

d_1	$+0.000" - .001" (+.000 - .025\text{mm})$
d_2	$h6$
ball radius	$+0.0000" - .0005" (+.0000 - .0127\text{mm})$



TECH
PAGES
289

Recommended for aluminum

HSAL End Mill - Ball End

ALUMASTAR Coating

Solid submicron grain carbide end mill - center cutting

Engineered for High Efficiency Milling

Specific coating engineered to repel aluminum

Engineered to run at 750-2500 SFM (225-750 M/Min.)

For high speed machining of aluminum

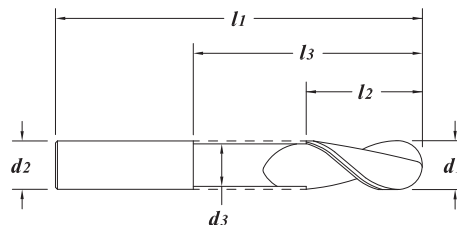
High velocity - high metal removal rate (for spindles 10,000 RPM and above)

Need to use properly balanced holders

Holds perpendicularity

Honed edge on radius for improved finish

Flats can be added within 48 hours



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									
42522	.1575	4.000	6.0	50	12	-	-	31.57	30.20	28.82	27.45
42582	.1875	3/16"	4.763	3/16"	2"	9/16"	-	23.40	22.39	21.37	20.35
42642	.1969	5.000	6.0	65	16	-	-	32.57	31.15	29.74	28.32
42702	.2362	6.000	6.0	65	19	-	-	31.52	30.15	28.78	27.41
42762	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	-	29.95	28.64	27.34	26.04
42764	.2500	1/4"	6.350	1/4"	4"	3/8"	1-1/8"	.235"	51.89	49.63	47.38
42842	.2756	7.000	8.0	65	19	-	-	45.84	43.85	41.85	39.86
42902	.3125	5/16"	7.938	5/16"	2-1/2"	3/4"	-	39.64	37.92	36.19	34.47
42962	.3150	8.000	8.0	65	19	-	-	41.70	39.89	38.07	36.26
43022	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	-	46.18	44.18	42.17	40.16
43023	.3750	3/8"	9.525	3/8"	4"	1/2"	1-1/8"	.355"	78.88	75.45	72.02
43102	.3937	10.000	10.0	70	24	-	-	70.84	67.76	64.68	61.60
43182	.4724	12.000	12.0	75	32	-	-	87.62	83.81	80.00	76.19
43242	.5000	1/2"	12.700	1/2"	3"	1-1/4"	-	83.24	79.62	76.00	72.38
43243	.5000	1/2"	12.700	1/2"	4"	5/8"	2-1/4"	.475"	106.98	102.33	97.68
43322	.6250	5/8"	15.875	5/8"	4"	1-5/8"	-	143.99	137.73	131.47	125.21
43382	.6299	16.000	16.0	100	40	-	-	151.58	144.99	138.40	131.81
43442	.7500	3/4"	19.050	3/4"	4"	1-5/8"	-	186.88	178.75	170.63	162.50
43444	.7500	3/4"	19.050	3/4"	5"	1"	3-1/16"	.715"	256.35	245.20	234.06
43482	.7874	20.000	20.0	100	32	-	-	262.32	250.91	239.51	228.10
43542	.9843	25.000	25.0	100	38	-	-	303.53	290.33	277.14	263.94
43602	1.000	1"	25.400	1"	4"	1-5/8"	-	318.70	304.84	290.99	277.13