



## Style: HDC-4C - Double End

Finisher

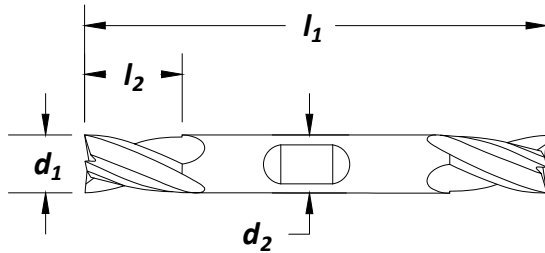
**Note**  
Operating parameters begin on page 310.

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Surface  
Treatment



**Feature:**

High red hardness for high heat conditions.

cutting diameter <b>d<sub>1</sub></b>	decimal equiv.	shank dia <b>d<sub>2</sub> (in)</b>	length of cut <b>l<sub>2</sub> (in)</b>	overall length <b>l<sub>1</sub> (in)</b>	no. of flutes	order number		
						Bright	<b>HDC-4C</b> TiN	TiCN
1/8	.1250	.375	.375	3.063	4	C52170	C32941	C32974
9/64	.1406	.375	.438	3.125	4	C32927	—	C32975
5/32	.1562	.375	.438	3.125	4	C52171	—	C32976
11/64	.1719	.375	.500	3.250	4	C32928	—	C32977
3/16	.1875	.375	.500	3.250	4	C52172	C32945	C32978
13/64	.2031	.375	.563	3.250	4	C32929	—	C32979
7/32	.2188	.375	.563	3.250	4	C52173	—	C32980
15/64	.2344	.375	.625	3.375	4	C32930	—	C32981
1/4	.2500	.375	.625	3.375	4	C52174	C32949	C32982
17/64	.2656	.375	.688	3.375	4	C32931	—	C32983
9/32	.2812	.375	.688	3.375	4	C52175	—	C32984
19/64	.2969	.375	.750	3.500	4	C32932	—	C32985
5/16	.3125	.375	.750	3.500	4	C52176	C32953	C32986
21/64	.3281	.375	.750	3.500	4	C32933	—	C32987
11/32	.3438	.375	.750	3.500	4	C52177	—	C32988
23/64	.3594	.375	.750	3.500	4	C32934	—	C32989
3/8	.3750	.375	.750	3.500	4	C52178	C32957	C32990
25/64	.3906	.500	1.000	4.125	4	C32935	—	C32991
13/32	.4062	.500	1.000	4.125	4	C52179	—	C32992
27/64	.4219	.500	1.000	4.125	4	C32936	—	C32993
7/16	.4375	.500	1.000	4.125	4	C52180	C32961	C32994
29/64	.4531	.500	1.000	4.125	4	C32937	—	C32995
15/32	.4688	.500	1.000	4.125	4	C52181	—	C32996
31/64	.4844	.500	1.000	4.125	4	C32938	—	C32997
1/2	.5000	.500	1.000	4.125	4	C52182	C32965	C32998
9/16	.5625	.625	1.375	5.000	4	C52183	C32966	C32999
5/8	.6250	.625	1.375	5.000	4	C52184	C32967	C33000
11/16	.6875	.750	1.625	5.625	4	C52185	—	C33001
3/4	.7500	.750	1.625	5.625	4	C52186	C32969	C33002
13/16	.8125	.875	1.875	6.125	4	C32939	—	C33003
7/8	.8750	.875	1.875	6.125	4	C52187	—	C33004
15/16	.9375	1.000	1.875	6.375	4	C32940	C32972	C33005
1	1.0000	1.000	1.875	6.375	4	C52188	C32973	C33006

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Center Cutting

Material Reference	Steel (HRC)				Stainless Steel			Cast Iron (HRC)		Aluminum and Non-Ferrous	Hi-Temp Alloy		Hardened Steel (HRC)
	Low Carbon		Alloy		Austenitic	Martensitic	PH	Gray	Nodular		Ni, Co, Fe Based Super Alloy	Titanium	
	Hardness	13-38	>38	16-38	> 38	300 Series	400 series		18-22	22-32			>45
TiN	★		★		★	★							
TiCN	☆		☆		☆	☆	★				★	★	

☆ = Best Performance    ★ = Acceptable

