Merlin Tools Ltd

Solid Carbide
3xD 5xD 8xD
Ultra High Performance
Carbide Drills and
Thread Mills

Manufactured in the USA
Distributed in the UK

ISO 9001:2008

NEW PRODUCT LINES

3xD Ultra High Performance Drills

Ultra High Performance Solid Carbide Drills - *TiALN* - DIN 6537
3xD - solid or with coolant 140º Point Angle - 30º Helix - Micro-Grain K30

Tolerance Shank h7
Tolerance Cutting m7

SOLID
Without through holes

COOLANT
With through holes

DRILL DIA	FL	OAL	SHANK DIA	PART № SOLID	PART № COOLANT
3	20	62	6	123 -XD300	133-XD300
3.1	20	62	6	123 -XD310	133-XD310
3.2	20	62	6	123 -XD320	133-XD320
3.3	20	62	6	123 -XD330	133-XD330
3.4	20	62	6	123 -XD340	133-XD340
3.5	20	62	6	123 -XD350	133-XD350
3.6	20	62	6	123 -XD360	133-XD360
3.7	20	62	6	123 -XD370	133-XD370
3.8	24	66	6	123 -XD380	133-XD380
3.9	24	66	6	123 -XD390	133-XD390
4	24	66	6	123 -XD400	133-XD400
4.1	24	66	6	123 -XD410	133-XD410
4.2	24	66	6	123 -XD420	133-XD420
4.3	24	66	6	123 -XD430	133-XD430
4.4	24	66	6	123 -XD440	133-XD440
4.5	24	66	6	123 -XD450	133-XD450
4.6	24	66	6	123 -XD460	133-XD460
4.7	24	66	6	123 -XD470	133-XD470
4.8	28	66	6	123 -XD480	133-XD480
4.9	28	66	6	123 -XD490	133-XD490
5	28	66	6	123 -XD500	133-XD500
5.1	28	66	6	123 -XD510	133-XD510
5.2	28	66	6	123 -XD520	133-XD520
5.3	28	66	6	123 -XD530	133-XD530
5.4	28	66	6	123 -XD540	133-XD540
5.5	28	66	6	123 -XD550	133-XD550
5.6	28	66	6	123 -XD560	133-XD560
5.7	28	66	6	123 -XD570	133-XD570
5.8	28	66	6	123 -XD580	133-XD580
5.9	28	66	6	123 -XD590	133-XD590
6	28	66	6	123 -XD600	133-XD600
6.1	34	79	8	123 -XD610	133-XD610
6.2	34	79	8	123 -XD620	133-XD620
6.3	34	79	8	123 -XD630	133-XD630
6.4	34	79	8	123 -XD640	133-XD640
6.5	34	79	8	123 -XD650	133-XD650
6.6	34	79	8	123 -XD660	133-XD660
6.7	34	79	8	123 -XD670	133-XD670
6.8	34	79	8	123 -XD680	133-XD680
6.9	34	79	8	123 -XD690	133-XD690
7	34	79	8	123 -XD700	133-XD700
7.1	41	79	8	123 -XD710	133-XD710
7.2	41	79	8	123 -XD720	133-XD720
7.3	41	79	8	123 -XD730	133-XD730
7.4	41	79	8	123 -XD740	133-XD740
7.5	41	79	8	123 -XD750	133-XD750
7.6	41	79	8	123 -XD760	133-XD760
7.7	41	79	8	123 -XD770	133-XD770
7.8	41	79	8	123 -XD780	133-XD780
7.9	41	79	8	123 -XD790	133-XD790
8	41	79	8	123 -XD800	133-XD800
8.1	47	89	10	123 -XD810	133-XD810
8.2	47	89	10	123 -XD820	133-XD820
8.3	47	89	10	123 -XD830	133-XD830

