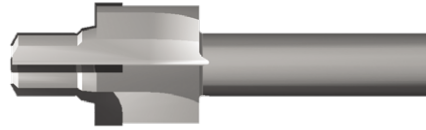
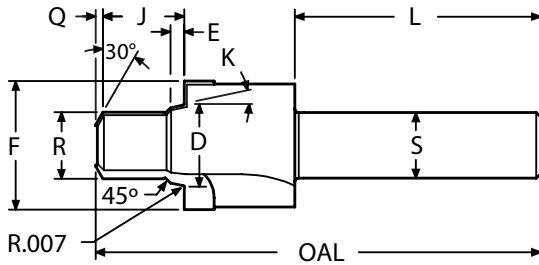


MS16142 (SAEJ1926/1) (SAEJ514) O-RING BOSS REAMER PILOT - CARBIDE TIPPED

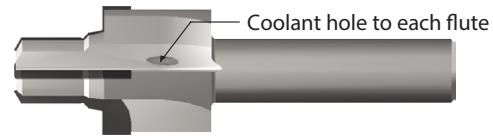
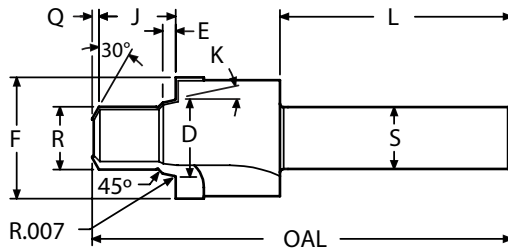


- Reams minor thread diameter to size
- Precision ground for maximum concentricity
- Often called ORB (followed by port size number)
- ALTiN+ coating extends tool life
- Meets the requirements of SAEJ1926/1
- Meets the requirements of SAEJ514

K	D	E	F	R	J	Q	L	S	OAL	FLUTES	TUBE	THREAD	SAE#	ORDER #		EDP #	
														UNCOATED	ALTiN+	UNCOATED	ALTiN+
12"	0.3605	0.082	0.682	0.271	0.479	0.032	1.75	0.500	3.00	3	0.125	0.3125-24 UNF-2B	SAE#2	MS16142-2R	MS16142-2RA	401319	401369
12"	0.4235	0.082	0.760	0.333	0.479	0.040	1.75	0.500	3.00	3	0.188	0.3750-24 UNF-2B	SAE#3	MS16142-3R	MS16142-3RA	401325	401375
12"	0.4895	0.101	0.838	0.388	0.558	0.045	1.88	0.500	3.12	3	0.250	0.4375-20 UNF-2B	SAE#4	MS16142-4R	MS16142-4RA	401328	401378
12"	0.5525	0.101	0.916	0.450	0.558	0.045	1.88	0.500	3.12	4	0.312	0.5000-20 UNF-2B	SAE#5	MS16142-5R	MS16142-5RA	401331	401381
12"	0.6185	0.105	0.990	0.507	0.620	0.055	1.88	0.500	3.38	4	0.375	0.5625-18 UNF-2B	SAE#6	MS16142-6R	MS16142-6RA	401334	401384
15"	0.8135	0.108	1.198	0.688	0.699	0.070	2.12	0.750	3.70	4	0.500	0.7500-16 UNF-2B	SAE#8	MS16142-8R	MS16142-8RA	401337	401387
15"	0.9445	0.108	1.354	0.804	0.792	0.080	2.12	0.750	3.80	4	0.625	0.8750-14 UNF-2B	SAE#10	MS16142-10R	MS16142-10RA	401301	401351
15"	1.1505	0.138	1.635	0.979	0.917	0.080	2.12	0.750	3.94	4	0.750	1.0625-12 UN-2B	SAE#12	MS16142-12R	MS16142-12RA	401304	401354
15"	1.2755	0.138	1.775	1.104	0.917	0.090	2.25	1.000	4.21	4	0.875	1.1875-12 UN-2B	SAE#14	MS16142-14R	MS16142-14RA	401307	401357
15"	1.4005	0.138	1.935	1.229	0.917	0.090	2.25	1.000	4.25	4	1.000	1.3125-12 UN-2B	SAE#16	MS16142-16R	MS16142-16RA	401310	401360
15"	1.7155	0.140	2.290	1.542	0.917	0.095	2.25	1.000	4.35	4	1.250	1.6250-12 UN-2B	SAE#20	MS16142-20R	MS16142-20RA	401313	401363
15"	1.9645	0.140	2.570	1.792	0.917	0.095	2.25	1.000	4.54	4	1.500	1.8750-12 UN-2B	SAE#24	MS16142-24R	MS16142-24RA	401316	401366
15"	2.5895	0.140	3.490	2.417	0.917	0.095	2.50	1.250	5.15	4	2.000	2.5000-12 UN-2B	SAE#32	MS16142-32R	MS16142-32RA	401322	401372

Thread mills are available. See pages 8-18.

