



HIGH SPEED STEEL TAPER SHANK CORE DRILLS

ICS USA

GENERAL PURPOSE

118° CHAMFER

Core drills are designed to enlarge previously drilled, cored, or punched holes as small as 60% of the tool diameter. Three and four flute core drills have better hole size control than two flute drills and produce a very good surface finish (although not to the standard produced by a reamer.) Note: Core drills cannot drill an original hole.

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
CD3FTS (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 size) 118° Chamfer Std. Spiral Hvy. Duty Web
CD4FTS (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 (Regular MT Shank) 1/4" To 3" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				OXIDE FINISH 3 FLUTE	OXIDE FINISH 4 FLUTE
#1 MT SHANK					
* 1/4	.2500	2-7/8	6-1/8	\$27.38	\$ -
* 9/32	.2812	3	6-1/4	27.38	-
* 5/16	.3125	3-1/8	6-3/8	29.36	-
* 11/32	.3438	3-1/4	6-1/2	36.34	-
3/8	.3750	3-1/2	6-3/4	36.34	-
13/32	.4062	3-5/8	7	34.80	-
7/16	.4375	3-7/8	7-1/4	36.46	-
15/32	.4688	4-1/8	7-1/2	38.72	-
#2 MT SHANK					
1/2	.5000	4-3/8	8-1/4	50.14	48.90
17/32	.5312	4-5/8	8-1/2	44.00	41.00
9/16	.5625	4-7/8	8-3/4	47.84	44.12
37/64	.5781	4-7/8	8-3/4	51.96	50.70
19/32	.5938	4-7/8	8-3/4	50.00	48.34
5/8	.6250	4-7/8	8-3/4	52.48	51.20
21/32	.6562	5-1/8	9	56.14	54.78
11/16	.6875	5-3/8	9-1/4	60.04	58.58
23/32	.7188	5-5/8	9-1/2	64.92	63.36
3/4	.7500	5-7/8	9-3/4	72.98	67.56
25/32	.7812	6	9-7/8	78.40	73.60
#3 MT SHANK					
13/16	.8125	6-1/8	10-3/4	90.82	83.70
27/32	.8438	6-1/8	10-3/4	92.14	87.48
55/64	.8594	6-1/8	10-3/4	-	93.08
7/8	.8750	6-1/8	10-3/4	98.12	91.18
29/32	.9062	6-1/8	10-3/4	102.18	96.68
15/16	.9375	6-1/8	10-3/4	101.86	98.80
31/32	.9688	6-3/8	11	113.44	110.66
1	1.0000	6-3/8	11	122.88	115.84
1-1/32	1.0312	6-1/2	11-1/8	139.10	124.56
1-1/16	1.0625	6-5/8	11-1/4	141.24	129.62
1-5/64	1.0781	6-7/8	11-1/2	-	151.24
#4 MT SHANK					
1-3/32	1.0938	6-7/8	12-1/2	166.74	145.18
1-1/8	1.1250	7-1/8	12-3/4	166.08	154.18
1-5/32	1.1562	7-1/4	12-7/8	176.74	163.20
1-3/16	1.1875	7-3/8	13	185.58	170.46
1-7/32	1.2188	7-1/2	13-1/8	213.72	182.36
1-1/4	1.2500	7-7/8	13-1/2	213.72	198.16
1-9/32	1.2812	8-1/2	14-1/8	287.64	228.18
1-5/16	1.3125	8-5/8	14-1/4	298.72	237.20

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				OXIDE FINISH 3 FLUTE	OXIDE FINISH 4 FLUTE
#4 MT SHANK					
1-11/32	1.3438	8-3/4	14-3/8	\$317.92	\$246.00
1-3/8	1.3750	8-7/8	14-1/2	317.92	252.28
1-13/32	1.4062	9	14-5/8	348.78	264.00
1-7/16	1.4375	9-1/8	14-3/4	348.78	276.78
1-15/32	1.4688	9-1/4	14-7/8	376.44	290.12
1-1/2	1.5000	9-3/8	15	376.44	298.82
#5 MT SHANK					
1-17/32	1.5312	9-3/8	16-3/8	417.16	335.98
1-9/16	1.5625	9-5/8	16-5/8	417.16	358.58
1-19/32	1.5938	9-7/8	16-7/8	445.24	397.64
1-39/64	1.6094	10	17	-	397.64
1-5/8	1.6250	10	17	-	408.30
1-21/32	1.6562	10-1/8	17-1/8	-	403.24
1-11/16	1.6875	10-1/8	17-1/8	467.30	418.32
1-23/32	1.7188	10-1/8	17-1/8	-	417.32
1-3/4	1.7500	10-1/8	17-1/8	-	444.86
1-25/32	1.7812	10-1/8	17-1/8	-	463.66
1-13/16	1.8125	10-1/8	17-1/8	-	476.88
1-27/32	1.8438	10-1/8	17-1/8	-	489.48
1-7/8	1.8750	10-3/8	17-3/8	573.92	518.22
1-29/32	1.9062	10-3/8	17-3/8	-	542.40
1-15/16	1.9375	10-3/8	17-3/8	-	552.42
1-31/32	1.9688	10-3/8	17-3/8	602.56	566.98
2	2.0000	10-3/8	17-3/8	-	586.22
2-1/32	2.0312	10-3/8	17-3/8	-	626.36
2-1/16	2.0625	10-1/4	17-3/8	-	626.36
2-1/8	2.1250	10-1/4	17-3/8	-	641.66
2-3/16	2.1875	10-1/4	17-3/8	-	700.06
2-1/4	2.2500	10-1/8	17-3/8	736.86	710.20
2-5/16	2.3125	10-1/8	17-3/8	-	783.50
2-3/8	2.3750	10-1/8	17-3/8	-	799.02
2-7/16	2.4375	11-1/4	18-3/4	-	799.96
2-1/2	2.5000	11-1/4	18-3/4	-	1000.86
2-9/16	2.5625	11-7/8	19-1/2	-	1075.20
2-5/8	2.6250	11-7/8	19-1/2	-	1135.68
2-11/16	2.6875	12-3/4	20-3/8	-	1232.12
2-3/4	2.7500	12-3/4	20-3/8	1516.90	1264.10
2-13/16	2.8125	13-3/8	21-1/8	-	1508.64
2-7/8	2.8750	13-3/8	21-1/8	-	1522.06
2-15/16	2.9375	14	21-3/4	-	1629.60
3	3.0000	14	21-3/4	-	1707.48

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.