

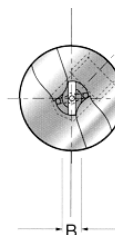
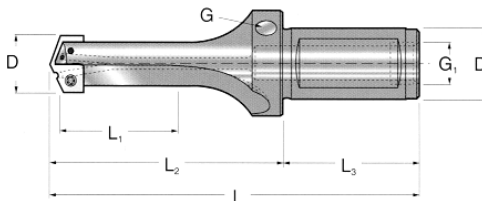
SPADE DRILLS

B

REPLACEABLE INSERT SPADE DRILLS Straight Shank Bodies



- FEATURES:**
- Interchanges with Allied Drill Bodies.
 - Radially ground corners for better surface finishes and longer tool life.
 - High performance HSS grade with a cobalt-enhanced substrate for increased tool life.
 - New tougher HSS grade for difficult operations.
 - Diameter range of 0.374 to 4.500 inch.
 - Cost Effective.



Short Series (dimensions in inches)

Insert Series	Drill Range D	L	L1	L2	L3	D1	B	G	G1	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	4 47/64	1 1/4	2 47/64	2	3/4	3/32	1/8	1/8	STL-024950	\$140.80	STL-OD139900	T7
USZ	0.437 - 0.510	4 47/64	1 1/4	2 47/64	2	3/4	3/32	1/8	1/8	STL-024951	\$140.80	STL-OD139901	T7
US0	0.511 - 0.608	4 7/8	1 3/8	2 7/8	2	3/4	1/8	1/8	1/8	STL-024952	\$140.80	STL-OD139902	T8
	0.609 - 0.697	4 7/8	1 3/8	2 7/8	2	3/4	1/8	1/8	1/8	STL-024953	\$140.80	STL-OD139903	T8
US1	0.703 - 0.856	6 21/64	2 5/8	4 21/64	2	3/4	5/32	1/8	1/8	STL-024954	\$143.00	STL-OD139904	T9
	0.859 - 0.967	6 21/64	2 5/8	4 21/64	2	1	5/32	1/8	1/8	STL-024955	\$154.00	STL-OD139905	T9
US2	0.968 - 1.186	7 3/8	3 3/8	5 1/8	2 1/4	1	3/16	1/8	1/8	STL-024956	\$154.00	STL-OD139906	T15
	1.187 - 1.404	7 29/64	3 3/8	5 13/64	2 1/4	1 1/4	3/16	1/8	1/8	STL-024957	\$176.00	STL-OD139906	T15
US3	1.406 - 1.888	9 9/16	4 3/4	6 13/16	2 3/4	1 1/2	1/4	1/8	1/8	STL-024958	\$187.00	STL-OD139907	T20
US4	1.889 - 2.563	10 1/32	5 1/8	7 9/32	2 3/4	1 1/2	5/16	1/8	1/2	STL-024959	\$320.00	STL-OD139907	T20
US5-6	2.500 - 3.528	12 3/16	6 3/4	8 15/16	3 1/4	2	7/16	1/8	1/2	STL-024960	\$435.00	STL-OD139908	T25
US6-7-8	3.531 - 4.500	12 7/8	6 3/4	9 3/8	3 1/2	2 1/2	7/16	1/8	1/2	STL-024961	\$396.00	STL-OD139908	T25

Standard Series (dimensions in inches)

Insert Series	Drill Range D	L	L1	L2	L3	D1	B	G	G1	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	5 55/64	2 3/8	3 55/64	2	3/4	3/32	1/8	1/8	STL-024962	\$147.40	STL-OD139900	T7
USZ	0.437 - 0.510	5 55/64	2 3/8	3 55/64	2	3/4	3/32	1/8	1/8	STL-024963	\$147.40	STL-OD139901	T7
US0	0.516 - 0.608	6	2 1/2	4	2	3/4	1/8	1/8	1/8	STL-024964	\$147.40	STL-OD139902	T8
	0.609 - 0.697	6	2 1/2	4	2	3/4	1/8	1/8	1/8	STL-024965	\$147.40	STL-OD139903	T8
US1	0.703 - 0.856	8 21/64	4 5/8	6 21/64	2	3/4	5/32	1/8	1/8	STL-024966	\$151.80	STL-OD139904	T9
	0.859 - 0.967	8 21/64	4 5/8	6 21/64	2	1	5/32	1/8	1/8	STL-024967	\$159.50	STL-OD139905	T9
US2	0.968 - 1.186	9 3/8	5 3/8	7 1/8	2 1/4	1	3/16	1/8	1/8	STL-024968	\$181.50	STL-OD139906	T15
	1.187 - 1.404	9 15/32	5 3/8	7 7/32	2 1/4	1 1/4	3/16	1/8	1/8	STL-024969	\$181.50	STL-OD139906	T15
US3	1.406 - 1.888	11 1/16	6 1/4	8 5/16	2 3/4	1 1/2	1/4	1/8	1/8	STL-024970	\$192.50	STL-OD139907	T20
US4	1.906 - 2.563	12 1/32	7 1/8	9 9/32	2 3/4	1 1/2	5/16	1/8	1/2	STL-024971	\$229.90	STL-OD139907	T20
US5-6	2.500 - 3.528	14 3/16	8 3/4	10 15/16	3 1/4	2	7/16	1/8	1/2	STL-024972	\$338.80	STL-OD139908	T25
US6-7-8	3.531 - 4.500	14 7/8	8 3/4	11 3/8	3 1/2	2 1/2	7/16	1/8	1/2	STL-024973	\$481.80	STL-OD139908	T25

