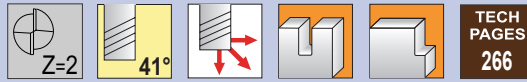


**TOLERANCES**

$d_1$	+0.000" -0.001" (+0.000 -0.025mm)
$d_2$	h6
$r$	+0.0005" -0.0005" (+0.0127 -0.0127mm)



**Series 142R**

.1575" - .4724"  
(4.000mm - 12.000mm)

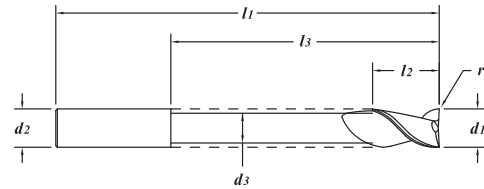
Recommended for aluminum

**HIGH PERFORMANCE END MILLS**

**HSAL End Mill - Corner Radius**

**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
- Flats can be added within 48 hours



EDP#	$d_1$ † Diameter		$d_2$ Shank Diameter	$l_1$ Overall Length	$l_2$ Flute Length	$r$ Corner Radius	$l_3$ Reach Length	$d_3$ Neck Diameter	1-11	12-24	25-49	50-100
	Decimal	Metric										
39222	.1575	4.000	6.0	50	12	0.30	-	-	28.90	27.64	26.39	25.13
39232	.1575	4.000	6.0	65	6	0.50	20	3.7	35.34	33.80	32.27	30.73
39242	.1575	4.000	6.0	65	6	1.00	20	3.7	35.34	33.80	32.27	30.73
39282	.1875	3/16"	4.763	3/16"	2"	9/16"	.010"	-	21.44	20.50	19.57	18.64
39342	.1969	5.000	6.0	65	16	0.30	-	-	29.82	28.52	27.23	25.93
39352	.1969	5.000	6.0	75	8	0.50	20	4.7	48.73	46.61	44.49	42.37
39362	.1969	5.000	6.0	75	8	1.00	20	4.7	48.73	46.61	44.49	42.37
39402	.2362	6.000	6.0	65	19	0.30	-	-	28.87	27.61	26.36	25.10
39412	.2362	6.000	6.0	75	10	0.50	25	5.7	47.16	45.11	43.06	41.01
39422	.2362	6.000	6.0	75	10	1.00	25	5.7	47.16	45.11	43.06	41.01
39432	.2362	6.000	6.0	75	10	1.50	25	5.7	47.16	45.11	43.06	41.01
39442	.2362	6.000	6.0	75	10	2.00	25	5.7	47.16	45.11	43.06	41.01
39462	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.015"	-	27.43	26.24	25.04	23.85
39602	.3125	5/16"	7.938	5/16"	2-1/2"	3/4"	.015"	-	36.29	34.72	33.14	31.56
39662	.3150	8.000	8.0	65	19	0.50	-	-	38.19	36.53	34.87	33.21
39672	.3150	8.000	8.0	75	12	0.50	25	7.4	58.19	55.66	53.13	50.60
39682	.3150	8.000	8.0	75	12	1.00	25	7.4	58.19	55.66	53.13	50.60
39692	.3150	8.000	8.0	75	12	2.00	25	7.4	58.19	55.66	53.13	50.60
39702	.3150	8.000	8.0	75	12	3.00	25	7.4	58.19	55.66	53.13	50.60
39722	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.030"	-	42.30	40.46	38.62	36.78
39802	.3937	10.000	10.0	70	24	0.50	-	-	64.87	62.05	59.23	56.41
39812	.3937	10.000	10.0	100	12	1.00	35	9.4	87.20	83.41	79.62	75.83
39822	.3937	10.000	10.0	100	12	1.50	35	9.4	87.20	83.41	79.62	75.83
39832	.3937	10.000	10.0	100	12	2.00	35	9.4	87.20	83.41	79.62	75.83
39842	.3937	10.000	10.0	100	12	3.00	35	9.4	87.20	83.41	79.62	75.83
39882	.4724	12.000	12.0	75	32	0.50	-	-	80.24	76.75	73.26	69.77
39892	.4724	12.000	12.0	100	16	0.50	40	11.4	103.13	98.65	94.16	89.68
39902	.4724	12.000	12.0	100	16	1.00	40	11.4	103.13	98.65	94.16	89.68
39912	.4724	12.000	12.0	100	16	1.50	40	11.4	103.13	98.65	94.16	89.68
39922	.4724	12.000	12.0	100	16	2.00	40	11.4	103.13	98.65	94.16	89.68
39932	.4724	12.000	12.0	100	16	3.00	40	11.4	103.13	98.65	94.16	89.68

