



PRODUCTIVITY TOOLING SOLUTIONS FOR THE METALWORKING INDUSTRY



 **DRILLCO**
CUTTING TOOLS

 **TRIUMPH**
TWIST DRILL

 **WALTER**
Surface Technologies

CHOOSE THE RIGHT DRILL FOR THE JOB

Drills come in different sizes, substrates, coatings and specifications. Choosing the right drill for the application at hand is an important part of any project and can have a significant impact on productivity, and life of your tools.

Here's a quick overview of several types of material substrates and design types to help increase productivity and reduce material waste and downtime.

Drill Bit Materials

High Speed Steel (HSS): The most commonly used tool material for general purpose drilling. Suitable for most materials, including low to medium strength steels, aluminum and other non-ferrous materials, as well as wood and plastic.

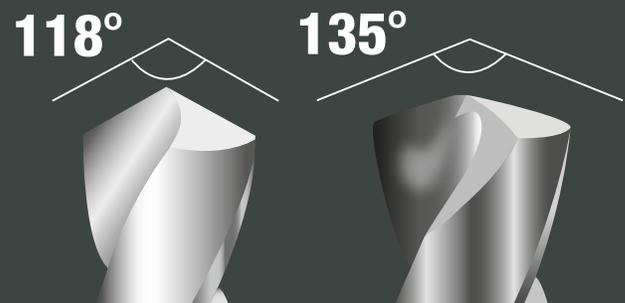
Cobalt (HSCo): This composition increases tool "hardness" and improved "wear resistance" making it a great option for drilling into harder steel as well as stainless steel grades.

Carbide (HM): Carbide tools are designed for very hard and very tough to machine materials. Carbide drills are more brittle than HSS or HSCo drills, and should only be used for production drilling in stationary equipment. They are not recommended for use in hand held portable drills.

Drill Point Angle

118° Standard: Used for mild steels and free machining materials.

118° or 135° Split Point: Self-centering, four-facet point allows for faster cutting and less "walking". Best for curved surfaces and "hand-drilling" on harder materials.



Drill Length

Shorter drills provide better accuracy, are more rigid and are better for drilling in tighter, more confined spaces. Shorter length tools also mitigate deflection and breakage. Jobber length drills are most common because they provide extra reach and they can be used in most applications.

Stub Length



Mechanic's Length



Jobber Length



Taper Length



**Extra Length
(8"/12"/18")**



Drill Coatings & Surface Treatments



Bright Finish: No finish or coating, just smooth polished for increased chip flow. For use on soft metals, aluminum, plastic and wood.



Black Oxide Surface Treatment: Reduces friction and heat damage. Increases tool life. For performance on low to medium tensile strength materials.



Black and Gold: Better resistance to corrosion and breakage while increasing lubricity. Reduces chipping and flaking. Can be used on most materials.



Titanium Nitride Coated (TiN): High hardness combined with low friction properties ensures considerably longer tool life and better cutting performance on most materials.



Bronze Surface Treatment: Will increase lubricity and bit life while reducing chip build-up. For performance on harder metals and stainless steel.

General Purpose Drills



Jobber Drills | High Speed Steel

Bright Finish
For aluminum and other non-ferrous materials

Point type	Series	Catalog page reference
118° Conventional point	200B, 240B, 280B	2-4



Also available in sets: 200B29

S&D Drills | High Speed Steel

Bright and Black Finish
For better performance on low to medium tensile strength materials

Point type	Series	Catalog page reference
118° Point 1/2" reduced shank	1000A, 1000F	56-59



Also available in sets: 1000A5, 1000A8, 1000F5, 1000F8

Heavy-Duty Drills

Jobber Drills | High Speed Steel

Black Oxide
For better performance on low to medium tensile strength materials

Point type	Series	Catalog page reference
135° Split point	400A, 440A, 480A	15-17



Also available in sets: 400AW29, 400HD29

Jobber Drills | High Speed Steel

Black & Gold Finish
Heavy-duty core guarantees increased strength and better resistance to breakage, with a 3-flat shank

Point type	Series	Catalog page reference
135° split point 3-flat shank THU DERBIT	T1HD+, T2HD+, T3HD+, MM1HD+, BP1HD+	8-13



Also available in sets: 17HDDC+, T17HD+

S&D Drills | Cobalt

Bronze Treatment
Stainless steel, titanium, high tensile steels and other hard materials

