

CHAMPION

CUTTING TOOL CORP

2015

1897

Innovative Cutting Tool Solutions



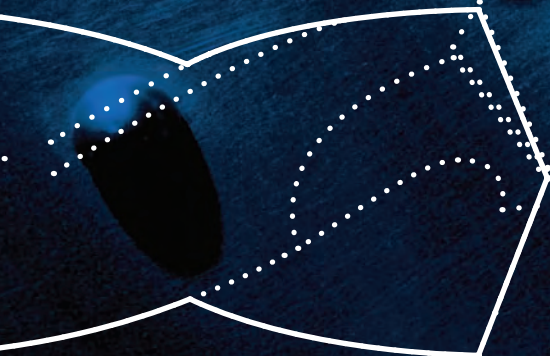


Innovative Cutting Tool Solutions

With over 100 years of market leading experience, Champion Cutting Tool Corp has been at the forefront of cutting tool knowledge and design. Innovative solutions provide tools that increase productivity and deliver exceptional results. Our flagship brands include Champion, Brute Platinum, ProLine and RotoBrute which are engineered to last longer, cut more holes and deliver better work-piece finish. We strive to offer the highest quality of customer care by providing personal technical support, product training, high order fill-rates and same-day shipping. Our distribution network serves cutting tool users in all 50 states in the U.S. Canada, Central and South America with a focus on manufacturing, steel fabrication, construction, and welding.



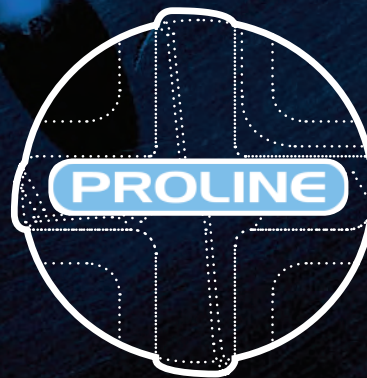
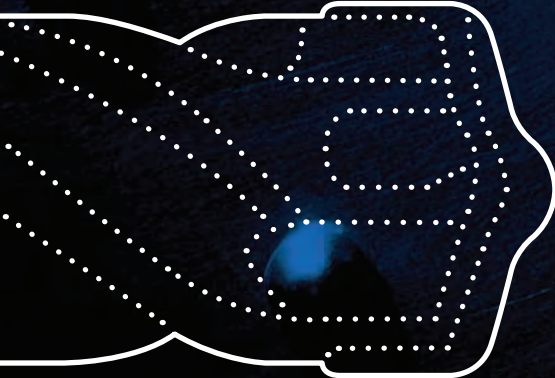
Champion cutting tools are as sophisticated as the machines that run them. Material selection, metallurgy and tool geometry are engineered to give you dependable performance and long life. Twist drills are manufactured to exacting standards that yield the lowest cost per hole; taps that provide you with close tolerance threads in high speed tapping heads; titanium nitride coated carbide burs for long life and smooth finish; reamers including bridge reamers, hand reamers, chucking reamers and chassis reamers for aligning and enlarging holes.



The Brute product range is rugged, cutting faster with increased durability. Brute Platinum drills, taps, reamers, countersinks and end mills are engineered for tough materials and environments. Champion's Brute drill was developed to outperform costly cobalt drills. The combination of quality raw materials, geometries and surface treatments provide consistent high quality for repeatable high performance.



RotoBrute is the quick and easy hole-making system for cutting large diameter holes in structural steel beams and plate. The RotoBrute drilling system features a complete line of magnetic drill presses and high-speed steel and carbide tipped annular cutters, engineered to drill large diameter holes in structural steel from 7/16" to 4" diameter.



Champion's ProLine includes over 500 sizes of hammer bits, masonry drills, diamond hole-cutters, core drills and steel chisels for the professional who needs to quickly penetrate a variety of materials including steel, concrete, wood and non-ferrous abrasive materials.

Your Productivity & Service Partner

CHAMPION
CUTTING TOOL CORP

INDUSTRY LEADER

Our broad range of industrial quality products deliver customer solutions in virtually every industry. An experienced management team with decades of industry expertise continues to execute the vision of the Company's founders.

INNOVATION

Providing tools that increase productivity and deliver exceptional results is what drives our team. Consistent flow of innovative, cutting edge products helps Champion lead the way by saving our customers time and money.

DEDICATED CUSTOMER SERVICE

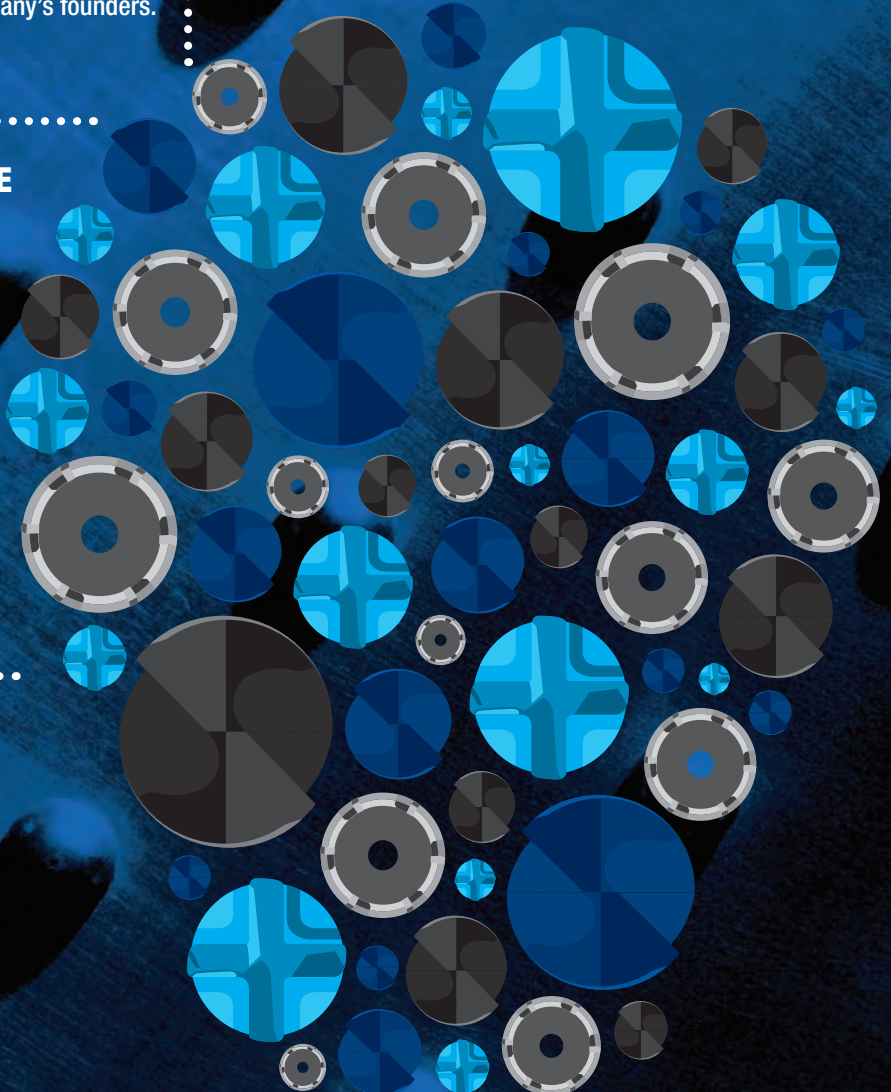
Our passionate team goes the extra mile to provide outstanding customer service. Knowledgeable cutting tool experts trained to answer product and application questions ensures our customers select the proper tool to meet their needs. Historical order fill-rates of 99% coupled with the same-day shipping results in a positive customer experience.

MERCHANDISING SOLUTIONS

In-store merchandising solutions to ensure cutting tools are organized and attractive. Display modules and signage designed to enhance your showroom regardless of space limitations. Tap into our expertise and we will help mix and match the right cutting tool modules to cater to the professionals, industries, markets or trades you serve.

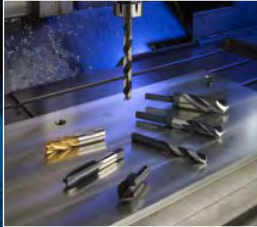
WEB TECHNICAL SUPPORT

Easy-to-find links to product information, technical documentation, instructional videos, product literature, comprehensive list of frequently asked questions and product documentation.



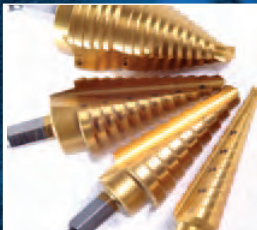


Product Overview



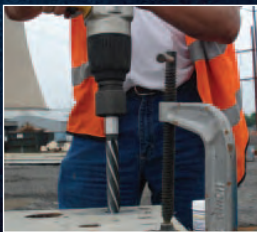
DRILLS

Industrial quality consistently measuring up to the highest standards. Available in high-speed steel, cobalt and carbide suit the application needed. From #80 micro-drills which are the width of a hair to 3-1/2" taper shank drills – all are designed for generating the lowest cost per hole.



STEP DRILLS

Titanium nitride coated, hex shank, split point, two-flute step drills provide fast accurate drilling of multiple diameters with one cutting tool. Excellent in electrical, plumbing and professional trades.



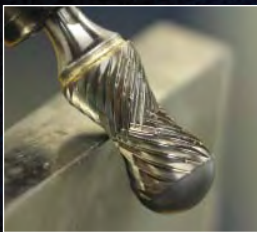
REAMERS

Align, de-bur and enlarge holes with an extensive range of bridge reamers, car reamers, adjustable blade reamers and chucking reamers.



CARBIDE TIPPED HOLE CUTTERS

The best method for drilling holes in 1/8" sheet metal or steel plate up to 1" thick. CT3, CT5 and CT7 hole cutters give you quick, clean, bur-free holes in seconds.



