



BASSETT™



Solid Carbide Cutting Tools
End Mills, Drills, Thread Mills, Burs



**GREENFIELD
INDUSTRIES**

Metalcutting Safety (read this before using Bassett/Putnam products)

Modern metalcutting operations involve high energy, high spindle or cutter speeds, and high temperatures and cutting forces. Hot, flying chips may be projected from the workpiece during metalcutting. Although advanced cutting tool materials are designed and manufactured to withstand the high cutting forces and temperatures that normally occur in these operations, they are susceptible to fragmenting in service, particularly if they are subjected to over-stress, severe impact or otherwise abused. Therefore, precautions should be taken to adequately protect workers, observers and equipment against hot, flying chips, fragmented cutting tools, broken workpieces or other similar projectiles. Machines should be fully guarded and personal protective equipment should be used at all times.

When grinding advanced cutting tool materials, a suitable means for collection and disposal of dust, mist or sludge should be provided. Overexposure to dust or mist containing metallic particles can be hazardous to health particularly if exposure continues over an extended period of time and may cause eye, skin and mucous membrane irritation and temporary or permanent respiratory disease. Certain existing pulmonary and skin conditions may be aggravated by exposure to dust or mist. Adequate ventilation, respiratory protection and eye protection should be provided when grinding and workers should avoid breathing of and prolonged skin contact with dust or mist. General In-

dustry Safety and Health Regulations, Part 1910. U.S. Department of Labor, published in Title 29 of the Code of Federal Regulations should be consulted. Obtain from Bassett/Putnam and read the applicable Material Safety Data Sheet before grinding.

Cutting tools are only one part of the worker-machine-tool system. Many variables exist in machining operations, including the metal removal rate; the workpiece size, shape, strength and rigidity; the chucking and fixturing; the load carrying capability of centers; the cutter and spindle speed and torque limitations; the holder and boring bar overhang; the available power; and the condition of the tooling and the machine. A safe metalcutting operation must take all of these variables, and others, into consideration.

Bassett/Putnam has no control over the end use of its products or the environment into which those products are placed. Bassett/Putnam urges that its customers adhere to the recommended standards of use of their metalcutting machines and tools, and that they follow procedures that ensure safe metalcutting operations. The information included throughout this catalog under the heading "Technical Data" and other recommendations on machining practices referred to herein are only advisory in nature and do not constitute representations or warranties and are not necessarily appropriate for any particular work environment or application.



BASSETT™

Bassett has manufactured the highest quality carbide cutting tools for six decades. Today, we serve clients throughout North America and the world from our modern, high-tech manufacturing facilities in Seneca, South Carolina, and worldwide. Our mission: to invest in the resources, technology, and people that enable us to provide world-class solid carbide round cutting tools for your most demanding applications.

A good tool begins with a good foundation. With Bassett, quality begins with a tradition of excellence. As part of the TDC Group, a vertically integrated company, Bassett has access to the finest raw materials from our own mines, which are refined in our own mills, and made into the blanks used in the manufacture of Bassett solid carbide cutting tools. All Bassett products conform to the strictest quality standards for your satisfaction.

Bassett Solid Carbide Cutting Tools

| | |
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| End Mills | 1-28 |
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BASSETT™



Solid Carbide End Mills



| Style No. | Flutes | Description | Finish | Page No. |
|---|--------------|--------------------------------|---------------------|----------|
| High-Performance Variable Index End Mills | | | | |
| Operating Parameters | | | | 2 |
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| MSE-V-4B | .4-flute | .ball nose | bright, TiAlN | 4 |
| MSE-V2-5R | .5-flute | .corner radius | bright, TiAlN | 5 |
| High-Performance End Mills for Steel and Stainless Steel | | | | |
| Operating Parameters | | | | 6 |
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| HPEM-5 | .5-flute | .square end | TiCN | 9 |
| High-Performance End Mills for Aluminum | | | | |
| Operating Parameters | | | | 10 |
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| HPAM-3 | .3-flute | .square end | bright, TiCN | 12 |
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| MRA | .multi-flute | .square end . . . for aluminum | bright, TiCN | 14 |
| General-Purpose End Mills | | | | |
| Operating Parameters | | | | 15 |
| Double End | | | | |
| MDE-2 | .2-flute | .square end | bright, TiCN | 16 |
| MDE-2B | .2-flute | .ball nose | bright, TiCN | 16 |
| MDE-4 | .4-flute | .square end | bright, TiCN | 17 |
| MDE-4B | .4-flute | .ball nose | bright, TiCN | 17 |
| Single End | | | | |
| MSE-2 | .2-flute | .square end | bright, TiCN | 18-19 |
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| MSE-4 | .4-flute | .square nose | bright, TiCN | 23-24 |
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| MEG-2 | .2-flute | .ball nose | TiCN | 27 |
| Chamfer Tools | | | | |
| MCH-2R | .2-flute | .single end | bright | 28 |
| MCH-2D | .2-flute | .double end | bright | 28 |
| MCH-4R | .4-flute | .single end | bright | 28 |
| MCH-4D | .4-flute | .double end | bright | 28 |

CARBIDE END MILLS

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Variable Index End Mills

Operating Parameters for Series MSE-V-* Variable Index End Mills

regular and stub length

side milling axial 1.5 x D • side milling radial .5 x D • slotting axial 1 x D

| INCH SIZES | Speed | | feed per tooth (inches) | | | | | | | |
|--|-------|--------|-------------------------|--------|--------|--------|--------|--------|--------|--------|
| | sfm | 5/32 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
| easy to cut stainless steel (304) | 280 | 0.0010 | 0.0012 | 0.0016 | 0.0020 | 0.0024 | 0.0026 | 0.0028 | 0.0028 | 0.0030 |
| moderately difficult to cut stainless | 240 | 0.0008 | 0.0010 | 0.0014 | 0.0018 | 0.0020 | 0.0022 | 0.0024 | 0.0026 | 0.0028 |
| difficult to cut stainless steels (315L) | 200 | 0.0006 | 0.0010 | 0.0012 | 0.0016 | 0.0018 | 0.0020 | 0.0022 | 0.0024 | 0.0024 |
| soft steels (1020) | 500 | 0.0010 | 0.0012 | 0.0016 | 0.0024 | 0.0024 | 0.0028 | 0.0030 | 0.0031 | 0.0039 |
| titanium alpha beta alloys (Ti6Al4V) | 170 | 0.0005 | 0.0006 | 0.0008 | 0.0012 | 0.0012 | 0.0016 | 0.0018 | 0.0020 | 0.0028 |
| gray cast iron (GG) | 500 | 0.0010 | 0.0012 | 0.0016 | 0.0024 | 0.0024 | 0.0028 | 0.0030 | 0.0031 | 0.0039 |

long length

side milling axial 1-3 x D • side milling radial .2 - .3 x D • slotting axial .3 - .5 x D

| INCH SIZES | Speed | | feed per tooth (inches) | | | | | | | |
|---|-------|--------|-------------------------|--------|--------|--------|--------|--------|--------|--------|
| | sfm | 5/32 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
| easy to cut stainless steel (304) | 280 | 0.0009 | 0.0011 | 0.0014 | 0.0018 | 0.0022 | 0.0023 | 0.0025 | 0.0025 | 0.0027 |
| moderately difficult to cut stainless | 240 | 0.0007 | 0.0009 | 0.0013 | 0.0016 | 0.0018 | 0.0020 | 0.0022 | 0.0023 | 0.0025 |
| difficult to cut stainless steel (315L) | 200 | 0.0005 | 0.0009 | 0.0011 | 0.0014 | 0.0016 | 0.0018 | 0.0020 | 0.0022 | 0.0022 |
| soft steels (1020) | 500 | 0.0009 | 0.0011 | 0.0014 | 0.0022 | 0.0022 | 0.0025 | 0.0027 | 0.0028 | 0.0035 |
| titanium alpha beta alloys (Ti6Al4V) | 170 | 0.0005 | 0.0005 | 0.0007 | 0.0011 | 0.0011 | 0.0014 | 0.0016 | 0.0018 | 0.0025 |
| gray cast iron (GG) | 500 | 0.0009 | 0.0011 | 0.0014 | 0.0022 | 0.0022 | 0.0025 | 0.0027 | 0.0028 | 0.0035 |

Operating Parameters for Series MSE-V2-* Variable Index End Mills



side milling axial 1.5 x D • side milling radial 0.5 x D • slotting axial 1 x D

| INCH SIZES material | speed | | chip load per tooth (inches) | | | | | | |
|---|---------|--------|------------------------------|--------|--------|--------|--------|--------|--------|
| | sfm | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
| medium and high carbon steels >0.3% C | 520-650 | 0.0015 | 0.0021 | 0.0023 | 0.0026 | 0.0030 | 0.0031 | 0.0038 | 0.0044 |
| alloy steels and tool steels <330HB, <35HRc | 520-590 | 0.0011 | 0.0017 | 0.0020 | 0.0023 | 0.0029 | 0.0029 | 0.0034 | 0.0040 |
| alloy steels and tool steels 340-450 HB, 36-48 HRc | 460-520 | 0.0010 | 0.0015 | 0.0016 | 0.0020 | 0.0026 | 0.0027 | 0.0030 | 0.0038 |
| austenitic stainless steel 302, 303, 304 | 290-370 | 0.0011 | 0.0017 | 0.0020 | 0.0023 | 0.0027 | 0.0029 | 0.0032 | 0.0040 |
| austenitic stainless steel 316, 316L | 190-260 | 0.0009 | 0.0013 | 0.0016 | 0.0019 | 0.0025 | 0.0025 | 0.0028 | 0.0032 |
| austenitic stainless steel duplex | 190-230 | 0.0008 | 0.0010 | 0.0014 | 0.0015 | 0.0019 | 0.0020 | 0.0023 | 0.0028 |
| cast iron, gray GG | 430-550 | 0.0014 | 0.0022 | 0.0025 | 0.0030 | 0.0035 | 0.0040 | 0.0045 | 0.0050 |
| ductile and maleable cast iron CGI < 80 KSI | 360-430 | 0.0009 | 0.0013 | 0.0018 | 0.0019 | 0.0025 | 0.0027 | 0.0030 | 0.0040 |
| nickel-based heat-resistant alloys | 80-130 | 0.0004 | 0.0007 | 0.0011 | 0.0015 | 0.0016 | 0.0019 | 0.0023 | 0.0028 |
| alpha-beta titanium alloys Ti6Al4V | 160-200 | 0.0008 | 0.0010 | 0.0014 | 0.0015 | 0.0021 | 0.0023 | 0.0028 | 0.0036 |

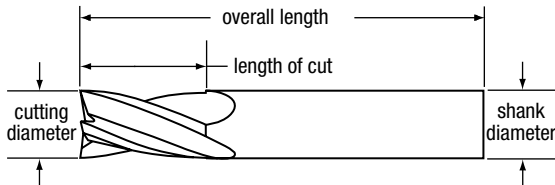
Variable Index End Mills for Ferrous Materials

Series **MSE-V-4R**

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius #1 | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiAIN |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1-1/2 | 4 | 0.010 | B40140 | B60140 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/8 | 1-1/2 | 4 | 0.010 | B40141 | B60141 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/8 | 2 | 4 | 0.010 | B40142 | B60142 |
| 3/16 | .1875 | 4.76 | 3/16 | 7/16 | 2 | 4 | 0.010 | B40143 | B60143 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 4 | 0.020 | B40144 | B60144 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2-1/2 | 4 | 0.020 | B40145 | B60145 |
| 1/4 | .2500 | 6.35 | 1/4 | 1-1/8 | 3 | 4 | 0.020 | B40146 | B60146 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 4 | 0.020 | B40147 | B60147 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2-1/2 | 4 | 0.020 | B40148 | B60148 |
| 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 4 | 0.020 | B40149 | B60149 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2-1/2 | 4 | 0.020 | B40150 | B60150 |
| 3/8 | .3750 | 9.53 | 3/8 | 1-1/8 | 3 | 4 | 0.020 | B40151 | B60151 |
| 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2-1/2 | 4 | 0.020 | B40152 | B60152 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 3 | 4 | 0.020 | B40153 | B60153 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2-1/2 | 4 | 0.030 | B40154 | B60154 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | 0.030 | B40155 | B60155 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 4 | 0.030 | B40156 | B60156 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 4 | 0.030 | B40157 | B60157 |
| 5/8 | .6250 | 15.88 | 5/8 | 1-1/4 | 3-1/2 | 4 | 0.030 | B40158 | B60158 |
| 5/8 | .6250 | 15.88 | 5/8 | 2-1/4 | 5 | 4 | 0.030 | B40159 | B60159 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 4 | 0.030 | B40160 | B60160 |
| 3/4 | .7500 | 19.05 | 3/4 | 1-1/2 | 4 | 4 | 0.030 | B40161 | B60161 |
| 3/4 | .7500 | 19.05 | 3/4 | 2-1/4 | 5 | 4 | 0.030 | B40162 | B60162 |
| 1 | 1.0000 | 25.40 | 1 | 1-1/2 | 4 | 4 | 0.030 | B40163 | B60163 |
| 1 | 1.0000 | 25.40 | 1 | 2-1/4 | 5 | 4 | 0.030 | B40164 | B60164 |

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Variable Index End Mills for Ferrous Materials

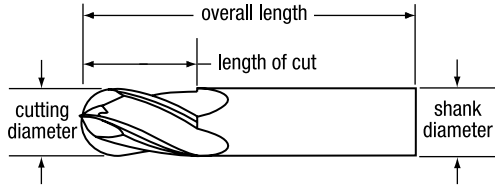
BASSETT™

Series MSE-V-4B

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiAlN |
| 1/8 | .1250 | 3.18 | 1/8 | 3/8 | 1-1/2 | 4 | B40308 | B60308 |
| 3/16 | .1875 | 4.76 | 3/16 | 7/16 | 2 | 4 | B40309 | B60309 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2-1/2 | 4 | B40310 | B60310 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2-1/2 | 4 | B40311 | B60311 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2-1/2 | 4 | B40312 | B60312 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 3 | 4 | B40313 | B60313 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | B40314 | B60314 |
| 5/8 | .6250 | 15.88 | 5/8 | 1-1/4 | 3-1/2 | 4 | B40315 | B60315 |
| 3/4 | .7500 | 19.05 | 3/4 | 1-1/2 | 4 | 4 | B40316 | B60316 |
| 1 | 1.0000 | 25.40 | 1 | 2-1/4 | 5 | 4 | B40317 | B60317 |

CARBIDE END MILLS

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V2 Variable Index End Mills for Ferrous Materials

Series **MSE-V2-5R**

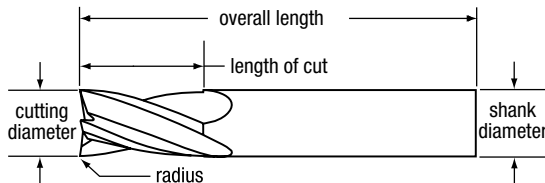
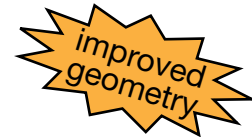
Applications |

- STAINLESS STEEL
- HARDENED STEEL
- HI-TEMP ALLOYS

Features |

- SOLID CARBIDE
- BRIGHT
- TiAlN
- VARIABLE INDEX
- CORNER RADIUS
- 5 FLUTE CC

- for slotting up to 1 x D
- minimized chatter from unequal flute spacing
- use one tool for roughing and finishing operations



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiAlN |
| 3/16 | .1875 | 4.76 | 3/16 | 3/8 | 2 | 5 | .010 | B40411 | B60411 |
| 3/16 | .1875 | 4.76 | 3/16 | 7/16 | 2 | 5 | .010 | B40412 | B60412 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 5 | .020 | B40413 | B60413 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2-1/2 | 5 | .020 | B40414 | B60414 |
| 1/4 | .2500 | 6.35 | 1/4 | 1-1/8 | 3 | 5 | .020 | B40415 | B60415 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 5 | .020 | B40416 | B60416 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2-1/2 | 5 | .020 | B40417 | B60417 |
| 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 5 | .020 | B40418 | B60418 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2-1/2 | 5 | .020 | B40419 | B60419 |
| 3/8 | .3750 | 9.53 | 3/8 | 1-1/8 | 3 | 5 | .020 | B40420 | B60420 |
| 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2-1/2 | 5 | .020 | B40421 | B60421 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 3 | 5 | .020 | B40422 | B60422 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2-1/2 | 5 | .030 | B40423 | B60423 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 5 | .030 | B40424 | B60424 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 5 | .030 | B40425 | B60425 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 5 | .030 | B40426 | B60426 |
| 5/8 | .6250 | 15.88 | 5/8 | 1-1/4 | 3-1/2 | 5 | .030 | B40427 | B60427 |
| 5/8 | .6250 | 15.88 | 5/8 | 2-1/4 | 5 | 5 | .030 | B40428 | B60428 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 5 | .030 | B40429 | B60429 |
| 3/4 | .7500 | 19.05 | 3/4 | 1-1/2 | 4 | 5 | .030 | B40430 | B60430 |
| 3/4 | .7500 | 19.05 | 3/4 | 2-1/4 | 5 | 5 | .030 | B40431 | B60431 |
| 1 | 1.0000 | 25.40 | 1 | 1-1/2 | 4 | 5 | .030 | B40432 | B60432 |
| 1 | 1.0000 | 25.40 | 1 | 2-1/4 | 5 | 5 | .030 | B40433 | B60433 |

CARBIDE END MILLS
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 INDEX



High-Performance End Mills for Steel

Operating Parameters: HPEM High-Performance End Mills for Steel

| Material | Hardness | | Surface Feet per Minute | | Chip Load per Tooth | | |
|--|----------|--------|-------------------------|------|---------------------|-------------|-----------|
| | Brinell | HRC | Speed Range | SFM | 1/32" - 1/4" | 1/4" - 1/2" | 1/2" - 1" |
| low alloy steels | <220 HB | <19 | Low | 300 | .0005 | .0010 | .0020 |
| | | | High | 360 | .0010 | .0020 | .0030 |
| medium alloy steels O1 to O7, W1 to W3, M1 to M3, T1 to T5, A2 to A3, S1 to S7, P2 to P3 | 225-286 | 20-30 | Low | 250 | .0003 | .0005 | .001 |
| | | | High | 350 | .0005 | .0010 | .0015 |
| high alloy steels M4 to M7, T6 to T15, D2 to D7, A4 to A7, P4 | 294-371 | 31-40 | Low | 120 | .0003 | .0005 | .0008 |
| | | | High | 250 | .0005 | .0010 | .0015 |
| stainless steels 200/300 series | 135-275 | <28 | Low | 100 | .0005 | .0010 | .0020 |
| | | | High | 200 | .0010 | .0020 | .0030 |
| stainless steels 400/500 series | 135-330 | <35 | Low | 100 | .0003 | .0008 | .0010 |
| | | | High | 200 | .0005 | .0010 | .0015 |
| nickel-based alloys | 140-475 | <32-50 | Low | 90 | .0005 | .0010 | .0015 |
| | | | High | 180 | .0010 | .0015 | .0040 |
| titanium alloys | 110-450 | <48 | Low | 80 | .0005 | .0010 | .0025 |
| | | | High | 100 | .0010 | .0030 | .0050 |
| inconel | 140-475 | <48 | Low | 30 | .0005 | .0010 | .0015 |
| | | | High | 50 | .0010 | .0015 | .0030 |
| aluminum, low silicon | — | — | Low | 800 | .0030 | .0040 | .0060 |
| | | | High | 1600 | .0040 | .0060 | .0080 |

Higher values for surface speed should be used for radial depths of cut less than 25% of the diameter. Lower values for surface speed should be used for radial depths of cut greater than 25% of the diameter. The above recommendations are for axial lengths of cut not to exceed 1 times the cutter diameter for profiling and .5 times the diameter for slotting. Recommended speeds above are for uncoated tools only and should be adjusted when using coated

tools. Generally, speeds can be increased by the following factors: TiCN-coated tools – 20-25% increase; TiAlN-coated tools – 40-50% increase. The above speeds are a recommended starting point only. If the tool is working well, without vibrations or significant noise, increase the SFM in 5-10% increments. Ultimate speeds will depend upon setup conditions. Higher or lower parameters may be required to achieve optimum conditions.

Series HPEM for stainless steels and exotic materials

Features and Benefits of HPEM End Mills

- Maximized strength due to increased cross-sectional area in the core and flute body.
- Combination of micrograin carbide substrate with high-performance coatings.
- Achieve 50% greater chip loads and 20% to 40% higher speeds than conventional end mills.

Applications for HPEM End Mills

- Designed for cutting applications involving excessive mechanical stress.
- Ideally suited for use in stainless steel and exotics such as hastalloy, waspalloy, and inconel.
- 3-flute square end for pocketing, slotting, or roughing.
- 3-flute ball nose gives enhanced surface finish in contour cutting and rapid chip removal in plunge cutting.
- 5-flute design for profiling and finishing applications.

