

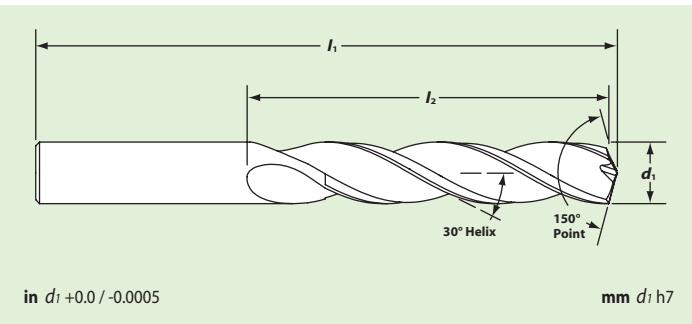
TRI-FLUTE D30 DRILLS

For drilling low carbon steel, alloy steel and cast iron




3 Helical Flutes

For improved hole roundness

D30



Three flute twist drills reduce chip load per flute for longer tool life. The self-centering drill point geometry allows easy penetration of the workpiece with minimal deflection and wandering. Three flute drills also improve hole roundness and hole tolerance. The three flute drill can also be used in aluminum by modifying the point geometry. See page 161.

 Carbon & tool steels ≤ 48 HRC	✓✓
 Stainless steels 400 series & PH series only	✓
 Cast irons	✓✓

✓ Good ✓✓ Very Good

Inch • Metric

	d_1 Cutter Dia Inch Metric	Dec Equiv	l_2 Flute Length	l_1 Overall Length	EDP Number	List Price
	3	.1181	16	46	40001	16.28
	3	.1181	31	57	44217	16.80
	3,1	.1220	18	49	40002	16.28
	3,1	.1220	31	57	44218	16.80
1/8		.1250	1-1/4	2-1/4	40003	16.70
	3,2	.1260	18	49	40004	16.49
	3,2	.1260	31	57	44219	17.01
	3,3	.1299	18	49	40006	16.75
	3,3	.1299	31	57	44221	17.22

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Inch • Metric • Continued

	d_1 Cutter Dia Inch Metric	Dec Equiv	l_2 Flute Length	l_1 Overall Length	EDP Number	List Price
	3,4	.1339	20	52	40007	17.17
	3,4	.1339	34	63	44222	17.69
#29		.1360	1-3/8	2-1/2	40008	17.43
	3,5	.1378	20	52	40009	17.27
	3,5	.1378	34	63	44223	17.80
9/64		.1406	1-3/8	2-1/2	40012	17.75
	3,6	.1417	20	52	40015	17.59
	3,6	.1417	34	63	44224	18.17
	3,7	.1457	20	52	40018	18.17
	3,7	.1457	34	63	44225	18.69
#25		.1495	1-3/8	2-1/2	40033	19.01
	3,8	.1496	22	55	40036	19.16
	3,8	.1496	34	63	44227	19.74
	3,9	.1535	22	55	40042	19.90
	3,9	.1535	34	63	44228	20.48
5/32		.1562	1-3/8	2-1/2	40048	21.05
	4	.1575	22	55	40054	20.84
	4	.1575	34	63	44229	21.47
#21		.1590	1-3/8	2-1/2	40057	21.16
#20		.1610	1-3/8	2-1/2	40060	21.47
	4,1	.1614	22	55	40063	21.37
	4,1	.1614	34	63	44230	22.05
	4,2	.1654	22	55	40066	21.74
	4,2	.1654	41	70	44231	22.63
#19		.1660	1-5/8	2-3/4	40072	22.16
11/64		.1719	1-5/8	2-3/4	40078	22.79
	4,4	.1732	24	58	40081	22.47
	4,4	.1732	41	70	44234	23.36
	4,5	.1772	24	58	40084	23.00
	4,5	.1772	41	70	44235	23.94
	4,6	.1811	24	58	40087	23.36
	4,6	.1811	41	70	44236	24.26
3/16		.1875	1-5/8	2-3/4	40090	24.41
	4,8	.1890	26	62	40093	24.20
	4,8	.1890	41	70	44239	25.20
	4,9	.1929	26	62	40099	24.78
	4,9	.1929	41	70	44240	25.73
	5	.1969	26	62	40102	25.52
	5	.1969	44	76	44241	26.51
	5,1	.2008	26	62	40105	26.78
	5,1	.2008	44	76	44242	27.83
13/64		.2031	1-3/4	3	40114	27.72
	5,2	.2047	26	62	40117	27.20
	5,2	.2047	44	76	44243	28.30
#3		.2130	1-3/4	3	40123	29.61
	5,5	.2165	28	66	40126	29.77
	5,5	.2165	44	76	44247	30.98
7/32		.2188	1-3/4	3	40132	31.03
	5,6	.2205	28	66	40135	30.45
	5,6	.2205	44	76	44248	31.66
	5,8	.2283	28	66	40138	30.98
	5,8	.2283	44	76	44251	32.18