Long Series (dimensions in inches)

Insert Series	Drill Range D	L	L1	L2	L3	D1	B	G	G1	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	7 55/64	4 3/8	5 55/64	2	3/4	3/32	1/8	1/8	STL-024974	\$165.00	STL-OD139900	T7
USZ	0.437 - 0.510	7 55/64	4 3/8	5 55/64	2	3/4	3/32	1/8	1/8	STL-024975	\$165.00	STL-OD139901	T7
US0	0.516 - 0.608	8	4 1/2	6	2	3/4	1/8	1/8	1/8	STL-024976	\$165.00	STL-OD139902	T8
	0.609 - 0.697	8	4 1/2	6	2	3/4	1/8	1/8	1/8	STL-024977	\$165.00	STL-OD139903	T8
US1	0.703 - 0.856	10 21/64	6 5/8	8 21/64	2	3/4	5/32	1/8	1/8	STL-024978	\$165.00	STL-OD139904	T9
	0.859 - 0.967	10 21/64	6 5/8	8 21/64	2	1	5/32	1/8	1/8	STL-024979	\$176.00	STL-OD139905	T9
US2	0.968 - 1.186	11 3/8	7 3/8	9 1/8	2 1/4	1	3/16	1/8	1/8	STL-024980	\$176.00	STL-OD139906	T15
	1.187 - 1.404	11 15/32	7 3/8	9 7/32	2 1/4	1 1/4	3/16	1/8	1/8	STL-024981	\$202.40	STL-OD139906	T15
US3	1.406 - 1.888	13 1/16	8 1/4	10 5/16	2 3/4	1 1/2	1/4	1/8	1/8	STL-024982	\$234.00	STL-OD139907	T20
US4	1.906 - 2.563	14 1/32	9 1/8	11 9/32	2 3/4	1 1/2	5/16	1/8	1/2	STL-024983	\$275.00	STL-OD139907	T20
US5-6	2.500 - 3.528	16 3/16	10 3/4	12 15/16	3 1/4	2	7/16	1/8	1/2	STL-024984	\$436.15	STL-OD139908	T25
US6-7-8	3.531 - 4.500	16 7/8	10 3/4	13 3/8	3 1/2	2 1/2	7/16	1/8	1/2	STL-024985	\$500.00	STL-OD139908	T25

Extra Long Series (dimensions in inches)

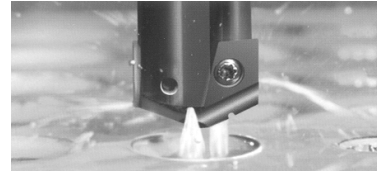
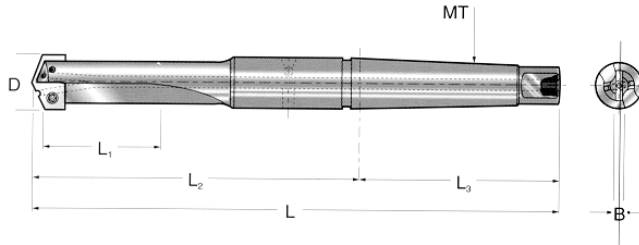
Insert Series	Drill Range D	L	L1	L2	L3	D1	B	G	G1	Part Number	Price Each	Insert Screw	Screw Driver
US1	0.703 - 0.856	14 21/64	10 5/8	12 21/64	2	3/4	5/32	1/8	1/8	STL-024986	\$179.30	STL-OD139904	T9
	0.859 - 0.967	14 21/64	10 5/8	12 21/64	2	1	5/32	1/8	1/8	STL-024987	\$192.50	STL-OD139905	T9
US2	0.968 - 1.186	15 3/8	11 3/8	13 1/8	2 1/4	1	3/16	1/8	1/8	STL-024988	\$198.00	STL-OD139906	T15
	1.187 - 1.404	15 15/32	11 3/8	13 7/32	2 1/4	1 1/4	3/16	1/8	1/8	STL-024989	\$209.00	STL-OD139906	T15

Call Us Today For All Of Your Machine Tool Needs!