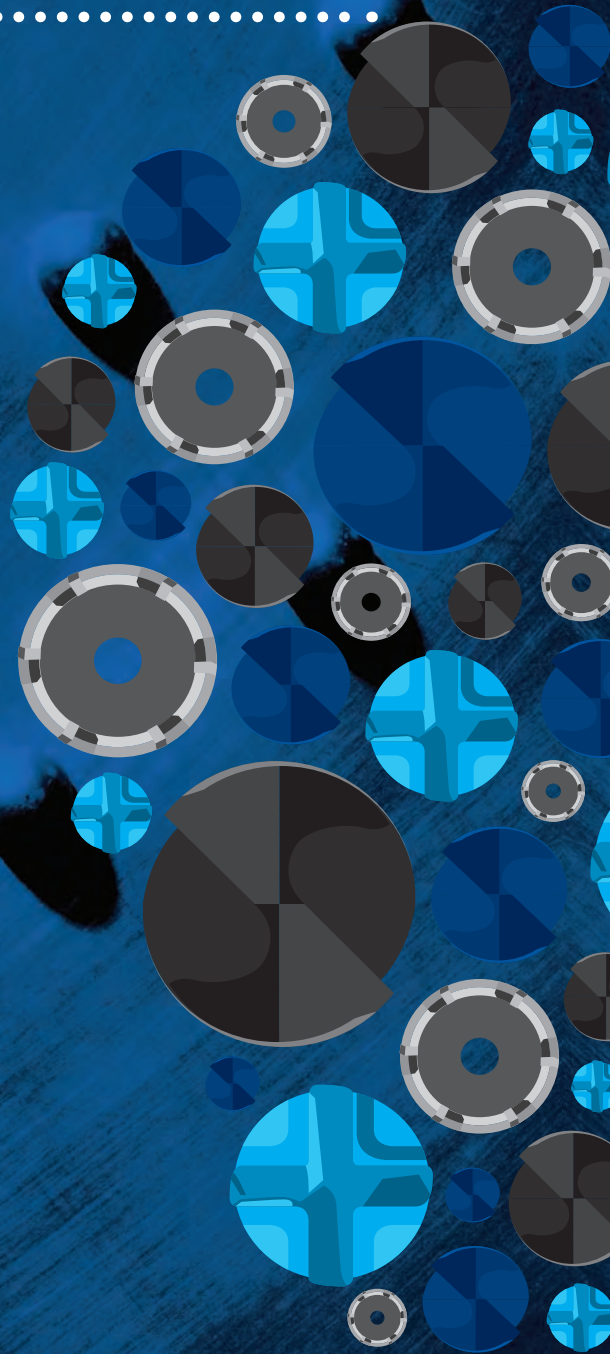
BURS

New combi burs and radius burs for industries from aerospace to automotive, transportation, defense, and welding industries. Over 250 sizes of double-cut, long, miniature burs, and bur kits.



COUNTERSINKS

Zero flute, single flute, and three flute countersinks for fixed and portable countersinking, chamfering and de-burring.



Product Overview

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THREADING TOOLS

High-speed steel and carbon steel hand taps, spiral point taps, pipe taps and dies, tap and die sets, and Brute XL22 heavy-duty spiral point taps for threading tough alloys. This range of tools is ideal for applications where extreme thread accuracy and tolerance is critical.



END MILLS

New Brute Platinum XLVC and XLVR high-performance end mills for milling tough materials fast and smooth, with accurate results. Full range of end mills in HSS, cobalt, and solid carbide end mills for machining in Bridgeport-type or CNC milling machines.



MAGNETIC DRILL PRESSES

The quickest method for drilling large diameter holes. RB30 low-profile for truck frame drilling, AC50 for versatile use of twist drills and annular cutters. Reliability and performance under heavy duty use, in the shop or in the field.



ANNULAR CUTTERS

RotoBrute carbide tipped and high-speed steel annular cutters are the choice of steel fabricators when drilling large diameter holes in steel in structural steel beams, plate, in the shop or in the field.



MASONRY DRILLS AND CHISELS

Over 500 sizes of hammer bits and steel chisels including SDS Plus, SDS-Max, spline, core, and PTC3 tile drills.



SETS

From Tap & Die Sets to Bur Kits to Reamer Sets to Silver & Deming Sets – Champion offers an array of sets for the mechanical, electrical and professional trades.

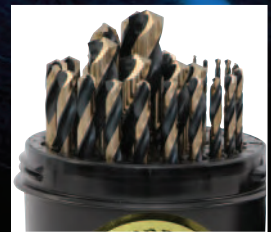


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Sheet Metal Cutters









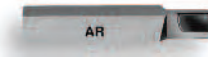
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Taps & Dies

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ProLine Masonry Drills and Hammer Chisels

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Cutting Tool Sets / Distributor Support / Technical Support

CHAMPION
BAUTE
PLATINUM

Drill Sets



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CHAMPION
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**Taper Shank Drill Sets
Silver & Deming Drill Sets
LH Drill & Screw Extractor Sets**



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CHAMPION
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**Screw Extractor Sets
Tap & Drill Indexes
Combination Drill & Tap Sets**




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CHAMPION

**Tap & Die Sets
Tap Kits
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CHAMPION

**Step Drill Sets
Carbide Bur Sets
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CHAMPION
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Carbide Tipped Hole Cutter Sets



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CHAMPION
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**Countersink Sets
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PROLINE

**Drill Displays
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CHAMPION

**Distributor Support
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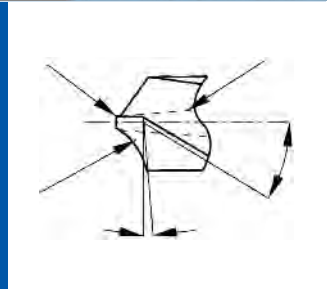


CHAMPION

**Technical
Technical Tips
Material Applications
Speeds, Feeds & Dimensions**



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Jobber Drills

List No. XL5

Straight Shank / Heavy Duty / Black & Bright Finish /
135° Split Point / NOMO® Surface Treatment / HSS



Description: Unique web geometry, especially useful in portable drilling of stainless steel, titanium alloys, and other hard to drill materials.

Application: Steel erection, mining, heavy construction. Used in a wide range of manufacturing plants, vehicle, railway and dockyard maintenance.



Brute Platinum XL5 Heavy Duty Jobber Drills

Field tests have proven Brute Platinum XL5 drills penetrate faster than cobalt. Users state lower fatigue levels, since less force is required to drill. Less breakage is also reported due to its unique "toughness: hardness" ratio, enabling them to flex when cobalt drills chip or snap.

Precision ground 135° split point eliminates the need for pilot hole drilling. Prevents "walking" and bites right into #300 and #400 series stainless steels.



Brute Platinum XL5 Jobber Drill Sets - see pages 140 & 141 for the full range

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XL5-1/16**	.0625	7/8	1-7/8
XL5-52	.0635	7/8	1-7/8
XL5-51	.0670	1	2
XL5-50	.0700	1	2
XL5-49	.0730	1	2
XL5-48	.0760	1	2
XL5-5/64**	.0781	1	2
XL5-47	.0785	1	2
XL5-46	.0810	1-1/8	2-1/8
XL5-45	.0820	1-1/8	2-1/8
XL5-44	.0860	1-1/8	2-1/8
XL5-43	.0890	1-1/4	2-1/4
XL5-42	.0935	1-1/4	2-1/4
XL5-3/32**	.0938	1-1/4	2-1/4
XL5-41	.0960	1-3/8	2-3/8
XL5-40	.0980	1-3/8	2-3/8
XL5-39	.0995	1-3/8	2-3/8
XL5-38	.1015	1-7/16	2-1/2
XL5-37	.1040	1-7/16	2-1/2
XL5-36†	.1065	1-7/16	2-1/2
XL5-7/64**	.1094	1-1/2	2-5/8
XL5-35	.1100	1-1/2	2-5/8
XL5-34	.1110	1-1/2	2-5/8
XL5-33	.1130	1-1/2	2-5/8
XL5-32	.1160	1-5/8	2-3/4
XL5-31	.1200	1-5/8	2-3/4
XL5-1/8**	.1250	1-5/8	2-3/4
XL5-30	.1285	1-5/8	2-3/4
XL5-29†	.1360	1-3/4	2-7/8
XL5-28	.1405	1-3/4	2-7/8
XL5-9/64**	.1406	1-3/4	2-7/8
XL5-27	.1440	1-7/8	3
XL5-26	.1470	1-7/8	3
XL5-25†	.1495	1-7/8	3
XL5-24	.1520	2	3-1/8
XL5-23	.1540	2	3-1/8
XL5-5/32**	.1562	2	3-1/8
XL5-22	.1570	2	3-1/8
XL5-21†	.1590	2-1/8	3-1/4
XL5-20	.1610	2-1/8	3-1/4
XL5-19	.1660	2-1/8	3-1/4
XL5-18	.1695	2-1/8	3-1/4
XL5-11/64*	.1719	2-1/8	3-1/4
XL5-17	.1730	2-3/16	3-3/8
XL5-16†	.1770	2-3/16	3-3/8
XL5-15	.1800	2-3/16	3-3/8
XL5-14	.1820	2-3/16	3-3/8



List No. XL5 continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XL5-13	.1850	2-5/16	3-1/2
XL5-3/16*	.1875	2-5/16	3-1/2
XL5-12	.1890	2-5/16	3-1/2
XL5-11	.1910	2-5/16	3-1/2
XL5-10	.1935	2-7/16	3-5/8
XL5-9	.1960	2-7/16	3-5/8
XL5-8	.1990	2-7/16	3-5/8
XL5-7†	.2010	2-7/16	3-5/8
XL5-13/64*	.2031	2-7/16	3-5/8
XL5-6	.2040	2-1/2	3-3/4
XL5-5	.2055	2-1/2	3-3/4
XL5-4	.2090	2-1/2	3-3/4
XL5-3	.2130	2-1/2	3-3/4
XL5-7/32*	.2188	2-1/2	3-3/4
XL5-2	.2210	2-5/8	3-7/8
XL5-1	.2280	2-5/8	3-7/8
XL5-A	.2340	2-5/8	3-7/8
XL5-15/64*	.2344	2-5/8	3-7/8
XL5-B	.2380	2-3/4	4
XL5-C	.2420	2-3/4	4
XL5-D	.2460	2-3/4	4
XL5-1/4/E*	.2500	2-3/4	4
XL5-F†	.2570	2-7/8	4-1/8
XL5-G	.2610	2-7/8	4-1/8
XL5-17/64*	.2656	2-7/8	4-1/8
XL5-H	.2660	2-7/8	4-1/8
XL5-I	.2720	2-7/8	4-1/8
XL5-J	.2770	2-7/8	4-1/8
XL5-K	.2810	2-15/16	4-1/4
XL5-9/32*	.2812	2-15/16	4-1/4
XL5-L	.2900	2-15/16	4-1/4
XL5-M	.2950	3-1/16	4-3/8
XL5-19/64*	.2969	3-1/16	4-3/8
XL5-N	.3020	3-1/16	4-3/8
XL5-5/16*†	.3125	3-3/16	4-1/2
XL5-O	.3160	3-3/16	4-1/2
XL5-P	.3230	3-5/16	4-5/8
XL5-21/64*	.3281	3-5/16	4-5/8
XL5-Q	.3320	3-7/16	4-3/4
XL5-R	.3390	3-7/16	4-3/4
XL5-11/32*	.3438	3-7/16	4-3/4
XL5-S	.3480	3-1/2	4-7/8
XL5-T	.3580	3-1/2	4-7/8
XL5-23/64*	.3594	3-1/2	4-7/8
XL5-U†	.3680	3-5/8	5
XL5-3/8	.3750	3-5/8	5
XL5-V	.3770	3-5/8	5

