

DRILLS- EXTRA LENGTH & DEEP HOLE

C

EXTRA LENGTH DRILLS
High Speed Steel
135° Self-Centering Split Point
6" Aircraft Extension

Longer Drills Available! Up To 48"! Call For More Information



Fractional Sizes				Black Oxide	
Dia.	Dec Equiv	Flute Len	Pkg Qty	Part Number	Price
3/64	0.0469	3/4	12	PTD-058003	\$5.41
1/16	0.0625	7/8	12	PTD-058004	\$2.44
5/64	0.0781	1	12	PTD-058005	\$2.44
3/32	0.0938	1-1/4	12	PTD-058006	\$1.87
7/64	0.1094	1-1/2	12	PTD-058007	\$2.02
1/8	0.125	1-5/8	12	PTD-058008	\$1.98
9/64	0.1406	1-3/4	12	PTD-058009	\$2.37
5/32	0.1562	2	12	PTD-058010	\$2.37
11/64	0.1719	2-1/8	12	PTD-058011	\$2.59
3/16	0.1875	2-5/16	12	PTD-058012	\$2.59
13/64	0.2031	2-7/16	12	PTD-058013	\$3.16
7/32	0.2188	2-1/2	12	PTD-058014	\$3.16
15/64	0.2344	2-5/8	12	PTD-058015	\$3.52
1/4	0.25	2-3/4	12	PTD-058016	\$3.45
17/64	0.2656	2-7/8	6	PTD-058017	\$7.90
9/32	0.2812	2-15/16	6	PTD-058018	\$8.20
19/64	0.2969	3-1/16	6	PTD-058019	\$9.63
5/16	0.3125	3-3/16	6	PTD-058020	\$10.45
21/64	0.3281	3-5/16	6	PTD-058021	\$11.35
11/32	0.3438	3-7/16	6	PTD-058022	\$11.23
23/64	0.3594	3-1/2	6	PTD-058023	\$12.61
3/8	0.375	3-5/8	6	PTD-058024	\$12.84
25/64	0.3906	3-3/4	6	PTD-058025	\$14.33
13/32	0.4062	3-7/8	6	PTD-058026	\$13.82
27/64	0.4219	3-15/16	6	PTD-058027	\$15.38
7/16	0.4375	4-1/16	6	PTD-058028	\$15.56
29/64	0.4531	4-3/16	6	PTD-058029	\$17.05
15/32	0.4688	4-5/16	6	PTD-058030	\$17.68
31/64	0.4844	4-3/8	6	PTD-058031	\$18.34
1/2	0.5	4-1/2	6	PTD-058032	\$18.66

Wire Sizes				Black Oxide	
Dia.	Dec Equiv	Flute Len	Pkg Qty	Part Number	Price
1	.2280	2-5/8	12	PTD-058101	\$3.71
2	.2210	2-5/8	12	PTD-058102	\$3.71
3	.2130	2-1/2	12	PTD-058103	\$3.35
4	.2090	2-1/2	12	PTD-058104	\$3.38
5	.2055	2-1/2	12	PTD-058105	\$3.38
6	.2040	2-1/2	12	PTD-058106	\$3.35
7	.2010	2-7/16	12	PTD-058107	\$3.35
8	.1990	2-7/16	12	PTD-058108	\$3.32
9	.1960	2-7/16	12	PTD-058109	\$3.23
10	.1935	2-7/16	12	PTD-058110	\$3.01
11	.1910	2-5/16	12	PTD-058111	\$2.77
12	.1890	2-5/16	12	PTD-058112	\$2.79
13	.1850	2-5/16	12	PTD-058113	\$2.74
14	.1820	2-3/16	12	PTD-058114	\$2.77
15	.1800	2-3/16	12	PTD-058115	\$2.77
16	.1770	2-3/16	12	PTD-058116	\$2.74
17	.1730	2-3/16	12	PTD-058117	\$2.85
18	.1695	2-1/8	12	PTD-058118	\$2.80
19	.1660	2-1/8	12	PTD-058119	\$2.74
20	.1610	2-1/8	12	PTD-058120	\$2.49
21	.1590	2-1/8	12	PTD-058121	\$2.49
22	.1570	2	12	PTD-058122	\$2.59
23	.1540	2	12	PTD-058123	\$2.59
24	.1520	2	12	PTD-058124	\$2.55
25	.1495	1-7/8	12	PTD-058125	\$2.55
26	.1470	1-7/8	12	PTD-058126	\$2.55
27	.1440	1-7/8	12	PTD-058127	\$2.49
28	.1405	1-3/4	12	PTD-058128	\$2.59
29	.1360	1-3/4	12	PTD-058129	\$2.52
30	.1285	1-5/8	12	PTD-058130	\$2.03

