



**BASSETT™**



***Solid Carbide Cutting Tools***  
***End Mills • Drills • Thread Mills • Burs***



**GREENFIELD  
INDUSTRIES**

**Index by Style Number**



**BASSETT™**

Style	Page Number
BA.....	54
BAE.....	54
BC.....	55
BD.....	55
BE.....	56
BF.....	56
BG.....	57
BH.....	57
BL.....	58
BM.....	58
BN.....	59
DC.....	45
DHP-5.....	38
DHPCF-5.....	39
DHPCF-8.....	40
DM.....	44-45
DR.....	41-42
DRS.....	42-43
DS.....	45

Style	Page Number
HPAM-2.....	15
HPAM-3.....	16
HPDEM-5.....	10
HPEM-3.....	11
HPEM-5.....	12
HPEM-6.....	13
MCH-2D.....	35
MCH-2R.....	35
MCH-4D.....	35
MCH-4R.....	35
MDE-2.....	20
MDE-2B.....	21
MDE-4.....	22
MDE-4B.....	23
MEG-2.....	34
MRA.....	18
MRS.....	17
MSE-2.....	24-25
MSE-2B.....	26-27

Style	Page Number
MSE-3.....	28
MSE-4.....	29-31
MSE-4B.....	32-33
MSEST-2.....	34
MSEV4B.....	5
MSEV-4R.....	3-5
MSEV25R.....	6-8
TM.....	48
TMC.....	48
TMBPP.....	49
TMBPPC.....	49
TMBPT.....	49
TMBPTC.....	49
TMM.....	50
TMMC.....	50
TMNP.....	49
TMNPC.....	49

**Metalcutting Safety** (read this before using Bassett 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 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 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 has no control over the end use of its products or the environment into which those products are placed. Bassett 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 world-wide. 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***

End Mills . . . . .	1-35
Drills. . . . .	36-45
Thread Mills. . . . .	46-51
Burs. . . . .	52-59
Index by EDP Number. . . . .	60-70

**NEW**  
**New**  
Mini Thread Mills  
*see page 51*  
**New**  
Extention Burs  
*start on page 53*



**GREENFIELD  
INDUSTRIES**

*a brand of*





**BASSETT**™



## ***Solid Carbide End Mills***





Contents

Style No.	Flutes	Description	Finish	Page No.
<b>High-Performance Variable Index End Mills</b>				
Operating Parameters				2
MSE-V-4R	.4-flute	.corner radius	bright, TiAlN	3-5
MSE-V-4B	.4-flute	.ball nose	bright, TiAlN	5
MSE-V2-5R	.5-flute	.corner radius	bright, TiAlN	6-8
<b>High-Performance End Mills for Steel and Stainless Steel</b>				
Operating Parameters				9
HPDEM-5	.5-flute	.square end, double end	bright, TiCN, TiAlN	10
HPEM-3	.3-flute	.square end	bright, TiCN, TiAlN	11
HPEM-5	.5-flute	.square end	bright, TiCN, TiAlN	12
HPEM-6	.6-flute	.square end	bright, TiAlN	13
<b>High-Performance End Mills for Aluminum</b>				
Operating Parameters				14
HPAM-2	.2-flute	.square end	bright, TiCN	15
HPAM-3	.3-flute	.square end	bright, TiCN	16
<b>High-Performance Roughing End Mills</b>				
Operating Parameters				17
MRS	.multi-flute	.square end . . . for steel	bright, TiCN	17
MRA	.multi-flute	.square end . . . for aluminum	bright, TiCN	18
<b>General-Purpose End Mills</b>				
Operating Parameters				19
<b>Double End</b>				
MDE-2	.2-flute	.square end	bright, TiCN	20
MDE-2B	.2-flute	.ball nose	bright, TiCN	21
MDE-4	.4-flute	.square end	bright, TiCN	22
MDE-4B	.4-flute	.ball nose	bright, TiCN	23
<b>Single End</b>				
MSE-2	.2-flute	.square end	bright, TiCN	24-25
MSE-2B	.2-flute	.ball nose	bright, TiCN	26-27
MSE-3	.3-flute	.square end	bright, TiCN	28
MSE-4	.4-flute	.square nose	bright, TiCN	29-31
MSE-4B	.4-flute	.ball nose	bright, TiCN	32-33
<b>Straight Flute</b>				
MSEST-2	.2-flute	.square end	bright	34
<b>Engraving Tool</b>				
MEG-2	.2-flute	.ball nose	TiCN	34
<b>Chamfer Tools</b>				
MCH-2R	.2-flute	.single end	bright	35
MCH-2D	.2-flute	.double end	bright	35
MCH-4R	.4-flute	.single end	bright	35
MCH-4D	.4-flute	.double end	bright	35

**Tolerances for Solid Carbide End Mills**

Cutting Diameter:  
1/32" through 1" +.000 -.002

Shank Diameter:  
h6

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

**Solid Carbide End Mills**



**BASSETT™**

**Variable Index End Mills**

**Operating Parameters for Series MSE-V-4\* Variable Index End Mills**

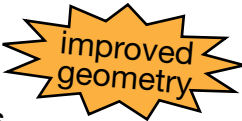
*regular and stub length*      side milling axial 1.5 x D • side milling radial .5 x D • slotting axial 1 x D

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 (303)	340	0.0010	0.0012	0.0016	0.0020	0.0024	0.0026	0.0028	0.0028	0.0030
moderately difficult to cut stainless (304)	290	0.0008	0.0010	0.0014	0.0018	0.0020	0.0022	0.0024	0.0026	0.0028
difficult to cut stainless steels (316L)	240	0.0006	0.0010	0.0012	0.0016	0.0018	0.0020	0.0022	0.0024	0.0024
soft steels (1020)	600	0.0010	0.0012	0.0016	0.0024	0.0024	0.0028	0.0030	0.0031	0.0039
titanium alpha beta alloys (Ti6Al4V)	200	0.0005	0.0006	0.0008	0.0012	0.0012	0.0016	0.0018	0.0020	0.0028
gray cast iron (GG)	600	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 (303)	340	0.0009	0.0011	0.0014	0.0018	0.0022	0.0023	0.0025	0.0025	0.0027
moderately difficult to cut stainless (304)	290	0.0007	0.0009	0.0013	0.0016	0.0018	0.0020	0.0022	0.0023	0.0025
difficult to cut stainless steel (316L)	240	0.0005	0.0009	0.0011	0.0014	0.0016	0.0018	0.0020	0.0022	0.0022
soft steels (1020)	600	0.0009	0.0011	0.0014	0.0022	0.0022	0.0025	0.0027	0.0028	0.0035
titanium alpha beta alloys (Ti6Al4V)	200	0.0005	0.0005	0.0007	0.0011	0.0011	0.0014	0.0016	0.0018	0.0025
gray cast iron (GG)	600	0.0009	0.0011	0.0014	0.0022	0.0022	0.0025	0.0027	0.0028	0.0035

**Operating Parameters for Series MSE-V2-5\* 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	600-750	0.0015	0.0021	0.0023	0.0026	0.0028	0.0030	0.0031	0.0039
alloy steels and tool steels <330HB, <35HRc	600-700	0.0011	0.0017	0.0020	0.0023	0.0028	0.0030	0.0031	0.0039
alloy steels and tool steels 340-450 HB, 36-48 HRc	525-625	0.0010	0.0015	0.0016	0.0020	0.0028	0.0030	0.0031	0.0039
austenitic stainless steel 302, 303, 304	350-445	0.0011	0.0017	0.0020	0.0023	0.0022	0.0024	0.0026	0.0028
austenitic stainless steel 316, 316L	225-315	0.0009	0.0013	0.0016	0.0019	0.0020	0.0024	0.0024	0.0024
austenitic stainless steel duplex 0.0024	190-230		0.0008	0.0010	0.0014	0.0015	0.0020	0.0024	0.0024
cast iron, gray GG	520-660	0.0014	0.0022	0.0025	0.0030	0.0028	0.0030	0.0031	0.0039
ductile and maleable cast iron CGI < 80 KSI	430-660	0.0009	0.0013	0.0018	0.0019	0.0028	0.0030	0.0031	0.0039
nickel-based heat-resistant alloys	100-160	0.0004	0.0007	0.0011	0.0015	0.0016	0.0019	0.0023	0.0028
alpha-beta titanium alloys Ti6Al4V	195-240	0.0008	0.0010	0.0014	0.0015	0.0016	0.0018	0.0020	0.0028



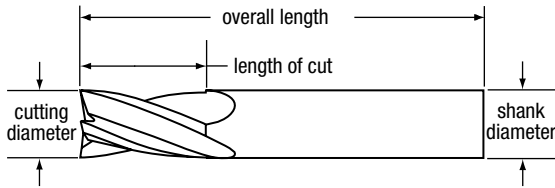
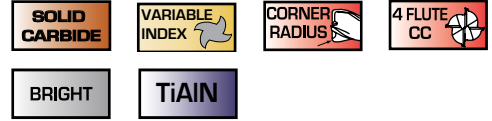
# Variable Index End Mills for Ferrous Materials

## Series MSE-V-4R

### Applications |



### Features |



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiAIN
1/8	.1250	3.18	1/8	1/4	1-1/2	4	0.000	B40165	B60165
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	0.000	B40166	B60166
1/8	.1250	3.18	1/8	3/8	1-1/2	4	0.010	B40141	B60141
1/8	.1250	3.18	1/8	1/2	1-1/2	4	0.000	B40231	B60231
1/8	.1250	3.18	1/8	1/2	1-1/2	4	0.010	B40232	B60232
3/16	.1875	4.76	3/16	3/8	2	4	0.000	B40167	B60167
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	0.000	B40168	B60168
3/16	.1875	4.76	3/16	7/16	2	4	0.010	B40143	B60143
3/16	.1875	4.76	3/16	3/4	2-1/2	4	0.000	B40169	B60169
3/16	.1875	4.76	3/16	3/4	2-1/2	4	0.010	B40170	B60170
1/4	.2500	6.35	1/4	1/2	2	4	0.000	B40171	B60171
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	0.000	B40172	B60172
1/4	.2500	6.35	1/4	3/4	2-1/2	4	0.020	B40145	B60145
1/4	.2500	6.35	1/4	3/4	2-1/2	4	0.045	B40234	B60234
1/4	.2500	6.35	1/4	1-1/8	3	4	0.000	B40173	B60173
1/4	.2500	6.35	1/4	1-1/8	3	4	0.020	B40146	B60146
1/4	.2500	6.35	1/4	1-1/4	3	4	0.000	B40233	B60233
5/16	.3125	7.94	5/16	1/2	2	4	0.000	B40174	B60174
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	0.000	B40175	B60175
5/16	.3125	7.94	5/16	13/16	2-1/2	4	0.020	B40148	B60148
5/16	.3125	7.94	5/16	1-1/4	3	4	0.000	B40176	B60176
5/16	.3125	7.94	5/16	1-1/4	3	4	0.020	B40177	B60177
3/8	.3750	9.53	3/8	5/8	2	4	0.000	B40178	B60178
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	0.000	B40179	B60179
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	0.000	B40180	B60180
3/8	.3750	9.53	3/8	1-1/8	3	4	0.020	B40151	B60151
3/8	.3750	9.53	3/8	2	4	4	0.000	B40181	B60181
3/8	.3750	9.53	3/8	2	4	4	0.020	B40182	B60182
7/16	.4375	11.11	7/16	5/8	2-1/2	4	0.000	B40183	B60183
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	0.000	B40184	B60184
7/16	.4375	11.11	7/16	1	3	4	0.020	B40153	B60153
7/16	.4375	11.11	7/16	2	4	4	0.000	B40185	B60185

continued on next page



**Solid Carbide End Mills**



**BASSETT™**

**Variable Index End Mills for Ferrous Materials**

Series **MSE-V-4R (continued)**

	cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
	fractional	decimal	metric						bright	TiAIN
	1/2	.5000	12.70	1/2	5/8	2-1/2	4	0.000	B40186	B60186
	1/2	.5000	12.70	1/2	5/8	2-1/2	4	0.020	B40237	B60237
	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	0.000	B40187	B60187
	1/2	.5000	12.70	1/2	1	3	4	0.030	B40155	B60155
	1/2	.5000	12.70	1/2	1	3	4	0.060	B40188	B60188
	1/2	.5000	12.70	1/2	1	3	4	0.090	B40189	B60189
	1/2	.5000	12.70	1/2	1	3	4	0.125	B40190	B60190
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.000	B40191	B60191
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.020	B40238	B60238
	1/2	.5000	12.70	1/2 *	1-1/4	3	4	0.020	-----	B60235
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.030	B40192	B60192
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.060	B40193	B60193
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.090	B40194	B60194
	1/2	.5000	12.70	1/2	1-1/4	3	4	0.125	B40195	B60195
	1/2	.5000	12.70	1/2	2	4	4	0.000	B40196	B60196
	1/2	.5000	12.70	1/2	2	4	4	0.030	B40156	B60156
	1/2	.5000	12.70	1/2	2	4	4	0.060	B40197	B60197
	1/2	.5000	12.70	1/2	2	4	4	0.090	B40198	B60198
	1/2	.5000	12.70	1/2	2	4	4	0.125	B40199	B60199
	5/8	.6250	15.88	5/8	3/4	3	4	0.000	B40200	B60200
	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	0.000	B40201	B60201
	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	1-1/4	3-1/2	4	0.060	B40202	B60202
	5/8	.6250	15.88	5/8	1-1/4	3-1/2	4	0.090	B40203	B60203
	5/8	.6250	15.88	5/8	1-1/4	3-1/2	4	0.125	B40204	B60204
	5/8	.6250	15.88	5/8	2-1/4	5	4	0.000	B40205	B60205
	5/8	.6250	15.88	5/8	2-1/4	5	4	0.030	B40159	B60159
	5/8	.6250	15.88	5/8	2-1/4	5	4	0.060	B40206	B60206
	5/8	.6250	15.88	5/8	2-1/4	5	4	0.090	B40207	B60207
	5/8	.6250	15.88	5/8	2-1/4	5	4	0.125	B40208	B60208
	3/4	.7500	19.05	3/4	7/8	3	4	0.030	B40236	B60236
	3/4	.7500	19.05	3/4	1	3	4	0.000	B40209	B60209
	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	0.000	B40210	B60210
	3/4	.7500	19.05	3/4	1-1/2	4	4	0.030	B40161	B60161
	3/4	.7500	19.05	3/4	1-1/2	4	4	0.060	B40211	B60211
	3/4	.7500	19.05	3/4	1-1/2	4	4	0.090	B40212	B60212
	3/4	.7500	19.05	3/4	1-1/2	4	4	0.125	B40213	B60213
	3/4	.7500	19.05	3/4	2-1/4	5	4	0.000	B40214	B60214
	3/4	.7500	19.05	3/4	2-1/4	5	4	0.030	B40162	B60162
	3/4	.7500	19.05	3/4	2-1/4	5	4	0.060	B40215	B60215
	3/4	.7500	19.05	3/4	2-1/4	5	4	0.090	B40216	B60216
	3/4	.7500	19.05	3/4	2-1/4	5	4	0.125	B40217	B60217

\* Weldon shank; all others plain shank

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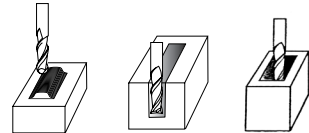
# Variable Index End Mills for Ferrous Materials

## Series MSE-V-4R (continued)

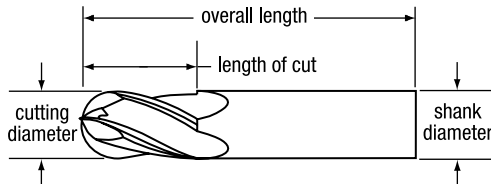
cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiAIN
1	1.0000	25.40	1	1-1/2	4	4	0.000	B40218	B60218
1	1.0000	25.40	1	1-1/2	4	4	0.030	B40163	B60163
1	1.0000	25.40	1	1-1/2	4	4	0.060	B40219	B60219
1	1.0000	25.40	1	1-1/2	4	4	0.090	B40220	B60220
1	1.0000	25.40	1	1-1/2	4	4	0.125	B40221	B60221
1	1.0000	25.40	1	2-1/4	5	4	0.000	B40222	B60222
1	1.0000	25.40	1	2-1/4	5	4	0.030	B40164	B60164
1	1.0000	25.40	1	2-1/4	5	4	0.060	B40223	B60223
1	1.0000	25.40	1	2-1/4	5	4	0.090	B40224	B60224
1	1.0000	25.40	1	2-1/4	5	4	0.125	B40225	B60225
1	1.0000	25.40	1	3	6	4	0.000	B40226	B60226
1	1.0000	25.40	1	3	6	4	0.030	B40227	B60227
1	1.0000	25.40	1	3	6	4	0.060	B40228	B60228
1	1.0000	25.40	1	3	6	4	0.090	B40229	B60229
1	1.0000	25.40	1	3	6	4	0.125	B40230	B60230

## Series MSE-V-4B

### Applications



### Features



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP Number	
fractional	decimal	metric					bright	TiAIN
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	5/8	2-1/2	4	B40390	B70190
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

Solid Carbide End Mills



V2 Variable Index End Mills for Ferrous Materials

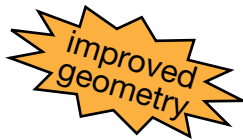
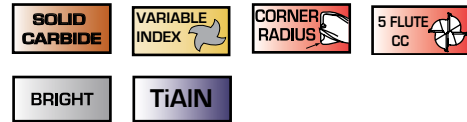
**BASSETT™**

Series **MSE-V2-5R**

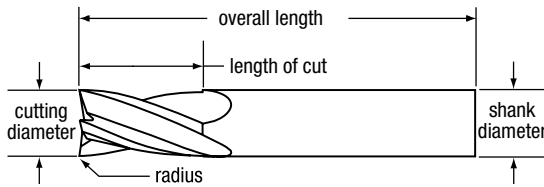
Applications |



Features |



- 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	0.000	B40410	B60410
3/16	.1875	4.76	3/16	3/8	2	5	0.010	B40411	B60411
3/16	.1875	4.76	3/16	7/16	2	5	0.000	B40434	B60434
3/16	.1875	4.76	3/16	7/16	2	5	0.010	B40412	B60412
3/16	.1875	4.76	3/16	3/4	2-1/2	5	0.000	B40435	B60435
3/16	.1875	4.76	3/16	3/4	2-1/2	5	0.010	B40436	B60436
6mm	0.2362	6mm	6mm	13mm	50mm	5	.5mm	B40499	B70199
1/4	.2500	6.35	1/4	1/2	2	5	0.000	B40437	B60437
1/4	.2500	6.35	1/4	1/2	2	5	0.020	B40413	B60413
1/4	.2500	6.35	1/4	3/4	2-1/2	5	0.000	B40438	B60438
1/4	.2500	6.35	1/4	3/4	2-1/2	5	0.020	B40414	B60414
1/4	.2500	6.35	1/4	1-1/8	3	5	0.010	B40439	B60439
1/4	.2500	6.35	1/4	1-1/8	3	5	0.020	B40415	B60415
1/4	.2500	6.35	1/4	1-1/4	3	5	0.000	B40440	B60440
5/16	.3125	7.94	5/16	1/2	2	5	0.000	B40441	B60441
5/16	.3125	7.94	5/16	1/2	2	5	0.020	B40416	B60416
5/16	.3125	7.94	5/16	13/16	2-1/2	5	0.000	B40442	B60442
5/16	.3125	7.94	5/16	13/16	2-1/2	5	0.020	B40417	B60417
5/16	.3125	7.94	5/16	1-1/4	3	5	0.000	B40443	B60443
5/16	.3125	7.94	5/16	1-1/4	3	5	0.020	B40444	B60444
3/8	.3750	9.53	3/8	1/2	2	5	0.030	B40320	B60320
3/8	.3750	9.53	3/8	5/8	2	5	0.000	B40445	B60445
3/8	.3750	9.53	3/8	5/8	2	5	0.020	B40418	B60418
3/8	.3750	9.53	3/8	7/8	2-1/2	5	0.000	B40446	B60446
3/8	.3750	9.53	3/8	7/8	2-1/2	5	0.020	B40419	B60419
3/8	.3750	9.53	3/8	1-1/8	3	5	0.000	B40447	B60447
3/8	.3750	9.53	3/8	1-1/8	3	5	0.020	B40420	B60420
3/8	.3750	9.53	3/8	2	4	5	0.000	B40448	B60448
3/8	.3750	9.53	3/8	2	4	5	0.020	B40449	B60449
7/16	.4375	11.11	7/16	5/8	2-1/2	5	0.000	B40450	B60450
7/16	.4375	11.11	7/16	5/8	2-1/2	5	0.020	B40421	B60421
7/16	.4375	11.11	7/16	1	3	5	0.000	B40451	B60451
7/16	.4375	11.11	7/16	1	3	5	0.020	B40422	B60422
7/16	.4375	11.11	7/16	2	4	5	0.000	B40452	B60452

continued on next page

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX





# V2 Variable Index End Mills for Ferrous Materials

## Series MSE-V2-5R (continued)

cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiAIN
1/2	.5000	12.70	1/2	5/8	2-1/2	5	0.000	B40453	B60453
1/2	.5000	12.70	1/2	5/8	2-1/2	5	0.030	B40423	B60423
1/2	.5000	12.70	1/2	1	3	5	0.000	B40454	B60454
1/2	.5000	12.70	1/2 *	1	3	5	0.020	B40321	B60321
1/2	.5000	12.70	1/2	1	3	5	0.030	B40424	B60424
1/2	.5000	12.70	1/2 *	1	3	5	0.030	B40322	B60322
1/2	.5000	12.70	1/2	1	3	5	0.060	B40455	B60455
1/2	.5000	12.70	1/2	1	3	5	0.090	B40456	B60456
1/2	.5000	12.70	1/2	1	3	5	0.125	B40457	B60457
1/2	.5000	12.70	1/2	1-1/4	3	5	0.000	B40458	B60458
1/2	.5000	12.70	1/2	1-1/4	3	5	0.020	B40323	B60323
1/2	.5000	12.70	1/2	1-1/4	3	5	0.030	B40459	B60459
1/2	.5000	12.70	1/2 *	1-1/4	3	5	0.030	B40324	B60324
1/2	.5000	12.70	1/2 *	1-1/4	3	5	0.045	B40325	B60325
1/2	.5000	12.70	1/2	1-1/4	3	5	0.060	B40460	B60460
1/2	.5000	12.70	1/2	1-1/4	3	5	0.090	B40461	B60461
1/2	.5000	12.70	1/2	1-1/4	3	5	0.125	B40462	B60462
1/2	.5000	12.70	1/2	2	4	5	0.000	B40463	B60463
1/2	.5000	12.70	1/2	2	4	5	0.030	B40425	B60425
1/2	.5000	12.70	1/2	2	4	5	0.060	B40464	B60464
1/2	.5000	12.70	1/2	2	4	5	0.090	B40465	B60465
1/2	.5000	12.70	1/2	2	4	5	0.125	B40466	B60466
5/8	.6250	15.88	5/8	3/4	3	5	0.000	B40467	B60467
5/8	.6250	15.88	5/8	3/4	3	5	0.030	B40426	B60426
5/8	.6250	15.88	5/8	1-1/4	3-1/2	5	0.000	B40468	B60468
5/8	.6250	15.88	5/8	1-1/4	3-1/2	5	0.030	B40427	B60427
5/8	.6250	15.88	5/8	1-1/4	3-1/2	5	0.060	B40469	B60469
5/8	.6250	15.88	5/8	1-1/4	3-1/2	5	0.090	B40470	B60470
5/8	.6250	15.88	5/8	1-1/4	3-1/2	5	0.125	B40471	B60471
5/8	.6250	15.88	5/8	2-1/4	5	5	0.000	B40472	B60472
5/8	.6250	15.88	5/8	2-1/4	5	5	0.030	B40428	B60428
5/8	.6250	15.88	5/8	2-1/4	5	5	0.060	B40473	B60473
5/8	.6250	15.88	5/8	2-1/4	5	5	0.090	B40474	B60474
5/8	.6250	15.88	5/8	2-1/4	5	5	0.125	B40475	B60475
3/4	.7500	19.05	1/2 *	1	3	5	0.030	-----	B60498
3/4	.7500	19.05	3/4	1	3	5	0.000	B40476	B60476
3/4	.7500	19.05	3/4	1	3	5	0.030	B40429	B60429
3/4	.7500	19.05	3/4	1-1/2	4	5	0.000	B40477	B60477
3/4	.7500	19.05	3/4	1-1/2	4	5	0.030	B40430	B60430
3/4	.7500	19.05	3/4	1-1/2	4	5	0.060	B40478	B60478
3/4	.7500	19.05	3/4	1-1/2	4	5	0.090	B40479	B60479
3/4	.7500	19.05	3/4	1-1/2	4	5	0.125	B40480	B60480
3/4	.7500	19.05	3/4	2-1/4	5	5	0.000	B40481	B60481
3/4	.7500	19.05	3/4	2-1/4	5	5	0.030	B40431	B60431
3/4	.7500	19.05	3/4	2-1/4	5	5	0.060	B40482	B60482
3/4	.7500	19.05	3/4	2-1/4	5	5	0.090	B40483	B60483
3/4	.7500	19.05	3/4	2-1/4	5	5	0.125	B40484	B60484

\* Weldon shank; all others plain shank

continued on next page

Solid Carbide End Mills



V2 Variable Index End Mills for Ferrous Materials



Series MSE-V2-5R (continued)

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

	cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
	fractional	decimal	metric						bright	TiAIN
1		1.0000	25.40	1	1-1/2	4	5	0.000	B40485	B60485
1		1.0000	25.40	1	1-1/2	4	5	0.030	B40432	B60432
1		1.0000	25.40	1	1-1/2	4	5	0.060	B40486	B60486
1		1.0000	25.40	1	1-1/2	4	5	0.090	B40487	B60487
1		1.0000	25.40	1	1-1/2	4	5	0.125	B40488	B60488
1		1.0000	25.40	1	2-1/4	5	5	0.000	B40489	B60489
1		1.0000	25.40	1	2-1/4	5	5	0.030	B40433	B60433
1		1.0000	25.40	1	2-1/4	5	5	0.060	B40490	B60490
1		1.0000	25.40	1	2-1/4	5	5	0.090	B40491	B60491
1		1.0000	25.40	1	2-1/4	5	5	0.125	B40492	B60492
1		1.0000	25.40	1	3	6	5	0.000	B40493	B60493
1		1.0000	25.40	1	3	6	5	0.030	B40494	B60494
1		1.0000	25.40	1	3	6	5	0.060	B40495	B60495
1		1.0000	25.40	1	3	6	5	0.090	B40496	B60496
1		1.0000	25.40	1	3	6	5	0.125	B40497	B60497



## 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	600	.0005	.0010	.0020
			High	750	.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	600	.0003	.0005	.0010
			High	750	.0005	.0010	.0015
high alloy steels M4 to M7, T6 to T15, D2 to D7, A4 to A7, P4	294-371	31-40	Low	525	.0003	.0005	.0008
			High	625	.0005	.0010	.0015
stainless steels 200/300 series	135-275	<28	Low	250	.0005	.0010	.0020
			High	350	.0010	.0020	.0030
stainless steels 400/500 series	135-330	<35	Low	340	.0003	.0008	.0010
			High	400	.0005	.0010	.0015
nickel-based alloys	140-475	<32-50	Low	100	.0005	.0010	.0015
			High	160	.0010	.0015	.0040
titanium alloys	110-450	<48	Low	195	.0005	.0010	.0025
			High	240	.0010	.0030	.0050
inconel	140-475	<48	Low	100	.0005	.0010	.0015
			High	160	.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.



