

HIGH SPEED STEEL SCREW MACHINE LENGTH DRILLS


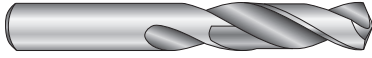



ICS USA

HEAVY DUTY

135° SPLIT POINT*

NAS 907 TYPE C SPECIFICATIONS

Screw Machine Length Drills were developed for screw machine operations where regular length drills were too long. The short length design reduces breakage and runout. They are now used in portable drilling where short, rigid drills are a requirement, and are especially suitable for N/C drilling applications. Also known as Short Length Drills or Stub Length Drills.

| ITEM NO. | ILLUSTRATION | CUTTING APPLICATION | STEEL SPECS | TECHNICAL DATA | NAS SPECS |
|-------------|---|--|-------------|--|-----------|
| SMR |  OXIDE FINISH | For drilling in hard steel, stainless steel, titanium and other hard materials. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web | C |
| SMP |  BRIGHT POLISHED FINISH | For drilling stainless steel and aluminum. Often used where oxide could potentially contaminate the weld around edge of the hole. Saves on clean-up time and machining costs. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web | C |
| SMGF |  GOLD OXIDE FINISH | For portable or machine drilling in hard steels, stainless steels and other hard materials. Designed as an alternative to black oxide. Gold oxide film reduces friction between the tool and the work. Does not smear metal. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web | C |
| SMG |  OXIDE FINISH | For use primarily in screw machine operations, and for general purpose drilling in mild steel and low alloys. | M2 | 118° Std. Pt. Std. Spiral Hvy. Duty Web | - |
| SMT |  GOLD TITANIUM FINISH | The combination of titanium nitride coating with the heavy duty design enhances chip flow, finished hole quality and up to 700% more drill life. Super hard RC-80 cutting edge. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web | C |

*SMG are general purpose 118° standard point.

(NAS) National Aerospace Standard

Fractional Sizes (Straight Shank) 3/64" to 1/2" Dia.

| SIZE | DEC. EQUIV. | FLUTE LENGTH | OVERALL LENGTH | HIGH SPEED STEEL | | | TiN COAT |
|-------|-------------|--------------|----------------|------------------|---------------|---------------|---------------|
| | | | | OXIDE FINISH | BRIGHT FINISH | GOLD FINISH | GOLD FINISH |
| | | | | 135° SPLIT PT | 135° SPLIT PT | 135° SPLIT PT | 135° SPLIT PT |
| | | | | SMR | SMP | SMGF | SMT |
| 3/64 | .0469 | 5/8 | 1-3/8 | 1.44 | 1.44 | 1.44 | 2.84 |
| 1/16 | .0625 | 5/8 | 1-5/8 | 0.94 | 0.94 | 0.94 | 2.52 |
| 5/64 | .0781 | 11/16 | 1-11/16 | 0.94 | 0.94 | 0.94 | 2.52 |
| 3/32 | .0938 | 3/4 | 1-3/4 | 0.98 | 0.98 | 0.98 | 2.60 |
| 7/64 | .1094 | 13/16 | 1-13/16 | 0.98 | 0.98 | 0.98 | 2.60 |
| 1/8 | .1250 | 7/8 | 1-7/8 | 1.04 | 1.04 | 1.04 | 2.84 |
| 9/64 | .1406 | 15/16 | 1-15/16 | 1.26 | 1.26 | 1.26 | 2.88 |
| 5/32 | .1562 | 1 | 2-1/16 | 1.34 | 1.34 | 1.34 | 3.12 |
| 11/64 | .1719 | 1-1/16 | 2-1/8 | 1.42 | 1.42 | 1.42 | 3.04 |
| 3/16 | .1875 | 1-1/8 | 2-3/16 | 1.54 | 1.54 | 1.54 | 3.14 |
| 13/64 | .2031 | 1-3/16 | 2-1/4 | 1.70 | 1.70 | 1.70 | 5.22 |
| 7/32 | .2188 | 1-1/4 | 2-3/8 | 1.92 | 1.92 | 1.92 | 5.34 |
| 15/64 | .2344 | 1-5/16 | 2-7/16 | 1.96 | 1.96 | 1.96 | 5.60 |
| 1/4 | .2500 | 1-3/8 | 2-1/2 | 2.02 | 2.02 | 2.02 | 5.68 |
| 17/64 | .2656 | 1-7/16 | 2-5/8 | 2.82 | 2.82 | 2.82 | 8.78 |
| 9/32 | .2812 | 1-1/2 | 2-11/16 | 2.98 | 2.98 | 2.98 | 8.90 |
| 19/64 | .2969 | 1-9/16 | 2-3/4 | 3.22 | 3.22 | 3.22 | 9.26 |
| 5/16 | .3125 | 1-5/8 | 2-13/16 | 3.38 | 3.38 | 3.38 | 9.56 |
| 21/64 | .3281 | 1-11/16 | 2-15/16 | 3.80 | 3.80 | 3.80 | 9.94 |
| 11/32 | .3438 | 1-11/16 | 3 | 4.06 | 4.06 | 4.06 | 10.36 |
| 23/64 | .3594 | 1-3/4 | 3-1/16 | 4.30 | 4.30 | 4.30 | 14.58 |
| 3/8 | .3750 | 1-13/16 | 3-1/8 | 4.68 | 4.68 | 4.68 | 14.74 |
| 25/64 | .3906 | 1-7/8 | 3-1/4 | 5.02 | 5.02 | 5.02 | 15.40 |
| 13/32 | .4062 | 1-15/16 | 3-5/16 | 5.46 | 5.46 | 5.46 | 18.00 |
| 27/64 | .4219 | 2 | 3-3/8 | 5.82 | 5.82 | 5.82 | 18.62 |
| 7/16 | .4375 | 2-1/16 | 3-7/16 | 6.36 | 6.36 | 6.36 | 18.90 |
| 29/64 | .4531 | 2-1/8 | 3-9/16 | 7.00 | 7.00 | 7.00 | 19.64 |
| 15/32 | .4688 | 2-1/8 | 3-5/8 | 7.44 | 7.44 | 7.44 | 20.10 |
| 31/64 | .4844 | 2-3/16 | 3-11/16 | 8.14 | 8.14 | 8.14 | 20.52 |
| 1/2 | .5000 | 2-1/4 | 3-3/4 | 8.14 | 8.14 | 8.14 | 21.06 |

PACKAGING


1/64 to 17/64 - 12 Drills/Envelope
9/32 to 1/2 - 6 Drills/Envelope
33/64 to 3/4 - 1 Drill/Tube

ORDERING NOTE

To complete your order we may substitute or interchange black or bright drills unless you have specified "no substitutions".

DRILL SETS

A variety of Screw Machine Length Drill Sets can found on page 14.



(Sizes continued on next page)