

# Merlin Tools Ltd



**Solid Carbide Application Tools**  
**Corner Rounding • Chamfering**  
**Countersinking • Spotting**  
**Engraving • Centering**

Manufactured in the USA  
Distributed in the UK

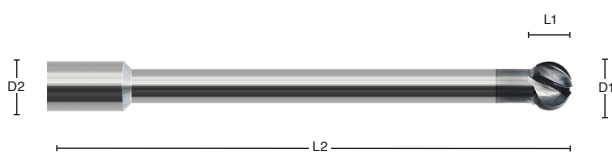


**NEW  
PRODUCT  
LINES**

# 220° Ball Nosed Lollipop Cutter

Series 722

**Ultra-High Performance Solid Carbide - TiAlN**  
**30° Right Hand Helix - Micro-grain K30 4-Flute 220° Ball Nosed**



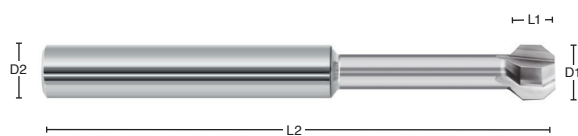
Tolerances: D1 +0.00/-0.051mm D2 h6

Cutter Dia-D1	Shank Dia-D2	FL L1	Neck Dia	Reach	OAL L2	Part Number
2	6	1.3	1.3	30	75	722-27302
2	6	1.3	1.3	36	75	722-27362
2	6	1.3	1.3	42	75	722-27422
3	6	2	2	30	75	722-27303
3	6	2	2	36	75	722-27363
3	6	2	2	42	75	722-27423
4	6	2.7	2.7	30	75	722-27304
4	6	2.7	2.7	36	75	722-27364
4	6	2.7	2.7	42	100	722-27424
6	6	4	4	28	75	722-27286
6	6	4	4	40	75	722-27406
6	6	4	4	44	75	722-27446
8	8	5.4	5.4	38	100	722-27388
8	8	5.4	5.4	54	100	722-27548
8	8	5.4	5.4	68	100	722-27688
10	10	6.7	6.7	48	100	722-24810
10	10	6.7	6.7	58	100	722-25810
10	10	6.7	6.7	68	100	722-26810
12	12	8	8	58	100	722-25812
12	12	8	8	68	100	722-26812
16	16	10.7	10.7	54	100	722-25416
16	16	10.7	10.7	68	100	722-26816

## Back Chamfering & Countersinking

Series 140

**Solid Carbide General Purpose - 90° Angle Staggered Teeth**  
**Micro-grain K30 4-Flute Back Chamfering & Countersinking Tool**

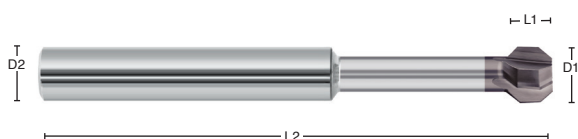


Tolerances: D1 +0.00/-0.051mm D2 h6

Cutter Dia-D1	OAL L2	FL L1	Neck Length	Neck Dia	Max Chamfer	Part Number
4	63	3	10	3	0.5	140-12507
6	63	4	15	4	1	140-12510
8	63	6	20	5	1.5	140-12512
10	100	8	25	6	2	140-12514
12	100	9	30	7	2.5	140-12516

Series 149

**Performance Solid Carbide - TiAlN - 90° Angle Staggered Teeth**  
**Micro-grain K30 4-Flute Back Chamfering & Countersinking Tool**



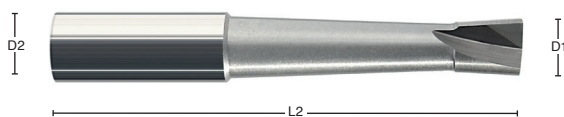
Tolerances: D1 +0.00/-0.051mm D2 h6

Cutter Dia-D1	OAL L2	FL L1	Neck Length	Neck Dia	Max Chamfer	Part Number
4	63	3	10	3	0.5	149-12507
6	63	4	15	4	1	149-12510
8	63	6	20	5	1.5	149-12512
10	100	8	25	6	2	149-12514
12	100	9	30	7	2.5	149-12516

