

Hard Plastics

- Double Edge
- Solid Carbide
- Upcut Spiral O Flute



For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal
Solid Surface

Low helix geometry designed to cut hard plastic with a smooth finish and upward chip flow.

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| Inch | | | | |
| H25XOS-52-622 | 1/4 | 3/8 | 1/4 | 2-1/2 |
| H25XOS-52-624 | | 3/4 | | |
| H25XOS-52-638 | 3/8 | 1 | 3/8 | 3 |
| H25XOS-52-650 | 1/2 | 1-1/8 | 1/2 | 3-1/2 |
| Metric | | | | |
| H25XOS-52-626 | 6 | 25 | 6 | 64 |
| H25XOS-52-640 | 8 | | 8 | 76 |
| H25XOS-52-642 | 10 | 10 | 76 | |
| H25XOS-52-644 | 12 | 35 | 12 | 88 |

Helix Angle $\approx 11^\circ$

- Double Edge
- Solid Carbide
- Downcut Spiral O Flute



For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal
Solid Surface

Designed to cut plastic with a smooth finish and downward chip flow.

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| Inch | | | | |
| H25XOS-57-623 | 1/4 | 3/8 | 1/4 | 2-1/2 |
| H25XAM-46413 | | 3/4 | | |
| H25XOS-57-637 | 3/8 | 1 | 3/8 | 3 |
| H25XOS-57-651 | 1/2 | 1-1/8 | 1/2 | 3-1/2 |
| Metric | | | | |
| H25XOS-57-627 | 6 | 25 | 6 | 64 |
| H25XOS-57-639 | 8 | | 8 | 76 |
| H25XOS-57-643 | 10 | 10 | 76 | |
| H25XOS-57-645 | 12 | 35 | 12 | 88 |

Helix Angle $\approx 10-11^\circ$

Hard Plastics

- Double Edge
- Solid Carbide
- Straight

For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal

Designed specifically to rout harder, more rigid plastics. The straight flute design helps to reduce part lifting in thin sheet applications



| Catalog Number | Cutting Edge Diameter | Cutting Edge Length | Shank Diameter | Overall Length |
|----------------|-----------------------|---------------------|----------------|----------------|
| Inch | | | | |
| H25XOS-56-041 | 1/8 | 1/4 | 1/4 | 2 |
| H25XOS-56-061 | 3/16 | 3/8 | | |
| H25XOS-56-081 | 1/4 | 3/4 | 3/8 | 2-1/2 |
| H25XOS-56-082 | | 7/8 | | |
| H25XOS-56-122 | 3/8 | 1 | 1/2 | 3 |
| H25XOS-56-162 | 1/2 | | | |
| Metric | | | | |
| mm | | | | |
| H25XOS-56-450 | 4 | 16 | 6 | 64 |
| H25XOS-56-451 | 5 | 20 | | |
| H25XOS-56-452 | 6 | 25 | 8 | 76 |
| H25XOS-56-454 | 8 | | 10 | 88 |
| H25XOS-56-456 | 10 | 35 | 12 | |
| H25XOS-56-458 | 12 | | | |

Hard Plastics

- Three Edge
- Solid Carbide
- Low Helix Finisher

For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal

Solid Surface

Designed for perfect balance and ultrasmooth finish over a wide speed range.



UPCUT

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| Inch | | | | |
| H25XOS-60-239 | 1/4 | 3/8 | 1/4 | 3 |
| H25XOS-60-241 | | 7/8 | | |
| H25XOS-60-243 | 3/8 | 5/8 | 3/8 | |
| H25XOS-60-245 | | 1-1/8 | | |
| H25XOS-60-249 | 1/2 | 2-1/8 | 1/2 | 3-1/2 |
| H25XOS-60-251 | | | | 4-1/2 |
| Metric | | | | |
| H25XOS-60-481 | 6 | 25 | 6 | 76 |
| H25XOS-60-471 | 8 | | 8 | |
| H25XOS-60-473 | 10 | 35 | 10 | |
| H25XOS-60-475 | 12 | | 12 | |
| H25XOS-60-483 | 14 | 45 | 14 | 110 |