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XL5-W	.3860	3-3/4	5-1/8
XL5-25/64*	.3906	3-3/4	5-1/8
XL5-X	.3970	3-3/4	5-1/8
XL5-Y	.4040	3-7/8	5-1/4
XL5-13/32*	.4062	3-7/8	5-1/4
XL5-Z	.4130	3-7/8	5-1/4
XL5-27/64*†	.4219	3-15/16	5-3/8
XL5-7/16*	.4375	4-1/16	5-1/2
XL5-29/64*	.4531	4-3/16	5-5/8
XL5-15/32*	.4688	4-5/16	5-3/4
XL5-31/64*	.4844	4-3/8	5-7/8
XL5-1/2*	.5000	4-1/2	6

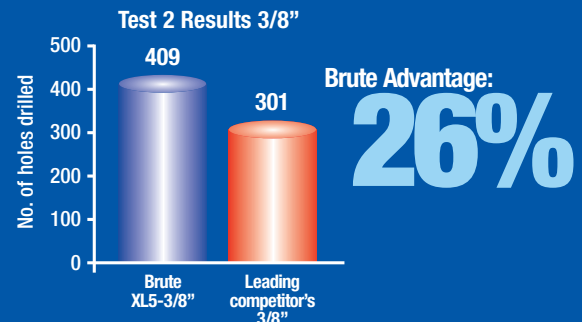
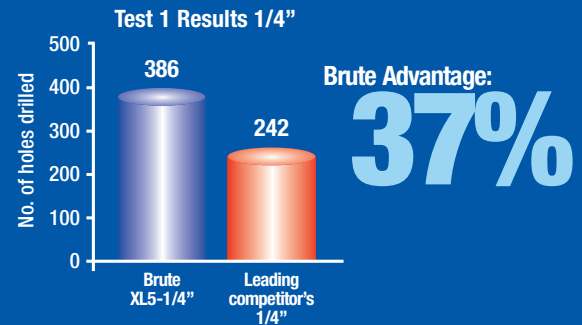
ipac ** Available in iPac twin pack
 * Available in iPac
 † Available in iPac combination drill and tap pack (308 Taps)

Brute Drill Performance Analysis

XL5 Jobber Drill

Test parameters

- Material Drilled: 4340 Alloy Steel, 1/2" thick (1/4" drills), 3/4" thick (3/8" drills)
- Machinery: Fixed CNC Drilling Machine, 458 rpm, 3.2 inches feed/minute



Observations: Competitor's drill walked on surface of material, while Brute drill bit right into steel.

CHAMPION

BlackGold® Jobber Drills



List No. XGO

Straight Shank / Heavy Duty / Black & Gold Finish /
135° Split Point / HSS

Description: Outperform ordinary jobber drills by penetrating faster and lasting longer. The functional black and gold surface treatment holds lubricant for smoother drilling. XGO jobbers meet NAS 907B aircraft specifications and are also available with 3/8" shank (see XG38 series).

Application: Recommended for drilling high tensile alloy steels & stainless steels. Very popular in truck and trailer manufacturing.



See XGO drill sets on pages 140 & 141

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XGO-36†	.1065	1-7/16	2-1/2
XGO-7/64**	.1094	1-1/2	2-5/8
XGO-35	.1100	1-1/2	2-5/8
XGO-34	.1110	1-1/2	2-5/8
XGO-33	.1130	1-1/2	2-5/8
XGO-32	.1160	1-5/8	2-3/4
XGO-31	.1200	1-5/8	2-3/4
XGO-1/8**	.1250	1-5/8	2-3/4
XGO-30	.1285	1-5/8	2-3/4
XGO-29†	.1360	1-3/4	2-7/8
XGO-28	.1405	1-3/4	2-7/8
XGO-9/64**	.1406	1-3/4	2-7/8
XGO-27	.1440	1-7/8	3
XGO-26	.1470	1-7/8	3
XGO-25†	.1495	1-7/8	3
XGO-24	.1520	2	3-1/8
XGO-23	.1540	2	3-1/8
XGO-5/32**	.1562	2	3-1/8
XGO-22	.1570	2	3-1/8
XGO-21†	.1590	2-1/8	3-1/4
XGO-20	.1610	2-1/8	3-1/4
XGO-19	.1660	2-1/8	3-1/4
XGO-18	.1695	2-1/8	3-1/4
XGO-11/64*	.1719	2-1/8	3-1/4
XGO-17	.1730	2-3/16	3-3/8
XGO-16†	.1770	2-3/16	3-3/8
XGO-15	.1800	2-3/16	3-3/8
XGO-14	.1820	2-3/16	3-3/8
XGO-13	.1850	2-5/16	3-1/2
XGO-3/16*	.1875	2-5/16	3-1/2
XGO-12	.1890	2-5/16	3-1/2
XGO-11	.1910	2-5/16	3-1/2
XGO-10	.1935	2-7/16	3-5/8
XGO-9	.1960	2-7/16	3-5/8
XGO-8	.1990	2-7/16	3-5/8
XGO-7†	.2010	2-7/16	3-5/8
XGO-13/64*	.2031	2-7/16	3-5/8
XGO-6	.2040	2-1/2	3-3/4
XGO-5	.2055	2-1/2	3-3/4
XGO-4	.2090	2-1/2	3-3/4
XGO-3	.2130	2-1/2	3-3/4
XGO-7/32*	.2188	2-1/2	3-3/4
XGO-2	.2210	2-5/8	3-7/8
XGO-1	.2280	2-5/8	3-7/8
XGO-A	.2340	2-5/8	3-7/8
XGO-15/64*	.2344	2-5/8	3-7/8
XGO-B	.2380	2-3/4	4

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XGO-60***	.0400	11/16	1-5/8
XGO-59***	.0410	11/16	1-5/8
XGO-58***	.0420	11/16	1-5/8
XGO-57***	.0430	3/4	1-3/4
XGO-56***	.0465	3/4	1-3/4
XGO-55***	.0520	7/8	1-7/8
XGO-54***	.0550	7/8	1-7/8
XGO-53***	.0595	7/8	1-7/8
XGO-1/16**	.0625	7/8	1-7/8
XGO-52	.0635	7/8	1-7/8
XGO-51	.0670	1	2
XGO-50	.0700	1	2
XGO-49	.0730	1	2
XGO-48	.0760	1	2
XGO-5/64**	.0781	1	2
XGO-47	.0785	1	2
XGO-46	.0810	1-1/8	2-1/8
XGO-45	.0820	1-1/8	2-1/8
XGO-44	.0860	1-1/8	2-1/8
XGO-43	.0890	1-1/4	2-1/4
XGO-42	.0935	1-1/4	2-1/4
XGO-3/32**	.0938	1-1/4	2-1/4
XGO-41	.0960	1-3/8	2-3/8
XGO-40	.0980	1-3/8	2-3/8
XGO-39	.0995	1-3/8	2-3/8
XGO-38	.1015	1-7/16	2-1/2
XGO-37	.1040	1-7/16	2-1/2

*** No split point



** Available in iPac twin pack

* Available in iPac

† Available in iPac combination drill and tap pack (308 Taps)

CHAMPION

List No. XGO continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XGO-C	.2420	2-3/4	4
XGO-D	.2460	2-3/4	4
XGO-1/4/E*	.2500	2-3/4	4
XGO-F	.2570	2-7/8	4-1/8
XGO-G	.2610	2-7/8	4-1/8
XGO-17/64*	.2656	2-7/8	4-1/8
XGO-H	.2660	2-7/8	4-1/8
XGO-I	.2720	2-7/8	4-1/8
XGO-J	.2770	2-7/8	4-1/8
XGO-K	.2810	2-15/16	4-1/4
XGO-9/32*	.2812	2-15/16	4-1/4
XGO-L	.2900	2-15/16	4-1/4
XGO-M	.2950	3-1/16	4-3/8
XGO-19/64*	.2969	3-1/16	4-3/8
XGO-N	.3020	3-1/16	4-3/8
XGO-5/16**	.3125	3-3/16	4-1/2
XGO-O	.3160	3-3/16	4-1/2
XGO-P	.3230	3-5/16	4-5/8
XGO-21/64*	.3281	3-5/16	4-5/8
XGO-Q	.3320	3-7/16	4-3/4

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XGO-R	.3390	3-7/16	4-3/4
XGO-11/32*	.3438	3-7/16	4-3/4
XGO-S	.3480	3-1/2	4-7/8
XGO-T	.3580	3-1/2	4-7/8
XGO-23/64*	.3594	3-1/2	4-7/8
XGO-U†	.3680	3-5/8	5
XGO-3/8	.3750	3-5/8	5
XGO-V	.3770	3-5/8	5
XGO-W	.3860	3-3/4	5-1/8
XGO-25/64*	.3906	3-3/4	5-1/8
XGO-X	.3970	3-3/4	5-1/8
XGO-Y	.4040	3-7/8	5-1/4
XGO-13/32*	.4062	3-7/8	5-1/4
XGO-Z	.4130	3-7/8	5-1/4
XGO-27/64**	.4219	3-15/16	5-3/8
XGO-7/16*	.4375	4-1/16	5-1/2
XGO-29/64*	.4531	4-3/16	5-5/8
XGO-15/32*	.4688	4-5/16	5-3/4
XGO-31/64*	.4844	4-3/8	5-7/8
XGO-1/2*	.5000	4-1/2	6

CHAMPION

Titanium Nitride Coated Jobber Drills

List No. 700T

Straight Shank / 135° Split Point* / HSS



Description: Titanium Nitride coating provides a surface hardness in excess of 80 Rockwell C scale, protecting the cutting edge from abrasion, and a protective shield against damaging heat generated at the cutting edge. The benefit is prolonged sharpness and durability of drill, allowing substantially higher speed and feed rates.