## Boring Tool

Series 101

**Solid Carbide - Single Point**  
**Micro-grain K30 - Boring Tools**



Tolerances: D1+0.000"-0.002" D2 h6

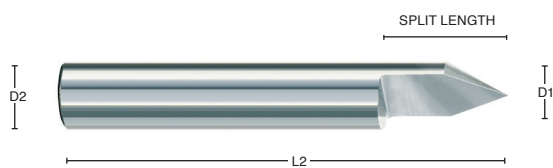
Minimum Hole Dia	Maximum Depth of Hole	Shank Dia-D2	OAL L2	Part Number
.090"	1/2"	1/8"	1-1/2"	101-0090
.120"	5/8"	1/8"	1-1/2"	101-0120
.150"	3/4"	3/16"	2"	101-0150
.180"	1"	3/16"	2"	101-0180
.210"	1-1/4"	1/4"	2"	101-0210
.240"	1-1/4"	1/4"	2"	101-0240
.270"	1-1/4"	5/16"	2-1/4"	101-0270
.300"	1-1/4"	5/16"	2-1/4"	101-0300
.330"	1-1/2"	3/8"	2-1/2"	101-0330
.360"	1-1/2"	3/8"	2-1/2"	101-0360



# Engraving Tools

Series 001

## Solid Carbide General Purpose 30°, 60°, 90° Inclusive - Micro-grain K30 Engraving Tool



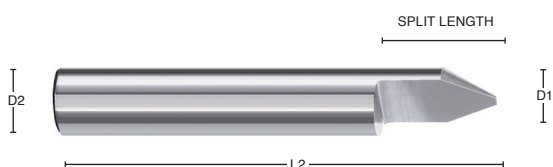
Tolerances: D1+0.00/-0.127mm +0.00/-0.005" D2 h6

Cutter Dia-D1	Shank Dia-D2	Included Angle	Split Length	OAL L2	Part Number
3	3	30°	8	38	001 -3305
6	6	30°	12	50	001 -6308
3	3	60°	8	38	001 -3605
6	6	60°	12	50	001 -6608
3	3	90°	8	38	001 -3905
6	6	90°	12	50	001 -6908
1/8"	1/8"	60°	3/8"	1-1/2"	001 -1860
1/4"	1/4"	60°	3/8"	2-1/2"	001 -1460

Cutter Dia-D1	Shank Dia-D2	Flat	Included Angle	Split Length	OAL L2	Part Number
6	6	0.25	60°	8	50	002 -6025
6	6	0.50	60°	8	50	002 -6050
6	6	0.75	60°	8	50	002 -6075
6	6	1.00	60°	8	50	002 -6010
6	6	1.25	60°	8	50	002 -6012
6	6	1.50	60°	8	50	002 -6015
6	6	2.00	60°	8	50	002 -6020

Series 002

## Solid Carbide General Purpose 60° Inclusive - Micro-grain K30 Engraving Tools with Flats



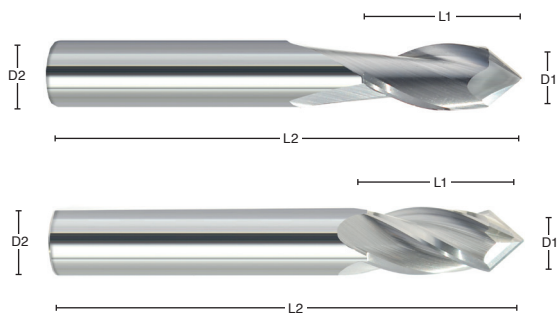
Tolerances: D1+0.00/-0.127mm D2 h6

Cutter Dia-D1	Shank Dia-D2	Flat	Included Angle	Split Length	OAL L2	Part Number
6	6	0.25	60°	8	50	002 -6025
6	6	0.50	60°	8	50	002 -6050
6	6	0.75	60°	8	50	002 -6075
6	6	1.00	60°	8	50	002 -6010
6	6	1.25	60°	8	50	002 -6012
6	6	1.50	60°	8	50	002 -6015
6	6	2.00	60°	8	50	002 -6020