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TRI-FLUTE D30 DRILLS

For drilling low carbon steel, alloy steel and cast iron

Inch • Metric • Continued

	d_1 Cutter Dia Inch Metric	Dec Equiv	l_2 Flute Length	l_1 Overall Length	EDP Number	List Price
15/64		.2344	2	3-1/4	40141	33.55
	6	.2362	28	66	40144	33.23
	6	.2362	51	82	44253	34.55
	6,1	.2402	31	70	40147	33.55
	6,1	.2402	51	82	44254	34.91
	6,2	.2441	31	70	40150	34.28
	6,2	.2441	51	82	44255	35.65
1/4		.2500	2	3-1/4	40156	34.18
	6,4	.2520	31	70	40159	35.02
	6,4	.2520	51	82	44258	36.44
	6,5	.2559	31	70	40165	34.76
	6,5	.2559	51	82	44259	36.17
F		.2570	2	3-1/4	40167	35.70
	6,6	.2598	31	70	40168	37.54
	6,6	.2598	54	89	44260	39.01
17/64		.2656	2-1/8	3-1/2	40174	37.96
	6,8	.2677	34	74	40177	38.06
	6,8	.2677	54	89	44263	39.59
	6,9	.2717	34	74	40179	38.85
	6,9	.2717	54	89	44264	40.37
	7	.2756	34	74	40183	39.59
	7	.2756	54	89	44265	41.16
9/32		.2812	2-1/8	3-1/2	40186	39.85
	7,2	.2835	34	74	40189	41.00
	7,2	.2835	54	89	44267	42.63
	7,4	.2913	34	74	40195	43.79
	7,4	.2913	60	95	44270	45.52
	7,5	.2953	34	74	40197	44.42
	7,5	.2953	60	95	44271	46.20
19/64		.2969	2-3/8	3-3/4	40198	45.68
	7,6	.2992	37	79	40240	44.84
	7,6	.2992	60	95	44272	46.67
	7,8	.3071	37	79	40243	47.88
	7,8	.3071	60	95	44275	49.77
5/16		.3125	2-3/8	3-3/4	40246	47.09
	8	.3150	37	79	40249	47.88
	8	.3150	60	95	44277	49.77
	8,1	.3189	37	79	40252	48.72
	8,1	.3189	60	95	44278	50.72
	8,2	.3228	37	79	40255	49.46
	8,2	.3228	63	101	44279	51.45
21/64		.3281	2-1/2	4	40261	52.19
	8,4	.3307	37	79	40267	51.92
	8,4	.3307	63	101	44282	54.02
Q		.3320	2-1/2	4	40270	53.81
	8,5	.3346	37	79	40273	52.76
	8,5	.3346	63	101	44283	54.97
	8,6	.3386	40	84	40279	53.71
	8,6	.3386	63	101	44284	55.86
11/32		.3438	2-1/2	4	40285	55.28
	8,8	.3465	40	84	40288	56.49
	8,8	.3465	63	101	44287	58.75

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Inch • Metric • Continued

	d_1 Cutter Dia Inch Metric	Dec Equiv	l_2 Flute Length	l_1 Overall Length	EDP Number	List Price
	9	.3543	40	84	40291	60.11
	9	.3543	70	108	44289	62.53
	9,1	.3583	40	84	40294	61.95
	9,1	.3583	70	108	44290	64.47
23/64		.3594	2-3/4	4-1/4	40297	63.05
	9,2	.3622	40	84	40300	62.27
	9,2	.3622	70	108	44291	64.73
	9,5	.3740	40	84	40306	67.25
	9,5	.3740	70	108	44295	69.93
3/8		.3750	2-3/4	4-1/4	40309	66.57
	9,6	.3780	43	89	40312	69.20
	9,6	.3780	70	108	44296	71.87
25/64		.3906	2-7/8	4-1/2	40324	78.86
	10	.3937	43	89	40327	77.44
	10	.3937	73	114	44301	79.80
	10,2	.4016	43	89	40333	80.75
	10,2	.4016	73	114	44303	83.16
13/32		.4062	2-7/8	4-1/2	40339	85.16
	10,4	.4094	43	89	40342	86.00
	10,4	.4094	73	114	44306	88.62
	10,5	.4134	43	89	40345	85.58
	10,5	.4134	73	114	44307	88.15
27/64		.4219	2-7/8	4-1/2	40354	89.36
	10,8	.4252	47	95	40357	92.61
	10,8	.4252	73	114	44311	95.39
	11	.4331	47	95	40360	95.45
	11	.4331	73	114	44313	98.28
7/16		.4375	2-7/8	4-1/2	40363	97.18
	11,5	.4528	47	95	40369	104.90
	11,5	.4528	76	120	44319	108.05
29/64		.4531	3	4-3/4	40372	105.32
	12	.4724	51	102	40378	110.30
	12	.4724	76	120	44325	113.56
	12,5	.4921	51	102	40381	114.03
	12,5	.4921	76	120	44331	117.50
1/2		.5000	3	4-3/4	40384	112.98
	13	.5118	51	102	40387	145.11
	13	.5118	82	127	44336	149.47
	13,5	.5315	54	107	40393	179.97
	13,5	.5315	82	127	44337	185.38
	14	.5512	54	107	40396	172.46
	14	.5512	82	127	44338	177.66
9/16		.5625	3-1/4	5	40399	184.43
	14,5	.5709	56	111	40402	222.65
	14,5	.5709	82	127	44339	229.37
	15	.5906	56	111	40405	213.05
	15	.5906	82	127	44340	219.45
	15,5	.6102	58	115	40408	213.05
	15,5	.6102	82	127	44341	219.45
5/8		.6250	3-1/4	5	40411	208.22
	16	.6299	58	115	40414	192.78
	16	.6299	82	127	44342	198.56