

# Merlin

Tools Ltd

**V5%**

**V6%**

**Solid Carbide  
Variable Helix 5 & 6 Flute  
Ball Nosed • Blue nAco Coated  
Hard Machining Range  
up to 70 HRc**

Manufactured in the USA  
Distributed in the UK



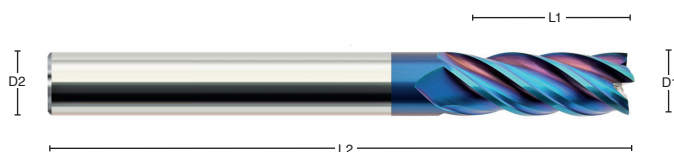
**NEW  
PRODUCT  
LINES**

# Variable Helix - 5 Flute - Blue nAco **V5**

Series 505

**Ultra-High Performance Solid Carbide - Blue nAco Coated**  
**34°/37° Variable Helix - Centre Cutting - Hard Machining up to 70 HRc**  
**Micro-grain K30 5-Flute Long**  
**V5 - Eccentric Relief - For Dry Cutting or Misting**

**V5**



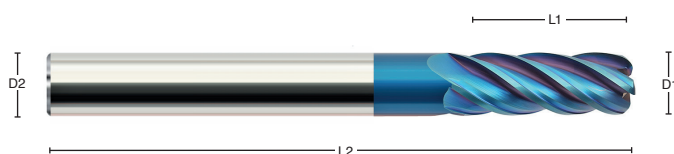
Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Part Number |
|---------------|--------------|-------|--------|-------------|
| 3             | 6            | 9     | 63     | 505-06958   |
| 4             | 6            | 12    | 63     | 505-61258   |
| 5             | 6            | 14    | 63     | 505-61458   |
| 6             | 6            | 15    | 75     | 505-61575   |
| 8             | 8            | 25    | 75     | 505-82575   |
| 10            | 10           | 38    | 100    | 505-10100   |
| 12            | 12           | 25    | 100    | 505-12100   |
| 16            | 16           | 56    | 150    | 505-16150   |
| 20            | 20           | 56    | 150    | 505-20150   |
| 25            | 25           | 75    | 150    | 505-25150   |

Series 505R

**Ultra-High Performance Solid Carbide - Blue nAco Coated**  
**34°/37° Variable Helix - Centre Cutting - Hard Machining up to 70 HRc**  
**Micro-grain K30 5-Flute Long - Corner Radius**  
**V5 - Eccentric Relief - For Dry Cutting or Misting**

**V5**



Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Corner Radius | Part Number     |
|---------------|--------------|-------|--------|---------------|-----------------|
| 3             | 6            | 9     | 63     | 0.50          | 505-06958-0.50R |
| 4             | 6            | 12    | 63     | 0.50          | 505-61258-0.50R |
| 5             | 6            | 14    | 63     | 0.50          | 505-61458-0.50R |
| 6             | 6            | 15    | 75     | 0.50          | 505-61575-0.50R |
| 6             | 6            | 15    | 75     | 0.75          | 505-61575-0.75R |
| 6             | 6            | 15    | 75     | 1.00          | 505-61575-1.00R |
| 8             | 8            | 25    | 75     | 0.50          | 505-82575-0.50R |
| 8             | 8            | 25    | 75     | 0.75          | 505-82575-0.75R |
| 8             | 8            | 25    | 75     | 1.00          | 505-82575-1.00R |
| 8             | 8            | 25    | 75     | 1.50          | 505-82575-1.50R |
| 8             | 8            | 25    | 75     | 2.00          | 505-82575-2.00R |
| 8             | 8            | 25    | 75     | 3.00          | 505-82575-3.00R |
| 10            | 10           | 38    | 100    | 0.50          | 505-10100-0.50R |
| 10            | 10           | 38    | 100    | 0.75          | 505-10100-0.75R |
| 10            | 10           | 38    | 100    | 1.00          | 505-10100-1.00R |
| 10            | 10           | 38    | 100    | 1.50          | 505-10100-1.50R |
| 10            | 10           | 38    | 100    | 2.00          | 505-10100-2.00R |
| 10            | 10           | 38    | 100    | 3.00          | 505-10100-3.00R |
| 12            | 12           | 50    | 100    | 0.50          | 505-12100-0.50R |
| 12            | 12           | 50    | 100    | 0.75          | 505-12100-0.75R |
| 12            | 12           | 50    | 100    | 1.00          | 505-12100-1.00R |
| 12            | 12           | 50    | 100    | 1.50          | 505-12100-1.50R |
| 12            | 12           | 50    | 100    | 2.00          | 505-12100-2.00R |
| 12            | 12           | 50    | 100    | 3.00          | 505-12100-3.00R |
| 16            | 16           | 56    | 150    | 0.50          | 505-16150-0.50R |
| 16            | 16           | 56    | 150    | 0.75          | 505-16150-0.75R |
| 16            | 16           | 56    | 150    | 1.00          | 505-16150-1.00R |
| 16            | 16           | 56    | 150    | 1.50          | 505-16150-1.50R |
| 16            | 16           | 56    | 150    | 2.00          | 505-16150-2.00R |
| 16            | 16           | 56    | 150    | 3.00          | 505-16150-3.00R |
| 16            | 16           | 56    | 150    | 4.00          | 505-16150-4.00R |
| 20            | 20           | 56    | 150    | 0.50          | 505-20150-0.50R |
| 20            | 20           | 56    | 150    | 1.00          | 505-20150-1.00R |
| 20            | 20           | 56    | 150    | 1.50          | 505-20150-1.50R |
| 20            | 20           | 56    | 150    | 2.00          | 505-20150-2.00R |
| 20            | 20           | 56    | 150    | 3.00          | 505-20150-3.00R |
| 20            | 20           | 56    | 150    | 4.00          | 505-20150-4.00R |