# Drill Mills

Series 288 & 488

## Solid Carbide Multi Purpose 90° Included Angle Centre Cutting Micro-grain K30 - 2 Flute Drill Mills

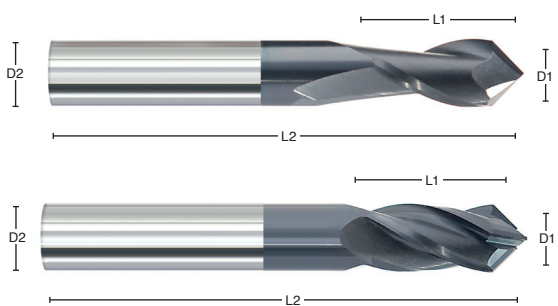


Tolerances: D1 +0.00/-0.051mm D2 h6

Cutter Dia-D1	FL L1	OAL L2	2 Flute Part Number	4 Flute Part Number
3	12	38	288 -12505	488 -14505
4	14	50	288 -12507	488 -14507
5	16	50	288 -12509	488 -14509
6	19	63	288 -12510	488 -14510
8	19	63	288 -12512	488 -14512
10	22	70	288 -12514	488 -14514
12	25	75	288 -12516	488 -14516
16	32	88	288 -12520	488 -14520
20	45	100	288 -12524	488 -14524

Series 289 & 489

## Performance Solid Carbide Multi Purpose - TiAlN 90° Included Angle Centre Cutting - Micro-grain K30 - 4 Flute Drill Mills



Tolerances: D1 +0.00/-0.051mm D2 h6

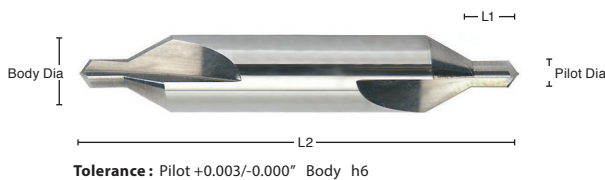
Cutter Dia-D1	FL L1	OAL L2	2 Flute Part Number	4 Flute Part Number
3	12	38	289 -12505	489 -14505
4	14	50	289 -12507	489 -14507
5	16	50	289 -12509	489 -14509
6	19	63	289 -12510	489 -14510
8	19	63	289 -12512	489 -14512
10	22	70	289 -12514	489 -14514
12	25	75	289 -12516	489 -14516
16	32	88	289 -12520	489 -14520
20	45	100	289 -12524	489 -14524



# Centre Drills

## Series 106

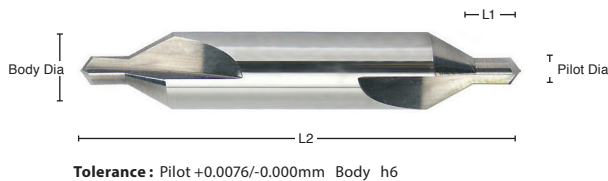
**Solid Carbide General Purpose - Bright Finish**  
**60° Included Point Angle - Micro-grain K30 - Centre Drills**



Pilot Dia	Body Dia	FL L1	OAL L2	Part Number	Tool BS
3/64"	1/8"	3/64"	1-1/4"	106-01608	1
5/64"	3/16"	5/64"	1-7/8"	106-01612	2
7/64"	1/4"	7/64"	2"	106-01616	3
1/8"	5/16"	1/8"	2-1/8"	106-01620	4
3/16"	7/16"	3/16"	2-3/4"	106-01628	5
7/32"	1/2"	7/32"	3"	106-01632	6

## Series 107

**Solid Carbide General Purpose - Bright Finish**  
**60° Included Point Angle - Micro-grain K30 - Centre Drills**

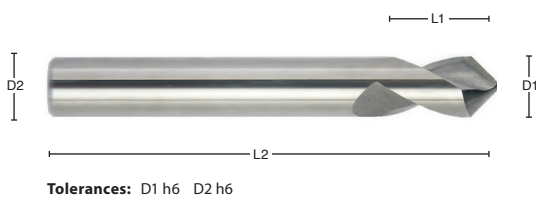


Pilot Dia	Body Dia	FL L1	OAL L2	Part Number
1.6	4	2.4	35.50	107-01708
2	5	2.9	40	107-01712
2.5	6.3	3.6	45	107-01716
3.15	8	5.6	50	107-01720
4	10	5.6	56	107-01728
5	12.5	6.9	63	107-01732