DRILL DIA	FL	OAL	SHANK DIA	PART № SOLID	PART № COOLANT
8.4	47	89	10	123 -XD840	133 -XD840
8.5	47	89	10	123 -XD850	133 -XD850
8.6	47	89	10	123 -XD860	133 -XD860
8.7	47	89	10	123 -XD870	133 -XD870
8.8	47	89	10	123 -XD880	133 -XD880
8.9	47	89	10	123 -XD890	133 -XD890
9	47	89	10	123 -XD900	133 -XD900
9.1	47	89	10	123 -XD910	133 -XD910
9.2	47	89	10	123 -XD920	133 -XD920
9.3	47	89	10	123 -XD930	133 -XD930
9.4	47	89	10	123 -XD940	133 -XD940
9.5	47	89	10	123 -XD950	133 -XD950
9.6	47	89	10	123 -XD960	133 -XD960
9.7	47	89	10	123 -XD970	133 -XD970
9.8	47	89	10	123 -XD980	133 -XD980
9.9	47	89	10	123 -XD990	133 -XD990
10	47	89	10	123 -XD100	133 -XD100
10.1	55	102	12	123 -XD101	133 -XD101
10.2	55	102	12	123 -XD102	133 -XD102
10.3	55	102	12	123 -XD103	133 -XD103
10.4	55	102	12	123 -XD104	133 -XD104
10.5	55	102	12	123 -XD105	133 -XD105
10.6	55	102	12	123 -XD106	133 -XD106
10.7	55	102	12	123 -XD107	133 -XD107
10.8	55	102	12	123 -XD108	133 -XD108
10.9	55	102	12	123 -XD109	133 -XD109
11	55	102	12	123 -XD110	133 -XD110
11.1	55	102	12	123 -XD111	133 -XD111
11.2	55	102	12	123 -XD112	133 -XD112
11.3	55	102	12	123 -XD113	133 -XD113
11.4	55	102	12	123 -XD114	133 -XD114
11.5	55	102	12	123- XD115	133- XD115
11.6	55	102	12	123 -XD116	133 -XD116
11.7	55	102	12	123 -XD117	133 -XD117
11.8	55	102	12	123 -XD118	133 -XD118
11.9	55	102	12	123 -XD119	133 -XD119
12	55	102	12	123 -XD120	133 -XD120
12.5	60	107	14	123 -XD125	133 -XD125
13	60	107	14	123 -XD130	133 -XD130
13.5	60	107	14	123 -XD135	133 -XD135
14	60	107	14	123 -XD140	133 -XD140
14.5	65	115	16	123 -XD145	133 -XD145
15	65	115	16	123 -XD150	133 -XD150
15.5	65	115	16	123 -XD155	133 -XD155
16	65	115	16	123 -XD160	133 -XD160
16.5	73	123	18	123 -XD165	133 -XD165
17	73	123	18	123 -XD170	133 -XD170
17.5	73	123	18	123 -XD175	133 -XD175
18	73	123	18	123 -XD180	133 -XD180
18.5	79	131	20	123 -XD185	133 -XD185
19	79	131	20	123 -XD190	133 -XD190
19.5	79	131	20	123 -XD195	133 -XD195
20	79	131	20	123 -XD200	133 -XD200

Ex Stock Delivery on All Tools

Extremely Competitive Pricing

Merlin Tools Ltd

Quality
Precision
Performance

Tel: 01509 610300 • Fax: 01509 610400 • Email: sales@merlintools.ltd.uk • www.merlintools.ltd.uk

5xD Ultra High Performance Drills

Ultra High Performance Solid Carbide Drills - *TiALN* - DIN 6537
5xD solid or with coolant - 140º Point Angle - 30º Helix - Micro-Grain K30

