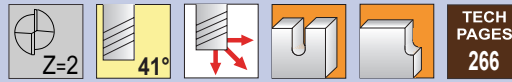


TOLERANCES

<i>d1</i>	+0.000" -0.001" (+.000 -0.025mm)
<i>d2</i>	h6
<i>ball radius</i>	+0.0000" -0.0005" (+.0000 -0.127mm)

Series 142B

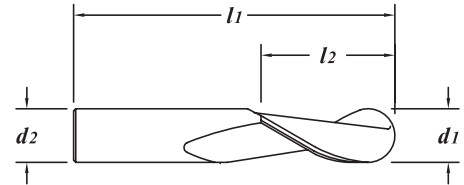


Recommended for Aluminum

HSAL End Mill - Ball End

ALUMASTAR Coating

- 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
- Honed edge on radius for improved finish
- Flats can be added within 48 hours



EDP#	<i>d1</i> † Diameter		<i>d2</i> Shank Diameter	<i>l1</i> Overall Length	<i>l2</i> 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"	9/16"	21.44	20.50	19.57	18.64
42642	.1969	5.000	6.0	65	16	29.82	28.52	27.23	25.93	
42702	.2362	6.000	6.0	65	19	28.87	27.61	26.36	25.10	
42762	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	27.43	26.24	25.04	23.85
42842	.2756	7.000	8.0	65	19	41.98	40.15	38.33	36.50	
42902	.3125	5/16"	7.938	5/16"	2-1/2"	3/4"	36.29	34.72	33.14	31.56
42962	.3150	8.000	8.0	65	19	38.19	36.53	34.87	33.21	
43022	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	42.30	40.46	38.62	36.78
43102	.3937	10.000	10.0	70	24	64.87	62.05	59.23	56.41	
43182	.4724	12.000	12.0	75	32	80.24	76.75	73.26	69.77	
43242	.5000	1/2"	12.700	1/2"	3"	1-1/4"	76.23	72.92	69.60	66.29
43322	.6250	5/8"	15.875	5/8"	4"	1-5/8"	131.86	126.13	120.39	114.66
43382	.6299	16.000	16.0	100	40	138.81	132.77	126.74	120.70	
43442	.7500	3/4"	19.050	3/4"	4"	1-5/8"	171.13	163.69	156.25	148.81
43482	.7874	20.000	20.0	100	32	240.22	229.78	219.33	208.89	
43542	.9843	25.000	25.0	100	38	277.96	265.87	253.79	241.70	
43602	1.000	1"	25.400	1"	4"	1-5/8"	291.85	279.16	266.47	253.78

MATERIAL HARDNESS (RC) 70 35 0

HIGH PERFORMANCE END MILLS