# Spotting Drills

## Series 109 & 110

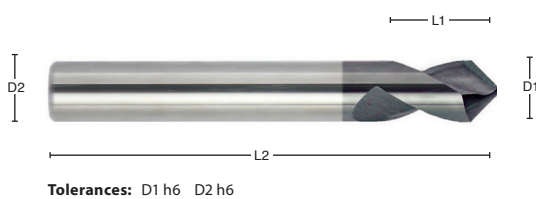
**Solid Carbide General Purpose**  
**90° & 120° Point - 30° Helix - Micro-grain K30 - NC Spotting Drills**



Cutter Dia-D1	Shank Dia-D2	Degree Point	FL L1	OAL L2	90° Part Number	120° Part Number
3	3	90	10	38	109-01903	110-01903
4	4	90	18	63	109-01904	110-01904
5	5	90	15	63	109-01905	110-01905
6	6	90	20	63	109-01906	110-01906
8	8	90	20	63	109-01908	110-01908
10	10	90	25	75	109-01910	110-01910
12	12	90	25	75	109-01912	110-01912
14	14	90	26	88	109-01914	110-01914
16	16	90	28	100	109-01916	110-01916
20	20	90	30	102	109-01920	110-01920

## Series 199 & 119

**Performance Solid Carbide - TiAlN**  
**90° & 120° Point - 30° Helix - Micro-grain K30 - NC Spotting Drills**

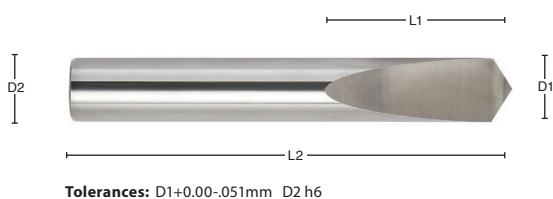


Cutter Dia-D1	Shank Dia-D2	Degree Point	FL L1	OAL L2	90° Part Number	120° Part Number
3	3	90	10	38	199-01903	119-01903
4	4	90	18	63	199-01904	119-01904
5	5	90	15	63	199-01905	119-01905
6	6	90	20	63	199-01906	119-01906
8	8	90	20	63	199-01908	119-01908
10	10	90	25	75	199-01910	119-01910
12	12	90	25	75	199-01912	119-01912
14	14	90	26	88	199-01914	119-01914
16	16	90	28	100	199-01916	119-01916
20	20	90	30	102	199-01920	119-01920

# Spade Drills

## Series 111

**Solid Carbide General Purpose**  
**118° Point - Micro-grain K30 - Spade Drill**



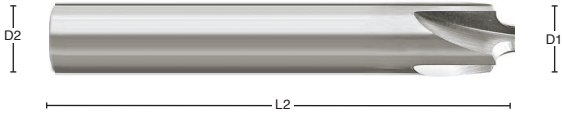
Cutter Dia - D1	Shank Dia-D2	FL L1	OAL L2	Part Number
3	3	12	38	111-33305
4	4	17	50	111-33307
6	6	20	50	111-33310
8	8	22	63	111-33312
10	10	28	63	111-33314
12	12	32	75	111-33316



# Corner Rounding Range

Series 112

## Solid Carbide General Purpose 90° Radius Plus Run Out - Micro-grain K30 4 Flute Corner Rounding

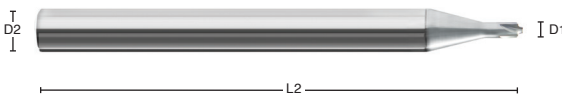


Tolerances: D1 +0.00/-0.051mm D2 h6

Radius	OAL L2	Shank Dia-D2	Part Number
0.5	64	8	112 -41105
1.0	64	8	112 -41110
1.5	70	10	112 -41115
2.0	70	10	112 -41120
2.5	76	12	112 -41125
3.0	76	12	112 -41130
3.5	89	16	112 -41135
4.0	89	16	112 -41140
4.5	89	16	112 -41145
5.0	89	16	112 -41150
5.5	100	20	112 -41155
6.0	100	20	112 -41160