Tolerances for Solid Carbide End Mills

Cutting Diameter:

1/32" through 1/4" +.000 –.002

17/64" through 1" +.000 –.003

Shank Diameter:

+.0000 –.0005

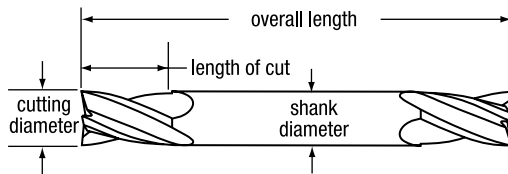
High-Performance End Mills For Steel

Series HPDEM-5 • Double End

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 5 | B05100 | B05605 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 5 | B05101 | B05609 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 1/2 | 5 | B05103 | B05613 |
| 5/16 | .3125 | 7.94 | 5/16 | 7/16 | 2 1/2 | 5 | B05104 | B05617 |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 1/2 | 5 | B05106 | B05621 |
| 7/16 | .4375 | 11.11 | 7/16 | 9/16 | 3 | 5 | B05108 | B05625 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 3 | 5 | B05110 | B05629 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

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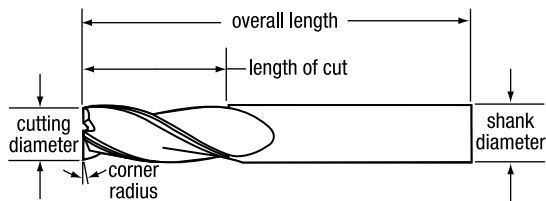
High-Performance End Mills For Steel

Series HPEM-3

Applications |



Features |

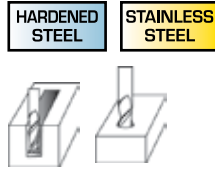


| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiCN |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 3 | .010 | B05105 | B05005 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 3 | .010 | B05140 | B05040 |
| 5/32 | .1562 | 3.97 | 3/16 | 5/16 | 2 | 3 | .010 | B05107 | B05007 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 3 | .010 | B05142 | B05042 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 3 | .010 | B05109 | B05009 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 3 | .010 | B05144 | B05044 |
| 7/32 | .2188 | 5.56 | 1/4 | 1/2 | 2 | 3 | .020 | B05111 | B05011 |
| 7/32 | .2188 | 5.56 | 1/4 | 3/4 | 2 1/2 | 3 | .020 | B05146 | B05046 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 | 3 | .020 | B05113 | B05013 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | .020 | B05148 | B05048 |
| 9/32 | .2812 | 7.14 | 5/16 | 7/16 | 2 | 3 | .020 | B05115 | B05015 |
| 9/32 | .2812 | 7.14 | 5/16 | 13/16 | 2 1/2 | 3 | .020 | B05150 | B05050 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 3 | .020 | B05117 | B05017 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 3 | .020 | B05152 | B05052 |
| 11/32 | .3438 | 8.73 | 3/8 | 1/2 | 2 | 3 | .020 | B05119 | B05019 |
| 11/32 | .3438 | 8.73 | 3/8 | 7/8 | 2 1/2 | 3 | .020 | B05154 | B05054 |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 | 3 | .020 | B05121 | B05021 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | .020 | B05156 | B05056 |
| 13/32 | .4062 | 10.32 | 7/16 | 9/16 | 2 1/2 | 3 | .020 | B05123 | B05023 |
| 13/32 | .4062 | 10.32 | 7/16 | 1 | 2 1/2 | 3 | .020 | B05158 | B05058 |
| 7/16 | .4375 | 11.11 | 7/16 | 9/16 | 2 1/2 | 3 | .020 | B05125 | B05025 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 2 1/2 | 3 | .020 | B05160 | B05060 |
| 15/32 | .4688 | 11.91 | 1/2 | 1/2 | 2 1/2 | 3 | .020 | B05127 | B05027 |
| 15/32 | .4688 | 11.91 | 1/2 | 1 1/4 | 3 | 3 | .020 | B05162 | B05062 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 3 | .030 | B05129 | B05029 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/4 | 3 | 3 | .030 | B05164 | B05064 |
| 5/8 | .6250 | 15.88 | 5/8 | 5/8 | 3 | 3 | .030 | B05131 | B05031 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 5/8 | 3 1/2 | 3 | .030 | B05166 | B05066 |
| 3/4 | .7500 | 19.05 | 3/4 | 7/8 | 3 | 3 | .030 | B05133 | B05032 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 5/8 | 4 | 3 | .030 | B05168 | B05067 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/8 | 3 | 3 | .030 | B05135 | B05034 |
| 1 | 1.0000 | 25.40 | 1 | 2 | 4 | 3 | .030 | B05170 | B05069 |

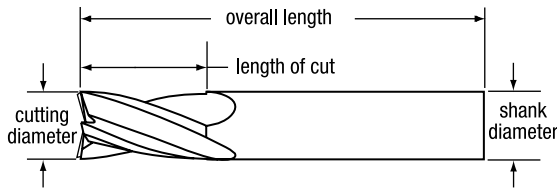
High-Performance End Mills For Steel

Series HPEM-5

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP Number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 5 | B05112 | B05405 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 5 | B05141 | B05440 |
| 5/32 | .1562 | 3.97 | 3/16 | 5/16 | 2 | 5 | B05114 | B05407 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 5 | B05143 | B05442 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 5 | B05116 | B05409 |
| 3/16 | .1875 | 4.76 | 3/16 | 9/16 | 2 | 5 | B05145 | B05444 |
| 7/32 | .2188 | 5.56 | 1/4 | 3/8 | 2 | 5 | B05118 | B05411 |
| 7/32 | .2188 | 5.56 | 1/4 | 3/4 | 2 1/2 | 5 | B05147 | B05446 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 | 5 | B05120 | B05413 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 5 | B05149 | B05448 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/4 | 4 | 5 | B05171 | B05513 |
| 9/32 | .2812 | 7.14 | 5/16 | 7/16 | 2 | 5 | B05122 | B05415 |
| 9/32 | .2812 | 7.14 | 5/16 | 13/16 | 2 1/2 | 5 | B05151 | B05450 |
| 5/16 | .3125 | 7.94 | 5/16 | 7/16 | 2 | 5 | B05124 | B05417 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 5 | B05153 | B05452 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/4 | 4 | 5 | B05173 | B05517 |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 | 5 | B05126 | B05421 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 5 | B05155 | B05456 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 4 | 5 | B05175 | B05521 |
| 7/16 | .4375 | 11.11 | 7/16 | 9/16 | 2 1/2 | 5 | B05128 | B05425 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 2 1/2 | 5 | B05157 | B05460 |
| 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 5 | B05177 | B05525 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 5 | B05130 | B05429 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/4 | 3 | 5 | B05159 | B05464 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 5 | B05179 | B05529 |
| 9/16 | .5625 | 14.29 | 9/16 | 1 1/2 | 3 1/2 | 5 | B05161 | B05465 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 5 | B05132 | B05431 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 5/8 | 3 1/2 | 5 | B05163 | B05466 |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/2 | 5 | 5 | B05181 | B05531 |
| 3/4 | .7500 | 19.05 | 3/4 | 7/8 | 3 | 5 | B05134 | B05432 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 5/8 | 4 | 5 | B05165 | B05467 |
| 3/4 | .7500 | 19.05 | 3/4 | 3 1/4 | 6 | 5 | B05183 | B05532 |
| 7/8 | .8750 | 22.23 | 7/8 | 2 | 4 | 5 | B05167 | B05468 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/8 | 3 | 5 | B05136 | B05434 |
| 1 | 1.0000 | 25.40 | 1 | 2 | 4 | 5 | B05169 | B05469 |
| 1 | 1.0000 | 25.40 | 1 | 3 1/4 | 6 | 5 | B05185 | B05533 |



High-Performance End Mills for Aluminum

BASSETT™

Operating Parameters: HPAM High-Performance End Mills for Aluminum

| Type of Cut | Aluminum Alloys 6061-T6, 7075-T6, 440, 356, 380, C61300 | Depth of Cut % of tool diameter | SFM (speed) | End Mill Diameter Chip Load per Tooth | | | | | |
|----------------------------------|---|---------------------------------------|----------------|---------------------------------------|--------|-------|--------|--------|-------|
| | | | | 1/4" | 3/8" | 1/2" | 5/8" | 3/4" | 1" |
| shallow slotting | < 32 HRC | < 50% | 1200 + | .0045 | .0071 | .0100 | .0123 | .0149 | .0200 |
| | > 32 HRC | | 600 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| deep slotting | < 32 HRC | 75-100% | 1200 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| | > 32 HRC | | 600 + | .0027 | .0043 | .0060 | .0074 | .0089 | .0120 |
| medium radial 1.0 x dia depth | < 32 HRC | 30% x dia. radial | 1200 + | .0045 | .0071 | .0100 | .0123 | .0149 | .0200 |
| | > 32 HRC | | 600 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| heavy radial 1.0 x dia depth | < 32 HRC | 50% x dia. radial | 1200 + | .0036 | .0057 | .0080 | .0098 | .0119 | .016 |
| medium radial 2.0 x dia depth | < 32 HRC | 30% x dia. radial | 1200 + | .0045 | .0071 | .0100 | .0123 | .0149 | .0200 |
| | > 32 HRC | | 600 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| heavy radial 2.0 x dia depth | < 32 HRC | 50% x dia. radial | 1200 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| finishing medium radial | < 32 HRC | < 25% of dia. | 1200 + | .0045 | .0071 | .0100 | .0123 | .0149 | .0200 |
| | > 32 HRC | | 600 + | .0036 | .0057 | .0080 | .0098 | .0119 | .0160 |
| finishing light radial | < 32HRC | < 10% of dia. | 1200 + | .0045 | .00713 | .0100 | .01225 | .01485 | .0200 |
| finishing | < 32 HRC | < .010 radial depth | 1200 + | .0054 | .0086 | .0120 | .0147 | .0178 | .0240 |
| | > 32 HRC | | 600 + | .0045 | .0071 | .0100 | .0123 | .0149 | .0200 |

This chart represents starting points based on a coated tool. Reduce rates up to 50% when using an uncoated tool.

These speed and feed rates are suggested as general guidelines. Machine type, horsepower, spindle speed limitations, toolholding and workholding devices all may impact a cutting tool's ability to perform properly. Greenfield Industries is not responsible for tool failure, part damage, or injury that may be caused by following these general recommendations..

Formulae

$$RPM = (SFM \times 3.82) / \text{tool diameter}$$

$$IPM = \text{number of flutes} \times RPM \times \text{chip load per tooth}$$

Series HPAM for aluminum and nonferrous materials

Features and Benefits of HPAM End Mills

- Delivers superior performance, providing increased tool life and improved part finish.
- Concentric margins stabilize the tool in the cut and reduce chatter at elevated speeds.
- Greater resistance to chipping with increased feed and speed rates over conventional carbide tools.
- Design incorporates rake enhancements in the flute for improved chip flow and higher feed rates at high and low spindle speeds.
- Tool design eliminates excess pressure that causes chip packing.

Applications for HPAM End Mills

- 2-flute square end offers excellent performance in roughing and finishing, in ramp cutting and in plunging.
- 2-flute ball nose designed for contouring aluminum, copper, and other non-ferrous materials.
- 3-flute square end gives superior surface finishes without sacrificing metal removal rates in high-speed slotting, profiling, and ramping.

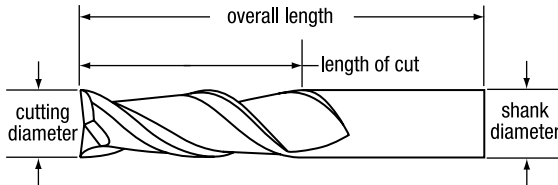
High-Performance End Mills for Aluminum

Series **HPAM-2** • square end

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 2 | B04440 | B06440 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/8 | 1 1/2 | 2 | B04405 | B06405 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 2 | B04444 | B06444 |
| 3/16 | .1875 | 4.76 | 3/16 | 9/16 | 2 | 2 | B04409 | B06409 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 1/2 | 2 | B04448 | B06448 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | B04413 | B06413 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/4 | 3 | 2 | B04548 | B06548 |
| 5/16 | .3125 | 7.94 | 5/16 | 7/16 | 2 1/2 | 2 | B04452 | B06452 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | B04417 | B06417 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/4 | 3 1/2 | 2 | B04552 | B06552 |
| 5/16 | .3125 | 7.94 | 5/16 | 2 1/8 | 4 | 2 | B04617 | B06617 |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 1/2 | 2 | B04456 | B06456 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | B04421 | B06421 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 4 | 2 | B04556 | B06556 |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 6 | 2 | B04621 | B06621 |
| 7/16 | .4375 | 11.11 | 7/16 | 9/16 | 2 1/2 | 2 | B04460 | B06460 |
| 7/16 | .4375 | 11.11 | 7/16 | 1 | 2 1/2 | 2 | B04425 | B06425 |
| 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 2 | B04560 | B06560 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 3 | 2 | B04464 | B06464 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/4 | 3 | 2 | B04429 | B06429 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 2 | B04564 | B06564 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 1/8 | 6 | 2 | B04629 | B06629 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 1/2 | 2 | B04466 | B06466 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 5/8 | 4 | 2 | B04431 | B06431 |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/2 | 5 | 2 | B04566 | B06566 |
| 5/8 | .6250 | 15.88 | 5/8 | 3 3/4 | 6 | 2 | B04631 | B06631 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 4 | 2 | B04467 | B06467 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 5/8 | 4 | 2 | B04432 | B06432 |
| 3/4 | .7500 | 19.05 | 3/4 | 3 1/4 | 6 | 2 | B04567 | B06567 |
| 3/4 | .7500 | 19.05 | 3/4 | 4 | 6 1/2 | 2 | B04632 | B06632 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/4 | 5 | 2 | B04469 | B06469 |
| 1 | 1.0000 | 25.40 | 1 | 2 | 5 | 2 | B04434 | B06434 |
| 1 | 1.0000 | 25.40 | 1 | 3 1/4 | 6 | 2 | B04569 | B06569 |
| 1 | 1.0000 | 25.40 | 1 | 4 1/8 | 7 | 2 | B04634 | B06634 |



High-Performance End Mills for Aluminum

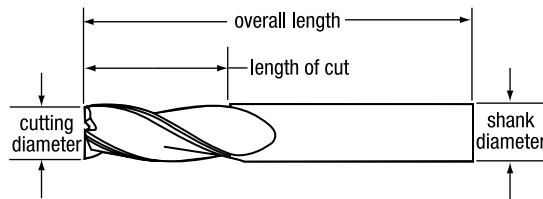
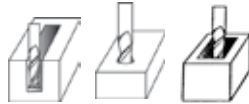
BASSETT™

Series **HPAM-3** • square end

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | bright | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|--------|------------|--|
| fractional | decimal | metric | | | | | | TiCN | |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 3 | B04005 | B06005 | |
| 1/8 | .1250 | 3.18 | 1/8 | 3/8 | 1 1/2 | 3 | B04040 | B06040 | |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 3 | B04009 | B06009 | |
| 3/16 | .1875 | 4.76 | 3/16 | 9/16 | 2 | 3 | B04044 | B06044 | |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 | 3 | B04013 | B06013 | |
| 1/4 | .2500 | 6.35 | 1/4 | 5/8 | 2 1/2 | 3 | B04048 | B06048 | |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/4 | 3 | 3 | B04148 | B06148 | |
| 5/16 | .3125 | 7.94 | 5/16 | 7/16 | 2 | 3 | B04017 | B06017 | |
| 5/16 | .3125 | 7.94 | 5/16 | 5/8 | 2 1/2 | 3 | B04052 | B06052 | |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/4 | 3 1/2 | 3 | B04152 | B06152 | |
| 5/16 | .3125 | 7.94 | 5/16 | 2 1/8 | 4 | 3 | B04217 | B06217 | |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 | 3 | B04021 | B06021 | |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 3 | B04056 | B06056 | |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 3 1/2 | 3 | B04156 | B06156 | |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 6 | 3 | B04221 | B06221 | |
| 7/16 | .4375 | 11.11 | 7/16 | 9/16 | 2 1/2 | 3 | B04025 | B06025 | |
| 7/16 | .4375 | 11.11 | 7/16 | 1 1/4 | 2 1/2 | 3 | B04060 | B06060 | |
| 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 3 | B04160 | B06160 | |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 3 | B04029 | B06029 | |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/4 | 3 | 3 | B04064 | B06064 | |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 3 | B04164 | B06164 | |
| 1/2 | .5000 | 12.70 | 1/2 | 3 1/8 | 6 | 3 | B04229 | B06229 | |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 3 | B04031 | B06031 | |
| 5/8 | .6250 | 15.88 | 5/8 | 1 5/8 | 4 | 3 | B04066 | B06066 | |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/2 | 5 | 3 | B04166 | B06166 | |
| 5/8 | .6250 | 15.88 | 5/8 | 3 3/4 | 6 | 3 | B04231 | B06231 | |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 3 | B04032 | B06032 | |
| 3/4 | .7500 | 19.05 | 3/4 | 1 5/8 | 4 | 3 | B04067 | B06067 | |
| 3/4 | .7500 | 19.05 | 3/4 | 3 1/4 | 6 | 3 | B04167 | B06167 | |
| 1 | 1.0000 | 25.40 | 1 | 1 1/4 | 4 | 3 | B04034 | B06034 | |
| 1 | 1.0000 | 25.40 | 1 | 2 | 5 | 3 | B04069 | B06069 | |
| 1 | 1.0000 | 25.40 | 1 | 3 1/4 | 6 | 3 | B04169 | B06169 | |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

High-Performance Roughers

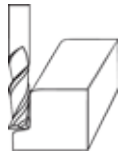
Operating Parameters for High-Performance Roughers

| Material | Hardness | | Surface Feet per Minute | | | Chip Load per Tooth | |
|---|-----------|---------|-------------------------|-------------|-----------|---------------------|---------------|
| | Brinell | HRC | Uncoated | TiCN | TiAlN | 1/4" to 1/2" | 1/2" - 1" |
| low and plain carbon, alloy, and tool steels | <220 HB | <19 | - | 325 - 500 | 430 - 575 | .0015 - .0030 | .0030 - .0045 |
| plain carbon, alloy and tool steels | 225 - 286 | 20 - 30 | - | 215 - 375 | 350 - 430 | .0015 - .0030 | .0030 - .0045 |
| | 294 - 371 | 31 - 40 | - | 180 - 280 | 210 - 320 | .0011 - .0021 | .0021 - .0032 |
| austenitic stainless steels 200 and 300 series | 135 - 275 | <28 | - | 215 - 440 | 250 - 500 | .0010 - .0025 | .0025 - .0040 |
| ferritic, martensitic, 400/500 series and PH stainless steels | 135 - 330 | <35 | - | 190 - 375 | 225 - 430 | .0015 - .0030 | .0030 - .0045 |
| aluminum, low silicon and other non-ferrous alloys | 50 -150 | 600 | 2000 | 2400 - 2500 | - | .0020 - .0038 | .0038 - .0077 |
| aluminum, high silicon | | | 600 - 2000 | 720 - 2500 | - | .0018 - .0035 | .0035 - .0071 |

Series **MRS** Rougher • multi-flute • center cutting • square end

Applications |

HARDENED STEEL

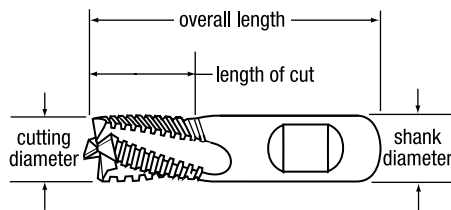


Features |

SOLID CARBIDE

BRIGHT

TiCN



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 | 3 | B03416 | B03816 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | B03216 | B03316 |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 | 4 | B03424 | B03824 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 4 | B03224 | B03324 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 4 | B03432 | B03832 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | B03232 | B03332 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 4 | B03440 | B03840 |
| 5/8 | .6250 | 15.88 | 5/8 | 1-1/4 | 3 1/2 | 4 | B03240 | B03340 |
| 3/4 | .7500 | 19.05 | 3/4 | 7/8 | 3 1/2 | 4 | B03448 | B03848 |
| 3/4 | .7500 | 19.05 | 3/4 | 1-1/2 | 4 | 4 | B03248 | B03348 |
| 1 | 1.0000 | 25.40 | 1 | 1 | 3 1/2 | 5 | B03464 | B03864 |
| 1 | 1.0000 | 25.40 | 1 | 1-1/2 | 4 | 5 | B03264 | B03364 |



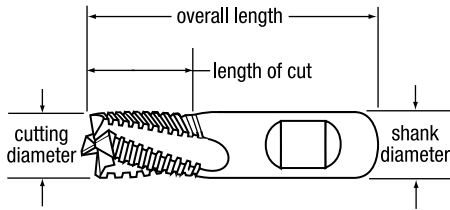
High-Performance Roughers

Series **MRA** Rougher • square end

Applications



Features



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | bright | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|--------|------------|--|
| fractional | decimal | metric | | | | | | TiCN | |
| 1/4 | .2500 | 6.35 | 1/4 | 3/8 | 2 | 3 | B10117 | B03117 | |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | B03016 | B03116 | |
| 3/8 | .3750 | 9.53 | 3/8 | 1/2 | 2 | 3 | B10118 | B03118 | |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | B03024 | B03124 | |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 3 | B10119 | B03119 | |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 3 | B03032 | B03132 | |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 1/2 | 3 | B03532 | B03632 | |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 3 | B10120 | B03120 | |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 3 | B03040 | B03140 | |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/4 | 5 | 3 | B03540 | B03640 | |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 1/2 | 3 | B10121 | B03121 | |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 3 | B03048 | B03148 | |
| 3/4 | .7500 | 19.05 | 3/4 | 2 1/4 | 5 | 3 | B03548 | B03648 | |
| 1 | 1.0000 | 25.40 | 1 | 1 1/8 | 3 1/2 | 3 | B10122 | B03122 | |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 3 | B03064 | B03164 | |
| 1 | 1.0000 | 25.40 | 1 | 2 1/4 | 5 | 3 | B03564 | B03664 | |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

General-Purpose End Mills

Features and Benefits of General-Purpose End Mills

- 10% cobalt submicron grain carbide substrate.
- 30° right-hand spiral, right-hand cut helix designed for maximum chip clearance.
- 2-, 3-, and 4-flute configurations available.
- Square end and ball nose end geometries available.
- Multiple lengths in select styles and sizes.
- TiCN-coated tools available in most styles.

Applications for General-Purpose End Mills

- Use in general milling applications in medium- to low-carbon steels, cast iron, non-ferrous light metals, and plastics.
- Double-end end mills economically increase productivity.
- 2-flute end mills are generally used for plunging, slotting, and heavy peripheral cuts.
- 3-flute end mills provide a compromise between the chip clearance of a 2-flute tool and the rigidity and wear resistance of a 4-flute tool; especially useful for many slotting operations.
- 4-flute end mills are most commonly used in profiling and in harder materials; stiffer construction results in minimal deflection. They also provide good surface finishes and wear-resistant characteristics for excellent size control.