SPADE DRILLS

B

REPLACEABLE INSERT SPADE DRILLS Morse Taper Bodies



Short Series

Insert Series	Drill Range D	MT	L	L1	L2	L3	B	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	#2	7 3/32	1 1/4	4 5/32	2 15/16	3/32	STL-024990	\$140.80	STL-OD139900	T7
USZ	0.437 - 0.510	#2	7 9/64	1 1/4	4 13/64	2 15/16	3/32	STL-024991	\$140.80	STL-OD139901	T7
US0	0.516 - 0.608	#2	7 19/64	1 3/8	4 23/64	2 15/16	1/8	STL-024992	\$140.80	STL-OD139902	T8
		#2	7 23/64	1 3/8	4 27/64	2 15/16	1/8	STL-024993	\$140.80	STL-OD139903	T8
US1	0.703 - 0.856	#3	9 3/4	2 5/8	6 1/16	3 11/16	5/32	STL-024994	\$151.80	STL-OD139904	T9
		#3	9 23/32	2 5/8	6 1/32	3 11/16	5/32	STL-024995	\$160.60	STL-OD139905	T9
US2	0.968 - 1.186	#3	10 1/4	3 3/8	6 9/16	3 11/16	3/16	STL-024996	\$166.10	STL-OD139006	T15
		#3	10 31/64	3 3/8	6 51/64	3 11/16	3/16	STL-024997	\$181.50	STL-OD139006	T15
US3	1.406 - 1.888	#4	13	4 3/4	8 3/8	4 5/8	1/4	STL-024998	\$187.00	STL-OD139907	T20
US4	1.906 - 2.563	#4	13 47/64	5 1/8	9 7/64	4 5/8	5/16	STL-024999	\$203.50	STL-OD139907	T20
US5-6	2.500 - 3.528	#5	17 15/16	6 3/4	12 1/16	5 7/8	7/16	STL-025000	\$325.00	STL-OD139908	T25
US6-7-8	3.531 - 4.500	#5	18 3/8	6 3/4	12 1/2	5 7/8	7/16	STL-025001	\$430.00	STL-OD139908	T25

Standard Series

Insert Series	Drill Range D	MT	L	L1	L2	L3	B	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	#2	8 7/32	2 3/8	5 9/32	2 15/16	3/32	STL-025002	\$140.80	STL-OD139900	T7
USZ	0.437 - 0.510	#2	8 17/64	2 3/8	5 21/64	2 15/16	3/32	STL-025003	\$140.80	STL-OD139901	T7
US0	0.516 - 0.608	#2	8 27/64	2 1/2	5 31/64	2 15/16	1/8	STL-025004	\$140.80	STL-OD139902	T8
		#2	8 1/2	2 1/2	5 9/16	2 15/16	1/8	STL-025005	\$140.80	STL-OD139903	T8
US1	0.703 - 0.856	#3	11 3/4	4 5/8	8 1/16	3 11/16	5/32	STL-025006	\$151.80	STL-OD139904	T9
		#3	11 3/4	4 5/8	8 1/32	3 11/16	5/32	STL-025007	\$160.60	STL-OD139905	T9
US2	0.968 - 1.186	#3	12 1/4	5 3/8	8 9/16	3 11/16	3/16	STL-025008	\$166.10	STL-OD139006	T15
		#3	12 31/64	5 3/8	8 51/64	3 11/16	3/16	STL-025009	\$181.50	STL-OD139006	T15
US3	1.406 - 1.888	#4	14 1/2	6 1/4	9 7/8	4 5/8	1/4	STL-025010	\$187.00	STL-OD139907	T20
US4	1.906 - 2.563	#4	15 47/64	7 1/8	11 7/64	4 5/8	5/16	STL-025011	\$229.90	STL-OD139907	T20
US5-6	2.500 - 3.528	#5	19 15/16	8 3/4	14 1/16	5 7/8	7/16	STL-025012	\$338.80	STL-OD139908	T25
US6-7-8	3.531 - 4.500	#5	20 3/8	8 3/4	14 1/2	5 7/8	7/16	STL-025013	\$481.80	STL-OD139908	T25

Long Series

Insert Series	Drill Range D	MT	L	L1	L2	L3	B	Part Number	Price Each	Insert Screw	Screw Driver
USY	0.375 - 0.433	#2	10 7/32	4 3/8	7 9/32	2 15/16	3/32	STL-025014	\$151.80	STL-OD139900	T7
USZ	0.437 - 0.510	#2	10 17/64	4 3/8	7 21/64	2 15/16	3/32	STL-025015	\$151.80	STL-OD139901	T7
US0	0.516 - 0.608	#2	10 27/64	4 1/2	7 31/64	2 15/16	1/8	STL-025016	\$151.80	STL-OD139902	T8
		#2	10 1/2	4 1/2	7 9/16	2 15/16	1/8	STL-025017	\$151.80	STL-OD139903	T8
US1	0.703 - 0.856	#3	13 3/4	6 5/8	10 1/16	3 11/16	5/32	STL-025018	\$154.00	STL-OD139904	T9
		#3	13 23/32	6 5/8	10 1/32	3 11/16	5/32	STL-025019	\$165.00	STL-OD139905	T9
US2	0.968 - 1.186	#3	14 1/4	7 3/8	10 9/16	3 11/16	3/16	STL-025020	\$165.00	STL-OD139006	T15
		#3	14 31/64	7 3/8	10 51/64	3 11/16	3/16	STL-025021	\$202.40	STL-OD139006	T15
US3	1.406 - 1.888	#4	16 1/2	8 1/4	11 7/8	4 5/8	1/4	STL-025022*	\$234.00	STL-OD139907	T20
US4	1.906 - 2.563	#4	17 47/64	9 1/8	13 7/64	4 5/8	5/16	STL-025023	\$275.00	STL-OD139907	T20
US5-6	2.500 - 3.528	#5	21 15/16	10 3/4	16 1/16	5 7/8	7/16	STL-025024	\$436.15	STL-OD139908	T25
US6-7-8	3.531 - 4.500	#5	22 3/8	10 3/4	16 1/2	5 7/8	7/16	STL-025025	\$500.00	STL-OD139908	T25