Application: Ideal for low to high carbon steels, alloyed steels, steel drop forgings, grey cast iron, titanium, stainless steel, nimonic alloys, manganese, spring steels and armor plate.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
700T-1/16	.0625	7/8	1-7/8
700T-5/64	.0781	1	2
700T-3/32	.0938	1-1/4	2-1/4
700T-40	.0980	1-3/8	2-3/8
700T-39	.0995	1-3/8	2-3/8
700T-38	.1015	1-7/16	2-1/2
700T-37	.1040	1-7/16	2-1/2
700T-36	.1065	1-7/16	2-1/2
700T-7/64	.1094	1-1/2	2-5/8
700T-35	.1100	1-1/2	2-5/8
700T-34	.1110	1-1/2	2-5/8
700T-33	.1130	1-1/2	2-5/8

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
700T-32	.1160	1-5/8	2-3/4
700T-31	.1200	1-5/8	2-3/4
700T-1/8	.1250	1-5/8	2-3/4
700T-30	.1285	1-5/8	2-3/4
700T-29	.1360	1-3/4	2-7/8
700T-28	.1405	1-3/4	2-7/8
700T-9/64	.1406	1-3/4	2-7/8
700T-27	.1440	1-7/8	3
700T-26	.1470	1-7/8	3
700T-25	.1495	1-7/8	3
700T-24	.1520	2	3-1/8
700T-23	.1540	2	3-1/8

Note: Wire gauge sizes 1 through 40 are all 118° point.

CHAMPION
CUTTING TOOL CORP.

CHAMPION

List No. 700T continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
700T-5/32	.1562	2	3-1/8	700T-3	.2130	2-1/2	3-3/4
700T-22	.1570	2	3-1/8	700T-7/32	.2188	2-1/2	3-3/4
700T-21	.1590	2-1/8	3-1/4	700T-2	.2210	2-5/8	3-7/8
700T-20	.1610	2-1/8	3-1/4	700T-1	.2280	2-5/8	3-7/8
700T-19	.1660	2-1/8	3-1/4	700T-15/64	.2344	2-5/8	3-7/8
700T-18	.1695	2-1/8	3-1/4	700T-1/4	.2500	2-3/4	4
700T-11/64	.1719	2-1/8	3-1/4	700T-17/64	.2656	2-7/8	4-1/8
700T-17	.1730	2-3/16	3-3/8	700T-9/32	.2812	2-15/16	4-1/4
700T-16	.1770	2-3/16	3-3/8	700T-19/64	.2969	3-1/16	4-3/8
700T-15	.1800	2-3/16	3-3/8	700T-5/16	.3125	3-3/16	4-1/2
700T-14	.1820	2-3/16	3-3/8	700T-21/64	.3281	3-5/16	4-5/8
700T-13	.1850	2-5/16	3-1/2	700T-11/32	.3438	3-7/16	4-3/4
700T-3/16	.1875	2-5/16	3-1/2	700T-23/64	.3594	3-1/2	4-7/8
700T-12	.1890	2-5/16	3-1/2	700T-3/8	.3750	3-5/8	5
700T-11	.1910	2-5/16	3-1/2	700T-25/64	.3906	3-3/4	5-1/8
700T-10	.1935	2-7/16	3-5/8	700T-13/32	.4062	3-7/8	5-1/4
700T-9	.1960	2-7/16	3-5/8	700T-27/64	.4219	3-15/16	5-3/8
700T-8	.1990	2-7/16	3-5/8	700T-7/16	.4375	4-1/16	5-1/2
700T-7	.2010	2-7/16	3-5/8	700T-29/64	.4531	4-3/16	5-5/8
700T-13/64	.2031	2-7/16	3-5/8	700T-15/32	.4688	4-5/16	5-3/4
700T-6	.2040	2-1/2	3-3/4	700T-31/64	.4844	4-3/8	5-7/8
700T-5	.2055	2-1/2	3-3/4	700T-1/2	.5000	4-1/2	6
700T-4	.2090	2-1/2	3-3/4				

Note: Wire gauge sizes 1 through 40 are all 118° point.

CHAMPION

Heavy Duty Jobber Drills

List No. 705SP

Type NAS907-B / Straight Shank /
135° Split Point / Steam Oxide Treated / HSS



Description: Heavy duty 135° split point for self centering and quick penetration. Heavy duty web geometry provides added rigidity.

Application: Recommended for drilling high tensile martensitic stainless steels, titanium alloys and hard steel. Very popular in truck and trailer manufacturing.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
705SP-60	.0400	11/16	1-5/8	705SP-52	.0635	7/8	1-7/8
705SP-59	.0410	11/16	1-5/8	705SP-51	.0670	1	2
705SP-58	.0420	11/16	1-5/8	705SP-50	.0700	1	2
705SP-57	.0430	3/4	1-3/4	705SP-49	.0730	1	2
705SP-56	.0465	3/4	1-3/4	705SP-48	.0760	1	2
705SP-3/64	.0469	3/4	1-3/4	705SP-5/64	.0781	1	2
705SP-55	.0520	7/8	1-7/8	705SP-47	.0785	1	2
705SP-54	.0550	7/8	1-7/8	705SP-46	.0810	1-1/8	2-1/8
705SP-53	.0595	7/8	1-7/8	705SP-45	.0820	1-1/8	2-1/8
705SP-1/16	.0625	7/8	1-7/8	705SP-44	.0860	1-1/8	2-1/8

Note: Wire gauge sizes 53 through 60 are not split point.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705SP-43	.0890	1-1/4	2-1/4
705SP-42	.0935	1-1/4	2-1/4
705SP-3/32	.0938	1-1/4	2-1/4
705SP-41	.0960	1-3/8	2-3/8
705SP-40	.0980	1-3/8	2-3/8
705SP-39	.0995	1-3/8	2-3/8
705SP-38	.1015	1-7/16	2-1/2
705SP-37	.1040	1-7/16	2-1/2
705SP-36	.1065	1-7/16	2-1/2
705SP-7/64	.1094	1-1/2	2-5/8
705SP-35	.1100	1-1/2	2-5/8
705SP-34	.1110	1-1/2	2-5/8
705SP-33	.1130	1-1/2	2-5/8
705SP-32	.1160	1-5/8	2-3/4
705SP-31	.1200	1-5/8	2-3/4
705SP-1/8	.1250	1-5/8	2-3/4
705SP-30	.1285	1-5/8	2-3/4
705SP-29	.1360	1-3/4	2-7/8
705SP-28	.1405	1-3/4	2-7/8
705SP-9/64	.1406	1-3/4	2-7/8
705SP-27	.1440	1-7/8	3
705SP-26	.1470	1-7/8	3
705SP-25	.1495	1-7/8	3
705SP-24	.1520	2	3-1/8
705SP-23	.1540	2	3-1/8
705SP-5/32	.1562	2	3-1/8
705SP-22	.1570	2	3-1/8
705SP-21	.1590	2-1/8	3-1/4
705SP-20	.1610	2-1/8	3-1/4
705SP-19	.1660	2-1/8	3-1/4
705SP-18	.1695	2-1/8	3-1/4
705SP-11/64	.1719	2-1/8	3-1/4
705SP-17	.1730	2-3/16	3-3/8
705SP-16	.1770	2-3/16	3-3/8
705SP-15	.1800	2-3/16	3-3/8
705SP-14	.1820	2-3/16	3-3/8
705SP-13	.1850	2-5/16	3-1/2
705SP-3/16	.1875	2-5/16	3-1/2
705SP-12	.1890	2-5/16	3-1/2
705SP-11	.1910	2-5/16	3-1/2
705SP-10	.1935	2-7/16	3-5/8
705SP-9	.1960	2-7/16	3-5/8
705SP-8	.1990	2-7/16	3-5/8
705SP-7	.2010	2-7/16	3-5/8
705SP-13/64	.2031	2-7/16	3-5/8
705SP-6	.2040	2-1/2	3-3/4
705SP-5	.2055	2-1/2	3-3/4

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705SP-4	.2090	2-1/2	3-3/4
705SP-3	.2130	2-1/2	3-3/4
705SP-7/32	.2188	2-1/2	3-3/4
705SP-2	.2210	2-5/8	3-7/8
705SP-1	.2280	2-5/8	3-7/8
705SP-A	.2340	2-5/8	3-7/8
705SP-15/64	.2344	2-5/8	3-7/8
705SP-B	.2380	2-3/4	4
705SP-C	.2420	2-3/4	4
705SP-D	.2460	2-3/4	4
705SP-1/4/E	.2500	2-3/4	4
705SP-F	.2570	2-7/8	4-1/8
705SP-G	.2610	2-7/8	4-1/8
705SP-17/64	.2656	2-7/8	4-1/8
705SP-H	.2660	2-7/8	4-1/8
705SP-I	.2720	2-7/8	4-1/8
705SP-J	.2770	2-7/8	4-1/8
705SP-K	.2810	2-15/16	4-1/4
705SP-9/32	.2812	2-15/16	4-1/4
705SP-L	.2900	2-15/16	4-1/4
705SP-M	.2950	3-1/16	4-3/8
705SP-19/64	.2969	3-1/16	4-3/8
705SP-N	.3020	3-1/16	4-3/8
705SP-5/16	.3125	3-3/16	4-1/2
705SP-O	.3160	3-3/16	4-1/2
705SP-P	.3230	3-5/16	4-5/8
705SP-21/64	.3281	3-5/16	4-5/8
705SP-Q	.3320	3-7/16	4-3/4
705SP-R	.3390	3-7/16	4-3/4
705SP-11/32	.3438	3-7/16	4-3/4
705SP-S	.3480	3-1/2	4-7/8
705SP-T	.3580	3-1/2	4-7/8
705SP-23/64	.3594	3-1/2	4-7/8
705SP-U	.3680	3-5/8	5
705SP-3/8	.3750	3-5/8	5
705SP-V	.3770	3-5/8	5
705SP-W	.3860	3-3/4	5-1/8
705SP-25/64	.3906	3-3/4	5-1/8
705SP-X	.3970	3-3/4	5-1/8
705SP-Y	.4040	3-7/8	5-1/4
705SP-13/32	.4062	3-7/8	5-1/4
705SP-Z	.4130	3-7/8	5-1/4
705SP-27/64	.4219	3-15/16	5-3/8
705SP-7/16	.4375	4-1/16	5-1/2
705SP-29/64	.4531	4-3/16	5-5/8
705SP-15/32	.4688	4-5/16	5-3/4
705SP-31/64	.4844	4-3/8	5-7/8
705SP-1/2	.5000	4-1/2	6

CHAMPION

General Purpose Jobber Drills List No. 705 - Steam Oxide Treated

Straight Shank / 118° Point / HSS



List No. 405* - Bright Finish

Straight Shank / 118° Point / HSS



Description: Designed for general purpose drilling, Series 705 drills are surface treated with black oxide finish for abrasion resistance and improved coolant adherence.