Cutting Data for General-Purpose Solid Carbide End Mills

| Material | Hardness | | Surface Feet per Minute | Chip Load per Tooth | | | | | | | | | | |
|---|----------|-------|-------------------------|---------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | Brinell | HRc | | 1/16" | 1/8" | 3/16" | 1/4" | 5/16" | 3/8" | 1/2" | 5/8" | 3/4" | 1" | |
| low and plain carbon, alloy and tool steels | <220 HB | <19 | Low High | 270 360 | .0004 | .0006 | .0010 | .0015 | .0020 | .0025 | .0030 | .0035 | .0040 | .0045 |
| plain carbon, alloy, and tool steels | 225-286 | 20-30 | Low High | 180 270 | .0004 | .0006 | .0010 | .0015 | .0020 | .0025 | .0030 | .0035 | .0040 | .0045 |
| | 294-371 | 31-40 | Low High | 135 180 | .0003 | .0004 | .0007 | .0011 | .0014 | .0018 | .0021 | .0025 | .0028 | .0032 |
| austenitic stainless steels 200 and 300 series | 135-275 | <28 | Low High | 180 315 | .0002 | .0004 | .0006 | .0010 | .0015 | .0020 | .0025 | .0030 | .0035 | .0040 |
| ductile and malleable cast iron | 120-320 | <35 | Low High | 160 270 | .0003 | .0004 | .0007 | .0011 | .0014 | .0018 | .0021 | .0025 | .0028 | .0032 |
| cast iron (gray) | 120-220 | <18 | Low High | 315 450 | .0008 | .0012 | .0020 | .0030 | .0040 | .0050 | .0060 | .0070 | .0080 | .0090 |
| | 220-320 | 19-34 | Low High | 225 315 | .0005 | .0007 | .0012 | .0018 | .0024 | .0030 | .0036 | .0042 | .0048 | .0055 |
| low-silicon aluminum & other non-ferrous alloys | 50-150 | — | Low High | 720 900 | .0006 | .0010 | .0016 | .0024 | .0032 | .0040 | .0048 | .0560 | .0064 | .0072 |
| cobalt-based high-temperature alloys | 150-425 | <45 | Low High | 30 45 | .0004 | .0006 | .0010 | .0015 | .0020 | .0025 | .0030 | .0035 | .0040 | .0045 |
| | 140-300 | <32 | Low High | 45 90 | .0002 | .0004 | .0006 | .0009 | .0012 | .0015 | .0018 | .0021 | .0024 | .0027 |
| nickel-based high-temperature alloys | 300-475 | 32-50 | Low High | 40 70 | .0002 | .0004 | .0006 | .0009 | .0012 | .0015 | .0018 | .0021 | .0024 | .0027 |

Higher values for surface speed should be used for radial depths of cut less than 25% of the diameter. Lower values for surface speed should be used for radial depths of cut greater than 25% of the diameter. The above recommendations are for axial lengths of cut not to exceed 1 times the cutter diameter for profiling and .5 times the diameter for slotting.

Recommended speeds above are for uncoated tools only and should be adjusted when using coated tools. Generally, speeds can be increased by the following factors:

- TiCN-coated tools – 20-25% increase
- TiAlN-coated tools – 40-50% increase

The above speeds are a recommended starting point only. If the tool is working well, without vibrations or significant noise, increase the SFM in 5-10% increments. Ultimate speeds will depend upon setup conditions. Higher or lower parameters may be required to achieve optimum conditions.



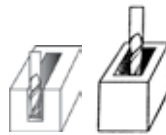
Double End General-Purpose

BASSETT™

Series MDE-2

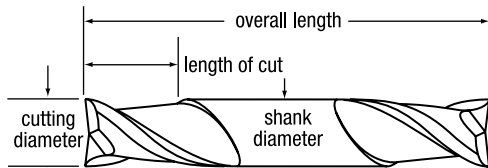
Applications |

STAINLESS STEEL
CAST IRON
NON-FERROUS MATERIALS



Features |

SOLID CARBIDE
BRIGHT
2 FLUTE CC
TiCN



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|---------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 2 | B52801 | B01681 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/16 | 1 1/2 | 2 | B52803 | B01682 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 2 | B52805W | B01683W |
| 1/8 | .1250 | 3.18 | 3/8 | 3/8 | 3 | 2 | B52401 | B01577 |
| 5/32 | .1562 | 3.97 | 3/8 | 5/16 | 3 1/8 | 2 | B52807 | B01684 |
| 5/32 | .1562 | 3.97 | 3/8 | 7/16 | 3 1/8 | 2 | B52403 | B01578 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/8 | 2 | 2 | B52809 | B01685 |
| 3/16 | .1875 | 4.76 | 3/8 | 1/2 | 3 1/4 | 2 | B52405 | B01579 |
| 7/32 | .2188 | 5.56 | 3/8 | 9/16 | 3 1/2 | 2 | B52407 | B01580 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 1/2 | 2 | B52814 | B01687 |
| 1/4 | .2500 | 6.35 | 3/8 | 5/8 | 3 1/2 | 2 | B52410 | B01581 |
| 9/32 | .2812 | 7.14 | 3/8 | 11/16 | 3 1/2 | 2 | B52412 | B01582 |
| 5/16 | .3125 | 7.94 | 3/8 | 3/4 | 3 1/2 | 2 | B52414 | B01583 |
| 3/8 | .3750 | 9.53 | 3/8 | 9/16 | 2 1/2 | 2 | B52818 | B01689 |
| 3/8 | .3750 | 9.53 | 3/8 | 3/4 | 3 1/2 | 2 | B52418 | B01585 |
| 7/16 | .4375 | 11.11 | 1/2 | 7/8 | 4 | 2 | B52420 | B01586 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 3 | 2 | B52823 | B01691 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 4 | 2 | B52423 | B01587 |

Series MDE-2-B

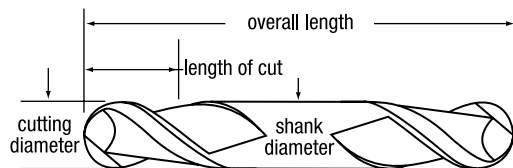
Applications |

CAST IRON
STEEL
NON-FERROUS MATERIALS



Features |

SOLID CARBIDE
2 FLUTE BALL CC
BRIGHT
TiCN



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 2 | B52881 | B01703 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/16 | 1 1/2 | 2 | B52883 | B01704 |
| 1/8 | .1250 | 3.18 | 3/8 | 3/8 | 3 | 2 | B52481 | B01599 |
| 5/32 | .1562 | 3.97 | 3/8 | 7/16 | 3 1/8 | 2 | B52483 | B01600 |
| 3/16 | .1875 | 4.76 | 3/8 | 1/2 | 3 1/4 | 2 | B52485 | B01601 |
| 7/32 | .2188 | 5.56 | 3/8 | 9/16 | 3 1/2 | 2 | B52487 | B01602 |
| 1/4 | .2500 | 6.35 | 3/8 | 5/8 | 3 1/2 | 2 | B52490 | B01603 |
| 9/32 | .2812 | 7.14 | 3/8 | 11/16 | 3 1/2 | 2 | B52492 | B01604 |
| 5/16 | .3125 | 7.94 | 3/8 | 3/4 | 3 1/2 | 2 | B52494 | B01605 |
| 3/8 | .3750 | 9.53 | 3/8 | 3/4 | 3 1/2 | 2 | B52498 | B01607 |
| 7/16 | .4375 | 11.11 | 1/2 | 7/8 | 4 | 2 | B52500 | B01608 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 4 | 2 | B52503 | B01609 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

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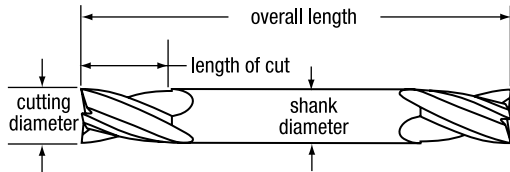
Double End General-Purpose

Series MDE-4

Applications |



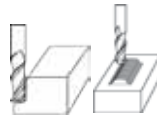
Features |



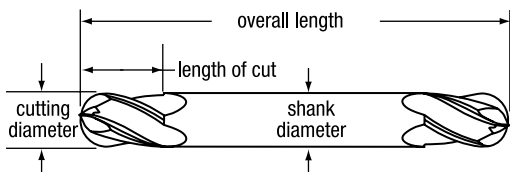
| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|---------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 4 | B52841 | B01692 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/16 | 1 1/2 | 4 | B52843 | B01693 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 4 | B52845W | B01694W |
| 1/8 | .1250 | 3.18 | 3/16 | 1/4 | 2 | 4 | B52845 | B01694 |
| 1/8 | .1250 | 3.18 | 3/8 | 3/8 | 3 | 4 | B52441 | B01588 |
| 5/32 | .1562 | 3.97 | 3/16 | 5/16 | 2 | 4 | B52847 | B01695 |
| 5/32 | .1562 | 3.97 | 3/8 | 7/16 | 3 1/8 | 4 | B52443 | B01589 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/8 | 2 | 4 | B52849 | B01696 |
| 3/16 | .1875 | 4.76 | 3/8 | 1/2 | 3 1/4 | 4 | B52445 | B01590 |
| 7/32 | .2188 | 5.56 | 3/8 | 9/16 | 3 1/2 | 4 | B52447 | B01591 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 1/2 | 4 | B52854 | B01698 |
| 1/4 | .2500 | 6.35 | 3/8 | 5/8 | 3 1/2 | 4 | B52450 | B01592 |
| 9/32 | .2812 | 7.14 | 3/8 | 11/16 | 3 1/2 | 4 | B52452 | B01593 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 1/2 | 4 | B52856 | B01699 |
| 5/16 | .3125 | 7.94 | 3/8 | 3/4 | 3 1/2 | 4 | B52454 | B01594 |
| 3/8 | .3750 | 9.53 | 3/8 | 9/16 | 2 1/2 | 4 | B52858 | B01700 |
| 3/8 | .3750 | 9.53 | 3/8 | 3/4 | 3 1/2 | 4 | B52458 | B01596 |
| 7/16 | .4375 | 11.11 | 1/2 | 7/8 | 4 | 4 | B52460 | B01597 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 3 | 4 | B52863 | B01702 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 4 | 4 | B52463 | B01598 |

Series MDE-4B

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 4 | B52921 | B01714 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/16 | 1 1/2 | 4 | B52923 | B01715 |
| 1/8 | .1250 | 3.18 | 3/8 | 3/8 | 3 | 4 | B52521 | B01610 |
| 5/32 | .1562 | 3.97 | 3/8 | 7/16 | 3 1/8 | 4 | B52523 | B01611 |
| 3/16 | .1875 | 4.76 | 3/8 | 1/2 | 3 1/4 | 4 | B52525 | B01612 |
| 7/32 | .2188 | 5.56 | 3/8 | 9/16 | 3 1/2 | 4 | B52527 | B01613 |
| 1/4 | .2500 | 6.35 | 3/8 | 5/8 | 3 1/2 | 4 | B52530 | B01614 |
| 9/32 | .2812 | 7.14 | 3/8 | 11/16 | 3 1/2 | 4 | B52532 | B01615 |
| 5/16 | .3125 | 7.94 | 3/8 | 3/4 | 3 1/2 | 4 | B52534 | B01616 |
| 3/8 | .3750 | 9.53 | 3/8 | 3/4 | 3 1/2 | 4 | B52538 | B01618 |
| 7/16 | .4375 | 11.11 | 1/2 | 7/8 | 4 | 4 | B52540 | B01619 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 4 | 4 | B52543 | B01620 |



Single End General-Purpose

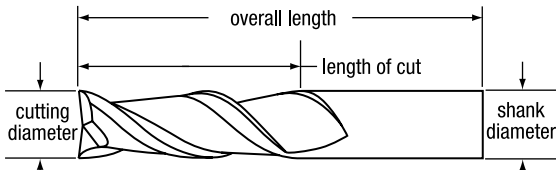
BASSETT™

Series **MSE-2**

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiCN |
| 1/32 | .0312 | 0.79 | 1/8 | 1/8 | 1 1/2 | 2 | | B52601 | B01621 |
| 3/64 | .0469 | 1.19 | 1/8 | 1/8 | 1 1/2 | 2 | | B52602 | B01622 |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 2 | | B52604 | B01623 |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 2 | | B52001 | B01441 |
| 5/64 | .0781 | 1.98 | 1/8 | 3/16 | 1 1/2 | 2 | | B52002 | B01442 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/16 | 1 1/2 | 2 | | B52606 | B01624 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/8 | 1 1/2 | 2 | | B52004 | B01443 |
| 7/64 | .1094 | 2.78 | 1/8 | 3/8 | 1 1/2 | 2 | | B52005 | B01444 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 2 | | B52608 | B01625 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 2 | | B52007 | B01445 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 2 | 0.010 | B52060 | B06800 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/4 | 2 1/4 | 2 | | B51200 | B01329 |
| 1/8 | .1250 | 3.18 | 1/8 | 1 | 3 | 2 | | B51400 | B01318 |
| 9/64 | .1406 | 3.57 | 3/16 | 9/16 | 2 | 2 | | B52008 | B01446 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 2 | | B52010 | B01447 |
| 11/64 | .1719 | 4.37 | 3/16 | 5/8 | 2 | 2 | | B52011 | B01448 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 2 | | B52612 | B01627 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 2 | | B52013 | B01449 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 2 | 0.010 | B52061 | B06801 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/4 | 2 1/2 | 2 | | B51202 | B01330 |
| 3/16 | .1875 | 4.76 | 3/16 | 1 1/8 | 3 | 2 | | B51402 | B01386 |
| 13/64 | .2031 | 5.16 | 1/4 | 5/8 | 2 1/2 | 2 | | B52014 | B01450 |
| 7/32 | .2188 | 5.56 | 1/4 | 5/8 | 2 1/2 | 2 | | B52016 | B01451 |
| 15/64 | .2344 | 5.95 | 1/4 | 3/4 | 2 1/2 | 2 | | B52017 | B01452 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 2 | | B52617 | B01629 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | | B52020 | B01453 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | 0.020 | B52062 | B06802 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | 0.030 | B52063 | B06803 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/8 | 3 | 2 | | B51204 | B01331 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 4 | 2 | | B51404 | B01319 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 6 | 2 | | B51405 | B01388 |
| 17/64 | .2656 | 6.75 | 5/16 | 3/4 | 2 1/2 | 2 | | B52021 | B01454 |
| 9/32 | .2812 | 7.14 | 5/16 | 3/4 | 2 1/2 | 2 | | B52023 | B01455 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 2 | | B52619 | B01630 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | | B52026 | B01457 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | 0.020 | B52065 | B06805 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | 0.030 | B52066 | B06806 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/8 | 3 | 2 | | B51206 | B01333 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 5/8 | 4 | 2 | | B51406 | B01389 |

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CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Single End General-Purpose

Series **MSE-2** (continued)

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiCN |
| 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 2 | | B52621 | B01631 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | | B52032 | B01461 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | 0.020 | B52068 | B06808 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | 0.030 | B52069 | B06809 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | 0.040 | B52070 | B06810 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/8 | 3 | 2 | | B51208 | B01334 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 3/4 | 4 | 2 | | B51408 | B01320 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 6 | 2 | | B51409 | B01391 |
| 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2 1/2 | 2 | | B52623 | B01632 |
| 7/16 | .4375 | 11.11 | 7/16 | 7/8 | 2 1/2 | 2 | | B52038 | B01465 |
| 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 2 | | B51210 | B01321 |
| 7/16 | .4375 | 11.11 | 7/16 | 3 | 6 | 2 | | B51410 | B01322 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 2 | | B52626 | B01633 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | | B52045 | B01469 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | 0.030 | B52072 | B06812 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | 0.050 | B52073 | B06813 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | 0.070 | B52074 | B06814 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 2 | | B51212 | B01338 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/2 | 6 | 2 | | B51411 | B01323 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 6 | 2 | | B51412 | B01394 |
| 9/16 | .5625 | 14.29 | 9/16 | 1 1/4 | 3 | 2 | | B52047 | B01470 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 2 | | B52628 | B01634 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 2 | | B52049 | B01471 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 2 | 0.030 | B52076 | B06816 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 2 | 0.050 | B52077 | B06817 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 2 | 0.070 | B52078 | B06818 |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/4 | 5 | 2 | | B51214 | B01324 |
| 5/8 | .6250 | 15.88 | 5/8 | 3 | 6 | 2 | | B51414 | B01395 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 2 | | B52631 | B01635 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 2 | | B52051 | B01472 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 2 | 0.030 | B52080 | B06820 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 2 | 0.060 | B52081 | B06821 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 2 | 0.090 | B52082 | B06822 |
| 3/4 | .7500 | 19.05 | 3/4 | 2 1/4 | 5 | 2 | | B51216 | B61216 |
| 3/4 | .7500 | 19.05 | 3/4 | 3 | 6 | 2 | | B51416 | B01396 |
| 7/8 | .8750 | 22.23 | 7/8 | 1 1/2 | 4 | 2 | | B52053 | B01473 |
| 7/8 | .8750 | 22.23 | 7/8 | 2 1/4 | 5 | 2 | | B51218 | B01325 |
| 7/8 | .8750 | 22.23 | 7/8 | 3 | 6 | 2 | | B51418 | B01326 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 2 | | B52057 | B01474 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 2 | 0.030 | B52084 | B06824 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 2 | 0.060 | B52085 | B06825 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 2 | 0.090 | B52086 | B06826 |
| 1 | 1.0000 | 25.40 | 1 | 2 1/4 | 5 | 2 | | B51220 | B01327 |
| 1 | 1.0000 | 25.40 | 1 | 3 | 6 | 2 | | B51420 | B01398 |

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Single End General-Purpose

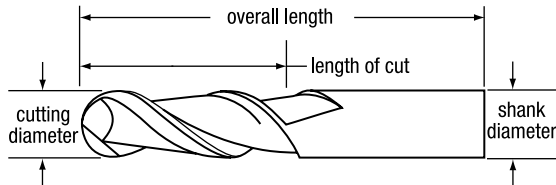
BASSETT™

Series MSE-2B

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/32 | .0312 | 0.79 | 1/8 | 1/8 | 1 1/2 | 2 | B52681 | B01651 |
| 3/64 | .0469 | 1.19 | 1/8 | 1/8 | 1 1/2 | 2 | B52682 | B01652 |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 2 | B52684 | B01653 |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 2 | B52201 | B01509 |
| 5/64 | .0781 | 1.98 | 1/8 | 3/16 | 1 1/2 | 2 | B52202 | B01564 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/8 | 1 1/2 | 2 | B52204 | B01511 |
| 7/64 | .1094 | 2.78 | 1/8 | 3/8 | 1 1/2 | 2 | B52205 | B01512 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 2 | B52688 | B01655 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 2 | B52207 | B01513 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/4 | 2 1/4 | 2 | B51300 | B01360 |
| 1/8 | .1250 | 3.18 | 1/8 | 1 | 3 | 2 | B51500 | B01414 |
| 9/64 | .1406 | 3.57 | 3/16 | 9/16 | 2 | 2 | B52208 | B01566 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 2 | B52210 | B01515 |
| 11/64 | .1719 | 4.37 | 3/16 | 5/8 | 2 | 2 | B52211 | B01516 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 2 | B52612 | B01657 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 2 | B52213 | B01517 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/4 | 2 1/2 | 2 | B51302 | B01363 |
| 3/16 | .1875 | 4.76 | 3/16 | 1 1/8 | 3 | 2 | B51502 | B01415 |
| 13/64 | .2031 | 5.16 | 1/4 | 5/8 | 2 1/2 | 2 | B52214 | B01364 |
| 7/32 | .2188 | 5.56 | 1/4 | 5/8 | 2 1/2 | 2 | B52216 | B01568 |
| 15/64 | .2344 | 5.95 | 1/4 | 3/4 | 2 1/2 | 2 | B52217 | B01570 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 2 | B52697 | B01659 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | B52220 | B01521 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/8 | 3 | 2 | B51304 | B01359 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 4 | 2 | B51504 | B01427 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 6 | 2 | B51505 | B01416 |
| 17/64 | .2656 | 6.75 | 5/16 | 3/4 | 2 1/2 | 2 | B52221 | B01572 |
| 9/32 | .2812 | 7.14 | 5/16 | 3/4 | 2 1/2 | 2 | B52223 | B01575 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 2 | B52699 | B01660 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | B52226 | B01525 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/8 | 3 | 2 | B51306 | B01361 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 5/8 | 4 | 2 | B51506 | B01417 |
| 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 2 | B52701 | B01661 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 2 | B52232 | B01529 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/8 | 3 | 2 | B51308 | B01362 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 3/4 | 4 | 2 | B51508 | B01418 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 6 | 2 | B51509 | B01419 |

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CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

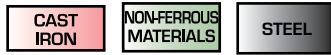
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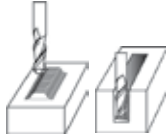
Single End General-Purpose

Series **MSE-2B** (continued)

Applications |



Features |



| fractional | cutting diameter | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------|------------------|--------|----------------|---------------|----------------|---------------|------------|--------|
| | decimal | metric | | | | | bright | TiCN |
| 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2 1/2 | 2 | B52703 | B01662 |
| 7/16 | .4375 | 11.11 | 7/16 | 7/8 | 2 1/2 | 2 | B52238 | B01584 |
| 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 2 | B51310 | B01365 |
| 7/16 | .4375 | 11.11 | 7/16 | 3 | 6 | 2 | B51510 | B01420 |
| 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 2 | B52706 | B01663 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | B52245 | B01537 |
| 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 2 | B51312 | B01367 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 6 | 2 | B51512 | B01422 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 1/2 | 6 | 2 | B51511 | B01366 |
| 9/16 | .5625 | 14.29 | 9/16 | 1 1/4 | 3 | 2 | B52247 | B01617 |
| 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 2 | B52708 | B01664 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 2 | B52249 | B01539 |
| 5/8 | .6250 | 15.88 | 5/8 | 2 1/4 | 5 | 2 | B51314 | B01368 |
| 5/8 | .6250 | 15.88 | 5/8 | 3 | 6 | 2 | B51514 | B01423 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 2 | B52711 | B01665 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 2 | B52251 | B01540 |
| 3/4 | .7500 | 19.05 | 3/4 | 2 1/4 | 5 | 2 | B51316 | B01369 |
| 3/4 | .7500 | 19.05 | 3/4 | 3 | 6 | 2 | B51516 | B01424 |
| 7/8 | .8750 | 22.23 | 7/8 | 1 1/2 | 4 | 2 | B52253 | B01595 |
| 7/8 | .8750 | 22.23 | 7/8 | 2 1/4 | 5 | 2 | B51318 | B01370 |
| 7/8 | .8750 | 22.23 | 7/8 | 3 | 6 | 2 | B51518 | B01425 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 2 | B52257 | B01542 |
| 1 | 1.0000 | 25.40 | 1 | 2 1/4 | 5 | 2 | B51320 | B01371 |
| 1 | 1.0000 | 25.40 | 1 | 3 | 6 | 2 | B51520 | B01426 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