Tolerance Shank h7
Tolerance Cutting m7

SOLID
Without through holes

COOLANT
With through holes

DRILL DIA	FL	OAL	SHANK DIA	PART № SOLID	PART № COOLANT
3	28	66	6	125 -XD300	135 -XD300
3.1	28	66	6	125 -XD310	135 -XD310
3.2	28	66	6	125 -XD320	135 -XD320
3.3	28	66	6	125 -XD330	135 -XD330
3.4	28	66	6	125 -XD340	135 -XD340
3.5	28	66	6	125 -XD350	135 -XD350
3.6	28	66	6	125 -XD360	135 -XD360
3.7	28	66	6	125 -XD370	135 -XD370
3.8	36	74	6	125 -XD380	135 -XD380
3.9	36	74	6	125 -XD390	135 -XD390
4	36	74	6	125 -XD400	135 -XD400
4.1	36	74	6	125 -XD410	135 -XD410
4.2	36	74	6	125 -XD420	135 -XD420
4.3	36	74	6	125 -XD430	135 -XD430
4.4	36	74	6	125 -XD440	135 -XD440
4.5	36	74	6	125 -XD450	135 -XD450
4.6	36	74	6	125 -XD460	135 -XD460
4.7	44	82	6	125 -XD470	135 -XD470
4.8	44	82	6	125 -XD480	135 -XD480
4.9	44	82	6	125 -XD490	135 -XD490
5	44	82	6	125 -XD500	135 -XD500
5.1	44	82	6	125 -XD510	135 -XD510
5.2	44	82	6	125 -XD520	135 -XD520
5.3	44	82	6	125 -XD530	135 -XD530
5.4	44	82	6	125 -XD540	135 -XD540
5.5	44	82	6	125 -XD550	135 -XD550
5.6	44	82	6	125 -XD560	135 -XD560
5.7	44	82	6	125 -XD570	135 -XD570
5.8	44	82	6	125 -XD580	135 -XD580
5.9	44	82	6	125 -XD590	135 -XD590
6	44	82	6	125 -XD600	135 -XD600
6.1	53	91	8	125 -XD610	135 -XD610
6.2	53	91	8	125 -XD620	135 -XD620
6.3	53	91	8	125 -XD630	135 -XD630
6.4	53	91	8	125 -XD640	135 -XD640
6.5	53	91	8	125 -XD650	135 -XD650
6.6	53	91	8	125 -XD660	135 -XD660
6.7	53	91	8	125 -XD670	135 -XD670
6.8	53	91	8	125 -XD680	135 -XD680
6.9	53	91	8	125 -XD690	135 -XD690
7	53	91	8	125 -XD700	135 -XD700
7.1	53	91	8	125 -XD710	135 -XD710
7.2	53	91	8	125 -XD720	135 -XD720
7.3	53	91	8	125 -XD730	135 -XD730
7.4	53	91	8	125 -XD740	135 -XD740
7.5	53	91	8	125 -XD750	135 -XD750
7.6	53	91	8	125 -XD760	135 -XD760
7.7	53	91	8	125 -XD770	135 -XD770
7.8	53	91	8	125 -XD780	135 -XD780
7.9	53	91	8	125 -XD790	135 -XD790
8	53	91	8	125 -XD800	135 -XD800
8.1	61	103	10	125 -XD810	135 -XD810
8.2	61	103	10	125 -XD820	135 -XD820
8.3	61	103	10	125 -XD830	135 -XD830

