



HIGH SPEED STEEL TAPER LENGTH CORE DRILLS

ICS USA

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
CD3FSS (3 Flute)	 OXIDE FINISH	Three-flute core drills have more chip clearing than four-flute core drills. They are used for deep holes and for holes requiring substantial enlarging.	M2	*90° Point (small sizes) 118° Chamfer Std. Spiral Hvy. Duty Web
CD4FSS (4 Flute)	 OXIDE FINISH	Four-flute core drills have a better surface finish than three-flute core drills and can be run at higher metal removal rates. They are used for holes requiring light to medium enlarging. Most users find them easier to resharpen and measure.	M2	118° Chamfer Std. Spiral Hvy. Duty Web

Fractional Sizes (Straight Shank) 1/4 To 2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				OXIDE FINISH 3 FLUTE	OXIDE FINISH 4 FLUTE
				CD3FSS	CD4FSS
*1/4	.2500	3-3/4	6-1/8	\$25.14	\$43.26
*17/64	.2656	3-7/8	6-1/4	36.08	36.08
*9/32	.2812	3-7/8	6-1/4	25.38	25.36
*19/64	.2969	4	6-3/8	25.38	-
*5/16	.3125	4	6-3/8	27.02	26.04
*21/64	.3281	4-1/8	6-1/2	39.12	39.12
*11/32	.3438	4-1/8	6-1/2	27.54	27.54
*23/64	.3594	4-1/4	6-3/4	42.16	42.16
3/8	.3750	4-1/4	6-3/4	29.68	27.44
25/64	.3906	4-3/8	7	44.18	-
13/32	.4062	4-3/8	7	31.10	49.80
27/64	.4219	4-5/8	7-1/4	46.38	46.38
7/16	.4375	4-5/8	7-1/4	36.24	32.64
29/64	.4531	4-3/4	7-1/2	49.36	49.36
15/32	.4688	4-3/4	7-1/2	34.78	34.78
31/64	.4844	4-3/4	7-3/4	54.94	-
1/2	.5000	4-3/4	7-3/4	38.70	36.10
33/64	.5156	4-3/4	8	59.66	54.48
17/32	.5312	4-3/4	8	42.10	36.10
35/64	.5469	4-7/8	8-1/4	-	59.28
9/16	.5625	4-7/8	8-1/4	45.72	39.82
19/32	.5938	4-7/8	8-3/4	47.82	43.68
39/64	.6094	4-7/8	8-3/4	75.58	68.16
5/8	.6250	4-7/8	8-3/4	51.36	46.24
41/64	.6406	5-1/8	9	-	72.96
21/32	.6562	5-1/8	9	54.98	49.54
43/64	.6719	5-3/8	9-1/4	-	78.08
11/16	.6875	5-3/8	9-1/4	59.98	52.98
45/64	.7031	5-5/8	9-1/2	-	84.28
23/32	.7188	5-5/8	9-1/2	65.74	57.22
3/4	.7500	5-7/8	9-3/4	67.72	61.10
49/64	.7656	6	9-7/8	-	96.58
25/32	.7812	6	9-7/8	67.72	66.50
51/64	.7969	6-1/8	10	-	109.94
13/16	.8125	6-1/8	10	77.46	75.66
27/32	.8438	6-1/8	10	80.42	78.96

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				OXIDE FINISH 3 FLUTE	OXIDE FINISH 4 FLUTE
				CD3FSS	CD4FSS
55/64	.8594	6-1/8	10	\$ -	\$119.76
7/8	.8750	6-1/8	10	81.54	82.44
57/64	.8906	6-1/8	10	125.50	102.42
29/32	.9062	6-1/8	10	86.76	86.38
59/64	.9219	6-1/8	10-3/4	-	129.64
15/16	.9375	6-1/8	10-3/4	89.60	89.22
61/64	.9531	6-3/8	11	89.60	126.26
31/32	.9688	6-3/8	11	99.76	100.00
63/64	.9844	6-3/8	11	-	138.26
1	1.0000	6-3/8	11	104.10	104.60
1-1/32	1.0312	6-1/2	11-1/8	124.46	104.60
1-1/16	1.0625	6-5/8	11-1/4	129.76	129.76
1-3/32	1.0938	6-7/8	11-1/2	141.64	141.64
1-1/8	1.1250	7-1/8	11-3/4	151.30	151.32
1-9/64	1.1406	7-1/4	11-7/8	-	207.20
1-5/32	1.1562	7-1/4	11-7/8	153.00	152.08
1-11/64	1.1719	7-3/8	12	-	212.86
1-3/16	1.1875	7-3/8	12	158.04	159.02
1-7/32	1.2188	7-1/2	12-1/8	170.56	169.02
1-1/4	1.2500	7-7/8	12-1/2	182.16	171.84
1-9/32	1.2812	8-1/2	14-1/8	213.04	213.04
1-5/16	1.3125	8-5/8	14-1/4	221.24	221.34
1-11/32	1.3438	8-3/4	14-3/8	229.50	229.50
1-3/8	1.3750	8-7/8	14-1/2	235.44	235.44
1-13/32	1.4062	9	14-5/8	245.96	245.96
1-7/16	1.4375	9-1/8	14-3/4	258.24	258.24
1-15/32	1.4688	9-1/4	14-7/8	304.34	304.34
1-1/2	1.5000	9-3/8	15	304.34	304.34
1-5/8	1.6250	9-7/8	15-5/8	420.90	409.34
1-11/16	1.6875	10	15-3/4	-	439.14
1-23/32	1.7188	10-1/2	16-1/4	-	431.74
1-3/4	1.7500	10-1/2	16-1/4	-	427.40
1-13/16	1.8125	10-1/2	16-1/4	541.42	504.40
1-27/32	1.8438	10-3/4	16-1/2	552.72	552.72
1-7/8	1.8750	10-3/4	16-1/2	-	494.60
2	2.0000	10-3/4	16-3/4	-	564.48