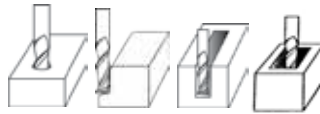
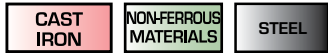
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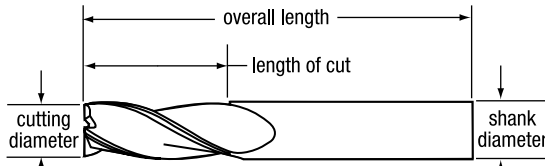
Single End General-Purpose

Series MSE-3

Applications



Features



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiCN |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 3 | | B27104 | B37104 |
| 5/64 | .0781 | 1.98 | 1/8 | 3/16 | 1 1/2 | 3 | | B27105 | B37105 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/8 | 1 1/2 | 3 | | B27106 | B37106 |
| 7/64 | .1094 | 2.78 | 1/8 | 3/8 | 1 1/2 | 3 | | B27107 | B37107 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 3 | | B27108 | B37108 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 3 | 0.010 | B27200 | B37200 |
| 9/64 | .1406 | 3.57 | 3/16 | 9/16 | 2 | 3 | | B27109 | B37109 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 3 | | B27110 | B37110 |
| 11/64 | .1719 | 4.37 | 3/16 | 5/8 | 2 | 3 | | B27111 | B37111 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 3 | | B27112 | B37112 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 3 | 0.010 | B27201 | B37201 |
| 13/64 | .2031 | 5.16 | 1/4 | 5/8 | 2 1/2 | 3 | | B27113 | B37113 |
| 7/32 | .2188 | 5.56 | 1/4 | 5/8 | 2 1/2 | 3 | | B27114 | B37114 |
| 15/64 | .2344 | 5.95 | 1/4 | 3/4 | 2 1/2 | 3 | | B27115 | B37115 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | | B27116 | B11971 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | 0.020 | B27202 | B37202 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 3 | 0.030 | B27203 | B37203 |
| 17/64 | .2656 | 6.75 | 5/16 | 3/4 | 2 1/2 | 3 | | B27117 | B37117 |
| 9/32 | .2812 | 7.14 | 5/16 | 3/4 | 2 1/2 | 3 | | B27118 | B37118 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 3 | | B27120 | B11972 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 3 | 0.020 | B27205 | B37205 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 3 | 0.030 | B27206 | B37206 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | | B27124 | B11973 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | 0.020 | B27208 | B37208 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | 0.030 | B27209 | B37209 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 3 | 0.040 | B27210 | B37210 |
| 7/16 | .4375 | 11.11 | 7/16 | 7/8 | 2 1/2 | 3 | | B27128 | B11974 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 3 | | B27132 | B11975 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 3 | 0.030 | B27212 | B37212 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 3 | 0.060 | B27213 | B37213 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 3 | 0.090 | B27214 | B37214 |
| 9/16 | .5625 | 14.29 | 9/16 | 1 1/4 | 3 | 3 | | B27136 | B37136 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 3 | | B27140 | B11976 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 3 | 0.030 | B27216 | B37216 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 3 | 0.060 | B27217 | B37217 |
| 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 3 | 0.090 | B27218 | B37218 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 3 | | B27148 | B11977 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 3 | 0.030 | B27220 | B37220 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 3 | 0.060 | B27221 | B37221 |
| 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 3 | 0.090 | B27222 | B37222 |
| 7/8 | .8750 | 22.23 | 7/8 | 1 1/2 | 4 | 3 | | B27156 | B11986 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 3 | | B27164 | B11978 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 3 | 0.030 | B27224 | B37224 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 3 | 0.060 | B27225 | B37225 |
| 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 3 | 0.090 | B27226 | B37226 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

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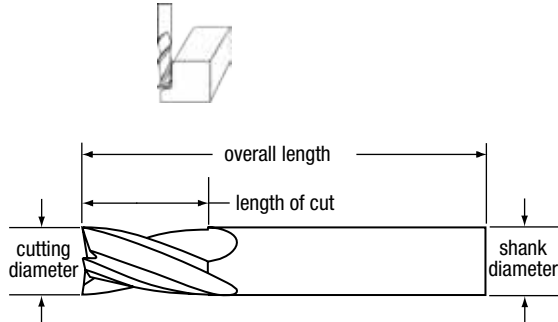
Single End General-Purpose

Series MSE-4

Applications



Features



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | | bright | TiCN |
| 1/32 | .0312 | 0.79 | 1/8 | 1/8 | 1 1/2 | 4 | | B52641 | B01636 |
| 3/64 | .0469 | 1.19 | 1/8 | 1/8 | 1 1/2 | 4 | | B52642 | B01637 |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 4 | | B52644 | B01638 |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 4 | | B52101 | B01475 |
| 5/64 | .0781 | 1.98 | 1/8 | 3/16 | 1 1/2 | 4 | | B52102 | B01476 |
| 3/32 | .0938 | 2.38 | 3/16 | 3/16 | 1 1/2 | 4 | | B52646 | B01639 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/8 | 1 1/2 | 4 | | B52104 | B01477 |
| 7/64 | .1094 | 2.78 | 1/8 | 3/8 | 1 1/2 | 4 | | B52105 | B01478 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 4 | | B52648 | B01640 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 4 | | B52107 | B01479 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 4 | 0.010 | B52160 | B01750 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/4 | 2 1/4 | 4 | | B51250 | B01343 |
| 1/8 | .1250 | 3.18 | 1/8 | 1 | 3 | 4 | | B51450 | B01399 |
| 9/64 | .1406 | 3.57 | 3/16 | 9/16 | 2 | 4 | | B52108 | B01480 |
| 5/32 | .1562 | 3.97 | 3/16 | 5/16 | 2 | 4 | | B52650 | B01641 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 4 | | B52110 | B01481 |
| 11/64 | .1719 | 4.37 | 3/16 | 5/8 | 2 | 4 | | B52111 | B01482 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/4 | 2 1/2 | 4 | | B51252 | B01344 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 4 | | B52113 | B01483 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 4 | 0.010 | B52162 | B01751 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 4 | | B52652 | B01642 |
| 3/16 | .1875 | 4.76 | 3/16 | 1 1/8 | 3 | 4 | | B51452 | B01400 |
| 13/64 | .2031 | 5.16 | 1/4 | 5/8 | 2 1/2 | 4 | | B52114 | B01484 |
| 7/32 | .2188 | 5.56 | 1/4 | 5/8 | 2 1/2 | 4 | | B52116 | B01485 |
| 15/64 | .2344 | 5.95 | 1/4 | 3/4 | 2 1/2 | 4 | | B52117 | B01486 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 4 | | B52657 | B01644 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 4 | | B52120 | B01487 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 4 | 0.020 | B52164 | B01752 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 4 | 0.030 | B52165 | B01753 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/8 | 3 | 4 | | B51254 | B01340 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 4 | 4 | | B51454 | B01732 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 6 | 4 | | B51455 | B01402 |
| 17/64 | .2656 | 6.75 | 5/16 | 3/4 | 2 1/2 | 4 | | B52121 | B01730 |
| 9/32 | .2812 | 7.14 | 5/16 | 3/4 | 2 1/2 | 4 | | B52123 | B01489 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 4 | | B52659 | B01645 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 4 | | B52126 | B01491 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 4 | 0.020 | B52167 | B01755 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 4 | 0.030 | B52168 | B01756 |

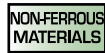
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Single End General-Purpose

Series **MSE-4** (continued)

Applications



Features



| | cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | corner radius | EDP number | |
|--|------------------|---------|--------|----------------|---------------|----------------|---------------|---------------|------------|--------|
| | fractional | decimal | metric | | | | | | bright | TiCN |
| | 5/16 | .3125 | 7.94 | 5/16 | 1 1/8 | 3 | 4 | | B51256 | B01347 |
| | 5/16 | .3125 | 7.94 | 5/16 | 1 5/8 | 4 | 4 | | B51456 | B01403 |
| | 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 4 | | B52661 | B01646 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 4 | | B52132 | B01495 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 4 | 0.020 | B52170 | B01758 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 4 | 0.030 | B52171 | B01759 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 4 | 0.040 | B52172 | B01760 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 1/8 | 3 | 4 | | B51258 | B01348 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 3/4 | 4 | 4 | | B51458 | B01733 |
| | 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 6 | 4 | | B51459 | B01405 |
| | 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2 1/2 | 4 | | B52663 | B01647 |
| | 7/16 | .4375 | 11.11 | 7/16 | 1 | 2 1/2 | 4 | | B52138 | B01499 |
| | 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 4 | | B51260 | B01341 |
| | 7/16 | .4375 | 11.11 | 7/16 | 3 | 6 | 4 | | B51460 | B01734 |
| | 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 4 | | B52666 | B01648 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | | B52145 | B01503 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | 0.030 | B52173 | B01762 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | 0.060 | B52174 | B01763 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | 0.090 | B52175 | B01764 |
| | 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 4 | | B51262 | B01352 |
| | 1/2 | .5000 | 12.70 | 1/2 | 3 | 6 | 4 | | B51462 | B01408 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 1/2 | 6 | 4 | | B51461 | B01407 |
| | 9/16 | .5625 | 14.29 | 9/16 | 1 1/4 | 3 | 4 | | B52147 | B01765 |
| | 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 4 | | B52668 | B01649 |
| | 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 4 | | B52149 | B01505 |
| | 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 4 | 0.030 | B52176 | B01766 |
| | 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 4 | 0.060 | B52177 | B01767 |
| | 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 4 | 0.090 | B52178 | B01768 |
| | 5/8 | .6250 | 15.88 | 5/8 | 2 1/4 | 5 | 4 | | B51264 | B01342 |
| | 5/8 | .6250 | 15.88 | 5/8 | 3 | 6 | 4 | | B51464 | B01409 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 4 | | B52671 | B01650 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 4 | | B52151 | B01506 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 4 | 0.030 | B52179 | B01770 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 4 | 0.060 | B52180 | B01771 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 4 | 0.090 | B52181 | B01772 |
| | 3/4 | .7500 | 19.05 | 3/4 | 2 1/4 | 5 | 4 | | B51266 | B01351 |
| | 3/4 | .7500 | 19.05 | 3/4 | 3 | 6 | 4 | | B51466 | B01410 |
| | 7/8 | .8750 | 22.23 | 7/8 | 1 1/2 | 4 | 4 | | B52153 | B01507 |
| | 7/8 | .8750 | 22.23 | 7/8 | 2 1/4 | 5 | 4 | | B51268 | B01355 |
| | 7/8 | .8750 | 22.23 | 7/8 | 3 | 6 | 4 | | B51468 | B01735 |
| | 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 4 | | B52157 | B01508 |
| | 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 4 | 0.030 | B52182 | B01774 |
| | 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 4 | 0.060 | B52183 | B01775 |
| | 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 4 | 0.090 | B52184 | B01776 |
| | 1 | 1.0000 | 25.40 | 1 | 2 1/4 | 5 | 4 | | B51270 | B01356 |
| | 1 | 1.0000 | 25.40 | 1 | 3 | 6 | 4 | | B51470 | B01412 |

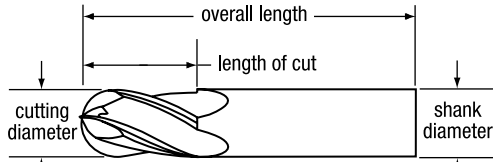
Single End General-Purpose

Series MSE-4B

Applications |



Features |



| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| fractional | decimal | metric | | | | | bright | TiCN |
| 1/32 | .0312 | 0.79 | 1/8 | 1/8 | 1 1/2 | 4 | B52721 | B01434 |
| 3/64 | .0469 | 1.19 | 1/8 | 1/8 | 1 1/2 | 4 | B52722 | B01435 |
| 1/16 | .0625 | 1.59 | 1/8 | 1/8 | 1 1/2 | 4 | B52724 | B01668 |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 4 | B52301 | B01901 |
| 5/64 | .0781 | 1.98 | 1/8 | 3/16 | 1 1/2 | 4 | B52302 | B01902 |
| 3/32 | .0938 | 2.38 | 1/8 | 3/8 | 1 1/2 | 4 | B52304 | B01904 |
| 7/64 | .1094 | 2.78 | 1/8 | 3/8 | 1 1/2 | 4 | B52305 | B01905 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/4 | 1 1/2 | 4 | B52728 | B01670 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 4 | B52307 | B01547 |
| 1/8 | .1250 | 3.18 | 1/8 | 3/4 | 2 1/4 | 4 | B51350 | B01374 |
| 1/8 | .1250 | 3.18 | 1/8 | 1 | 3 | 4 | B51550 | B01850 |
| 9/64 | .1406 | 3.57 | 3/16 | 9/16 | 2 | 4 | B52308 | B01908 |
| 5/32 | .1562 | 3.97 | 3/16 | 9/16 | 2 | 4 | B52310 | B01549 |
| 11/64 | .1719 | 4.37 | 3/16 | 5/8 | 2 | 4 | B52311 | B01911 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/16 | 2 | 4 | B52732 | B01672 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 4 | B52313 | B01551 |
| 3/16 | .1875 | 4.76 | 3/16 | 3/4 | 2 1/2 | 4 | B51352 | B01377 |
| 3/16 | .1875 | 4.76 | 3/16 | 1 1/8 | 3 | 4 | B51552 | B01852 |
| 13/64 | .2031 | 5.16 | 1/4 | 5/8 | 2 1/2 | 4 | B52314 | B01914 |
| 7/32 | .2188 | 5.56 | 1/4 | 5/8 | 2 1/2 | 4 | B52316 | B01553 |
| 15/64 | .2344 | 5.95 | 1/4 | 3/4 | 2 1/2 | 4 | B52317 | B01917 |
| 1/4 | .2500 | 6.35 | 1/4 | 1/2 | 2 | 4 | B52737 | B01674 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 4 | B52320 | B01555 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/8 | 3 | 4 | B51354 | B01373 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 4 | 4 | B51554 | B01854 |
| 1/4 | .2500 | 6.35 | 1/4 | 1 1/2 | 6 | 4 | B51555 | B01430 |
| 17/64 | .2656 | 6.75 | 5/16 | 3/4 | 2 1/2 | 4 | B52321 | B01921 |
| 9/32 | .2812 | 7.14 | 5/16 | 3/4 | 2 1/2 | 4 | B52323 | B01557 |
| 5/16 | .3125 | 7.94 | 5/16 | 1/2 | 2 | 4 | B52739 | B01675 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 4 | B52326 | B01559 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 1/8 | 3 | 4 | B51356 | B01375 |
| 5/16 | .3125 | 7.94 | 5/16 | 1 5/8 | 4 | 4 | B51556 | B01856 |
| 3/8 | .3750 | 9.53 | 3/8 | 5/8 | 2 | 4 | B52741 | B01676 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 | 2 1/2 | 4 | B52332 | B01563 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/8 | 3 | 4 | B51358 | B01376 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 1/2 | 6 | 4 | B51559 | B01433 |
| 3/8 | .3750 | 9.53 | 3/8 | 1 3/4 | 4 | 4 | B51558 | B01858 |

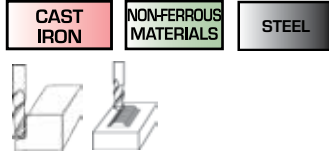
continued on next page



Single End General-Purpose

Series **MSE-4B** (continued)

Applications |



Features |



CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

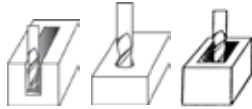
INDEX

| | cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number | |
|--|------------------|---------|--------|----------------|---------------|----------------|---------------|------------|--------|
| | fractional | decimal | metric | | | | | bright | TiCN |
| | 7/16 | .4375 | 11.11 | 7/16 | 5/8 | 2 1/2 | 4 | B52743 | B01439 |
| | 7/16 | .4375 | 11.11 | 7/16 | 1 | 2 1/2 | 4 | B52338 | B01567 |
| | 7/16 | .4375 | 11.11 | 7/16 | 2 | 4 | 4 | B51360 | B01378 |
| | 7/16 | .4375 | 11.11 | 7/16 | 3 | 6 | 4 | B51560 | B01860 |
| | 1/2 | .5000 | 12.70 | 1/2 | 5/8 | 2 1/2 | 4 | B52746 | B01678 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 4 | B52345 | B01571 |
| | 1/2 | .5000 | 12.70 | 1/2 | 2 | 4 | 4 | B51362 | B01380 |
| | 1/2 | .5000 | 12.70 | 1/2 | 1 1/2 | 6 | 4 | B51561 | B01431 |
| | 1/2 | .5000 | 12.70 | 1/2 | 3 | 6 | 4 | B51562 | B01436 |
| | 9/16 | .5625 | 14.29 | 9/16 | 1 1/4 | 3 | 4 | B52347 | B01947 |
| | 5/8 | .6250 | 15.88 | 5/8 | 3/4 | 3 | 4 | B52748 | B01679 |
| | 5/8 | .6250 | 15.88 | 5/8 | 1 1/4 | 3 1/2 | 4 | B52349 | B01573 |
| | 5/8 | .6250 | 15.88 | 5/8 | 2 1/4 | 5 | 4 | B51364 | B01379 |
| | 5/8 | .6250 | 15.88 | 5/8 | 3 | 6 | 4 | B51564 | B01437 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 | 3 | 4 | B52751 | B01680 |
| | 3/4 | .7500 | 19.05 | 3/4 | 1 1/2 | 4 | 4 | B52351 | B01574 |
| | 3/4 | .7500 | 19.05 | 3/4 | 2 1/4 | 5 | 4 | B51366 | B01381 |
| | 3/4 | .7500 | 19.05 | 3/4 | 3 | 6 | 4 | B51566 | B01438 |
| | 7/8 | .8750 | 22.23 | 7/8 | 1 1/2 | 4 | 4 | B52353 | B01953 |
| | 7/8 | .8750 | 22.23 | 7/8 | 2 1/4 | 5 | 4 | B51368 | B01382 |
| | 7/8 | .8750 | 22.23 | 7/8 | 3 | 6 | 4 | B51568 | B01868 |
| | 1 | 1.0000 | 25.40 | 1 | 1 1/2 | 4 | 4 | B52357 | B01576 |
| | 1 | 1.0000 | 25.40 | 1 | 2 1/4 | 5 | 4 | B51370 | B01383 |
| | 1 | 1.0000 | 25.40 | 1 | 3 | 6 | 4 | B51570 | B01440 |

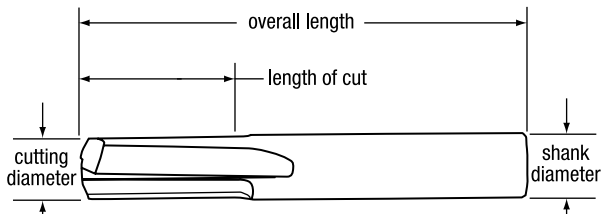
Single End General-Purpose

Series **MSEST-2** • straight flutes

Applications | **CAST IRON** **NON-FERROUS MATERIALS** **STEEL**



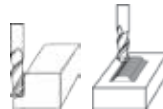
Features | **SOLID CARBIDE** **2 FLUTE CC** **BRIGHT**



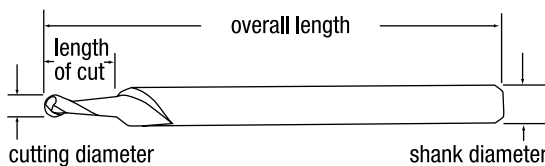
| cutting diameter | | | shank diameter | length of cut | overall length | no. of flutes | EDP number bright |
|------------------|---------|--------|----------------|---------------|----------------|---------------|-------------------|
| fractional | decimal | metric | | | | | |
| 1/16 | .0625 | 1.59 | 1/8 | 3/16 | 1 1/2 | 2 | B53201 |
| 1/8 | .1250 | 3.18 | 1/8 | 1/2 | 1 1/2 | 2 | B53203 |
| 3/16 | .1875 | 4.76 | 3/16 | 5/8 | 2 | 2 | B53205 |
| 1/4 | .2500 | 6.35 | 1/4 | 3/4 | 2 1/2 | 2 | B53207 |
| 5/16 | .3125 | 7.94 | 5/16 | 13/16 | 2 1/2 | 2 | B53210 |
| 3/8 | .3750 | 9.53 | 3/8 | 7/8 | 2 1/2 | 2 | B53212 |
| 1/2 | .5000 | 12.70 | 1/2 | 1 | 3 | 2 | B53215 |

Series **MEG-2 Engraving Tool**

Applications | **CAST IRON** **NON-FERROUS MATERIALS** **STEEL**



Features | **SOLID CARBIDE** **2 FLUTE BALL CC** **TiCN**



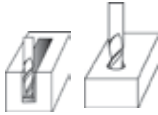
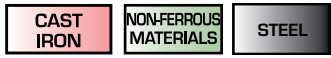
| cutting diameter | | shank diameter | length of cut | overall length | no. of flutes | EDP number TiCN |
|------------------|--------|----------------|---------------|----------------|---------------|-----------------|
| decimal | metric | | | | | |
| .021 | 0.53 | 1/8 | .040 | 1 1/2 | 2 | B10901 |
| .025 | 0.64 | 1/8 | .040 | 1 1/2 | 2 | B10903 |
| .030 | 0.76 | 1/8 | .040 | 1 1/2 | 2 | B10906 |



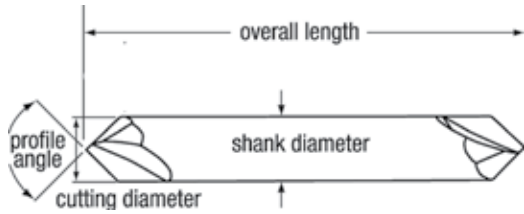
Chamfer Tools

Series **MCH-2R Single End and MCH-2D Double End Chamfer Tool** • 60°, 82°, 90°, and 120° point

Applications



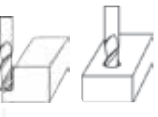
Features



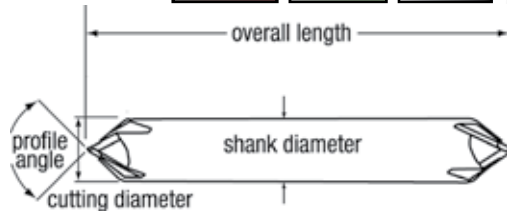
| cutting diameter | | | shank diameter | overall length | no. of flutes | profile angle (°) | EDP number | |
|------------------|---------|--------|----------------|----------------|---------------|-------------------|------------|------------|
| fractional | decimal | metric | | | | | single end | double end |
| 1/8 | .1250 | 3.18 | 1/8 | 1 1/2 | 2 | 82 | B10013 | |
| 1/8 | .1250 | 3.18 | 1/8 | 1 1/2 | 2 | 90 | B10014 | B10026 |
| 3/16 | .1875 | 4.76 | 3/16 | 2 | 2 | 90 | B10016 | B10027 |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 2 | 60 | B10017 | |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 2 | 82 | B10018 | |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 2 | 90 | B10019 | B10028 |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 2 | 60 | B10020 | |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 2 | 82 | B10021 | |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 2 | 90 | B10022 | B10029 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 2 | 60 | B10023 | |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 2 | 82 | B10024 | |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 2 | 90 | B10025 | B10030 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 2 | 120 | B10232 | |
| 3/4 | .7500 | 19.05 | 3/4 | 4 | 2 | 90 | B10233 | B10231 |