DRILL DIA	FL	OAL	SHANK DIA	PART № SOLID	PART № COOLANT
8.4	61	103	10	125 -XD840	135 -XD840
8.5	61	103	10	125 -XD850	135 -XD850
8.6	61	103	10	125 -XD860	135 -XD860
8.7	61	103	10	125 -XD870	135 -XD870
8.8	61	103	10	125 -XD880	135 -XD880
8.9	61	103	10	125 -XD890	135 -XD890
9	61	103	10	125 -XD900	135 -XD900
9.1	61	103	10	125 -XD910	135 -XD910
9.2	61	103	10	125 -XD920	135 -XD920
9.3	61	103	10	125 -XD930	135 -XD930
9.4	61	103	10	125 -XD940	135 -XD940
9.5	61	103	10	125 -XD950	135 -XD950
9.6	61	103	10	125 -XD960	135 -XD960
9.7	61	103	10	125 -XD970	135 -XD970
9.8	61	103	10	125 -XD980	135 -XD980
9.9	61	103	10	125 -XD990	135 -XD990
10	61	103	10	125 -XD100	135 -XD100
10.1	71	118	12	125 -XD101	135 -XD101
10.2	71	118	12	125 -XD102	135 -XD102
10.3	71	118	12	125 -XD103	135 -XD103
10.4	71	118	12	125 -XD104	135 -XD104
10.5	71	118	12	125 -XD105	135 -XD105
10.6	71	118	12	125 -XD106	135 -XD106
10.7	71	118	12	125 -XD107	135 -XD107
10.8	71	118	12	125 -XD108	135 -XD108
10.9	71	118	12	125 -XD109	135 -XD109
11	71	118	12	125 -XD110	135 -XD110
11.1	71	118	12	125 -XD111	135 -XD111
11.2	71	118	12	125 -XD112	135 -XD112
11.3	71	118	12	125 -XD113	135 -XD113
11.4	71	118	12	125 -XD114	135 -XD114
11.5	71	118	12	125- XD115	135- XD115
11.6	71	118	12	125 -XD116	135 -XD116
11.7	71	118	12	125 -XD117	135 -XD117
11.8	71	118	12	125 -XD118	135 -XD118
11.9	71	118	12	125 -XD119	135 -XD119
12	71	118	12	125 -XD120	135 -XD120
12.5	77	124	14	125 -XD125	135 -XD125
13	77	124	14	125 -XD130	135 -XD130
13.5	77	124	14	125 -XD135	135 -XD135
14	77	124	14	125 -XD140	135 -XD140
14.5	83	133	16	125 -XD145	135 -XD145
15	83	133	16	125 -XD150	135 -XD150
15.5	83	133	16	125 -XD155	135 -XD155
16	83	133	16	125 -XD160	135 -XD160
16.5	93	143	18	125 -XD165	135 -XD165
17	93	143	18	125 -XD170	135 -XD170
17.5	93	143	18	125 -XD175	135 -XD175
18	93	143	18	125 -XD180	135 -XD180
18.5	101	153	20	125 -XD185	135 -XD185
19	101	153	20	125 -XD190	135 -XD190
19.5	101	153	20	125 -XD195	135 -XD195
20	101	153	20	125 -XD200	135 -XD200

Ex Stock Delivery on All Tools

Extremely Competitive Pricing

Merlin Tools Ltd

Quality
Precision
Performance

Tel: 01509 610300 • Fax: 01509 610400 • Email: sales@merlintools.ltd.uk • www.merlintools.ltd.uk

8xD Ultra High Performance Drills

Ultra High Performance Solid Carbide Drills - *TiALN* - DIN 6537
8xD with coolant only - 140º Point Angle - 30º Helix - Micro-Grain K30

