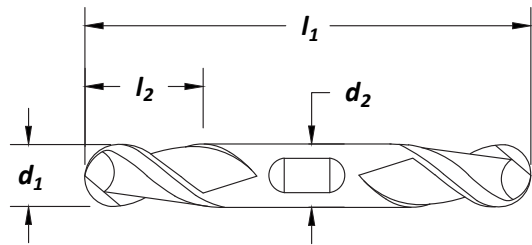




Surface Treatment



High Speed Steel

Center Cutting

cutting diameter <b>d<sub>1</sub></b>	decimal equiv.	shank dia <b>d<sub>2</sub> (in)</b>	length of cut <b>l<sub>2</sub> (in)</b>	overall length <b>l<sub>1</sub> (in)</b>	no. of flutes	order number		
						Bright	<b>HD-2B</b> TiN	TiCN
1/8	.1250	.375	.1875	3.125	2	C75117	C75120	C75123
1/8	.1250	.375	.375	3.063	2	C42184	C39142	C39158
5/32	.1562	.375	.438	3.125	2	C39136	C39143	C39159
3/16	.1875	.375	.281	3.250	2	C75118	C75121	C75124
3/16	.1875	.375	.438	3.250	2	C42186	C39144	C39160
7/32	.2188	.375	.500	3.250	2	C39137	C39145	C39161
1/4	.2500	.375	.375	3.375	2	C75119	C75122	C75125
1/4	.2500	.375	.500	3.375	2	C42189	C39146	C39162
9/32	.2812	.375	.563	3.375	2	C39138	C39147	C39163
5/16	.3125	.375	.563	3.500	2	C42191	C39148	C39164
11/32	.3438	.375	.563	3.500	2	C39139	C39149	C39165
3/8	.3750	.375	.563	3.500	2	C42194	C39150	C39166
13/32	.4062	.500	.813	4.125	2	C39140	C39151	C39167
7/16	.4375	.500	.813	4.125	2	C42197	C39152	C39168
1/2	.5000	.500	.813	4.125	2	C42199	C39153	C39169
5/8	.6250	.625	1.125	5.000	2	C42202	C39154	C39170
3/4	.7500	.750	1.313	5.625	2	C42205	C39155	C39171
7/8	.8750	.875	1.563	6.125	2	C39141	C39156	C39172
1	1.0000	1.000	1.625	6.375	2	C42212	C39157	C39173

Material Reference	Steel (HRC)				Stainless Steel			Cast Iron (HRC)		Aluminum and Non-Ferrous	Hi-Temp Alloy		Hardened Steel (HRC)
	Low Carbon		Alloy		Austenitic	Martensitic	PH	Gray	Nodular		Ni, Co, Fe Based Super Alloy	Titanium	
	Hardness	13-38	>38	16-38	>38	300 Series	400 series		18-22	22-32			>45
TiN	◆		◆					◆					
TiCN	☆		☆					☆		◆			

☆ = Best Performance    ◆ = Acceptable