Series **MCH-4R Single End and MCH-2D Double End Chamfer Tool** • 60°, 82°, 90°, and 120° point

Applications



Features



| cutting diameter | | | shank diameter | overall length | no. of flutes | profile angle (°) | EDP number | |
|------------------|---------|--------|----------------|----------------|---------------|-------------------|------------|------------|
| fractional | decimal | metric | | | | | single end | double end |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 4 | 60 | B10219 | |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 4 | 82 | B10220 | |
| 1/4 | .2500 | 6.35 | 1/4 | 2 1/2 | 4 | 90 | B10221 | B10228 |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 4 | 60 | B10222 | |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 4 | 82 | B10223 | |
| 3/8 | .3750 | 9.53 | 3/8 | 2 1/2 | 4 | 90 | B10224 | B10229 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 4 | 60 | B10225 | |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 4 | 82 | B10226 | |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 4 | 90 | B10227 | B10230 |
| 1/2 | .5000 | 12.70 | 1/2 | 3 | 4 | 120 | B10235 | |
| 3/4 | .7500 | 19.05 | 3/4 | 4 | 4 | 90 | B10236 | B10234 |



Carbide Drills



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CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

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Feeds and Speeds for Bassett General Purpose Solid Carbide Drills

| Material Group | Recommended Speed (SFM) | Feed (IPR) | | | |
|-----------------------------------|----------------------------|------------|---------|---------|--------|
| | | 1/16-in. | 1/8-in. | 1/4-in. | 1/2-in |
| Low Carbon Steels, Annealed | 85-150 | .0005 | .0010 | .0020 | .0040 |
| Medium Carbon Steels 275-425 BHn | 65-120 | .0005 | .0010 | .0020 | .0030 |
| Stainless Steel, Soft 135-275 BHn | 50-150 | .0005 | .0005 | .0020 | .0040 |
| Stainless Steel, Hard 275-425 BHn | 30-90 | .0005 | .0005 | .0010 | .0015 |
| Cast Iron, Soft 120-220 BHn | 100-300 | .0010 | .0020 | .0040 | .0050 |
| Cast Iron, Hard 220-320 BHn | 60-200 | .0015 | .0010 | .0020 | .0030 |
| Ductile Iron | 70-250 | .0010 | .0020 | .0030 | .0050 |
| Malleable iron | 80-250 | .0010 | .0020 | .0030 | .0050 |
| Aluminum / Aluminum Alloys | 150-400 | .0010 | .0020 | .0030 | .0050 |
| Brass / Bronze | 100-300 | .0005 | .0010 | .0020 | .0040 |
| Copper / Copper Alloys | 150-400 | .0010 | .0030 | .0050 | .0060 |
| Magnesium / Magnesium Alloys | 200-650 | .0015 | .0030 | .0050 | .0080 |
| Plastics - Glass Filled | 150-300 | .0010 | .0020 | .0030 | .0050 |
| Plastics | 250-600 | .0015 | .0030 | .0040 | .0060 |

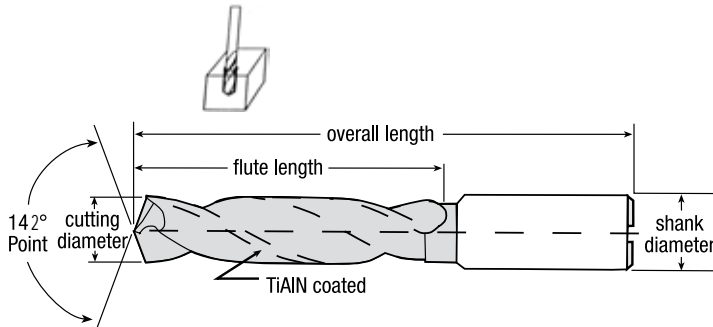
High-Performance

Series DHP-5 High-Performance Jobber Length Drill

Applications



Features



| fraction | cutting diameter | | | shank diameter | | flute length | | overall length | | EDP number |
|----------|------------------|-----------|----------|----------------|--------|--------------|------|----------------|-------|------------|
| | metric | dec equiv | mm equiv | inch | metric | inch | mm | inch | mm | |
| | 3.0 | .1181 | | .118 | 3.0 | .94 | 24.0 | 2.48 | 63.0 | B56000 |
| | 3.3 | .1299 | | .157 | 4.0 | 1.26 | 32.0 | 2.72 | 69.0 | B56006 |
| | 3.8 | .1496 | | .157 | 4.0 | 1.26 | 32.0 | 2.72 | 69.0 | B56017 |
| | 4.2 | .1654 | | .197 | 5.0 | 1.50 | 38.0 | 3.15 | 80.0 | B56027 |
| | 5.0 | .1969 | | .197 | 5.0 | 1.50 | 38.0 | 3.15 | 80.0 | B56046 |
| | 5.5 | .2165 | | .236 | 6.0 | 1.57 | 40.0 | 3.23 | 82.0 | B56058 |
| | 6.0 | .2362 | | .236 | 6.0 | 1.57 | 40.0 | 3.23 | 82.0 | B56068 |
| 1/4 | | .2500 | 6.4 | .250 | 6.4 | 2.00 | 50.8 | 3.75 | 95.3 | B56075 |
| | 6.5 | .2559 | | .315 | 8.0 | 1.89 | 48.0 | 3.58 | 91.0 | B56077 |
| | 6.8 | .2677 | | .315 | 8.0 | 1.89 | 48.0 | 3.58 | 91.0 | B56084 |
| | 7.0 | .2756 | | .315 | 8.0 | 1.89 | 48.0 | 3.58 | 91.0 | B56087 |
| 9/32 | | .2813 | 7.1 | .438 | 11.1 | 2.00 | 50.8 | 3.75 | 95.3 | B56091 |
| 19/64 | | .2969 | 7.5 | .438 | 11.1 | 2.00 | 50.8 | 3.75 | 95.3 | B56098 |
| 5/16 | | .3125 | 7.9 | .438 | 11.1 | 2.00 | 50.8 | 3.75 | 95.3 | B56104 |
| | 8.0 | .3150 | | .315 | 8.0 | 1.89 | 48.0 | 3.58 | 91.0 | B56105 |
| 21/64 | | .3281 | 8.3 | .375 | 9.5 | 2.00 | 50.8 | 4.00 | 101.6 | B56111 |
| | 8.5 | .3346 | | .394 | 10.0 | 2.17 | 55.0 | 4.06 | 103.0 | B56115 |
| | 9.0 | .3543 | | .394 | 10.0 | 2.17 | 55.0 | 4.06 | 103.0 | B56123 |
| 23/64 | | .3594 | 9.1 | .375 | 9.5 | 2.00 | 50.8 | 4.00 | 101.6 | B56126 |
| 3/8 | | .3750 | 9.5 | .375 | 9.5 | 2.00 | 50.8 | 4.00 | 101.6 | B56132 |
| 25/64 | | .3906 | 9.9 | .375 | 9.5 | 2.00 | 50.8 | 4.00 | 101.6 | B56139 |
| | 10.0 | .3937 | | .394 | 10.0 | 2.17 | 55.0 | 4.06 | 103.0 | B56140 |
| 13/32 | | .4063 | 10.3 | .500 | 12.7 | 2.50 | 63.5 | 4.75 | 120.7 | B56144 |
| | 10.5 | .4134 | | .472 | 12.0 | 2.36 | 60.0 | 4.72 | 120.0 | B56146 |
| | 11.0 | .4331 | | .472 | 12.0 | 2.36 | 60.0 | 4.72 | 120.0 | B56149 |
| 7/16 | | .4375 | 11.1 | .500 | 12.7 | 2.50 | 63.5 | 4.75 | 120.7 | B56150 |
| 29/64 | | .4531 | 11.5 | .500 | 12.7 | 2.50 | 63.5 | 4.75 | 120.7 | B56153 |
| 15/32 | | .4688 | 11.9 | .500 | 12.7 | 2.50 | 63.5 | 4.75 | 120.7 | B56155 |
| | 12.0 | .4724 | | .472 | 12.0 | 2.60 | 66.0 | 4.72 | 120.0 | B56156 |
| 31/64 | | .4844 | 12.3 | .500 | 12.7 | 3.00 | 76.2 | 5.00 | 127.0 | B56158 |
| | 12.5 | .4921 | | .551 | 14.0 | 2.83 | 72.0 | 4.96 | 126.0 | B56159 |
| 1/2 | | .5000 | 12.7 | .500 | 12.7 | 3.00 | 76.2 | 5.00 | 127.0 | B56160 |

TOLERANCE - Drill Diameter: h6; Shank Diameter: h7



High-Performance

BASSETT™

Series DHPCF-5 High-Performance Coolant Fed Jobber Length Drill

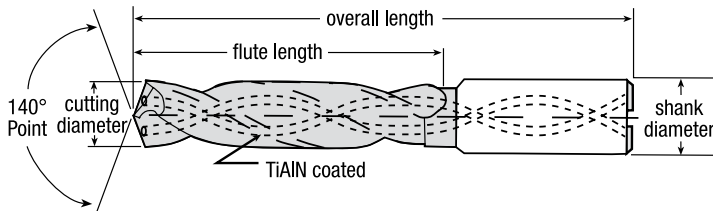
Applications

- STAINLESS STEEL
- ALLOY-HARD STEEL
- CARBON STEEL
- HARDENED STEEL



Features

- SUB-MICRON CARBIDE SUBSTRATE
- 140°
- 5 X DIA DEPTH
- TiAlN
- h6 SHANK TOLERANCE
- h7 CUTTING TOLERANCE



| | cutting diameter | | | shank diameter | | flute length | | overall length | | EDP number | |
|-------|------------------|--------|-----------|----------------|------|--------------|-------|----------------|-------|------------|--------|
| | fraction | metric | dec equiv | mm equiv | inch | metric | inch | mm | inch | | mm |
| | | 3.0 | .1181 | | .236 | 6.0 | 1.102 | 28.0 | 2.598 | 66.0 | B54300 |
| | | 3.3 | .1299 | | .236 | 6.0 | 1.102 | 28.0 | 2.598 | 66.0 | B54306 |
| | | 3.8 | .1496 | | .236 | 6.0 | 1.417 | 36.0 | 2.913 | 74.0 | B54317 |
| | | 4.2 | .1654 | | .236 | 6.0 | 1.417 | 36.0 | 2.913 | 74.0 | B54327 |
| | | 5.0 | .1969 | | .236 | 6.0 | 1.732 | 44.0 | 3.228 | 82.0 | B54346 |
| | | 5.5 | .2165 | | .236 | 6.0 | 1.732 | 44.0 | 3.228 | 82.0 | B54358 |
| | | 6.0 | .2362 | | .236 | 6.0 | 1.732 | 44.0 | 3.228 | 82.0 | B54368 |
| 1/4 | | 6.4 | .2500 | 6.4 | .250 | 6.4 | 2.080 | 52.8 | 3.580 | 90.9 | B54375 |
| | | 6.5 | .2559 | | .315 | 8.0 | 2.087 | 53.0 | 3.583 | 91.0 | B54377 |
| | | 6.8 | .2677 | | .315 | 8.0 | 2.087 | 53.0 | 3.583 | 91.0 | B54384 |
| | | 7.0 | .2756 | | .315 | 8.0 | 2.087 | 53.0 | 3.583 | 91.0 | B54387 |
| 9/32 | | 7.1 | .2813 | 7.1 | .313 | 7.9 | 2.080 | 52.8 | 3.580 | 90.9 | B54391 |
| 19/64 | | 7.5 | .2969 | 7.5 | .313 | 7.9 | 2.080 | 52.8 | 3.580 | 90.9 | B54398 |
| 5/16 | | 7.9 | .3125 | 7.9 | .313 | 7.9 | 2.080 | 52.8 | 3.580 | 90.9 | B54404 |
| | | 8.0 | .3150 | | .315 | 8.0 | 2.087 | 53.0 | 3.583 | 91.0 | B54405 |
| 21/64 | | 8.3 | .3281 | 8.3 | .375 | 9.5 | 2.400 | 61.0 | 4.050 | 102.9 | B54412 |
| | | 8.5 | .3346 | | .394 | 10.0 | 2.402 | 61.0 | 4.055 | 103.0 | B54415 |
| | | 8.8 | .3465 | | .394 | 10.0 | 2.402 | 61.0 | 4.055 | 103.0 | B54420 |
| | | 9.0 | .3543 | | .394 | 10.0 | 2.402 | 61.0 | 4.055 | 103.0 | B54423 |
| 3/8 | | 9.5 | .3750 | 9.5 | .375 | 9.5 | 2.400 | 61.0 | 4.050 | 102.9 | B54432 |
| | | 10 | .3937 | | .394 | 10.0 | 2.402 | 61.0 | 4.055 | 103.0 | B54440 |
| 13/32 | | 10.3 | .4063 | 10.3 | .438 | 11.1 | 2.800 | 71.1 | 4.640 | 117.9 | B54444 |
| | | 10.5 | .4134 | | .472 | 12.0 | 2.795 | 71.0 | 4.646 | 118.0 | B54446 |
| | | 10.8 | .4252 | | .472 | 12.0 | 2.795 | 71.0 | 4.646 | 118.0 | B54448 |
| | | 11.0 | .4331 | | .472 | 12.0 | 2.795 | 71.0 | 4.646 | 118.0 | B54449 |
| 7/16 | | 11.1 | .4375 | 11.1 | .438 | 11.1 | 2.800 | 71.1 | 4.640 | 117.9 | B54450 |
| 29/64 | | 11.5 | .4531 | 11.5 | .500 | 12.7 | 3.030 | 77.0 | 4.875 | 123.8 | B54453 |
| 15/32 | | 11.9 | .4688 | 11.9 | .500 | 12.7 | 3.030 | 77.0 | 4.875 | 123.8 | B54455 |
| | | 12.0 | .4724 | | .472 | 12.0 | 2.795 | 71.0 | 4.646 | 118.0 | B54456 |
| 31/64 | | 12.3 | .4844 | 12.3 | .500 | 12.7 | 3.030 | 77.0 | 4.875 | 123.8 | B54458 |
| | | 12.5 | .4921 | | .551 | 14.0 | 3.031 | 77.0 | 4.882 | 124.0 | B54459 |
| 1/2 | | 12.7 | .5000 | 12.7 | .500 | 12.7 | 3.030 | 77.0 | 4.875 | 123.8 | B54460 |

TOLERANCE - Drill Diameter: h6; Shank Diameter: h7

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

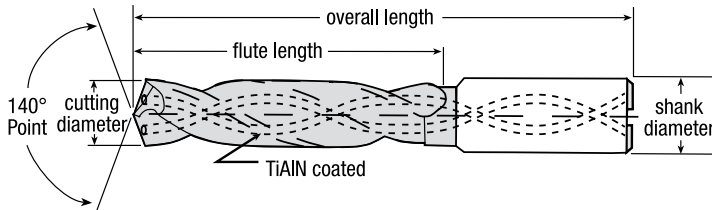
INDEX

High-Performance

Series DHPCF-8 High-Performance Coolant Fed Jobber Length Drill

Applications

- STAINLESS STEEL
- ALLOY-HARD STEEL
- CARBON STEEL
- HARDENED STEEL



Features

- SUB-MICRON CARBIDE SUBSTRATE
- 140°
- TiAlN
- 8 X DIA DEPTH
- h6 SHANK TOLERANCE
- h7 CUTTING TOLERANCE



| fraction | cutting diameter | | | shank diameter | | flute length | | overall length | | EDP number |
|----------|------------------|-----------|----------|----------------|--------|--------------|-------|----------------|-------|------------|
| | metric | dec equiv | mm equiv | inch | metric | inch | mm | inch | mm | |
| | 3.5 | .1378 | | .236 | 6.0 | 1.34 | 34.0 | 2.83 | 72.0 | B54509 |
| | 3.8 | .1496 | | .236 | 6.0 | 1.69 | 43.0 | 3.19 | 81.0 | B54517 |
| | 4.2 | .1654 | | .236 | 6.0 | 1.69 | 43.0 | 3.19 | 81.0 | B54527 |
| | 4.5 | .1772 | | .236 | 6.0 | 1.69 | 43.0 | 3.19 | 81.0 | B54535 |
| | 4.8 | .1890 | | .236 | 6.0 | 2.24 | 57.0 | 3.74 | 95.0 | B54541 |
| | 5.0 | .1969 | | .236 | 6.0 | 2.24 | 57.0 | 3.74 | 95.0 | B54546 |
| | 5.5 | .2165 | | .236 | 6.0 | 2.24 | 57.0 | 3.74 | 95.0 | B54558 |
| | 6.0 | .2362 | | .236 | 6.0 | 2.24 | 57.0 | 3.74 | 95.0 | B54568 |
| 1/4 | | .2500 | 6.4 | .250 | 6.4 | 3.00 | 76.2 | 4.50 | 114.3 | B54575 |
| | 6.5 | .2559 | | .315 | 8.0 | 2.99 | 76.0 | 4.49 | 114.0 | B54577 |
| | 6.8 | .2677 | | .315 | 8.0 | 2.99 | 76.0 | 4.49 | 114.0 | B54584 |
| | 7.0 | .2756 | | .315 | 8.0 | 2.99 | 76.0 | 4.49 | 114.0 | B54587 |
| 9/32 | | .2813 | 7.1 | .313 | 7.9 | 3.00 | 76.2 | 4.50 | 114.3 | B54591 |
| | 7.5 | .2953 | | .315 | 8.0 | 2.99 | 76.0 | 4.49 | 114.0 | B54597 |
| 19/64 | | .2969 | 7.5 | .313 | 7.9 | 3.00 | 76.2 | 4.50 | 114.3 | B54598 |
| 5/16 | | .3125 | 7.9 | .313 | 7.9 | 3.00 | 76.2 | 4.50 | 114.3 | B54604 |
| | 8.0 | .3150 | | .315 | 8.0 | 2.99 | 76.0 | 4.49 | 114.0 | B54605 |
| | 8.5 | .3346 | | .394 | 10.0 | 3.74 | 95.0 | 5.59 | 142.0 | B54615 |
| | 8.8 | .3465 | | .394 | 10.0 | 3.74 | 95.0 | 5.59 | 142.0 | B54620 |
| | 9.0 | .3543 | | .394 | 10.0 | 3.74 | 95.0 | 5.59 | 142.0 | B54623 |
| | 9.5 | .3740 | | .394 | 10.0 | 3.74 | 95.0 | 5.59 | 142.0 | B54631 |
| 3/8 | | .3750 | 9.5 | .375 | 9.5 | 3.75 | 95.3 | 5.75 | 146.1 | B54632 |
| | 10.0 | .3937 | | .394 | 10.0 | 3.74 | 95.0 | 5.59 | 142.0 | B54640 |
| | 10.2 | .4016 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54642 |
| | 10.5 | .4134 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54646 |
| | 10.8 | .4252 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54648 |
| | 11.0 | .4331 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54649 |
| 7/16 | | .4375 | 11.1 | .438 | 11.1 | 4.50 | 114.3 | 6.50 | 165.1 | B54650 |
| | 11.5 | .4528 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54652 |
| | 12.0 | .4724 | | .472 | 12.0 | 4.49 | 114.0 | 6.38 | 162.0 | B54656 |
| | 12.5 | .4921 | | .551 | 14.0 | 5.24 | 133.0 | 7.01 | 178.0 | B54659 |
| 1/2 | | .5000 | 12.7 | .500 | 12.7 | 5.25 | 133.4 | 7.00 | 177.8 | B54660 |