Wire Sizes (cont.)				Black Oxide	
Dia.	Dec Equiv	Flute Len	Pkg Qty	Part Number	Price
31	.1200	1-5/8	12	PTD-058131	\$2.13
32	.1160	1-5/8	12	PTD-058132	\$2.13
33	.1130	1-1/2	12	PTD-058133	\$2.13
34	.1110	1-1/2	12	PTD-058134	\$2.13
35	.1100	1-1/2	12	PTD-058135	\$2.13
36	.1065	1-7/16	12	PTD-058136	\$2.09
37	.1040	1-7/16	12	PTD-058137	\$2.13
38	.1015	1-7/16	12	PTD-058138	\$2.13
39	.0995	1-3/8	12	PTD-058139	\$2.13
40	.0980	1-3/8	12	PTD-058140	\$1.84
41	.0960	1-3/8	12	PTD-058141	\$1.94
42	.0935	1-1/4	12	PTD-058142	\$1.94
43	.0890	1-1/4	12	PTD-058143	\$2.47
44	.0860	1-1/8	12	PTD-058144	\$2.52
45	.0820	1-1/8	12	PTD-058145	\$2.52
46	.0810	1-1/8	12	PTD-058146	\$2.42
47	.0785	1	12	PTD-058147	\$2.45
48	.0760	1	12	PTD-058148	\$2.52
49	.0730	1	12	PTD-058149	\$2.52
50	.0700	1	12	PTD-058150	\$2.42
51	.0670	1	12	PTD-058151	\$2.52
52	.0635	7/8	12	PTD-058152	\$2.47
53	.0595	7/8	12	PTD-058153	\$4.95
54	.0550	7/8	12	PTD-058154	\$4.95
55	.0520	7/8	12	PTD-058155	\$4.95
56	.0465	3/4	12	PTD-058156	\$4.95
57	.0430	3/4	12	PTD-058157	\$5.99
58	.0420	11/16	12	PTD-058158	\$6.10
59	.0410	11/16	12	PTD-058159	\$6.10
60	.0400	11/16	12	PTD-058160	\$5.99

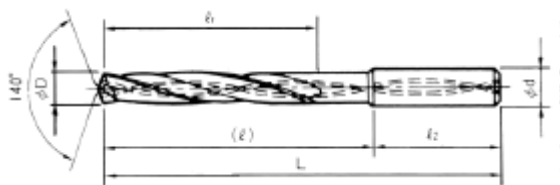
DEEP HOLE DRILLS

Solid Carbide, Coated Drills With Spiral Oil Holes



FEATURES:

- Spiral oil hole permits higher speed drilling
- Effectively evacuates chips even in deep holes
- Regrinding drill will not alter oil hole position
- Wide flutes allow for effective chip removal and no chip packing



RECOMMENDED CUTTING CONDITIONS

Material	Hardness Bhn	0.1250" - 0.3125"		0.3125" - 0.6250"	
		Speed (SFM)	Feed (ipr)	Speed (SFM)	Feed (ipr)
CARBON STEEL	-250	250-500	0.006-0.012	300-500	0.006-0.014
CARBON STEEL	250-	225-360	0.005-0.009	225-360	0.005-0.010
ALLOY STEEL	-250	250-400	0.006-0.010	250-400	0.006-0.012
ALLOY STEEL	250-	225-360	0.005-0.008	225-360	0.005-0.010
DIE STEEL	-280	125-200	0.004-0.008	150-230	0.004-0.008
STAINLESS STEEL	-200	125-230	0.004-0.008	150-265	0.005-0.010
DUCTILE CAST IRON	-200	200-330	0.008-0.014	200-330	0.009-0.016
HARDENED STEELS	40-45 Rc	75-150	0.001-0.003	75-150	0.002-0.005

COOLANT:

For maximum results, coolant must be supplied through the tool. For cutting fluid, dilute and emulsion type with 3-5 parts water. 150 PSI or greater is recommended.

DSC-S (L/D up to 3)

D	d	I1	I2	L	Part Number	Price Each
0.203	0.236	1.083	1.575	2.953	TO-DSCU203S	\$69.26
0.218	0.236	1.181	1.575	2.953	TO-DSCU218S	\$73.84
0.234	0.236	1.181	1.575	2.953	TO-DSCU234S	\$73.84
0.250	0.276	1.280	1.575	3.150	TO-DSCU250S	\$78.84
0.265	0.276	1.378	1.575	3.150	TO-DSCU265S	\$83.30
0.281	0.315	1.476	1.654	3.346	TO-DSCU281S	\$88.30
0.296	0.315	1.575	1.654	3.543	TO-DSCU296S	\$92.88
0.312	0.315	1.575	1.654	3.543	TO-DSCU312S	\$92.88
0.328	0.354	1.673	1.693	3.740	TO-DSCU328S	\$97.24
0.343	0.354	1.772	1.693	3.740	TO-DSCU343S	\$102.24
0.359	0.394	1.870	1.732	3.937	TO-DSCU359S	\$106.82
0.375	0.394	1.969	1.732	4.173	TO-DSCU375S	\$111.80
0.390	0.394	1.969	1.732	4.173	TO-DSCU390S	\$111.80
0.406	0.433	2.067	1.811	4.173	TO-DSCU406S	\$139.58
0.421	0.433	2.165	1.811	4.409	TO-DSCU421S	\$144.88
0.437	0.472	2.264	1.850	4.646	TO-DSCU437S	\$151.02
0.453	0.472	2.362	1.890	4.646	TO-DSCU453S	\$151.02
0.468	0.472	2.362	1.890	4.646	TO-DSCU468S	\$154.34
0.484	0.512	2.461	1.890	4.921	TO-DSCU484S	\$172.54
0.500	0.512	2.559	1.969	4.921	TO-DSCU500S	\$178.26
0.515	0.551	2.657	1.969	5.197	TO-DSCU515S	\$183.98
0.531	0.551	2.657	1.969	5.197	TO-DSCU531S	\$183.98
0.546	0.591	2.756	2.047	5.197	TO-DSCU546S	\$190.32
0.562	0.591	2.854	2.047	5.512	TO-DSCU562S	\$222.98
0.578	0.591	2.953	2.126	5.512	TO-DSCU578S	\$230.16
0.593	0.630	3.051	2.126	5.906	TO-DSCU593S	\$236.82
0.609	0.630	3.051	2.126	5.906	TO-DSCU609S	\$236.82
0.625	0.630	3.150	2.205	5.906	TO-DSCU625S	\$243.26

Additional Sizes Available. Please Call For More Information.

Call Us Today For All Of Your Machine Tool Needs!