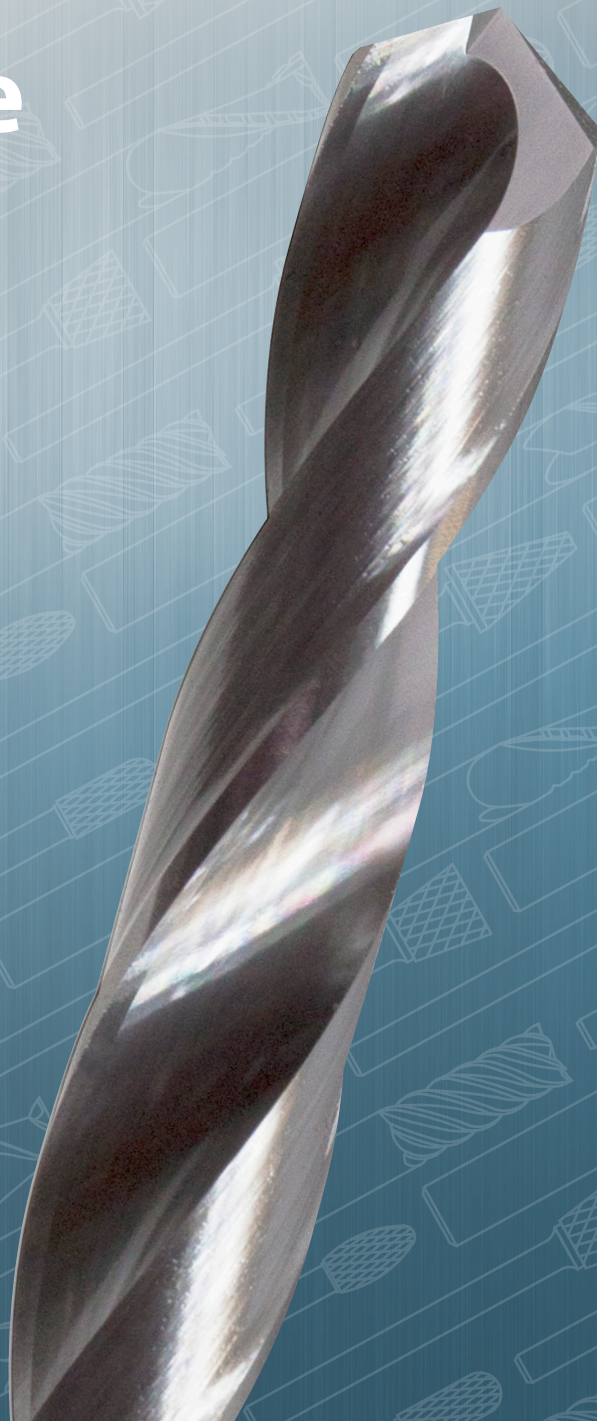




*The Cutting Edge **M**astered*

Solid Carbide Jobber Drills

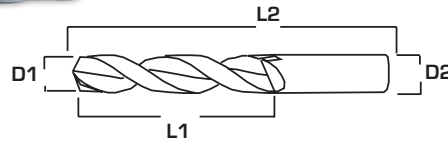
• 2 Flute and 3 Flute



Solid Carbide 2 Flute and 3 Flute

2 Flute - 118° Four Facet Point

3 Flute - 130° High Performance Point



Cutting Edge Tolerance/Shank Tolerance
+.000 - .0002

D1 - Cutting Diameter
L1 - Cutting Length
D2 - Shank Diameter
L2 - Overall Length