Solid Carbide End Mills



# High-Performance End Mills For Steel

**BASSETT™**

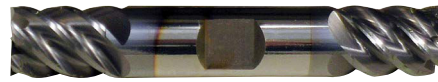
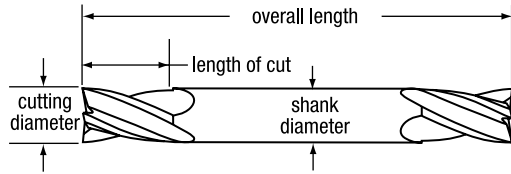
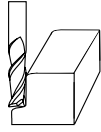
Series **HPDEM-5 • Double End**

**Applications |**

- HARDENED STEEL
- STAINLESS STEEL
- HI-TEMP ALLOYS

**Features |**

- SOLID CARBIDE
- 5 FLUTE CC
- 47°
- BRIGHT
- TiCN
- TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number		
fractional	decimal	metric						bright	TiCN	TiAlN
1/8	.1250	3.18	1/8	1/4	1 1/2	5	0.000	B05100	B05605	B66100
3/16	.1875	4.76	3/16	5/16	2	5	0.000	B05101	B05609	B66101
1/4	.2500	6.35	1/4	3/8	2 1/2	5	0.000	B05103	B05613	B66103
5/16	.3125	7.94	5/16	7/16	2 1/2	5	0.000	B05104	B05617	B66104
3/8	.3750	9.53	3/8	1/2	2 1/2	5	0.000	B05106	B05621	B66106
7/16	.4375	11.11	7/16	9/16	3	5	0.000	B05108	B05625	B66108
1/2	.5000	12.70	1/2 *	5/8	3	5	0.000	B05110	B05629	B66110

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

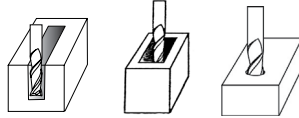
INDEX



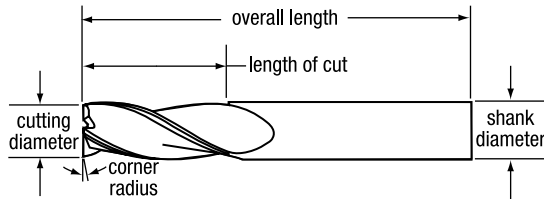
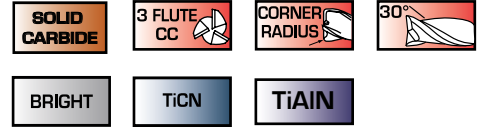
# High-Performance End Mills For Steel

## 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	TiAlN
1/8	.1250	3.18	1/8	1/4	1 1/2	3	0.010	B05105	B05005	B05305
1/8	.1250	3.18	1/8	1/2	1 1/2	3	0.010	B05140	B05040	B05340
5/32	.1562	3.97	3/16	5/16	1 1/2	3	0.010	B05107	B05007	B05307
5/32	.1562	3.97	3/16	9/16	2	3	0.010	B05142	B05042	B05342
3/16	.1875	4.76	3/16	5/16	2	3	0.010	B05109	B05009	B05309
3/16	.1875	4.76	3/16	5/8	2	3	0.010	B05144	B05044	B05344
7/32	.2188	5.56	1/4	1/2	2	3	0.020	B05111	B05011	B05311
7/32	.2188	5.56	1/4	3/4	2 1/2	3	0.020	B05146	B05046	B05346
1/4	.2500	6.35	1/4	3/8	2	3	0.020	B05113	B05013	B05313
1/4	.2500	6.35	1/4	3/4	2 1/2	3	0.020	B05148	B05048	B05348
9/32	.2812	7.14	5/16	7/16	2	3	0.020	B05115	B05015	B05315
9/32	.2812	7.14	5/16	13/16	2 1/2	3	0.020	B05150	B05050	B05350
5/16	.3125	7.94	5/16	7/16	2	3	0.020	B05117	B05017	B05317
5/16	.3125	7.94	5/16	13/16	2 1/2	3	0.020	B05152	B05052	B05352
11/32	.3438	8.73	3/8	1/2	2	3	0.020	B05119	B05019	B05319
11/32	.3438	8.73	3/8	7/8	2 1/2	3	0.020	B05154	B05054	B05354
3/8	.3750	9.53	3/8	1/2	2	3	0.020	B05121	B05021	B05321
3/8	.3750	9.53	3/8	7/8	2 1/2	3	0.020	B05156	B05056	B05356
13/32	.4062	10.32	7/16	9/16	2 1/2	3	0.020	B05123	B05023	B05323
13/32	.4062	10.32	7/16	1	2 1/2	3	0.020	B05158	B05058	B05358
7/16	.4375	11.11	7/16	9/16	2 1/2	3	0.020	B05125	B05025	B05325
7/16	.4375	11.11	7/16	1	2 1/2	3	0.020	B05160	B05060	B05360
15/32	.4688	11.91	1/2 *	5/8	2 1/2	3	0.020	B05127	B05027	B05327
15/32	.4688	11.91	1/2 *	1 1/4	3	3	0.020	B05162	B05062	B05362
1/2	.5000	12.70	1/2 *	5/8	2 1/2	3	0.030	B05129	B05029	B05329
1/2	.5000	12.70	1/2 *	1 1/4	3	3	0.030	B05164	B05064	B05364
5/8	.6250	15.88	5/8 *	3/4	3	3	0.030	B05131	B05031	B05331
5/8	.6250	15.88	5/8 *	1 5/8	4	3	0.030	B05166	B05066	B05366
3/4	.7500	19.05	3/4 *	7/8	3	3	0.030	B05133	B05032	B05332
3/4	.7500	19.05	3/4 *	1 5/8	4	3	0.030	B05168	B05067	B05367
1	1.0000	25.40	1 *	1 1/8	3	3	0.030	B05135	B05034	B05334
1	1.0000	25.40	1 *	2	4	3	0.030	B05170	B05069	B05369

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



# High-Performance End Mills For Steel

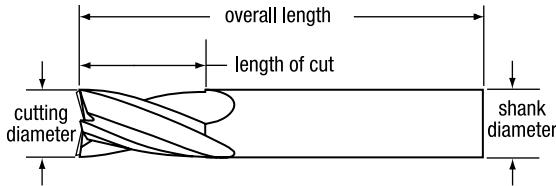
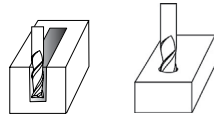
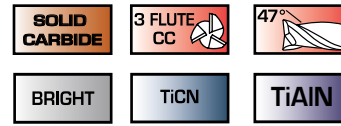
**BASSETT™**

Series **HPEM-5**

**Applications**



**Features**



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number		
fractional	decimal	metric						bright	TiCN	TiAlN
1/8	.1250	3.18	1/8	1/4	1 1/2	5	0.000	B05112	B05405	B05805
1/8	.1250	3.18	1/8	1/2	1 1/2	5	0.000	B05141	B05440	B05840
1/8	.1250	3.18	1/8	1/2	2	5	0.000	B05098	-----	B70175
5/32	.1562	3.97	3/16	5/16	2	5	0.000	B05114	B05407	B05807
5/32	.1562	3.97	3/16	9/16	2	5	0.000	B05143	B05442	B05842
3/16	.1875	4.76	3/16	5/16	2	5	0.000	B05116	B05409	B05809
3/16	.1875	4.76	3/16	9/16	2	5	0.000	B05145	B05444	B05844
7/32	.2188	5.56	1/4	3/8	2	5	0.000	B05118	B05411	B05811
7/32	.2188	5.56	1/4	3/4	2 1/2	5	0.000	B05147	B05446	B05846
1/4	.2500	6.35	1/4	3/8	2	5	0.000	B05120	B05413	B05813
1/4	.2500	6.35	1/4	3/4	2 1/2	5	0.000	B05149	B05448	B05848
1/4	.2500	6.35	1/4	1 1/4	4	5	0.000	B05171	B05513	B05913
9/32	.2812	7.14	5/16	7/16	2	5	0.000	B05122	B05415	B05815
9/32	.2812	7.14	5/16	13/16	2 1/2	5	0.000	B05151	B05450	B05850
5/16	.3125	7.94	5/16	7/16	2	5	0.000	B05124	B05417	B05817
5/16	.3125	7.94	5/16	13/16	2 1/2	5	0.000	B05153	B05452	B05852
5/16	.3125	7.94	5/16	1 1/4	4	5	0.000	B05173	B05517	B05917
3/8	.3750	9.53	3/8	1/2	2	5	0.000	B05126	B05421	B05821
3/8	.3750	9.53	3/8	7/8	2 1/2	5	0.000	B05155	B05456	B05856
3/8	.3750	9.53	3/8	1 1/2	4	5	0.000	B05175	B05521	B05921
7/16	.4375	11.11	7/16	9/16	2 1/2	5	0.000	B05128	B05425	B05825
7/16	.4375	11.11	7/16	1	2 1/2	5	0.000	B05157	B05460	B05860
7/16	.4375	11.11	7/16	2	4	5	0.000	B05177	B05525	B05925
1/2	.5000	12.70	1/2 *	5/8	2 1/2	5	0.000	B05130	B05429	B05829
1/2	.5000	12.70	1/2 *	1 1/4	3	5	0.000	B05159	B05464	B05864
1/2	.5000	12.70	1/2 *	2	4	5	0.000	B05179	B05529	B05929
9/16	.5625	14.29	9/16 *	1 1/2	3 1/2	5	0.000	B05161	B05465	B05865
5/8	.6250	15.88	5/8 *	3/4	3	5	0.000	B05132	B05431	B05831
5/8	.6250	15.88	5/8 *	1 5/8	4	5	0.000	B05163	B05466	B05866
5/8	.6250	15.88	5/8 *	2 1/2	5	5	0.000	B05181	B05531	B05931
3/4	.7500	19.05	3/4 *	7/8	3	5	0.000	B05134	B05432	B05832
3/4	.7500	19.05	3/4 *	1 5/8	4	5	0.000	B05165	B05467	B05867
3/4	.7500	19.05	3/4 *	3 1/4	6	5	0.000	B05183	B05532	B05932
7/8	.8750	22.23	7/8 *	2	4	5	0.000	B05167	B05468	B05868
1	1.0000	25.40	1 *	1 1/8	3	5	0.000	B05136	B05434	B05834
1	1.0000	25.40	1 *	2	4	5	0.000	B05169	B05469	B05869
1	1.0000	25.40	1 *	3 1/4	6	5	0.000	B05185	B05533	B05933

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



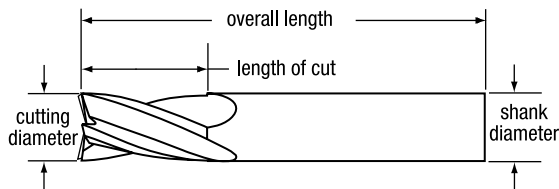
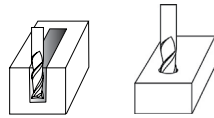
# High-Performance End Mills For Steel

## Series HPEM-6

### Applications |



### Features |



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiAIN
3/16	.1875	4.76	3/16	5/8	2	6	0.000	-----	B70180
1/4	.2500	6.35	1/4	3/4	2 1/2	6	0.000	B50187	B70187
3/8	.3750	9.52	3/8	7/8	2 1/2	6	0.000	-----	B70181
1/2	.5000	12.70	1/2	1 1/4	3	6	0.000	B70185	B70186

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

**Solid Carbide End Mills**



**High-Performance End Mills for Aluminum**

**BASSETT™**

**Operating Parameters: HPAM High-Performance End Mills for Aluminum**

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

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.

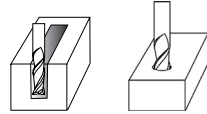




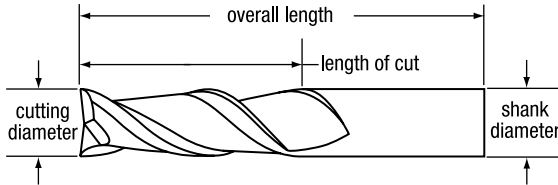
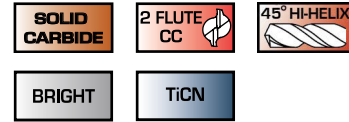
# High-Performance End Mills for Aluminum

Series HPAM-2 • square end

Applications |



Features |



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiCN
1/8	.1250	3.18	1/8	1/4	1 1/2	2	0.000	B04440	B06440
1/8	.1250	3.18	1/8	3/8	1 1/2	2	0.000	B04405	B06405
3/16	.1875	4.76	3/16	5/16	2	2	0.000	B04444	B06444
3/16	.1875	4.76	3/16	9/16	2	2	0.000	B04409	B06409
1/4	.2500	6.35	1/4	3/8	2 1/2	2	0.000	B04448	B06448
1/4	.2500	6.35	1/4	3/4	2 1/2	2	0.000	B04413	B06413
1/4	.2500	6.35	1/4	1 1/4	3	2	0.000	B04548	B06548
5/16	.3125	7.94	5/16	7/16	2 1/2	2	0.000	B04452	B06452
5/16	.3125	7.94	5/16	13/16	2 1/2	2	0.000	B04417	B06417
5/16	.3125	7.94	5/16	1 1/4	3 1/2	2	0.000	B04552	B06552
5/16	.3125	7.94	5/16	2 1/8	4	2	0.000	B04617	B06617
3/8	.3750	9.53	3/8	1/2	2 1/2	2	0.000	B04456	B06456
3/8	.3750	9.53	3/8	1	2 1/2	2	0.000	B04421	B06421
3/8	.3750	9.53	3/8	1 1/2	4	2	0.000	B04556	B06556
3/8	.3750	9.53	3/8	2 1/2	6	2	0.000	B04621	B06621
7/16	.4375	11.11	7/16	9/16	2 1/2	2	0.000	B04460	B06460
7/16	.4375	11.11	7/16	1	2 1/2	2	0.000	B04425	B06425
7/16	.4375	11.11	7/16	2	4	2	0.000	B04560	B06560
1/2	.5000	12.70	1/2	5/8	3	2	0.000	B04464	B06464
1/2	.5000	12.70	1/2	1 1/4	3	2	0.000	B04429	B06429
1/2	.5000	12.70	1/2	2	4	2	0.000	B04564	B06564
1/2	.5000	12.70	1/2	3 1/8	6	2	0.000	B04629	B06629
5/8	.6250	15.88	5/8	3/4	3 1/2	2	0.000	B04466	B06466
5/8	.6250	15.88	5/8	1 5/8	4	2	0.000	B04431	B06431
5/8	.6250	15.88	5/8	2 1/2	5	2	0.000	B04566	B06566
5/8	.6250	15.88	5/8	3 3/4	6	2	0.000	B04631	B06631
3/4	.7500	19.05	3/4	1	4	2	0.000	B04467	B06467
3/4	.7500	19.05	3/4	1 5/8	4	2	0.000	B04432	B06432
3/4	.7500	19.05	3/4	3 1/4	6	2	0.000	B04567	B06567
3/4	.7500	19.05	3/4	4	6 1/2	2	0.000	B04632	B06632
1	1.0000	25.40	1	1 1/4	5	2	0.000	B04469	B06469
1	1.0000	25.40	1	2	5	2	0.000	B04434	B06434
1	1.0000	25.40	1	3 1/4	6	2	0.000	B04569	B06569
1	1.0000	25.40	1	4 1/8	7	2	0.000	B04634	B06634

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills

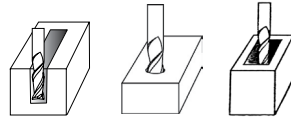


# High-Performance End Mills for Aluminum

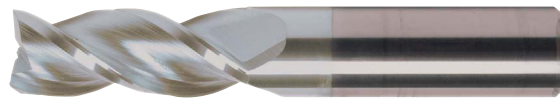
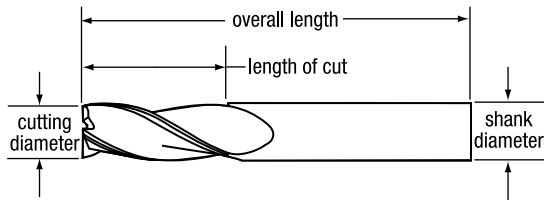
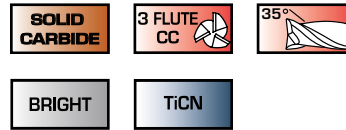
**BASSETT™**

Series **HPAM-3** • square end

**Applications |**



**Features |**



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiCN
1/8	.1250	3.18	1/8	1/4	1 1/2	3	0.000	B04005	B06005
1/8	.1250	3.18	1/8	3/8	1 1/2	3	0.000	B04040	B06040
3/16	.1875	4.76	3/16	5/16	2	3	0.000	B04009	B06009
3/16	.1875	4.76	3/16	9/16	2	3	0.000	B04044	B06044
1/4	.2500	6.35	1/4	3/8	2	3	0.000	B04013	B06013
1/4	.2500	6.35	1/4	5/8	2 1/2	3	0.000	B04048	B06048
1/4	.2500	6.35	1/4	1 1/4	3	3	0.000	B04148	B06148
5/16	.3125	7.94	5/16	7/16	2	3	0.000	B04017	B06017
5/16	.3125	7.94	5/16	5/8	2 1/2	3	0.000	B04052	B06052
5/16	.3125	7.94	5/16	1 1/4	3 1/2	3	0.000	B04152	B06152
5/16	.3125	7.94	5/16	2 1/8	4	3	0.000	B04217	B06217
3/8	.3750	9.53	3/8	1/2	2	3	0.000	B04021	B06021
3/8	.3750	9.53	3/8	1	2 1/2	3	0.000	B04056	B06056
3/8	.3750	9.53	3/8	1 1/2	3 1/2	3	0.000	B04156	B06156
3/8	.3750	9.53	3/8	2 1/2	6	3	0.000	B04221	B06221
7/16	.4375	11.11	7/16	9/16	2 1/2	3	0.000	B04025	B06025
7/16	.4375	11.11	7/16	1 1/4	2 1/2	3	0.000	B04060	B06060
7/16	.4375	11.11	7/16	2	4	3	0.000	B04160	B06160
1/2	.5000	12.70	1/2	5/8	2 1/2	3	0.000	B04029	B06029
1/2	.5000	12.70	1/2	1 1/4	3	3	0.000	B04064	B06064
1/2	.5000	12.70	1/2	2	4	3	0.000	B04164	B06164
1/2	.5000	12.70	1/2	3 1/8	6	3	0.000	B04229	B06229
5/8	.6250	15.88	5/8	3/4	3	3	0.000	B04031	B06031
5/8	.6250	15.88	5/8	1 5/8	4	3	0.000	B04066	B06066
5/8	.6250	15.88	5/8	2 1/2	5	3	0.000	B04166	B06166
5/8	.6250	15.88	5/8	3 3/4	6	3	0.000	B04231	B06231
3/4	.7500	19.05	3/4	1	3	3	0.000	B04032	B06032
3/4	.7500	19.05	3/4	1 5/8	4	3	0.000	B04067	B06067
3/4	.7500	19.05	3/4	3 1/4	6	3	0.000	B04167	B06167
1	1.0000	25.40	1	1 1/4	4	3	0.000	B04034	B06034
1	1.0000	25.40	1	2	5	3	0.000	B04069	B06069
1	1.0000	25.40	1	3 1/4	6	3	0.000	B04169	B06169

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



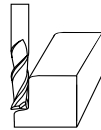
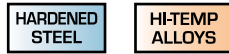
# High-Performance Roughers

## Operating Parameters for High-Performance Roughers

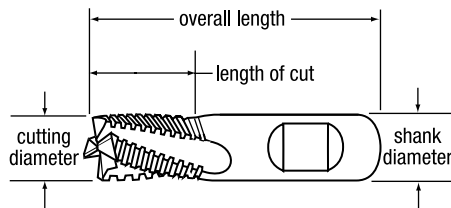
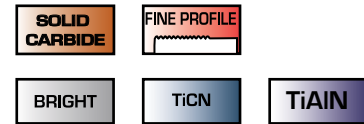
Material	Hardness		Surface Feet per Minute			Chip Load per Tooth	
	Brinell	HRC	Uncoated	TiCN	TiAlN	1/4" to 1/2"	1/2" - 1"
low and plain carbon, alloy, and tool steels	<220 HB	<19	-	325 - 500	430 - 575	.0015 - .0030	.0030 - .0045
plain carbon, alloy and tool steels	225 - 286	20 - 30	-	215 - 375	350 - 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
			600 - 2000	720 - 2500	-	.0018 - .0035	.0035 - .0071

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

#### Applications |



#### Features |



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	bright	EDP Number		
fractional	decimal	metric							TiCN	TiAlN	
1/4	.2500	6.35	1/4 *	3/8	2	3	0.000	B03416	B03816	B66416	
1/4	.2500	6.35	1/4 *	3/4	2 1/2	3	0.000	B03216	B03316	B66215	
3/8	.3750	9.53	3/8 *	1/2	2	4	0.000	B03424	B03824	B66424	
3/8	.3750	9.53	3/8 *	7/8	2 1/2	4	0.000	B03224	B03324	B66223	
1/2	.5000	12.70	1/2 *	5/8	2 1/2	4	0.000	B03432	B03832	B66432	
1/2	.5000	12.70	1/2 *	1	3	4	0.000	B03232	B03332	B66232	
5/8	.6250	15.88	5/8 *	3/4	3	4	0.000	B03440	B03840	B66440	
5/8	.6250	15.88	5/8 *	1-1/4	3 1/2	4	0.000	B03240	B03340	B66240	
3/4	.7500	19.05	3/4 *	7/8	3 1/2	4	0.000	B03448	B03848	B66448	
3/4	.7500	19.05	3/4 *	1-1/2	4	4	0.000	B03248	B03348	B66248	
1	1.0000	25.40	1 *	1	3 1/2	4	0.000	B03464	B03864	B66464	
1	1.0000	25.40	1 *	1-1/2	4	4	0.000	B03264	B03364	B66264	

\* Weldon shank

Solid Carbide End Mills

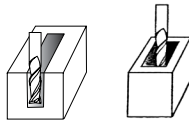


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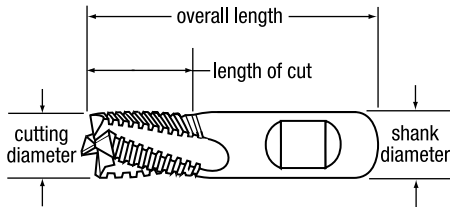
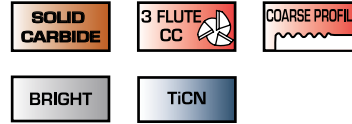
# High-Performance Roughers

Series **MRA** Rougher • square end

**Applications**



**Features**



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP Number	
fractional	decimal	metric						bright	TiCN
1/4	.2500	6.35	1/4 *	3/8	2	3	0.000	B10117	B03117
1/4	.2500	6.35	1/4 *	3/4	2 1/2	3	0.000	B03016	B03116
3/8	.3750	9.53	3/8 *	1/2	2	3	0.000	B10118	B03118
3/8	.3750	9.53	3/8 *	7/8	2 1/2	3	0.000	B03024	B03124
1/2	.5000	12.70	1/2 *	5/8	2 1/2	3	0.000	B10119	B03119
1/2	.5000	12.70	1/2 *	1	3	3	0.000	B03032	B03132
1/2	.5000	12.70	1/2 *	2	4 1/2	3	0.000	B03532	B03632
5/8	.6250	15.88	5/8 *	3/4	3	3	0.000	B10120	B03120
5/8	.6250	15.88	5/8 *	1 1/4	3 1/2	3	0.000	B03040	B03140
5/8	.6250	15.88	5/8 *	2 1/4	5	3	0.000	B03540	B03640
3/4	.7500	19.05	3/4 *	1	3 1/2	3	0.000	B10121	B03121
3/4	.7500	19.05	3/4 *	1 1/2	4	3	0.000	B03048	B03148
3/4	.7500	19.05	3/4 *	2 1/4	5	3	0.000	B03548	B03648
1	1.0000	25.40	1 *	1 1/8	3 1/2	3	0.000	B10122	B03122
1	1.0000	25.40	1 *	1 1/2	4	3	0.000	B03064	B03164
1	1.0000	25.40	1 *	2 1/4	5	3	0.000	B03564	B03664

\* Weldon shank

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

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.



Solid Carbide End Mills



# Double End General-Purpose

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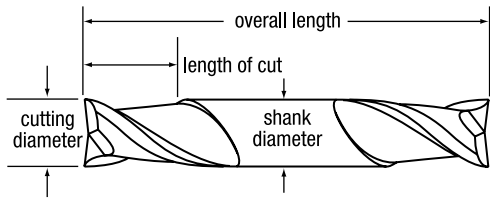
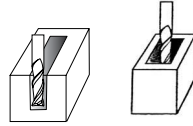
Series **MDE-2**

**Applications |**

- STAINLESS STEEL
- CAST IRON
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

**Features |**

- SOLID CARBIDE
- 2 FLUTE CC
- BRIGHT
- TiCN
- TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
fractional	decimal	metric						bright	TiCN	TiAlN
1/16	.0625	1.59	1/8	1/8	1 1/2	2	0.000	B52801	B01681	B00207
3/32	.0938	2.38	1/8	3/16	1 1/2	2	0.000	B52803	B01682	B00208
1/8	.1250	3.18	1/8	1/4	1 1/2	2	0.000	B52805W	B01683W	B00209
1/8	.1250	3.18	3/8 *	3/8	3	2	0.000	B52401	B01577	B00220
5/32	.1562	3.97	3/16	5/16	2	2	0.000	B52807	B01684	B00210
5/32	.1562	3.97	3/8 *	7/16	3	2	0.000	B52403	B01578	B00221
3/16	.1875	4.76	3/16	3/8	2	2	0.000	B52809	B01685	B00211
3/16	.1875	4.76	3/8 *	1/2	3	2	0.000	B52405	B01579	B11987
7/32	.2188	5.56	3/8 *	9/16	3 1/2	2	0.000	B52407	B01580	B00212
1/4	.2500	6.35	1/4	1/2	2 1/2	2	0.000	B52814	B01687	B00213
1/4	.2500	6.35	3/8 *	5/8	3 1/2	2	0.000	B52410	B01581	B00222
9/32	.2812	7.14	3/8 *	11/16	3 1/2	2	0.000	B52412	B01582	B00215
5/16	.3125	7.94	3/8 *	3/4	3 1/2	2	0.000	B52414	B01583	B00224
3/8	.3750	9.53	3/8	9/16	3	2	0.000	B52818	B01689	B40779
3/8	.3750	9.53	3/8 *	3/4	3 1/2	2	0.000	B52418	B01585	B00225
7/16	.4375	11.11	1/2 *	7/8	4	2	0.000	B52420	B01586	B00226
1/2	.5000	12.70	1/2	5/8	3	2	0.000	B52823	B01691	B00217
1/2	.5000	12.70	1/2 *	1	4	2	0.000	B52423	B01587	B00227

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



# Double End General-Purpose

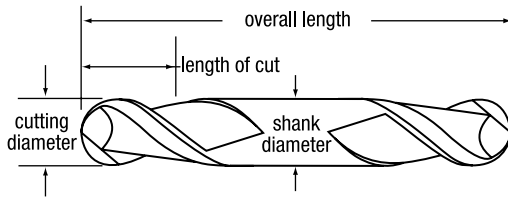
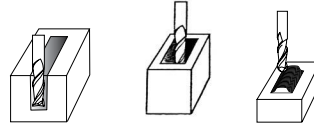
Series **MDE-2B**

**Applications |**

- CAST IRON
- STEEL
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

**Features |**

- SOLID CARBIDE
- 2 FLUTE BALL CO.
- BRIGHT
- TiCN
- TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAlN
1/16	.0625	1.59	1/8	1/8	1 1/2	2	B52881	B01703	B69881
3/32	.0938	2.38	1/8	3/16	1 1/2	2	B52883	B01704	B69883
1/8	.1250	3.18	3/8 *	3/8	3	2	B52481	B01599	B69481
5/32	.1562	3.97	3/8 *	7/16	3	2	B52483	B01600	B69483
3/16	.1875	4.76	3/8 *	1/2	3	2	B52485	B01601	B69485
7/32	.2188	5.56	3/8 *	9/16	3 1/2	2	B52487	B01602	B69487
1/4	.2500	6.35	3/8 *	5/8	3 1/2	2	B52490	B01603	B69490
9/32	.2812	7.14	3/8 *	11/16	3 1/2	2	B52492	B01604	B69492
5/16	.3125	7.94	3/8 *	3/4	3 1/2	2	B52494	B01605	B69494
3/8	.3750	9.53	3/8 *	3/4	3 1/2	2	B52498	B01607	B69498
7/16	.4375	11.11	1/2 *	7/8	4	2	B52500	B01608	B69500
1/2	.5000	12.70	1/2 *	1	4	2	B52503	B01609	B69503

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



**BASSETT™**

# Double End General-Purpose

Series **MDE-4**

**Applications**

STAINLESS STEEL

CAST IRON

HI-TEMP ALLOYS

NON-FERROUS MATERIALS

**Features**

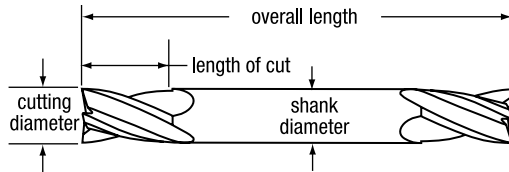
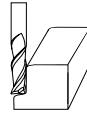
SOLID CARBIDE

4+ FLUTE CC

BRIGHT

TiCN

TiAIN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
fractional	decimal	metric						bright	TiCN	TiAIN
1/16	.0625	1.59	1/8	1/8	1 1/2	4	0.000	B52841	B01692	B00342
3/32	.0938	2.38	1/8	3/16	1 1/2	4	0.000	B52843	B01693	B69843
1/8	.1250	3.18	1/8	1/4	1 1/2	4	0.000	B52845W	B01694W	B69846
1/8	.1250	3.18	3/16	1/4	2	4	0.000	B52845	B01694	B69845
1/8	.1250	3.18	3/8 *	7/16	3	4	0.000	B52441	B01588	B11999
5/32	.1562	3.97	3/16	5/16	2	4	0.000	B52847	B01695	B00345
5/32	.1562	3.97	3/8 *	7/16	3	4	0.000	B52443	B01589	B69443
3/16	.1875	4.76	3/16	3/8	2	4	0.000	B52849	B01696	B00346
3/16	.1875	4.76	3/8 *	1/2	3	4	0.000	B52445	B01590	B12000
7/32	.2188	5.56	3/8 *	9/16	3 1/2	4	0.000	B52447	B01591	B69447
1/4	.2500	6.35	1/4	1/2	2 1/2	4	0.000	B52854	B01698	B00348
1/4	.2500	6.35	3/8 *	5/8	3 1/2	4	0.000	B52450	B01592	B00357
9/32	.2812	7.14	3/8 *	11/16	3 1/2	4	0.000	B52452	B01593	B69452
5/16	.3125	7.94	5/16	1/2	2 1/2	4	0.000	B52856	B01699	B00349
5/16	.3125	7.94	3/8 *	3/4	3 1/2	4	0.000	B52454	B01594	B00359
3/8	.3750	9.53	3/8	9/16	3	4	0.000	B52858	B01700	B40780
3/8	.3750	9.53	3/8 *	3/4	3 1/2	4	0.000	B52458	B01596	B00360
7/16	.4375	11.11	1/2 *	7/8	4	4	0.000	B52460	B01597	B69460
1/2	.5000	12.70	1/2	5/8	3	4	0.000	B52863	B01702	B00352
1/2	.5000	12.70	1/2 *	1	4	4	0.000	B52463	B01598	B00362

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



# Double End General-Purpose

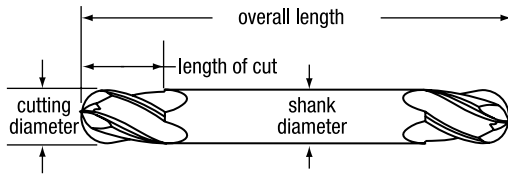
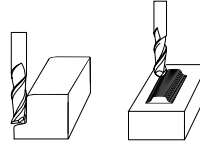
Series **MDE-4B**