- ✓ **Longer Tool Life**
- ✓ **Increased Feed Rate**
- ✓ **Improved Surface Finish**
- ✓ **Extremely Competitive Pricing**
- ✓ **All Corner Radius Tools Ex Stock**
- ✓ **Vibration / Chatter Free Machining**

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# Variable Helix - 6 Flute - Blue nAco V6

Series 605

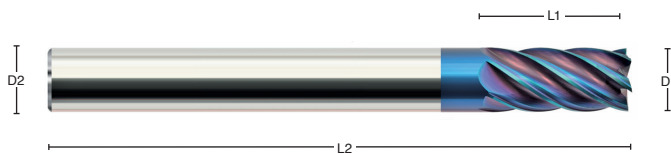
**Ultra-High Performance Solid Carbide - Blue nAco Coated**

**33°/35° Harmonic - Variable Pitch - Centre Cutting - Hard Machining up to 70 HRc**

**Micro-grain K30 6-Flute Long**

**V6 - Eccentric Relief - For Dry Cutting or Misting**

**V6**



Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Part Number |
|---------------|--------------|-------|--------|-------------|
| 6             | 6            | 18    | 75     | 605 -01875  |
| 8             | 8            | 24    | 75     | 605 -02475  |
| 10            | 10           | 30    | 100    | 605 -30100  |
| 12            | 12           | 36    | 100    | 605 -36100  |
| 16            | 16           | 50    | 125    | 605 -50125  |
| 20            | 20           | 60    | 150    | 605 -60150  |

Series 605R

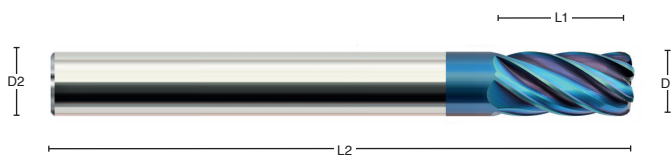
**Ultra-High Performance Solid Carbide - Blue nAco Coated**