Point type	Series	Catalog page reference
135° 1/2" reduced shank	1000C	61



Also available in sets: 1000C5, 1000C8

Jobber Drills | High Speed Steel

Black Oxide
For low to medium tensile strength materials

Point type	Series	Catalog page reference
118° Conventional point	200A, 240A, 280A	2-4



Also available in sets: 200A29, 200AW29

Screw Machine | High Speed Steel

Black Oxide
For better performance on low to medium tensile strength materials

Point type	Series	Catalog page reference
135° Split point straight shank	300A, 340A, 380A	34-37



Also available in sets: 300A29

Jobber Drills | High Speed Steel

Black & Gold Finish
Most materials

Point type	Series	Catalog page reference
135° Split point NITRO	400N, 440N, 480N, 1035N	12-14-54



Also available in sets: 400N29, 400NW29

Jobber Drills | Cobalt

Bronze Treatment
Stainless steel, titanium, high tensile steels and other hard materials

Point type	Series	Catalog page reference
135° Split point	500A, 540A, 580A	25-28



Also available in sets: 500A29, 500AW29

Mechanic's Length | High Speed Steel

Black & Gold Finish
For most materials

Point type	Series	Catalog page reference
135° Split point with 3-flats NITRO	350N, 1045N	32-55



Also available in sets: 350N29, 350NW29

Ask your territory manager about our full lineup and full SKU listing.



General Purpose Drill Sets

Product number	Catalog page reference
200A29 200AW29 200B29	18




Jobber Drills | High Speed Steel

Black & Gold Finish
Heavy-duty core guarantees increased strength and better resistance to breakage

Point type	Series	Catalog page reference
135° Split point THU DERBIT	T1HD, T2HD, T3HD, MM1HD, BP1HD	8-13



Also available in sets: 17HDDC, T17HD

S&D Drills | High Speed Steel

Black & Gold Finish
Most materials

Point type	Series	Catalog page reference
118° Split point 1/2" reduced shank with 3-flats NITRO	1000N	53-54



Also available in sets: 1000N8, 1000N5

Screw Machine | Cobalt

Bronze Treatment
Stainless steel, titanium, high tensile steels and other hard materials

Point type	Series	Catalog page reference
135° Split point	300C, 380C	38-39



Also available in sets: 300C29

Construction Reamers

Reamers are available in car (shorter) and bridge (longer) length as:



Shank Styles

Taper Shank



Hex Shank



3-Flat Shank



Flute Styles

Spiral Flute



High-Spiral Flute



Straight Flute



Construction Reamers

High Speed Steel

Black Oxide
For better performance on low to medium tensile strength materials

Type	Series	Catalog page reference
Construction	4275 4285 4290 125HX	195-201



Heavy-Duty Construction Reamers

High Speed Steel

Black and Gold
For most materials

Type	Series	Catalog page reference
Construction	4275N 4285N 4290N 125SF	195-201

NITRO



Ask about Drillco's new Step Reamers!



New

Carbide Burrs

Single and Double Cut

Bright Finish
For most ferrous metals, hard alloys; aluminum

Series	Catalog page reference
7000	167-178



Aluminum/Non-Ferrous Cut

Bright Finish
For rapid stock removal with minimum chip buildup

Product number	Catalog page reference
7000AAL-7000LAL	175



Ask your territory manager about our full lineup and full SKU listing.



General Purpose Taps



Hand Taps | Carbon Steel

Bright Finish
For cleaning up threads or repairing damaged threads

Type	Series	Catalog page reference
Taper, plug, bottoming/through or blind hole	2000C	117-118



High Speed Steel

Bright Finish
Low to medium tensile strength materials, and aluminum

Type	Series	Catalog page reference
Taper, plug, bottoming/through or blind hole	2000, 2800	108-109, 112-113



High Speed Steel

Black Oxide
For better performance on low to medium tensile strength materials

Type	Series	Catalog page reference
Taper, plug, bottoming/through or blind hole	2000N	106-107

NITRO



Spiral Point Taps | High Speed Steel

Bright Finish
For low to medium tensile strength materials

Type	Series	Catalog page reference
Plug/Through hole	2100	128-129



High Speed Steel

Black Oxide
For better performance on low to medium tensile strength materials

Type	Series	Catalog page reference
Plug/Through hole	2100N	126-127

NITRO



General Purpose Taps Sets

Series	Catalog page reference
Hand taps 2000N & 2000	152 
Spiral point taps 2100N & 2100	
Taps and drills 2000N & 2000	
Taps and drills 2800	

Spiral Flute Taps | High Speed Steel

Bright Finish
For low to medium tensile strength materials

Type	Series	Catalog page reference
Plug/Bottoming for blind hole	2000F	140



High Speed Steel

Bright Finish
For tougher applications, including stainless steel

Type	Series	Catalog page reference
Bottoming for blind hole	2000PF	138-139

NITRO



Ask your territory manager about our full lineup and full SKU listing.