Wire	D1	L1	D2	L2	2 Flute	3 Flute
#70	.0280	5/16	.0280	1-1/4	601-002*	~
#69	.0292	5/16	.0292	1-1/4	601-004*	~
#68	.0310	5/16	.0310	1-1/4	601-006*	~
~	1/32	5/16	1/32	1-1/4	601-008*	~
#67	.0320	5/16	.0320	1-1/4	601-010*	~
#66	.0330	5/16	.0330	1-1/4	601-012*	~
#65	.0350	5/8	.0350	1-1/2	601-014*	~
#64	.0360	5/8	.0360	1-1/2	601-016*	~
#63	.0370	5/8	.0370	1-1/2	601-018*	~
#62	.0380	5/8	.0380	1-1/2	601-020*	~
#61	.0390	5/8	.0390	1-1/2	601-022*	~
~	.0394	5/8	.0394	1-1/2	601-024*	~
#60	.0400	3/4	.0400	1-1/2	601-026*	~
#59	.0410	3/4	.0410	1-1/2	601-028*	~
#58	.0420	3/4	.0420	1-1/2	601-030*	~
#57	.0430	3/4	.0430	1-1/2	601-032*	~
#56	.0465	3/4	.0465	1-1/2	601-034*	~
~	3/64	3/4	3/64	1-1/2	601-036*	~
#55	.0520	3/4	.0520	1-1/2	601-038*	~
#54	.0550	3/4	.0550	1-1/2	601-040*	~
~	.0591	3/4	.0591	1-1/2	601-042*	~
#53	.0595	3/4	.0595	1-1/2	601-044*	~
~	1/16	3/4	1/16	1-1/2	601-046	~
#52	.0635	3/4	.0635	1-1/2	601-048	~
#51	.0670	3/4	.0670	1-1/2	601-050	~
#50	.0700	7/8	.0700	1-3/4	601-052	~
#49	.0730	7/8	.0730	1-3/4	601-054	~
#48	.0760	7/8	.0760	1-3/4	601-056	~
~	5/64	7/8	5/64	1-3/4	601-058	~
#47	.0785	7/8	.0785	1-3/4	601-060	~
~	.0787	7/8	.0787	1-3/4	601-062	~
#46	.0810	7/8	.0810	1-3/4	601-064	~
#45	.0820	7/8	.0820	1-3/4	601-066	~
#44	.0860	1	.0860	2	601-068	~
#43	.0890	1	.0890	2	601-070	~
#42	.0935	1	.0935	2	601-072	~
~	3/32	1	3/32	2	601-074	~

* 135° Point

Wire	D1	L1	D2	L2	2 Flute	3 Flute
#41	.0960	1	.0960	2	601-076	~
#40	.0980	1	.0980	2	601-078	~
~	.0984	1	.0984	2	601-080	~
#39	.0995	1-1/4	.0995	2-1/4	601-082	~
#38	.1015	1-1/4	.1015	2-1/4	601-084	~
#37	.1040	1-1/4	.1040	2-1/4	601-086	~
#36	.1065	1-1/4	.1065	2-1/4	601-088	~
~	7/64	1-1/4	7/64	2-1/4	601-090	~
#35	.1100	1-1/4	.1100	2-1/4	601-092	~
#34	.1110	1-1/4	.1110	2-1/4	601-094	~
#33	.1130	1-1/4	.1130	2-1/4	601-096	~
#32	.1160	1-1/4	.1160	2-1/4	601-098	~
~	.1181	1-1/4	.1181	2-1/4	601-100	~
#31	.1200	1-1/4	.1200	2-1/4	601-102	~
~	1/8	1-1/4	1/8	2-1/4	601-104	601-504
#30	.1285	1-3/8	.1285	2-1/2	601-106	601-506
#29	.1360	1-3/8	.1360	2-1/2	601-108	601-508
~	.1378	1-3/8	.1378	2-1/2	601-110	601-510
#28	.1405	1-3/8	.1405	2-1/2	601-112	601-512
~	9/64	1-3/8	9/64	2-1/2	601-114	601-514
#27	.1440	1-3/8	.1440	2-1/2	601-116	601-516
#26	.1470	1-3/8	.1470	2-1/2	601-118	601-518
#25	.1495	1-3/8	.1495	2-1/2	601-120	601-520
#24	.1520	1-3/8	.1520	2-1/2	601-122	601-522
#23	.1540	1-3/8	.1540	2-1/2	601-124	601-524
~	5/32	1-3/8	5/32	2-1/2	601-126	601-526
#22	.1570	1-3/8	.1570	2-1/2	601-128	601-528
~	.1575	1-3/8	.1575	2-1/2	601-130	601-530
#21	.1590	1-3/8	.1590	2-1/2	601-132	601-532
#20	.1610	1-3/8	.1610	2-1/2	601-134	601-534
#19	.1660	1-5/8	.1660	2-3/4	601-136	601-536
#18	.1695	1-5/8	.1695	2-3/4	601-138	601-538
~	11/64	1-5/8	11/64	2-3/4	601-140	601-540
#17	.1730	1-5/8	.1730	2-3/4	601-142	601-542
#16	.1770	1-5/8	.1770	2-3/4	601-144	601-544
~	.1772	1-5/8	.1772	2-3/4	601-146	601-546
#15	.1800	1-5/8	.1800	2-3/4	601-148	601-548
#14	.1820	1-5/8	.1820	2-3/4	601-150	601-550