Tolerance Shank h7
Tolerance Cutting m7

COOLANT
With through holes

DRILL DIA	FL	OAL	SHANK DIA	PART № COOLANT
3	34	72	6	138 -XD300
3.1	34	72	6	138 -XD310
3.2	34	72	6	138 -XD320
3.3	34	72	6	138 -XD330
3.4	34	72	6	138 -XD340
3.5	34	72	6	138 -XD350
3.6	34	72	6	138 -XD360
3.7	34	72	6	138 -XD370
3.8	43	81	6	138 -XD380
3.9	43	81	6	138 -XD390
4	43	81	6	138 -XD400
4.1	43	81	6	138 -XD410
4.2	43	81	6	138 -XD420
4.3	43	81	6	138 -XD430
4.4	43	81	6	138 -XD440
4.5	43	81	6	138 -XD450
4.6	43	81	6	138 -XD460
4.7	43	81	6	138 -XD470
4.8	57	95	6	138 -XD480
4.9	57	95	6	138 -XD490
5	57	95	6	138 -XD500
5.1	57	95	6	138 -XD510
5.2	57	95	6	138 -XD520
5.3	57	95	6	138 -XD530
5.4	57	95	6	138 -XD540
5.5	57	95	6	138 -XD550
5.6	57	95	6	138 -XD560
5.7	57	95	6	138 -XD570
5.8	57	95	6	138 -XD580
5.9	57	95	6	138 -XD590
6	57	95	6	138 -XD600
6.1	76	114	8	138 -XD610
6.2	76	114	8	138 -XD620
6.3	76	114	8	138 -XD630
6.4	76	114	8	138 -XD640
6.5	76	114	8	138 -XD650
6.6	76	114	8	138 -XD660
6.7	76	114	8	138 -XD670
6.8	76	114	8	138 -XD680
6.9	76	114	8	138 -XD690
7	76	114	8	138 -XD700
7.1	76	114	8	138 -XD710
7.2	76	114	8	138 -XD720
7.3	76	114	8	138 -XD730
7.4	76	114	8	138 -XD740
7.5	76	114	8	138 -XD750
7.6	76	114	8	138 -XD760
7.7	76	114	8	138 -XD770
7.8	76	114	8	138 -XD780
7.9	76	114	8	138 -XD790
8	76	114	8	138 -XD800
8.1	95	142	10	138 -XD810
8.2	95	142	10	138 -XD820
8.3	95	142	10	138 -XD830

DRILL DIA	FL	OAL	SHANK DIA	PART № COOLANT
8.4	95	142	10	138 -XD840
8.5	95	142	10	138 -XD850
8.6	95	142	10	138 -XD860
8.7	95	142	10	138 -XD870
8.8	95	142	10	138 -XD880
8.9	95	142	10	138 -XD890
9	95	142	10	138 -XD900
9.1	95	142	10	138 -XD910
9.2	95	142	10	138 -XD920
9.3	95	142	10	138 -XD930
9.4	95	142	10	138 -XD940
9.5	95	142	10	138 -XD950
9.6	95	142	10	138 -XD960
9.7	95	142	10	138 -XD970
9.8	95	142	10	138 -XD980
9.9	95	142	10	138 -XD990
10	114	162	10	138 -XD100
10.1	114	162	12	138 -XD101
10.2	114	162	12	138 -XD102
10.3	114	162	12	138 -XD103
10.4	114	162	12	138 -XD104
10.5	114	162	12	138 -XD105
10.6	114	162	12	138 -XD106
10.7	114	162	12	138 -XD107
10.8	114	162	12	138 -XD108
10.9	114	162	12	138 -XD109
11	114	162	12	138 -XD110
11.1	114	162	12	138 -XD111
11.2	114	162	12	138 -XD112
11.3	114	162	12	138 -XD113
11.4	114	162	12	138 -XD114
11.5	114	162	12	138 -XD115
11.6	114	162	12	138 -XD116
11.7	114	162	12	138 -XD117
11.8	114	162	12	138 -XD118
11.9	114	162	12	138 -XD119
12	114	162	12	138 -XD120
12.5	133	182	14	138 -XD125
13	133	182	14	138 -XD130
13.5	133	182	14	138 -XD135
14	133	182	14	138 -XD140
14.5	152	204	16	138 -XD145
15	152	204	16	138 -XD150
15.5	152	204	16	138 -XD155
16	152	204	16	138 -XD160
16.5	171	223	18	138 -XD165
17	171	223	18	138 -XD170
17.5	171	223	18	138 -XD175
18	171	223	18	138 -XD180
18.5	190	244	20	138 -XD185
19	190	244	20	138 -XD190
19.5	190	244	20	138 -XD195
20	190	244	20	138 -XD200

Ex Stock Delivery on All Tools

Extremely Competitive Pricing

Merlin Tools Ltd

Quality
Precision
Performance

Tel: 01509 610300 • Fax: 01509 610400 • Email: sales@merlintools.ltd.uk • www.merlintools.ltd.uk

Solid Carbide Thread Mills - *AlTiN* Coated

Tolerance Shank h6
Tolerance Cutting h10

UNF — Ultra High Performance Solid Carbide - K20/25 - *AlTiN Coated Thread Mill* Spiral Flute - 15º Helix — UNC

