

# SMALL HOLE INDEXABLE DRILLS

D

LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

LATHE BUSHINGS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

COOLANT/FLUIDS  
TOOL STORAGE

## HORNET™ DRILLS

### HORNET™ SMALL DIAMETER INDEXABLE DRILLS

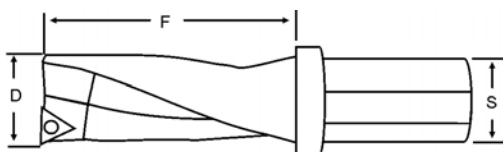
OTM™ “Stinger™” Style Flood Coolant



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			
0.656	1.500	0.500	OT-0656-15-05	\$75.00	SC-11	TX-207
0.672	1.500	0.500	OT-0672-15-05			
0.688	1.500	0.500	OT-0688-15-05			
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	\$80.00	\$1.00	\$5.00
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			

#### FEATURES:

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



\*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 High Temp/High Nickel alloys as well as cast iron and aluminum.
23CU	Coated Carbide grade for low speed applications and operations requiring toughness. First choice in stainless steels.
40CU	Excellent overall Steel and Stainless Steel 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
		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

Call Us Or Visit Our Website For Our Complete Selection!

2010-11 Master Catalog

269