TOLERANCE - Drill Diameter: h6; Shank Diameter: h7



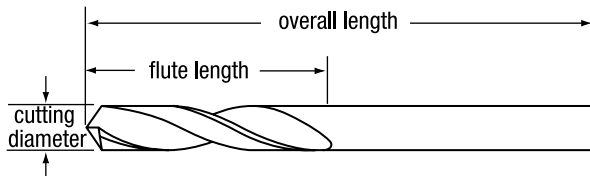
Jobber Length

Series DR Jobber Length Drill

Applications



Features



| cutting diameter frac | wire/let | decimal | flute length | overall length | EDP number |
|--------------------------|----------|---------|-----------------|-------------------|---------------|
| | | | | | |
| | 60 | .0400 | 5/8 | 1 1/2 | B53511 |
| | 59 | .0410 | 3/4 | 1 1/2 | B53512 |
| | 58 | .0420 | 3/4 | 1 1/2 | B53514 |
| | 57 | .0430 | 3/4 | 1 1/2 | B53515 |
| | 56 | .0465 | 3/4 | 1 1/2 | B53518 |
| 3/64 | | .0469 | 3/4 | 1 1/2 | B53521 |
| | 55 | .0520 | 3/4 | 1 1/2 | B53523 |
| | 54 | .0550 | 3/4 | 1 1/2 | B53525 |
| | 53 | .0595 | 3/4 | 1 1/2 | B53529 |
| 1/16 | | .0625 | 3/4 | 1 1/2 | B53531 |
| | 52 | .0635 | 3/4 | 1 1/2 | B53533 |
| | 51 | .0670 | 3/4 | 1 1/2 | B53536 |
| | 50 | .0700 | 7/8 | 1 3/4 | B53538 |
| | 49 | .0730 | 7/8 | 1 3/4 | B53541 |
| | 48 | .0760 | 7/8 | 1 3/4 | B53543 |
| 5/64 | | .0781 | 7/8 | 1 3/4 | B53545 |
| | 47 | .0785 | 7/8 | 1 3/4 | B53546 |
| | 46 | .0810 | 7/8 | 1 3/4 | B53549 |
| | 45 | .0820 | 7/8 | 1 3/4 | B53550 |
| | 44 | .0860 | 1 | 2 | B53553 |
| | 43 | .0890 | 1 | 2 | B53556 |
| | 42 | .0935 | 1 | 2 | B53559 |
| 3/32 | | .0938 | 1 | 2 | B53560 |
| | 41 | .0960 | 1 | 2 | B53562 |
| | 40 | .0980 | 1 | 2 | B53564 |
| | 39 | .0995 | 1 1/4 | 2 1/4 | B53566 |
| | 38 | .1015 | 1 1/4 | 2 1/4 | B53567 |
| | 37 | .1040 | 1 1/4 | 2 1/4 | B53569 |
| | 36 | .1065 | 1 1/4 | 2 1/4 | B53571 |
| 7/64 | | .1094 | 1 1/4 | 2 1/4 | B53573 |
| | 35 | .1100 | 1 1/4 | 2 1/4 | B53574 |
| | 34 | .1110 | 1 1/4 | 2 1/4 | B53576 |
| | 33 | .1130 | 1 1/4 | 2 1/4 | B53577 |
| | 32 | .1160 | 1 1/4 | 2 1/4 | B53579 |
| | 31 | .1200 | 1 1/4 | 2 1/4 | B53581 |
| 1/8 | | .1250 | 1 1/4 | 2 1/4 | B53583 |
| | 30 | .1285 | 1 1/4 | 2 1/4 | B53586 |
| | 29 | .1360 | 1 3/8 | 2 1/2 | B53589 |
| | 28 | .1405 | 1 3/8 | 2 1/2 | B53591 |
| 9/64 | | .1406 | 1 3/8 | 2 1/2 | B53592 |
| | 27 | .1440 | 1 3/8 | 2 1/2 | B53594 |

| cutting diameter frac | wire/let | decimal | flute length | overall length | EDP number |
|--------------------------|----------|---------|-----------------|-------------------|---------------|
| | | | | | |
| | 25 | .1495 | 1 3/8 | 2 1/2 | B53598 |
| | 24 | .1520 | 1 3/8 | 2 1/2 | B53600 |
| | 23 | .1540 | 1 3/8 | 2 1/2 | B53602 |
| 5/32 | | .1563 | 1 3/8 | 2 1/2 | B53603 |
| | 22 | .1570 | 1 3/8 | 2 1/2 | B53604 |
| | 21 | .1590 | 1 3/8 | 2 1/2 | B53606 |
| | 20 | .1610 | 1 3/8 | 2 1/2 | B53607 |
| | 19 | .1660 | 1 5/8 | 2 3/4 | B53610 |
| | 18 | .1695 | 1 5/8 | 2 3/4 | B53613 |
| 11/64 | | .1719 | 1 5/8 | 2 3/4 | B53614 |
| | 17 | .1730 | 1 5/8 | 2 3/4 | B53615 |
| | 16 | .1770 | 1 5/8 | 2 3/4 | B53617 |
| | 15 | .1800 | 1 5/8 | 2 3/4 | B53619 |
| | 14 | .1820 | 1 5/8 | 2 3/4 | B53621 |
| | 13 | .1850 | 1 5/8 | 2 3/4 | B53622 |
| 3/16 | | .1875 | 1 5/8 | 2 3/4 | B53625 |
| | 12 | .1890 | 1 5/8 | 2 3/4 | B53626 |
| | 11 | .1910 | 1 5/8 | 2 3/4 | B53628 |
| | 10 | .1935 | 1 5/8 | 2 3/4 | B53630 |
| | 9 | .1960 | 1 3/4 | 3 | B53631 |
| | 8 | .1990 | 1 3/4 | 3 | B53633 |
| | 7 | .2010 | 1 3/4 | 3 | B53635 |
| 13/64 | | .2031 | 1 3/4 | 3 | B53637 |
| | 6 | .2040 | 1 3/4 | 3 | B53638 |
| | 5 | .2055 | 1 3/4 | 3 | B53640 |
| | 4 | .2090 | 1 3/4 | 3 | B53643 |
| | 3 | .2130 | 1 3/4 | 3 | B53645 |
| 7/32 | | .2188 | 1 3/4 | 3 | B53647 |
| | 2 | .2210 | 1 3/4 | 3 | B53649 |
| | 1 | .2280 | 1 3/4 | 3 | B53652 |
| | A | .2340 | 2 | 3 1/4 | B53655 |
| 15/64 | | .2344 | 2 | 3 1/4 | B53657 |
| | B | .2380 | 2 | 3 1/4 | B53660 |
| | C | .2420 | 2 | 3 1/4 | B53662 |
| | D | .2460 | 2 | 3 1/4 | B53664 |
| 1/4 | | .2500 | 2 | 3 1/4 | B53666 |
| | E | .2500 | 2 | 3 1/4 | B53666 |
| | F | .2570 | 2 | 3 1/4 | B53670 |
| | G | .2610 | 2 1/8 | 3 1/2 | B53672 |
| 17/64 | | .2656 | 2 1/8 | 3 1/2 | B53675 |
| | H | .2660 | 2 1/8 | 3 1/2 | B53677 |
| | I | .2720 | 2 1/8 | 3 1/2 | B53678 |

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CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Jobber Length • Stub Length

Series DR Jobber Length Drill (continued)

Applications



Features



| cutting diameter frac | wire/let | decimal | flute length | overall length | EDP number |
|--------------------------|----------|---------|-----------------|-------------------|---------------|
| | J | .2770 | 2 1/8 | 3 1/2 | B53681 |
| | K | .2810 | 2 1/8 | 3 1/2 | B53683 |
| 9/32 | | .2812 | 2 1/8 | 3 1/2 | B53685 |
| | L | .2900 | 2 1/8 | 3 1/2 | B53688 |
| | M | .2950 | 2 3/8 | 3 3/4 | B53689 |
| 19/64 | | .2969 | 2 3/8 | 3 3/4 | B53691 |
| | N | .3020 | 2 3/8 | 3 3/4 | B53693 |
| 5/16 | | .3125 | 2 3/8 | 3 3/4 | B53694 |
| | O | .3160 | 2 3/8 | 3 3/4 | B53696 |
| | P | .3230 | 2 3/8 | 3 3/4 | B53698 |
| 21/64 | | .3281 | 2 1/2 | 4 | B53701 |
| | Q | .3320 | 2 1/2 | 4 | B53704 |
| 11/32 | | .3438 | 2 1/2 | 4 | B53708 |
| | S | .3480 | 2 1/2 | 4 | B53710 |
| | T | .3580 | 2 1/2 | 4 | B53713 |
| 23/64 | | .3594 | 2 1/2 | 4 | B53715 |

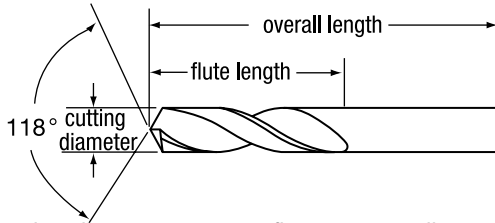
| cutting diameter frac | wire/let | decimal | flute length | overall length | EDP number |
|--------------------------|----------|---------|-----------------|-------------------|---------------|
| | U | .3680 | 2 3/4 | 4 1/4 | B53718 |
| 3/8 | | .3750 | 2 3/4 | 4 1/4 | B53720 |
| | V | .3770 | 2 7/8 | 4 1/4 | B53722 |
| | W | .3860 | 2 7/8 | 4 1/2 | B53724 |
| 25/64 | | .3906 | 2 7/8 | 4 1/2 | B53725 |
| | X | .3970 | 2 7/8 | 4 1/2 | B53727 |
| | Y | .4040 | 2 7/8 | 4 1/2 | B53729 |
| 13/32 | | .4062 | 2 7/8 | 4 1/2 | B53731 |
| | Z | .4130 | 2 7/8 | 4 1/2 | B53732 |
| 27/64 | | .4219 | 2 7/8 | 4 1/2 | B53735 |
| 7/16 | | .4375 | 3 | 4 1/2 | B53737 |
| 29/64 | | .4531 | 3 | 4 3/4 | B53739 |
| 15/32 | | .4688 | 3 | 4 3/4 | B53741 |
| 31/64 | | .4844 | 3 | 4 3/4 | B53742 |
| 1/2 | | .5000 | 3 | 4 3/4 | B53744 |

Series DRS Slow Spiral Stub Length Drill

Applications



Features



| cutting diameter frac | wire | decimal | flute length | overall length | EDP number |
|--------------------------|------|---------|-----------------|-------------------|---------------|
| | 60 | .0400 | 3/8 | 1 1/2 | B36060 |
| | 59 | .0410 | 3/8 | 1 1/2 | B36059 |
| | 58 | .0420 | 3/8 | 1 1/2 | B36058 |
| | 57 | .0430 | 3/8 | 1 1/2 | B36057 |
| | 56 | .0465 | 3/8 | 1 1/2 | B36056 |
| | 55 | .0520 | 3/8 | 1 1/2 | B36055 |
| | 54 | .0550 | 3/8 | 1 1/2 | B36054 |
| | 53 | .0595 | 3/8 | 1 1/2 | B36053 |
| 1/16 | | .0625 | 3/8 | 1 1/2 | B36404 |
| | 52 | .0635 | 3/8 | 1 1/2 | B36052 |
| | 51 | .0670 | 3/8 | 1 1/2 | B36051 |
| | 50 | .0700 | 3/8 | 1 1/2 | B36050 |
| | 49 | .0730 | 3/8 | 1 1/2 | B36049 |
| | 48 | .0760 | 1/2 | 1 1/2 | B36048 |
| 5/64 | | .0781 | 1/2 | 1 1/2 | B36405 |
| | 47 | .0785 | 1/2 | 1 1/2 | B36047 |
| | 46 | .0810 | 1/2 | 1 1/2 | B36046 |
| | 45 | .0820 | 1/2 | 1 1/2 | B36045 |

| cutting diameter frac | wire | decimal | flute length | overall length | EDP number |
|--------------------------|------|---------|-----------------|-------------------|---------------|
| | 44 | .0860 | 1/2 | 2 | B36044 |
| | 43 | .0890 | 1/2 | 2 | B36043 |
| 3/32 | | .0935 | 1/2 | 2 | B36042 |
| | 42 | .0938 | 1/2 | 2 | B36406 |
| | 41 | .0960 | 1/2 | 2 | B36041 |
| | 40 | .0980 | 5/8 | 2 | B36040 |
| | 39 | .0995 | 5/8 | 2 | B36039 |
| | 38 | .1015 | 5/8 | 2 | B36038 |
| | 37 | .1040 | 5/8 | 2 | B36037 |
| | 36 | .1065 | 5/8 | 2 | B36036 |
| 7/64 | | .1094 | 5/8 | 2 | B36407 |
| | 35 | .1100 | 5/8 | 2 | B36035 |
| | 34 | .1110 | 5/8 | 2 | B36034 |
| | 33 | .1130 | 5/8 | 2 | B36033 |
| | 32 | .1160 | 5/8 | 2 | B36032 |
| | 31 | .1200 | 5/8 | 2 | B36031 |
| 1/8 | | .1250 | 5/8 | 2 | B36408 |
| | 30 | .1285 | 5/8 | 2 | B36030 |

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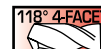
Stub Length

Series **DRS** Slow Spiral Stub Length Drill (continued)

Applications



Features



| | cutting diameter | | flute length | overall length | EDP number |
|-------|------------------|--------------|--------------|----------------|------------|
| | frac | wire decimal | | | |
| 9/64 | 29 | .1360 | 5/8 | 2 | B36029 |
| | | .1406 | 5/8 | 2 | B36409 |
| | 27 | .1440 | 5/8 | 2 | B36027 |
| | 26 | .1470 | 5/8 | 2 | B36026 |
| | 25 | .1495 | 5/8 | 2 | B36025 |
| 5/32 | 24 | .1520 | 5/8 | 2 | B36024 |
| | 23 | .1540 | 5/8 | 2 | B36023 |
| | | .1563 | 3/4 | 2 | B36410 |
| | 21 | .1590 | 3/4 | 2 | B36021 |
| | 20 | .1610 | 3/4 | 2 | B36020 |
| 11/64 | 19 | .1660 | 3/4 | 2 1/8 | B36019 |
| | 18 | .1695 | 3/4 | 2 1/8 | B36018 |
| | | .1719 | 3/4 | 2 1/8 | B36411 |
| | 17 | .1730 | 3/4 | 2 1/8 | B36017 |
| | | .1770 | 3/4 | 2 1/8 | B36016 |
| 3/16 | 15 | .1800 | 3/4 | 2 3/16 | B36015 |
| | 14 | .1820 | 3/4 | 2 3/16 | B36014 |
| | 13 | .1850 | 3/4 | 2 3/16 | B36013 |
| | | .1875 | 3/4 | 2 3/16 | B36412 |
| | 12 | .1890 | 3/4 | 2 3/16 | B36012 |
| 13/64 | 11 | .1910 | 3/4 | 2 3/16 | B36011 |
| | 10 | .1935 | 3/4 | 2 3/16 | B36010 |
| | 9 | .1960 | 3/4 | 2 1/4 | B36009 |
| | 8 | .1990 | 3/4 | 2 1/4 | B36008 |
| | 7 | .2010 | 3/4 | 2 1/4 | B36007 |

| | cutting diameter | | flute length | overall length | EDP number |
|-------|------------------|---------------------|--------------|----------------|------------|
| | frac | wire/letter decimal | | | |
| 7/32 | 6 | .2040 | 3/4 | 2 1/4 | B36006 |
| | 5 | .2055 | 3/4 | 2 1/4 | B36005 |
| | 4 | .2090 | 3/4 | 2 1/4 | B36004 |
| | 3 | .2130 | 1 | 2 1/2 | B36003 |
| | | .2188 | 1 | 2 1/2 | B36414 |
| 15/64 | 2 | .2210 | 1 | 2 1/2 | B36002 |
| | 1 | .2280 | 1 | 2 1/2 | B36001 |
| | | .2344 | 1 | 2 1/2 | B36415 |
| | 1/4 | .2500 | 1 | 2 1/2 | B36416 |
| | 17/64 | .2656 | 1 | 2 1/2 | B36417 |
| 19/64 | 9/32 | .2813 | 1 | 2 1/2 | B36418 |
| | 19/64 | .2969 | 1 1/4 | 2 1/2 | B36419 |
| | 5/16 | .3125 | 1 1/4 | 2 1/2 | B36420 |
| | 21/64 | .3281 | 1 1/4 | 2 1/2 | B36421 |
| | 11/32 | .3438 | 1 1/4 | 2 1/2 | B36422 |
| 27/64 | 23/64 | .3594 | 1 1/4 | 2 1/2 | B36423 |
| | 25/64 | .3906 | 1 1/4 | 2 3/4 | B36425 |
| | 13/32 | .4063 | 1 1/4 | 2 3/4 | B36426 |
| | 27/64 | .4219 | 1 1/4 | 2 3/4 | B36427 |
| | 7/16 | .4375 | 1 1/4 | 2 3/4 | B36428 |
| 31/64 | 29/64 | .4531 | 1 1/4 | 3 | B36429 |
| | 15/32 | .4688 | 1 1/4 | 3 | B36430 |
| | 31/64 | .4844 | 1 1/4 | 3 | B36431 |
| | 1/2 | .5000 | 1 1/4 | 3 | B36432 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

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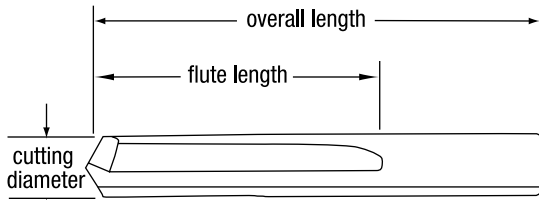
Straight Flute

Series DM Straight Flute Drill

Applications



Features



Tolerances for Series DM Drills
 Cutting Diameter: +.000, -.0005
 Shank Diameter: +.0000, -.0005

| cutting diameter frac | wire /mm | decimal | flute length | overall length | EDP number |
|--------------------------|----------|---------|--------------|----------------|------------|
| 1/32 | | .0313 | 1/2 | 1 1/2 | B54100 |
| | 60 | .0400 | 1/2 | 1 1/2 | B54101 |
| | 59 | .0410 | 1/2 | 1 1/2 | B54102 |
| | 58 | .0420 | 1/2 | 1 1/2 | B54104 |
| | 57 | .0430 | 1/2 | 1 1/2 | B54105 |
| | 56 | .0465 | 1/2 | 1 1/2 | B54108 |
| 3/64 | | .0469 | 1/2 | 1 1/2 | B54112 |
| | 55 | .0520 | 1/2 | 1 1/2 | B54113 |
| | 54 | .0550 | 1/2 | 1 1/2 | B54115 |
| | 53 | .0595 | 1/2 | 1 1/2 | B54119 |
| 1/16 | | .0625 | 5/8 | 1 5/8 | B54121 |
| | 52 | .0635 | 11/16 | 1 11/16 | B54123 |
| | 51 | .0670 | 11/16 | 1 11/16 | B54126 |
| | 50 | .0700 | 11/16 | 1 11/16 | B54128 |
| | 49 | .0730 | 11/16 | 1 11/16 | B54131 |
| | 48 | .0760 | 11/16 | 1 11/16 | B54133 |
| 5/64 | | .0781 | 11/16 | 1 11/16 | B54135 |
| | 47 | .0785 | 3/4 | 1 3/4 | B54136 |
| | 46 | .0810 | 3/4 | 1 3/4 | B54139 |
| | 45 | .0820 | 3/4 | 1 3/4 | B54140 |
| | 44 | .0860 | 3/4 | 1 3/4 | B54143 |
| | 43 | .0890 | 3/4 | 1 3/4 | B54146 |
| | 42 | .0935 | 3/4 | 1 3/4 | B54149 |
| 3/32 | | .0938 | 3/4 | 1 3/4 | B54150 |
| | 41 | .0960 | 13/16 | 1 13/16 | B54152 |
| | 40 | .0980 | 13/16 | 1 13/16 | B54154 |
| | 39 | .0995 | 13/16 | 1 13/16 | B54156 |
| | 38 | .1015 | 13/16 | 1 13/16 | B54157 |
| | 37 | .1040 | 13/16 | 1 13/16 | B54159 |
| | 36 | .1065 | 13/16 | 1 13/16 | B54161 |
| 7/64 | | .1094 | 13/16 | 1 13/16 | B54163 |
| | 35 | .1100 | 7/8 | 1 7/8 | B54164 |
| | 34 | .1110 | 7/8 | 1 7/8 | B54166 |
| | 33 | .1130 | 7/8 | 1 7/8 | B54167 |
| | 32 | .1160 | 7/8 | 1 7/8 | B54169 |
| | 31 | .1200 | 7/8 | 1 7/8 | B54171 |
| 1/8 | | .1250 | 7/8 | 1 7/8 | B54173 |
| | 30 | .1285 | 15/16 | 1 15/16 | B54176 |
| | 29 | .1360 | 15/16 | 1 15/16 | B54179 |
| | 28 | .1405 | 15/16 | 1 15/16 | B54181 |
| 9/64 | | .1406 | 15/16 | 1 15/16 | B54182 |
| | 27 | .1440 | 1 | 2 1/16 | B54184 |

| cutting diameter frac | wire/mm | decimal | flute length | overall length | EDP number |
|--------------------------|---------|---------|--------------|----------------|------------|
| | 26 | .1470 | 1 | 2 1/16 | B54186 |
| | 25 | .1495 | 1 | 2 1/16 | B54188 |
| | 24 | .1520 | 1 | 2 1/16 | B54190 |
| | 23 | .1540 | 1 | 2 1/16 | B54192 |
| 5/32 | | .1563 | 1 | 2 1/16 | B54193 |
| | 22 | .1570 | 1 1/16 | 2 1/8 | B54194 |
| | 21 | .1590 | 1 1/16 | 2 1/8 | B54196 |
| | 20 | .1610 | 1 1/16 | 2 1/8 | B54197 |
| | 19 | .1660 | 1 1/16 | 2 1/8 | B54200 |
| | 18 | .1695 | 1 1/16 | 2 1/8 | B54203 |
| 11/64 | | .1719 | 1 1/16 | 2 1/8 | B54204 |
| | 17 | .1730 | 1 1/8 | 2 3/16 | B54205 |
| | 16 | .1770 | 1 1/8 | 2 3/16 | B54207 |
| | 15 | .1800 | 1 1/8 | 2 3/16 | B54209 |
| | 14 | .1820 | 1 1/8 | 2 3/16 | B54211 |
| | 13 | .1850 | 1 1/8 | 2 3/16 | B54212 |
| 3/16 | | .1875 | 1 1/8 | 2 3/16 | B54215 |
| | 12 | .1890 | 1 3/16 | 2 1/4 | B54216 |
| | 11 | .1910 | 1 3/16 | 2 1/4 | B54218 |
| | 10 | .1935 | 1 3/16 | 2 1/4 | B54220 |
| | 9 | .1960 | 1 3/16 | 2 1/4 | B54221 |
| | 8 | .1990 | 1 3/16 | 2 1/4 | B54223 |
| | 7 | .2010 | 1 3/16 | 2 1/4 | B54225 |
| 13/64 | | .2031 | 1 3/16 | 2 1/4 | B54227 |
| | 6 | .2040 | 1 1/4 | 2 3/8 | B54228 |
| | 5 | .2055 | 1 1/4 | 2 3/8 | B54230 |
| | 4 | .2090 | 1 1/4 | 2 3/8 | B54233 |
| | 3 | .2130 | 1 1/4 | 2 3/8 | B54235 |
| 7/32 | | .2188 | 1 1/4 | 2 3/8 | B54237 |
| | 2 | .2210 | 1 5/16 | 2 7/16 | B54239 |
| | 1 | .2280 | 1 5/16 | 2 7/16 | B54245 |
| 15/64 | | .2344 | 1 5/16 | 2 7/16 | B54242 |
| 1/4 | | .2500 | 1 3/8 | 2 1/2 | B54247 |
| 17/64 | | .2656 | 1 7/16 | 2 5/8 | B54248 |
| 9/32 | | .2813 | 1 1/2 | 2 11/16 | B54250 |
| 19/64 | | .2969 | 1 9/16 | 2 3/4 | B54251 |
| 5/16 | | .3125 | 1 5/8 | 2 13/16 | B54253 |
| 21/64 | | .3281 | 1 11/16 | 2 15/16 | B54254 |
| 11/32 | | .3438 | 1 11/16 | 3 | B54256 |
| 23/64 | | .3594 | 1 3/4 | 3 1/16 | B54257 |
| 3/8 | | .3750 | 1 13/16 | 3 1/8 | B54259 |
| 25/64 | | .3906 | 1 7/8 | 3 1/4 | B54260 |

continued on next page



Straight Flute • Spade • Drill and Countersink

BASSETT™

Series DM Straight Flute Drill (continued)

| cutting diameter | | flute length | overall length | EDP number |
|------------------|---------|--------------|----------------|------------|
| frac | decimal | | | |
| 13/32 | .4063 | 1 15/16 | 3 5/16 | B54262 |
| 27/64 | .4219 | 2 | 3 3/8 | B54263 |
| 7/16 | .4375 | 2 1/16 | 3 7/16 | B54265 |
| 15/32 | .4688 | 2 1/8 | 3 5/8 | B54267 |
| 1/2 | .5000 | 2 1/4 | 3 3/4 | B54270 |