Series 112M

## Solid Carbide General Purpose 90° Radius Plus Run Out - Micro-grain K30 4-Flute Miniature Corner Rounding

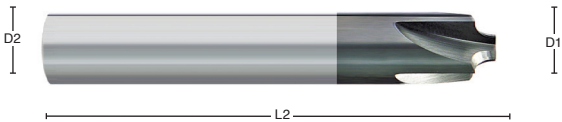


Tolerances: D1 +0.00/-0.051mm D2 h6

Radius	OAL L2	Shank Dia-D2	Part Number
0.2	38	3	112 -M4102
0.25	38	3	112 -M4125
0.3	38	3	112 -M4103
0.4	38	3	112 -M4104
0.5	38	3	112 -M4105
0.6	38	3	112 -M4106
0.7	38	3	112 -M4107
0.75	38	3	112 -M4175
0.8	38	3	112 -M4108
0.9	38	3	112 -M4109
1	38	3	112 -M4110

Series 122

## Performance Solid Carbide -TiALN 90° Radius Plus Run Out - Micro-grain K30 4-Flute Corner Rounding

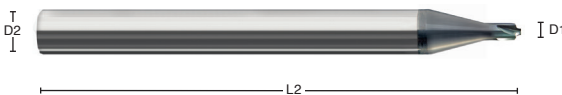


Tolerances: D1 +0.00/-0.051mm D2 h6

Radius	OAL L2	Shank Dia-D2	Part Number
0.5	64	8	122 -41105
1.0	64	8	122 -41110
1.5	70	10	122 -41115
2.0	70	10	122 -41120
2.5	76	12	122 -41125
3.0	76	12	122 -41130
3.5	89	16	122 -41135
4.0	89	16	122 -41140
4.5	89	16	122 -41145
5.0	89	16	122 -41150
5.5	100	20	122 -41155
6.0	100	20	122 -41160

Series 122M

## Performance Solid Carbide -TiALN 90° Radius Plus Run Out - Micro-grain K30 4-Flute Miniature Corner Rounding



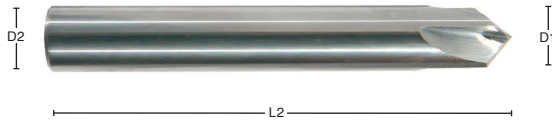
Tolerances: D1 +0.00/-0.051mm D2 h6

Radius	OAL L2	Shank Dia-D2	Part Number
0.2	38	3	122 -M4102
0.25	38	3	122 -M4125
0.3	38	3	122 -M4103
0.4	38	3	122 -M4104
0.5	38	3	122 -M4105
0.6	38	3	122 -M4106
0.7	38	3	122 -M4107
0.75	38	3	122 -M4175
0.8	38	3	122 -M4108
0.9	38	3	122 -M4109
1	38	3	122 -M4110

# Countersinking & Chamfer Range

## Series 113

### Solid Carbide General Purpose \_ Bright Finish 60° 82° 90° Angle Chamfer Tool - Micro-grain K30 4-Flute

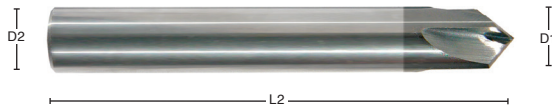


Tolerances: D1+0.00-.051mm D2 h6

Cutter Dia-D1	Shank Dia-D2	OAL L2	Angle	Part Number	Cutter Dia-D1	Shank Dia-D2	OAL L2	Angle	Part Number
4	4	50	60°	113 -42260	8	8	64	60°	113 -82260
4	4	50	82°	113 -42282	8	8	64	82°	113 -82282
4	4	50	90°	113 -42290	8	8	64	90°	113 -82290
5	5	50	60°	113 -52260	10	10	70	60°	113 -10260
5	5	50	82°	113 -52282	10	10	70	82°	113 -10282
5	5	50	90°	113 -52290	10	10	70	90°	113 -10290
6	6	64	60°	113 -62260	12	12	76	60°	113 -12260
6	6	64	82°	113 -62282	12	12	76	82°	113 -12282
6	6	64	90°	113 -62290	12	12	76	90°	113 -12290