**Applications |**

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

**Features |**

- SOLID CARBIDE
- 4 FLUTE BALL CO
- BRIGHT
- TiCN
- TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAlN
1/16	.0625	1.59	1/8	1/8	1 1/2	4	B52921	B01714	B69921
3/32	.0938	2.38	1/8	3/16	1 1/2	4	B52923	B01715	B69923
1/8	.1250	3.18	3/8 *	3/8	3	4	B52521	B01610	B69521
5/32	.1562	3.97	3/8 *	7/16	3	4	B52523	B01611	B69523
3/16	.1875	4.76	3/8 *	1/2	3	4	B52525	B01612	B69525
7/32	.2188	5.56	3/8 *	9/16	3 1/2	4	B52527	B01613	B69527
1/4	.2500	6.35	3/8 *	5/8	3 1/2	4	B52530	B01614	B69530
9/32	.2812	7.14	3/8 *	11/16	3 1/2	4	B52532	B01615	B69532
5/16	.3125	7.94	3/8 *	3/4	3 1/2	4	B52534	B01616	B69534
3/8	.3750	9.53	3/8 *	3/4	3 1/2	4	B52538	B01618	B69538
7/16	.4375	11.11	1/2 *	7/8	4	4	B52540	B01619	B69540
1/2	.5000	12.70	1/2 *	1	4	4	B52543	B01620	B69543

\* Weldon shank; all others plain shank

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



Single End General-Purpose

**BASSETT™**

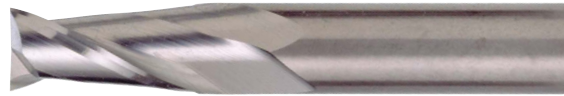
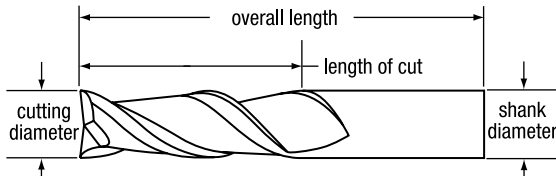
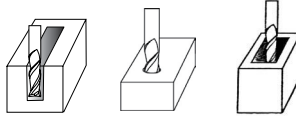
Series **MSE-2**

Applications |

STEEL
CAST IRON
HI-TEMP ALLOYS
NON-FERROUS MATERIALS

Features |

SOLID CARBIDE
2 FLUTE CC
CORNER RADIUS
  
BRIGHT
TiCN
TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
fractional	decimal	metric						bright	TiCN	TiAlN
1/32	.0312	0.79	1/8	1/8	1 1/2	2	0.000	B52601	B01621	B69601
3/64	.0469	1.19	1/8	1/8	1 1/2	2	0.000	B52602	B01622	B69602
1/16	.0625	1.59	1/8	1/8	1 1/2	2	0.000	B52604	B01623	B69604
1/16	.0625	1.59	1/8	1/4	1 1/2	2	0.000	B52001	B01441	B69001
5/64	.0781	1.98	1/8	1/4	1 1/2	2	0.000	B52002	B01442	B69002
3/32	.0938	2.38	1/8	1/4	1 1/2	2	0.000	B52606	B01624	B69606
3/32	.0938	2.38	1/8	3/8	1 1/2	2	0.000	B52004	B01443	B69004
7/64	.1094	2.78	1/8	3/8	1 1/2	2	0.000	B52005	B01444	B69005
1/8	.1250	3.18	1/8	1/4	1 1/2	2	0.000	B52608	B01625	B69608
1/8	.1250	3.18	1/8	1/2	1 1/2	2	0.000	B52007	B01445	B69007
1/8	.1250	3.18	1/8	1/2	1 1/2	2	0.010	B52060	B06800	B69060
1/8	.1250	3.18	1/8	3/4	2 1/4	2	0.000	B51200	B01329	B68200
1/8	.1250	3.18	1/8	1	3	2	0.000	B51400	B01318	B68400
9/64	.1406	3.57	3/16	9/16	2	2	0.000	B52008	B01446	B69008
5/32	.1562	3.97	3/16	9/16	2	2	0.000	B52010	B01447	B69010
11/64	.1719	4.37	3/16	5/8	2	2	0.000	B52011	B01448	B00059
3/16	.1875	4.76	3/16	5/16	2	2	0.000	B52612	B01627	B62612
3/16	.1875	4.76	3/16	5/8	2	2	0.000	B52013	B01449	B69013
3/16	.1875	4.76	3/16	5/8	2	2	0.010	B52061	B06801	B69061
3/16	.1875	4.76	3/16	3/4	2 1/2	2	0.000	B51202	B01330	B68202
3/16	.1875	4.76	3/16	1 1/8	3	2	0.000	B51402	B01386	B68402
13/64	.2031	5.16	1/4	5/8	2 1/2	2	0.000	B52014	B01450	B69014
7/32	.2188	5.56	1/4	5/8	2 1/2	2	0.000	B52016	B01451	B10575
15/64	.2344	5.95	1/4	3/4	2 1/2	2	0.000	B52017	B01452	B69017
6mm	.2362	6.00	6mm	25mm	75mm	2	0.000	B52019	-----	B69112
1/4	.2500	6.35	1/4	1/2	2	2	0.000	B52617	B01629	B81577
1/4	.2500	6.35	1/4	3/4	2 1/2	2	0.000	B52020	B01453	B69020
1/4	.2500	6.35	1/4	3/4	2 1/2	2	0.020	B52062	B06802	B69062
1/4	.2500	6.35	1/4	3/4	2 1/2	2	0.030	B52063	B06803	B69063
1/4	.2500	6.35	1/4	1 1/8	3	2	0.000	B51204	B01331	B68204
1/4	.2500	6.35	1/4	1 1/2	4	2	0.000	B51404	B01319	B68404
1/4	.2500	6.35	1/4	1 1/2	6	2	0.000	B51405	B01388	B68405
17/64	.2656	6.75	5/16	3/4	2 1/2	2	0.000	B52021	B01454	B69021
9/32	.2812	7.14	5/16	3/4	2 1/2	2	0.000	B52023	B01455	B69023

continued on next page

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX





# Single End General-Purpose

## Series MSE-2 (continued)

cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
fractional	decimal	metric						bright	TiCN	TiAlN
5/16	.3125	7.94	5/16	1/2	2	2	0.000	B52619	B01630	B81578
5/16	.3125	7.94	5/16	13/16	2 1/2	2	0.000	B52026	B01457	B69026
5/16	.3125	7.94	5/16	13/16	2 1/2	2	0.020	B52065	B06805	B69065
5/16	.3125	7.94	5/16	13/16	2 1/2	2	0.030	B52066	B06806	B69066
5/16	.3125	7.94	5/16	1 1/8	3	2	0.000	B51206	B01333	B68206
5/16	.3125	7.94	5/16	1 5/8	4	2	0.000	B51406	B01389	B68406
3/8	.3750	9.53	3/8	5/8	2	2	0.000	B52621	B01631	B81579
3/8	.3750	9.53	3/8	1	2 1/2	2	0.000	B52032	B01461	B00062
3/8	.3750	9.53	3/8	1	2 1/2	2	0.020	B52068	B06808	B69068
3/8	.3750	9.53	3/8	1	2 1/2	2	0.030	B52069	B06809	B69069
3/8	.3750	9.53	3/8	1	2 1/2	2	0.045	B52070	B06810	B69070
3/8	.3750	9.53	3/8	1 1/8	3	2	0.000	B51208	B01334	B68208
3/8	.3750	9.53	3/8	1 3/4	4	2	0.000	B51408	B01320	B68408
3/8	.3750	9.53	3/8	1 1/2	6	2	0.000	B51409	B01391	B68409
7/16	.4375	11.11	7/16	5/8	2 1/2	2	0.000	B52623	B01632	B69623
7/16	.4375	11.11	7/16	1	2 1/2	2	0.000	B52038	B01465	B69038
7/16	.4375	11.11	7/16	2	4	2	0.000	B51210	B01321	B68210
7/16	.4375	11.11	7/16	3	6	2	0.000	B51410	B01322	B68410
1/2	.5000	12.70	1/2	5/8	2 1/2	2	0.000	B52626	B01633	B81581
1/2	.5000	12.70	1/2	1	3	2	0.000	B52045	B01469	B69045
1/2	.5000	12.70	1/2	1	3	2	0.030	B52072	B06812	B69072
1/2	.5000	12.70	1/2	1	3	2	0.060	B52073	B06813	B69073
1/2	.5000	12.70	1/2	1	3	2	0.090	B52074	B06814	B69074
1/2	.5000	12.70	1/2	2	4	2	0.000	B51212	B01338	B68212
1/2	.5000	12.70	1/2	1 1/2	6	2	0.000	B51411	B01323	B68411
1/2	.5000	12.70	1/2	3	6	2	0.000	B51412	B01394	B68412
9/16	.5625	14.29	9/16	1 1/4	3	2	0.000	B52047	B01470	B69047
5/8	.6250	15.88	5/8	3/4	3	2	0.000	B52628	B01634	B69628
5/8	.6250	15.88	5/8	1 1/4	3 1/2	2	0.000	B52049	B01471	B00064
5/8	.6250	15.88	5/8	1 1/4	3 1/2	2	0.030	B52076	B06816	B69076
5/8	.6250	15.88	5/8	1 1/4	3 1/2	2	0.060	B52077	B06817	B69077
5/8	.6250	15.88	5/8	1 1/4	3 1/2	2	0.090	B52078	B06818	B69078
5/8	.6250	15.88	5/8	2 1/4	5	2	0.000	B51214	B01324	B68214
5/8	.6250	15.88	5/8	3	6	2	0.000	B51414	B01395	B68414
3/4	.7500	19.05	3/4	1	3	2	0.000	B52631	B01635	B81583
3/4	.7500	19.05	3/4	1 1/2	4	2	0.000	B52051	B01472	B00065
3/4	.7500	19.05	3/4	1 1/2	4	2	0.030	B52080	B06820	B69080
3/4	.7500	19.05	3/4	1 1/2	4	2	0.060	B52081	B06821	B69081
3/4	.7500	19.05	3/4	1 1/2	4	2	0.090	B52082	B06822	B69082
3/4	.7500	19.05	3/4	2 1/4	5	2	0.000	B51216	B61216	B68216
3/4	.7500	19.05	3/4	3	6	2	0.000	B51416	B01396	B68416
7/8	.8750	22.23	7/8	1 1/2	4	2	0.000	B52053	B01473	B69053
7/8	.8750	22.23	7/8	2 1/4	5	2	0.000	B51218	B01325	B68218
7/8	.8750	22.23	7/8	3	6	2	0.000	B51418	B01326	B68418
1	1.0000	25.40	1	1 1/2	4	2	0.000	B52057	B01474	B00067
1	1.0000	25.40	1	1 1/2	4	2	0.030	B52084	B06824	B69084
1	1.0000	25.40	1	1 1/2	4	2	0.060	B52085	B06825	B69085
1	1.0000	25.40	1	1 1/2	4	2	0.090	B52086	B06826	B69086
1	1.0000	25.40	1	2 1/4	5	2	0.000	B51220	B01327	B68220
1	1.0000	25.40	1	3	6	2	0.000	B51420	B01398	B68420

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



Single End General-Purpose

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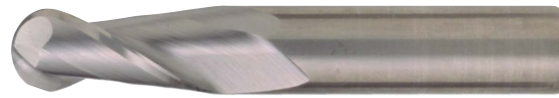
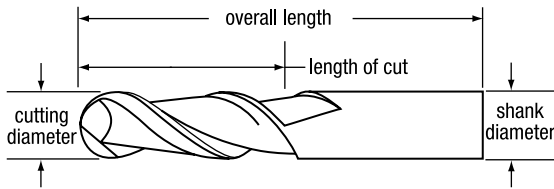
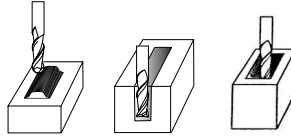
Series **MSE-2B**

Applications |

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

Features |

- SOLID CARBIDE
- 2 FLUTE BALL CC
- BRIGHT
- TiCN
- TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAlN
1/32	.0312	0.79	1/8	1/8	1 1/2	2	B52681	B01651	B69681
3/64	.0469	1.19	1/8	1/8	1 1/2	2	B52682	B01652	B69682
1/16	.0625	1.59	1/8	1/8	1 1/2	2	B52684	B01653	B69684
1/16	.0625	1.59	1/8	1/4	1 1/2	2	B52201	B01509	B69201
5/64	.0781	1.98	1/8	1/4	1 1/2	2	B52202	B01564	B69202
3/32	.0938	2.38	1/8	3/8	1 1/2	2	B52204	B01511	B69204
7/64	.1094	2.78	1/8	3/8	1 1/2	2	B52205	B01512	B69205
1/8	.1250	3.18	1/8	1/4	1 1/2	2	B52688	B01655	B69688
1/8	.1250	3.18	1/8	1/2	1 1/2	2	B52207	B01513	B69207
1/8	.1250	3.18	1/8	3/4	2 1/4	2	B51300	B01360	B68300
1/8	.1250	3.18	1/8	1	3	2	B51500	B01414	B68500
9/64	.1406	3.57	3/16	9/16	2	2	B52208	B01566	B69208
5/32	.1562	3.97	3/16	9/16	2	2	B52210	B01515	B69210
11/64	.1719	4.37	3/16	5/8	2	2	B52211	B01516	B69211
3/16	.1875	4.76	3/16	5/16	2	2	B52692	B01657	B69692
3/16	.1875	4.76	3/16	5/8	2	2	B52213	B01517	B00236
3/16	.1875	4.76	3/16	3/4	2 1/2	2	B51302	B01363	B68302
3/16	.1875	4.76	3/16	1 1/8	3	2	B51502	B01415	B68502
13/64	.2031	5.16	1/4	5/8	2 1/2	2	B52214	B01364	B69214
7/32	.2188	5.56	1/4	5/8	2 1/2	2	B52216	B01568	B69216
15/64	.2344	5.95	1/4	3/4	2 1/2	2	B52217	B01570	B69217
1/4	.2500	6.35	1/4	1/2	2	2	B52697	B01659	B69697
1/4	.2500	6.35	1/4	3/4	2 1/2	2	B52220	B01521	B69220
1/4	.2500	6.35	1/4	1 1/8	3	2	B51304	B01359	B68304
1/4	.2500	6.35	1/4	1 1/2	4	2	B51504	B01427	B68504
1/4	.2500	6.35	1/4	1 1/2	6	2	B51505	B01416	B68505
17/64	.2656	6.75	5/16	3/4	2 1/2	2	B52221	B01572	B69221
9/32	.2812	7.14	5/16	3/4	2 1/2	2	B52223	B01575	B69223
5/16	.3125	7.94	5/16	1/2	2	2	B52699	B01660	B69699
5/16	.3125	7.94	5/16	13/16	2 1/2	2	B52226	B01525	B00241
5/16	.3125	7.94	5/16	1 1/8	3	2	B51306	B01361	B68306
5/16	.3125	7.94	5/16	1 5/8	4	2	B51506	B01417	B68506

continued on next page

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



# Single End General-Purpose

## Series MSE-2B (continued)

cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAIN
3/8	.3750	9.53	3/8	5/8	2	2	B52701	B01661	B69701
3/8	.3750	9.53	3/8	1	2 1/2	2	B52232	B01529	B12014
3/8	.3750	9.53	3/8	1 1/8	3	2	B51308	B01362	B68308
3/8	.3750	9.53	3/8	1 3/4	4	2	B51508	B01418	B68508
3/8	.3750	9.53	3/8	1 1/2	6	2	B51509	B01419	B68509
7/16	.4375	11.11	7/16	5/8	2 1/2	2	B52703	B01662	B69703
7/16	.4375	11.11	7/16	7/8	2 1/2	2	B52238	B01584	B12015
7/16	.4375	11.11	7/16	2	4	2	B51310	B01365	B68310
7/16	.4375	11.11	7/16	3	6	2	B51510	B01420	B68510
1/2	.5000	12.70	1/2	5/8	2 1/2	2	B52706	B01663	B69706
1/2	.5000	12.70	1/2	1	3	2	B52245	B01537	B00244
1/2	.5000	12.70	1/2	2	4	2	B51312	B01367	B68312
1/2	.5000	12.70	1/2	3	6	2	B51512	B01422	B68512
1/2	.5000	12.70	1/2	1 1/2	6	2	B51511	B01366	B68511
9/16	.5625	14.29	9/16	1 1/4	3	2	B52247	B01617	B69247
5/8	.6250	15.88	5/8	3/4	3	2	B52708	B01664	B69708
5/8	.6250	15.88	5/8	1 1/4	3 1/2	2	B52249	B01539	B00246
5/8	.6250	15.88	5/8	2 1/4	5	2	B51314	B01368	B68314
5/8	.6250	15.88	5/8	3	6	2	B51514	B01423	B68514
3/4	.7500	19.05	3/4	1	3	2	B52711	B01665	B69711
3/4	.7500	19.05	3/4	1 1/2	4	2	B52251	B01540	B69251
3/4	.7500	19.05	3/4	2 1/4	5	2	B51316	B01369	B68316
3/4	.7500	19.05	3/4	3	6	2	B51516	B01424	B68516
7/8	.8750	22.23	7/8	1 1/2	4	2	B52253	B01595	B69253
7/8	.8750	22.23	7/8	2 1/4	5	2	B51318	B01370	B68318
7/8	.8750	22.23	7/8	3	6	2	B51518	B01425	B68518
1	1.0000	25.40	1	1 1/2	4	2	B52257	B01542	B00250
1	1.0000	25.40	1	2 1/4	5	2	B51320	B01371	B68320
1	1.0000	25.40	1	3	6	2	B51520	B01426	B68520

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



Single End General-Purpose

BASSETT™

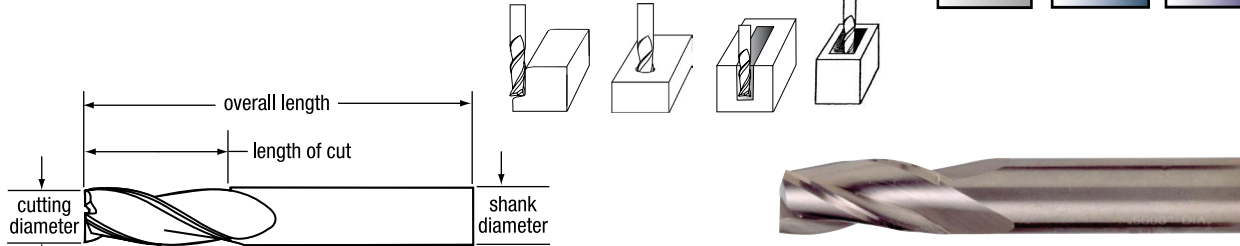
Series MSE-3

Applications |

STEEL | CAST IRON | HI-TEMP ALLOYS | NON-FERROUS MATERIALS

Features |

SOLID CARBIDE | 3 FLUTE CC | CORNER RADIUS | BRIGHT | TiCN | TiAlN



	cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
	fractional	decimal	metric						bright	TiCN	TiAlN
	1/16	.0625	1.59	1/8	1/4	1 1/2	3	0.000	B27104	B37104	B67104
	5/64	.0781	1.98	1/8	1/4	1 1/2	3	0.000	B27105	B37105	B67105
	3/32	.0938	2.38	1/8	3/8	1 1/2	3	0.000	B27106	B37106	B67106
	7/64	.1094	2.78	1/8	3/8	1 1/2	3	0.000	B27107	B37107	B67107
	1/8	.1250	3.18	1/8	1/2	1 1/2	3	0.000	B27108	B37108	B67108
	1/8	.1250	3.18	1/8	1/2	1 1/2	3	0.010	B27200	B37200	B67200
	9/64	.1406	3.57	3/16	9/16	2	3	0.000	B27109	B37109	B67109
	5/32	.1562	3.97	3/16	9/16	2	3	0.000	B27110	B37110	B67110
	11/64	.1719	4.37	3/16	5/8	2	3	0.000	B27111	B37111	B67111
	3/16	.1875	4.76	3/16	5/8	2	3	0.000	B27112	B37112	B67112
	3/16	.1875	4.76	3/16	5/8	2	3	0.010	B27201	B37201	B67201
	13/64	.2031	5.16	1/4	5/8	2 1/2	3	0.000	B27113	B37113	B67113
	7/32	.2188	5.56	1/4	5/8	2 1/2	3	0.000	B27114	B37114	B67114
	15/64	.2344	5.95	1/4	3/4	2 1/2	3	0.000	B27115	B37115	B67115
	1/4	.2500	6.35	1/4	3/4	2 1/2	3	0.000	B27116	B11971	B67116
	1/4	.2500	6.35	1/4	3/4	2 1/2	3	0.020	B27202	B37202	B67202
	1/4	.2500	6.35	1/4	3/4	2 1/2	3	0.030	B27203	B37203	B67203
	17/64	.2656	6.75	5/16	3/4	2 1/2	3	0.000	B27117	B37117	B67117
	9/32	.2812	7.14	5/16	3/4	2 1/2	3	0.000	B27118	B37118	B67118
	5/16	.3125	7.94	5/16	13/16	2 1/2	3	0.000	B27120	B11972	B67120
	5/16	.3125	7.94	5/16	13/16	2 1/2	3	0.020	B27205	B37205	B67205
	5/16	.3125	7.94	5/16	13/16	2 1/2	3	0.030	B27206	B37206	B67206
	3/8	.3750	9.53	3/8	7/8	2 1/2	3	0.000	B27124	B11973	B67124
	3/8	.3750	9.53	3/8	7/8	2 1/2	3	0.020	B27208	B37208	B67208
	3/8	.3750	9.53	3/8	7/8	2 1/2	3	0.030	B27209	B37209	B67209
	3/8	.3750	9.53	3/8	7/8	2 1/2	3	0.045	B27210	B37210	B67210
	7/16	.4375	11.11	7/16	7/8	2 1/2	3	0.000	B27128	B11974	B67128
	1/2	.5000	12.70	1/2	1	3	3	0.000	B27132	B11975	B67132
	1/2	.5000	12.70	1/2	1	3	3	0.030	B27212	B37212	B67212
	1/2	.5000	12.70	1/2	1	3	3	0.060	B27213	B37213	B67213
	1/2	.5000	12.70	1/2	1	3	3	0.090	B27214	B37214	B67214
	9/16	.5625	14.29	9/16	1 1/4	3	3	0.000	B27136	B37136	B67136
	5/8	.6250	15.88	5/8	1 1/4	3 1/2	3	0.000	B27140	B11976	B67140
	5/8	.6250	15.88	5/8	1 1/4	3 1/2	3	0.030	B27216	B37216	B67216
	5/8	.6250	15.88	5/8	1 1/4	3 1/2	3	0.060	B27217	B37217	B67217
	5/8	.6250	15.88	5/8	1 1/4	3 1/2	3	0.090	B27218	B37218	B67218
	3/4	.7500	19.05	3/4	1 1/2	4	3	0.000	B27148	B11977	B67148
	3/4	.7500	19.05	3/4	1 1/2	4	3	0.030	B27220	B37220	B67220
	3/4	.7500	19.05	3/4	1 1/2	4	3	0.060	B27221	B37221	B67221
	3/4	.7500	19.05	3/4	1 1/2	4	3	0.090	B27222	B37222	B67222
	7/8	.8750	22.23	7/8	1 1/2	4	3	0.000	B27156	B11986	B67156
	1	1.0000	25.40	1	1 1/2	4	3	0.000	B27164	B11978	B67164
	1	1.0000	25.40	1	1 1/2	4	3	0.030	B27224	B37224	B67224
	1	1.0000	25.40	1	1 1/2	4	3	0.060	B27225	B37225	B67225
	1	1.0000	25.40	1	1 1/2	4	3	0.090	B27226	B37226	B67226



# Single End General-Purpose

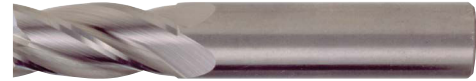
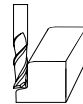
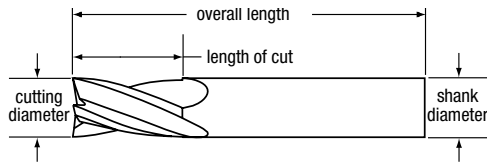
## Series MSE-4

### Applications |

STEEL
CAST IRON
NON-FERROUS MATERIALS
HI-TEMP ALLOYS

### Features |

SOLID CARBIDE
4+ FLUTE CC
CORNER RADIUS
  
BRIGHT
TiCN
TiAlN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
fractional	decimal	metric						bright	TiCN	TiAlN
1/32	.0312	0.79	1/8	1/16	1 1/2	4	0.000	B52643	-----	B69643
1/32	.0312	0.79	1/8	1/8	1 1/2	4	0.000	B52641	B01636	B69641
3/64	.0469	1.19	1/8	1/8	1 1/2	4	0.000	B52642	B01637	B69642
1/16	.0625	1.59	1/8	1/8	1 1/2	4	0.000	B52644	B01638	B69644
1/16	.0625	1.59	1/8	1/4	1 1/2	4	0.000	B52101	B01475	B69101
1/16	.0625	1.59	1/8	1/4	1 1/2	4	0.010	B52645	-----	B69645
5/64	.0781	1.98	1/8	1/4	1 1/2	4	0.000	B52102	B01476	B69102
3/32	.0938	2.38	1/8	1/4	1 1/2	4	0.000	B52646	B01639	B69646
3/32	.0938	2.38	1/8	3/8	1 1/2	4	0.000	B52104	B01477	B69104
3/32	.0938	2.38	1/8	3/8	1 1/2	4	0.010	B52106	-----	B69106
3/32	.0938	2.38	1/8	3/8	1 1/2	4	0.020	B52190	-----	B69157
7/64	.1094	2.78	1/8	1/4	1 1/2	4	0.000	B52118	-----	B62118
7/64	.1094	2.78	1/8	3/8	1 1/2	4	0.000	B52105	B01478	B69105
1/8	.1250	3.18	1/8	1/4	1 1/2	4	0.000	B52648	B01640	B69648
1/8	.1250	3.18	1/8	1/2	1 1/2	4	0.000	B52107	B01479	B69107
1/8	.1250	3.18	1/8	1/2	1 1/2	4	0.010	B52160	B01750	B69160
1/8	.1250	3.18	1/8	1/2	1 1/2	4	0.015	B52191	-----	B69158
1/8	.1250	3.18	1/8	1/2	1 1/2	4	0.020	B52095	-----	B62095
1/8	.1250	3.18	1/8	1/2	1 1/2	4	0.030	B52192	-----	B69159
1/8	.1250	3.18	1/8	3/4	2 1/4	4	0.000	B51250	B01343	B68250
1/8	.1250	3.18	1/8	1	3	4	0.000	B51450	B01399	B68450
1/8	.1250	3.18	1/8	1	3	4	0.045	B52096	-----	B62096
9/64	.1406	3.57	3/16	9/16	2	4	0.000	B52108	B01480	B69108
5/32	.1562	3.97	3/16	5/16	2	4	0.000	B52650	B01641	B69650
5/32	.1562	3.97	3/16	9/16	2	4	0.000	B52110	B01481	B69110
11/64	.1719	4.37	3/16	5/8	2	4	0.000	B52111	B01482	B69111
3/16	.1875	4.76	3/16	5/16	2	4	0.000	B52652	B01642	B69652
3/16	.1875	4.76	3/16	5/8	2	4	0.000	B52113	B01483	B69113
3/16	.1875	4.76	3/16	5/8	2	4	0.010	B52162	B01751	B69162
3/16	.1875	4.76	3/16	5/8	2	4	0.015	B52087	-----	B62087
3/16	.1875	4.76	3/16	5/8	2	4	0.020	B52088	-----	B62088
3/16	.1875	4.76	3/16	5/8	2	4	0.030	B52089	-----	B62089
3/16	.1875	4.76	3/16	3/4	2 1/2	4	0.000	B51252	B01344	B68252
3/16	.1875	4.76	3/16	1	3	4	0.000	B52090	-----	B62090
3/16	.1875	4.76	3/16	1	3	4	0.045	B52193	-----	B69163
3/16	.1875	4.76	3/16	1	4	4	0.000	B51451	-----	B68451
3/16	.1875	4.76	3/16	1	4	4	0.045	B52091	-----	B62091
3/16	.1875	4.76	3/16	1 1/8	3	4	0.000	B51452	B01400	B68452

continued on next page

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Solid Carbide End Mills



**BASSETT™**

# Single End General-Purpose

Series **MSE-4** (continued)

