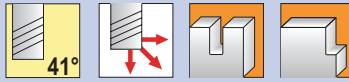


# Series 142M

.1575" - 1.000"  
(4.000mm - 25.400mm)

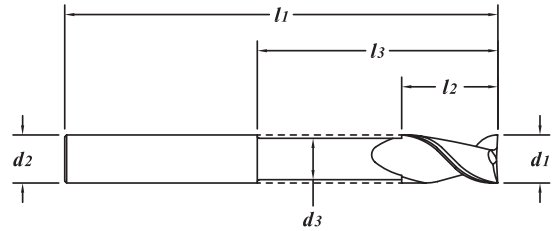


TOLERANCES	
$d_1$	+0.000" - .001" (+.000 - .025mm)
$d_2$	h6

Recommended for Aluminum

## HSAL End Mill - 2 Flute - Square 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



MATERIAL HARDNESS (Rc) 70  
35  
0

EDP#	$d_1$ † Diameter		$d_2$ Shank Diameter	$l_1$ Overall Length	$l_2$ Flute Length	$l_3$ Reach Length	$d_3$ Neck Diameter	1-11	12-24	25-49	50-100
	Decimal	Metric									
41222	.1575	4.000	6.0	50	12	-	-	24.70	23.63	22.55	21.48
41232	.1575	4.000	6.0	65	6	16	3.7	30.92	29.58	28.23	26.89
41282	.1875	3/16"	4.763	2"	9/16"	-	-	18.62	17.81	17.00	16.19
41342	.1969	5.000	6.0	65	16	-	-	25.48	24.38	23.27	22.16
41352	.1969	5.000	6.0	75	8	20	4.7	43.34	41.46	39.57	37.69
41402	.2362	6.000	6.0	65	19	-	-	24.68	23.61	22.53	21.46
41412	.2362	6.000	6.0	75	10	25	5.7	41.95	40.13	38.30	36.48
41462	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	-	23.44	22.42	21.40	20.38
41542	.2756	7.000	8.0	65	19	-	-	37.84	36.19	34.55	32.90
41602	.3125	5/16"	7.938	5/16"	2-1/2"	3/4"	-	32.56	31.14	29.73	28.31
41662	.3150	8.000	8.0	65	19	-	-	34.28	32.79	31.30	29.81
41672	.3150	8.000	8.0	75	12	25	7.4	51.73	49.48	47.23	44.98
41722	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	-	38.25	36.59	34.92	33.26
41802	.3937	10.000	10.0	70	24	-	-	57.56	55.06	52.55	50.05
41812	.3937	10.000	10.0	75	12	30	9.4	63.73	60.96	58.19	55.42
41822	.3937	10.000	10.0	100	12	35	9.4	76.73	73.39	70.06	66.72
41882	.4724	12.000	12.0	75	32	-	-	64.38	61.58	58.78	55.98
41892	.4724	12.000	12.0	75	16	30	11.4	69.30	66.29	63.27	60.26
41902	.4724	12.000	12.0	100	16	35	11.4	94.54	90.43	86.32	82.21
41912	.4724	12.000	12.0	100	16	40	11.4	94.54	90.43	86.32	82.21
41942	.5000	1/2"	12.700	1/2"	3"	1-1/4"	-	61.17	58.51	55.85	53.19
42022	.6250	5/8"	15.875	5/8"	4"	1-5/8"	-	121.91	116.61	111.31	106.01
42072	.6299	16.000	16.0	75	16	30	15.4	120.75	115.50	110.25	105.00
42082	.6299	16.000	16.0	100	40	-	-	128.31	122.73	117.15	111.57
42092	.6299	16.000	16.0	100	20	40	15.4	133.22	127.42	121.63	115.84
42102	.6299	16.000	16.0	125	20	60	15.4	170.23	162.83	155.43	148.03
42142	.7500	3/4"	19.050	3/4"	4"	1-5/8"	-	155.99	149.20	142.42	135.64
42212	.7874	20.000	20.0	100	32	-	-	209.42	200.31	191.21	182.10
42222	.7874	20.000	20.0	100	20	40	19	214.33	205.01	195.69	186.37
42232	.7874	20.000	20.0	125	20	60	19	248.19	237.40	226.61	215.82
42242	.9843	25.000	25.0	100	38	-	-	241.64	231.13	220.63	210.12
42302	1.000	1"	25.400	1"	4"	1-5/8"	-	234.44	224.25	214.05	203.86