Helix Angle $\approx 10^\circ$

DOWNCUT

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| Inch | | | | |
| H25XOS-60-240 | 1/4 | 3/8 | 1/4 | 3 |
| H25XOS-60-242 | | 7/8 | | |
| H25XOS-60-244 | 3/8 | 5/8 | 3/8 | |
| H25XOS-60-246 | | 1-1/8 | | |
| H25XOS-60-250 | 1/2 | 2-1/8 | 1/2 | 3-1/2 |
| H25XOS-60-252 | | | | 4-1/2 |
| Metric | | | | |
| H25XOS-60-482 | 6 | 25 | 6 | 76 |
| H25XOS-60-472 | 8 | | 8 | |
| H25XOS-60-474 | 10 | 35 | 10 | |
| H25XOS-60-476 | 12 | | 12 | |
| H25XOS-60-484 | 14 | 45 | 14 | 110 |

Helix Angle $\approx 10^\circ$

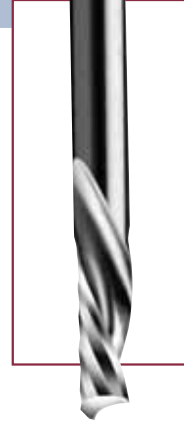
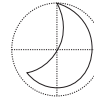
Hard Plastics

- Single Edge
- Solid Carbide
- Downcut Spiral O Flute

For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal

Designed to provide a smooth finish in hard plastics. The down cut spiral helps maximize part holding.



METRIC

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| H25XAM-51510 | 1/8 | 1/2 | 1/8 | 2 |
| H25XOS-62-712 | | | 1/4 | |
| H25XOS-62-719 | 3/16 | 5/8 | 3/16 | |
| H25XAM-51504 | 1/4 | 3/4 | 1/4 | |
| H25XOS-62-727 | | 1-1/2 | | 3 |
| H25XOS-62-733 | | 3/8 | | |
| H25XOS-62-740 | 1/2 | 1-5/8 | 1/2 | 3-1/2 |

Helix Angle $\approx 21^\circ$

| Catalog Number | Cutting Edge Dia. mm | Cutting Edge Length mm | Shank Dia. mm | Overall Length mm |
|----------------|----------------------|------------------------|---------------|-------------------|
| H25XOS-62-802 | 2 | 8 | 2 | 50 |
| H25XOS-62-804 | | | 6 | 64 |
| H25XOS-62-806 | 2.5 | 8 | 2.5 | 50 |
| H25XOS-62-808 | | | 6 | 64 |
| H25XOS-62-810 | 3 | 8 | 3 | 50 |
| H25XOS-62-812 | | | 6 | |
| H25XOS-62-814 | 3 | 12 | 3 | 64 |
| H25XOS-62-816 | | | 6 | |
| H25XOS-62-818 | 4 | 8 | 4 | |
| H25XOS-62-820 | | 12 | | |
| H25XOS-62-822 | 4 | 20 | 6 | |
| H25XOS-62-824 | | 30 | | |
| H25XOS-62-826 | 5 | 30 | 4 | |
| H25XOS-62-828 | | 16 | | |
| H25XOS-62-830 | 5 | 30 | 5 | |
| H25XOS-62-832 | | 8 | | |
| H25XOS-62-834 | 6 | 8 | 6 | |
| H25XOS-62-836 | | 12 | | |
| H25XOS-62-838 | 6 | 20 | 6 | |
| H25XOS-62-840 | | 30 | | |
| H25XOS-62-842 | 8 | 38 | 6 | |
| H25XOS-62-844 | | 25 | | |
| H25XOS-62-846 | 8 | 38 | 8 | |
| H25XOS-62-848 | | 30 | | |
| H25XOS-62-849 | 10 | 35 | 10 | |
| H25XOS-62-847 | | 38 | | 12 |

Helix Angle $\approx 21^\circ$

Hard Plastics

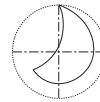
- Single Edge
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For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal

Solid Surface

Designed to provide a smooth finish in hard plastics with upward chip removal.



METRIC

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| H25XOS-63-701 | 1/16 | 1/4 | 1/8 | 2 |
| H25XOS-63-700 | | | 1/4 | |
| H25XOS-63-711 | 1/8 | 1/2 | 1/8 | |
| H25XAM-51410 | | | 1/4 | |
| H25XOS-63-743* | | | 3/16 | |
| H25XOS-63-716 | 3/16 | 3/8 | 3/16 | |
| H25XOS-63-718 | | 5/8 | | |
| H25XOS-63-724 | 1/4 | 3/8 | 1/4 | |
| H25XOS-63-744* | | 3/4 | | |
| H25XAM-51404 | | 1-1/2 | | |
| H25XOS-63-727 | | 5/8 | | 2-1/2 |
| H25XOS-63-730 | 3/8 | 1-1/8 | 3/8 | 3 |
| H25XOS-63-733 | | 1-5/8 | 1/2 | 3-1/2 |
| H25XOS-63-745* | | 1/2 | | |
| H25XOS-63-746* | | | | |