Production (CNC) Taps

Cobalt

Black Oxide or TiCN Coated
For production tapping on CNC machines

Type	Series	Catalog page reference
Through or blind hole	2150N, 2250N, 2160N, 2260N, 2270N	124-125, 136-137, 140-141

NITRO-MAX



Pipe Taps



High Speed Steel

Bright Finish
For long life on most materials

Type	Series	Catalog page reference
Through or blind hole	2900, 2900E, 2700E, 2930, 2950	143-147



High Speed Steel Annular Cutters



High Speed Steel

Bright Finish
For low to medium tensile strength materials

	Series	Catalog page reference
1", 2", 3", and 4" Depth of Cut	9100SE, 9200SE, 9300SE, 9400SE	180-186



High Speed Steel + Aluminum (M2Al)

Bronze Treatment
For most materials

	Series	Catalog page reference
SST	05-A, 05-E	146-148



High Speed Steel + Aluminum (M2Al)

AlCrN Coated
For hard steel

	Series	Catalog page reference
ICECUT	05-B, 05-F	147-149



Heavy-Duty Annular Cutters



Cobalt

Bronze Finish
For long life on stainless steel, titanium, high tensile steel, other hard materials

	Series	Catalog page reference
1", 2" and 3" Depth of Cut	9100N, 9200N, 9300N	180-186

NITRO



Carbide (TCT)

Bright Finish
For high performance on cast iron, cast steel, other hard materials

	Series	Catalog page reference
CARBIDE CORECUT	05-D, 05-F, 05-H	148



Check out Drillco's new TCT Hole Cutters

New



Magnetic Drilling Machines



The Ultimate Core Cutting System
Light, powerful and safe

Product name	Series	Catalogue page reference
ICECUT MINI ICECUT 100 ICECUT 200 ICECUT 200PM ICECUT 300 ICECUT 400 ICECUT 250P	39-D	151-160

Features

- ACCUDRILL Visual Amp Meter
- Material and Thickness Detector
- Lightweight Units
- Quick Release Reversible Handle
- Mechanical Clutch
- Steel Sliding Guard
- Swivel Base (ICECUT 300 and 400)



Countersinks



General Purpose High Speed Steel

Bright Finish
For low to medium tensile strength materials

Type	Series	Catalog page reference
Single flute 3-flute 4-flute 6-flute	3600E 3700E 3800E 3900E	227-230



Heavy-Duty High Speed Steel + Aluminum (M2Ai)

AlCrN Coated
For hard steel

Type	Series	Catalog page reference
4-flute	01-U	138



Set: 01-U 950

Dies



Cutting Lubricants



General Purpose High Speed Steel

Bright Finish
Low to medium tensile strength materials,
carbon steel

Type	Series	Catalog page reference
Adjustable round split dies, hexagon dies	3000DS, 3000E 3050E, 3100E 3300E, 3350E 3360E, 3380E	155-166



High Performance Lubricants

Series	Catalog page reference
53-A 53-B 53-C	189-191



End Mills



General Purpose High Speed Steel

Bright Finish
For low to medium tensile strength materials

Type	Series	Catalog page reference
2 flute finishing Multi-flute finishing Ball nose	5075A, 5000A 5600A, 5400A 6150A, 5100A 5250A, 5350A 5650A, 6400A, 6420A	211-215, 217- 221, 224



Heavy-Duty Cobalt

Bright Finish
For most materials

Type	Series	Catalog page reference
2 flute finishing Multi-flute finishing Ball nose Roughing	6500A, 6900A 6700A, 6725A 6750A, 6950A 6650A, 7140	216, 222-223, 225-226



Heavy-Duty Solid Carbide

Bright Finish
For steel, stainless steel, titanium, cast iron,
brass, bronze

Type	Series	Catalog page reference
2 & 4 flute finishing Ball nose	7200, 7300 7250, 7350 7600, 7700 7650, 7750 7400, 7500	208-210



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