	cutting diameter			shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
	fractional	decimal	metric						bright	TiCN	TiAlN
	13/64	.2031	5.16	1/4	5/8	2 1/2	4	0.000	B52114	B01484	B69114
	7/32	.2188	5.56	1/4	5/8	2 1/2	4	0.000	B52116	B01485	B69116
	15/64	.2344	5.95	1/4	3/4	2 1/2	4	0.000	B52117	B01486	B69117
	6mm	.2362	6.00	6mm	32mm	100mm	4	0.000	B52194	-----	B69115
	1/4	.2500	6.35	1/4	1/2	2	4	0.000	B52657	B01644	B69657
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.000	B52120	B01487	B69120
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.010	B52092	-----	B62092
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.015	B52093	-----	B62093
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.020	B52164	B01752	B69164
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.030	B52165	B01753	B69165
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.045	B69118	-----	B69119
	1/4	.2500	6.35	1/4	3/4	2 1/2	4	0.060	B52195	-----	B69122
	1/4	.2500	6.35	1/4	1 1/8	3	4	0.000	B51254	B01340	B68254
	1/4	.2500	6.35	1/4	1 1/2	4	4	0.000	B51454	B01732	B68454
	1/4	.2500	6.35	1/4	1 1/2	6	4	0.000	B51455	B01402	B68455
	17/64	.2656	6.75	5/16	3/4	2 1/2	4	0.000	B52121	B01730	B69121
	9/32	.2812	7.14	5/16	3/4	2 1/2	4	0.000	B52123	B01489	B69123
	19/64	.2969	7.54	5/16	7/8	2 1/2	4	0.000	B52196	-----	B69124
	5/16	.3125	7.94	5/16	1/2	2	4	0.000	B52659	B01645	B81587
	5/16	.3125	7.94	5/16	13/16	2 1/2	4	0.000	B52126	B01491	B69126
	5/16	.3125	7.94	5/16	13/16	2 1/2	4	0.020	B52167	B01755	B69167
	5/16	.3125	7.94	5/16	13/16	2 1/2	4	0.030	B52168	B01756	B69168
	5/16	.3125	7.94	5/16	1	3	4	0.000	B52097	-----	B68457
	5/16	.3125	7.94	5/16	1 1/8	3	4	0.000	B51256	B01347	B68256
	5/16	.3125	7.94	5/16	1 5/8	4	4	0.000	B51456	B01403	B68456
	21/64	.3281	8.33	3/8	7/8	2 1/2	4	0.000	B51475	-----	B68475
	11/32	.3438	8.73	3/8	7/8	2 1/2	4	0.000	B51476	-----	B69129
	23/64	.3594	9.13	3/8	7/8	2 1/2	4	0.000	B51477	-----	B68477
	3/8	.3750	9.53	3/8	5/8	2	4	0.000	B52661	B01646	B81588
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.000	B52132	B01495	B69132
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.010	B52430	-----	B69130
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.015	B52431	-----	B69131
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.020	B52170	B01758	B69170
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.030	B52171	B01759	B69171
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.045	B52172	B01760	B69172
	3/8	.3750	9.53	3/8	1	2 1/2	4	0.060	B52134	-----	B69134
	3/8	.3750	9.53	3/8	1	4	4	0.000	B52472	-----	B68472
	3/8	.3750	9.53	3/8	1	4	4	0.020	B52436	-----	B69136
	3/8	.3750	9.53	3/8	1 1/8	3	4	0.000	B51258	B01348	B68258
	3/8	.3750	9.53	3/8	1 3/4	4	4	0.000	B51458	B01733	B68458
	3/8	.3750	9.53	3/8	1 1/2	6	4	0.000	B51459	B01405	B68459
	25/64	.3906	9.92	7/16	7/8	2 3/4	4	0.000	B52274	-----	B61074
	13/32	.4062	10.32	7/16	7/8	2-3/4	4	0.000	B52098	-----	B62098
	27/64	.4218	10.71	7/16	7/8	2-3/4	4	0.000	B52099	-----	B62099
	7/16	.4375	11.11	7/16	5/8	2 1/2	4	0.000	B52663	B01647	B69663
	7/16	.4375	11.11	7/16	1	2 1/2	4	0.000	B52138	B01499	B69138
	7/16	.4375	11.11	7/16	2	4	4	0.000	B51260	B01341	B68260
	7/16	.4375	11.11	7/16	3	6	4	0.000	B51460	B01734	B68460

continued on next page

CARBIDE END MILLS  
CARBIDE DRILLS  
CARBIDE THREAD MILLS  
CARBIDE BURS  
INDEX



# Single End General-Purpose

## Series MSE-4 (continued)

fractional	cutting diameter		shank diameter	length of cut	overall length	no. of flutes	corner radius	EDP number		
	decimal	metric						bright	TiCN	TiAlN
29/64	.4531	11.51	1/2	1	3	4	0.000	B52276	-----	B62276
15/32	.4688	11.91	1/2	1	3	4	0.000	B52277	-----	B62077
31/64	.4844	12.30	1/2	1	3	4	0.000	B52278	-----	B62078
1/2	.5000	12.70	1/2	5/8	2 1/2	4	0.000	B52666	B01648	B81590
1/2	.5000	12.70	1/2	1	3	4	0.000	B52145	B01503	B69145
1/2	.5000	12.70	1/2	1	3	4	0.015	B52243	-----	B69143
1/2	.5000	12.70	1/2	1	3	4	0.020	B52244	-----	B69144
1/2	.5000	12.70	1/2	1	3	4	0.030	B52173	B01762	B69173
1/2	.5000	12.70	1/2	1	3	4	0.045	B52246	-----	B69146
1/2	.5000	12.70	1/2	1	3	4	0.060	B52174	B01763	B69174
1/2	.5000	12.70	1/2	1	3	4	0.090	B52175	B01764	B69175
1/2	.5000	12.70	1/2	1	3	4	0.125	B52185	-----	B62100
1/2	.5000	12.70	1/2	2	4	4	0.000	B51262	B01352	B68262
1/2	.5000	12.70	1/2	3	6	4	0.000	B51462	B01408	B68462
1/2	.5000	12.70	1/2	1 1/2	6	4	0.000	B51461	B01407	B68461
9/16	.5625	14.29	9/16	1 1/4	3	4	0.000	B52147	B01765	B69147
5/8	.6250	15.88	5/8	3/4	3	4	0.000	B52668	B01649	B81591
5/8	.6250	15.88	5/8	1 1/4	3 1/2	4	0.000	B52149	B01505	B69149
5/8	.6250	15.88	5/8	1 1/4	3 1/2	4	0.030	B52176	B01766	B69176
5/8	.6250	15.88	5/8	1 1/4	3 1/2	4	0.060	B52177	B01767	B69177
5/8	.6250	15.88	5/8	1 1/4	3 1/2	4	0.090	B52178	B01768	B69178
5/8	.6250	15.88	5/8	2 1/4	5	4	0.000	B51264	B01342	B68264
5/8	.6250	15.88	5/8	3	6	4	0.000	B51464	B01409	B68464
3/4	.7500	19.05	3/4	1	3	4	0.000	B52671	B01650	B81592
3/4	.7500	19.05	3/4	1 1/2	4	4	0.000	B52151	B01506	B69151
3/4	.7500	19.05	3/4	1 1/2	4	4	0.030	B52179	B01770	B69179
3/4	.7500	19.05	3/4	1 1/2	4	4	0.060	B52180	B01771	B69180
3/4	.7500	19.05	3/4	1 1/2	4	4	0.090	B52181	B01772	B69181
3/4	.7500	19.05	3/4	2 1/4	5	4	0.000	B51266	B01351	B68266
3/4	.7500	19.05	3/4	3	6	4	0.000	B51466	B01410	B68466
7/8	.8750	22.23	7/8	1 1/2	4	4	0.000	B52153	B01507	B69153
7/8	.8750	22.23	7/8	2 1/4	5	4	0.000	B51268	B01355	B68268
7/8	.8750	22.23	7/8	3	6	4	0.000	B51468	B01735	B68468
1	1.0000	25.40	1	1 1/2	4	4	0.000	B52157	B01508	B00046
1	1.0000	25.40	1	1 1/2	4	4	0.030	B52182	B01774	B69182
1	1.0000	25.40	1	1 1/2	4	4	0.060	B52183	B01775	B69183
1	1.0000	25.40	1	1 1/2	4	4	0.090	B52184	B01776	B69184
1	1.0000	25.40	1	2 1/4	5	4	0.000	B51270	B01356	B68270
1	1.0000	25.40	1	3	6	4	0.000	B51470	B01412	B68470

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



Single End General-Purpose

**BASSETT™**

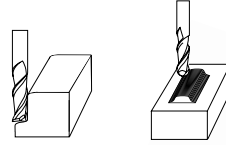
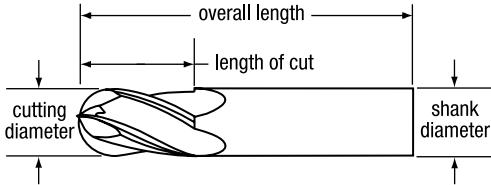
Series **MSE-4B**

Applications |

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

Features |

- SOLID CARBIDE
- 4 FLUTE BALL CO.
- BRIGHT
- TiCN
- TiAIN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAIN
1/32	.0312	0.79	1/8	1/16	1 1/2	4	B52516	-----	B69716
1/32	.0312	0.79	1/8	1/8	1 1/2	4	B52721	B01434	B69721
1/32	.0312	0.79	1/8	3/32	1 1/2	4	B52517	-----	B69717
1mm	.0394	1mm	3mm	2mm	38mm	4	B52518	-----	B69718
1mm	.0394	1mm	3mm	4mm	38mm	4	B52219	-----	B69719
3/64	.0469	1.19	1/8	1/8	1 1/2	4	B52722	B01435	B69722
1.5mm	.0591	1.5mm	3mm	6mm	38mm	4	B52520	-----	B69720
1/16	.0625	1.59	1/8	1/8	1 1/2	4	B52724	B01668	B69724
1/16	.0625	1.59	1/8	1/4	1 1/2	4	B52301	B01901	B69301
5/64	.0781	1.98	1/8	1/4	1 1/2	4	B52302	B01902	B69302
2mm	.0790	2mm	3mm	8mm	38mm	4	B52187	-----	B69303
3/32	.0938	2.38	1/8	3/8	1 1/2	4	B52304	B01904	B69304
3/32	.0938	2.38	1/8	3/16	1 1/2	4	B52506	-----	B69306
7/64	.1094	2.78	1/8	3/8	1 1/2	4	B52305	B01905	B69305
1/8	.1250	3.18	1/8	1/4	1 1/2	4	B52728	B01670	B69728
1/8	.1250	3.18	1/8	1/2	1 1/2	4	B52307	B01547	B00018
1/8	.1250	3.18	1/8	5/8	2	4	B52599	-----	B68499
1/8	.1250	3.18	1/8	3/4	2 1/4	4	B51350	B01374	B68350
1/8	.1250	3.18	1/8	1	3	4	B51550	B01850	B68550
9/64	.1406	3.57	3/16	9/16	2	4	B52308	B01908	B69308
5/32	.1562	3.97	3/16	5/16	2	4	B52509	-----	B69309
5/32	.1562	3.97	3/16	9/16	2	4	B52310	B01549	B69310
11/64	.1719	4.37	3/16	5/8	2	4	B52311	B01911	B69311
3/16	.1875	4.76	3/16	5/16	2	4	B52732	B01672	B69732
3/16	.1875	4.76	3/16	5/8	2	4	B52313	B01551	B69313
3/16	.1875	4.76	3/16	3/4	2 1/2	4	B51352	B01377	B68352
3/16	.1875	4.76	3/16	1 1/8	3	4	B51552	B01852	B68552
13/64	.2031	5.16	1/4	5/8	2 1/2	4	B52314	B01914	B69314
7/32	.2188	5.56	1/4	5/8	2 1/2	4	B52316	B01553	B69316
15/64	.2344	5.95	1/4	3/4	2 1/2	4	B52317	B01917	B69317
1/4	.2500	6.35	1/4	1/2	2	4	B52737	B01674	B69737
1/4	.2500	6.35	1/4	3/4	2 1/2	4	B52320	B01555	B69320
1/4	.2500	6.35	1/4	1	4	4	B52293	-----	B68503
1/4	.2500	6.35	1/4	1 1/8	3	4	B51354	B01373	B68354
1/4	.2500	6.35	1/4	1 1/2	4	4	B51554	B01854	B68554
1/4	.2500	6.35	1/4	1 1/2	6	4	B51555	B01430	B68555
17/64	.2656	6.75	5/16	3/4	2 1/2	4	B52321	B01921	B69321
9/32	.2812	7.14	5/16	3/4	2 1/2	4	B52323	B01557	B69323

continued on next page

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



# Single End General-Purpose

## Series MSE-4B (continued)

cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number		
fractional	decimal	metric					bright	TiCN	TiAlN
5/16	.3125	7.94	5/16	1/2	2	4	B52739	B01675	B69739
5/16	.3125	7.94	5/16	13/16	2 1/2	4	B52326	B01559	B69326
5/16	.3125	7.94	5/16	1 1/8	3	4	B51356	B01375	B68356
5/16	.3125	7.94	5/16	1 5/8	4	4	B51556	B01856	B68556
23/64	.3594	9.13	3/8	7/8	2 1/2	4	B52457	-----	B01857
3/8	.3750	9.53	3/8	5/8	2	4	B52741	B01676	B69741
3/8	.3750	9.53	3/8	1	2 1/2	4	B52332	B01563	B00025
3/8	.3750	9.53	3/8	1 1/8	3	4	B51358	B01376	B68358
3/8	.3750	9.53	3/8	1 1/2	6	4	B51559	B01433	B68559
3/8	.3750	9.53	3/8	1 3/4	4	4	B51558	B01858	B68558
25/64	.3906	9.92	7/16	7/8	2-3/4	4	B52188	-----	B68574
27/64	.4219	10.71	7/16	7/8	2 3/4	4	B52475	-----	B68575
7/16	.4375	11.11	7/16	5/8	2 1/2	4	B52743	B01439	B69743
7/16	.4375	11.11	7/16	1	2 1/2	4	B52338	B01567	B35859
7/16	.4375	11.11	7/16	2	4	4	B51360	B01378	B68360
7/16	.4375	11.11	7/16	3	6	4	B51560	B01860	B68560
31/64	.4844	12.30	1/2	1	3	4	B52363	-----	B68563
1/2	.5000	12.70	1/2	5/8	2 1/2	4	B52746	B01678	B69746
1/2	.5000	12.70	1/2	1	3	4	B52345	B01571	B69345
1/2	.5000	12.70	1/2	2	4	4	B51362	B01380	B68362
1/2	.5000	12.70	1/2	1 1/2	6	4	B51561	B01431	B68561
1/2	.5000	12.70	1/2	3	6	4	B51562	B01436	B68562
9/16	.5625	14.29	9/16	1 1/4	3	4	B52347	B01947	B69347
5/8	.6250	15.88	5/8	3/4	3	4	B52748	B01679	B69748
5/8	.6250	15.88	5/8	1 1/4	3 1/2	4	B52349	B01573	B00028
5/8	.6250	15.88	5/8	2 1/4	5	4	B51364	B01379	B68364
5/8	.6250	15.88	5/8	3	6	4	B51564	B01437	B68564
3/4	.7500	19.05	3/4	1	3	4	B52751	B01680	B69751
3/4	.7500	19.05	3/4	1 1/2	4	4	B52351	B01574	B00030
3/4	.7500	19.05	3/4	2 1/4	5	4	B51366	B01381	B68366
3/4	.7500	19.05	3/4	3	6	4	B51566	B01438	B68566
7/8	.8750	22.23	7/8	1 1/2	4	4	B52353	B01953	B69353
7/8	.8750	22.23	7/8	2 1/4	5	4	B51368	B01382	B68368
7/8	.8750	22.23	7/8	3	6	4	B51568	B01868	B68568
1	1.0000	25.40	1	1 1/2	4	4	B52357	B01576	B00032
1	1.0000	25.40	1	2 1/4	5	4	B51370	B01383	B68370
1	1.0000	25.40	1	3	6	4	B51570	B01440	B68570

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Solid Carbide End Mills



Single End General-Purpose

BASSETT™

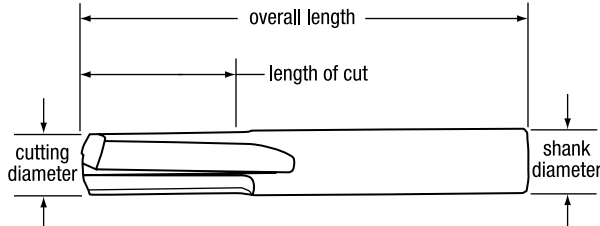
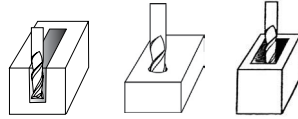
Series MEST-2 • straight flutes

Applications |

- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- NON-FERROUS MATERIALS

Features |

- SOLID CARBIDE
- 2 FLUTE CC
- BRIGHT
- TiAIN



cutting diameter			shank diameter	length of cut	overall length	no. of flutes	EDP number	
fractional	decimal	metric					bright	TiAIN
1/16	.0625	1.59	1/8	3/16	1 1/2	2	B53201	B70201
1/8	.1250	3.18	1/8	1/2	1 1/2	2	B53203	B70203
3/16	.1875	4.76	3/16	5/8	2	2	B53205	B70205
1/4	.2500	6.35	1/4	3/4	2 1/2	2	B53207	B70207
5/16	.3125	7.94	5/16	13/16	2 1/2	2	B53210	B70210
3/8	.3750	9.53	3/8	7/8	2 1/2	2	B53212	B70212
1/2	.5000	12.70	1/2	1	3	2	B53215	B70215

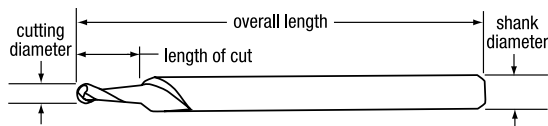
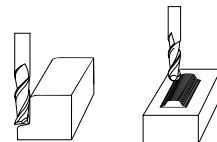
Series MEG-2 Engraving Tool

Applications |

- STEEL
- CAST IRON
- NON-FERROUS MATERIALS

Features |

- SOLID CARBIDE
- 2 FLUTE BALL CC
- TiCN



cutting diameter		shank diameter	length of cut	overall length	no. of flutes	EDP number	
decimal	metric					TiCN	
.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	



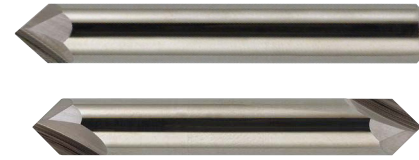
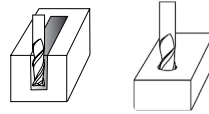
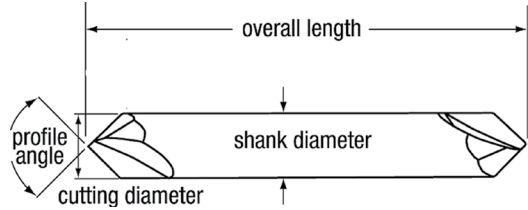
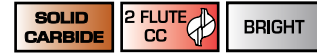
# Chamfer Tools

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

**Applications** |



**Features** |



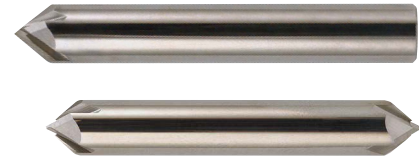
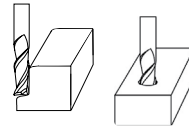
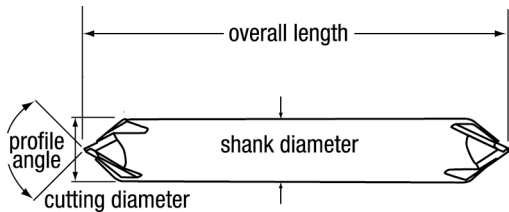
cutting diameter			shank diameter	overall length	no. of flutes	profile angle (°)	EDP number	
fractional	decimal	metric					single end	double end
1/8	.1250	3.18	1/8	1 1/2	2	60	B10010	-----
1/8	.1250	3.18	1/8	1 1/2	2	82	B10013	-----
1/8	.1250	3.18	1/8	1 1/2	2	90	B10014	B10026
3/16	.1875	4.76	3/16	2	2	90	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
3/8	.3750	9.53	3/8	2 1/2	2	120	B10012	-----
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-4D 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
3/8	.3750	9.53	3/8	2 1/2	4	120	B10011	-----
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





**BASSETT™**



***Carbide Drills***



# Contents

Style No.	Description	Page No.
	Operating Parameters . . . . .	37
DHP-5 . . .	High-Performance 5xD Jobber Length Drill . . . . .	38
DHPCF-5 . .	Coolant-Feed High-Performance 5xD Jobber Length Drill . . . . .	39
DHPCF-8 . .	Coolant-Feed High-Performance 8xD Jobber Length Drill . . . . .	40
DR . . . . .	Jobber Length, fractional, wire, letter sizes . . . . .	.41-42
DRS . . . . .	Stub Length, fractional, wire sizes. . . . .	.42-43
DM . . . . .	Straight Flute Stub Length, fractional, wire sizes . . . . .	.44-45
DS . . . . .	Spade Stub Length, fractional sizes. . . . .	45
DC . . . . .	Combination Drill and Countersink, fractional sizes. . . . .	45

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

## 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

Solid Carbide Drills



**BASSETT™**

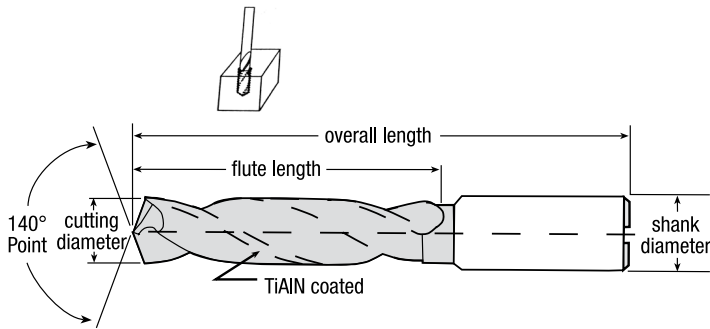
# High-Performance

## Series DHP-5 High-Performance Jobber Length Drill

**Applications**



**Features**



	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		.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
			.4134		.472	12.0	2.36	60.0	4.72	120.0	B56146
			.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: h7; Shank Diameter: h6

CARBIDE END MILLS  
CARBIDE DRILLS  
CARBIDE THREAD MILLS  
CARBIDE BURS  
INDEX



# High-Performance

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

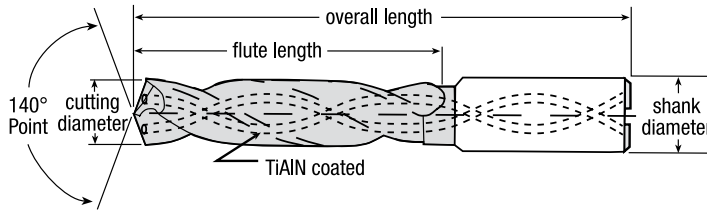
### Applications

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



### Features

- SUB-MICRON CARBIDE SUBSTRATE
- 140°
- 5 X DIA DEPTH
- TiAIN
- 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
	1/4	6.0	.2362	.236	6.0	1.732	44.0	3.228	82.0	B54368
		6.0	.2362	.236	6.0	1.732	44.0	3.228	82.0	B54368
		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		.2813	.313	7.9	2.080	52.8	3.580	90.9	B54391
	19/64		.2969	.313	7.9	2.080	52.8	3.580	90.9	B54398
	5/16		.3125	.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		.3281	.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		.3750	.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		.4063	.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		.4375	.438	11.1	2.800	71.1	4.640	117.9	B54450
	29/64		.4531	.500	12.7	3.030	77.0	4.875	123.8	B54453
	15/32		.4688	.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		.4844	.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		.5000	.500	12.7	3.030	77.0	4.875	123.8	B54460

**TOLERANCE** - Drill Diameter: h7; Shank Diameter: h6

Solid Carbide Drills



**BASSETT™**

# High-Performance

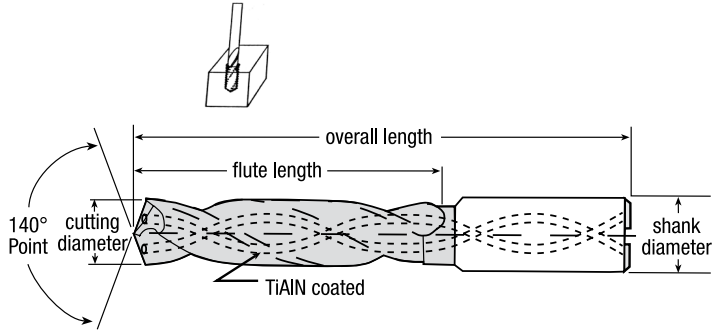
## Series **DHPCF-8** High-Performance Coolant Fed Jobber Length Drill

**Applications**

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

**Features**

- SUB-MICRON CARBIDE SUBSTRATE
- 140°
- TiAIN
- 8 X DIA DEPTH
- 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
		3.5	.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: h7; Shank Diameter: h6

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

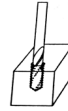
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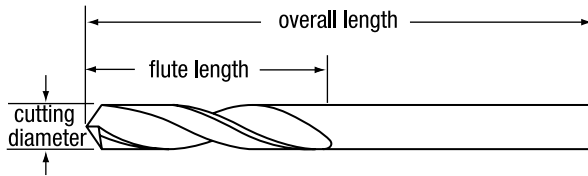
# Jobber Length

## Series DR Jobber Length Drill

### Applications



### Features



cutting diameter	flute length	overall length	EDP number
frac wire/let decimal	length	length	
1/32			B53509
			B53511
			B53512
			B53514
			B53515
			B53518
3/64			B53521
			B53523
			B53525
			B53529
1/16			B53531
			B53533
			B53536
			B53538
			B53541
			B53543
5/64			B53545
			B53546
			B53549
			B53550
			B53553
			B53556
			B53559
3/32			B53560
			B53562
			B53564
			B53566
			B53567
			B53569
			B53571
7/64			B53573
			B53574
			B53576
			B53577
			B53579
			B53581
1/8			B53583
			B53586
			B53589
			B53591
9/64			B53592
			B53594

cutting diameter	flute length	overall length	EDP number
frac wire/let decimal	length	length	
			B53596
			B53598
			B53600
			B53602
5/32			B53603
			B53604
			B53606
			B53607
			B53610
			B53613
11/64			B53614
			B53615
			B53617
			B53619
			B53621
			B53622
3/16			B53625
			B53626
			B53628
			B53630
			B53631
			B53633
			B53635
13/64			B53637
			B53638
			B53640
			B53643
			B53645
7/32			B53647
			B53649
			B53652
			B53655
15/64			B53657
			B53660
			B53662
			B53664
1/4			B53666
			B53670
			B53672
17/64			B53675
			B53677
			B53678

continued on next page



Solid Carbide Drills



**BASSETT™**

# Jobber Length • Stub Length

## Series DR Jobber Length Drill (continued)

	cutting diameter		flute length	overall length	EDP number
	frac	wire/let decimal			
	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
19/64	M	.2950	2 3/8	3 3/4	B53689
		.2969	2 3/8	3 3/4	B53691
5/16	N	.3020	2 3/8	3 3/4	B53693
		.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

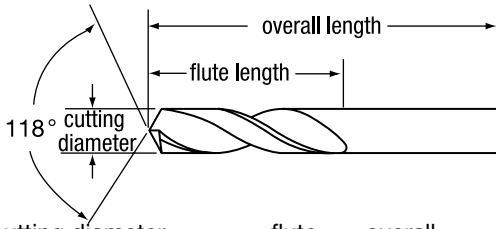
	cutting diameter		flute length	overall length	EDP number
	frac	wire/let decimal			
3/8	U	.3680	2 3/4	4 1/4	B53718
		.3750	2 3/4	4 1/4	B53720
	V	.3770	2 7/8	4 1/4	B53722
	W	.3860	2 7/8	4 1/2	B53724
25/64		.3906	2 7/8	4 1/2	B53725
	X	.3970	2 7/8	4 1/2	B53727
13/32		.4040	2 7/8	4 1/2	B53729
	Y	.4062	2 7/8	4 1/2	B53731
27/64		.4130	2 7/8	4 1/2	B53732
	Z	.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 Stub Length Drill

### Applications |



### Features |



	cutting diameter		flute length	overall length	EDP number
	frac	wire decimal			
	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
1/16	55	.0520	3/8	1 1/2	B36055
	54	.0550	3/8	1 1/2	B36054
	53	.0595	3/8	1 1/2	B36053
	52	.0625	3/8	1 1/2	B36404
	51	.0635	3/8	1 1/2	B36052
5/64	50	.0670	3/8	1 1/2	B36051
	49	.0700	3/8	1 1/2	B36050
	48	.0730	3/8	1 1/2	B36049
	47	.0760	1/2	1 1/2	B36048
	46	.0781	1/2	1 1/2	B36405
	45	.0785	1/2	1 1/2	B36047
	44	.0810	1/2	1 1/2	B36046
	43	.0820	1/2	1 1/2	B36045

	cutting diameter		flute length	overall length	EDP number
	frac	wire decimal			
3/32	44	.0860	1/2	2	B36044
	43	.0890	1/2	2	B36043
	42	.0935	1/2	2	B36042
	41	.0938	1/2	2	B36406
	40	.0960	1/2	2	B36041
7/64	39	.0980	5/8	2	B36040
	38	.0995	5/8	2	B36039
	37	.1015	5/8	2	B36038
	36	.1040	5/8	2	B36037
	35	.1065	5/8	2	B36036
	34	.1094	5/8	2	B36407
	33	.1100	5/8	2	B36035
	32	.1110	5/8	2	B36034
	31	.1130	5/8	2	B36033
	30	.1160	5/8	2	B36032
1/8	29	.1200	5/8	2	B36031
	28	.1250	5/8	2	B36408
	27	.1285	5/8	2	B36030

continued on next page



# Stub Length

## Series DRS Stub Length Drill (continued)

cutting diameter frac	wire	decimal	flute length	overall length	EDP number
9/64	29	.1360	5/8	2	B36029
		.1406	5/8	2	B36409
	28	.1405	5/8	2	B36028
	27	.1440	5/8	2	B36027
	26	.1470	5/8	2	B36026
5/32	25	.1495	5/8	2	B36025
	24	.1520	5/8	2	B36024
	23	.1540	5/8	2	B36023
		.1563	3/4	2	B36410
	22	.1570	3/4	2	B36022
11/64	21	.1590	3/4	2	B36021
	20	.1610	3/4	2	B36020
	19	.1660	3/4	2 1/8	B36019
	18	.1695	3/4	2 1/8	B36018
		.1719	3/4	2 1/8	B36411
3/16	17	.1730	3/4	2 1/8	B36017
	16	.1770	3/4	2 1/8	B36016
	15	.1800	3/4	2 3/16	B36015
	14	.1820	3/4	2 3/16	B36014
	13	.1850	3/4	2 3/16	B36013
9/64	12	.1875	3/4	2 3/16	B36412
	11	.1890	3/4	2 3/16	B36012
	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	

cutting diameter frac	wire/letter	decimal	flute length	overall length	EDP number	
13/64	7	.2010	3/4	2 1/4	B36007	
		.2031	3/4	2 1/4	B36413	
	6	.2040	3/4	2 1/4	B36006	
	5	.2055	3/4	2 1/4	B36005	
	4	.2090	3/4	2 1/4	B36004	
7/32	3	.2130	1	2 1/2	B36003	
		.2188	1	2 1/2	B36414	
	2	.2210	1	2 1/2	B36002	
	1	.2280	1	2 1/2	B36001	
	15/64		.2344	1	2 1/2	B36415
17/64	1/4	.2500	1	2 1/2	B36416	
		.2656	1	2 1/2	B36417	
	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
	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
	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