Series 405 are often used in drilling non-ferrous materials such as aluminum, magnesium, brass and bronze.

Application: General purpose drill, used in all types of materials. Low carbon steels, alloyed steels, steel drop forgings and armor plate.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705-80	.0135	1/8	3/4	705-44	.0860	1-1/8	2-1/8
705-79	.0145	1/8	3/4	705-43	.0890	1-1/4	2-1/4
705-1/64	.0156	3/16	3/4	705-42	.0935	1-1/4	2-1/4
705-78	.0160	3/16	7/8	705-3/32	.0938	1-1/4	2-1/4
705-77	.0180	3/16	7/8	705-41	.0960	1-3/8	2-3/8
705-76	.0200	3/16	7/8	705-40	.0980	1-3/8	2-3/8
705-75	.0210	1/4	1	705-39	.0995	1-3/8	2-3/8
705-74	.0225	1/4	1	705-38	.1015	1-7/16	2-1/2
705-73	.0240	5/16	1-1/8	705-37	.1040	1-7/16	2-1/2
705-72	.0250	5/16	1-1/8	705-36	.1065	1-7/16	2-1/2
705-71	.0260	3/8	1-1/4	705-7/64	.1094	1-1/2	2-5/8
705-70	.0280	3/8	1-1/4	705-35	.1100	1-1/2	2-5/8
705-69	.0292	1/2	1-3/8	705-34	.1110	1-1/2	2-5/8
705-68	.0310	1/2	1-3/8	705-33	.1130	1-1/2	2-5/8
705-1/32	.0312	1/2	1-3/8	705-32	.1160	1-5/8	2-3/4
705-67	.0320	1/2	1-3/8	705-31	.1200	1-5/8	2-3/4
705-66	.0330	1/2	1-3/8	705-1/8	.1250	1-5/8	2-3/4
705-65	.0350	5/8	1-1/2	705-30	.1285	1-5/8	2-3/4
705-64	.0360	5/8	1-1/2	705-29	.1360	1-3/4	2-7/8
705-63	.0370	5/8	1-1/2	705-28	.1405	1-3/4	2-7/8
705-62	.0380	5/8	1-1/2	705-9/64	.1406	1-3/4	2-7/8
705-61	.0390	11/16	1-5/8	705-27	.1440	1-7/8	3
705-60	.0400	11/16	1-5/8	705-26	.1470	1-7/8	3
705-59	.0410	11/16	1-5/8	705-25	.1495	1-7/8	3
705-58	.0420	11/16	1-5/8	705-24	.1520	2	3-1/8
705-57	.0430	3/4	1-3/4	705-23	.1540	2	3-1/8
705-56	.0465	3/4	1-3/4	705-5/32	.1562	2	3-1/8
705-3/64	.0469	3/4	1-3/4	705-22	.1570	2	3-1/8
705-55	.0520	7/8	1-7/8	705-21	.1590	2-1/8	3-1/4
705-54	.0550	7/8	1-7/8	705-20	.1610	2-1/8	3-1/4
705-53	.0595	7/8	1-7/8	705-19	.1660	2-1/8	3-1/4
705-1/16	.0625	7/8	1-7/8	705-18	.1695	2-1/8	3-1/4
705-52	.0635	7/8	1-7/8	705-11/64	.1719	2-1/8	3-1/4
705-51	.0670	1	2	705-17	.1730	2-3/16	3-3/8
705-50	.0700	1	2	705-16	.1770	2-3/16	3-3/8
705-49	.0730	1	2	705-15	.1800	2-3/16	3-3/8
705-48	.0760	1	2	705-14	.1820	2-3/16	3-3/8
705-5/64	.0781	1	2	705-13	.1850	2-5/16	3-1/2
705-47	.0785	1	2	705-3/16	.1875	2-5/16	3-1/2
705-46	.0810	1-1/8	2-1/8	705-12	.1890	2-5/16	3-1/2
705-45	.0820	1-1/8	2-1/8	705-11	.1910	2-5/16	3-1/2

*Please specify 405 (bright finish) when ordering.

CHAMPION

List No. 705 continued



List No. 405* continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705-10	.1935	2-7/16	3-5/8
705-9	.1960	2-7/16	3-5/8
705-8	.1990	2-7/16	3-5/8
705-7	.2010	2-7/16	3-5/8
705-13/64	.2031	2-7/16	3-5/8
705-6	.2040	2-1/2	3-3/4
705-5	.2055	2-1/2	3-3/4
705-4	.2090	2-1/2	3-3/4
705-3	.2130	2-1/2	3-3/4
705-7/32	.2188	2-1/2	3-3/4
705-2	.2210	2-5/8	3-7/8
705-1	.2280	2-5/8	3-7/8
705-A	.2340	2-5/8	3-7/8
705-15/64	.2344	2-5/8	3-7/8
705-B	.2380	2-3/4	4
705-C	.2420	2-3/4	4
705-D	.2460	2-3/4	4
705-1/4/E	.2500	2-3/4	4
705-F	.2570	2-7/8	4-1/8
705-G	.2610	2-7/8	4-1/8
705-17/64	.2656	2-7/8	4-1/8
705-H	.2660	2-7/8	4-1/8
705-I	.2720	2-7/8	4-1/8
705-J	.2770	2-7/8	4-1/8
705-K	.2810	2-15/16	4-1/4
705-9/32	.2812	2-15/16	4-1/4
705-L	.2900	2-15/16	4-1/4
705-M	.2950	3-1/16	4-3/8
705-19/64	.2969	3-1/16	4-3/8
705-N	.3020	3-1/16	4-3/8
705-5/16	.3125	3-3/16	4-1/2
705-O	.3160	3-3/16	4-1/2
705-P	.3230	3-5/16	4-5/8
705-21/64	.3281	3-5/16	4-5/8
705-Q	.3320	3-7/16	4-3/4
705-R	.3390	3-7/16	4-3/4
705-11/32	.3438	3-7/16	4-3/4
705-S	.3480	3-1/2	4-7/8
705-T	.3580	3-1/2	4-7/8
705-23/64	.3594	3-1/2	4-7/8
705-U	.3680	3-5/8	5
705-3/8	.3750	3-5/8	5

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705-V	.3770	3-5/8	5
705-W	.3860	3-3/4	5-1/8
705-25/64	.3906	3-3/4	5-1/8
705-X	.3970	3-3/4	5-1/8
705-Y	.4040	3-7/8	5-1/4
705-13/32	.4062	3-7/8	5-1/4
705-Z	.4130	3-7/8	5-1/4
705-27/64	.4219	3-15/16	5-3/8
705-7/16	.4375	4-1/16	5-1/2
705-29/64	.4531	4-3/16	5-5/8
705-15/32	.4688	4-5/16	5-3/4
705-31/64	.4844	4-3/8	5-7/8
705-1/2	.5000	4-1/2	6
705-33/64**	.5156	4-13/16	6-5/8
705-17/32**	.5312	4-13/16	6-5/8
705-35/64**	.5469	4-13/16	6-5/8
705-9/16**	.5625	4-13/16	6-5/8
705-37/64**	.5781	4-13/16	6-5/8
705-19/32**	.5938	5-3/16	7-1/8
705-39/64**	.6094	5-3/16	7-1/8
705-5/8**	.6250	5-3/16	7-1/8
705-41/64**	.6406	5-3/16	7-1/8
705-21/32**	.6562	5-3/16	7-1/8
705-43/64**	.6719	5-5/8	7-5/8
705-11/16**	.6875	5-5/8	7-5/8

Will **not fit 1/2" capacity chucks.

**Available in surface treated black finish only (#705).



*Please specify 405 (bright finish) when ordering.

CHAMPION

General Purpose Jobber Drills

List No. US5

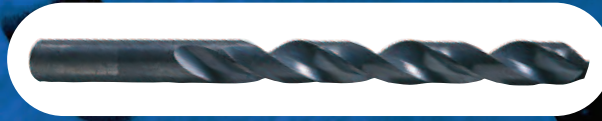
Straight Shank / 118° Point /
Steam Oxide Treated / HSS

List No. USHD

135° Split Point

Description: Designed for general purpose drilling. Surface treated with black oxide for abrasion resistance and improved coolant adherence.

Application: Contractor series jobber drills are recommended for portable drilling of low to medium carbon steels, cast iron and wood.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US5-60	.0400	11/16	1-5/8
US5-59	.0410	11/16	1-5/8
US5-58	.0420	11/16	1-5/8
US5-57	.0430	3/4	1-3/4
US5-56	.0465	3/4	1-3/4
US5-55	.0520	7/8	1-7/8
US5-54	.0550	7/8	1-7/8
US5-53	.0595	7/8	1-7/8
US5-1/16	.0625	7/8	1-7/8
US5-52	.0635	7/8	1-7/8
US5-51	.0670	1	2
US5-50	.0700	1	2
US5-49	.0730	1	2
US5-48	.0760	1	2
US5-5/64	.0781	1	2
US5-47	.0785	1	2
US5-46	.0810	1-1/8	2-1/8
US5-45	.0820	1-1/8	2-1/8
US5-44	.0860	1-1/8	2-1/8
US5-43	.0890	1-1/4	2-1/4
US5-42	.0935	1-1/4	2-1/4
US5-3/32	.0938	1-1/4	2-1/4
US5-41	.0960	1-3/8	2-3/8
US5-40	.0980	1-3/8	2-3/8
US5-39	.0995	1-3/8	2-3/8
US5-38	.1015	1-7/16	2-1/2
US5-37	.1040	1-7/16	2-1/2
US5-36	.1065	1-7/16	2-1/2
US5-7/64	.1094	1-1/2	2-5/8
US5-35	.1100	1-1/2	2-5/8
US5-34	.1110	1-1/2	2-5/8
US5-33	.1130	1-1/2	2-5/8
US5-32	.1160	1-5/8	2-3/4
US5-31	.1200	1-5/8	2-3/4
US5-1/8	.1250	1-5/8	2-3/4
US5-30	.1285	1-5/8	2-3/4
US5-29	.1360	1-3/4	2-7/8
US5-28	.1405	1-3/4	2-7/8
US5-9/64	.1406	1-3/4	2-7/8
US5-27	.1440	1-7/8	3
US5-26	.1470	1-7/8	3
US5-25	.1495	1-7/8	3
US5-24	.1520	2	3-1/8
US5-23	.1540	2	3-1/8
US5-5/32	.1562	2	3-1/8
US5-22	.1570	2	3-1/8
US5-21	.1590	2-1/8	3-1/4