Applications | NON-FERROUS MATERIALS CAST IRON STEEL

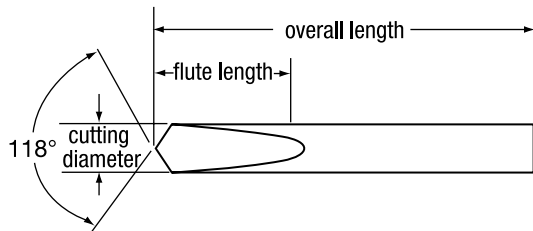
Features | SOLID CARBIDE 118° 4-FACE BRIGHT

Series DS Spade Stub Length Drill

Applications | NON-FERROUS MATERIALS STAINLESS STEEL HARDENED STEEL



Features | SOLID CARBIDE 118° BRIGHT



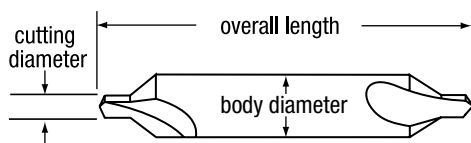
| cutting diameter | | flute length | overall length | EDP number |
|------------------|---------|--------------|----------------|------------|
| fractional | decimal | | | |
| 1/32 | .0313 | 3/16 | 1 1/2 | B53451 |
| 1/16 | .0625 | 5/16 | 1 1/2 | B53454 |
| 3/32 | .0938 | 7/16 | 1 1/2 | B53456 |
| 1/8 | .1250 | 7/16 | 1 1/2 | B53458 |
| 5/32 | .1563 | 15/32 | 2 | B53460 |
| 3/16 | .1875 | 9/16 | 2 | B53462 |

| cutting diameter | | flute length | overall length | EDP number |
|------------------|---------|--------------|----------------|------------|
| fractional | decimal | | | |
| 7/32 | .2188 | 19/32 | 2 | B53464 |
| 1/4 | .2500 | 11/16 | 2 | B53467 |
| 3/8 | .3750 | 1 | 2 1/2 | B53475 |
| 13/32 | .4063 | 1 | 2 1/2 | B53477 |

Series DC Combination Stub Length Drill and Countersink

Applications | NON-FERROUS MATERIALS CAST IRON STEEL

Features | SOLID CARBIDE 118° BRIGHT



| tool number | cutting diameter | | body diameter | overall length | EDP number |
|-------------|------------------|---------|---------------|----------------|------------|
| | fraction | decimal | | | |
| 1 | 3/64 | .125 | 1/8 | 1 1/2 | B53433 |
| 2 | 5/64 | .188 | 3/16 | 2 | B53433 |
| 3 | 7/64 | .250 | 1/4 | 2 | B53433 |
| 4 | 1/8 | .313 | 5/16 | 2 1/8 | B53434 |
| 5 | 3/16 | .438 | 7/16 | 2 3/4 | B53435 |
| 6 | 7/32 | .500 | 1/2 | 3 | B53436 |



Thread Mills



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| TM/TMC | UN Thread Mills, with and without coolant | .41 |
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| TMBPS/TMBPSC | BSPP Thread Mills, with and without coolant | .42 |
| TMBPT/TMBPTC | BSPT Thread Mills, with and without coolant | .42 |
| TMM/TMMC | Metric Thread Mills, with and without coolant | .43 |
| | Thread Mill Programming Request Form. | .44 |

Features

- Helical flute design reduces thread chatter, improving product thread finish and quality
- Advanced TiAlN coating is standard for increasing speeds
- Ideal for internal and external threads
- Full range of sizes available
 - Internal threads #4 to 1" UNC and UNF
 - Pipe threads 1/16" to 1" NPT, NPTF and NPSM
 - Metric internal threads M4.5 x .75 through M20 x 3
- Specials program for nonstandard sizes and other coatings

Benefits

- Thread milling is a superior process for threading most materials
- More economical than using taps:
 - One thread mill can produce several diameters of threaded holes of the same pitch
 - Same tool makes right or left-hand threads
 - Avoid chip packing in blind holes, a primary cause of tap breakage
 - One tool for through and blind holes
 - Pitch diameter can be controlled by CNC offset

Applications

- Bassett thread mills are the ideal choice when:
- Machine tool has helical interpolation capabilities
 - Thread specification calls for full threads close to bottom of hole
 - Thread specification requires a special tap
 - Small lot size is to be threaded
 - Need to cut large diameter threads on low horsepower machines
 - Workpiece is thin walled which can be milled more easily than tapped
 - CNC machine has a slower RPM capability below what is recommended for carbide thread mills

Calculating Thread Mill Feed Rate

For internal threads: $(D1 - d1) / D1 \times \text{RPM} \times \text{ipr}$
For external threads: $(D1 + d1) / D1 \times \text{RPM} \times \text{ipr}$
 where
 D1 is the major diameter of the thread
 d1 is the cutting diameter
 RPM is the calculated speed rate = $(3.82 \times \text{SFM}) / \text{Diameter}$
 ipr is the calculated feed rate = $\text{IPT (inches per tooth)} \times \text{number of flutes per cutter}$
 Example: to cut an internal 7/8-14 thread using a four-flute, 1/2" diameter cutter in bronze, the programmed feed rate would be $((.875 - .500) / .875) \times (3438 \text{ RPM} \times .016)$ or 23.6 ipm

Operating Parameters for Helical Thread Mills

| material | surface feet per minute (SFM) | cutter diameter (inches) | | | | | |
|-----------------------|-------------------------------|--------------------------|--------|--------|--------|--------|--------|
| | | 0.125 | 0.250 | 0.375 | 0.500 | 0.750 | 1.000 |
| Al-Si Alloys | 600 | 0.0010 | 0.0020 | 0.0030 | 0.0040 | 0.0050 | 0.0060 |
| cast iron | 600 | 0.0008 | 0.0015 | 0.0020 | 0.0030 | 0.0040 | 0.0050 |
| brass or bronze | 450 | 0.0010 | 0.0020 | 0.0030 | 0.0040 | 0.0050 | 0.0060 |
| steel <200 Bhn | 600 | 0.0007 | 0.0015 | 0.0020 | 0.0030 | 0.0040 | 0.0050 |
| steel <325 Bhn | 575 | 0.0005 | 0.0010 | 0.0015 | 0.0020 | 0.0030 | 0.0040 |
| stainless steel | 525 | 0.0005 | 0.0008 | 0.0015 | 0.0020 | 0.0030 | 0.0040 |
| tool steels, annealed | 125 | 0.0005 | 0.0008 | 0.0012 | 0.0015 | 0.0020 | 0.0030 |

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

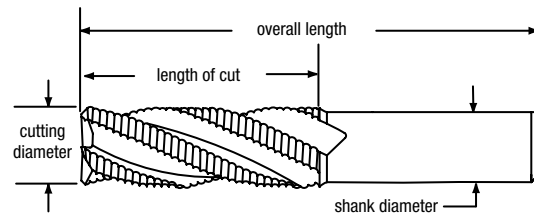
CARBIDE BURS

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Series **TM Solid** and **TMC Coolant-Thru** Thread Mills for Internal Threads

Applications | STEEL STAINLESS STEEL HI-TEMP ALLOYS NON-FERROUS MATERIALS

Features | SOLID CARBIDE UNC TiAIN



| thread size | shank diameter | cutting diameter | length of cut | overall length | number of flutes | EDP number | |
|-------------|----------------|------------------|---------------|----------------|------------------|-------------|--------------|
| | | | | | | non-coolant | coolant-thru |
| 6-32 | 1/8 | .095 | .218 | 2 | 3 | B71000 | — |
| 8-32 | 1/8 | .115 | .250 | 2 | 3 | B71002 | — |
| 8-36 | 1/8 | .115 | .250 | 2 | 3 | B71003 | — |
| 10-24 | 3/16 | .120 | .312 | 2 | 3 | B71004 | — |
| 10-32 | 3/16 | .120 | .312 | 2 | 3 | B71005 | — |
| 1/4-20 | 3/16 | .180 | .500 | 2 1/2 | 3 | B71008 | B71508 |
| 1/4-28 | 3/16 | .180 | .500 | 2 1/2 | 3 | B71009 | B71509 |
| 5/16-18 | 1/4 | .240 | .625 | 2 1/2 | 3 | B71010 | B71510 |
| 5/16-24 | 1/4 | .240 | .625 | 2 1/2 | 3 | B71011 | B71511 |
| 3/8-16 | 5/16 | .290 | .750 | 3 | 4 | B71012 | B71512 |
| 3/8-24 | 5/16 | .290 | .750 | 3 | 4 | B71013 | B71513 |
| 7/16-14 | 3/8 | .340 | .875 | 3 | 4 | B71014 | B71514 |
| 7/16-20 | 3/8 | .340 | .875 | 3 | 4 | B71015 | B71515 |
| 1/2-13 | 3/8 | .350 | .875 | 3 1/2 | 4 | B71016 | B71516 |
| 1/2-20 | 3/8 | .350 | .875 | 3 1/2 | 4 | B71017 | — |
| 9/16-12 | 1/2 | .370 | .875 | 3 1/2 | 4 | B71018 | B71518 |
| 9/16-18 | 1/2 | .370 | .875 | 3 1/2 | 4 | B71019 | B71519 |
| 5/8-11 | 1/2 | .470 | 1.250 | 3 1/2 | 5 | B71020 | B71520 |
| 5/8-18 | 1/2 | .470 | 1.250 | 3 1/2 | 5 | B71021 | B71521 |
| 3/4-10 | 1/2 | .495 | 1.250 | 3 1/2 | 5 | B71022 | B71522 |
| 3/4-12 | 1/2 | .495 | 1.250 | 3 1/2 | 5 | B71023 | B71523 |
| 3/4-16 | 1/2 | .495 | 1.250 | 3 1/2 | 5 | B71025 | B71525 |
| 7/8-9 | 1/2 | .495 | 1.250 | 3 1/2 | 5 | B71026 | B71526 |
| 7/8-14 | 1/2 | .495 | 1.250 | 3 1/2 | 5 | B71027 | B71527 |
| 1-8 | 3/4 | .620 | 1.375 | 4 | 5 | B71028 | B71528 |
| 1-12 | 3/4 | .620 | 1.375 | 4 | 5 | B71029 | B71529 |



NPT • BSPP • BSPT

BASSETT™

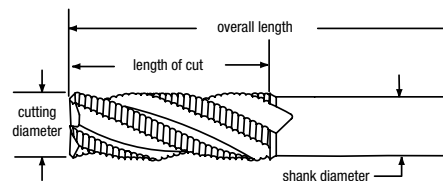
Series **TMNP Solid** and **TMNPC Coolant-Thru** Thread Mills for Internal Threads

Applications

NON-FERROUS MATERIALS
STEEL
STAINLESS STEEL
HITEMP ALLOYS

Features

NPT
SOLID CARBIDE
TiAIN



| thread size | shank diameter | cutting diameter | length of cut | overall length | number of flutes | EDP number | |
|-------------|----------------|------------------|---------------|----------------|------------------|-------------|--------------|
| | | | | | | non-coolant | coolant-thru |
| 1/16-27 | 1/4 | .245 | .437 | 2 1/2 | 3 | B71050 | B71550 |
| 1/8-27 | 5/16 | .310 | .437 | 2 1/2 | 4 | B71051 | B71551 |
| 1/4, 3/8-18 | 3/8 | .305 | .625 | 3 | 4 | B71052 | B71552 |
| 1/2, 3/4-14 | 1/2 | .495 | .875 | 3 1/2 | 4 | B71055 | B71555 |
| 1-11.5 | 3/4 | .620 | 1.125 | 4 | 5 | B71056 | B71556 |

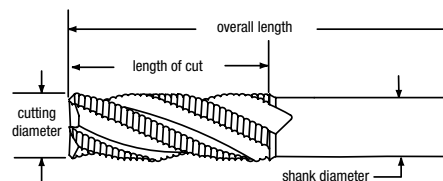
Series **TMBPS Solid** and **TMBPSC Coolant-Thru** Thread Mills for Internal Threads

Applications

NON-FERROUS MATERIALS
STEEL
STAINLESS STEEL
HITEMP ALLOYS

Features

BSPP
SOLID CARBIDE
TiAIN



| thread size | shank diameter | cutting diameter | length of cut | overall length | number of flutes | EDP number | |
|--------------|----------------|------------------|---------------|----------------|------------------|-------------|--------------|
| | | | | | | non-coolant | coolant-thru |
| 1/16, 1/8-28 | 1/4 | .240 | .572 | 2 1/2 | 3 | B71100 | B71600 |
| 1/4-19 | 5/16 | .312 | .737 | 3 | 4 | B71101 | B71601 |
| 1/2-14 | 1/2 | .470 | 1.143 | 3 1/2 | 4 | B71102 | B71602 |
| 1-11 | 5/8 | .620 | 1.546 | 4 | 5 | B71104 | B71604 |

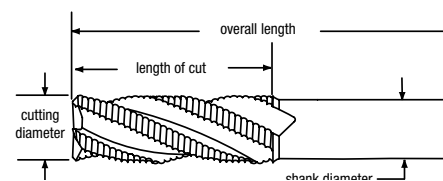
Series **TMBPT Solid** and **TMBPTC Coolant-Thru** Thread Mills for Internal Threads

Applications

NON-FERROUS MATERIALS
STEEL
STAINLESS STEEL
HITEMP ALLOYS

Features

BSPT
SOLID CARBIDE
TiAIN



| thread size | shank diameter | cutting diameter | length of cut | overall length | number of flutes | EDP number | |
|--------------|----------------|------------------|---------------|----------------|------------------|-------------|--------------|
| | | | | | | non-coolant | coolant-thru |
| 1/16, 1/8-28 | 1/4 | .240 | .401 | 2 1/2 | 3 | B71120 | B71620 |
| 1/4-19 | 5/16 | .312 | .578 | 3 | 4 | B71121 | B71621 |
| 1/2-14 | 1/2 | .470 | .785 | 3 1/2 | 4 | B71122 | B71622 |
| 1-11 | 5/8 | .620 | 1.546 | 4 | 5 | B71123 | B71623 |

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CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

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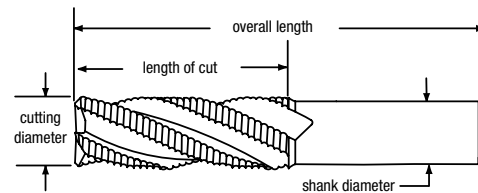
Series **TMM Solid** and **TMMC Coolant-Thru** Thread Mills for Internal Threads

Applications |

NON-FERROUS MATERIALS
STEEL
STAINLESS STEEL
HI-TEMP ALLOYS

Features |

SOLID CARBIDE
METRIC
TiAIN



| thread size | shank diameter | cutting diameter | length of cut | overall length | number of flutes | EDP number | |
|-------------|----------------|------------------|---------------|----------------|------------------|-------------|--------------|
| | | | | | | non-coolant | coolant-thru |
| M4 X 0.70 | 1/8 | .120 | .250 | 2 | 2 | B71070 | B71570 |
| M4.5 X 0.75 | 1/8 | .120 | .250 | 2 | 3 | B71071 | B71571 |
| M5 X 0.80 | 3/16 | .120 | .312 | 2 | 3 | B71072 | B71572 |
| M6 X 1.00 | 3/16 | .170 | .500 | 2 1/2 | 3 | B71073 | B71573 |
| M8 X 0.75 | 1/4 | .235 | .625 | 2 1/2 | 3 | B71074 | B71574 |
| M8 X 1.00 | 1/4 | .235 | .625 | 2 1/2 | 3 | B71075 | B71575 |
| M8 X 1.25 | 1/4 | .235 | .625 | 2 1/2 | 3 | B71076 | B71576 |
| M10 X 1.25 | 5/16 | .300 | .750 | 3 | 4 | B71077 | B71577 |
| M10 X 1.50 | 5/16 | .300 | .750 | 3 | 4 | B71078 | B71578 |
| M12 X 1.00 | 3/8 | .360 | .875 | 3 1/2 | 4 | B71079 | B71579 |
| M12 X 1.25 | 3/8 | .360 | .875 | 3 1/2 | 4 | B71080 | B71580 |
| M12 X 1.75 | 3/8 | .360 | .875 | 3 1/2 | 4 | B71081 | B71581 |
| M14 X 1.50 | 3/8 | .360 | .875 | 3 1/2 | 4 | B71082 | B71582 |
| M16 X 2.00 | 1/2 | .470 | 1.250 | 3 1/2 | 5 | B71083 | B71583 |
| M18 X 2.50 | 1/2 | .470 | 1.250 | 3 1/2 | 5 | B71084 | B71584 |
| M20 X 3.00 | 1/2 | .470 | 1.250 | 3 1/2 | 5 | B71085 | B71585 |



Thread Mill Programming Request Form

Bassett offers free programming assistance to users of any Bassett thread milling product. If you are not familiar with thread milling, we highly recommend that you complete this program request form and fax it to 1-800-892-4290. The Technical Support department will return a suggested CNC program.

Enduser Company Name _____

Contact _____

Telephone Number _____

Email Address _____

Distributor Name _____

Distributor Telephone Number _____

Distributor or Enduser
Purchase Order Number _____

Thread Specifications:

Thread Type _____

RH/LH _____

Thread Diameter _____

TPI or Pitch (mm) _____

Class of Thread (1B, 2B, 3B) _____

Minimum Drilling Depth _____

Full Thread Length Min _____

Material _____

Material Hardness _____

CNC Machine Info

Brand _____

Model _____

Lathe _____

Milling Machine _____

Is machine capable of helical interpolation?
_____ yes _____ no

(if "no", machine cannot thread mill)

Tool Specs

Description _____

EDP MNumber _____

Tool Diameter _____

Number of Flutes _____

FAX TO
1-800-892-4290

CARBIDE END MILLS

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CARBIDE THREAD MILLS

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|-----------|--------------------------------------|----------|
| BA . . | Cylindrical, No End Cut | 47 |
| BAE . . | Cylindrical with End Cut | 47 |
| BC . . | Cylindrical, Ball Nose | 48 |
| BD . . | Ball Shape | 48 |
| BE . . | Egg Shape | 49 |
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| BN . . | Inverted Taper, No End Cut | 52 |

Standard Shank Styles



Shank A — 1/8" solid carbide



Shank B — 1/8" hardened steel



Shank C — 1/4" hardened steel



Shank D — 1/4" solid carbide

Recommended Bur Speeds (RPM)

| Bur Dia. | Standard Cut | | Monarch Cut | |
|----------|----------------------------------|--|----------------------------------|--|
| | stainless inconel titanium | all other materials in chart (right) | stainless inconel titanium | all other materials in chart (right) |
| 1/16 | 75,000 | 50,000 | 37,500 | 25,000 |
| 1/8 | 53,000 | 35,000 | 26,500 | 17,500 |
| 3/16 | 38,000 | 26,000 | 19,000 | 13,000 |
| 1/4 | 33,000 | 22,000 | 16,500 | 11,000 |
| 5/16 | 30,000 | 20,000 | 15,000 | 10,000 |
| 3/8 | 27,000 | 18,000 | 13,500 | 9,000 |
| 1/2 | 24,000 | 16,000 | 12,000 | 8,000 |
| 5/8 | 23,000 | 15,300 | 11,500 | 7,650 |
| 3/4 | 21,000 | 14,000 | 10,500 | 7,000 |
| 7/8 | 20,000 | 13,000 | 10,000 | 6,500 |
| 1 | 18,000 | 12,000 | 9,000 | 6,000 |

Run aluminum cut burs at approximately the same speed as end mills designed for aluminum when machine milling.

Shank

Bur Selection

when selecting a bur for a particular application, several factors must be taken into consideration.

The first is the selection of an appropriate shape and diameter that will be most suitable to the part being deburred. If working inside a slot, be certain that the maximum diameter of the bur is smaller than the slot. Secondly, shank size must be selected. The correct shank will be determined by the size of the equipment being used and considering the diameter and length of the fluted portion of the bur.

The last decision is which cut, or flute pattern, to select. This is determined by the hardness of the material being removed and the finish required.