INDEX

Solid Carbide Drills



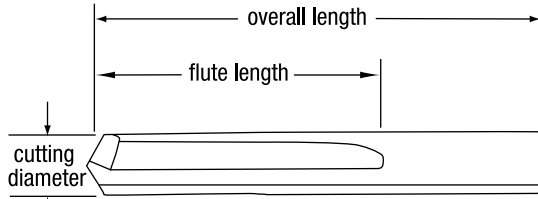
Straight Flute

**BASSETT™**

Series **DM** Straight Flute Drill

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

Features | **SOLID CARBIDE** | **140° 4-FACET** | **BRIGHT**



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

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



# Straight Flute • Spade • Drill and Countersink

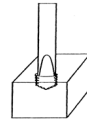
## Series DM Straight Flute Drill (continued)

cutting diameter frac	cutting diameter decimal	flute length	overall length	EDP number
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
29/64	.4531	2 1/8	3 9/16	B54266

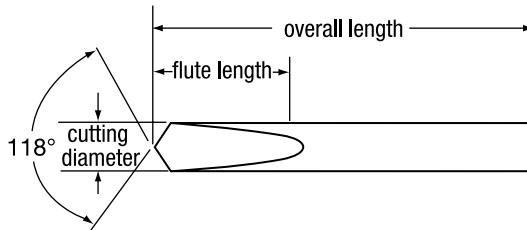
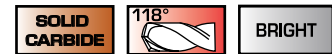
cutting diameter frac	cutting diameter decimal	flute length	overall length	EDP number
15/32	.4688	2 1/8	3 5/8	B54267
31/64	.4844	2 3/16	3 11/16	B54268
1/2	.5000	2 1/4	3 3/4	B54270

## Series DS Spade Stub Length Drill

### Applications



### Features



cutting diameter fractional	cutting diameter decimal	flute length	overall length	EDP number
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

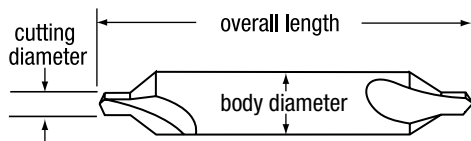
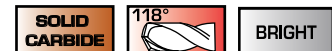
cutting diameter fractional	cutting diameter decimal	flute length	overall length	EDP number
7/32	.2188	19/32	2	B53464
1/4	.2500	11/16	2	B53467
3/8	.3750	1	2 1/2	B53475

## Series DC Combination Stub Length Drill and Countersink

### Applications



### Features



tool number	cutting diameter fraction	cutting diameter decimal	body diameter	overall length	EDP number
1	3/64	.125	1/8	1 1/2	B53431
2	5/64	.188	3/16	2	B53432
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



**BASSETT™**



## ***Thread Mills***





Style No.	Description	Page No.
	Operating Parameters . . . . .	.47
	TM/TMC . . . . . UN Thread Mills, with and without coolant . . . . .	.48
	TMNP/TMNPC . . . . . NPT / NPTF Thread Mills, with and without coolant . . . . .	.49
	TMBPP/TMBPPC . . . . . BSPP Thread Mills, with and without coolant . . . . .	.49
	TMBPT/TMBPTC . . . . . BSPT Thread Mills, with and without coolant . . . . .	.49
	TMM/TMMC . . . . . Metric Thread Mills, with and without coolant . . . . .	.50
<b>NEW</b>	BMTM2/BMTM3 . . . . . Mini Thread Mills . . . . .	51a
	BMTMM2/BMTMM3 . . . . . Metric Mini Thread Mills . . . . .	51b
	Thread Mill Programming Request Form. . . . .	51c

**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
		feed per tooth (inches)					
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



**Solid Carbide Helical Thread Mills**



**UN/UNC**

**BASSETT™**

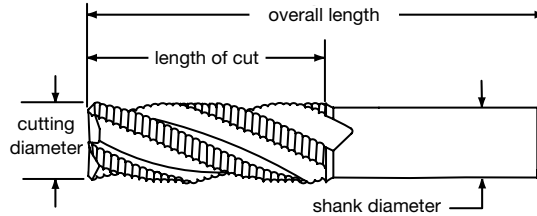
Series **TM Solid** and **TMC Coolant-Thru** Thread Mills for Internal and External Threads

**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

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



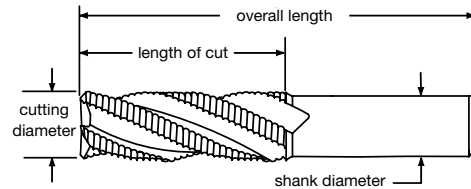
**Solid Carbide Helical Thread Mills**

**NPT / NPTF • BSPP • BSPT**

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

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

**Features** | NPT / NPTF SOLID CARBIDE TiAIN

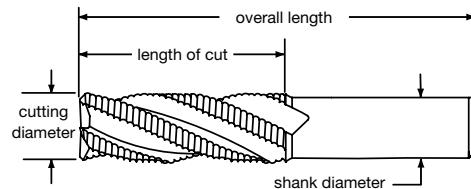


thread size	shank diameter	cutting diameter	length of cut	overall length	number of flutes	EDP number	
						non-coolant	coolant-thru
1/16-27	1/4	.245	.437	2 1/2	3	B71050	B71550
1/8-27	5/16	.310	.437	2 1/2	4	B71051	B71551
1/4, 3/8-18	3/8	.305	.625	3	4	B71052	B71552
1/2, 3/4-14	1/2	.495	.875	3 1/2	4	B71055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

Series **TMBPP Solid** and **TMBPPC Coolant-Thru** Thread Mills for Internal and External Threads

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

**Features** | BSPP SOLID CARBIDE TiAIN

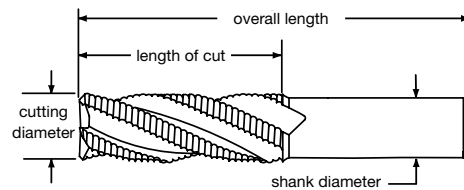


thread size	shank diameter	cutting diameter	length of cut	overall length	number of flutes	EDP number	
						non-coolant	coolant-thru
1/16, 1/8-28	1/4	.240	.572	2 1/2	3	B71100	B71600
1/4-19	5/16	.312	.737	3	4	B71101	B71601
1/2-14	1/2	.470	1.143	3 1/2	4	B71102	B71602
1-11	5/8	.620	1.546	4	5	B71104	B71604

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

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

**Solid Carbide Helical Thread Mills**



**BASSETT™**

**Metric**

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

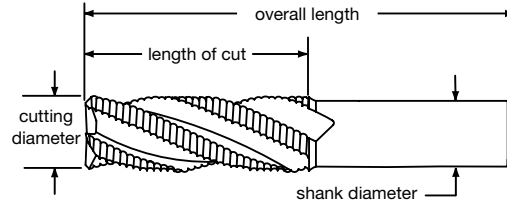
CARBIDE END MILLS

**Applications**

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

**Features**

- SOLID CARBIDE
- METRIC
- TiAlN



CARBIDE DRILLS

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	—
M4.5 X 0.75	1/8	.120	.250	2	3	B71071	—
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

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Series **BMTM2**  $2 \times d_1$  ( $l \leq 2 \times$  Thread Diameter)

Applications

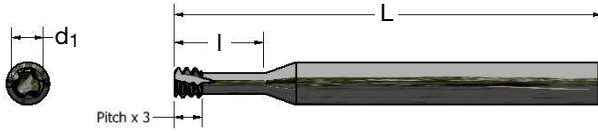
NON-FERROUS MATERIALS
  STEEL
  STAINLESS STEEL
  HI-TEMP ALLOYS

Features

SOLID CARBIDE
  INCH
  AlCrN

Note

\* Bore diameter applies to the smallest thread diameter.



American UN	UNC	UNF	TPI	thread pitch	description	class of fit	shank dia	d <sub>1</sub> cutting dia	L overall length	l cut depth	pitch x 3 thread length	no. of flutes	no. of teeth	*bore dia.	order number
<b>BMTM2</b>															
	1-72		72	0.014	BMTM2-0571154-72UN	2B	1/4	.057	2.5	.154	0.042	3	3	.060	B76124
1-64		2-64	64	0.016	BMTM2-0571165-64UN	2B	1/4	.057	2.5	.165	0.047	3	3	.060	B76125
2-56		3-56	56	0.018	BMTM2-0651197-56UN	2B	1/4	.065	2.5	.197	0.054	3	3	.069	B76126
3-48		4-48	48	0.021	BMTM2-0751236-48UN	2B	1/4	.075	2.5	.236	0.063	3	3	.080	B76127
4, 5-40		6-40	40	0.025	BMTM2-0851236-40UN	2B	1/4	.085	2.5	.236	0.075	3	3	.090	B76128
		8-36	36	0.028	BMTM2-1151343-36UN	2B	1/4	.115	2.5	.343	0.083	3	3	.125	B76129
6, 8-32		10-32	32	0.031	BMTM2-1001292-32UN	2B	1/4	.100	2.5	.292	0.094	3	3	.110	B76130
8-32		10-32	32	0.031	BMTM2-1201394-32UN	2B	1/4	.120	2.5	.394	0.094	3	3	.130	B76131
		1/4x28	28	0.036	BMTM2-1801520-28UN	2B	1/4	.180	2.5	.520	0.107	3	3	.190	B76132
10-24		5/16x24	24	0.042	BMTM2-1301400-24UN	2B	1/4	.130	2.5	.400	0.125	3	3	.140	B76133
		5/16x24	24	0.042	BMTM2-2401650-24UN	2B	1/4	.240	2.5	.650	0.125	3	3	.255	B76134
1/4x20		7/16x20	20	0.05	BMTM2-1851530-20UN	2B	1/4	.185	2.5	.530	0.150	3	3	.200	B76135
		7/16x20	20	0.05	BMTM2-3401900-20UN	2B	3/8	.340	3	.900	0.150	4	3	.355	B76136
3/8x16			16	0.063	BMTM2-2901750-16UN	2B	3/8	.290	3	.750	0.188	4	3	.307	B76137
7/16x14			14	0.071	BMTM2-3401900-14UN	2B	3/8	.340	3	.900	0.214	4	3	.355	B76138
1/2-13			13	0.077	BMTM2-35011.10-13UN	2B	3/8	.350	3	1.10	0.231	4	3	.415	B76139

Series **BMTM3**  $3 \times d_1$  ( $l \leq 3 \times$  Thread Diameter)

Applications

NON-FERROUS MATERIALS
  STEEL
  STAINLESS STEEL
  HI-TEMP ALLOYS

Features

SOLID CARBIDE
  INCH
  AlCrN

Note

\* Bore diameter applies to the smallest thread diameter.

American UN	UNC	UNF	TPI	thread pitch	description	class of fit	shank dia	d <sub>1</sub> cutting dia	L overall length	l cut depth	pitch x 3 thread length	no. of flutes	no. of teeth	*bore dia.	order number
<b>BMTM3</b>															
	1-72		72	0.014	BMTM3-0571240-72UN	2B	1/4	.057	2.5	.240	0.042	3	3	.060	B76140
2-56		3-56	56	0.018	BMTM3-0651260-56UN	2B	1/4	.065	2.5	.260	0.054	3	3	.069	B76141
4, 5-40		6-40	40	0.025	BMTM3-0851310-40UN	2B	1/4	.085	2.5	.310	0.075	3	3	.090	B76142
5-40		6-40	40	0.025	BMTM3-1001400-32UN	2B	1/4	.100	2.5	.400	0.075	3	3	.110	B76143
8-32		10-32	32	0.031	BMTM3-1201500-32UN	2B	1/4	.120	2.5	.500	0.094	3	3	.130	B76144
		1/4x28	28	0.036	BMTM3-1801750-28UN	2B	1/4	.180	2.5	.750	0.107	3	3	.190	B76145
1/4x20		7/16x20	20	0.05	BMTM3-1851750-20UN	2B	1/4	.185	2.5	.750	0.150	3	3	.200	B76146
		5/16x24	24	0.042	BMTM3-2401940-24UN	2B	1/4	.240	2.5	.940	0.125	3	3	.255	B76147
5/16x18			18	0.056	BMTM3-2401900-18UN	2B	1/4	.240	2.5	.900	0.167	3	3	.255	B76148

## Mini Solid Carbide Helical Thread Mills



**BASSETT™**

# Metric

Series **BMTMM2**  $2 \times d_1$  ( $l \leq 2 \times$  Thread Diameter)

### Applications

NON-FERROUS MATERIALS

STEEL

STAINLESS STEEL

HI-TEMP ALLOYS

### Features

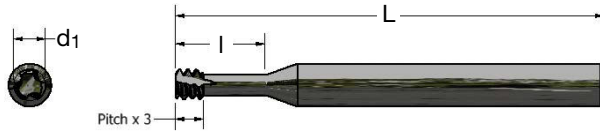
SOLID CARBIDE

METRIC

AlCrN

#### Note

\* Bore diameter applies to the smallest thread diameter.



ISO metric		pitch		description	class of fit	shank dia	d <sub>1</sub> cutting dia	L overall length	l cut depth	pitch x 3 thread length	no. of flutes	no. of teeth	*bore dia.	order number
M course	M fine	mm	inch											
M1.6x0.35		0.35	0.014	BMTMM2-0471140-0.35ISO	6H	1/8	.047	2.5	.140	0.042	3	3	.050	B76149
M2x0.4		0.4	0.016	BMTMM2-0601165-0.4ISO	6H	1/4	.060	2.5	.165	0.048	3	3	.065	B76150
M2.2x0.45		0.45	0.018	BMTMM2-0651180-0.45ISO	6H	1/4	.065	2.5	.180	0.054	3	3	.070	B76151
M2.5x0.45		0.45	0.018	BMTMM2-0751200-0.45ISO	6H	1/4	.075	2.5	.200	0.054	3	3	.080	B76152
M3x0.5	M3.5-M16x0.5	0.5	0.020	BMTMM2-0901245-05ISO	6H	1/4	.090	2.5	.245	0.060	3	3	.095	B76153
M3.5x0.6		0.6	0.024	BMTMM2-1051285-061ISO	6H	1/4	.105	2.5	.285	0.072	3	3	.111	B76154
M4x0.7		0.7	0.028	BMTMM2-1201325-0.7ISO	6H	1/4	.120	2.5	.325	0.084	3	3	.126	B76155
M5x0.8		0.8	0.031	BMTMM2-1551400-0.81ISO	6H	1/4	.155	2.5	.400	0.093	3	3	.161	B76156
M6x1.0	M8-M40x1.0	1	0.039	BMTMM2-1851500-1.0ISO	6H	1/4	.185	2.5	.500	0.117	3	3	.193	B76157
M8x1.25		1.25	0.049	BMTMM2-2451650-1.25ISO	6H	1/4	.245	2.5	.650	0.147	3	3	.257	B76158
M10x1.5	M12-M48x1.50	1.5	0.059	BMTMM2-3301800-1.5ISO	6H	3/8	.330	3	.800	0.177	3	3	.343	B76159
M12x1.75		1.75	0.069	BMTMM2-36011.0-1.75ISO	6H	3/8	.360	3	1.000	0.207	4	3	.395	B76160

Series **BMTMM3**  $3 \times d_1$  ( $l \leq 3 \times$  Thread Diameter)

### Applications

NON-FERROUS MATERIALS

STEEL

STAINLESS STEEL

HI-TEMP ALLOYS

### Features

SOLID CARBIDE

METRIC

AlCrN

#### Note

\* Bore diameter applies to the smallest thread diameter.

ISO metric		pitch		description	class of fit	shank dia	d <sub>1</sub> cutting dia	L overall length	l cut depth	pitch x 3 thread length	no. of flutes	no. of teeth	*bore dia.	order number
M course	M fine	mm	inch											
M1.6x0.35		0.35	0.014	BMTMM3-0471197-0.35ISO	6H	1/8	.047	2.5	.197	0.042	3	3	.050	B76161
M2x0.4		0.4	0.016	BMTMM3-0601245-04ISO	6H	1/4	.060	2.5	.245	0.048	3	3	.065	B76162
M2.5x0.45		0.45	0.018	BMTMM3-0751275-0.45ISO	6H	1/4	.075	2.5	.275	0.054	3	3	.080	B76163
M3x0.5	M3.5-M16x0.5	0.5	0.020	BMTMM3-0901360-0.5ISO	6H	1/4	.090	2.5	.360	0.060	3	3	.095	B76164
M4x0.7		0.7	0.028	BMTMM3-1201490-07ISO	6H	1/4	.120	2.5	.490	0.084	3	3	.126	B76165
M5x0.8		0.8	0.031	BMTMM3-1551610-08ISO	6H	1/4	.155	2.5	.610	0.093	3	3	.161	B76166
M6x1.0	M8-M40x1.0	1	0.039	BMTMM3-1851725-1.0ISO	6H	1/4	.185	2.5	.725	0.117	3	3	.193	B76167
M8x1.25		1.25	0.049	BMTMM3-2451725-1.25ISO	6H	1/4	.245	2.5	.970	0.147	3	3	.257	B76168



# Thread Mill Programming Request Form

Greenfield Industries offers free programming assistance to users of our thread milling products. 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.

Endures Company Name \_\_\_\_\_

Contact \_\_\_\_\_

Telephone Number \_\_\_\_\_

Email Address \_\_\_\_\_

Distributor Name \_\_\_\_\_

Distributor Telephone Number \_\_\_\_\_

Distributor or Endures  
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 \_\_\_\_\_

Order Number \_\_\_\_\_

Tool Diameter \_\_\_\_\_

Number of Flutes \_\_\_\_\_

**FAX TO**  
**1-800-892-4290**





**BASSETT**™



***Solid Carbide Burs***



## Contents & Technical Information

Style No.	Shape	Page No.
BA . . .	Cylindrical, No End Cut . . . . .	54
BAE . . .	Cylindrical with End Cut . . . . .	54
BC . . .	Cylindrical, Ball Nose . . . . .	55
BD . . .	Ball Shape . . . . .	55
BE . . .	Egg Shape . . . . .	56
BF . . .	Round Nose Tree Shape . . . . .	56
BG . . .	Pointed Tree Shape . . . . .	57
BH . . .	Flame Shape . . . . .	57
BL . . .	Included Cone Radius Shape . . . . .	58
BM . . .	Pointed Cone Shape . . . . .	58
BN . . .	Inverted Taper, No End Cut . . . . .	59

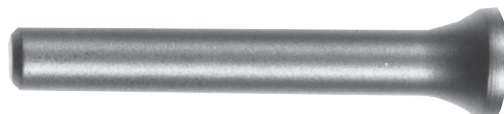
### Standard Shank Styles



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.

### ALL NEW! Carbide Extension Burs

now available on many style types. In this section indicated by **NEW** next to the USCTI number.

**NEW**

Features: Wide selection of shapes and sizes, constructed from solid carbide, bright surface treatment, right-hand spiral cut and double cut available, solid carbide shanks (Styles A and D) and brazed steel shanks (Styles B and C) available.

### 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.

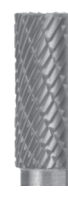
Secondly, shank size must be selected. The correct shank will be determined by the size of the equipment being used and considering the diameter and length of the fluted portion of the bur.

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 offband 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

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

**Solid Carbide Burs**



**Cylindrical**

**BASSETT™**

Series BA, Cylindrical Burs without End Cut



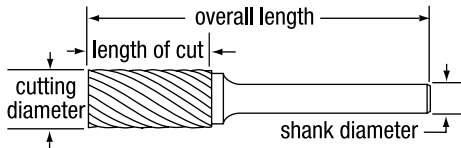
**Applications** | STEEL | CAST IRON | NON-FERROUS MATERIALS | STAINLESS STEEL

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



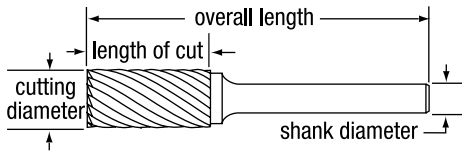
**Applications** | STEEL | CAST IRON | HI-TEMP ALLOYS | STAINLESS STEEL

**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
<b>NEW</b> SA-1L6	1/4	.2500	1/2	6-1/2	1/4	C	B55900	B55923
SA-3	3/8	.3750	3/4	2-1/2	1/4	C	B54803	B54812
<b>NEW</b> SA-3L6	3/8	.3750	3/4	6-3/4	1/4	C	B55901	B55924
SA-5	1/2	.5000	1	2-3/4	1/4	C	B54804	B54813
<b>NEW</b> SA-5L6	1/2	.5000	1	7	1/4	C	B55902	B55925
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** | STEEL | CAST IRON | HI-TEMP ALLOYS | STAINLESS STEEL

**Features** | SOLID CARBIDE | ALUMINUM CUT | BRIGHT | **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
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	B	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" solid carbide. B – 1/8" hardened steel. C – 1/4" hardened steel. D – 1/4" solid carbide.

CARBIDE END MILLS

CARBIDE END MILLS

CARBIDE DRILLS

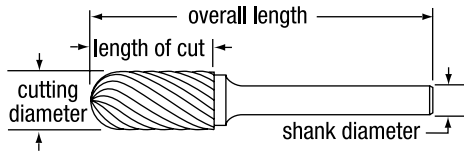
CARBIDE BURS

INDEX



# Cylindrical • Ball

## Series BC, Cylindrical Burs with Ball Nose

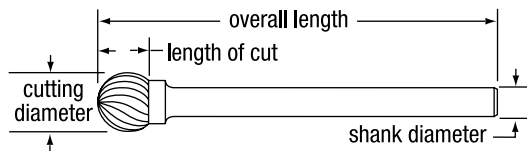


**Applications** | NON-FERROUS MATERIALS

**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
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	D	B54874	B54883	B55862
<b>NEW</b> SC-1L6	1/4	.2500	1/2	6-1/2	1/4	C	B55903	B55926	-
SC-3	3/8	.3750	3/4	2-1/2	1/4	C	B54875	B54884	B55863
<b>NEW</b> SC-3L6	3/8	.3750	3/4	6-3/4	1/4	C	B55904	B55927	-
SC-5	1/2	.5000	1	2-3/4	1/4	C	B54876	B54885	B55864
<b>NEW</b> SC-5L6	1/2	.5000	1	7	1/4	C	B55905	B55928	-
SC-6	5/8	.6250	1	2-3/4	1/4	C	B54877	B54886	-
SC-7	3/4	.7500	1	2-3/4	1/4	C	B54878	B54887	B55865

## Series BD, Ball Shape



**Applications** | NON-FERROUS MATERIALS

**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
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
<b>NEW</b> SD-1L6	1/4	.2500	7/32	6-7/32	1/4	C	B55906	B55929	-
SD-3	3/8	.3750	3/8	2-5/64	1/4	C	B54911	B54920	B55868
<b>NEW</b> SD-3L6	3/8	.3750	5/16	6-5/16	1/4	C	B55907	B55930	-
SD-5	1/2	.5000	1/2	2-13/64	1/4	C	B54912	B54921	B55869
<b>NEW</b> SD-5L6	1/2	.5000	7/16	6-7/16	1/4	C	B55908	B55931	-
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" solid carbide. B – 1/8" hardened steel. C – 1/4" hardened steel. D – 1/4" solid carbide.



**Solid Carbide Burs**

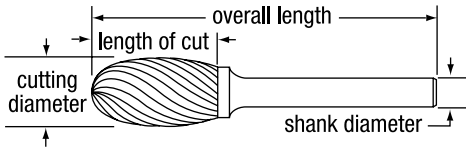


**Egg • Round Nose Tree**

**BASSETT™**

Series BE, Egg Shape

CARBIDE END MILLS



**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



CARBIDE END MILLS

CARBIDE DRILLS

**Applications**

- NON-FERROUS MATERIALS

**Features**

- SOLID CARBIDE
- ALUMINUM CUT
- BRIGHT

**Applications**

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

**Features**

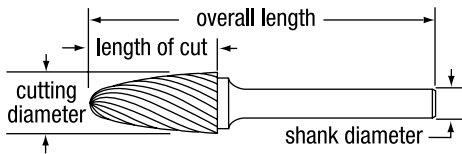
- SOLID CARBIDE
- DOUBLE CUT
- BRIGHT



SCTI reference	cutting diameter		length of cut	overall length	shank diameter	shank type	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	-
<b>NEW</b> SE-1L6	1/4	.2500	3/8	6-3/8	1/4	C	B55909	B55932	-
SE-3	3/8	.3750	5/8	2-3/8	1/4	C	B54947	B54956	B55873
<b>NEW</b> SE-3L6	3/8	.3750	5/8	6-5/8	1/4	C	B55910	B55933	-
SE-5	1/2	.5000	7/8	2-5/8	1/4	C	B54948	B54957	B55874
<b>NEW</b> SE-5L6	1/2	.5000	7/8	6-7/8	1/4	C	B55911	B55934	-
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

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



INDEX

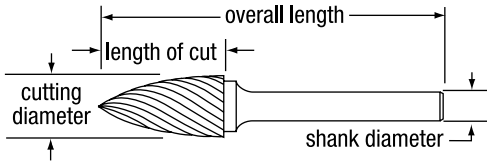
SCTI reference	cutting diameter		length of cut	overall length	shank diameter	shank type	EDP number		
	inch	decimal					standard	double	aluminum
SF-41	1/8	.1250	1/4	1-1/2	1/8	A	B55628	B55629	-
SF-42	1/8	.1250	1/2	1-1/2	1/8	A	B54981	B54990	-
SF-51	1/4	.2500	1/2	1-3/4	1/8	B	B55707	B55719	-
SF-1	1/4	.2500	5/8	2	1/4	D	B54982	B54991	B55878
<b>NEW</b> SF-1L6	1/4	.2500	1/2	6-1/2	1/4	C	B55912	B55935	-
SF-3	3/8	.3750	3/4	2-1/2	1/4	C	B54983	B54992	B55879
<b>NEW</b> SF-3L6	3/8	.3750	3/4	6-3/4	1/4	C	B55913	B55936	-
SF-5	1/2	.5000	1	2-3/4	1/4	C	B54984	B54993	B55880
<b>NEW</b> SF-5L6	1/2	.5000	1	7	1/4	C	B55914	B55937	-
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" solid carbide. B – 1/8" hardened steel. C – 1/4" hardened steel. D – 1/4" solid carbide.



# Pointed Tree • Flame Shape

Series BG, Pointed Tree Shape



**Applications** |

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

**Features** |

- SOLID CARBIDE
- STANDARD CUT
- BRIGHT



**Applications** |

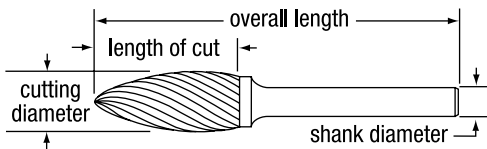
- STEEL
- CAST IRON
- HI-TEMP ALLOYS
- STAINLESS STEEL

**Features** |

- SOLID CARBIDE
- DOUBLE CUT
- BRIGHT

SCTI reference	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
<b>NEW</b> SG-1L6	1/4	.2500	1/2	6-1/2	1/4	C	B55915	B55938
SG-3	3/8	.3750	3/4	2-1/2	1/4	C	B55019	B55028
<b>NEW</b> SG-3L6	3/8	.3750	3/4	6-3/4	1/4	C	B55916	B55939
SG-5	1/2	.5000	1	2-3/4	1/4	C	B55020	B55029
<b>NEW</b> SG-5L6	1/2	.5000	1	7	1/4	C	B55917	B55940
SG-6	5/8	.6250	1	2-3/4	1/4	C	B55021	B55030

Series BH, Flame 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	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
<b>NEW</b> SH-2L6	5/16	.3125	3/4	6-3/4	1/4	C	B55918	B55941
SH-5	1/2	.5000	1-1/4	3	1/4	C	B55055	B55062
<b>NEW</b> SH-5L6	1/2	.5000	1-1/4	7-1/4	1/4	C	B55919	B55942

Shank Type: A – 1/8" solid carbide. B – 1/8" hardened steel. C – 1/4" hardened steel. D – 1/4" solid carbide.



Solid Carbide Burs

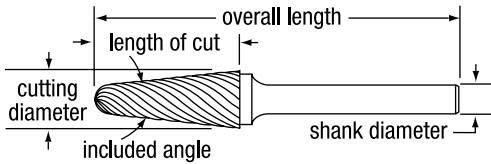


14° Included Cone, Radius • Pointed Cone

BASSETT™

Series BL, 14° Included Cone Radius Shape

CARBIDE END MILLS



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

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

CARBIDE END MILLS



**Applications** | NON-FERROUS MATERIALS

**Features** | SOLID CARBIDE | ALUMINUM CUT | BRIGHT



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

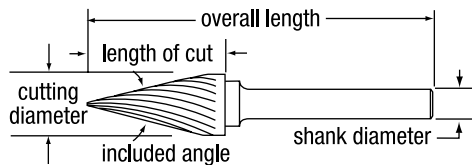
**Features** | SOLID CARBIDE | DOUBLE CUT | BRIGHT

CARBIDE DRILLS

SCTI reference	cutting diameter		length of cut	overall length	shank diameter	shank type	EDP number		
	inch	decimal					standard	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	B55170
SL-1	1/4	.2500	5/8	2	1/4	D	B55146	B55155	B55171
<b>NEW</b> SL-1L6	1/4	.2500	5/8	6-5/8	1/4	C	B55920	B55943	-
SL-3	3/8	.3750	1-1/16	2-15/16	1/4	C	B55147	B55156	-
<b>NEW</b> SL-3L6	3/8	.3750	1-1/16	7-1/16	1/4	C	B55921	B55944	-
SL-4	1/2	.5000	1-1/8	3	1/4	C	B55148	B55157	B55884
<b>NEW</b> SL-5L6	1/2	.5000	1-1/8	7-1/8	1/4	C	B55922	B55945	-
SL-6	5/8	.6250	1 5/16	3 3/16	1/4	C	B55149	B55158	B55885

Series BM, Pointed Cone 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

INDEX

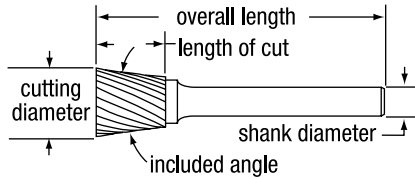
SCTI reference	included angle	cutting diameter		length of cut	overall length	shank diameter	shank type	EDP number	
		inch	decimal					standard	double
SM-41	12°	1/8	.1250	3/8	1-1/2	1/8	A	B55644	B55645
SM-42	14°	1/8	.1250	7/16	1-1/2	1/8	A	B55181	B55190
SM-43	7°	1/8	.1250	5/8	1-1/2	1/8	A	B55648	B55649
SM-51	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	D	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" solid carbide. B — 1/8" hardened steel. C — 1/4" hardened steel. D — 1/4" 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

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Shank Type: A – 1/8" solid carbide. B – 1/8" hardened steel. C – 1/4" hardened steel. D – 1/4" solid carbide.