MS16142 (SAEJ1926/1) (SAEJ514) O-RING BOSS REAMER PILOT - CARBIDE TIPPED - COOLANT THROUGH



- Reams minor thread diameter to size
- Precision ground for maximum concentricity
- Often called ORB (followed by port size number)
- ALTiN+ coating extends tool life
- Meets the requirements of SAEJ1926/1
- Meets the requirements of SAEJ514

K	D	E	F	R	J	Q	L	S	OAL	FLUTES	TUBE	THREAD	SAE#	ORDER #			
														UNCOATED	ALTiN+	UNCOATED	ALTiN+
12°	0.3605	0.082	0.682	0.271	0.479	0.032	1.75	0.500	3.00	3	0.125	0.3125-24 UNF-2B	SAE#2	MS16142-2R-X3	MS16142-2R-X3A	401513	401563
12°	0.4235	0.082	0.760	0.333	0.479	0.040	1.75	0.500	3.00	3	0.188	0.3750-24 UNF-2B	SAE#3	MS16142-3R-X3	MS16142-3R-X3A	401516	401566
12°	0.4895	0.101	0.838	0.388	0.558	0.045	1.88	0.500	3.12	3	0.250	0.4375-20 UNF-2B	SAE#4	MS16142-4R-X3	MS16142-4R-X3A	401519	401569
12°	0.5525	0.101	0.916	0.450	0.558	0.045	1.88	0.500	3.12	3	0.312	0.5000-20 UNF-2B	SAE#5	MS16142-5R-X3	MS16142-5R-X3A	401522	401572
12°	0.6185	0.105	0.990	0.507	0.620	0.055	1.88	0.500	3.38	3	0.375	0.5625-18 UNF-2B	SAE#6	MS16142-6R-X3	MS16142-6R-X3A	401525	401575
15°	0.8135	0.108	1.198	0.688	0.699	0.070	2.12	0.750	3.70	5	0.500	0.7500-16 UNF-2B	SAE#8	MS16142-8R-X5	MS16142-8R-X5A	401528	401578
15°	0.9445	0.108	1.354	0.804	0.792	0.080	2.12	0.750	3.80	5	0.625	0.8750-14 UNF-2B	SAE#10	MS16142-10R-X5	MS16142-10R-X5A	401501	401551
15°	1.1505	0.138	1.635	0.979	0.917	0.080	2.12	0.750	3.94	5	0.750	1.0625-12 UN-2B	SAE#12	MS16142-12R-X5	MS16142-12R-X5A	401504	401554
15°	1.2755	0.138	1.775	1.104	0.917	0.090	2.25	1.000	4.21	5	0.875	1.1875-12 UN-2B	SAE#14	MS16142-14R-X5	MS16142-14R-X5A	401507	401557
15°	1.4005	0.138	1.935	1.229	0.917	0.090	2.25	1.000	4.25	5	1.000	1.3125-12 UN-2B	SAE#16	MS16142-16R-X5	MS16142-16R-X5A	401510	401560

Thread mills are available. See pages 8-18.

PORT & CAVITY TECHNICAL INFORMATION

MATERIAL	HB/Rc	SPEED (SFM)		CUTTING CONDITIONS	
		UNCOATED	ALTiN+	INFEED PER FLUTE REAM	INFEED PER FLUTE SPOT FACE
CAST IRON	130 HB	75-210	200-450	.001-.0025	.0008-.0020
CARBON STEEL	18 Rc	125-190	190-400	.001-.0030	.001-.0020
ALLOY STEEL	20 Rc	70-135	130-350	.001-.0030	.0008-.0020
TOOL STEEL	25 Rc	75-100	100-220	.001-.0025	.0005-.0020
300 STAINLESS STEEL	150 HB	90-100	100-230	.001-.0020	.0007-.0015
400 STAINLESS STEEL	195 HB	90-135	135-300	.001-.0020	.0005-.0015
HIGH TEMP ALLOY (NICKEL & COBALT BASE)	20 Rc	30-125	100-150	.0008-.0015	.0005-.0010
TITANIUM	25 Rc	50-100	100-140	.001-.0020	.0005-.0010
HEAT TREATED ALLOYS (38-45Rc)	40 Rc	50-75	75-130	.0008-.0015	.0005-.0010
ALUMINUM	100 HB	850-1000	800-1500	.002-.0040	.0010-.0030
BRASS, ZINC	80 HB	750-950	800-1200	.002-.0040	.0010-.0030

SFM = Surface Feet per Minute
RPM = SFM x 3.82 divided by tool diameter

Starting parameters only. Setup and machine rigidity may affect performance.

PROBLEM	CAUSE	SOLUTION
RAPID FLANK WEAR	CUTTING CONDITIONS	Check for excessive speed and feed - see chart.
	TOOL	Select a coated tool.
	PROGRAM	Remove dwell from program at end of cut.
BUILT-UP EDGE	TOOL	Select a coated tool. The coating will resist built-up edges.
	HEAT	Use coolant through port tool. If coolant is not available, use shop air and a coated tool.
SURFACE TORN	TOOL	Use a coated tool. On most carbon steels, an uncoated tool will not produce an acceptable finish.
CHATTER	TOOL	Hone cutting edge of spot face. Use Coated Tool. Increase chip load.
LIGHT CHATTER	PROGRAM	Increase speed by 15-20%. A faster speed reduces forces. A dwell typically will not remove chatter.
POOR TOOL LIFE	AMOUNT OF STOCK	Rough port to 0.97 inch of finish size.
	PART	Make sure prior operation did not work harden the material.

SAMPLE PROGRAM FOR MAXIMUM PRODUCTIVITY

N51 (Sample Port Tool Program: MS33649-4RA (ALTiN+) cutting Carbon Steel

T51 M06

S2916 M03

G00 G90 G54 X0. Y0.

G43 H51 Z0.1 M08

G01 Z-0.6 F23.3

S1290 M03

G04 P1.

G01 Z-.73 F10.3

G00 Z5. M09

Select Tool

SFM = 300 ; RPM = 300 x 3.82 / Reamer Diameter

RPM = 300 X 3.82 / 0.393

RPM = 2916

Feed Rate = RPM x 0.002 x 4 (Number of Flutes)

RPM = 300 x 3.82 / 0.888 (Spot Face Diameter)

Dwell to slow down spindle

Feed rate = RPM x 0.002 x 4 (Number of Flutes)