Extra Long Series

Insert Series	Drill Range D	MT	L	L1	L2	L3	B	Part Number	Price Each	Insert Screw	Screw Driver
US1	0.703 - 0.856	#3	17 3/4	10 5/8	14 1/16	3 11/16	5/32	STL-025026	\$179.30	STL-OD139904	T9
		#3	17 3/4	10 5/8	14 1/16	3 11/16	5/32	STL-025027	\$192.50	STL-OD139905	T9
US2	0.968 - 1.186	#3	18 1/4	11 3/8	14 9/16	3 11/16	3/16	STL-025028	\$198.00	STL-OD139906	T15
		#3	18 31/64	11 3/8	14 51/64	3 11/16	3/16	STL-025029	\$209.00	STL-OD139906	T15

*Denotes Non-Stock Item. Please Allow 6-8 Weeks For Delivery.

See Pages 171 & 178 For Morse Taper Holders!

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2004-05 Product Catalog

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Soft, Round & Hard Jaws

5C, 16C, CHICK Collet Chucks

Retention Knobs ER, DA, TG Collets

Drill Chucks Tapping Equip

Shell Mills Carbide Inserts

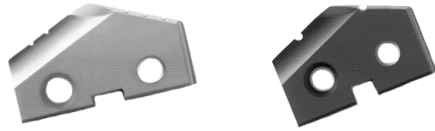
Mills & Lathes Bandsaws

Reamers Carbide Saws

Flat Stock/Drill Rod Measuring Tools

SPADE DRILL INSERTS

UNIVERSAL SPADE DRILL INSERTS
 Insert Series US0, US1, US2 & US3



Grade Information

<p>DGZ Grade: PVD coated grade. The first choice for high performance machining of:</p> <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • High Temp alloys • Aluminum alloys <p>For stable conditions at higher cutting speeds.</p>	<p>SP9530 Grade: PVD coated grade. The first choice for general purpose holemaking:</p> <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • Aluminum alloys <p>For unstable or difficult conditions at lower cutting speeds.</p>
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US0 Series Inserts			SP9530 \$21.26 ea.	DGZ \$25.73 ea
Inch	mm	Thick-ness	Part Number	Part Number
-	13.00	1/8	STL-027479	STL-024212
33/64	13.10		STL-027480	STL-024439
17/32	13.90		STL-027481	STL-024440
-	13.90		STL-027482	STL-024441
-	14.00		STL-027483	STL-024432
9/16	14.29		STL-027484	STL-024433
-	14.50		STL-027485	STL-024434
37/64	14.68		STL-027486	STL-024435
-	15.00		STL-027487	STL-024436
19/32	15.08		STL-027488	STL-024437
39/64	15.50	STL-027489	STL-024438	
5/8	15.88	STL-027490	STL-024211	
41/64	16.27	STL-027492	STL-024442	
-	16.50	STL-027493	STL-024214	
21/32	16.67	STL-027494	STL-024215	
43/64	17.06	STL-027496	STL-024443	
11/16	17.46	STL-027497	STL-024217	
-	17.50	-	STL-025375	

US1 Series Inserts			SP9530 \$23.89 ea	DGZ \$28.91 ea
Inch	mm	Thick-ness	Part Number	Part Number
45/64	17.86	5/32	STL-027498	STL-024218
-	18.00		STL-027499	STL-024219
23/32	18.26		STL-027500	STL-024220
-	18.50		STL-027501	STL-024221
47/64	18.65		STL-027502	STL-024222
-	19.00		STL-027503	STL-024223
3/4	19.05		STL-027504	STL-024224
-	19.50		STL-027505	STL-024225
25/32	19.84		STL-027506	STL-024226
51/64	20.24		STL-027508	STL-024444
-	20.50	STL-027509	STL-024228	
13/16	20.64	STL-027510	STL-024229	
53/64	21.03	STL-027512	STL-024445	
55/64	21.83	STL-027514	STL-024446	
-	22.00	STL-027515	STL-024232	
7/8	22.23	STL-027516	STL-024233	
57/64	22.62	STL-027517	STL-024447	
29/32	23.02	STL-027519	STL-024235	
59/64	23.42	STL-027520	STL-024236	
15/16	23.81	STL-027521	STL-024237	
-	24.00	STL-027522	STL-024238	