**MATERIAL HARDNESS (RC)**

70

35

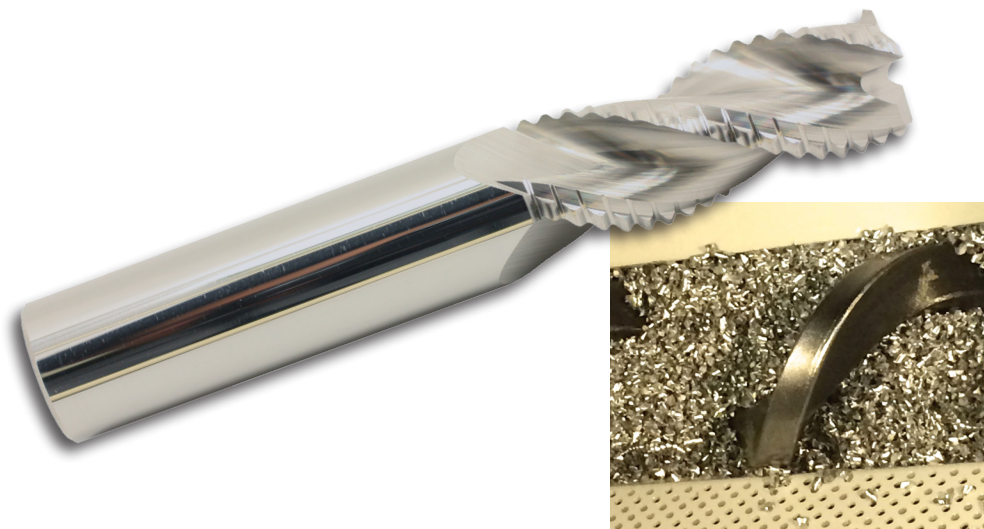
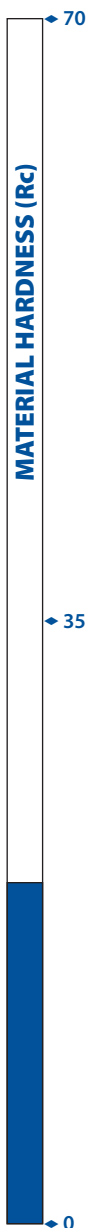
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continued →

Series 142R (continued)

.5000" - .7874"  
(12.700mm - 20.000mm)

EDP#	$d1$ † Diameter		$d2$ Shank Diameter	$l1$ Overall Length	$l2$ Flute Length	$r$ Corner Radius	$l3$ Reach Length	$d3$ Neck Diameter	1-11	12-24	25-49	50-100	
	Decimal	Metric											
39942	.5000	1/2"	12.700	1/2"	3"	1-1/4"	.030"	-	-	76.23	72.92	69.60	66.29
40022	.6250	5/8"	15.875	5/8"	4"	1-5/8"	.030"	-	-	131.86	126.13	120.39	114.66
40082	.6299		16.000	16.0	100	40	1.00	-	-	138.81	132.77	126.74	120.70
40092	.6299		16.000	16.0	125	20	1.00	60	15.4	188.62	180.42	172.22	164.02
40102	.6299		16.000	16.0	125	20	2.00	60	15.4	188.62	180.42	172.22	164.02
40142	.7500	3/4"	19.050	3/4"	4"	1-5/8"	.030"	-	-	171.13	163.69	156.25	148.81
40182	.7874		20.000	20.0	100	40	1.00	-	-	240.22	229.78	219.33	208.89
40192	.7874		20.000	20.0	150	20	1.00	65	19.0	328.96	314.66	300.35	286.05
40202	.7874		20.000	20.0	150	20	2.00	65	19.0	328.96	314.66	300.35	286.05
40212	.7874		20.000	20.0	150	20	3.00	65	19.0	328.96	314.66	300.35	286.05



*ARC Series hog mill (pg. 1 14)  
produces tiny chips*