

Indexable Combined Drill & Countersinks

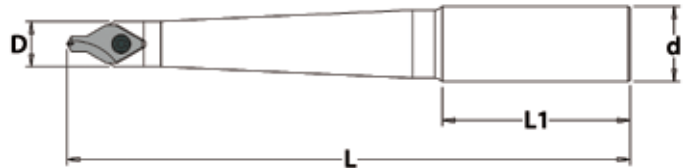
Carbide Inserts

- Secure insert pocket allows for quick and repeatable indexes
- Easy change over from one size to another – same body holds #2, #3, #4 and #5 inserts
- Carbide inserts for extended tool life
- One grade handles all applications
- Multiple bodies available for the same indexable insert (5/16", 3/8", 1/2", 5/8", 3/4", 1", and 1-1/4")
- Convenient, low-cost and economical

Individual Holders



5/8" holder body style shown



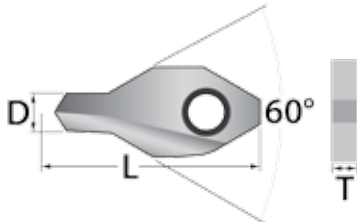
Dimensions (Inch)	Screw Reference	Key Reference	d Shank Diameter (Inch)	D Diameter (Inch)	L1 Length (Inch)	L Overall Length (Inch)	Code
5/16 x 4	TSB-0307	Torx® 9	5/16	0.393	1-13/32	4	530660
3/8 x 4	TSB-0307	Torx® 9	3/8	0.393	1-9/16	4	530661
1/2 x 4	TSB-0307	Torx® 9	1/2	0.393	1-23/32	4	530662
5/8 x 5	TSB-0307	Torx® 9	5/8	0.393	1-7/8	5	530663
3/4 x 6	TSB-0307	Torx® 9	3/4	0.393	1-7/8	6	530664
1 x 7	TSB-0307	Torx® 9	1	0.393	2-3/16	7	530665
1-1/4 x 8	TSB-0307	Torx® 9	1-1/4	0.393	2-11/32	8	530666



Indexable Combined Drill & Countersink Sets

Description	Code
5/8" x 5" Holder, 4 Carbide Inserts #2, #3, #4, and #5, and a Torx® 9 Key	530671
1/2" x 4" Holder, 4 Carbide Inserts #2, #3, #4, and #5, and a Torx® 9 Key	530672

Replacement Inserts



Insert	Material	D (Inch)	L Length (Inch)	T Thickness (Inch)	Code
#2	Carbide	5/64	0.811	0.157	530667
#3	Carbide	7/64	0.811	0.157	530668
#4	Carbide	1/8	0.811	0.157	530669
#5	Carbide	3/16	0.811	0.157	530670

Spare Screw



Description	Code
TSB-0307 (Torx® 9)	530673

Recommended Cutting Data

Material	Cutting Speed		Feed/Revolution							
			#2 (5/64")		#3 (7/64")		#4 (1/8")		#5 (3/16")	
	ft./min.	m/min.	inch/rev.	mm/rev.	inch/rev.	mm/rev.	inch/rev.	mm/rev.	inch/rev.	mm/rev.
Mild Steel	160-230	50-70	0.001-0.002	0.03-0.05	0.0025-0.004	0.06-0.10	0.003-0.0047	0.08-0.12	0.003-0.0055	0.08-0.14
Alloy Steel	150-210	45-65	0.0008-0.002	0.02-0.05	0.0015-0.003	0.04-0.08	0.0025-0.004	0.06-0.10	0.0025-0.004	0.06-0.10
Tool Steel	130-200	40-60	0.0004-0.0015	0.01-0.04	0.0008-0.0025	0.02-0.06	0.0015-0.003	0.04-0.08	0.0015-0.003	0.04-0.08
Stainless Steel	20-65	5-20	0.0004-0.0008	0.01-0.02	0.0004-0.001	0.01-0.03	0.0008-0.002	0.02-0.05	0.0008-0.0025	0.02-0.06
Cast Iron	160-230	50-70	0.0008-0.0025	0.02-0.06	0.0015-0.003	0.04-0.08	0.0025-0.004	0.06-0.10	0.0025-0.004	0.06-0.10
Aluminum	330-660	100-200	0.0004-0.0015	0.01-0.04	0.0008-0.002	0.02-0.05	0.0008-0.0025	0.02-0.06	0.0008-0.0025	0.02-0.06