US2 Series Inserts			SP9530 \$28.09 ea	DGZ \$33.99 ea
Inch	mm	Thick-ness	Part Number	Part Number
31/32	24.61	3/16	STL-027523	STL-024239
63/64	25.00		STL-027524	STL-024240
1	25.40		STL-027525	STL-024241
1-1/64	25.80		STL-027526	STL-024242
-	26.00		STL-027527	STL-024243
1-1/32	26.19		STL-027528	STL-024244
1-1/16	26.99		STL-027529	STL-024245
-	27.00		-	STL-024246
1-3/32	27.78		STL-027530	STL-024247
-	28.00		STL-027531	STL-024248
1-1/8	28.58		STL-027532	STL-024249
-	29.00		STL-027535	STL-024250
1-5/32	29.37		STL-027534	STL-024251
-	30.00		-	STL-025377
1-3/16	30.16		STL-027536	STL-024252
1-7/32	30.96		STL-027537	STL-024253
-	31.00		STL-027538	STL-024254
1-1/4	31.75		STL-027539	STL-024255
-	32.00		STL-027540	STL-024256
1-9/32	32.54		STL-027541	STL-024257
-	33.00	STL-027542	STL-024258	
1-5/16	33.34	STL-027543	STL-024259	
-	34.00	STL-027544	STL-024260	
1-11/32	34.13	STL-027545	STL-024261	
1-3/8	34.93	STL-027546	STL-024262	
-	35.00	-	STL-025378	

US3 Series Inserts			SP9530 \$35.70 ea	DGZ \$40.45 ea
Inch	mm	Thick-ness	Part Number	Part Number
1-13/32	35.72	1/4	STL-027548	STL-024263
-	36.00		STL-027549	STL-024264
1-7/16	36.51		STL-027550	STL-024265
-	37.00		STL-027551	STL-024266
1-15/32	37.31		STL-027552	STL-024267
-	38.00		STL-027553	STL-024268
1-1/2	38.10		STL-027554	STL-024269
1-17/32	38.89		STL-027555	STL-024270
-	39.00		STL-027556	STL-024271
1-9/16	39.69		STL-027557	STL-024272
-	40.00		STL-027558	STL-024273
1/19/32	40.48		STL-027559	STL-024274
-	41.00		STL-027560	STL-024275
1-5/8	41.28		STL-027561	STL-024276
-	42.00		STL-027562	STL-024277
1-21/32	42.07		STL-027563	STL-024278
1-11/16	42.86		STL-027564	STL-024279
-	43.00		STL-027565	STL-024280
1-23/32	43.66		STL-027566	STL-024281
-	44.00		STL-027567	STL-024282
1/3/2004	44.45	STL-027568	STL-024283	
-	45.00	STL-027569	STL-024284	
1-25/32	45.24	STL-027570	STL-024285	
-	46.00	STL-027571	STL-024286	
1-13/16	46.04	STL-027572	STL-024287	
1-27/32	46.83	STL-027573	STL-024288	
-	47.00	STL-027574	STL-024289	
1-7/8	47.63	STL-027575	STL-024290	

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Jaw Nuts

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KURT Vises

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ER, DA, TG Collets

Toolholders
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Turning/Boring

Endmills
Carbide & HSS

Milling Cutters
Drills & Taps

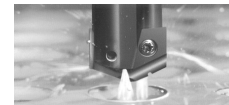
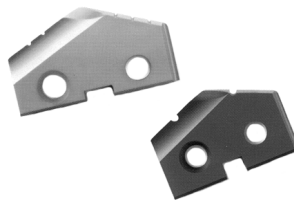
Air Tools
Deburring Tools

SPADE DRILL INSERTS

B

UNIVERSAL SPADE DRILL INSERTS

Insert Series US4, US5 & US6



Grade Information

DGZ Grade: PVD coated grade. The first choice for high performance machining of:

- Unalloyed steel
- Alloyed steel
- Tool steel
- Stainless steel
- High Temp alloys
- Aluminum alloys

For stable conditions at higher cutting speeds.

SP9530 Grade: PVD coated grade. The first choice for general purpose holmaking:

- Unalloyed steel
- Alloyed steel
- Tool steel
- Stainless steel
- Aluminum alloys

For unstable or difficult conditions at lower cutting speeds.

US4 Series Inserts			SP9530 \$45.15 ea	DGZ \$49.67 ea
Inch	mm	Thick-ness	Part Number	Part Number
-	48.00	5/16	-	STL-024291
1-29/32	48.42		STL-027577	STL-024292
-	49.00		STL-027578	STL-024293
1-15/16	49.21		STL-027579	STL-024294
-	50.00		STL-027580	STL-024295
1-31/32	50.01		STL-027581	STL-024296
2	50.80		STL-027582	STL-024297
-	51.00		STL-027583	STL-024298
2 19/32	51.59		STL-027584	STL-024299
2-3/64	52.00		STL-027585	STL-024300
2-1/16	52.39		STL-027586	STL-024301
-	53.00		STL-027587	STL-024302
2-3/32	53.18		STL-027588	STL-024303
2-1/8	53.98		STL-027589	STL-024304
-	54.00		STL-027590	STL-024305
2-5/32	54.79		STL-027591	STL-024306
-	55.00		STL-027592	STL-024307
2-3/16	55.56		STL-027593	STL-024308
-	56.00		STL-027594	STL-024309
2-7/32	56.36		STL-027595	STL-024310
-	57.00	STL-027596	STL-024311	
2-1/4	57.15	STL-027597	STL-024312	
2-9/32	57.94	STL-027598	STL-024313	
-	58.00	STL-027599	STL-024314	
2-5/16	58.74	STL-027600	STL-024315	
-	59.00	STL-027601	STL-024316	
2-11/32	59.53	STL-027602	STL-024317	
-	60.00	STL-027603	STL-024318	
2-3/8	60.33	STL-027604	STL-024319	
-	61.00	STL-027605	STL-024320	
2-13/32	61.12	STL-027606	STL-024321	
2-7/16	61.91	STL-027607	STL-024322	
-	62.00	STL-027608	STL-024323	
2-15/32	62.71	-	-	
-	63.00	STL-027610	STL-024325	
2-1/2	63.50	STL-027611	STL-024326	
-	64.00	STL-027612	STL-024327	
2-17/32	64.29	STL-027613	STL-024328	
-	65.00	STL-027614	STL-024329	
2-9/16	5.09	STL-027615	STL-024330	