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US5-20	.1610	2-1/8	3-1/4
US5-19	.1660	2-1/8	3-1/4
US5-18	.1695	2-1/8	3-1/4
US5-11/64	.1719	2-1/8	3-1/4
US5-17	.1730	2-3/16	3-3/8
US5-16	.1770	2-3/16	3-3/8
US5-15	.1800	2-3/16	3-3/8
US5-14	.1820	2-3/16	3-3/8
US5-13	.1850	2-5/16	3-1/2
US5-3/16	.1875	2-5/16	3-1/2
US5-12	.1890	2-5/16	3-1/2
US5-11	.1910	2-5/16	3-1/2
US5-10	.1935	2-7/16	3-5/8
US5-9	.1960	2-7/16	3-5/8
US5-8	.1990	2-7/16	3-5/8
US5-7	.2010	2-7/16	3-5/8
US5-13/64	.2031	2-7/16	3-5/8
US5-6	.2040	2-1/2	3-3/4
US5-5	.2055	2-1/2	3-3/4
US5-4	.2090	2-1/2	3-3/4
US5-3	.2130	2-1/2	3-3/4
US5-7/32	.2188	2-1/2	3-3/4
US5-2	.2210	2-5/8	3-7/8
US5-1	.2280	2-5/8	3-7/8
US5-A	.2340	2-5/8	3-7/8
US5-15/64	.2344	2-5/8	3-7/8
US5-B	.2380	2-3/4	4
US5-C	.2420	2-3/4	4
US5-D	.2460	2-3/4	4
US5-1/4/E	.2500	2-3/4	4
US5-F	.2570	2-7/8	4-1/8
US5-G	.2610	2-7/8	4-1/8
US5-17/64	.2656	2-7/8	4-1/8
US5-H	.2660	2-7/8	4-1/8
US5-I	.2720	2-7/8	4-1/8
US5-J	.2770	2-7/8	4-1/8
US5-K	.2810	2-15/16	4-1/4
US5-9/32	.2812	2-15/16	4-1/4
US5-L	.2900	2-15/16	4-1/4
US5-M	.2950	3-1/16	4-3/8
US5-19/64	.2969	3-1/16	4-3/8
US5-N	.3020	3-1/16	4-3/8
US5-5/16	.3125	3-3/16	4-1/2
US5-O	.3160	3-3/16	4-1/2
US5-P	.3230	3-5/16	4-5/8
US5-21/64	.3281	3-5/16	4-5/8
US5-Q	.3320	3-7/16	4-3/4

CHAMPION

List No. US5 / List No. USHD continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US5-R	.3390	3-7/16	4-3/4
US5-11/32	.3438	3-7/16	4-3/4
US5-S	.3480	3-1/2	4-7/8
US5-T	.3580	3-1/2	4-7/8
US5-23/64	.3594	3-1/2	4-7/8
US5-U	.3680	3-5/8	5
US5-3/8	.3750	3-5/8	5
US5-V	.3770	3-5/8	5
US5-W	.3860	3-3/4	5-1/8
US5-25/64	.3906	3-3/4	5-1/8

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US5-X	.3970	3-3/4	5-1/8
US5-Y	.4040	3-7/8	5-1/4
US5-13/32	.4062	3-7/8	5-1/4
US5-Z	.4130	3-7/8	5-1/4
US5-27/64	.4219	3-15/16	5-3/8
US5-7/16	.4375	4-1/16	5-1/2
US5-29/64	.4531	4-3/16	5-5/8
US5-15/32	.4688	4-5/16	5-3/4
US5-31/64	.4844	4-3/8	5-7/8
US5-1/2	.5000	4-1/2	6

CHAMPION

Cobalt Jobber Drills

List No. 705C

Straight Shank / 135° Split Point / Type "J"
Gold Oxide Finish / M42 Cobalt HSS



Description: Heavy duty web construction. Manufactured from heat-resistant premium cobalt high speed steel. Cobalt drills can maintain their cutting ability at high temperatures and are extremely resistant.

Application: High tensile materials such as high-strength alloy steels, stainless steel, titanium, manganese steel, armor plate and inconel.



705C - Perfect for high tensile materials

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
705C-80	.0135	1/8	3/4
705C-79	.0145	1/8	3/4
705C-1/64	.0156	3/16	3/4
705C-78	.0160	3/16	7/8
705C-77	.0180	3/16	7/8
705C-76	.0200	3/16	7/8
705C-75	.0210	1/4	1
705C-74	.0225	1/4	1
705C-73	.0240	5/16	1-1/8
705C-72	.0250	5/16	1-1/8
705C-71	.0260	3/8	1-1/4
705C-70	.0280	3/8	1-1/4
705C-69	.0292	1/2	1-3/8
705C-68	.0310	1/2	1-3/8
705C-1/32	.0312	1/2	1-3/8
705C-67	.0320	1/2	1-3/8
705C-66	.0330	1/2	1-3/8
705C-65	.0350	5/8	1-1/2
705C-64	.0360	5/8	1-1/2
705C-63	.0370	5/8	1-1/2
705C-62	.0380	5/8	1-1/2



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705C-61	.0390	11/16	1-5/8	705C-22	.1570	2	3-1/8
705C-60	.0400	11/16	1-5/8	705C-21	.1590	2-1/8	3-1/4
705C-59	.0410	11/16	1-5/8	705C-20	.1610	2-1/8	3-1/4
705C-58	.0420	11/16	1-5/8	705C-19	.1660	2-1/8	3-1/4
705C-57	.0430	3/4	1-3/4	705C-18	.1695	2-1/8	3-1/4
705C-56	.0465	3/4	1-3/4	705C-11/64	.1719	2-1/8	3-1/4
705C-3/64	.0469	3/4	1-3/4	705C-17	.1730	2-3/16	3-3/8
705C-55	.0520	7/8	1-7/8	705C-16	.1770	2-3/16	3-3/8
705C-54	.0550	7/8	1-7/8	705C-15	.1800	2-3/16	3-3/8
705C-53	.0595	7/8	1-7/8	705C-14	.1820	2-3/16	3-3/8
705C-1/16	.0625	7/8	1-7/8	705C-13	.1850	2-5/16	3-1/2
705C-52	.0635	7/8	1-7/8	705C-3/16	.1875	2-5/16	3-1/2
705C-51	.0670	1	2	705C-12	.1890	2-5/16	3-1/2
705C-50	.0700	1	2	705C-11	.1910	2-5/16	3-1/2
705C-49	.0730	1	2	705C-10	.1935	2-7/16	3-5/8
705C-48	.0760	1	2	705C-9	.1960	2-7/16	3-5/8
705C-5/64	.0781	1	2	705C-8	.1990	2-7/16	3-5/8
705C-47	.0785	1	2	705C-7	.2010	2-7/16	3-5/8
705C-46	.0810	1-1/8	2-1/8	705C-13/64	.2031	2-7/16	3-5/8
705C-45	.0820	1-1/8	2-1/8	705C-6	.2040	2-1/2	3-3/4
705C-44	.0860	1-1/8	2-1/8	705C-5	.2055	2-1/2	3-3/4
705C-43	.0890	1-1/4	2-1/4	705C-4	.2090	2-1/2	3-3/4
705C-42	.0935	1-1/4	2-1/4	705C-3	.2130	2-1/2	3-3/4
705C-3/32	.0938	1-1/4	2-1/4	705C-7/32	.2188	2-1/2	3-3/4
705C-41	.0960	1-3/8	2-3/8	705C-2	.2210	2-5/8	3-7/8
705C-40	.0980	1-3/8	2-3/8	705C-1	.2280	2-5/8	3-7/8
705C-39	.0995	1-3/8	2-3/8	705C-A	.2340	2-5/8	3-7/8
705C-38	.1015	1-7/16	2-1/2	705C-15/64	.2344	2-5/8	3-7/8
705C-37	.1040	1-7/16	2-1/2	705C-B	.2380	2-3/4	4
705C-36	.1065	1-7/16	2-1/2	705C-C	.2420	2-3/4	4
705C-7/64	.1094	1-1/2	2-5/8	705C-D	.2460	2-3/4	4
705C-35	.1100	1-1/2	2-5/8	705C-1/4/E	.2500	2-3/4	4
705C-34	.1110	1-1/2	2-5/8	705C-F	.2570	2-7/8	4-1/8
705C-33	.1130	1-1/2	2-5/8	705C-G	.2610	2-7/8	4-1/8
705C-32	.1160	1-5/8	2-3/4	705C-17/64	.2656	2-7/8	4-1/8
705C-31	.1200	1-5/8	2-3/4	705C-H	.2660	2-7/8	4-1/8
705C-1/8	.1250	1-5/8	2-3/4	705C-I	.2720	2-7/8	4-1/8
705C-30	.1285	1-5/8	2-3/4	705C-J	.2770	2-7/8	4-1/8
705C-29	.1360	1-3/4	2-7/8	705C-K	.2810	2-15/16	4-1/4
705C-28	.1405	1-3/4	2-7/8	705C-9/32	.2812	2-15/16	4-1/4
705C-9/64	.1406	1-3/4	2-7/8	705C-L	.2900	2-15/16	4-1/4
705C-27	.1440	1-7/8	3	705C-M	.2950	3-1/16	4-3/8
705C-26	.1470	1-7/8	3	705C-19/64	.2969	3-1/16	4-3/8
705C-25	.1495	1-7/8	3	705C-N	.3020	3-1/16	4-3/8
705C-24	.1520	2	3-1/8	705C-5/16	.3125	3-3/16	4-1/2
705C-23	.1540	2	3-1/8	705C-O	.3160	3-3/16	4-1/2
705C-5/32	.1562	2	3-1/8	705C-P	.3230	3-5/16	4-5/8



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705C-21/64	.3281	3-5/16	4-5/8	705C-25/64	.3906	3-3/4	5-1/8
705C-Q	.3320	3-7/16	4-3/4	705C-X	.3970	3-3/4	5-1/8
705C-R	.3390	3-7/16	4-3/4	705C-Y	.4040	3-7/8	5-1/4
705C-11/32	.3438	3-7/16	4-3/4	705C-13/32	.4062	3-7/8	5-1/4
705C-S	.3480	3-1/2	4-7/8	705C-Z	.4130	3-7/8	5-1/4
705C-T	.3580	3-1/2	4-7/8	705C-27/64	.4219	3-15/16	5-3/8
705C-23/64	.3594	3-1/2	4-7/8	705C-7/16	.4375	4-1/16	5-1/2
705C-U	.3680	3-5/8	5	705C-29/64	.4531	4-3/16	5-5/8
705C-3/8	.3750	3-5/8	5	705C-15/32	.4688	4-5/16	5-3/4
705C-V	.3770	3-5/8	5	705C-31/64	.4844	4-3/8	5-7/8
705C-W	.3860	3-3/4	5-1/8	705C-1/2	.5000	4-1/2	6