**BASSETT**™



***Index by EDP Number***



**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
B00018	MSE-4B	32	B01362	MSE-2B	27	B01451	MSE-2	24	B01580	MDE-2	20
B00025	MSE-4B	33	B01363	MSE-2B	26	B01452	MSE-2	24	B01581	MDE-2	20
B00028	MSE-4B	33	B01364	MSE-2B	26	B01453	MSE-2	24	B01582	MDE-2	20
B00030	MSE-4B	33	B01365	MSE-2B	27	B01454	MSE-2	24	B01583	MDE-2	20
B00032	MSE-4B	33	B01366	MSE-2B	27	B01455	MSE-2	24	B01584	MSE-2B	27
B00046	MSE-4	31	B01367	MSE-2B	27	B01457	MSE-2	25	B01585	MDE-2	20
B00059	MSE-2	24	B01368	MSE-2B	27	B01461	MSE-2	25	B01586	MDE-2	20
B00062	MSE-2	25	B01369	MSE-2B	27	B01465	MSE-2	25	B01587	MDE-2	20
B00064	MSE-2	25	B01370	MSE-2B	27	B01469	MSE-2	25	B01588	MDE-4	22
B00065	MSE-2	25	B01371	MSE-2B	27	B01470	MSE-2	25	B01589	MDE-4	22
B00067	MSE-2	25	B01373	MSE-4B	32	B01471	MSE-2	25	B01590	MDE-4	22
B00207	MDE-2	20	B01374	MSE-4B	32	B01472	MSE-2	25	B01591	MDE-4	22
B00208	MDE-2	20	B01375	MSE-4B	33	B01473	MSE-2	25	B01592	MDE-4	22
B00209	MDE-2	20	B01376	MSE-4B	33	B01474	MSE-2	25	B01593	MDE-4	22
B00210	MDE-2	20	B01377	MSE-4B	32	B01475	MSE-4	29	B01594	MDE-4	22
B00211	MDE-2	20	B01378	MSE-4B	33	B01476	MSE-4	29	B01595	MSE-2B	27
B00212	MDE-2	20	B01379	MSE-4B	33	B01477	MSE-4	29	B01596	MDE-4	22
B00213	MDE-2	20	B01380	MSE-4B	33	B01478	MSE-4	29	B01597	MDE-4	22
B00215	MDE-2	20	B01381	MSE-4B	33	B01479	MSE-4	29	B01598	MDE-4	22
B00217	MDE-2	20	B01382	MSE-4B	33	B01480	MSE-4	29	B01599	MDE-2B	21
B00220	MDE-2	20	B01383	MSE-4B	33	B01481	MSE-4	29	B01600	MDE-2B	21
B00221	MDE-2	20	B01386	MSE-2	24	B01482	MSE-4	29	B01601	MDE-2B	21
B00222	MDE-2	20	B01388	MSE-2	24	B01483	MSE-4	29	B01602	MDE-2B	21
B00224	MDE-2	20	B01389	MSE-2	25	B01484	MSE-4	30	B01603	MDE-2B	21
B00225	MDE-2	20	B01391	MSE-2	25	B01485	MSE-4	30	B01604	MDE-2B	21
B00226	MDE-2	20	B01394	MSE-2	25	B01486	MSE-4	30	B01605	MDE-2B	21
B00227	MDE-2	20	B01395	MSE-2	25	B01487	MSE-4	30	B01607	MDE-2B	21
B00236	MSE-2B	26	B01396	MSE-2	25	B01489	MSE-4	30	B01608	MDE-2B	21
B00241	MSE-2B	26	B01398	MSE-2	25	B01491	MSE-4	30	B01609	MDE-2B	21
B00244	MSE-2B	27	B01399	MSE-4	29	B01495	MSE-4	30	B01610	MDE-4B	23
B00246	MSE-2B	27	B01400	MSE-4	29	B01499	MSE-4	30	B01611	MDE-4B	23
B00250	MSE-2B	27	B01402	MSE-4	30	B01503	MSE-4	31	B01612	MDE-4B	23
B00342	MDE-4	22	B01403	MSE-4	30	B01505	MSE-4	31	B01613	MDE-4B	23
B00345	MDE-4	22	B01405	MSE-4	30	B01506	MSE-4	31	B01614	MDE-4B	23
B00346	MDE-4	22	B01407	MSE-4	31	B01507	MSE-4	31	B01615	MDE-4B	23
B00348	MDE-4	22	B01408	MSE-4	31	B01508	MSE-4	31	B01616	MDE-4B	23
B00349	MDE-4	22	B01409	MSE-4	31	B01509	MSE-2B	26	B01617	MSE-2B	27
B00352	MDE-4	22	B01410	MSE-4	31	B01511	MSE-2B	26	B01618	MDE-4B	23
B00357	MDE-4	22	B01412	MSE-4	31	B01512	MSE-2B	26	B01619	MDE-4B	23
B00359	MDE-4	22	B01414	MSE-2B	26	B01513	MSE-2B	26	B01620	MDE-4B	23
B00360	MDE-4	22	B01415	MSE-2B	26	B01515	MSE-2B	26	B01621	MSE-2	24
B00362	MDE-4	22	B01416	MSE-2B	26	B01516	MSE-2B	26	B01622	MSE-2	24
B01318	MSE-2	24	B01417	MSE-2B	26	B01517	MSE-2B	26	B01623	MSE-2	24
B01319	MSE-2	24	B01418	MSE-2B	27	B01521	MSE-2B	26	B01624	MSE-2	24
B01320	MSE-2	25	B01419	MSE-2B	27	B01525	MSE-2B	26	B01625	MSE-2	24
B01321	MSE-2	25	B01420	MSE-2B	27	B01529	MSE-2B	27	B01627	MSE-2	24
B01322	MSE-2	25	B01422	MSE-2B	27	B01537	MSE-2B	27	B01629	MSE-2	24
B01323	MSE-2	25	B01423	MSE-2B	27	B01539	MSE-2B	27	B01630	MSE-2	25
B01324	MSE-2	25	B01424	MSE-2B	27	B01540	MSE-2B	27	B01631	MSE-2	25
B01325	MSE-2	25	B01425	MSE-2B	27	B01542	MSE-2B	27	B01632	MSE-2	25
B01326	MSE-2	25	B01426	MSE-2B	27	B01547	MSE-4B	32	B01633	MSE-2	25
B01327	MSE-2	25	B01427	MSE-2B	26	B01549	MSE-4B	32	B01634	MSE-2	25
B01329	MSE-2	24	B01430	MSE-4B	32	B01551	MSE-4B	32	B01635	MSE-2	25
B01330	MSE-2	24	B01431	MSE-4B	33	B01553	MSE-4B	32	B01636	MSE-4	29
B01331	MSE-2	24	B01433	MSE-4B	33	B01555	MSE-4B	32	B01637	MSE-4	29
B01333	MSE-2	25	B01434	MSE-4B	32	B01557	MSE-4B	32	B01638	MSE-4	29
B01334	MSE-2	25	B01435	MSE-4B	32	B01559	MSE-4B	33	B01639	MSE-4	29
B01338	MSE-2	25	B01436	MSE-4B	33	B01563	MSE-4B	33	B01640	MSE-4	29
B01340	MSE-4	30	B01437	MSE-4B	33	B01564	MSE-2B	26	B01641	MSE-4	29
B01341	MSE-4	30	B01438	MSE-4B	33	B01566	MSE-2B	26	B01642	MSE-4	29
B01342	MSE-4	31	B01439	MSE-4B	33	B01567	MSE-4B	33	B01644	MSE-4	30
B01343	MSE-4	29	B01440	MSE-4B	33	B01568	MSE-2B	26	B01645	MSE-4	30
B01344	MSE-4	29	B01441	MSE-2	24	B01570	MSE-2B	26	B01646	MSE-4	30
B01347	MSE-4	30	B01442	MSE-2	24	B01571	MSE-4B	33	B01647	MSE-4	30
B01348	MSE-4	30	B01443	MSE-2	24	B01572	MSE-2B	26	B01648	MSE-4	31
B01351	MSE-4	31	B01444	MSE-2	24	B01573	MSE-4B	33	B01649	MSE-4	31
B01352	MSE-4	31	B01445	MSE-2	24	B01574	MSE-4B	33	B01650	MSE-4	31
B01355	MSE-4	31	B01446	MSE-2	24	B01575	MSE-2B	26	B01651	MSE-2B	26
B01356	MSE-4	31	B01447	MSE-2	24	B01576	MSE-4B	33	B01652	MSE-2B	26
B01359	MSE-2B	26	B01448	MSE-2	24	B01577	MDE-2	20	B01653	MSE-2B	26
B01360	MSE-2B	26	B01449	MSE-2	24	B01578	MDE-2	20	B01655	MSE-2B	26
B01361	MSE-2B	26	B01450	MSE-2	24	B01579	MDE-2	20	B01657	MSE-2B	26

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Index by EDP Number



**BASSETT™**

EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number
B01659	MSE-2B	26	B01868	MSE-4B	33	B04040	HPAM-3	16	B05040	HPEM-3	11
B01660	MSE-2B	26	B01901	MSE-4B	32	B04044	HPAM-3	16	B05042	HPEM-3	11
B01661	MSE-2B	27	B01902	MSE-4B	32	B04048	HPAM-3	16	B05044	HPEM-3	11
B01662	MSE-2B	27	B01904	MSE-4B	32	B04052	HPAM-3	16	B05046	HPEM-3	11
B01663	MSE-2B	27	B01905	MSE-4B	32	B04056	HPAM-3	16	B05048	HPEM-3	11
B01664	MSE-2B	27	B01908	MSE-4B	32	B04060	HPAM-3	16	B05050	HPEM-3	11
B01665	MSE-2B	27	B01911	MSE-4B	32	B04064	HPAM-3	16	B05052	HPEM-3	11
B01668	MSE-4B	32	B01914	MSE-4B	32	B04066	HPAM-3	16	B05054	HPEM-3	11
B01670	MSE-4B	32	B01917	MSE-4B	32	B04067	HPAM-3	16	B05056	HPEM-3	11
B01672	MSE-4B	32	B01921	MSE-4B	32	B04069	HPAM-3	16	B05058	HPEM-3	11
B01674	MSE-4B	32	B01947	MSE-4B	33	B04148	HPAM-3	16	B05060	HPEM-3	11
B01675	MSE-4B	33	B01953	MSE-4B	33	B04152	HPAM-3	16	B05062	HPEM-3	11
B01676	MSE-4B	33	B03016	MRA	18	B04156	HPAM-3	16	B05064	HPEM-3	11
B01678	MSE-4B	33	B03024	MRA	18	B04160	HPAM-3	16	B05066	HPEM-3	11
B01679	MSE-4B	33	B03032	MRA	18	B04164	HPAM-3	16	B05067	HPEM-3	11
B01680	MSE-4B	33	B03040	MRA	18	B04166	HPAM-3	16	B05069	HPEM-3	11
B01681	MDE-2	20	B03048	MRA	18	B04167	HPAM-3	16	B05098	HPEM-5	12
B01682	MDE-2	20	B03064	MRA	18	B04169	HPAM-3	16	B05100	HPDEM-5	10
B01683W	MDE-2	20	B03116	MRA	18	B04217	HPAM-3	16	B05101	HPDEM-5	10
B01684	MDE-2	20	B03117	MRA	18	B04221	HPAM-3	16	B05103	HPDEM-5	10
B01685	MDE-2	20	B03118	MRA	18	B04229	HPAM-3	16	B05104	HPDEM-5	10
B01687	MDE-2	20	B03119	MRA	18	B04231	HPAM-3	16	B05105	HPEM-3	11
B01689	MDE-2	20	B03120	MRA	18	B04405	HPAM-2	15	B05106	HPDEM-5	10
B01691	MDE-2	20	B03121	MRA	18	B04409	HPAM-2	15	B05107	HPEM-3	11
B01692	MDE-4	22	B03122	MRA	18	B04413	HPAM-2	15	B05108	HPDEM-5	10
B01693	MDE-4	22	B03124	MRA	18	B04417	HPAM-2	15	B05109	HPEM-3	11
B01694	MDE-4	22	B03132	MRA	18	B04421	HPAM-2	15	B05110	HPDEM-5	10
B01694W	MDE-4	22	B03140	MRA	18	B04425	HPAM-2	15	B05111	HPEM-3	11
B01695	MDE-4	22	B03148	MRA	18	B04429	HPAM-2	15	B05112	HPEM-5	12
B01696	MDE-4	22	B03164	MRA	18	B04431	HPAM-2	15	B05113	HPEM-3	11
B01698	MDE-4	22	B03216	MRS	17	B04432	HPAM-2	15	B05114	HPEM-5	12
B01699	MDE-4	22	B03224	MRS	17	B04434	HPAM-2	15	B05115	HPEM-3	11
B01700	MDE-4	22	B03232	MRS	17	B04440	HPAM-2	15	B05116	HPEM-5	12
B01702	MDE-4	22	B03240	MRS	17	B04444	HPAM-2	15	B05117	HPEM-3	11
B01703	MDE-2B	21	B03248	MRS	17	B04448	HPAM-2	15	B05118	HPEM-5	12
B01704	MDE-2B	21	B03264	MRS	17	B04452	HPAM-2	15	B05119	HPEM-3	11
B01714	MDE-4B	23	B03316	MRS	17	B04456	HPAM-2	15	B05120	HPEM-5	12
B01715	MDE-4B	23	B03324	MRS	17	B04460	HPAM-2	15	B05121	HPEM-3	11
B01730	MSE-4	30	B03332	MRS	17	B04464	HPAM-2	15	B05122	HPEM-5	12
B01732	MSE-4	30	B03340	MRS	17	B04466	HPAM-2	15	B05123	HPEM-3	11
B01733	MSE-4	30	B03348	MRS	17	B04467	HPAM-2	15	B05124	HPEM-5	12
B01734	MSE-4	30	B03364	MRS	17	B04469	HPAM-2	15	B05125	HPEM-3	11
B01735	MSE-4	31	B03416	MRS	17	B04458	HPAM-2	15	B05126	HPEM-5	12
B01750	MSE-4	29	B03424	MRS	17	B04552	HPAM-2	15	B05127	HPEM-3	11
B01751	MSE-4	29	B03432	MRS	17	B04556	HPAM-2	15	B05128	HPEM-5	12
B01752	MSE-4	30	B03440	MRS	17	B04560	HPAM-2	15	B05129	HPEM-3	11
B01753	MSE-4	30	B03448	MRS	17	B04564	HPAM-2	15	B05130	HPEM-5	12
B01755	MSE-4	30	B03464	MRS	17	B04566	HPAM-2	15	B05131	HPEM-3	11
B01756	MSE-4	30	B03532	MRA	18	B04567	HPAM-2	15	B05132	HPEM-5	12
B01758	MSE-4	30	B03540	MRA	18	B04569	HPAM-2	15	B05133	HPEM-3	11
B01759	MSE-4	30	B03548	MRA	18	B04617	HPAM-2	15	B05134	HPEM-5	12
B01760	MSE-4	30	B03564	MRA	18	B04621	HPAM-2	15	B05135	HPEM-3	11
B01762	MSE-4	31	B03632	MRA	18	B04629	HPAM-2	15	B05136	HPEM-5	12
B01763	MSE-4	31	B03640	MRA	18	B04631	HPAM-2	15	B05140	HPEM-3	11
B01764	MSE-4	31	B03648	MRA	18	B04632	HPAM-2	15	B05141	HPEM-5	12
B01765	MSE-4	31	B03664	MRA	18	B04634	HPAM-2	15	B05142	HPEM-3	11
B01766	MSE-4	31	B03816	MRS	17	B05005	HPEM-3	11	B05143	HPEM-5	12
B01767	MSE-4	31	B03824	MRS	17	B05007	HPEM-3	11	B05144	HPEM-3	11
B01768	MSE-4	31	B03832	MRS	17	B05009	HPEM-3	11	B05145	HPEM-5	12
B01770	MSE-4	31	B03840	MRS	17	B05011	HPEM-3	11	B05146	HPEM-3	11
B01771	MSE-4	31	B03848	MRS	17	B05013	HPEM-3	11	B05147	HPEM-5	12
B01772	MSE-4	31	B03864	MRS	17	B05015	HPEM-3	11	B05148	HPEM-3	11
B01774	MSE-4	31	B04005	HPAM-3	16	B05017	HPEM-3	11	B05149	HPEM-5	12
B01775	MSE-4	31	B04009	HPAM-3	16	B05019	HPEM-3	11	B05150	HPEM-3	11
B01776	MSE-4	31	B04013	HPAM-3	16	B05021	HPEM-3	11	B05151	HPEM-5	12
B01850	MSE-4B	32	B04017	HPAM-3	16	B05023	HPEM-3	11	B05152	HPEM-3	11
B01852	MSE-4B	32	B04021	HPAM-3	16	B05025	HPEM-3	11	B05153	HPEM-5	12
B01854	MSE-4B	32	B04025	HPAM-3	16	B05027	HPEM-3	11	B05154	HPEM-3	11
B01856	MSE-4B	33	B04029	HPAM-3	16	B05029	HPEM-3	11	B05155	HPEM-5	12
B01857	MSE-4B	33	B04031	HPAM-3	16	B05031	HPEM-3	11	B05156	HPEM-3	11
B01858	MSE-4B	33	B04032	HPAM-3	16	B05032	HPEM-3	11	B05157	HPEM-5	12
B01860	MSE-4B	33	B04034	HPAM-3	16	B05034	HPEM-3	11	B05158	HPEM-3	11





**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
B05159	HPEM-5	12	B05456	HPEM-5	12	B06052	HPAM-3	16	B06825	MSE-2	25
B05160	HPEM-3	11	B05460	HPEM-5	12	B06056	HPAM-3	16	B06826	MSE-2	25
B05161	HPEM-5	12	B05464	HPEM-5	12	B06060	HPAM-3	16	B10010	MCH-2R	35
B05162	HPEM-3	11	B05465	HPEM-5	12	B06064	HPAM-3	16	B10011	MCH-4R	35
B05163	HPEM-5	12	B05466	HPEM-5	12	B06066	HPAM-3	16	B10012	MCH-2R	35
B05164	HPEM-3	11	B05467	HPEM-5	12	B06067	HPAM-3	16	B10013	MCH-2R	35
B05165	HPEM-5	12	B05468	HPEM-5	12	B06069	HPAM-3	16	B10014	MCH-2R	35
B05166	HPEM-3	11	B05469	HPEM-5	12	B06148	HPAM-3	16	B10016	MCH-2R	35
B05167	HPEM-5	12	B05513	HPEM-5	12	B06152	HPAM-3	16	B10017	MCH-2R	35
B05168	HPEM-3	11	B05517	HPEM-5	12	B06156	HPAM-3	16	B10018	MCH-2R	35
B05169	HPEM-5	12	B05521	HPEM-5	12	B06160	HPAM-3	16	B10019	MCH-2R	35
B05170	HPEM-3	11	B05525	HPEM-5	12	B06164	HPAM-3	16	B10020	MCH-2R	35
B05171	HPEM-5	12	B05529	HPEM-5	12	B06166	HPAM-3	16	B10021	MCH-2R	35
B05173	HPEM-5	12	B05531	HPEM-5	12	B06167	HPAM-3	16	B10022	MCH-2R	35
B05175	HPEM-5	12	B05532	HPEM-5	12	B06169	HPAM-3	16	B10023	MCH-2R	35
B05177	HPEM-5	12	B05533	HPEM-5	12	B06217	HPAM-3	16	B10024	MCH-2R	35
B05179	HPEM-5	12	B05605	HPDEM-5	10	B06221	HPAM-3	16	B10025	MCH-2R	35
B05181	HPEM-5	12	B05609	HPDEM-5	10	B06229	HPAM-3	16	B10026	MCH-2D	35
B05183	HPEM-5	12	B05613	HPDEM-5	10	B06231	HPAM-3	16	B10027	MCH-2D	35
B05185	HPEM-5	12	B05617	HPDEM-5	10	B06405	HPAM-2	15	B10028	MCH-2D	35
B05305	HPEM-3	11	B05621	HPDEM-5	10	B06409	HPAM-2	15	B10029	MCH-2D	35
B05307	HPEM-3	11	B05625	HPDEM-5	10	B06413	HPAM-2	15	B10030	MCH-2D	35
B05309	HPEM-3	11	B05629	HPDEM-5	10	B06417	HPAM-2	15	B10117	MRA	18
B05311	HPEM-3	11	B05805	HPEM-5	12	B06421	HPAM-2	15	B10118	MRA	18
B05313	HPEM-3	11	B05807	HPEM-5	12	B06425	HPAM-2	15	B10119	MRA	18
B05315	HPEM-3	11	B05809	HPEM-5	12	B06429	HPAM-2	15	B10120	MRA	18
B05317	HPEM-3	11	B05811	HPEM-5	12	B06431	HPAM-2	15	B10121	MRA	18
B05319	HPEM-3	11	B05813	HPEM-5	12	B06432	HPAM-2	15	B10122	MRA	18
B05321	HPEM-3	11	B05815	HPEM-5	12	B06434	HPAM-2	15	B10219	MCH-4R	35
B05323	HPEM-3	11	B05817	HPEM-5	12	B06440	HPAM-2	15	B10220	MCH-4R	35
B05325	HPEM-3	11	B05821	HPEM-5	12	B06444	HPAM-2	15	B10221	MCH-4R	35
B05327	HPEM-3	11	B05825	HPEM-5	12	B06448	HPAM-2	15	B10222	MCH-4R	35
B05329	HPEM-3	11	B05829	HPEM-5	12	B06452	HPAM-2	15	B10223	MCH-4R	35
B05331	HPEM-3	11	B05831	HPEM-5	12	B06456	HPAM-2	15	B10224	MCH-4R	35
B05332	HPEM-3	11	B05832	HPEM-5	12	B06460	HPAM-2	15	B10225	MCH-4R	35
B05334	HPEM-3	11	B05834	HPEM-5	12	B06464	HPAM-2	15	B10226	MCH-4R	35
B05340	HPEM-3	11	B05840	HPEM-5	12	B06466	HPAM-2	15	B10227	MCH-4R	35
B05342	HPEM-3	11	B05842	HPEM-5	12	B06467	HPAM-2	15	B10228	MCH-4D	35
B05344	HPEM-3	11	B05844	HPEM-5	12	B06469	HPAM-2	15	B10229	MCH-4D	35
B05346	HPEM-3	11	B05846	HPEM-5	12	B06548	HPAM-2	15	B10230	MCH-4D	35
B05348	HPEM-3	11	B05848	HPEM-5	12	B06552	HPAM-2	15	B10231	MCH-2D	35
B05350	HPEM-3	11	B05850	HPEM-5	12	B06556	HPAM-2	15	B10232	MCH-2R	35
B05352	HPEM-3	11	B05852	HPEM-5	12	B06560	HPAM-2	15	B10233	MCH-2R	35
B05354	HPEM-3	11	B05856	HPEM-5	12	B06564	HPAM-2	15	B10234	MCH-4D	35
B05356	HPEM-3	11	B05860	HPEM-5	12	B06566	HPAM-2	15	B10235	MCH-4R	35
B05358	HPEM-3	11	B05864	HPEM-5	12	B06567	HPAM-2	15	B10236	MCH-4R	35
B05360	HPEM-3	11	B05865	HPEM-5	12	B06569	HPAM-2	15	B10575	MSE-2	24
B05362	HPEM-3	11	B05866	HPEM-5	12	B06617	HPAM-2	15	B10901	MEG-2	34
B05364	HPEM-3	11	B05867	HPEM-5	12	B06621	HPAM-2	15	B10903	MEG-2	34
B05366	HPEM-3	11	B05868	HPEM-5	12	B06629	HPAM-2	15	B10906	MEG-2	34
B05367	HPEM-3	11	B05869	HPEM-5	12	B06631	HPAM-2	15	B11971	MSE-3	28
B05369	HPEM-3	11	B05913	HPEM-5	12	B06632	HPAM-2	15	B11972	MSE-3	28
B05405	HPEM-5	12	B05917	HPEM-5	12	B06634	HPAM-2	15	B11973	MSE-3	28
B05407	HPEM-5	12	B05921	HPEM-5	12	B06800	MSE-2	24	B11974	MSE-3	28
B05409	HPEM-5	12	B05925	HPEM-5	12	B06801	MSE-2	24	B11975	MSE-3	28
B05411	HPEM-5	12	B05929	HPEM-5	12	B06802	MSE-2	24	B11976	MSE-3	28
B05413	HPEM-5	12	B05931	HPEM-5	12	B06803	MSE-2	24	B11977	MSE-3	28
B05415	HPEM-5	12	B05932	HPEM-5	12	B06805	MSE-2	25	B11978	MSE-3	28
B05417	HPEM-5	12	B05933	HPEM-5	12	B06806	MSE-2	25	B11986	MSE-3	28
B05421	HPEM-5	12	B06005	HPAM-3	16	B06808	MSE-2	25	B11987	MDE-2	20
B05425	HPEM-5	12	B06009	HPAM-3	16	B06809	MSE-2	25	B11999	MDE-4	22
B05429	HPEM-5	12	B06013	HPAM-3	16	B06810	MSE-2	25	B12000	MDE-4	22
B05431	HPEM-5	12	B06017	HPAM-3	16	B06812	MSE-2	25	B12014	MSE-2B	27
B05432	HPEM-5	12	B06021	HPAM-3	16	B06813	MSE-2	25	B12015	MSE-2B	27
B05434	HPEM-5	12	B06025	HPAM-3	16	B06814	MSE-2	25	B27104	MSE-3	28
B05440	HPEM-5	12	B06029	HPAM-3	16	B06816	MSE-2	25	B27105	MSE-3	28
B05442	HPEM-5	12	B06031	HPAM-3	16	B06817	MSE-2	25	B27106	MSE-3	28
B05444	HPEM-5	12	B06032	HPAM-3	16	B06818	MSE-2	25	B27107	MSE-3	28
B05446	HPEM-5	12	B06034	HPAM-3	16	B06820	MSE-2	25	B27108	MSE-3	28
B05448	HPEM-5	12	B06040	HPAM-3	16	B06821	MSE-2	25	B27109	MSE-3	28
B05450	HPEM-5	12	B06044	HPAM-3	16	B06822	MSE-2	25	B27110	MSE-3	28
B05452	HPEM-5	12	B06048	HPAM-3	16	B06824	MSE-2	25	B27111	MSE-3	28

