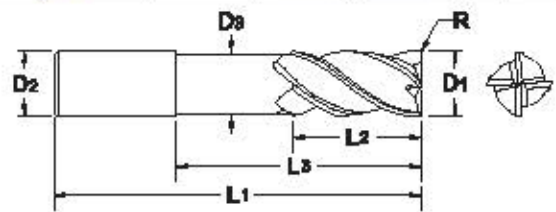


4  
Flute

**TuffCut® XT  
Series 277N**



- Improved geometries.
- Enhanced corner protection.
- Variable helix.



ALTi ma <sup>x</sup> Blaze		Diameter		Shank	Neck Diameter	OAL	Flute Length	Neck Length	Corner Radius	Reach
Tool No.	EDP	D1	Decimal	D2 (h6)	D3	L1	L2	L3	R	L3/D1
27712500N3B	27720	1/8	.1250	1/8	.115	3	3/16	3/8		3
27712502N3B	27721	1/8	.1250	1/8	.115	3	3/16	3/8	.015	3
27712500N5B	27722	1/8	.1250	1/8	.115	3	3/16	5/8		5
27712502N5B	27723	1/8	.1250	1/8	.115	3	3/16	5/8	.015	5
27718700N3B	27724	3/16	.1875	3/16	.177	3	1/4	9/16		3
27718702N3B	27725	3/16	.1875	3/16	.177	3	1/4	9/16	.015	3
27718704N3B	27726	3/16	.1875	3/16	.177	3	1/4	9/16	.030	3
27718700N5B	27727	3/16	.1875	3/16	.177	3	1/4	15/16		5
27718702N5B	27728	3/16	.1875	3/16	.177	3	1/4	15/16	.015	5
27718704N5B	27729	3/16	.1875	3/16	.177	3	1/4	15/16	.030	5
27725000N3B	27730	1/4	.2500	1/4	.240	3	3/8	3/4		3
27725002N3B	27731	1/4	.2500	1/4	.240	3	3/8	3/4	.015	3
27725004N3B	27732	1/4	.2500	1/4	.240	3	3/8	3/4	.030	3
27725006N3B	27733	1/4	.2500	1/4	.240	3	3/8	3/4	.060	3
27725000N5B	27734	1/4	.2500	1/4	.240	4	3/8	1-1/4		5
27725002N5B	27735	1/4	.2500	1/4	.240	4	3/8	1-1/4	.015	5
27725004N5B	27736	1/4	.2500	1/4	.240	4	3/8	1-1/4	.030	5
27725006N5B	27737	1/4	.2500	1/4	.240	4	3/8	1-1/4	.060	5
27731200N3B	27738	5/16	.3125	5/16	.300	3	7/16	15/16		3
27731202N3B	27739	5/16	.3125	5/16	.300	3	7/16	15/16	.015	3
27731204N3B	27740	5/16	.3125	5/16	.300	3	7/16	15/16	.030	3
27737500N3B	27741	3/8	.3750	3/8	.360	3	1/2	1-1/8		3
27737502N3B	27742	3/8	.3750	3/8	.360	3	1/2	1-1/8	.015	3
27737504N3B	27743	3/8	.3750	3/8	.360	3	1/2	1-1/8	.030	3
27737506N3B	27744	3/8	.3750	3/8	.360	3	1/2	1-1/8	.060	3
27737500N4B	27745	3/8	.3750	3/8	.360	4	1/2	1-1/2		4
27737502N4B	27746	3/8	.3750	3/8	.360	4	1/2	1-1/2	.015	4
27737504N4B	27747	3/8	.3750	3/8	.360	4	1/2	1-1/2	.030	4
27737506N4B	27748	3/8	.3750	3/8	.360	4	1/2	1-1/2	.060	4
27737500N5B	27749	3/8	.3750	3/8	.360	4	1/2	1-7/8		5
27737502N5B	27750	3/8	.3750	3/8	.360	4	1/2	1-7/8	.015	5
27737504N5B	27751	3/8	.3750	3/8	.360	4	1/2	1-7/8	.030	5
27737506N5B	27752	3/8	.3750	3/8	.360	4	1/2	1-7/8	.060	5
27750000N3B	27753	1/2	.5000	1/2	.480	4	5/8	1-1/2		3
27750002N3B	27754	1/2	.5000	1/2	.480	4	5/8	1-1/2	.015	3
27750004N3B	27755	1/2	.5000	1/2	.480	4	5/8	1-1/2	.030	3
27750006N3B	27756	1/2	.5000	1/2	.480	4	5/8	1-1/2	.060	3
27750007N3B	27757	1/2	.5000	1/2	.480	4	5/8	1-1/2	.090	3

Inch	
D1	Tolerance
1/8 - 1/4	+0.000/-0.002
>1/4 - 1	+0.000/-0.003

Inch	
D2	Tolerance (h6)
.1182 - .2362	+0/-0.0031
.2363 - .3937	+0/-0.0035
.3938 - .7087	+0/-0.0043
.7088 - 1.000	+0/-0.0051

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