## Series 114

### Performance Solid Carbide - TiALN 60° 82° 90° Angle Chamfer Tool - Micro-grain K30 4-Flute

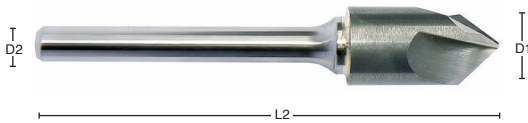


Tolerances: D1+0.00-.051mm D2 h6

Cutter Dia-D1	Shank Dia-D2	OAL L2	Angle	Part Number	Cutter Dia-D1	Shank Dia-D2	OAL L2	Angle	Part Number
4	4	50	60°	114 -42260	8	8	64	60°	114 -82260
4	4	50	82°	114 -42282	8	8	64	82°	114 -82282
4	4	50	90°	114 -42290	8	8	64	90°	114 -82290
5	5	50	60°	114 -52260	10	10	70	60°	114 -10260
5	5	50	82°	114 -52282	10	10	70	82°	114 -10282
5	5	50	90°	114 -52290	10	10	70	90°	114 -10290
6	6	64	60°	114 -62260	12	12	76	60°	114 -12260
6	6	64	82°	114 -62282	12	12	76	82°	114 -12282
6	6	64	90°	114 -62290	12	12	76	90°	114 -12290

## Series C

### Solid Carbide General Purpose - Countersinks 60° 82° 90° Included Point Angle - Micro-grain K30 1, 3, 6-Flute



Cutter Dia-D1	Shank Dia-D2	OAL L2	No. Of Flutes	Point Angle	Part Number	Cutter Dia-D1	Shank Dia-D2	OAL L2	No. Of Flutes	Point Angle	Part Number
3	3	38	1	60°	C-018160	12.7	6	72	1	60°	C-012160
3	3	38	1	82°	C-018182	12.7	6	72	1	82°	C-012182
3	3	38	1	90°	C-018190	12.7	6	72	1	90°	C-012190
3	3	38	3	60°	C-018360	12.7	6	72	3	60°	C-012360
3	3	38	3	82°	C-018382	12.7	6	72	3	82°	C-012382
3	3	38	3	90°	C-018390	12.7	6	72	3	90°	C-012392
3	3	38	6	60°	C-018660	12.7	6	72	6	60°	C-012660
3	3	38	6	82°	C-018682	12.7	6	72	6	82°	C-012682
3	3	38	6	90°	C-018690	12.7	6	72	6	90°	C-012690
5	5	50	1	60°	C-316160	16	8	75	1	60°	C-058160
5	5	50	1	82°	C-316182	16	8	75	1	82°	C-058182
5	5	50	1	90°	C-316190	16	8	75	1	90°	C-058190
5	5	50	3	60°	C-316360	16	8	75	3	60°	C-058360
5	5	50	3	82°	C-316382	16	8	75	3	82°	C-058382
5	5	50	3	90°	C-316390	16	8	75	3	90°	C-058390
5	5	50	6	60°	C-316660	16	8	75	6	60°	C-058660
5	5	50	6	82°	C-316682	16	8	75	6	82°	C-058682
5	5	50	6	90°	C-316690	16	8	75	6	90°	C-058690
6	6	50	1	60°	C-014160	19	8	75	1	60°	C-034160
6	6	50	1	82°	C-014182	19	8	75	1	82°	C-034182
6	6	50	1	90°	C-014190	19	8	75	1	90°	C-034190
6	6	50	3	60°	C-014360	19	8	75	3	60°	C-034360
6	6	50	3	82°	C-014382	19	8	75	3	82°	C-034382
6	6	50	3	90°	C-014390	19	8	75	3	90°	C-034390
6	6	50	6	60°	C-014660	19	8	75	6	60°	C-034660
6	6	50	6	82°	C-014682	19	8	75	6	82°	C-034682
6	6	50	6	90°	C-014690	19	8	75	6	90°	C-034690
9.5	6	66	1	60°	C-038160	25	8	83	1	60°	C-001160
9.5	6	66	1	82°	C-038182	25	8	83	1	82°	C-001182
9.5	6	66	1	90°	C-038190	25	8	83	1	90°	C-001190
9.5	6	66	3	60°	C-038360	25	8	83	3	60°	C-001360
9.5	6	66	3	82°	C-038382	25	8	83	3	82°	C-001382
9.5	6	66	3	90°	C-038390	25	8	83	3	90°	C-001390
9.5	6	66	6	60°	C-038660	25	8	83	6	60°	C-001660
9.5	6	66	6	82°	C-038682	25	8	83	6	82°	C-001682
9.5	6	66	6	90°	C-038690	25	8	83	6	90°	C-001690



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