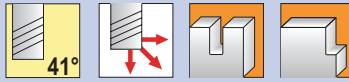


# Series 142R

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



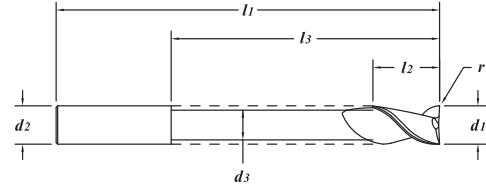
**TOLERANCES**

$d1$	+0.000" -0.001" (+0.000 -0.025mm)
$d2$	h6
$r$	+0.0005" -0.0005" (+0.0127 -0.0127mm)

Recommended for Aluminum

## HSAL End Mill - 2 Flute - Corner Radius 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#	$d1$ † 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										
39222	.1575	4.000	6.0	50	12	0.3	-	-	28.90	27.64	26.39	25.13
<b>NEW</b> 39232	.1575	4.000	6.0	65	6	0.5	20	3.7	35.34	33.80	32.27	30.73
<b>NEW</b> 39242	.1575	4.000	6.0	65	6	1.0	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	0.3	-	-	29.82	28.52	27.23	25.93
<b>NEW</b> 39352	.1969	5.000	6.0	75	8	0.5	20	4.7	48.73	46.61	44.49	42.37
<b>NEW</b> 39362	.1969	5.000	6.0	75	8	1.0	20	4.7	48.73	46.61	44.49	42.37
39402	.2362	6.000	6.0	65	19	0.3	-	-	28.87	27.61	26.36	25.10
<b>NEW</b> 39412	.2362	6.000	6.0	75	10	0.5	25	5.7	47.16	45.11	43.06	41.01
<b>NEW</b> 39422	.2362	6.000	6.0	75	10	1.0	25	5.7	47.16	45.11	43.06	41.01
<b>NEW</b> 39432	.2362	6.000	6.0	75	10	1.5	25	5.7	47.16	45.11	43.06	41.01
<b>NEW</b> 39442	.2362	6.000	6.0	75	10	2.0	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	0.5	-	-	38.19	36.53	34.87	33.21
<b>NEW</b> 39672	.3150	8.000	8.0	75	12	0.5	25	7.4	58.19	55.66	53.13	50.60
<b>NEW</b> 39682	.3150	8.000	8.0	75	12	1.0	25	7.4	58.19	55.66	53.13	50.60
<b>NEW</b> 39692	.3150	8.000	8.0	75	12	2.0	25	7.4	58.19	55.66	53.13	50.60
<b>NEW</b> 39702	.3150	8.000	8.0	75	12	3.0	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	0.5	-	-	64.87	62.05	59.23	56.41
<b>NEW</b> 39812	.3937	10.000	10.0	100	12	1.0	35	9.4	87.20	83.41	79.62	75.83
<b>NEW</b> 39822	.3937	10.000	10.0	100	12	1.5	35	9.4	87.20	83.41	79.62	75.83
<b>NEW</b> 39832	.3937	10.000	10.0	100	12	2.0	35	9.4	87.20	83.41	79.62	75.83
<b>NEW</b> 39842	.3937	10.000	10.0	100	12	3.0	35	9.4	87.20	83.41	79.62	75.83
39882	.4724	12.000	12.0	75	32	0.5	-	-	80.24	76.75	73.26	69.77
<b>NEW</b> 39892	.4724	12.000	12.0	100	16	0.5	40	11.4	103.13	98.65	94.16	89.68
<b>NEW</b> 39902	.4724	12.000	12.0	100	16	1.0	40	11.4	103.13	98.65	94.16	89.68
<b>NEW</b> 39912	.4724	12.000	12.0	100	16	1.5	40	11.4	103.13	98.65	94.16	89.68
<b>NEW</b> 39922	.4724	12.000	12.0	100	16	2.0	40	11.4	103.13	98.65	94.16	89.68
<b>NEW</b> 39932	.4724	12.000	12.0	100	16	3.0	40	11.4	103.13	98.65	94.16	89.68

# Series 142R (continued)

.5000" - 1.000"  
(12.700mm - 25.400mm)

HIGH PERFORMANCE  
END MILLS

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	1.0	-	-	138.81	132.77	126.74	120.70
<b>NEW</b> 40092	.6299		16.000	16.0	125	20	1.0	60	15.4	188.62	180.42	172.22	164.02
<b>NEW</b> 40102	.6299		16.000	16.0	125	20	2.0	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	1.0	-	-	240.22	229.78	219.33	208.89
<b>NEW</b> 40192	.7874		20.000	20.0	150	20	1.0	65	19.0	328.96	314.66	300.35	286.05
<b>NEW</b> 40202	.7874		20.000	20.0	150	20	2.0	65	19.0	328.96	314.66	300.35	286.05
<b>NEW</b> 40212	.7874		20.000	20.0	150	20	3.0	65	19.0	328.96	314.66	300.35	286.05

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MATERIAL HARDNESS (Rc)