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Index by EDP Number



**BASSETT**

EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number
B27112	MSE-3	28	B36035	DRS.	42	B37202	MSE-3	28	B40193	MSE-V-4R	4
B27113	MSE-3	28	B36036	DRS.	42	B37203	MSE-3	28	B40194	MSE-V-4R	4
B27114	MSE-3	28	B36037	DRS.	42	B37205	MSE-3	28	B40195	MSE-V-4R	4
B27115	MSE-3	28	B36038	DRS.	42	B37206	MSE-3	28	B40196	MSE-V-4R	4
B27116	MSE-3	28	B36039	DRS.	42	B37208	MSE-3	28	B40197	MSE-V-4R	4
B27117	MSE-3	28	B36040	DRS.	42	B37209	MSE-3	28	B40198	MSE-V-4R	4
B27118	MSE-3	28	B36041	DRS.	42	B37210	MSE-3	28	B40199	MSE-V-4R	4
B27120	MSE-3	28	B36042	DRS.	42	B37212	MSE-3	28	B40200	MSE-V-4R	4
B27124	MSE-3	28	B36043	DRS.	42	B37213	MSE-3	28	B40201	MSE-V-4R	4
B27128	MSE-3	28	B36044	DRS.	42	B37214	MSE-3	28	B40202	MSE-V-4R	4
B27132	MSE-3	28	B36045	DRS.	42	B37216	MSE-3	28	B40203	MSE-V-4R	4
B27136	MSE-3	28	B36046	DRS.	42	B37217	MSE-3	28	B40204	MSE-V-4R	4
B27140	MSE-3	28	B36047	DRS.	42	B37218	MSE-3	28	B40205	MSE-V-4R	4
B27148	MSE-3	28	B36048	DRS.	42	B37220	MSE-3	28	B40206	MSE-V-4R	4
B27156	MSE-3	28	B36049	DRS.	42	B37221	MSE-3	28	B40207	MSE-V-4R	4
B27164	MSE-3	28	B36050	DRS.	42	B37222	MSE-3	28	B40208	MSE-V-4R	4
B27200	MSE-3	28	B36051	DRS.	42	B37224	MSE-3	28	B40209	MSE-V-4R	4
B27201	MSE-3	28	B36052	DRS.	42	B37225	MSE-3	28	B40210	MSE-V-4R	4
B27202	MSE-3	28	B36053	DRS.	42	B37226	MSE-3	28	B40211	MSE-V-4R	4
B27203	MSE-3	28	B36054	DRS.	42	B40140	MSE-V-4R	3	B40212	MSE-V-4R	4
B27205	MSE-3	28	B36055	DRS.	42	B40141	MSE-V-4R	3	B40213	MSE-V-4R	4
B27206	MSE-3	28	B36056	DRS.	42	B40142	MSE-V-4R	3	B40214	MSE-V-4R	4
B27208	MSE-3	28	B36057	DRS.	42	B40143	MSE-V-4R	3	B40215	MSE-V-4R	4
B27209	MSE-3	28	B36058	DRS.	42	B40144	MSE-V-4R	3	B40216	MSE-V-4R	4
B27210	MSE-3	28	B36059	DRS.	42	B40145	MSE-V-4R	3	B40217	MSE-V-4R	4
B27212	MSE-3	28	B36060	DRS.	42	B40146	MSE-V-4R	3	B40218	MSE-V-4R	5
B27213	MSE-3	28	B36404	DRS.	42	B40147	MSE-V-4R	3	B40219	MSE-V-4R	5
B27214	MSE-3	28	B36405	DRS.	42	B40148	MSE-V-4R	3	B40220	MSE-V-4R	5
B27216	MSE-3	28	B36406	DRS.	42	B40149	MSE-V-4R	3	B40221	MSE-V-4R	5
B27217	MSE-3	28	B36407	DRS.	42	B40150	MSE-V-4R	3	B40222	MSE-V-4R	5
B27218	MSE-3	28	B36408	DRS.	42	B40151	MSE-V-4R	3	B40223	MSE-V-4R	5
B27220	MSE-3	28	B36409	DRS.	43	B40152	MSE-V-4R	3	B40224	MSE-V-4R	5
B27221	MSE-3	28	B36410	DRS.	43	B40153	MSE-V-4R	3	B40225	MSE-V-4R	5
B27222	MSE-3	28	B36411	DRS.	43	B40154	MSE-V-4R	4	B40226	MSE-V-4R	5
B27224	MSE-3	28	B36412	DRS.	43	B40155	MSE-V-4R	4	B40227	MSE-V-4R	5
B27225	MSE-3	28	B36413	DRS.	43	B40156	MSE-V-4R	4	B40228	MSE-V-4R	5
B27226	MSE-3	28	B36414	DRS.	43	B40157	MSE-V-4R	4	B40229	MSE-V-4R	5
B35859	MSE-4B	33	B36415	DRS.	43	B40158	MSE-V-4R	4	B40230	MSE-V-4R	5
B36001	DRS.	43	B36416	DRS.	43	B40159	MSE-V-4R	4	B40231	MSE-V-4R	3
B36002	DRS.	43	B36417	DRS.	43	B40160	MSE-V-4R	4	B40232	MSE-V-4R	3
B36003	DRS.	43	B36418	DRS.	43	B40161	MSE-V-4R	4	B40233	MSE-V-4R	3
B36004	DRS.	43	B36419	DRS.	43	B40162	MSE-V-4R	4	B40234	MSE-V-4R	3
B36005	DRS.	43	B36420	DRS.	43	B40163	MSE-V-4R	5	B40236	MSE-V-4R	4
B36006	DRS.	43	B36421	DRS.	43	B40164	MSE-V-4R	5	B40237	MSE-V-4R	4
B36007	DRS.	43	B36422	DRS.	43	B40165	MSE-V-4R	3	B40238	MSE-V-4R	4
B36008	DRS.	43	B36423	DRS.	43	B40166	MSE-V-4R	3	B40308	MSE-V-4B	5
B36009	DRS.	43	B36424	DRS.	43	B40167	MSE-V-4R	3	B40309	MSE-V-4B	5
B36010	DRS.	43	B36425	DRS.	43	B40168	MSE-V-4R	3	B40310	MSE-V-4B	5
B36011	DRS.	43	B36426	DRS.	43	B40169	MSE-V-4R	3	B40311	MSE-V-4B	5
B36012	DRS.	43	B36427	DRS.	43	B40170	MSE-V-4R	3	B40312	MSE-V-4B	5
B36013	DRS.	43	B36428	DRS.	43	B40171	MSE-V-4R	3	B40313	MSE-V-4B	5
B36014	DRS.	43	B36429	DRS.	43	B40172	MSE-V-4R	3	B40314	MSE-V-4B	5
B36015	DRS.	43	B36430	DRS.	43	B40173	MSE-V-4R	3	B40315	MSE-V-4B	5
B36016	DRS.	43	B36431	DRS.	43	B40174	MSE-V-4R	3	B40316	MSE-V-4B	5
B36017	DRS.	43	B36432	DRS.	43	B40175	MSE-V-4R	3	B40317	MSE-V-4B	5
B36018	DRS.	43	B37104	MSE-3	28	B40176	MSE-V-4R	3	B40320	MSE-V2-5R	6
B36019	DRS.	43	B37105	MSE-3	28	B40177	MSE-V-4R	3	B40321	MSE-V2-5R	7
B36020	DRS.	43	B37106	MSE-3	28	B40178	MSE-V-4R	3	B40322	MSE-V2-5R	7
B36021	DRS.	43	B37107	MSE-3	28	B40179	MSE-V-4R	3	B40323	MSE-V2-5R	7
B36022	DRS.	43	B37108	MSE-3	28	B40180	MSE-V-4R	3	B40324	MSE-V2-5R	7
B36023	DRS.	43	B37109	MSE-3	28	B40181	MSE-V-4R	3	B40325	MSE-V2-5R	7
B36024	DRS.	43	B37110	MSE-3	28	B40182	MSE-V-4R	3	B40390	MSE-V-4B	5
B36025	DRS.	43	B37111	MSE-3	28	B40183	MSE-V-4R	3	B40410	MSE-V2-5R	6
B36026	DRS.	43	B37112	MSE-3	28	B40184	MSE-V-4R	3	B40411	MSE-V2-5R	6
B36027	DRS.	43	B37113	MSE-3	28	B40185	MSE-V-4R	3	B40412	MSE-V2-5R	6
B36028	DRS.	43	B37114	MSE-3	28	B40186	MSE-V-4R	4	B40413	MSE-V2-5R	6
B36029	DRS.	43	B37115	MSE-3	28	B40187	MSE-V-4R	4	B40414	MSE-V2-5R	6
B36030	DRS.	42	B37117	MSE-3	28	B40188	MSE-V-4R	4	B40415	MSE-V2-5R	6
B36031	DRS.	42	B37118	MSE-3	28	B40189	MSE-V-4R	4	B40416	MSE-V2-5R	6
B36032	DRS.	42	B37136	MSE-3	28	B40190	MSE-V-4R	4	B40417	MSE-V2-5R	6
B36033	DRS.	42	B37200	MSE-3	28	B40191	MSE-V-4R	4	B40418	MSE-V2-5R	6
B36034	DRS.	42	B37201	MSE-3	28	B40192	MSE-V-4R	4	B40419	MSE-V2-5R	6



**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
B40420	MSE-V2-5R	6	B40492	MSE-V2-5R	8	B51455	MSE-4	30	B52066	MSE-2	25
B40421	MSE-V2-5R	6	B40493	MSE-V2-5R	8	B51456	MSE-4	30	B52068	MSE-2	25
B40422	MSE-V2-5R	6	B40494	MSE-V2-5R	8	B51458	MSE-4	30	B52069	MSE-2	25
B40423	MSE-V2-5R	7	B40495	MSE-V2-5R	8	B51459	MSE-4	30	B52070	MSE-2	25
B40424	MSE-V2-5R	7	B40496	MSE-V2-5R	8	B51460	MSE-4	30	B52072	MSE-2	25
B40425	MSE-V2-5R	7	B40497	MSE-V2-5R	8	B51461	MSE-4	31	B52073	MSE-2	25
B40426	MSE-V2-5R	7	B40499	MSE-V2-5R	6	B51462	MSE-4	31	B52074	MSE-2	25
B40427	MSE-V2-5R	7	B40779	MDE-1	20	B51464	MSE-4	31	B52076	MSE-2	25
B40428	MSE-V2-5R	7	B40780	MDE-4	22	B51466	MSE-4	31	B52077	MSE-2	25
B40429	MSE-V2-5R	7	B50187	HPEM-6	13	B51468	MSE-4	31	B52078	MSE-2	25
B40430	MSE-V2-5R	7	B51200	MSE-2	24	B51470	MSE-4	31	B52080	MSE-2	25
B40431	MSE-V2-5R	7	B51202	MSE-2	24	B51475	MSE-4	30	B52081	MSE-2	25
B40432	MSE-V2-5R	8	B51204	MSE-2	24	B51476	MSE-4	30	B52082	MSE-2	25
B40433	MSE-V2-5R	8	B51206	MSE-2	25	B51477	MSE-4	30	B52084	MSE-2	25
B40434	MSE-V2-5R	6	B51208	MSE-2	25	B51500	MSE-2B	26	B52085	MSE-2	25
B40435	MSE-V2-5R	6	B51210	MSE-2	25	B51502	MSE-2B	26	B52086	MSE-2	25
B40436	MSE-V2-5R	6	B51212	MSE-2	25	B51504	MSE-2B	26	B52087	MSE-4	29
B40437	MSE-V2-5R	6	B51214	MSE-2	25	B51505	MSE-2B	26	B52088	MSE-4	29
B40438	MSE-V2-5R	6	B51216	MSE-2	25	B51506	MSE-2B	26	B52089	MSE-4	29
B40439	MSE-V2-5R	6	B51218	MSE-2	25	B51508	MSE-2B	27	B52090	MSE-4	29
B40440	MSE-V2-5R	6	B51220	MSE-2	25	B51509	MSE-2B	27	B52091	MSE-4	29
B40441	MSE-V2-5R	6	B51250	MSE-4	29	B51510	MSE-2B	27	B52092	MSE-4	30
B40442	MSE-V2-5R	6	B51252	MSE-4	29	B51511	MSE-2B	27	B52093	MSE-4	30
B40443	MSE-V2-5R	6	B51254	MSE-4	30	B51512	MSE-2B	27	B52095	MSE-4	29
B40444	MSE-V2-5R	6	B51256	MSE-4	30	B51514	MSE-2B	27	B52096	MSE-4	29
B40445	MSE-V2-5R	6	B51258	MSE-4	30	B51516	MSE-2B	27	B52097	MSE-4	30
B40446	MSE-V2-5R	6	B51260	MSE-4	30	B51518	MSE-2B	27	B52098	MSE-4	30
B40447	MSE-V2-5R	6	B51262	MSE-4	31	B51520	MSE-2B	27	B52099	MSE-4	30
B40448	MSE-V2-5R	6	B51264	MSE-4	31	B51550	MSE-4B	32	B52101	MSE-4	29
B40449	MSE-V2-5R	6	B51266	MSE-4	31	B51552	MSE-4B	32	B52102	MSE-4	29
B40450	MSE-V2-5R	6	B51268	MSE-4	31	B51554	MSE-4B	32	B52104	MSE-4	29
B40451	MSE-V2-5R	6	B51270	MSE-4	31	B51555	MSE-4B	32	B52105	MSE-4	29
B40452	MSE-V2-5R	6	B51300	MSE-2B	26	B51556	MSE-4B	33	B52106	MSE-4	29
B40453	MSE-V2-5R	7	B51302	MSE-2B	26	B51558	MSE-4B	33	B52107	MSE-4	29
B40454	MSE-V2-5R	7	B51304	MSE-2B	26	B51559	MSE-4B	33	B52108	MSE-4	29
B40455	MSE-V2-5R	7	B51306	MSE-2B	26	B51560	MSE-4B	33	B52110	MSE-4	29
B40456	MSE-V2-5R	7	B51308	MSE-2B	27	B51561	MSE-4B	33	B52111	MSE-4	29
B40457	MSE-V2-5R	7	B51310	MSE-2B	27	B51562	MSE-4B	33	B52113	MSE-4	29
B40458	MSE-V2-5R	7	B51312	MSE-2B	27	B51564	MSE-4B	33	B52114	MSE-4	30
B40459	MSE-V2-5R	7	B51314	MSE-2B	27	B51566	MSE-4B	33	B52116	MSE-4	30
B40460	MSE-V2-5R	7	B51316	MSE-2B	27	B51568	MSE-4B	33	B52117	MSE-4	30
B40461	MSE-V2-5R	7	B51318	MSE-2B	27	B51570	MSE-4B	33	B52118	MSE-4	29
B40462	MSE-V2-5R	7	B51320	MSE-2B	27	B52001	MSE-2	24	B52120	MSE-4	30
B40463	MSE-V2-5R	7	B51350	MSE-4B	32	B52002	MSE-2	24	B52121	MSE-4	30
B40464	MSE-V2-5R	7	B51352	MSE-4B	32	B52004	MSE-2	24	B52123	MSE-4	30
B40465	MSE-V2-5R	7	B51354	MSE-4B	32	B52005	MSE-2	24	B52126	MSE-4	30
B40466	MSE-V2-5R	7	B51356	MSE-4B	33	B52007	MSE-2	24	B52132	MSE-4	30
B40467	MSE-V2-5R	7	B51358	MSE-4B	33	B52008	MSE-2	24	B52134	MSE-4	30
B40468	MSE-V2-5R	7	B51360	MSE-4B	33	B52010	MSE-2	24	B52138	MSE-4	30
B40469	MSE-V2-5R	7	B51362	MSE-4B	33	B52011	MSE-2	24	B52145	MSE-4	31
B40470	MSE-V2-5R	7	B51364	MSE-4B	33	B52013	MSE-2	24	B52147	MSE-4	31
B40471	MSE-V2-5R	7	B51366	MSE-4B	33	B52014	MSE-2	24	B52149	MSE-4	31
B40472	MSE-V2-5R	7	B51368	MSE-4B	33	B52016	MSE-2	24	B52151	MSE-4	31
B40473	MSE-V2-5R	7	B51370	MSE-4B	33	B52017	MSE-2	24	B52153	MSE-4	31
B40474	MSE-V2-5R	7	B51400	MSE-2	24	B52019	MSE-2	24	B52157	MSE-4	31
B40475	MSE-V2-5R	7	B51402	MSE-2	24	B52020	MSE-2	24	B52160	MSE-4	29
B40476	MSE-V2-5R	7	B51404	MSE-2	24	B52021	MSE-2	24	B52162	MSE-4	29
B40477	MSE-V2-5R	7	B51405	MSE-2	24	B52023	MSE-2	24	B52164	MSE-4	30
B40478	MSE-V2-5R	7	B51406	MSE-2	25	B52026	MSE-2	25	B52165	MSE-4	30
B40479	MSE-V2-5R	7	B51408	MSE-2	25	B52032	MSE-2	25	B52167	MSE-4	30
B40480	MSE-V2-5R	7	B51409	MSE-2	25	B52038	MSE-2	25	B52168	MSE-4	30
B40481	MSE-V2-5R	7	B51410	MSE-2	25	B52045	MSE-2	25	B52170	MSE-4	30
B40482	MSE-V2-5R	7	B51411	MSE-2	25	B52047	MSE-2	25	B52171	MSE-4	30
B40483	MSE-V2-5R	7	B51412	MSE-2	25	B52049	MSE-2	25	B52172	MSE-4	30
B40484	MSE-V2-5R	7	B51414	MSE-2	25	B52051	MSE-2	25	B52173	MSE-4	31
B40485	MSE-V2-5R	8	B51416	MSE-2	25	B52053	MSE-2	25	B52174	MSE-4	31
B40486	MSE-V2-5R	8	B51418	MSE-2	25	B52057	MSE-2	25	B52175	MSE-4	31
B40487	MSE-V2-5R	8	B51420	MSE-2	25	B52060	MSE-2	24	B52176	MSE-4	31
B40488	MSE-V2-5R	8	B51450	MSE-4	29	B52061	MSE-2	24	B52177	MSE-4	31
B40489	MSE-V2-5R	8	B51451	MSE-4	29	B52062	MSE-2	24	B52178	MSE-4	31
B40490	MSE-V2-5R	8	B51452	MSE-4	29	B52063	MSE-2	24	B52179	MSE-4	31
B40491	MSE-V2-5R	8	B51454	MSE-4	30	B52065	MSE-2	25	B52180	MSE-4	31

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX

Index by EDP Number



**BASSETT™**

EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number
B52181	MSE-4	31	B52401	MDE-2	20	B52648	MSE-4	29	B53458	DS	45
B52182	MSE-4	31	B52403	MDE-2	20	B52650	MSE-4	29	B53460	DS	45
B52183	MSE-4	31	B52405	MDE-2	20	B52652	MSE-4	29	B53462	DS	45
B52184	MSE-4	31	B52407	MDE-2	20	B52657	MSE-4	30	B53464	DS	45
B52185	MSE-4	31	B52410	MDE-2	20	B52659	MSE-4	30	B53467	DS	45
B52187	MSE-4B	32	B52412	MDE-2	20	B52661	MSE-4	30	B53475	DS	45
B52188	MSE-4B	33	B52414	MDE-2	20	B52663	MSE-4	30	B53509	DR	41
B52190	MSE-4	29	B52418	MDE-2	20	B52666	MSE-4	31	B53511	DR	41
B52191	MSE-4	29	B52420	MDE-2	20	B52668	MSE-4	31	B53512	DR	41
B52192	MSE-4	29	B52423	MDE-2	20	B52671	MSE-4	31	B53514	DR	41
B52193	MSE-4	29	B52430	MSE-4	30	B52681	MSE-2B	26	B53515	DR	41
B52194	MSE-4	30	B52431	MSE-4	30	B52682	MSE-2B	26	B53518	DR	41
B52195	MSE-4	30	B52436	MSE-4	30	B52684	MSE-2B	26	B53521	DR	41
B52196	MSE-4	30	B52441	MDE-4	22	B52688	MSE-2B	26	B53523	DR	41
B52201	MSE-2B	26	B52443	MDE-4	22	B52692	MSE-2B	26	B53525	DR	41
B52202	MSE-2B	26	B52445	MDE-4	22	B52697	MSE-2B	26	B53529	DR	41
B52204	MSE-2B	26	B52447	MDE-4	22	B52699	MSE-2B	26	B53531	DR	41
B52205	MSE-2B	26	B52450	MDE-4	22	B52701	MSE-2B	27	B53533	DR	41
B52207	MSE-2B	26	B52452	MDE-4	22	B52703	MSE-2B	27	B53536	DR	41
B52208	MSE-2B	26	B52454	MDE-4	22	B52706	MSE-2B	27	B53538	DR	41
B52210	MSE-2B	26	B52457	MSE-4B	33	B52708	MSE-2B	27	B53541	DR	41
B52211	MSE-2B	26	B52458	MDE-4	22	B52711	MSE-2B	27	B53543	DR	41
B52213	MSE-2B	26	B52460	MDE-4	22	B52721	MSE-4B	32	B53545	DR	41
B52214	MSE-2B	26	B52463	MDE-4	22	B52722	MSE-4B	32	B53546	DR	41
B52216	MSE-2B	26	B52472	MSE-4	30	B52724	MSE-4B	32	B53549	DR	41
B52217	MSE-2B	26	B52475	MSE-4B	33	B52728	MSE-4B	32	B53550	DR	41
B52219	MSE-4B	32	B52481	MDE-2B	21	B52732	MSE-4B	32	B53553	DR	41
B52220	MSE-2B	26	B52483	MDE-2B	21	B52737	MSE-4B	32	B53556	DR	41
B52221	MSE-2B	26	B52485	MDE-2B	21	B52739	MSE-4B	33	B53559	DR	41
B52223	MSE-2B	26	B52487	MDE-2B	21	B52741	MSE-4B	33	B53560	DR	41
B52226	MSE-2B	26	B52490	MDE-2B	21	B52743	MSE-4B	33	B53562	DR	41
B52232	MSE-2B	27	B52492	MDE-2B	21	B52746	MSE-4B	33	B53564	DR	41
B52238	MSE-2B	27	B52494	MDE-2B	21	B52748	MSE-4B	33	B53566	DR	41
B52243	MSE-4	31	B52498	MDE-2B	21	B52751	MSE-4B	33	B53567	DR	41
B52244	MSE-4	31	B52500	MDE-2B	21	B52801	MDE-2	20	B53569	DR	41
B52245	MSE-2B	27	B52503	MDE-2B	21	B52803	MDE-2	20	B53571	DR	41
B52246	MSE-4	31	B52506	MSE-4B	32	B52805W	MDE-2	20	B53573	DR	41
B52247	MSE-2B	27	B52509	MSE-4B	32	B52807	MDE-2	20	B53574	DR	41
B52249	MSE-2B	27	B52516	MSE-4B	32	B52809	MDE-2	20	B53576	DR	41
B52251	MSE-2B	27	B52517	MSE-4B	32	B52814	MDE-2	20	B53577	DR	41
B52253	MSE-2B	27	B52518	MSE-4B	32	B52818	MDE-2	20	B53579	DR	41
B52257	MSE-2B	27	B52520	MSE-4B	32	B52823	MDE-2	20	B53581	DR	41
B52274	MSE-4	30	B52521	MDE-4B	23	B52841	MDE-4	22	B53583	DR	41
B52276	MSE-4	31	B52523	MDE-4B	23	B52843	MDE-4	22	B53586	DR	41
B52277	MSE-4	31	B52525	MDE-4B	23	B52845	MDE-4	22	B53589	DR	41
B52278	MSE-4	31	B52527	MDE-4B	23	B52845W	MDE-4	22	B53591	DR	41
B52293	MSE-4B	32	B52530	MDE-4B	23	B52847	MDE-4	22	B53592	DR	41
B52301	MSE-4B	32	B52532	MDE-4B	23	B52849	MDE-4	22	B53594	DR	41
B52302	MSE-4B	32	B52534	MDE-4B	23	B52854	MDE-4	22	B53596	DR	41
B52304	MSE-4B	32	B52538	MDE-4B	23	B52856	MDE-4	22	B53598	DR	41
B52305	MSE-4B	32	B52540	MDE-4B	23	B52858	MDE-4	22	B53600	DR	41
B52307	MSE-4B	32	B52543	MDE-4B	23	B52863	MDE-4	22	B53602	DR	41
B52308	MSE-4B	32	B52599	MSE-4B	32	B52881	MDE-2B	21	B53603	DR	41
B52310	MSE-4B	32	B52601	MSE-2	24	B52883	MDE-2B	21	B53604	DR	41
B52311	MSE-4B	32	B52602	MSE-2	24	B52921	MDE-4B	23	B53606	DR	41
B52313	MSE-4B	32	B52604	MSE-2	24	B52923	MDE-4B	23	B53607	DR	41
B52314	MSE-4B	32	B52606	MSE-2	24	B53201	MSEST-2	34	B53610	DR	41
B52316	MSE-4B	32	B52608	MSE-2	24	B53203	MSEST-2	34	B53613	DR	41
B52317	MSE-4B	32	B52612	MSE-2	24	B53205	MSEST-2	34	B53614	DR	41
B52320	MSE-4B	32	B52617	MSE-2	24	B53207	MSEST-2	34	B53615	DR	41
B52321	MSE-4B	32	B52619	MSE-2	25	B53210	MSEST-2	34	B53617	DR	41
B52323	MSE-4B	32	B52621	MSE-2	25	B53212	MSEST-2	34	B53619	DR	41
B52326	MSE-4B	33	B52623	MSE-2	25	B53215	MSEST-2	34	B53621	DR	41
B52332	MSE-4B	33	B52626	MSE-2	25	B53431	DC	45	B53622	DR	41
B52338	MSE-4B	33	B52628	MSE-2	25	B53432	DC	45	B53625	DR	41
B52345	MSE-4B	33	B52631	MSE-2	25	B53433	DC	45	B53626	DR	41
B52347	MSE-4B	33	B52641	MSE-4	29	B53434	DC	45	B53628	DR	41
B52349	MSE-4B	33	B52642	MSE-4	29	B53435	DC	45	B53630	DR	41
B52351	MSE-4B	33	B52643	MSE-4	29	B53436	DC	45	B53631	DR	41
B52353	MSE-4B	33	B52644	MSE-4	29	B53451	DS	45	B53633	DR	41
B52357	MSE-4B	33	B52645	MSE-4	29	B53454	DS	45	B53635	DR	41
B52363	MSE-4B	33	B52646	MSE-4	29	B53456	DS	45	B53637	DR	41



**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
B53638	DR	41	B54150	DM	44	B54346	DHPCF-5	39	B54815	BA	54
B53640	DR	41	B54152	DM	44	B54358	DHPCF-5	39	B54816	BA	54
B53643	DR	41	B54154	DM	44	B54368	DHPCF-5	39	B54837	BAE	54
B53645	DR	41	B54156	DM	44	B54375	DHPCF-5	39	B54838	BAE	54
B53647	DR	41	B54157	DM	44	B54377	DHPCF-5	39	B54839	BAE	54
B53649	DR	41	B54159	DM	44	B54384	DHPCF-5	39	B54840	BAE	54
B53652	DR	41	B54161	DM	44	B54387	DHPCF-5	39	B54843	BAE	54
B53655	DR	41	B54163	DM	44	B54391	DHPCF-5	39	B54847	BAE	54
B53657	DR	41	B54164	DM	44	B54398	DHPCF-5	39	B54848	BAE	54
B53660	DR	41	B54166	DM	44	B54404	DHPCF-5	39	B54849	BAE	54
B53662	DR	41	B54167	DM	44	B54405	DHPCF-5	39	B54850	BAE	54
B53664	DR	41	B54169	DM	44	B54412	DHPCF-5	39	B54851	BAE	54
B53666	DR	41	B54171	DM	44	B54415	DHPCF-5	39	B54873	BC	55
B53670	DR	41	B54173	DM	44	B54420	DHPCF-5	39	B54874	BC	55
B53672	DR	41	B54176	DM	44	B54423	DHPCF-5	39	B54875	BC	55
B53675	DR	41	B54179	DM	44	B54432	DHPCF-5	39	B54876	BC	55
B53677	DR	41	B54181	DM	44	B54440	DHPCF-5	39	B54877	BC	55
B53678	DR	41	B54182	DM	44	B54444	DHPCF-5	39	B54878	BC	55
B53681	DR	42	B54184	DM	44	B54446	DHPCF-5	39	B54882	BC	55
B53683	DR	42	B54186	DM	44	B54448	DHPCF-5	39	B54883	BC	55
B53685	DR	42	B54188	DM	44	B54449	DHPCF-5	39	B54884	BC	55
B53688	DR	42	B54190	DM	44	B54450	DHPCF-5	39	B54885	BC	55
B53689	DR	42	B54192	DM	44	B54453	DHPCF-5	39	B54886	BC	55
B53691	DR	42	B54193	DM	44	B54455	DHPCF-5	39	B54887	BC	55
B53693	DR	42	B54194	DM	44	B54456	DHPCF-5	39	B54909	BD	55
B53694	DR	42	B54196	DM	44	B54458	DHPCF-5	39	B54910	BD	55
B53696	DR	42	B54197	DM	44	B54459	DHPCF-5	39	B54911	BD	55
B53698	DR	42	B54200	DM	44	B54460	DHPCF-5	39	B54912	BD	55
B53701	DR	42	B54203	DM	44	B54509	DHPCF-8	40	B54913	BD	55
B53704	DR	42	B54204	DM	44	B54517	DHPCF-8	40	B54914	BD	55
B53708	DR	42	B54205	DM	44	B54527	DHPCF-8	40	B54915	BD	55
B53710	DR	42	B54207	DM	44	B54535	DHPCF-8	40	B54918	BD	55
B53713	DR	42	B54209	DM	44	B54541	DHPCF-8	40	B54919	BD	55
B53715	DR	42	B54211	DM	44	B54546	DHPCF-8	40	B54920	BD	55
B53718	DR	42	B54212	DM	44	B54558	DHPCF-8	40	B54921	BD	55
B53720	DR	42	B54215	DM	44	B54568	DHPCF-8	40	B54922	BD	55
B53722	DR	42	B54216	DM	44	B54575	DHPCF-8	40	B54923	BD	55
B53724	DR	42	B54218	DM	44	B54577	DHPCF-8	40	B54924	BD	55
B53725	DR	42	B54220	DM	44	B54584	DHPCF-8	40	B54945	BE	56
B53727	DR	42	B54221	DM	44	B54587	DHPCF-8	40	B54946	BE	56
B53729	DR	42	B54223	DM	44	B54591	DHPCF-8	40	B54947	BE	56
B53731	DR	42	B54225	DM	44	B54597	DHPCF-8	40	B54948	BE	56
B53732	DR	42	B54227	DM	44	B54598	DHPCF-8	40	B54950	BE	56
B53735	DR	42	B54228	DM	44	B54604	DHPCF-8	40	B54954	BE	56
B53737	DR	42	B54230	DM	44	B54605	DHPCF-8	40	B54955	BE	56
B53739	DR	42	B54233	DM	44	B54615	DHPCF-8	40	B54956	BE	56
B53741	DR	42	B54235	DM	44	B54620	DHPCF-8	40	B54957	BE	56
B53742	DR	42	B54237	DM	44	B54623	DHPCF-8	40	B54959	BE	56
B53744	DR	42	B54239	DM	44	B54631	DHPCF-8	40	B54981	BF	56
B54100	DM	44	B54242	DM	44	B54632	DHPCF-8	40	B54982	BF	56
B54101	DM	44	B54245	DM	44	B54640	DHPCF-8	40	B54983	BF	56
B54102	DM	44	B54247	DM	44	B54642	DHPCF-8	40	B54984	BF	56
B54104	DM	44	B54248	DM	44	B54646	DHPCF-8	40	B54985	BF	56
B54105	DM	44	B54250	DM	44	B54648	DHPCF-8	40	B54986	BF	56
B54108	DM	44	B54251	DM	44	B54649	DHPCF-8	40	B54990	BF	56
B54112	DM	44	B54253	DM	44	B54650	DHPCF-8	40	B54991	BF	56
B54113	DM	44	B54254	DM	44	B54652	DHPCF-8	40	B54992	BF	56
B54115	DM	44	B54256	DM	44	B54656	DHPCF-8	40	B54993	BF	56
B54119	DM	44	B54257	DM	44	B54659	DHPCF-8	40	B54994	BF	56
B54121	DM	44	B54259	DM	44	B54660	DHPCF-8	40	B54995	BF	56
B54123	DM	44	B54260	DM	44	B54801	BA	54	B55017	BG	57
B54126	DM	44	B54262	DM	45	B54802	BA	54	B55018	BG	57
B54128	DM	44	B54263	DM	45	B54803	BA	54	B55019	BG	57
B54131	DM	44	B54265	DM	45	B54804	BA	54	B55020	BG	57
B54133	DM	44	B54266	DM	45	B54805	BA	54	B55021	BG	57
B54135	DM	44	B54267	DM	45	B54806	BA	54	B55026	BG	57
B54136	DM	44	B54268	DM	45	B54807	BA	54	B55027	BG	57
B54139	DM	44	B54270	DM	45	B54810	BA	54	B55028	BG	57
B54140	DM	44	B54300	DHPCF-5	39	B54811	BA	54	B55029	BG	57
B54143	DM	44	B54306	DHPCF-5	39	B54812	BA	54	B55030	BG	57
B54146	DM	44	B54317	DHPCF-5	39	B54813	BA	54	B55053	BH	57
B54149	DM	44	B54327	DHPCF-5	39	B54814	BA	54	B55054	BH	57

