



HIGH SPEED STEEL TAPER LENGTH CORE DRILLS

ICS USA

GENERAL PURPOSE

118° CHAMFER

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	ITEM NO.		SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	ITEM NO.	
				3 FLUTE	4 FLUTE					3 FLUTE	4 FLUTE
*1/4	.2500	3-3/4	6-1/8	CD3FSS016	CD4FSS016	55/64	.8594	6-1/8	10	CD3FSS055	CD4FSS055
*17/64	.2656	3-7/8	6-1/4	CD3FSS017	CD4FSS017	7/8	.8750	6-1/8	10	CD3FSS056	CD4FSS056
*9/32	.2812	3-7/8	6-1/4	CD3FSS018	CD4FSS018	57/64	.8906	6-1/8	10	CD3FSS057	CD4FSS057
*19/64	.2969	4	6-3/8	CD3FSS019	CD4FSS019	29/32	.9062	6-1/8	10	CD3FSS058	CD4FSS058
*5/16	.3125	4	6-3/8	CD3FSS020	CD4FSS020	59/64	.9219	6-1/8	10-3/4	CD3FSS059	CD4FSS059
*21/64	.3281	4-1/8	6-1/2	CD3FSS021	CD4FSS021	15/16	.9375	6-1/8	10-3/4	CD3FSS060	CD4FSS060
*11/32	.3438	4-1/8	6-1/2	CD3FSS022	CD4FSS022	61/64	.9531	6-3/8	11	CD3FSS061	CD4FSS061
*23/64	.3594	4-1/4	6-3/4	CD3FSS023	CD4FSS023	31/32	.9688	6-3/8	11	CD3FSS062	CD4FSS062
3/8	.3750	4-1/4	6-3/4	CD3FSS024	CD4FSS024	63/64	.9844	6-3/8	11	CD3FSS063	CD4FSS063
25/64	.3906	4-3/8	7	CD3FSS025	CD4FSS025	1	1.0000	6-3/8	11	CD3FSS100	CD4FSS100
13/32	.4062	4-3/8	7	CD3FSS026	CD4FSS026	1-1/32	1.0312	6-1/2	11-1/8	CD3FSS102	CD4FSS102
27/64	.4219	4-5/8	7-1/4	CD3FSS027	CD4FSS027	1-1/16	1.0625	6-5/8	11-1/4	CD3FSS104	CD4FSS104
7/16	.4375	4-5/8	7-1/4	CD3FSS028	CD4FSS028	1-3/32	1.0938	6-7/8	11-1/2	CD3FSS106	CD4FSS106
29/64	.4531	4-3/4	7-1/2	CD3FSS029	CD4FSS029	1-1/8	1.1250	7-1/8	11-3/4	CD3FSS108	CD4FSS108
15/32	.4688	4-3/4	7-1/2	CD3FSS030	CD4FSS030	1-9/64	1.1406	7-1/4	11-7/8	CD3FSS109	CD4FSS109
31/64	.4844	4-3/4	7-3/4	CD3FSS031	CD4FSS031	1-5/32	1.1562	7-1/4	11-7/8	CD3FSS110	CD4FSS110
1/2	.5000	4-3/4	7-3/4	CD3FSS032	CD4FSS032	1-11/64	1.1719	7-3/8	12	CD3FSS111	CD4FSS111
33/64	.5156	4-3/4	8	CD3FSS033	CD4FSS033	1-3/16	1.1875	7-3/8	12	CD3FSS112	CD4FSS112
17/32	.5312	4-3/4	8	CD3FSS034	CD4FSS034	1-7/32	1.2188	7-1/2	12-1/8	CD3FSS114	CD4FSS114
35/64	.5469	4-7/8	8-1/4	CD3FSS035	CD4FSS035	1-1/4	1.2500	7-7/8	12-1/2	CD3FSS116	CD4FSS116
9/16	.5625	4-7/8	8-1/4	CD3FSS036	CD4FSS036	1-9/32	1.2812	8-1/2	14-1/8	CD3FSS118	CD4FSS118
19/32	.5938	4-7/8	8-3/4	CD3FSS038	CD4FSS038	1-5/16	1.3125	8-5/8	14-1/4	CD3FSS120	CD4FSS120
39/64	.6094	4-7/8	8-3/4	CD3FSS039	CD4FSS039	1-11/32	1.3438	8-3/4	14-3/8	CD3FSS122	CD4FSS122
5/8	.6250	4-7/8	8-3/4	CD3FSS040	CD4FSS040	1-3/8	1.3750	8-7/8	14-1/2	CD3FSS124	CD4FSS124
41/64	.6406	5-1/8	9	CD3FSS041	CD4FSS041	1-13/32	1.4062	9	14-5/8	CD3FSS126	CD4FSS126
21/32	.6562	5-1/8	9	CD3FSS042	CD4FSS042	1-7/16	1.4375	9-1/8	14-3/4	CD3FSS128	CD4FSS128
43/64	.6719	5-3/8	9-1/4	CD3FSS043	CD4FSS043	1-15/32	1.4688	9-1/4	14-7/8	CD3FSS130	CD4FSS130
11/16	.6875	5-3/8	9-1/4	CD3FSS044	CD4FSS044	1-1/2	1.5000	9-3/8	15	CD3FSS132	CD4FSS132
45/64	.7031	5-5/8	9-1/2	CD3FSS045	CD4FSS045	1-5/8	1.6250	9-7/8	15-5/8	CD3FSS140	CD4FSS140
23/32	.7188	5-5/8	9-1/2	CD3FSS046	CD4FSS046	1-11/16	1.6875	10	15-3/4	CD3FSS144	CD4FSS144
3/4	.7500	5-7/8	9-3/4	CD3FSS048	CD4FSS048	1-23/32	1.7188	10-1/2	16-1/4	CD3FSS146	CD4FSS146
49/64	.7656	6	9-7/8	CD3FSS049	CD4FSS049	1-3/4	1.7500	10-1/2	16-1/4	CD3FSS148	CD4FSS148
25/32	.7812	6	9-7/8	CD3FSS050	CD4FSS050	1-13/16	1.8125	10-1/2	16-1/4	CD3FSS152	CD4FSS152
51/64	.7969	6-1/8	10	CD3FSS051	CD4FSS051	1-27/32	1.8438	10-3/4	16-1/2	CD3FSS154	CD4FSS154
13/16	.8125	6-1/8	10	CD3FSS052	CD4FSS052	1-7/8	1.8750	10-3/4	16-1/2	CD3FSS156	CD4FSS156
27/32	.8438	6-1/8	10	CD3FSS054	CD4FSS054	2	2.0000	10-3/4	16-3/4	CD3FSS200	CD4FSS200

CALL FOR PRICE

NOTE: Core drilling should be executed at approximately the same drilling speeds as would be employed in using a 2 flute drill. Feeds should be intermediate between those recommended for a drill and for a reamer for similar circumstances.