US5 Series Inserts			SP9530 \$61.09 ea	DGZ \$70.56 ea
Inch	mm	Thick-ness	Part Number	Part Number
2-1/2	63.50	7/16	STL-027616	STL-024331
-	64.00		STL-027617	STL-024332
2-17/32	64.29		STL-027618	STL-024333
2-9/16	65.09		STL-027619	STL-024334
2-19/32	65.88		STL-027620	STL-024335
-	66.00		STL-027621	STL-024336
2-5/8	66.68		STL-027622	STL-024337
2-21/32	67.47		STL-027623	STL-024338
-	68.00		STL-027624	STL-024339
2-11/16	68.26		STL-027625	STL-024340
2-23/32	69.05		STL-027626	STL-024341
2-3/4	69.85		STL-027627	STL-024342
-	70.00		STL-027628	STL-024343
2-25/32	70.64		STL-027629	STL-024344
2-13/16	71.44		STL-027630	STL-024345
2-27/32	72.00		STL-027632	STL-024347
2-7/8	73.03		STL-027633	STL-024348
2-29/32	73.82		STL-027634	STL-024349
-	74.00		STL-027635	STL-024350
2-15/16	74.61		STL-027636	STL-024351
2-13/32	75.41	STL-027637	STL-024352	
-	76.00	STL-027638	STL-024353	
3	76.20	STL-027639	STL-024354	

US6 Series Inserts			SP9530 \$71.59 ea	DGZ \$82.69 ea
Inch	mm	Thick-ness	Part Number	Part Number
3-1/32	76.99	7/16	STL-027640	STL-024355
3-1/16	77.79		STL-027641	STL-024356
-	78.00		STL-027642	STL-024357
3-3/32	78.58		STL-027643	STL-024358
3-1/8	79.38		STL-027644	STL-024359
-	80.00		STL-027645	STL-024360
3-5/32	80.17		STL-027646	STL-024361
3-3/16	80.96		STL-027647	STL-024362
3-7/32	81.76		STL-027648	STL-024363
-	82.00		STL-027649	STL-024364
3-1/4	82.55		STL-027650	STL-024365
3-9/32	83.34		STL-027651	STL-024366
-	84.00		STL-027652	STL-024367
3-5/16	84.14		STL-027653	STL-024368
3-11/32	84.93		STL-027654	STL-024369
3-3/8	85.73		STL-027655	STL-024370
-	86.00		STL-027656	STL-024371
3-13/32	86.52		STL-027657	STL-024372
3-7/16	87.31		STL-027658	STL-024373
-	88.00		STL-027659	STL-024374
3-15/32	88.11	STL-027660	STL-024375	
3-1/2	88.90	STL-027661	STL-024376	

Soft, Round & Hard Jaws

5C, 16C, CHICK Collet Chucks

Retention Knobs ER, DA, TG Collets

Drill Chucks Tapping Equip

Shell Mills Carbide Inserts

Mills & Lathes Bandsaws

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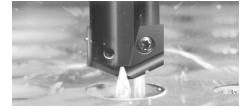
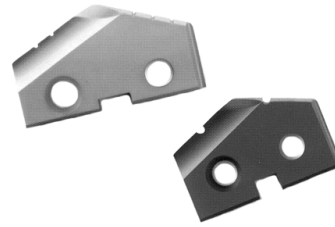
Air Tools
Deburring Tools