- Standard (right-hand spiral) cut is a general-purpose flute pattern which is designed for use in cast iron, steel, and other ferrous metals.
- Double cut, a general-purpose tooth pattern, gives better control than the standard cut in off-band grinding. It minimizes slivers while producing a better finish. It can be used with slower speed grinders than standard cut.
- Aluminum (end mill) cut can be used for deburring softer, non-ferrous metals and non-metallic materials. The wide clearance and end mill type geometry of the flutes promotes fast stock removal with minimum loading.



standard cut



double cut



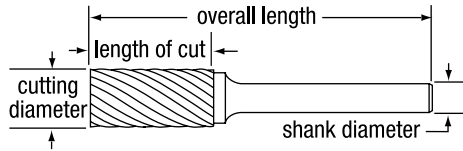
aluminum cut

Bur Selection by Material

| Workpiece Material | First Choice | Alternative |
|--------------------|--------------|--------------|
| aluminum | aluminum cut | - |
| brass | double cut | standard cut |
| bronze | double cut | standard cut |
| cast iron | double cut | standard cut |
| copper | aluminum cut | - |
| fiberglass | double cut | standard cut |
| inconel | double cut | standard cut |
| malleable iron | double cut | standard cut |
| magnesium | aluminum cut | - |
| masonite | double cut | standard cut |
| plastic | standard cut | - |
| steel alloy | double cut | - |
| carbon steel | double cut | - |
| stainless steel | double cut | - |
| titanium | double cut | - |
| zinc | aluminum cut | standard cut |

Cylindrical

Series BA, Cylindrical Burs without End Cut



Applications |

STEEL CAST IRON NON-FERROUS MATERIALS STAINLESS STEEL

Features |

SOLID CARBIDE STANDARD CUT BRIGHT



Applications |

STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL

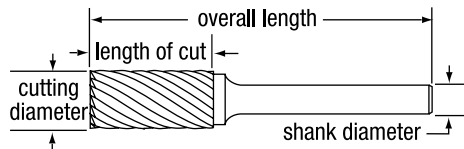
Features |

SOLID CARBIDE DOUBLE CUT BRIGHT



| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|
| | inch | decimal | | | | | standard | double |
| SA-41 | 1/16 | .0625 | 1/4 | 1 1/2 | 1/8 | A | B55600 | B55601 |
| SA-42 | 3/32 | .0938 | 7/16 | 1 1/2 | 1/8 | A | B55608 | B55609 |
| SA-43 | 1/8 | .1250 | 9/16 | 1 1/2 | 1/8 | A | B54801 | B54810 |
| SA-51 | 1/4 | .2500 | 1/2 | 1 3/4 | 1/8 | B | B55700 | B55712 |
| SA-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | D | B54802 | B54811 |
| SA-3 | 3/8 | .3750 | 3/4 | 2 1/2 | 1/4 | C | B54803 | B54812 |
| SA-5 | 1/2 | .5000 | 1 | 2 3/4 | 1/4 | C | B54804 | B54813 |
| SA-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | C | B54805 | B54814 |
| SA-7 | 3/4 | .7500 | 1 | 2 3/4 | 1/4 | C | B54806 | B54815 |
| SA-9 | 1 | 1.0000 | 1 | 2 3/4 | 1/4 | C | B54807 | B54816 |

Series BAE, Cylindrical Burs with End Cut



Applications |

STEEL CAST IRON NON-FERROUS MATERIALS STEEL

Features |

SOLID CARBIDE STANDARD CUT BRIGHT



Applications |

NON-FERROUS MATERIALS

Features |

SOLID CARBIDE DOUBLE CUT BRIGHT

Applications |

STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL

Features |

SOLID CARBIDE ALUMINUM CUT BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|----------|
| | inch | decimal | | | | | standard | double | aluminum |
| SB-41 | 1/16 | .0625 | 1/4 | 1 1/2 | 1/8 | A | B55604 | - | - |
| SB-42 | 3/32 | .0938 | 7/16 | 1 1/2 | 1/8 | A | B55612 | - | - |
| SB-43 | 1/8 | .1250 | 9/16 | 1 1/2 | 1/8 | A | B54837 | - | - |
| SB-51 | 1/4 | .2500 | 1/2 | 1 3/4 | 1/8 | A | B55701 | B55713 | - |
| SB-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | D | B54838 | B54847 | B55856 |
| SB-3 | 3/8 | .3750 | 3/4 | 2 1/2 | 1/4 | C | B54839 | B54848 | B55857 |
| SB-5 | 1/2 | .5000 | 1 | 2 3/4 | 1/4 | C | B54840 | B54849 | B55858 |
| SB-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | C | - | B54850 | B55859 |
| SB-7 | 3/4 | .7500 | 1 | 2 3/4 | 1/4 | C | - | B54851 | B55860 |
| SB-9 | 1 | 1.0000 | 1 | 2 3/4 | 1/4 | C | B54843 | - | - |

Shank Type: A – 1/8" (3mm) solid carbide. B – 1/8" (3mm) hardened steel. C – 1/4" (6mm) hardened steel. D – 1/4" (6mm) solid carbide

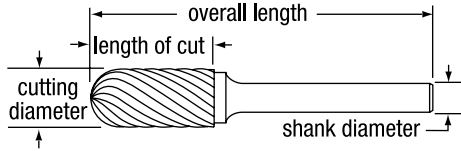


Cylindrical • Ball

BASSETT™

Series **BC**, Cylindrical Burs with Ball Nose

CARBIDE END MILLS



Applications

- STEEL
- CAST IRON
- NON-FERROUS MATERIALS
- STAINLESS STEEL

Features

- SOLID CARBIDE
- STANDARD CUT
- BRIGHT



CARBIDE DRILLS

Applications

- NON-FERROUS MATERIALS

Features

- SOLID CARBIDE
- ALUMINUM CUT
- BRIGHT

Applications

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- STAINLESS STEEL

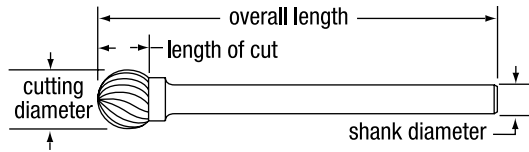
Features

- SOLID CARBIDE
- DOUBLE CUT
- BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | standard | EDP number | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|----------|------------|----------|
| | inch | decimal | | | | | | double | aluminum |
| SC-41 | 3/32 | .0938 | 7/16 | 1 1/2 | 1/8 | A | B55620 | B55621 | - |
| SC-42 | 1/8 | .1250 | 9/16 | 1 1/2 | 1/8 | A | B54873 | B54882 | - |
| SC-51 | 1/4 | .2500 | 1/2 | 1 3/4 | 1/8 | B | B55704 | B55716 | - |
| SC-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | A | B54874 | B54883 | B55862 |
| SC-3 | 3/8 | .3750 | 3/4 | 2 1/2 | 1/4 | A | B54875 | B54884 | B55863 |
| SC-5 | 1/2 | .5000 | 1 | 2 3/4 | 1/4 | A | B54876 | B54885 | B55864 |
| SC-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | A | B54877 | B54886 | - |
| SC-7 | 3/4 | .7500 | 1 | 2 3/4 | 1/4 | C | B54878 | B54887 | B55865 |

Series **BD**, Ball Shape

CARBIDE THREAD MILLS



Applications

- STEEL
- CAST IRON
- NON-FERROUS MATERIALS
- STAINLESS STEEL

Features

- SOLID CARBIDE
- STANDARD CUT
- BRIGHT



Applications

- NON-FERROUS MATERIALS

Features

- SOLID CARBIDE
- ALUMINUM CUT
- BRIGHT

Applications

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- STAINLESS STEEL

Features

- SOLID CARBIDE
- DOUBLE CUT
- BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | standard | EDP number | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|----------|------------|----------|
| | inch | decimal | | | | | | double | aluminum |
| SD-41 | 3/32 | .0938 | 3/32 | 1 1/2 | 1/8 | A | B55624 | B55625 | - |
| SD-42 | 1/8 | .1250 | 1/8 | 1 1/2 | 1/8 | A | B54909 | B54918 | - |
| SD-51 | 1/4 | .2500 | 1/4 | 1 3/4 | 1/8 | B | B55705 | B55717 | - |
| SD-1 | 1/4 | .2500 | 1/4 | 2 | 1/4 | D | B54910 | B54919 | B55867 |
| SD-3 | 3/8 | .3750 | 3/8 | 2 5/64 | 1/4 | C | B54911 | B54920 | B55868 |
| SD-5 | 1/2 | .5000 | 1/2 | 2 13/64 | 1/4 | C | B54912 | B54921 | B55869 |
| SD-6 | 5/8 | .6250 | 5/8 | 2 5/16 | 1/4 | C | B54913 | B54922 | - |
| SD-7 | 3/4 | .7500 | 3/4 | 2 7/16 | 1/4 | C | B54914 | B54923 | - |
| SD-9 | 1 | 1.0000 | 1 | 2 11/16 | 1/4 | C | B54915 | B54924 | - |

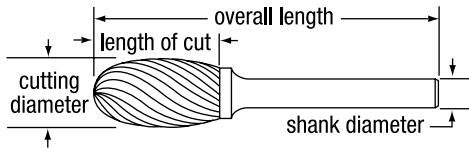
Shank Type: A — 1/8" (3mm) solid carbide. B — 1/8" (3mm) hardened steel. C — 1/4" (6mm) hardened steel. D — 1/4" (6mm) solid carbide

CARBIDE BURS

INDEX

Egg • Round Nose Tree

Series BE, Egg Shape



Applications | NON-FERROUS MATERIALS

Features | SOLID CARBIDE ALUMINUM CUT BRIGHT



Applications | STEEL CAST IRON NON-FERROUS MATERIALS STAINLESS STEEL

Features | SOLID CARBIDE STANDARD CUT BRIGHT

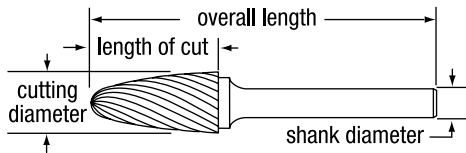


Applications | STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL

Features | SOLID CARBIDE DOUBLE CUT BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|----------|
| | inch | decimal | | | | | standard | double | aluminum |
| SE-41 | 1/8 | .1250 | 7/32 | 1 1/2 | 1/8 | A | B54945 | B54954 | - |
| SE-51 | 1/4 | .2500 | 3/8 | 1 5/8 | 1/8 | B | - | B55718 | - |
| SE-1 | 1/4 | .2500 | 3/8 | 2 | 1/4 | D | B54946 | B54955 | - |
| SE-3 | 3/8 | .3750 | 5/8 | 2 3/8 | 1/4 | C | B54947 | B54956 | B55873 |
| SE-5 | 1/2 | .5000 | 7/8 | 2 5/8 | 1/4 | C | B54948 | B54957 | B55874 |
| SE-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | C | - | - | B55875 |
| SE-7 | 3/4 | .7500 | 1 | 2 3/4 | 1/4 | C | B54950 | B54959 | - |

Series BF, Round Nose Tree Shape



Applications | NON-FERROUS MATERIALS

Features | SOLID CARBIDE ALUMINUM CUT BRIGHT



Applications | STEEL CAST IRON NON-FERROUS MATERIALS STAINLESS STEEL

Features | SOLID CARBIDE STANDARD CUT BRIGHT



Applications | STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL

Features | SOLID CARBIDE DOUBLE CUT BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|----------|
| | inch | decimal | | | | | standard | double | aluminum |
| SF-41 | 1/8 | .1250 | 1/4 | 1 1/2 | 1/8 | A | B55628 | B55629 | - |
| SF-42 | 1/8 | .1250 | 1/2 | 1 1/2 | 1/8 | A | B54981 | B54990 | - |
| SF-51 | 1/4 | .2500 | 1/2 | 1 3/4 | 1/8 | B | B55707 | B55719 | - |
| SF-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | D | B54982 | B54991 | B55878 |
| SF-3 | 3/8 | .3750 | 3/4 | 2 1/2 | 1/4 | C | B54983 | B54992 | B55879 |
| SF-5 | 1/2 | .5000 | 1 | 2 3/4 | 1/4 | C | B54984 | B54993 | B55880 |
| SF-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | C | B54985 | B54994 | B55881 |
| SF-7 | 3/4 | .7500 | 1 | 2 3/4 | 1/4 | C | B54986 | B54995 | - |

Shank Type: A – 1/8" (3mm) solid carbide. B – 1/8" (3mm) hardened steel. C – 1/4" (6mm) hardened steel. D – 1/4" (6mm) solid carbide

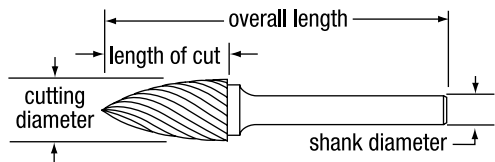


Pointed Tree • Flame Shape

BASSETT™

Series **BG**, Pointed Tree Shape

CARBIDE END MILLS



Applications | **STEEL** | **CAST IRON** | **NON-FERROUS MATERIALS** | **STAINLESS STEEL**

Features | **SOLID CARBIDE** | **STANDARD CUT** | **BRIGHT**



CARBIDE DRILLS

Applications | **STEEL** | **CAST IRON** | **HI-TEMP ALLOYS** | **STAINLESS STEEL**

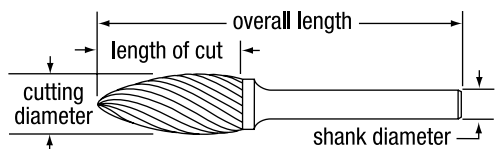
Features | **SOLID CARBIDE** | **DOUBLE CUT** | **BRIGHT**

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|
| | inch | decimal | | | | | standard | double |
| SG-42 | 1/8 | .1250 | 5/16 | 1 1/2 | 1/8 | A | B55636 | B55637 |
| SG-43 | 1/8 | .1250 | 3/8 | 1 1/2 | 1/8 | A | B55017 | B55026 |
| SG-41 | 1/8 | .1250 | 1/4 | 1 1/2 | 1/8 | A | B55632 | B55633 |
| SG-51 | 1/4 | .2500 | 1/2 | 1 3/4 | 1/8 | B | - | B55720 |
| SG-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | D | B55018 | B55027 |
| SG-3 | 3/8 | .3750 | 3/4 | 2 1/2 | 1/4 | C | B55019 | B55028 |
| SG-5 | 1/2 | .5000 | 1 | 2 3/4 | 1/4 | C | B55020 | B55029 |
| SG-6 | 5/8 | .6250 | 1 | 2 3/4 | 1/4 | C | B55021 | B55030 |

CARBIDE THREAD MILLS

Series **BH**, Flame Shape

CARBIDE BURS



Applications | **STEEL** | **CAST IRON** | **NON-FERROUS MATERIALS** | **STAINLESS STEEL**

Features | **SOLID CARBIDE** | **STANDARD CUT** | **BRIGHT**



Applications | **STEEL** | **CAST IRON** | **HI-TEMP ALLOYS** | **STAINLESS STEEL**

Features | **SOLID CARBIDE** | **DOUBLE CUT** | **BRIGHT**

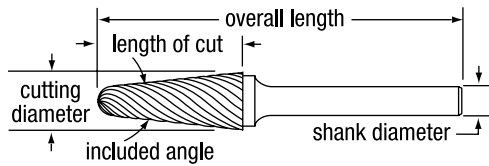
| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|
| | inch | decimal | | | | | standard | double |
| SH-41 | 1/8 | .1250 | 1/4 | 1 1/2 | 1/8 | A | B55053 | B55060 |
| SH-2 | 5/16 | .3125 | 3/4 | 2 1/2 | 1/4 | C | B55054 | B55061 |
| SH-5 | 1/2 | .5000 | 1 1/4 | 3 | 1/4 | C | B55055 | B55062 |

INDEX

Shank Type: A — 1/8" (3mm) solid carbide. B — 1/8" (3mm) hardened steel. C — 1/4" (6mm) hardened steel. D — 1/4" (6mm) solid carbide

14° Included Cone, Radius • Pointed Cone

Series **BL**, 14° Included Cone Radius Shape



- Applications** | STEEL CAST IRON NON-FERROUS MATERIALS STAINLESS STEEL
- Features** | SOLID CARBIDE STANDARD CUT BRIGHT



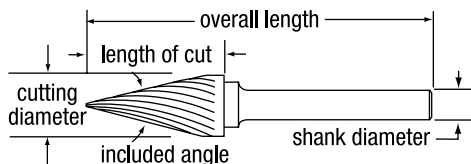
- Applications** | NON-FERROUS MATERIALS
- Features** | SOLID CARBIDE ALUMINUM CUT BRIGHT



- Applications** | STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL
- Features** | SOLID CARBIDE DOUBLE CUT BRIGHT

| SCTI reference | cutting diameter | | length of cut | overall length | shank diameter | shank type | standard | EDP number | | |
|----------------|------------------|---------|---------------|----------------|----------------|------------|----------|------------|----------|--|
| | inch | decimal | | | | | | double | aluminum | |
| SL-41 | 1/8 | .1250 | 3/8 | 1 1/2 | 1/8 | A | B55640 | B55641 | - | |
| SL-42 | 1/8 | .1250 | 1/2 | 1 1/2 | 1/8 | A | B55145 | B55154 | - | |
| SL-1 | 1/4 | .2500 | 5/8 | 2 | 1/4 | D | B55146 | B55155 | - | |
| SL-3 | 3/8 | .3750 | 1 1/16 | 2 15/16 | 1/4 | C | B55147 | B55156 | - | |
| SL-4 | 1/2 | .5000 | 1 1/8 | 3 | 1/4 | C | B55148 | B55157 | B55884 | |
| SL-6 | 5/8 | .6250 | 1 5/16 | 3 3/16 | 1/4 | C | B55149 | B55158 | B55885 | |

Series **BM**, Pointed Cone Shape



- Applications** | STEEL CAST IRON NON-FERROUS MATERIALS STAINLESS STEEL
- Features** | SOLID CARBIDE STANDARD CUT BRIGHT



- Applications** | STEEL CAST IRON HI-TEMP ALLOYS STAINLESS STEEL
- Features** | SOLID CARBIDE DOUBLE CUT BRIGHT

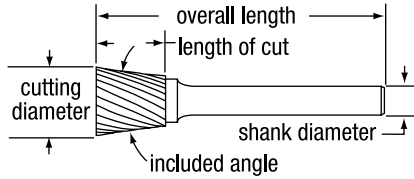
| SCTI reference | included angle | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | |
|----------------|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|
| | | inch | decimal | | | | | standard | double |
| SM-41 | 12° | 1/8 | .1250 | 3/8 | 1 1/2 | 1/8 | A | B55644 | B55645 |
| SM-42 | 14° | 1/8 | .1250 | 7/16 | 1 1/2 | 1/8 | A | B55181 | B55190 |
| SM-43 | 7° | 1/8 | .1250 | 5/8 | 1 1/2 | 1/8 | A | B55648 | B55649 |
| SM-51 | 22° | 1/4 | .2500 | 1/2 | 1 7/8 | 1/8 | B | B55709 | B55721 |
| SM-1 | 22° | 1/4 | .2500 | 1/2 | 2 | 1/4 | D | B55182 | B55191 |
| SM-3 | 10° | 1/4 | .2500 | 1 | 2 | 1/4 | C | B55183 | B55192 |
| SM-4 | 28° | 3/8 | .3750 | 5/8 | 2 1/2 | 1/4 | C | B55184 | B55193 |
| SM-5 | 28° | 1/2 | .5000 | 7/8 | 2 3/4 | 1/4 | C | B55185 | B55194 |

Shank Type: A – 1/8" (3mm) solid carbide. B – 1/8" (3mm) hardened steel. C – 1/4" (6mm) hardened steel. D – 1/4" (6mm) solid carbide



Inverted Taper

Series **BN**, Inverted Taper Shape



Applications |

- STEEL
- CAST IRON
- NON-FERROUS MATERIALS
- STAINLESS STEEL

Features |

- SOLID CARBIDE
- STANDARD CUT
- BRIGHT



Applications |

- STEEL
- CAST IRON
- H-TEMP ALLOYS
- STAINLESS STEEL

Features |

- SOLID CARBIDE
- DOUBLE CUT
- BRIGHT

| SCTI reference | included angle | cutting diameter | | length of cut | overall length | shank diameter | shank type | EDP number | |
|----------------|----------------|------------------|---------|---------------|----------------|----------------|------------|------------|--------|
| | | inch | decimal | | | | | standard | double |
| SN-41 | – | 3/32 | .0938 | 3/16 | 1 1/2 | 1/8 | A | B55652 | – |
| SN-51 | 10° | 1/4 | .2500 | 1/4 | 1 1/2 | 1/8 | A | B55710 | B55722 |

Shank Type: A – 1/8" (3mm) solid carbide. B – 1/8" (3mm) hardened steel. C – 1/4" (6mm) hardened steel. D – 1/4" (6mm) solid carbide



BASSETT™



Index by EDP Number



| | EDP Number | Style Number | Page Number | EDP Number | Style Number | Page Number | EDP Number | Style Number | Page Number | EDP Number | Style Number | Page Number |
|----------------------|------------|--------------|-------------|------------|--------------|-------------|------------|--------------|-------------|------------|--------------|-------------|
| CARBIDE END MILLS | B01318 | MSE-2-TC | 18 | B01403 | MSE-4-TC | 26 | B01483 | MSE-4-TC | 25 | B01592 | MDE-4-TC | 17 |
| | B01319 | MSE-2-TC | 18 | B01405 | MSE-4-TC | 26 | B01484 | MSE-4-TC | 25 | B01593 | MDE-4-TC | 17 |
| | B01320 | MSE-2-TC | 19 | B01407 | MSE-4-TC | 26 | B01485 | MSE-4-TC | 25 | B01594 | MDE-4-TC | 17 |
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Metalcutting Safety

(read this before using Bassettproducts)

Modern metalcutting operations involve high energy, high spindle or cutter speeds, and high temperatures and cutting forces. Hot, flying chips may be projected from the workpiece during metalcutting. Although advanced cutting tool materials are designed and manufactured to withstand the high cutting forces and temperatures that normally occur in these operations, they are susceptible to fragmenting in service, particularly if they are subjected to over-stress, severe impact or otherwise abused. Therefore, precautions should be taken to adequately protect workers, observers and equipment against hot, flying chips, fragmented cutting tools, broken workpieces or other similar projectiles. Machines should be fully guarded and personal protective equipment should be used at all times.

When grinding advanced cutting tool materials, a suitable means for collection and disposal of dust, mist or sludge should be provided. Overexposure to dust or mist containing metallic particles can be hazardous to health particularly if exposure continues over an extended period of time and may cause eye, skin and mucous membrane irritation and temporary or permanent respiratory disease. Certain existing pulmonary and skin conditions may be aggravated by exposure to dust or mist. Adequate ventilation, respiratory protection and eye protection should be provided when grinding and workers should avoid breathing of and prolonged skin contact with dust or mist. General Industry Safety and Health

Regulations, Part 1910. U.S. Department of Labor, published in Title 29 of the Code of Federal Regulations should be consulted. Obtain from Bassett/Putnam and read the applicable Material Safety Data Sheet before grinding.

Cutting tools are only one part of the worker-machine-tool system. Many variables exist in machining operations, including the metal removal rate; the workpiece size, shape, strength and rigidity; the chucking and fixturing; the load carrying capability of centers; the cutter and spindle speed and torque limitations; the holder and boring bar overhang; the available power; and the condition of the tooling and the machine. A safe metalcutting operation must take all of these variables, and others, into consideration.

Bassett/Putnam has no control over the end use of its products or the environment into which those products are placed. Bassett/Putnam urges that its customers adhere to the recommended standards of use of their metalcutting machines and tools, and that they follow procedures that ensure safe metalcutting operations. The information included throughout this catalog under the heading "Technical Data" and other recommendations on machining practices referred to herein are only advisory in nature and do not constitute representations or warranties and are not necessarily appropriate for any particular work environment or application.



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