UNF 940 series

Extremely Competitive Pricing

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
8-36	3.05	6.35	6	63	940 -00705	3	9
10-32	3.55	7.14	6	63	940 -00707	3	9
12-28	4.05	8.15	6	63	940 -00708	3	9
1/4-28	4.60	10.87	6	63	940 -00709	3	12
5/16-24	5.80	14.81	6	63	940 -00710	3	14
3/8-24	7.50	15.88	8	75	940 -00711	4	15
7/16,1/2-20	8.75	21.59	10	80	940 -00713	4	17
9/16-18	11.30	23.98	12	80	940 -00714	4	17
5/8-18	11.90	28.22	12	80	940 -00715	4	20
3/4-16	13.90	31.75	14	80	940 -00716	4	20
7/8-14	15.90	36.27	16	89	940 -00717	4	20
1-12	19.20	38.10	20	100	940 -00718	4	18

UNC 950 series

Ex Stock Delivery on All Tools

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
4-40	2.05	4.45	6	63	950 -00704	2	7
6-32	2.30	5.54	6	63	950 -00705	3	7
8-32	3.05	6.35	6	63	950 -00706	3	8
10-24	3.55	7.42	6	63	950 -00707	3	7
12-24	4.05	8.46	6	63	950 -00709	3	8
1/4-20	4.40	10.16	6	63	950 -00710	3	8
5/16-18	5.80	14.27	6	63	950 -00711	3	9
3/8-16	7.20	15.88	8	75	950 -00712	4	10
7/16-14	8.75	18.14	10	80	950 -00713	4	10
1/2-13	9.40	21.49	10	80	950 -00714	4	11
9/16-12	11.30	23.27	12	80	950 -00715	4	11
5/8-11	11.90	27.69	12	80	950 -00716	4	12
3/4-10	13.90	30.48	14	80	950 -00717	4	12
7/8-9	15.90	36.68	16	89	950 -00718	4	13
1-8	19.20	38.10	20	100	950 -00719	4	12

MF — Ultra High Performance Solid Carbide - K20/25 - *AlTiN Coated Thread Mill* Spiral Flute - 15º Helix — M

MF 960 series

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
M6-.75	4.50	10.50	6	63	960 -10110	3	14
M8-1.00	5.90	13.00	6	63	960 -10112	3	13
M10-1.25	7.80	16.25	8	75	960 -10114	4	13
M12-1.25	9.40	18.75	10	80	960 -10116	4	15
M14-1.50	9.90	25.50	10	80	960 -10118	4	17
M16-1.50	11.90	28.50	12	80	960 -10120	4	19
M20 M22-1.50	15.90	42.00	16	100	960 -10124	4	28

M 970 series

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
M3-.50	2.25	4.50	6	63	970 -10105	3	9
M3.5-.60	2.60	5.40	6	63	970 -10106	3	9
M4-.70	2.92	6.30	6	63	970 -10107	3	9
M4.5-.75	3.30	7.50	6	63	970 -10108	3	10
M5-.80	3.70	8.00	6	63	970 -10109	3	10
M6-1.00	4.50	10.00	6	63	970 -10110	3	10
M8-1.25	5.90	13.75	6	63	970 -10112	3	11
M10-1.50	7.80	16.50	8	75	970 -10114	4	11
M12-1.75	9.40	21.00	10	80	970 -10116	4	12
M14-2.00	9.90	26.00	10	80	970 -10118	4	13
M16-2.00	11.90	28.00	12	80	970 -10120	4	14
M18-2.50	13.50	30.00	14	80	970 -10122	4	12
M20-2.50	15.25	35.00	16	89	970 -10124	4	14
M24-3.00	18.20	39.00	20	100	970 -10126	4	13

Merlin Tools Ltd

Quality
Precision
Performance

Tel: 01509 610300 • Fax: 01509 610400 • Email: sales@merlintools.ltd.uk • www.merlintools.ltd.uk