Metric Jobber Drills

List No. XL8

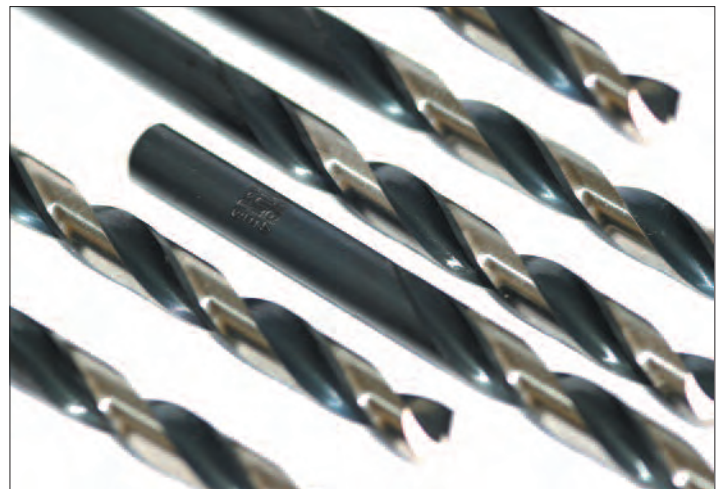
Heavy Duty / 135° Split Point / Black & Bright Finish / HSS / NOMO® Surface Treatment



Description: Self-centering 135° split point eliminates the need for center punching or pilot hole drilling. Unique NOMO® treatment maximizes the number of holes per drill.

Application: For high performance portable and fixed drilling. Engineered for use in metal working industries including machinery repair, steel erection, mining, construction, railway repair, utilities and dockyard maintenance.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XL8-1.0	0.0394	11/16	1-5/8	XL8-11.5	0.4528	4-3/16	5-5/8
XL8-1.5	0.0591	7/8	1-7/8	XL8-12.0	0.4724	4-3/8	5-7/8
XL8-2.0	0.0787	1	2	XL8-12.5	0.4921	4-1/2	6
XL8-2.5	0.0984	1-3/8	2-3/8	XL8-13.0	0.5118	4-1/2	6
XL8-3.0	0.1181	1-5/8	2-3/4				
XL8-3.5	0.1378	1-3/4	2-7/8				
XL8-4.0	0.1575	2-1/8	3-1/4				
XL8-4.5	0.1772	2-3/16	3-3/8				
XL8-5.0	0.1969	2-7/16	3-5/8				
XL8-5.5	0.2165	2-1/2	3-3/4				
XL8-6.0	0.2362	2-3/4	4				
XL8-6.5	0.2559	2-7/8	4-1/8				
XL8-7.0	0.2756	2-7/8	4-1/8				
XL8-7.5	0.2953	3-1/16	4-3/8				
XL8-8.0	0.3150	3-3/16	4-1/2				
XL8-8.5	0.3346	3-7/16	4-3/4				
XL8-9.0	0.3543	3-1/2	4-7/8				
XL8-9.5	0.3740	3-5/8	5				
XL8-10.0	0.3937	3-3/4	5-1/8				
XL8-10.5	0.4134	3-7/8	5-1/4				
XL8-11.0	0.4331	4-1/16	5-1/2				



Brute Platinum XL8 are available in cased sets. See page 141

CHAMPION

Metric Jobber Drills

List No. 708

Straight Shank / 118° Point /

Steam Oxide Surface Treatment / HSS



Description: Designed for general purpose drilling. Surface treated with a black steam oxide finish for abrasion resistance and improved coolant adherence.

Application: For drilling portably and in fixed machinery. For drilling metric holes in machines commonly used in the printing, knitting, woodworking and metal working industries.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
708-.25	.0098	5/64	3/4	708-2.50	.0984	1-3/8	2-3/8
708-.30	.0118	3/32	3/4	708-2.60	.1024	1-7/16	2-1/2
708-.32	.0126	3/32	3/4	708-2.70	.1063	1-7/16	2-1/2
708-.35	.0138	1/8	3/4	708-2.80	.1102	1-1/2	2-5/8
708-.38	.0150	3/16	3/4	708-2.90	.1142	1-5/8	2-3/4
708-.40	.0157	3/16	3/4	708-3.00	.1181	1-5/8	2-3/4
708-.45	.0177	3/16	7/8	708-3.10	.1220	1-5/8	2-3/4
708-.50	.0197	3/16	7/8	708-3.20	.1260	1-5/8	2-3/4
708-.55	.0217	1/4	1	708-3.30	.1299	1-3/4	2-7/8
708-.60	.0236	5/16	1-1/8	708-3.40	.1339	1-3/4	2-7/8
708-.65	.0256	3/8	1-1/4	708-3.50	.1378	1-3/4	2-7/8
708-.70	.0276	3/8	1-1/4	708-3.60	.1417	1-7/8	3
708-.75	.0295	1/2	1-3/8	708-3.70	.1457	1-7/8	3
708-.80	.0315	1/2	1-3/8	708-3.80	.1496	1-7/8	3
708-.85	.0335	5/8	1-1/2	708-3.90	.1535	2	3-1/8
708-.90	.0354	5/8	1-1/2	708-4.00	.1575	2-1/8	3-1/4
708-.95	.0374	5/8	1-1/2	708-4.10	.1614	2-1/8	3-1/4
708-1.00	.0394	11/16	1-5/8	708-4.20	.1654	2-1/8	3-1/4
708-1.05	.0413	11/16	1-5/8	708-4.30	.1693	2-1/8	3-1/4
708-1.10	.0433	3/4	1-3/4	708-4.40	.1732	2-3/16	3-3/8
708-1.15	.0453	3/4	1-3/4	708-4.50	.1772	2-3/16	3-3/8
708-1.20	.0472	7/8	1-7/8	708-4.60	.1811	2-3/16	3-3/8
708-1.25	.0492	7/8	1-7/8	708-4.70	.1850	2-5/16	3-1/2
708-1.30	.0512	7/8	1-7/8	708-4.80	.1890	2-5/16	3-1/2
708-1.35	.0531	7/8	1-7/8	708-4.90	.1929	2-7/16	3-5/8
708-1.40	.0551	7/8	1-7/8	708-5.00	.1969	2-7/16	3-5/8
708-1.45	.0571	7/8	1-7/8	708-5.10	.2008	2-7/16	3-5/8
708-1.50	.0591	7/8	1-7/8	708-5.20	.2047	2-1/2	3-3/4
708-1.55	.0610	7/8	1-7/8	708-5.30	.2087	2-1/2	3-3/4
708-1.60	.0630	7/8	1-7/8	708-5.40	.2126	2-11/2	3-3/4
708-1.65	.0650	1	2	708-5.50	.2165	2-1/2	3-3/4
708-1.70	.0669	1	2	708-5.60	.2205	2-5/8	3-7/8
708-1.75	.0689	1	2	708-5.70	.2244	2-5/8	3-7/8
708-1.80	.0709	1	2	708-5.80	.2283	2-5/8	3-7/8
708-1.85	.0728	1	2	708-5.90	.2323	2-5/8	3-7/8
708-1.90	.0748	1	2	708-6.00	.2362	2-3/4	4
708-1.95	.0768	1	2	708-6.10	.2402	2-3/4	4
708-2.00	.0787	1	2	708-6.20	.2441	2-3/4	4
708-2.05	.0807	1-1/8	2-1/8	708-6.30	.2480	2-3/4	4
708-2.10	.0827	1-1/8	2-1/8	708-6.40	.2520	2-7/8	4-1/8
708-2.15	.0846	1-1/8	2-1/8	708-6.50	.2559	2-7/8	4-1/8
708-2.20	.0866	1-1/4	2-1/4	708-6.60	.2598	2-7/8	4-1/8
708-2.25	.0886	1-1/4	2-1/4	708-6.70	.2638	2-7/8	4-1/8
708-2.30	.0906	1-1/4	2-1/4	708-6.80	.2677	2-7/8	4-1/8
708-2.35	.0925	1-1/4	2-1/4	708-6.90	.2717	2-7/8	4-1/8
708-2.40	.0945	1-3/8	2-3/8	708-7.00	.2756	2-7/8	4-1/8
708-2.45	.0965	1-3/8	2-3/8	708-7.10	.2795	2-15/16	4-1/4

Note: Metric drills 13mm and larger will not fit into 1/2" drill chucks.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
708-7.20	.2835	2-15/16	4-1/4	708-9.50	.3740	3-5/8	5
708-7.30	.2874	2-15/16	4-1/4	708-9.60	.3780	3-3/4	5-1/8
708-7.40	.2913	3-1/16	4-3/8	708-9.70	.3819	3-3/4	5-1/8
708-7.50	.2953	3-1/16	4-3/8	708-9.80	.3858	3-3/4	5-1/8
708-7.60	.2992	3-1/16	4-3/8	708-9.90	.3898	3-3/4	5-1/8
708-7.70	.3031	3-3/16	4-1/2	708-10.00	.3937	3-3/4	5-1/8
708-7.80	.3071	3-3/16	4-1/2	708-10.20	.4016	3-3/4	5-1/8
708-7.90	.3110	3-3/16	4-1/2	708-10.50	.4134	3-7/8	5-1/4
708-8.00	.3150	3-3/16	4-1/2	708-10.80	.4252	4-1/16	5-1/2
708-8.10	.3189	3-5/16	4-5/8	708-11.00	.4331	4-1/16	5-1/2
708-8.20	.3228	3-5/16	4-5/8	708-11.20	.4409	4-1/16	5-1/2
708-8.30	.3268	3-5/16	4-5/8	708-11.50	.4528	4-3/16	5-5/8
708-8.40	.3307	3-7/16	4-3/4	708-11.80	.4646	4-3/8	5-3/4
708-8.50	.3346	3-7/16	4-3/4	708-12.00	.4724	4-3/8	5-7/8
708-8.60	.3386	3-7/16	4-3/4	708-12.20	.4803	4-3/8	5-7/8
708-8.70	.3425	3-7/16	4-3/4	708-12.50	.4921	4-1/2	6
708-8.80	.3465	3-1/2	4-7/8	708-12.80	.5039	4-1/2	6
708-8.90	.3504	3-1/2	4-7/8	708-13.00*	.5118	4-1/2	6
708-9.00	.3543	3-1/2	4-7/8	708-14.00*	.5512	4-13/16	6-5/8
708-9.10	.3583	3-1/2	4-7/8	706-15.50*	.6102	5-3/16	7-1/8
708-9.20	.3622	3-5/8	5	708-16.50*	.6496	5-3/16	7-1/8
708-9.30	.3661	3-5/8	5	708-17.50*	.6890	5-5/8	7-5/8
708-9.40	.3701	3-5/8	5				

Note: Metric drills larger than 13mm will not fit into 1/2" drill chucks.