Wire	D1	L1	D2	L2	2 Flute	3 Flute
#13	.1850	1-5/8	.1850	2-3/4	601-152	601-552
~	3/16	1-5/8	3/16	2-3/4	601-154	601-554
#12	.1890	1-5/8	.1890	2-3/4	601-156	601-556
#11	.1910	1-5/8	.1910	2-3/4	601-158	601-558
#10	.1935	1-5/8	.1935	2-3/4	601-160	601-560
#9	.1960	1-3/4	.1960	3	601-162	601-562
~	.1968	1-3/4	.1968	3	601-164	601-564
#8	.1990	1-3/4	.1990	3	601-166	601-566
#7	.2010	1-3/4	.2010	3	601-168	601-568
~	13/64	1-3/4	13/64	3	601-170	601-570
#6	.2040	1-3/4	.2040	3	601-172	601-572
#5	.2055	1-3/4	.2055	3	601-174	601-574
#4	.2090	1-3/4	.2090	3	601-176	601-576
#3	.2130	1-3/4	.2130	3	601-178	601-578
~	.2165	1-3/4	.2165	3	601-180	601-580
~	7/32	1-3/4	7/32	3	601-182	601-582
#2	.2210	1-3/4	.2210	3	601-184	601-584
Letter	D1	L1	D2	L2	2 Flute	3 Flute
A	.2340	2	.2340	3-1/4	601-188	601-588
~	15/64	2	15/64	3-1/4	601-190	601-590
~	.2362	2	.2362	3-1/4	601-192	601-592
B	.2380	2	.2380	3-1/4	601-194	601-594
C	.2420	2	.2420	3-1/4	601-196	601-596
D	.2460	2	.2460	3-1/4	601-198	601-598
E	1/4	2	1/4	3-1/4	601-200	601-600
~	.2559	2	.2559	3-1/4	601-202	601-602
F	.2570	2	.2570	3-1/4	601-204	601-604
G	.2610	2-1/8	.2610	3-1/2	601-206	601-606
~	17/64	2-1/8	17/64	3-1/2	601-208	601-608
H	.2660	2-1/8	.2660	3-1/2	601-210	601-610
I	.2720	2-1/8	.2720	3-1/2	601-212	601-612
~	.2756	2-1/8	.2756	3-1/2	601-214	601-614
J	.2770	2-1/8	.2770	3-1/2	601-216	601-616
K	.2810	2-1/8	.2810	3-1/2	601-218	601-618
~	9/32	2-1/8	9/32	3-1/2	601-220	601-620
L	.2900	2-1/8	.2900	3-1/2	601-222	601-622
M	.2950	2-3/8	.2950	4	601-224	601-624
~	.2953	2-3/8	.2953	4	601-226	601-626
~	19/64	2-3/8	19/64	4	601-228	601-628
N	.3020	2-3/8	.3020	4	601-230	601-630
~	5/16	2-3/8	5/16	4	601-232	601-632
~	.3150	2-3/8	.3150	4	601-234	601-634

