

Series 142R

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

HIGH EFFICIENCY MILLING



TECH
PAGES
289

TOLERANCES

$d1$	+0.000" - .001" (+0.000 - .025mm)
$d2$	h6
r	+0.0005" - .0005" (+0.0127 - .0127mm)

Recommended for aluminum

HSAL End Mill - Corner Radius

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.)

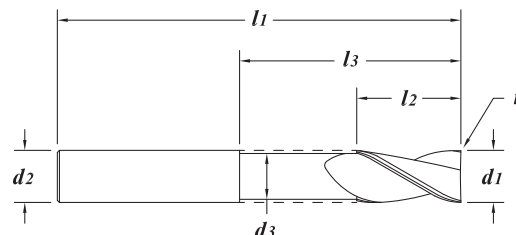
For high speed machining of aluminum

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

Need to use properly balanced holders

Holds perpendicularity

Flats can be added within 48 hours



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	0.30	-	-	31.57	30.20	28.82	27.45
39232	.1575	4.000	6.0	65	6	0.50	20	3.7	38.59	36.92	35.24	33.56
39242	.1575	4.000	6.0	65	6	1.00	20	3.7	38.59	36.92	35.24	33.56
39282	.1875	3/16"	4.763	3/16"	2"	9/16"	.010"	-	23.40	22.39	21.37	20.35
39342	.1969	5.000	6.0	65	16	0.30	-	-	32.57	31.15	29.74	28.32
39352	.1969	5.000	6.0	75	8	0.50	20	4.7	53.21	50.90	48.58	46.27
39362	.1969	5.000	6.0	75	8	1.00	20	4.7	53.21	50.90	48.58	46.27
39402	.2362	6.000	6.0	65	19	0.30	-	-	31.52	30.15	28.78	27.41
39412	.2362	6.000	6.0	75	10	0.50	25	5.7	51.50	49.26	47.02	44.78
39422	.2362	6.000	6.0	75	10	1.00	25	5.7	51.50	49.26	47.02	44.78
39432	.2362	6.000	6.0	75	10	1.50	25	5.7	51.50	49.26	47.02	44.78
39442	.2362	6.000	6.0	75	10	2.00	25	5.7	51.50	49.26	47.02	44.78
39462	.2500	1/4"	6.350	1/4"	2-1/2"	3/4"	.015"	-	29.95	28.64	27.34	26.04
39602	.3125	5/16"	7.938	5/16"	2-1/2"	3/4"	.015"	-	39.64	37.92	36.19	34.47
39662	.3150	8.000	8.0	65	19	0.50	-	-	41.70	39.89	38.07	36.26
39672	.3150	8.000	8.0	75	12	0.50	25	7.4	63.55	60.79	58.02	55.26
39682	.3150	8.000	8.0	75	12	1.00	25	7.4	63.55	60.79	58.02	55.26
39692	.3150	8.000	8.0	75	12	2.00	25	7.4	63.55	60.79	58.02	55.26
39702	.3150	8.000	8.0	75	12	3.00	25	7.4	63.55	60.79	58.02	55.26
39722	.3750	3/8"	9.525	3/8"	2-1/2"	7/8"	.030"	-	46.18	44.18	42.17	40.16
39802	.3937	10.000	10.0	70	24	0.50	-	-	70.84	67.76	64.68	61.60
39812	.3937	10.000	10.0	100	12	1.00	35	9.4	95.22	91.08	86.94	82.80
39822	.3937	10.000	10.0	100	12	1.50	35	9.4	95.22	91.08	86.94	82.80
39832	.3937	10.000	10.0	100	12	2.00	35	9.4	95.22	91.08	86.94	82.80
39842	.3937	10.000	10.0	100	12	3.00	35	9.4	95.22	91.08	86.94	82.80
39882	.4724	12.000	12.0	75	32	0.50	-	-	87.62	83.81	80.00	76.19
39892	.4724	12.000	12.0	100	16	0.50	40	11.4	112.62	107.72	102.83	97.93
39902	.4724	12.000	12.0	100	16	1.00	40	11.4	112.62	107.72	102.83	97.93
39912	.4724	12.000	12.0	100	16	1.50	40	11.4	112.62	107.72	102.83	97.93
39922	.4724	12.000	12.0	100	16	2.00	40	11.4	112.62	107.72	102.83	97.93
39932	.4724	12.000	12.0	100	16	3.00	40	11.4	112.62	107.72	102.83	97.93

EDP#	$d1^{\dagger}$ 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"	-	-	83.24	79.62	76.00	72.38
40022	.6250	5/8"	15.875	5/8"	4"	1-5/8"	.030"	-	-	143.99	137.73	131.47	125.21
40082	.6299		16.000	16.0	100	40	1.00	-	-	151.58	144.99	138.40	131.81
40092	.6299		16.000	16.0	125	20	1.00	60	15.4	205.98	197.02	188.07	179.11
40102	.6299		16.000	16.0	125	20	2.00	60	15.4	205.98	197.02	188.07	179.11
40142	.7500	3/4"	19.050	3/4"	4"	1-5/8"	.030"	-	-	186.88	178.75	170.63	162.50
40182	.7874		20.000	20.0	100	40	1.00	-	-	262.32	250.91	239.51	228.10
40192	.7874		20.000	20.0	150	20	1.00	65	19.0	359.21	343.60	327.98	312.36
40202	.7874		20.000	20.0	150	20	2.00	65	19.0	359.21	343.60	327.98	312.36
40212	.7874		20.000	20.0	150	20	3.00	65	19.0	359.21	343.60	327.98	312.36



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MATERIAL HARDNESS (Rc)