Series 142R

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

HIGH EFFICIENCY MILLING

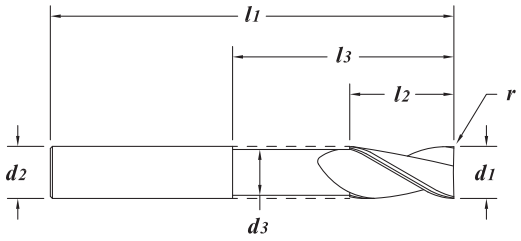
TOLERANCES	
d_1	+.000" –.001" (+.000 –.025mm)
d_2	h6
r	+.0005" –.0005" (+.0127 –.0127mm)

Recommended for aluminum

HSAL End Mill - Corner Radius

BALINIT® MAYURA 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



MATERIAL HARDNESS (Rc)
70
35
0

EDP#	d_1 † Diameter Decimal	Diameter	Metric	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
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

† *Metric equivalents are for reference only*

EDP#	d_1 † Diameter Decimal	Diameter	Metric	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
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

70
MATERIAL HARDNESS (Rc)
35
0