

# SMALL HOLE INDEXABLE DRILLS

## HORNET™ DRILLS

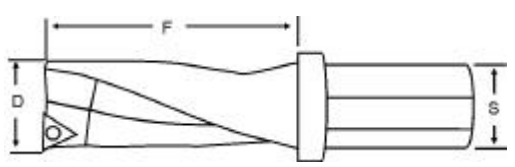
### HORNET™ SMALL DIAMETER INDEXABLE DRILLS

OTM™ "Stinger™" Style  
Flood Coolant



**FEATURES:**

- For smaller diameter holes
- Drill diameter range: 0.484 to 0.844
- Up to 2" drill depth
- Flood coolant
- Made in USA



D	F	S	Indexable Small Hole Drill		Accessories	
Drill Dia	Drill Depth	Shank Dia	Part Number	Price Each	Screw	Wrench
0.484	1.500	0.500	OT-0484-15-05	\$70.00	SC-12	TX-206
0.500	1.500	0.500	OT-0500-15-05			
0.516	1.500	0.500	OT-0516-15-05			
0.531	1.500	0.500	OT-0531-15-05			
0.547	1.500	0.500	OT-0547-15-05			
0.563	1.500	0.500	OT-0563-15-05			
0.578	1.500	0.500	OT-0578-15-05			
0.594	1.500	0.500	OT-0594-15-05			
0.609	1.500	0.500	OT-0609-15-05			
0.625	1.500	0.500	OT-0625-15-05			
0.641	1.500	0.500	OT-0641-15-05	\$75.00	SC-12	\$5.00
0.656	1.500	0.500	OT-0656-15-05			
0.672	1.500	0.500	OT-0672-15-05			
0.688	1.500	0.500	OT-0688-15-05	\$75.00	SC-11	TX-207
0.703	1.500	0.500	OT-0703-15-05			
0.719	2.000	0.625	OT-0719-20-06			
0.734	2.000	0.625	OT-0734-20-06			
0.75	2.000	0.625	OT-0750-20-06			
0.766	2.000	0.625	OT-0766-20-06			
0.781	2.000	0.625	OT-0781-20-06			
0.797	2.000	0.750	OT-0797-20-07			
0.813	2.000	0.750	OT-0813-20-07			
0.828	2.000	0.750	OT-0828-20-07			
0.844	2.000	0.750	OT-0844-20-07			

\*OTM & "Stinger" are trademarks of Manchester OTM

## INSERTS



Drill Dia	IC	T	R	H	INSERTS				Quantity Discount
					Cermet 5NU CT525 P01-P15	Coated 23CU 2025	Coated 40CU 4025	Uncoated 13U 13A	
0.484 to 0.703	0.156	0.078	0.031	0.087	US-151 \$6.12	US-152 \$8.17	US-153 \$10.72	US-154 \$5.80	10-29 pcs 10% OFF
0.719 to 0.844	0.218	0.093	0.031	0.098	US-161 \$5.80	US-162 \$8.09	US-163 \$8.09	US-164 \$5.80	30+ pcs 15% OFF

### INSERT GRADES

5NU	Super Cermet for semi-roughing to finishing in a wide variety of materials. Works at higher cutting speeds, providing excellent surface finishes.
13U	Sub micron grade for use in <b>High Temp/High Nickel alloys</b> as well as <b>cast iron and aluminum</b> .
23CU	Coated Carbide grade for low speed applications and operations requiring toughness. First choice in <b>stainless steels</b> .
40CU	Excellent overall <b>Steel and Stainless Steel</b> grade over a wide range, exhibiting good heat and wear resistance.
3015	For cast iron.

## CUTTING & GRADE INFORMATION



Material	Condition	Insert Grade	SFM	FPT
Aluminum	-	5N	1000+	.002-.006
		13	900-1800	.002-.006
Cast Iron, gray	-	5N	500-900	.001-.003
		13	300-500	.001-.003
		23C	300-500	.001-.003
Cast Iron, nodular (ductile)	-	5N	500-700	.001-.003
		13	350-450	.001-.0022
		23C	350-450	.001-.0022
Cast Iron, malleable	-	5N	400-800	.001-.003
		13	300-500	.001-.003
		23C	300-500	.001-.003
Steel, low carbon	annealed	5N	600-900	.0012-.0018
		40C	500-800	.0012-.0018
Steel, low carbon	carburized, 35-50 Rc	5N	300-400	.0012-.0018
		40C	250-350	.0012-.0018

Material	Condition	Insert Grade	SFM	FPT
Steel, medium carbon	17-32 Rc	5N	500-700	.0012-.003
		40C	400-600	.0012-.003
Tool Steel	annealed	5N	350-450	.001-.0015
	35-50 Rc	5N	150-250	.0007-.0012
4130, 4140, 4150	Annealed	5N	500-700	.0012-.003
		40C	400-600	.0012-.003
6150	Annealed	5N	500-600	.0012-.0015
		40C	400-600	.0012-.0015
Stainless Steel	300 Series	23C	300-500	.0012-.0015
		40C	400-600	.0012-.0015
Stainless Steel	400 Series	23C	400-600	.0012-.0015
		40C	500-700	.0012-.0015
High Temp Alloys	-	13	100-175	.0005-.0008
Inconel 718	-	13	150-250	.0015-.0025
Titanium Alloys	-	13	150-250	.0005-.001

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