**33°/35° Harmonic - Variable Pitch - Centre Cutting - Hard Machining up to 70 HRc**

**Micro-grain K30 6-Flute Long Corner Radius**

**V6 - Eccentric Relief - For Dry Cutting or Misting**

**V6**



Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Corner Radius | Part Number      |
|---------------|--------------|-------|--------|---------------|------------------|
| 6             | 6            | 18    | 75     | 0.50          | 605 -01875-0.50R |
| 6             | 6            | 18    | 75     | 0.75          | 605 -01875-0.75R |
| 6             | 6            | 18    | 75     | 1.00          | 605 -01875-1.00R |
| 8             | 8            | 24    | 75     | 0.50          | 605 -02475-0.50R |
| 8             | 8            | 24    | 75     | 0.75          | 605 -02475-0.75R |
| 8             | 8            | 24    | 75     | 1.00          | 605 -02475-1.00R |
| 10            | 10           | 30    | 100    | 0.50          | 605 -30100-0.50R |
| 10            | 10           | 30    | 100    | 0.75          | 605 -30100-0.75R |
| 10            | 10           | 30    | 100    | 1.00          | 605 -30100-1.00R |
| 12            | 12           | 36    | 100    | 0.50          | 605 -36100-0.50R |
| 12            | 12           | 36    | 100    | 0.75          | 605 -36100-0.75R |
| 12            | 12           | 36    | 100    | 1.00          | 605 -36100-1.00R |
| 16            | 16           | 50    | 125    | 0.50          | 605 -50125-0.50R |
| 16            | 16           | 50    | 125    | 0.75          | 605 -50125-0.75R |
| 16            | 16           | 50    | 125    | 1.00          | 605 -50125-1.00R |
| 20            | 20           | 60    | 150    | 0.50          | 605 -60150-0.50R |
| 20            | 20           | 60    | 150    | 0.75          | 605 -60150-0.75R |
| 20            | 20           | 60    | 150    | 1.00          | 605 -60150-1.00R |

- ✓ **Longer Tool Life**
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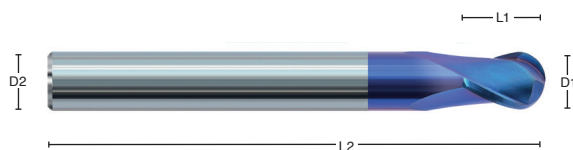


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# Ball Nosed - 2 Flute - Blue nAco Coated

Series 671

**Ultra-High Performance Solid Carbide - Blue nAco Coated**  
**30° Helix - Centre Cutting - Hard Machining up to 70 HRc**  
**Micro-grain K30 2-Flute Ball Nosed**  
**For Dry Cutting or Misting**

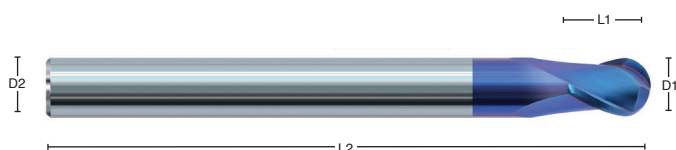


Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Reach | Part Number |
|---------------|--------------|-------|--------|-------|-------------|
| 1             | 6            | 3     | 50     | 7     | 671 -06350  |
| 2             | 6            | 4     | 50     | 8     | 671 -06450  |
| 3             | 6            | 5     | 50     | 9     | 671 -06550  |
| 4             | 6            | 6     | 50     | 12    | 671 -06650  |
| 5             | 6            | 7     | 50     | 15    | 671 -06750  |
| 6             | 6            | 8     | 50     | ~     | 671 -06850  |
| 8             | 8            | 10    | 63     | ~     | 671 -01063  |
| 10            | 10           | 12    | 75     | ~     | 671 -11275  |
| 12            | 12           | 16    | 75     | ~     | 671 -11675  |
| 16            | 16           | 20    | 100    | ~     | 671 -12100  |
| 20            | 20           | 25    | 100    | ~     | 671 -25100  |

Series 672

**Ultra-High Performance Solid Carbide - Blue nAco Coated**  
**30° Helix - Centre Cutting - Hard Machining up to 70 HRc**  
**Micro-grain K30 2-Flute Long Ball Nosed**  
**For Dry Cutting or Misting**



Tolerances: D1 +0.00/-0.051mm D2 h6

| Cutter Dia-D1 | Shank Dia-D2 | FL L1 | OAL L2 | Reach | Part Number |
|---------------|--------------|-------|--------|-------|-------------|
| 1             | 6            | 3     | 75     | 7     | 672 -06353  |
| 2             | 6            | 4     | 75     | 8     | 672 -06453  |
| 3             | 6            | 5     | 75     | 9     | 672 -06553  |
| 4             | 6            | 6     | 75     | 15    | 672 -06653  |
| 5             | 6            | 7     | 75     | 18    | 672 -06753  |
| 6             | 6            | 8     | 75     | ~     | 672 -06853  |
| 8             | 8            | 10    | 100    | ~     | 672 -01064  |
| 10            | 10           | 12    | 100    | ~     | 672 -11264  |
| 12            | 12           | 16    | 100    | ~     | 672 -11680  |
| 16            | 16           | 20    | 150    | ~     | 672 -12080  |
| 20            | 20           | 25    | 150    | ~     | 672 -25105  |



**Extremely Competitive Pricing**



**Ex Stock Delivery on All Tools**



**Increased Feed Rate**



**Longer Tool Life**



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