Solid Carbide Thread Mills - *AlTiN* Coated

Tolerance Shank h6
Tolerance Cutting h10

NPT — Ultra High Performance Solid Carbide - K20/25 - *AlTiN Coated Thread Mill* Spiral Flute - 15º Helix — NPTF

NPT 920 series

Extremely Competitive Pricing

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
1/16-27	5.90	9.40	6	63	920 -00604	3	10
1/8-27	7.60	14.10	8	75	920 -00608	4	15
1/4,3/8-18	9.15	15.52	10	80	920 -00616	4	11
1/2-14	11.90	21.77	12	80	920 -00632	4	12
1-11.5	15.90	28.70	16	100	920 -00664	4	13
2.5-8	19.90	38.10	20	100	920 -00684	4	12

NPTF 930 series

Ex Stock Delivery on All Tools

MIN THREAD DIA/PITCH	CUTTER DIA	CUT LENGTH	SHANK DIA	OAL	PART NUMBER	No OF FLUTES	No OF THREADS
1/16-27	5.90	9.40	6	63	930 -00604	3	10
1/8-27	7.60	14.10	8	75	930 -00608	4	15
1/4-18	9.15	15.52	10	80	930 -00616	4	11
3/8-18	10.80	18.34	12	80	930 -00624	4	13
1/2-14	11.90	21.77	12	80	930 -00632	4	12
1-11.5	15.90	28.70	16	100	930 -00664	4	13
2.5-8	19.90	38.10	20	100	930 -00684	4	12

Technical Information Ultra High Performance Drills - *TiALN*

Material	Speed	Feed Rate	Speed	Feed Rate	Diameter	A	B	C	D	E	F	G
	Solid vc m/min	123+125 fr code	Coolant vc m/min	133,135+138 fr code	**3mm**	0.040	0.050	0.063	0.080	0.100	0.125	0.160
					4mm	0.050	0.063	0.080	0.100	0.125	0.160	0.200
Structural+Case Carbursing Steel	110	E	145	F	**5mm**	0.050	0.063	0.080	0.100	0.125	0.160	0.200
Free Cutting + Tempered Steel	105	F	110	G	**6mm**	0.063	0.080	0.100	0.125	0.160	0.200	0.250
Alloyed Steel	55	D	65	D	**8mm**	0.080	0.100	0.125	0.160	0.200	0.250	0.315
Stainless Steel	45	C	55	D	**10mm**	0.100	0.125	0.160	0.200	0.250	0.315	0.400
Aluminium	180	G	220	H	**12mm**	0.100	0.125	0.160	0.200	0.250	0.315	0.400
Special Alloys	25	C	35	C	**16mm**	0.125	0.160	0.200	0.250	0.315	0.400	0.500
Hardened Steel	25	A	35	A	**20mm**	0.160	0.200	0.250	0.315	0.400	0.500	0.630

Technical Information Solid Carbide Thread Mills - *AlTiN Coated*

Material	Feed mm/ per Flute by Shank Diameter						
Specification	SMPM	6mm	8mm	10mm	12mm	16mm	20mm
Steel	75-180	0.013	0.015	0.018	0.025	0.038	0.045
Stainless Steel	45-150	0.013	0.015	0.018	0.025	0.038	0.045
Aluminimum	250+	0.02	0.03	0.038	0.05	0.064	0.075
Titanium	25-40	0.01	0.013	0.018	0.018	0.02	0.02
Brass	150-250	0.02	0.03	0.038	0.05	0.064	0.075
Cast Iron	75-150	0.013	0.018	0.018	0.025	0.038	0.045

Call us now for your FREE 200 page Product Catalogue!

01509 610300

Solid Carbide Endmills • Drills including 3xD - 5xD - 8xD
Solid Carbide Threadmills ISO Metric & NPT
Izar HSSCo & Izarmax ASP52 Endmills • Machine Taps HSSCo & ASP2023
Carbide Rotary Burrs • Collets & Chucks