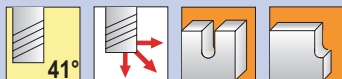


142B - 2 Flute

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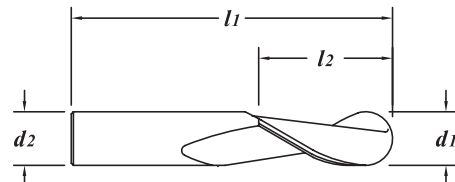
| TOLERANCES | | |
|-------------|-----------------------------------|-----------------------------------|
| d_1 | +.000" -.001" (+.000 -.025mm) | |
| d_2 | 3mm - 6mm | +.0000" -.0003" (+.0000 -.0075mm) |
| | 1/4" - 1" | -.0001" -.0004" (-.0025 -.0100mm) |
| Ball radius | +.0000" -.0005" (+.0000 -.0127mm) | |

HSAL - Ball End - ALUMASTAR Coated

Solid submicron grain carbide end mill - center cutting
 Specific coating engineered to repel aluminum
 Engineered to run at 750-2500 SFM (225-750 M/Min.)

For high speed machining of aluminum

High velocity - high metal removal rate (for spindles 10,000 RPM and above)
 Need to use properly balanced holders
 Holds perpendicularity
 Flats can be added within 48 hours



| EDP# | d_1 † Diameter | | d_2 Shank Diameter | l_1 Overall Length | l_2 Flute Length | 1-11 | 12-24 | 25-49 | 50-100 |
|-------|---------------------|--------|----------------------------|----------------------------|--------------------------|--------|--------|--------|--------|
| | Decimal | Metric | | | | | | | |
| 42522 | .1575 | 4.000 | 6.0 | 50 | 12 | 28.90 | 27.64 | 26.39 | 25.13 |
| 42582 | .1875 | 3/16" | 4.763 | 3/16" | 2" | 21.44 | 20.50 | 19.57 | 18.64 |
| 42642 | .1969 | | 5.000 | 6.0 | 65 | 29.82 | 28.52 | 27.23 | 25.93 |
| 42702 | .2362 | | 6.000 | 6.0 | 65 | 28.87 | 27.61 | 26.36 | 25.10 |
| 42762 | .2500 | 1/4" | 6.350 | 1/4" | 2-1/2" | 27.43 | 26.24 | 25.04 | 23.85 |
| 42842 | .2756 | | 7.000 | 8.0 | 65 | 41.98 | 40.15 | 38.33 | 36.50 |
| 42902 | .3125 | 5/16" | 7.938 | 5/16" | 2-1/2" | 36.29 | 34.72 | 33.14 | 31.56 |
| 42962 | .3150 | | 8.000 | 8.0 | 65 | 38.19 | 36.53 | 34.87 | 33.21 |
| 43022 | .3750 | 3/8" | 9.525 | 3/8" | 2-1/2" | 42.30 | 40.46 | 38.62 | 36.78 |
| 43102 | .3937 | | 10.000 | 10.0 | 70 | 64.87 | 62.05 | 59.23 | 56.41 |
| 43182 | .4724 | | 12.000 | 12.0 | 75 | 80.24 | 76.75 | 73.26 | 69.77 |
| 43242 | .5000 | 1/2" | 12.700 | 1/2" | 3" | 76.23 | 72.92 | 69.60 | 66.29 |
| 43322 | .6250 | 5/8" | 15.875 | 5/8" | 4" | 131.86 | 126.13 | 120.39 | 114.66 |
| 43382 | .6299 | | 16.000 | 16.0 | 100 | 138.81 | 132.77 | 126.74 | 120.70 |
| 43442 | .7500 | 3/4" | 19.050 | 3/4" | 4" | 171.13 | 163.69 | 156.25 | 148.81 |
| 43482 | .7874 | | 20.000 | 20.0 | 100 | 240.22 | 229.78 | 219.33 | 208.89 |
| 43542 | .9843 | | 25.000 | 25.0 | 100 | 277.96 | 265.87 | 253.79 | 241.70 |
| 43602 | 1.000 | 1" | 25.400 | 1" | 4" | 291.85 | 279.16 | 266.47 | 253.78 |