Helix Angle $\approx 21^\circ$

*Special point for improved bottom finish.

| Catalog Number | Cutting Edge Dia. mm | Cutting Edge Length mm | Shank Dia. mm | Overall Length mm | |
|----------------|----------------------|------------------------|---------------|-------------------|----|
| H25XOS-63-802 | 2 | 8 | 2 | 50 | |
| H25XOS-63-804 | | | 6 | 64 | |
| H25XOS-63-806 | 2.5 | | 2.5 | 50 | |
| H25XOS-63-808 | | | 6 | 64 | |
| H25XOS-63-810 | 3 | | 3 | 50 | |
| H25XOS-63-812 | | | 6 | | |
| H25XOS-63-814 | 3 | | 12 | 3 | 64 |
| H25XOS-63-816 | | | | 6 | |
| H25XOS-63-818 | 4 | | 8 | 4 | |
| H25XOS-63-820 | | | 12 | | |
| H25XOS-63-822 | 4 | 20 | 6 | | |
| H25XOS-63-824 | | 30 | 4 | | |
| H25XOS-63-826 | | 30 | 4 | | |
| H25XOS-63-828 | 5 | 16 | 5 | | |
| H25XOS-63-830 | | 30 | 6 | | |
| H25XOS-63-832 | | 30 | 5 | | |
| H25XOS-63-834 | 6 | 8 | 6 | 76 | |
| H25XOS-63-836 | | 12 | | | |
| H25XOS-63-838 | | 20 | | | |
| H25XOS-63-840 | | 30 | | | |
| H25XOS-63-842 | 8 | 38 | 8 | 64 | |
| H25XOS-63-844 | | 25 | | | |
| H25XOS-63-846 | 10 | 38 | 10 | 76 | |
| H25XOS-63-848 | | 30 | | | |
| H25XOS-63-849 | | 35 | | | |
| H25XOS-63-847 | 12 | 38 | 12 | | |

Helix Angle $\approx 21^\circ$

Hard Plastics

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For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal
Solid Surface

The polished flute allows for a razor sharp cutting edge finish. The down cut spiral helps improve part holding.

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| H25XOS-64-000 | 1/16 | 1/4 | 1/8 | 2 |
| H25XOS-64-012 | 1/8 | 1/2 | 1/4 | |
| H25XOS-64-016 | 3/16 | 3/8 | 3/16 | |
| H25XOS-64-018 | | 5/8 | 1/4 | |
| H25XOS-64-024 | | 3/8 | | |
| H25XOS-64-025 | 1/4 | 3/4 | 3/8 | 3 |
| H25XOS-64-026 | 1-1/4 | | | |
| H25XOS-64-031 | 3/4 | | | |
| H25XOS-64-033 | 3/8 | 1-1/8 | | |

Helix Angle $\approx 21^\circ$

- Single Edge
- Solid Carbide
- Upcut Spiral O Flute


For Use On:

Hard Plastic: Cast and extruded acrylic, Melamine, Nylon, Polycarbonate, ABS, Acetal
Soft Plastic: ABS, Polycarbonate, Polyethylene, PVC, Polypropylene, HDPE, Polystyrene, UHMW, and Extruded Acrylic
Solid Surface

The polished flute allows for razor sharp cutting edge and easy chip evacuation.

| Catalog Number | Cutting Edge Dia. | Cutting Edge Length | Shank Dia. | Overall Length |
|----------------|-------------------|---------------------|------------|----------------|
| H25XOS-65-000 | 1/16 | 1/4 | 1/8 | 2 |
| H25XOS-65-010 | 1/8 | | 1/4 | |
| H25XOS-65-013 | | 1/2 | 1/8 | |
| H25XOS-65-012 | | 1/4 | 1/4 | |
| H25XOS-65-019 | 3/16 | 5/8 | 3/16 | |
| H25XOS-65-018 | | 1-1/4 | 1/4 | 3 |
| H25XOS-65-020 | 2 | | | |
| H25XOS-65-023 | 2-1/2 | | | |
| H25XOS-65-025 | 1/4 | 7/8 | 1/4 | 3 |
| H25XOS-65-026 | | 1-1/4 | | |
| H25XOS-65-027 | | 1-1/2 | | |
| H25XOS-65-033 | 3/8 | 1-1/8 | 3/8 | |

Helix Angle $\approx 21^\circ$