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Index by EDP Number



**BASSETT**™

EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number
B55055	BH	57	B55864	BC	55	B56098	DHP-5	38	B60192	MSE-V-4R	4
B55060	BH	57	B55865	BC	55	B56104	DHP-5	38	B60193	MSE-V-4R	4
B55061	BH	57	B55867	BD	55	B56105	DHP-5	38	B60194	MSE-V-4R	4
B55062	BH	57	B55868	BD	55	B56111	DHP-5	38	B60195	MSE-V-4R	4
B55145	BL	58	B55869	BD	55	B56115	DHP-5	38	B60196	MSE-V-4R	4
B55146	BL	58	B55873	BE	56	B56123	DHP-5	38	B60197	MSE-V-4R	4
B55147	BL	58	B55874	BE	56	B56126	DHP-5	38	B60198	MSE-V-4R	4
B55148	BL	58	B55875	BE	56	B56132	DHP-5	38	B60199	MSE-V-4R	4
B55149	BL	58	B55878	BF	56	B56139	DHP-5	38	B60200	MSE-V-4R	4
B55154	BL	58	B55879	BF	56	B56140	DHP-5	38	B60201	MSE-V-4R	4
B55155	BL	58	B55880	BF	56	B56144	DHP-5	38	B60202	MSE-V-4R	4
B55156	BL	58	B55881	BF	56	B56146	DHP-5	38	B60203	MSE-V-4R	4
B55157	BL	58	B55884	BL	58	B56149	DHP-5	38	B60204	MSE-V-4R	4
B55158	BL	58	B55885	BL	58	B56150	DHP-5	38	B60205	MSE-V-4R	4
B55170	BL	58	B55900	BA	54	B56153	DHP-5	38	B60206	MSE-V-4R	4
B55171	BL	58	B55901	BA	54	B56155	DHP-5	38	B60207	MSE-V-4R	4
B55181	BM	58	B55902	BA	54	B56156	DHP-5	38	B60208	MSE-V-4R	4
B55182	BM	58	B55903	BC	55	B56158	DHP-5	38	B60209	MSE-V-4R	4
B55183	BM	58	B55904	BC	55	B56159	DHP-5	38	B60210	MSE-V-4R	4
B55184	BM	58	B55905	BC	55	B56160	DHP-5	38	B60211	MSE-V-4R	4
B55185	BM	58	B55906	BD	55	B60140	MSE-V-4R	3	B60212	MSE-V-4R	4
B55190	BM	58	B55907	BD	55	B60141	MSE-V-4R	3	B60213	MSE-V-4R	4
B55191	BM	58	B55908	BD	55	B60142	MSE-V-4R	3	B60214	MSE-V-4R	4
B55192	BM	58	B55909	BE	56	B60143	MSE-V-4R	3	B60215	MSE-V-4R	4
B55193	BM	58	B55910	BE	56	B60144	MSE-V-4R	3	B60216	MSE-V-4R	4
B55194	BM	58	B55911	BE	56	B60145	MSE-V-4R	3	B60217	MSE-V-4R	4
B55600	BA	54	B55912	BF	56	B60146	MSE-V-4R	3	B60218	MSE-V-4R	5
B55601	BA	54	B55913	BF	56	B60147	MSE-V-4R	3	B60219	MSE-V-4R	5
B55604	BAE	54	B55914	BF	56	B60148	MSE-V-4R	3	B60220	MSE-V-4R	5
B55608	BA	54	B55915	BG	57	B60149	MSE-V-4R	3	B60221	MSE-V-4R	5
B55609	BA	54	B55916	BG	57	B60150	MSE-V-4R	3	B60222	MSE-V-4R	5
B55612	BAE	54	B55917	BG	57	B60151	MSE-V-4R	3	B60223	MSE-V-4R	5
B55620	BC	55	B55918	BH	57	B60152	MSE-V-4R	3	B60224	MSE-V-4R	5
B55621	BC	55	B55919	BH	57	B60153	MSE-V-4R	3	B60225	MSE-V-4R	5
B55624	BD	55	B55920	BL	58	B60154	MSE-V-4R	4	B60226	MSE-V-4R	5
B55625	BD	55	B55921	BL	58	B60155	MSE-V-4R	4	B60227	MSE-V-4R	5
B55628	BF	56	B55922	BL	58	B60156	MSE-V-4R	4	B60228	MSE-V-4R	5
B55629	BF	56	B55923	BA	54	B60157	MSE-V-4R	4	B60229	MSE-V-4R	5
B55632	BG	57	B55924	BA	54	B60158	MSE-V-4R	4	B60230	MSE-V-4R	5
B55633	BG	57	B55925	BA	54	B60159	MSE-V-4R	4	B60231	MSE-V-4R	3
B55636	BG	57	B55926	BC	55	B60160	MSE-V-4R	4	B60232	MSE-V-4R	3
B55637	BG	57	B55927	BC	55	B60161	MSE-V-4R	4	B60233	MSE-V-4R	3
B55640	BL	58	B55928	BC	55	B60162	MSE-V-4R	4	B60234	MSE-V-4R	3
B55641	BL	58	B55929	BD	55	B60163	MSE-V-4R	5	B60235	MSE-V-4R	4
B55644	BM	58	B55930	BD	55	B60164	MSE-V-4R	5	B60236	MSE-V-4R	4
B55645	BM	58	B55931	BD	55	B60165	MSE-V-4R	3	B60237	MSE-V-4R	4
B55648	BM	58	B55932	BE	56	B60166	MSE-V-4R	3	B60238	MSE-V-4R	4
B55649	BM	58	B55933	BE	56	B60167	MSE-V-4R	3	B60308	MSE-V-4B	5
B55652	BN	59	B55934	BE	56	B60168	MSE-V-4R	3	B60309	MSE-V-4B	5
B55700	BA	54	B55935	BF	56	B60169	MSE-V-4R	3	B60310	MSE-V-4B	5
B55701	BAE	54	B55936	BF	56	B60170	MSE-V-4R	3	B60311	MSE-V-4B	5
B55704	BC	55	B55937	BF	56	B60171	MSE-V-4R	3	B60312	MSE-V-4B	5
B55705	BD	55	B55938	BG	57	B60172	MSE-V-4R	3	B60313	MSE-V-4B	5
B55707	BF	56	B55939	BG	57	B60173	MSE-V-4R	3	B60314	MSE-V-4B	5
B55709	BM	58	B55940	BG	57	B60174	MSE-V-4R	3	B60315	MSE-V-4B	5
B55710	BN	59	B55941	BH	57	B60175	MSE-V-4R	3	B60316	MSE-V-4B	5
B55712	BA	54	B55942	BH	57	B60176	MSE-V-4R	3	B60317	MSE-V-4B	5
B55713	BAE	54	B55943	BL	58	B60177	MSE-V-4R	3	B60320	MSE-V2-5R	6
B55716	BC	55	B55944	BL	58	B60178	MSE-V-4R	3	B60321	MSE-V2-5R	7
B55717	BD	55	B55945	BL	58	B60179	MSE-V-4R	3	B60322	MSE-V2-5R	7
B55718	BE	56	B56000	DHP-5	38	B60180	MSE-V-4R	3	B60323	MSE-V2-5R	7
B55719	BF	56	B56006	DHP-5	38	B60181	MSE-V-4R	3	B60324	MSE-V2-5R	7
B55720	BG	57	B56017	DHP-5	38	B60182	MSE-V-4R	3	B60325	MSE-V2-5R	7
B55721	BM	58	B56027	DHP-5	38	B60183	MSE-V-4R	3	B60410	MSE-V2-5R	6
B55722	BN	59	B56046	DHP-5	38	B60184	MSE-V-4R	3	B60411	MSE-V2-5R	6
B55856	BAE	54	B56058	DHP-5	38	B60185	MSE-V-4R	3	B60412	MSE-V2-5R	6
B55857	BAE	54	B56068	DHP-5	38	B60186	MSE-V-4R	4	B60413	MSE-V2-5R	6
B55858	BAE	54	B56075	DHP-5	38	B60187	MSE-V-4R	4	B60414	MSE-V2-5R	6
B55859	BAE	54	B56077	DHP-5	38	B60188	MSE-V-4R	4	B60415	MSE-V2-5R	6
B55860	BAE	54	B56084	DHP-5	38	B60189	MSE-V-4R	4	B60416	MSE-V2-5R	6
B55862	BC	55	B56087	DHP-5	38	B60190	MSE-V-4R	4	B60417	MSE-V2-5R	6
B55863	BC	55	B56091	DHP-5	38	B60191	MSE-V-4R	4	B60418	MSE-V2-5R	6



**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
B60419	MSE-V2-5R	6	B60491	MSE-V2-5R	8	B67202	MSE-3	28	B68412	MSE-2	25
B60420	MSE-V2-5R	6	B60492	MSE-V2-5R	8	B67203	MSE-3	28	B68414	MSE-2	25
B60421	MSE-V2-5R	6	B60493	MSE-V2-5R	8	B67205	MSE-3	28	B68416	MSE-2	25
B60422	MSE-V2-5R	6	B60494	MSE-V2-5R	8	B67206	MSE-3	28	B68418	MSE-2	25
B60423	MSE-V2-5R	7	B60495	MSE-V2-5R	8	B67208	MSE-3	28	B68420	MSE-2	25
B60424	MSE-V2-5R	7	B60496	MSE-V2-5R	8	B67209	MSE-3	28	B68450	MSE-4	29
B60425	MSE-V2-5R	7	B60497	MSE-V2-5R	8	B67210	MSE-3	28	B68451	MSE-4	29
B60426	MSE-V2-5R	7	B60498	MSE-V2-5R	7	B67212	MSE-3	28	B68452	MSE-4	29
B60427	MSE-V2-5R	7	B61074	MSE-4	30	B67213	MSE-3	28	B68454	MSE-4	30
B60428	MSE-V2-5R	7	B61216	MSE-2	25	B67214	MSE-3	28	B68455	MSE-4	30
B60429	MSE-V2-5R	7	B62077	MSE-4	31	B67216	MSE-3	28	B68456	MSE-4	30
B60430	MSE-V2-5R	7	B62078	MSE-4	31	B67217	MSE-3	28	B68457	MSE-4	30
B60431	MSE-V2-5R	7	B62087	MSE-4	29	B67218	MSE-3	28	B68458	MSE-4	30
B60432	MSE-V2-5R	8	B62088	MSE-4	29	B67220	MSE-3	28	B68459	MSE-4	30
B60433	MSE-V2-5R	8	B62089	MSE-4	29	B67221	MSE-3	28	B68460	MSE-4	30
B60434	MSE-V2-5R	6	B62090	MSE-4	29	B67222	MSE-3	28	B68461	MSE-4	31
B60435	MSE-V2-5R	6	B62091	MSE-4	29	B67224	MSE-3	28	B68462	MSE-4	31
B60436	MSE-V2-5R	6	B62092	MSE-4	30	B67225	MSE-3	28	B68464	MSE-4	31
B60437	MSE-V2-5R	6	B62093	MSE-4	30	B67226	MSE-3	28	B68466	MSE-4	31
B60438	MSE-V2-5R	6	B62095	MSE-4	29	B68200	MSE-2	24	B68468	MSE-4	31
B60439	MSE-V2-5R	6	B62096	MSE-4	29	B68202	MSE-2	24	B68470	MSE-4	31
B60440	MSE-V2-5R	6	B62098	MSE-4	30	B68204	MSE-2	24	B68472	MSE-4	30
B60441	MSE-V2-5R	6	B62099	MSE-4	30	B68206	MSE-2	25	B68475	MSE-4	30
B60442	MSE-V2-5R	6	B62100	MSE-4	31	B68208	MSE-2	25	B68477	MSE-4	30
B60443	MSE-V2-5R	6	B62118	MSE-4	29	B68210	MSE-2	25	B68499	MSE-4B	32
B60444	MSE-V2-5R	6	B62276	MSE-4	31	B68212	MSE-2	25	B68500	MSE-2B	26
B60445	MSE-V2-5R	6	B62612	MSE-2	24	B68214	MSE-2	25	B68502	MSE-2B	26
B60446	MSE-V2-5R	6	B66100	HPDEM-5	10	B68216	MSE-2	25	B68503	MSE-4B	32
B60447	MSE-V2-5R	6	B66101	HPDEM-5	10	B68218	MSE-2	25	B68504	MSE-2B	26
B60448	MSE-V2-5R	6	B66103	HPDEM-5	10	B68220	MSE-2	25	B68505	MSE-2B	26
B60449	MSE-V2-5R	6	B66104	HPDEM-5	10	B68250	MSE-4	29	B68506	MSE-2B	26
B60450	MSE-V2-5R	6	B66106	HPDEM-5	10	B68252	MSE-4	29	B68508	MSE-2B	27
B60451	MSE-V2-5R	6	B66108	HPDEM-5	10	B68254	MSE-4	30	B68509	MSE-2B	27
B60452	MSE-V2-5R	6	B66110	HPDEM-5	10	B68256	MSE-4	30	B68510	MSE-2B	27
B60453	MSE-V2-5R	7	B66215	MRS	17	B68258	MSE-4	30	B68511	MSE-2B	27
B60454	MSE-V2-5R	7	B66223	MRS	17	B68260	MSE-4	30	B68512	MSE-2B	27
B60455	MSE-V2-5R	7	B66232	MRS	17	B68262	MSE-4	31	B68514	MSE-2B	27
B60456	MSE-V2-5R	7	B66240	MRS	17	B68264	MSE-4	31	B68516	MSE-2B	27
B60457	MSE-V2-5R	7	B66248	MRS	17	B68266	MSE-4	31	B68518	MSE-2B	27
B60458	MSE-V2-5R	7	B66264	MRS	17	B68268	MSE-4	31	B68520	MSE-2B	27
B60459	MSE-V2-5R	7	B66416	MRS	17	B68270	MSE-4	31	B68550	MSE-4B	32
B60460	MSE-V2-5R	7	B66424	MRS	17	B68300	MSE-2B	26	B68552	MSE-4B	32
B60461	MSE-V2-5R	7	B66432	MRS	17	B68302	MSE-2B	26	B68554	MSE-4B	32
B60462	MSE-V2-5R	7	B66440	MRS	17	B68304	MSE-2B	26	B68555	MSE-4B	32
B60463	MSE-V2-5R	7	B66448	MRS	17	B68306	MSE-2B	26	B68556	MSE-4B	33
B60464	MSE-V2-5R	7	B66464	MRS	17	B68308	MSE-2B	27	B68558	MSE-4B	33
B60465	MSE-V2-5R	7	B67104	MSE-3	28	B68310	MSE-2B	27	B68559	MSE-4B	33
B60466	MSE-V2-5R	7	B67105	MSE-3	28	B68312	MSE-2B	27	B68560	MSE-4B	33
B60467	MSE-V2-5R	7	B67106	MSE-3	28	B68314	MSE-2B	27	B68561	MSE-4B	33
B60468	MSE-V2-5R	7	B67107	MSE-3	28	B68316	MSE-2B	27	B68562	MSE-4B	33
B60469	MSE-V2-5R	7	B67108	MSE-3	28	B68318	MSE-2B	27	B68563	MSE-4B	33
B60470	MSE-V2-5R	7	B67109	MSE-3	28	B68320	MSE-2B	27	B68564	MSE-4B	33
B60471	MSE-V2-5R	7	B67110	MSE-3	28	B68350	MSE-4B	32	B68566	MSE-4B	33
B60472	MSE-V2-5R	7	B67111	MSE-3	28	B68352	MSE-4B	32	B68568	MSE-4B	33
B60473	MSE-V2-5R	7	B67112	MSE-3	28	B68354	MSE-4B	32	B68570	MSE-4B	33
B60474	MSE-V2-5R	7	B67113	MSE-3	28	B68356	MSE-4B	33	B68574	MSE-4B	33
B60475	MSE-V2-5R	7	B67114	MSE-3	28	B68358	MSE-4B	33	B68575	MSE-4B	33
B60476	MSE-V2-5R	7	B67115	MSE-3	28	B68360	MSE-4B	33	B69001	MSE-2	24
B60477	MSE-V2-5R	7	B67116	MSE-3	28	B68362	MSE-4B	33	B69002	MSE-2	24
B60478	MSE-V2-5R	7	B67117	MSE-3	28	B68364	MSE-4B	33	B69004	MSE-2	24
B60479	MSE-V2-5R	7	B67118	MSE-3	28	B68366	MSE-4B	33	B69005	MSE-2	24
B60480	MSE-V2-5R	7	B67120	MSE-3	28	B68368	MSE-4B	33	B69007	MSE-2	24
B60481	MSE-V2-5R	7	B67124	MSE-3	28	B68370	MSE-4B	33	B69008	MSE-2	24
B60482	MSE-V2-5R	7	B67128	MSE-3	28	B68400	MSE-2	24	B69010	MSE-2	24
B60483	MSE-V2-5R	7	B67132	MSE-3	28	B68402	MSE-2	24	B69013	MSE-2	24
B60484	MSE-V2-5R	7	B67136	MSE-3	28	B68404	MSE-2	24	B69014	MSE-2	24
B60485	MSE-V2-5R	8	B67140	MSE-3	28	B68405	MSE-2	24	B69017	MSE-2	24
B60486	MSE-V2-5R	8	B67148	MSE-3	28	B68406	MSE-2	25	B69020	MSE-2	24
B60487	MSE-V2-5R	8	B67156	MSE-3	28	B68408	MSE-2	25	B69021	MSE-2	24
B60488	MSE-V2-5R	8	B67164	MSE-3	28	B68409	MSE-2	25	B69023	MSE-2	24
B60489	MSE-V2-5R	8	B67200	MSE-3	28	B68410	MSE-2	25	B69026	MSE-2	25
B60490	MSE-V2-5R	8	B67201	MSE-3	28	B68411	MSE-2	25	B69038	MSE-2	25

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX



Index by EDP Number



**BASSETT™**

EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number	EDP Number	Style Number	Page Number
B69045	MSE-2	25	B69170	MSE-4	30	B69532	MDE-4B	23	B70212	MSEST-2	34
B69047	MSE-2	25	B69171	MSE-4	30	B69534	MDE-4B	23	B70215	MSEST-2	34
B69053	MSE-2	25	B69172	MSE-4	30	B69538	MDE-4B	23	B71000	TM	48
B69060	MSE-2	24	B69173	MSE-4	31	B69540	MDE-4B	23	B71002	TM	48
B69061	MSE-2	24	B69174	MSE-4	31	B69543	MDE-4B	23	B71003	TM	48
B69062	MSE-2	24	B69175	MSE-4	31	B69601	MSE-2	24	B71004	TM	48
B69063	MSE-2	24	B69176	MSE-4	31	B69602	MSE-2	24	B71005	TM	48
B69065	MSE-2	25	B69177	MSE-4	31	B69604	MSE-2	24	B71008	TM	48
B69066	MSE-2	25	B69178	MSE-4	31	B69606	MSE-2	24	B71009	TM	48
B69068	MSE-2	25	B69179	MSE-4	31	B69608	MSE-2	24	B71010	TM	48
B69069	MSE-2	25	B69180	MSE-4	31	B69623	MSE-2	25	B71011	TM	48
B69070	MSE-2	25	B69181	MSE-4	31	B69628	MSE-2	25	B71012	TM	48
B69072	MSE-2	25	B69182	MSE-4	31	B69641	MSE-4	29	B71013	TM	48
B69073	MSE-2	25	B69183	MSE-4	31	B69642	MSE-4	29	B71014	TM	48
B69074	MSE-2	25	B69184	MSE-4	31	B69643	MSE-4	29	B71015	TM	48
B69076	MSE-2	25	B69201	MSE-2B	26	B69644	MSE-4	29	B71016	TM	48
B69077	MSE-2	25	B69202	MSE-2B	26	B69645	MSE-4	29	B71017	TM	48
B69078	MSE-2	25	B69204	MSE-2B	26	B69646	MSE-4	29	B71018	TM	48
B69080	MSE-2	25	B69205	MSE-2B	26	B69648	MSE-4	29	B71019	TM	48
B69081	MSE-2	25	B69207	MSE-2B	26	B69650	MSE-4	29	B71020	TM	48
B69082	MSE-2	25	B69208	MSE-2B	26	B69652	MSE-4	29	B71021	TM	48
B69084	MSE-2	25	B69210	MSE-2B	26	B69657	MSE-4	30	B71022	TM	48
B69085	MSE-2	25	B69211	MSE-2B	26	B69663	MSE-4	30	B71023	TM	48
B69086	MSE-2	25	B69214	MSE-2B	26	B69681	MSE-2B	26	B71025	TM	48
B69101	MSE-4	29	B69216	MSE-2B	26	B69682	MSE-2B	26	B71026	TM	48
B69102	MSE-4	29	B69217	MSE-2B	26	B69684	MSE-2B	26	B71027	TM	48
B69104	MSE-4	29	B69220	MSE-2B	26	B69688	MSE-2B	26	B71028	TM	48
B69105	MSE-4	29	B69221	MSE-2B	26	B69692	MSE-2B	26	B71029	TM	48
B69106	MSE-4	29	B69223	MSE-2B	26	B69697	MSE-2B	26	B71050	TMNP	49
B69107	MSE-4	29	B69247	MSE-2B	27	B69699	MSE-2B	26	B71051	TMNP	49
B69108	MSE-4	29	B69251	MSE-2B	27	B69701	MSE-2B	27	B71052	TMNP	49
B69110	MSE-4	29	B69253	MSE-2B	27	B69703	MSE-2B	27	B71055	TMNP	49
B69111	MSE-4	29	B69301	MSE-4B	32	B69706	MSE-2B	27	B71056	TMNP	49
B69112	MSE-2	24	B69302	MSE-4B	32	B69708	MSE-2B	27	B71070	TMM	50
B69113	MSE-4	29	B69303	MSE-4B	32	B69711	MSE-2B	27	B71071	TMM	50
B69114	MSE-4	30	B69304	MSE-4B	32	B69716	MSE-4B	32	B71072	TMM	50
B69115	MSE-4	30	B69305	MSE-4B	32	B69717	MSE-4B	32	B71073	TMM	50
B69116	MSE-4	30	B69306	MSE-4B	32	B69718	MSE-4B	32	B71074	TMM	50
B69117	MSE-4	30	B69308	MSE-4B	32	B69719	MSE-4B	32	B71075	TMM	50
B69118	MSE-4	30	B69309	MSE-4B	32	B69720	MSE-4B	32	B71076	TMM	50
B69119	MSE-4	30	B69310	MSE-4B	32	B69721	MSE-4B	32	B71077	TMM	50
B69120	MSE-4	30	B69311	MSE-4B	32	B69722	MSE-4B	32	B71078	TMM	50
B69121	MSE-4	30	B69313	MSE-4B	32	B69724	MSE-4B	32	B71079	TMM	50
B69122	MSE-4	30	B69314	MSE-4B	32	B69728	MSE-4B	32	B71080	TMM	50
B69123	MSE-4	30	B69316	MSE-4B	32	B69732	MSE-4B	32	B71081	TMM	50
B69124	MSE-4	30	B69317	MSE-4B	32	B69737	MSE-4B	32	B71082	TMM	50
B69126	MSE-4	30	B69320	MSE-4B	32	B69739	MSE-4B	33	B71083	TMM	50
B69129	MSE-4	30	B69321	MSE-4B	32	B69741	MSE-4B	33	B71084	TMM	50
B69130	MSE-4	30	B69323	MSE-4B	32	B69743	MSE-4B	33	B71085	TMM	50
B69131	MSE-4	30	B69326	MSE-4B	33	B69746	MSE-4B	33	B71100	TMBPP	49
B69132	MSE-4	30	B69345	MSE-4B	33	B69748	MSE-4B	33	B71101	TMBPP	49
B69134	MSE-4	30	B69347	MSE-4B	33	B69751	MSE-4B	33	B71102	TMBPP	49
B69136	MSE-4	30	B69353	MSE-4B	33	B69843	MDE-4	22	B71104	TMBPP	49
B69138	MSE-4	30	B69443	MDE-4	22	B69845	MDE-4	22	B71120	TMBPT	49
B69143	MSE-4	31	B69447	MDE-4	22	B69846	MDE-4	22	B71121	TMBPT	49
B69144	MSE-4	31	B69452	MDE-4	22	B69881	MDE-2B	21	B71122	TMBPT	49
B69145	MSE-4	31	B69460	MDE-4	22	B69883	MDE-2B	21	B71123	TMBPT	49
B69146	MSE-4	31	B69481	MDE-2B	21	B69921	MDE-4B	23	B71508	TMC	48
B69147	MSE-4	31	B69483	MDE-2B	21	B69923	MDE-4B	23	B71509	TMC	48
B69149	MSE-4	31	B69485	MDE-2B	21	B70175	HPEM-5	12	B71510	TMC	48
B69151	MSE-4	31	B69487	MDE-2B	21	B70180	HPEM-6	13	B71511	TMC	48
B69153	MSE-4	31	B69490	MDE-2B	21	B70181	HPEM-6	13	B71512	TMC	48
B69157	MSE-4	29	B69492	MDE-2B	21	B70185	HPEM-6	13	B71513	TMC	48
B69158	MSE-4	29	B69494	MDE-2B	21	B70186	HPEM-6	13	B71514	TMC	48
B69159	MSE-4	29	B69498	MDE-2B	21	B70187	HPEM-6	13	B71515	TMC	48
B69160	MSE-4	29	B69500	MDE-2B	21	B70190	MSE-V-4B	5	B71516	TMC	48
B69162	MSE-4	29	B69503	MDE-2B	21	B70199	MSE-V2-5R	6	B71518	TMC	48
B69163	MSE-4	29	B69521	MDE-4B	23	B70201	MSEST-2	34	B71519	TMC	48
B69164	MSE-4	30	B69523	MDE-4B	23	B70203	MSEST-2	34	B71520	TMC	48
B69165	MSE-4	30	B69525	MDE-4B	23	B70205	MSEST-2	34	B71521	TMC	48
B69167	MSE-4	30	B69527	MDE-4B	23	B70207	MSEST-2	34	B71522	TMC	48
B69168	MSE-4	30	B69530	MDE-4B	23	B70210	MSEST-2	34	B71523	TMC	48



**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
B71525	TMC	48	B76164	BMTMM3	51b						
B71526	TMC	48	B76165	BMTMM3	51b						
B71527	TMC	48	B76166	BMTMM3	51b						
B71528	TMC	48	B76167	BMTMM3	51b						
B71529	TMC	48	B76168	BMTMM3	51b						
B71550	TMNPC	49	B81577	MSE-2	24						
B71551	TMNPC	49	B81578	MSE-2	25						
B71552	TMNPC	49	B81579	MSE-2	25						
B71555	TMNPC	49	B81581	MSE-2	25						
B71556	TMNPC	49	B81583	MSE-2	25						
B71572	TMMC	50	B81587	MSE-4	30						
B71573	TMMC	50	B81588	MSE-4	30						
B71574	TMMC	50	B81590	MSE-4	31						
B71575	TMMC	50	B81591	MSE-4	31						
B71576	TMMC	50	B81592	MSE-4	31						
B71577	TMMC	50									
B71578	TMMC	50									
B71579	TMMC	50									
B71580	TMMC	50									
B71581	TMMC	50									
B71582	TMMC	50									
B71583	TMMC	50									
B71584	TMMC	50									
B71585	TMMC	50									
B71600	TMBPPC	49									
B71601	TMBPPC	49									
B71602	TMBPPC	49									
B71604	TMBPPC	49									
B71620	TMBPTC	49									
B71621	TMBPTC	49									
B71622	TMBPTC	49									
B71623	TMBPTC	49									
B76124	BMTM2	51a									
B76125	BMTM2	51a									
B76126	BMTM2	51a									
B76127	BMTM2	51a									
B76128	BMTM2	51a									
B76129	BMTM2	51a									
B76130	BMTM2	51a									
B76131	BMTM2	51a									
B76132	BMTM2	51a									
B76133	BMTM2	51a									
B76134	BMTM2	51a									
B76135	BMTM2	51a									
B76136	BMTM2	51a									
B76137	BMTM2	51a									
B76138	BMTM2	51a									
B76139	BMTM2	51a									
B76140	BMTM3	51a									
B76141	BMTM3	51a									
B76142	BMTM3	51a									
B76143	BMTM3	51a									
B76144	BMTM3	51a									
B76145	BMTM3	51a									
B76146	BMTM3	51a									
B76147	BMTM3	51a									
B76148	BMTM3	51a									
B76149	BMTMM2	51b									
B76150	BMTMM2	51b									
B76151	BMTMM2	51b									
B76152	BMTMM2	51b									
B76153	BMTMM2	51b									
B76154	BMTMM2	51b									
B76155	BMTMM2	51b									
B76156	BMTMM2	51b									
B76157	BMTMM2	51b									
B76158	BMTMM2	51b									
B76159	BMTMM2	51b									
B76160	BMTMM2	51b									
B76161	BMTMM3	51b									
B76162	BMTMM3	51b									
B76163	BMTMM3	51b									

CARBIDE END MILLS

CARBIDE DRILLS

CARBIDE THREAD MILLS

CARBIDE BURS

INDEX







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