

Legacy

High Performance Solid Carbide Drills



- Premium Submicron Carbide
- PVD TiAlN Coated
 - Available In Short, Long, and Extra-Long Lengths
 - Coolant Through Design



High Performance Design for a Wide Range of Applications

The Legacy provides high performance in a wide variety of materials. It is ideally suited to perform in all general engineering steels, high-alloy and tool steels, cast iron, as well as many stainless steel applications. This reduces inventory needed to machine a broad range of materials.

Double Margin Design

Four margins greatly enhance tool stability. This improves hole geometry and straightness. Stability is provided when inclusions, cross holes, irregular exits, and incline exits are encountered.

Flute Design

The flute design is well matched to the point and provides rapid chip removal enabling high penetration rates.

Lower Thrust Point Design

The 140° point is designed to lower thrust requirements making the tool more versatile in varied work environments.

Coolant-Through Design

Coolant is delivered directly to the point which enables higher cutting speeds and chip loads.

Factory Reconditioning

The high performance experienced with a new tool can be restored through reconditioning to factory tolerances.

In presence of
James O'Connell
John Burgess

Inventor:
Stephen A. Morse

Legacy

Short Length
High Performance Solid Carbide
Coolant-Through Drills
For Steel and Cast Iron

Drill and Shank Diameter Tolerances			
Drill Diameter (D)	Tolerance m7	Shank Diameter (d)	Tolerance h6
3<D≤6 .1181<D≤.2362	+0.004/+0.016 +.0002/+0.006	6 .2362	0.000/-0.008 .0000/-0.003
6<D≤10 .2362<D≤.3937	+0.006/+0.021 +.0002/+0.008	8 - 10 .3150 - .3937	0.000/-0.009 .0000/-0.004
10<D≤18 .3937<D≤.7087	+0.007/+0.025 +.0003/+0.010	12 - 18 .4724 - .7087	0.000/-0.011 .0000/-0.004
18<D .7087<D	+0.008/+0.029 +.0003/+0.011	20 .7874	0.000/-0.013 .0000/-0.005

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



Speeds & Feeds: Page 13

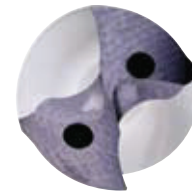
List 5400S Short Coolant Through

INCH	FRACTION	SIZE			DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.
		LETTER	WIRE	METRIC							
5/32			21	4mm	.1562	24	66	6	36	17	52200
				.1575	24	66	6	36	17	52201	
				.1590	24	66	6	36	17	52202	
				.1654	24	66	6	36	17	52203	
				.1772	24	66	6	36	17	52204	
3/16			3	4.8mm	.1875	28	66	6	36	20	52205
				.1890	28	66	6	36	20	52206	
				.1969	28	66	6	36	20	52207	
				.2130	28	66	6	36	20	52208	
				.2165	28	66	6	36	20	52209	
7/32			2	5.8mm	.2188	28	66	6	36	20	52210
				.2210	28	66	6	36	20	52211	
				.2283	28	66	6	36	20	52212	
				.2340	28	66	6	36	20	52213	
				.2362	28	66	6	36	20	52214	
1/4			C	6mm	.2420	34	79	8	36	24	52215
				.2500	34	79	8	36	24	52216	
				.2559	34	79	8	36	24	52217	
				.2570	34	79	8	36	24	52218	
				.2660	34	79	8	36	24	52219	
			E	6.5mm	.2677	34	79	8	36	24	52220
				.2720	34	79	8	36	24	52221	
				.2756	34	79	8	36	24	52222	
				.2770	34	79	8	36	24	52223	
				.2812	34	79	8	36	24	52224	
9/32			F	7mm	.2812	41	79	8	36	29	52225
				.2953	41	79	8	36	29	52226	
				.2969	41	79	8	36	29	52227	
				.3125	41	79	8	36	29	52228	
				.3150	41	79	8	36	29	52229	
5/16			H	8mm	.3230	47	89	10	40	35	52229

(continued)

Legacy

Short Length High Performance Solid Carbide Coolant-Through Drills For Steel and Cast Iron



Low Thrust Point Design.
Honed Cutting Edges

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



(continued)

List 5400S Short Coolant Through

INCH	FRACTION	SIZE			DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.
		LETTER	WIRE	METRIC							
.3810	21/64	Q			.3281	47	89	10	40	35	52230
					.3320	47	89	10	40	35	52231
		8.5mm		.3346	47	89	10	40	35	52232	
		9mm		.3543	47	89	10	40	35	52233	
	23/64			.3594	47	89	10	40	35	52234	
			U		.3680	47	89	10	40	35	52235
.3810	3/8				.3740	47	89	10	40	35	52236
			9.5mm		.3750	47	89	10	40	35	52237
	25/64				.3810	47	89	10	40	35	52238
			10mm		.3906	47	89	10	40	35	52239
	13/32				.3937	47	89	10	40	35	52240
			10.5mm		.4062	55	102	12	45	40	52241
.5050	27/64				.4134	55	102	12	45	40	52242
			11mm		.4219	55	102	12	45	40	52243
	7/16				.4331	55	102	12	45	40	52244
			11.5mm		.4375	55	102	12	45	40	52245
	15/32				.4528	55	102	12	45	40	52246
			12mm		.4688	55	102	12	45	40	52247
.5050	1/2				.4724	55	102	12	45	40	52248
			12.5mm		.4921	60	107	14	45	43	52249
	9/16				.5000	60	107	14	45	43	52250
			13mm		.5050	60	107	14	45	43	52251
	5/8				.5118	60	107	14	45	43	52252
			13.5mm		.5315	60	107	14	45	43	52253
.6330	3/4				.5512	60	107	14	45	43	52254
			14mm		.5625	65	115	16	48	45	52255
	9/16				.5709	65	115	16	48	45	52256
			14.5mm		.5906	65	115	16	48	45	52257
	5/8				.6250	65	115	16	48	45	52258
			15mm		.6299	65	115	16	48	45	52259
3/4				.6330	73	123	18	48	51	52260	
		16mm		.7500	79	131	20	50	55	52261	

LEGACY High Performance Carbide Drills