Letter	D1	L1	D2	L2	2 Flute	3 Flute
O	.3160	2-3/8	.3160	4	601-236	601-636
P	.3230	2-3/8	.3230	4	601-238	601-638
~	21/64	2-3/8	21/64	4	601-240	601-640
Q	.3320	2-3/8	.3320	4	601-242	601-642
~	.3346	2-3/8	.3346	4	601-244	601-644
R	.3390	2-3/8	.3390	4	601-246	601-646
~	11/32	2-3/8	11/32	4	601-248	601-648
S	.3480	2-3/8	.3480	4	601-250	601-650
~	.3543	2-3/4	.3543	4-1/4	601-252	601-652
T	.3580	2-3/4	.3580	4-1/4	601-254	601-654
~	23/64	2-3/4	23/64	4-1/4	601-256	601-656
U	.3680	2-3/4	.3680	4-1/4	601-258	601-658
~	.3740	2-3/4	.3740	4-1/4	601-260	601-660
~	3/8	2-3/4	3/8	4-1/4	601-262	601-662
V	.3770	2-3/4	.3770	4-1/4	601-264	601-664
W	.3860	2-7/8	.3860	4-1/2	601-266	601-666
~	25/64	2-7/8	25/64	4-1/2	601-268	601-668
~	.3937	2-7/8	.3937	4-1/2	601-270	601-670
X	.3970	2-7/8	.3970	4-1/2	601-272	601-672
Y	.4040	2-7/8	.4040	4-1/2	601-274	601-674
~	13/32	2-7/8	13/32	4-1/2	601-276	601-676
Z	.4130	2-7/8	.4130	4-1/2	601-278	601-678
~	.4134	2-7/8	.4134	4-1/2	601-280	601-680
~	27/64	2-7/8	27/64	4-1/2	601-282	601-682
~	.4331	2-7/8	.4331	4-1/2	601-284	601-684
~	7/16	2-7/8	7/16	4-1/2	601-286	601-686
~	.4527	3	.4527	4-3/4	601-288	601-688
~	29/64	3	29/64	4-3/4	601-290	601-690
~	15/32	3	15/32	4-3/4	601-292	601-692
~	.4724	3	.4724	4-3/4	601-294	601-694
~	31/64	3	31/64	4-3/4	601-296	601-696
~	.4921	3	.4921	4-3/4	601-298	601-698
~	1/2	3	1/2	4-3/4	601-300	601-700
~	17/32	4	17/32	6	601-302	601-702
~	9/16	4	9/16	6	601-304	601-704
~	19/32	4	19/32	6	601-306	601-706
~	5/8	4	5/8	6	601-308	601-708
~	21/32	4	21/32	6	601-310	601-710
~	11/16	4	11/16	6	601-312	601-712
~	23/32	4	23/32	6	601-314	601-714
~	3/4	4	3/4	6	601-316	601-716
~	7/8	4	7/8	6	601-320	601-720
~	1	4	1	6	601-322	601-722



Replace or Resharpener
drills at first sign of
dulling or rounding



Standard Drill Recommendations

Material Group	Speed SFM	Feed Rate (I.P.R.)				
		1/16"	1/8"	1/4"	1/2"	3/4"
Aluminum/ Aluminum Alloys	300-600	.0008	.003	.007	.012	.015
Aluminum Alloyed Si > 10%	150-400	.0008	.002	.006	.010	.012
Soft Cast Irons	200-300	.001	.003	.005	.010	.012
Medium Cast Irons	125-225	.001	.003	.005	.008	.010
Malleable Cast Irons	65-200	.0005	.002	.004	.007	.010
Brass	200-300	.0007	.002	.003	.004	.006
Bronze	150-250	.0007	.002	.003	.004	.006
Coppers/ Copper Alloys	150-300	.001	.003	.006	.010	.012
Magnesium	300-600	.001	.003	.007	.012	.015
Nickel Alloys	75-200	.001	.003	.005	.009	.012
Free Machining Stainless Steels	100-150	.001	.003	.005	.008	.012
Work Hardening Stainless Steels	50-100	.0005	.002	.004	.006	.010
Low Carbon Steels	150-300	.001	.002	.004	.007	.012
Medium Carbon Steels	100-200	.001	.002	.003	.006	.010
High Tensile (35-40 Rc) Steels	75-150	.001	.002	.003	.004	.005
High Tensile (40-45 Rc) Steels	50-100	.0007	.001	.002	.003	.004
High Tensile (45 Rc+) Steels	25-75	.0005	.0007	.001	.002	.003
Tool Steels	40-100	.001	.0015	.003	.005	.008
Soft Titanium	80-125	.001	.002	.004	.006	.010
Titanium Alloys Hard Titanium	40-100	.0007	.001	.002	.005	.008

PowerA Coating

PowerA is Mastercut Tool Corp's proprietary coating that surpasses the proven performance of TiAlN for superior extreme machining results. With a thermal stability above 1,600°F (900°C), this coating excels in high speed dry machining applications. Harder than our original TiAlN by 1000 HV and with an increase in thermal stability of 200°F (100°C), PowerA will ensure that heat buildup, friction, and edge breakdown are all greatly reduced, resulting in better cutting performance and longer tool life. As with its predecessor, PowerA will be an excellent coating for applications involving tough-to-cut tool steels, stainless, cast iron

and non-ferrous material, and it can also be used very effectively for interrupted cuts. PowerA can be run at more aggressive speeds and feeds than other coatings, and can be run without coolant in specific applications. **PowerA continues to be the coating of choice for tough-to-cut materials.**

Hardness: 3800 HV

Coating Thickness: 2-4 Microns

Thermal Stability: 1,650°F or 900°C

Consider PowerA coatings to run more aggressive speeds and feeds!



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