SPADE DRILL INSERTS

B

UNIVERSAL SPADE DRILL INSERTS

Insert Series US7, US8 & USY & USZ



US7 Series Inserts			SP9530 \$84.95 ea	DGZ \$93.45 ea
Inch	mm	Thick-ness	Part Number	Part Number
3-17/32	89.69	7/16	STL-027662	STL-024378
-	90.00		STL-027663	STL-024379
3-9/16	90.49		STL-027664	STL-024380
3-19/32	91.28		STL-027665	STL-024381
-	92.00		STL-027666	STL-024382
3-5/8	92.08		STL-027667	STL-024383
3-21/32	92.87		STL-027668	STL-024384
3-11/16	93.66		STL-027669	STL-024385
-	94.00		STL-027670	STL-024386
3-23/32	94.46		STL-027671	STL-024387
3-3/4	95.25		STL-027672	STL-024388
-	96.00		STL-027673	STL-024389
3-25/32	96.04		STL-027674	STL-024390
3-13/16	96.84		STL-027675	STL-024391
3-27/32	97.63		STL-027676	STL-024392
-	98.00		STL-027677	STL-024393
3-7/8	98.43		-	STL-024394
3-29/32	99.22		STL-027678	STL-024395
3-15/16	100.00		STL-027680	STL-024396
3-31/32	100.81		STL-027681	STL-024397
4	101.60	STL-027682	STL-024398	

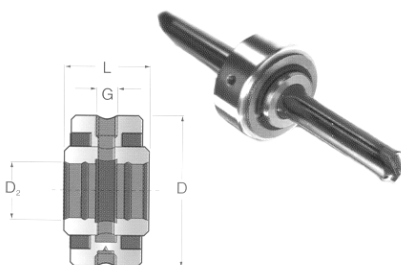
US8 Series Inserts			SP9530 \$97.36 ea	DGZ \$107.10 ea
Inch	mm	Thick-ness	Part Number	Part Number
4-1/64	102.00	7/16	STL-027683	STL-024399
4-1/16	103.19		STL-027684	STL-024400
4-3/32	104.00		STL-027685	STL-024401
4-1/8	104.78		STL-027686	STL-024402
-	106.00		STL-027687	STL-024403
4-3/16	106.36		STL-027688	STL-024404
4-1/4	107.95		STL-027689	STL-024405
4-5/16	109.54		STL-027690	STL-024406
-	110.00		STL-027691	STL-024407
4-3/8	111.13		STL-027692	STL-024408
-	112.00		STL-027693	STL-024409
4-7/16	112.71		STL-027694	STL-024410
-	114.00		STL-027695	STL-024411
4-1/2	114.30		STL-027696	STL-024412

Grade Information	
DGZ Grade: PVD coated grade. The first choice for high performance machining of: <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • High Temp alloys • Aluminum alloys For stable conditions at higher cutting speeds.	SP9530 Grade: PVD coated grade. The first choice for general purpose holemaking: <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • Aluminum alloys For unstable or difficult conditions at lower cutting speeds.

USY Series Inserts			SP9530 \$19.69 ea	DGZ \$24.91 ea
Inch	mm	Thick-ness	Part Number	Part Number
-	9.50	3/32	STL-027697	STL-024413
3/8	9.53		STL-027698	STL-024414
-	9.80		STL-027699	STL-024415
25/64	9.92		-	STL-025273
-	10.00		STL-027700	STL-024416
-	10.20		STL-027701	STL-024417
13/32	10.32		STL-027702	STL-024418
-	10.50		STL-027703	STL-024419
27/64	10.72		STL-027704	STL-024420
-	10.80		STL-027705	STL-024421
-	11.00		STL-027706	STL-024422

USZ Series Inserts			SP9530 \$19.69 ea	DGZ \$24.91 ea
Inch	mm	Thick-ness	Part Number	Part Number
7/16	11.11	3/32	STL-027707	STL-024423
-	11.50		STL-027708	STL-024424
29/64	11.51		STL-027709	STL-024425
15/32	11.91		STL-027710	STL-024426
-	2.00		STL-027711	STL-024427
31/64	12.30		STL-027712	STL-024428
-	12.50		STL-027713	STL-024429
1/2	12.70		STL-027714	STL-024430

ROTARY COOLANT RING



MT	D	L	D1	G	Part Number	Price Each
2	2.250	1.500	0.750	1/8	STL-P9010X002MT	\$45.70
3	2.375	1.500	1.000	1/8	STL-P9010X003MT	\$52.72
4	2.750	1.500	1.250	1/8	STL-P9010X004MT	\$54.88
5	4.000	2.000	2.000	3/8	STL-P9010X005MT	\$69.22

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SPADE DRILL CUTTING CONDITIONS

B



Grade Information	
<p>DGZ Grade: PVD coated grade. The first choice for high performance machining of:</p> <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • High Temp alloys • Aluminum alloys <p>For stable conditions at higher cutting speeds.</p>	<p>SP9530 Grade: PVD coated grade. The first choice for general purpose holmaking:</p> <ul style="list-style-type: none"> • Unalloyed steel • Alloyed steel • Tool steel • Stainless steel • Aluminum alloys <p>For unstable or difficult conditions at lower cutting speeds.</p>

