







HIGH SPEED STEEL AIRCRAFT EXTENSION DRILLS

ICS USA/WIS

HEAVY DUTY

SPLIT POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA	NAS* SPECS
AC-06B AC-12B AC-18B	 OXIDE FINISH	For portable or machine drilling in hard steels, stainless steels and other hard materials. Mfr. to NAS 907-B specs.	M2, M7	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	B
AC-12A	 OXIDE FINISH	For portable or machine drilling in mild steels, aluminum, and magnesium alloys. Mfr. to NAS 907-A specs.	M2, M7	118° Split Pt. (P-5) Std. Spiral Hvy. Duty Web	A
AC-12L (Left Hand)	 GOLD FINISH	For portable or machine drilling where left hand rotation is required. Often used to drill out broken studs and screws.	M2, M7	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	B
AC-12S (Stub)	 BRIGHT POLISHED FINISH	For portable drilling where increased rigidity is required. Designed for drilling in hard steels. Screw machine flute length.	M2, M7	135° Split Pt. (P-3) Spec. Fast Spiral Hvy. Duty Web	C
AC-06C AC-12C	 GOLD COBALT FINISH	For portable or machine drilling in stainless steel, titanium, and other work hardening metals. Mfr. to NAS 907-J specs.	M42	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	J
AC-06T AC-12T	 GOLD TITANIUM COATED	The combination of titanium nitride coating with the heavy duty design enhances chip flow, finished hole quality and up to 700% more drill life.	M2, M7	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	B

*(NAS) National Aerospace Standard

Fractional Sizes (Straight Shank) 3/64" to 3/4" Dia.

SIZE	DEC. EQUIV.	HIGH SPEED STEEL						COBALT		TIN COATED	
		6" LENGTH	12" LENGTH	18" LENGTH	12" LENGTH	12" LENGTH	12" LENGTH	6" LENGTH	12" LENGTH	6" LENGTH	12" LENGTH
		Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Left Hand Jobber Flute Length	Screw Machine Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length
		135° Split Point	135° Split Point	135° Split Point	118° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point
		AC-06B	AC-12B	AC-18B	AC-12A	AC-12L	AC-12S	AC-06C	AC-12C	AC-06T	AC-12T
3/64	.0469	7.02	14.12	-	-	-	-	-	-	-	-
1/16	.0625	3.52	5.60	9.30	5.90	7.44	6.16	5.26	7.36	5.58	7.20
5/64	.0781	3.42	5.68	9.38	6.00	7.44	6.24	5.22	7.46	5.48	7.26
3/32	.0938	3.32	5.12	8.82	5.38	7.02	5.54	4.46	7.62	5.38	6.70
7/64	.1094	3.20	5.16	8.86	5.44	7.02	5.54	4.46	7.84	5.26	6.76
1/8	.1250	3.06	4.82	8.52	5.10	7.36	5.04	4.46	6.48	5.12	6.42
9/64	.1406	3.42	5.28	8.96	5.56	-	5.54	5.56	7.04	5.48	6.86
5/32	.1562	3.70	5.90	9.60	6.22	7.68	6.16	5.28	8.10	5.76	7.50
11/64	.1719	3.98	6.34	10.04	6.68	8.32	6.62	5.78	8.62	6.04	7.94
3/16	.1875	4.36	6.84	10.54	7.20	8.96	7.12	5.78	9.60	6.42	8.44
13/64	.2031	4.64	7.06	10.76	7.44	9.44	7.36	7.16	10.16	8.72	10.20
7/32	.2188	4.82	7.62	11.32	8.02	10.44	7.98	7.16	12.16	8.90	10.76
15/64	.2344	5.14	8.14	11.84	8.56	10.98	8.34	7.76	12.16	9.22	11.28
1/4	.2500	5.34	8.70	12.40	9.18	11.46	8.72	11.88	12.64	9.42	11.84
17/64	.2656	6.22	10.16	13.86	10.70	13.10	10.16	13.10	15.26	-	16.70
9/32	.2812	7.24	10.82	14.52	11.42	14.06	10.64	16.50	-	17.36	-
19/64	.2969	8.14	11.54	15.24	12.16	15.18	11.34	17.02	-	18.08	-
5/16	.3125	8.96	12.62	16.32	13.28	16.30	12.46	17.28	18.24	16.24	19.16
21/64	.3281	10.48	13.56	17.26	14.28	17.28	13.38	17.90	19.82	-	20.10
11/32	.3438	10.60	14.24	17.92	15.00	19.12	14.08	19.50	21.18	-	20.78
23/64	.3594	11.12	15.12	18.82	15.94	20.94	14.70	21.14	22.72	-	23.06
3/8	.3750	11.82	15.86	19.56	16.72	22.12	15.52	22.58	23.84	20.86	23.80
25/64	.3906	12.24	16.80	20.50	17.70	23.70	16.32	-	25.42	-	27.36
13/32	.4062	12.62	17.88	21.58	18.82	24.72	17.26	-	27.34	-	28.44
27/64	.4219	13.28	18.72	22.40	19.70	26.24	18.06	-	29.02	-	29.26
7/16	.4375	14.96	20.16	23.86	21.24	27.84	19.44	-	31.30	-	30.72
7/16TS	.4375	-	22.40	-	-	-	-	-	-	-	-
29/64	.4531	14.96	21.14	24.82	22.26	30.72	20.24	-	33.12	-	31.68
15/32	.4688	14.96	22.18	25.88	23.36	32.08	21.12	-	35.04	-	32.74
31/64	.4844	14.96	23.14	26.84	24.38	33.10	21.84	-	37.04	-	33.70
1/2	.5000	11.42	23.76	27.44	25.00	33.10	22.48	34.72	38.58	21.96	34.30
1/2TS	.5000	-	26.00	-	-	-	-	-	-	-	-
*9/16	.5629	-	39.06	-	-	-	-	-	83.12	-	52.92
*5/8	.6250	-	41.90	-	-	-	-	-	90.28	-	55.76
*3/4	.7500	-	52.98	-	-	-	-	-	105.20	-	-

Minimum order 12 each (3/64" - 17/64"); 6 each (9/32" - 1/2"). Add 15% for orders accepted in less than standard packaging.
(* 1/2" Shank). 7/16TS and 1/2TS have 3/8" Shank.