Soft, Round & Hard Jaws

5C, 16C, CHICK Collet Chucks

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Drill Chucks Tapping Equip

Shell Mills Carbide Inserts

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Reamers Carbide Saws

Flat Stock/Drill Rod Measuring Tools

Grade DGZ		Cutting Speed (SFPM)		Feed per Revolution (Inch/Rev)					
Material		Min	Max	Ø0.394-0.630	0.669-0.866	0.905-0.984	1.000-1.378	1.417-2.559	2.625-4.500
Unalloyed Steel	<180 HBN	130	250	0.004-0.010	0.005-0.012	0.006-0.014	0.008-0.016	0.012-0.022	0.015-0.025
	180-280 HBN	120	230	0.004-0.009	0.005-0.011	0.006-0.012	0.008-0.015	0.012-0.020	0.015-0.022
Alloyed Steel	200-280 HBN	100	210	0.004-0.009	0.005-0.011	0.006-0.012	0.008-0.015	0.012-0.020	0.015-0.022
	280-355 HBN	80	150	0.003-0.008	0.004-0.010	0.005-0.011	0.007-0.014	0.010-0.018	0.012-0.020
Tool Steel	355-415 HBN	80	130	0.003-0.006	0.004-0.007	0.005-0.009	0.007-0.011	0.010-0.015	0.012-0.018
	>415 HBN	30	100	0.002-0.005	0.004-0.006	0.005-0.008	0.007-0.010	0.009-0.014	0.012-0.016
Stainless Steel	Martensitic	30	100	0.004-0.006	0.005-0.007	0.006-0.008	0.007-0.009	0.008-0.011	0.010-0.015
	Austenitic+Ferritic	30	100	0.004-0.006	0.005-0.007	0.006-0.008	0.007-0.009	0.008-0.011	0.010-0.015
Cast Iron	Refractory	15	80	0.002-0.004	0.004-0.005	0.005-0.007	0.006-0.008	0.007-0.010	0.010-0.015
	Gray	100	210	0.004-0.009	0.006-0.011	0.008-0.015	0.012-0.020	0.015-0.024	0.018-0.028
	Spheroidal	100	180	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
	Nodular	100	180	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
High Temperature Alloys	Malleable	100	180	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
	Iron Based	15	30	0.002-0.004	0.003-0.005	0.004-0.007	0.005-0.008	0.006-0.010	0.008-0.012
	Cobalt Based	15	30	0.002-0.004	0.003-0.005	0.004-0.007	0.005-0.008	0.006-0.010	0.008-0.012
	Nickel Based	15	30	0.002-0.004	0.003-0.005	0.004-0.007	0.005-0.008	0.006-0.010	0.008-0.012
Aluminum Alloys	Titanium Based	15	50	0.002-0.004	0.003-0.005	0.004-0.007	0.005-0.008	0.006-0.010	0.008-0.012
	Si<16%	300	1000	0.006-0.008	0.008-0.012	0.010-0.015	0.015-0.020	0.020-0.025	0.022-0.030
	Si>16%	300	800	0.006-0.007	0.008-0.011	0.010-0.014	0.014-0.018	0.018-0.024	0.020-0.028

Grade SP9530		Cutting Speed (SFPM)		Feed per Revolution (Inch/Rev)					
Material		Min	Max	Ø0.394-0.630	0.669-0.866	0.905-0.984	1.000-1.378	1.417-2.559	2.625-4.500
Unalloyed Steel	<180 HBN	130	200	0.004-0.010	0.005-0.012	0.006-0.014	0.008-0.016	0.012-0.022	0.015-0.025
	180-280 HBN	120	180	0.004-0.009	0.005-0.011	0.006-0.012	0.008-0.015	0.012-0.020	0.015-0.022
Alloyed Steel	200-280 HBN	100	130	0.004-0.009	0.005-0.011	0.006-0.012	0.008-0.015	0.012-0.020	0.015-0.022
	280-355 HBN	80	110	0.003-0.008	0.004-0.010	0.005-0.011	0.007-0.014	0.010-0.018	0.012-0.020
Tool Steel	355-415 HBN	70	100	0.003-0.006	0.004-0.007	0.005-0.009	0.007-0.011	0.010-0.015	0.012-0.018
	>415 HBN	-	-	-	-	-	-	-	-
Stainless Steel	Martensitic	30	70	0.004-0.006	0.005-0.007	0.006-0.008	0.007-0.009	0.008-0.011	0.010-0.015
	Austenitic+Ferritic	30	70	0.004-0.006	0.005-0.007	0.006-0.008	0.007-0.009	0.008-0.011	0.010-0.015
	Refractory	-	-	-	-	-	-	-	-
Cast Iron	Gray	100	150	0.004-0.009	0.006-0.011	0.008-0.015	0.012-0.020	0.015-0.024	0.018-0.028
	Spheroidal	100	130	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
	Nodular	100	130	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
	Malleable	100	130	0.004-0.008	0.006-0.010	0.008-0.012	0.012-0.015	0.015-0.020	0.018-0.024
High Temperature Alloys	Iron Based	-	-	-	-	-	-	-	-
	Cobalt Based	-	-	-	-	-	-	-	-
	Nickel Based	-	-	-	-	-	-	-	-
	Titanium Based	-	-	-	-	-	-	-	-
Aluminum alloys	Si<16%	300	600	0.006-0.008	0.008-0.012	0.010-0.015	0.015-0.020	0.020-0.025	0.022-0.030
	Si>16%	300	500	0.006-0.007	0.008-0.011	0.010-0.014	0.014-0.018	0.018-0.024	0.020-0.028

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