BruteLube Cutting Fluid & Wax

List No. XLUB

Description: Multi-purpose cutting and tapping fluid specially formulated to extend tool life and reduce chip welding. Provides a precision finish with closer tolerances on finished work. Complies with OSHA regulations and contains no 1,1,1 Trichloroethane. Formulated to cling to tools for a continuous shield against friction and heat.

List No. XLUB-WAX

Description: Formulated to extend tool life, reduce chip welding and clings to the tool at any angle, including overhead operations. Continuous shield against friction and heat, reducing tool costs and work piece scrap. Provides a close tolerance precision finish. Effective on stainless steel, aluminum, and exotic alloys.

Improves cutting tool performance and tool life when drilling, reaming and threading. Apply directly to cutting tools and work piece surfaces.



EDP No.	Description
XLUB4	4 oz.
XLUB16	16 oz.
XLUB128	1 gallon
XLUB-WAX-2	2 oz.
XLUB-WAX-16	17 oz.
XLUB-STICK-16	16 oz.

See pages 163-164 for BruteLube Material Safety Data Sheets



Left Hand Jobber Drills

List No. XL5LH

Straight Shank / 135° Split Point / Heavy Duty
NOMO® Surface Treatment / HSS



Description: NOMO® treatment increases surface hardness. Penetrates faster than cobalt due to unique geometry and metallurgy. The precision 135° split point eliminates the need for pilot hole drilling, prevents “walking” and bites right into #300 and #400 series stainless steels.


Application: Portable drilling of stainless steel, titanium alloys and other hard to drill materials.

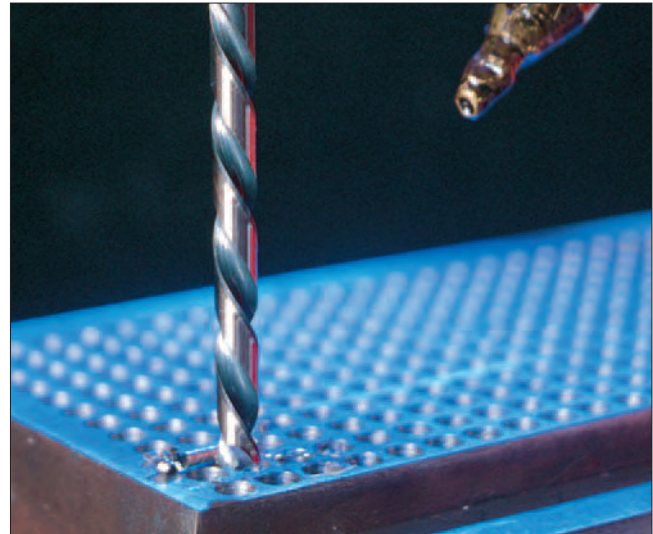


EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XL5LH-5/64	.0781	1	2
XL5LH-7/64	.1094	1-1/2	2-5/8
XL5LH-5/32	.1562	2	3-1/8
XL5LH-1/4	.2500	2-3/4	4
XL5LH-19/64	.2969	3-1/16	4-3/8

Designed for use in left hand rotation multiple spindle, gear driven drilling heads, screw machine operations, lathes and any machinery with a left hand rotation.

Left hand drills are also commonly used for drilling out broken or frozen bolts.

 All sizes available as part of an iPac screw extractor and left hand drill combination pack.



Left Hand Jobber Drills

List No. 705LH

Straight Shank / 118° Point / Bright Finish / HSS

Application: For use in left hand rotation multiple spindle, gear driven drilling heads, screw machine operations and lathes.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
705LH-1/16	.0625	7/8	1-7/8	705LH-19/64	.2969	3-1/16	4-3/8
705LH-5/64	.0781	1	2	705LH-5/16	.3125	3-3/16	4-1/2
705LH-3/32	.0938	1-1/4	2-1/4	705LH-21/64	.3281	3-5/16	4-5/8
705LH-7/64	.1094	1-1/2	2-5/8	705LH-11/32	.3438	3-7/16	4-3/4
705LH-1/8	.1250	1-5/8	2-3/4	705LH-23/64	.3594	3-1/2	4-7/8
705LH-9/64	.1406	1-3/4	2-7/8	705LH-3/8	.3750	3-5/8	5
705LH-5/32	.1562	2	3-1/8	705LH-25/64	.3906	3-3/4	5-1/8
705LH-11/64	.1719	2-1/8	3-1/4	705LH-13/32	.4062	3-7/8	5-1/4
705LH-3/16	.1875	2-5/16	3-1/2	705LH-27/64	.4219	3-15/16	5-3/8
705LH-13/64	.2031	2-7/16	3-5/8	705LH-7/16	.4375	4-1/16	5-1/2
705LH-7/32	.2188	2-1/2	3-3/4	705LH-29/64	.4531	4-3/16	5-5/8
705LH-15/64	.2344	2-5/8	3-7/8	705LH-15/32	.4688	4-5/16	5-3/4
705LH-1/4	.2500	2-3/4	4	705LH-31/64	.4844	4-3/8	5-7/8
705LH-17/64	.2656	2-7/8	4-1/8	705LH-1/2	.5000	4-1/2	6
705LH-9/32	.2812	2-15/16	4-1/4				



Mechanics Length Drills

List No. XL28

Self Centering 135° Split Point / Flatted Shanks /
NOMO® Surface Treatment / HSS



Description: Strong, rigid overall length. Heavy duty 135° split point for self-centering and quick penetration. Heavy duty web geometry provides added rigidity. The three flatted shank design ensures positive grip in keyless drill chucks.

Applications: Ideal for the aircraft industry. Used for the drilling of high tensile martensitic stainless steels, titanium alloys and hard steel.



XL28 reduced overall length for extra strength

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XL28-1/16**	.0625	7/8	1-7/8
XL28-5/64**	.0781	1	2
XL28-3/32**	.0938	1-1/4	2-1/4
XL28-7/64**	.1094	1-5/16	2-3/8
XL28-1/8**	.1250	1-7/16	2-1/2

Note: 3/16 - 1/2" have 3 flats; 3/8 - 1/2" have 3/8" shanks

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XL28-9/64**	.1406	1-9/16	2-5/8
XL28-5/32**	.1562	1-11/16	2-3/4
XL28-11/64*	.1719	1-13/16	2-7/8
XL28-3/16*	.1875	1-7/8	3
XL28-13/64*	.2031	1-15/16	3-1/8
XL28-7/32*	.2188	2	3-1/4
XL28-15/64*	.2344	2-1/16	3-3/8
XL28-1/4*	.2500	2	3-1/2
XL28-17/64*	.2656	2-1/8	3-5/8
XL28-9/32*	.2812	2-1/4	3-3/4
XL28-19/64*	.2969	2-3/8	3-7/8
XL28-5/16*	.3125	2-1/2	4
XL28-21/64*	.3281	2-9/16	4-1/16
XL28-11/32*	.3438	2-5/8	4-1/8
XL28-23/64*	.3594	2-11/16	4-3/16
XL28-3/8*	.3750	2-11/16	4-1/4
XL28-25/64*	.3906	2-3/4	4-5/16
XL28-13/32*	.4062	2-13/16	4-3/8
XL28-27/64*	.4219	2-7/8	4-7/16
XL28-7/16*	.4375	2-15/16	4-1/2
XL28-29/64*	.4531	3	4-5/8
XL28-15/32*	.4688	3-1/8	4-3/4
XL28-31/64*	.4844	3-1/4	4-7/8
XL28-1/2*	.5000	3-3/8	5



** Available in iPac twin pack
* Available in iPac



Mechanics Length Drills

List No. XM28

Self Centering 135° Split Point / 3-Flats Straight Shank /
NOMO® Surface Treatment



Description: Strong, rigid overall length. Heavy duty 135° split point for self-centering and quick penetration. Heavy duty web geometry provides added rigidity.

Application: Ideal for the aircraft industry. Used for the drilling of high tensile martensitic stainless steels, titanium alloys and hard steel.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XM28-25/64	.3906	2-3/4	4-5/16
XM28-13/32	.4062	2-13/16	4-3/8
XM28-27/64	.4219	2-7/8	4-7/16
XM28-7/16	.4375	2-15/16	4-1/2

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XM28-29/64	.4531	3	4-5/8
XM28-15/32	.4688	3-1/8	4-3/4
XM28-31/64	.4844	3-1/4	4-7/8
XM28-1/2	.5000	3-3/8	5



3/8" Shank Drills

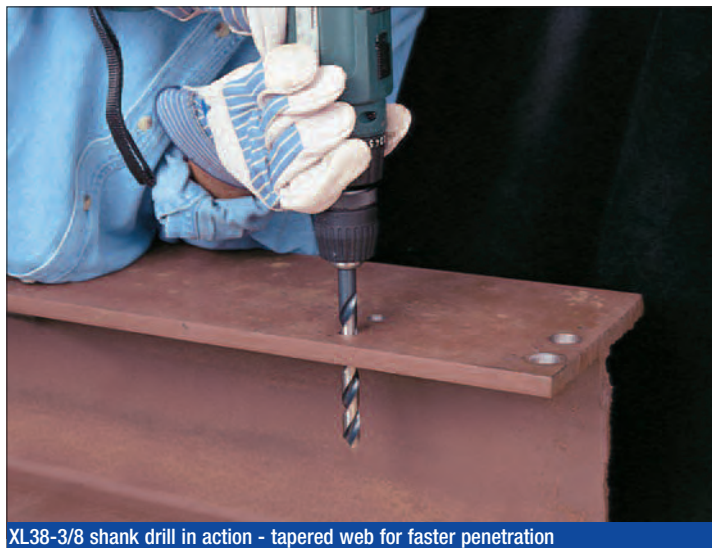
List No. XL38

Heavy Duty / Black & Bright Finish /
NOMO® Surface Treatment / 135° Split Point / HSS



Description: 135° self piloting split point to reduce drill "walking" when starting a hole, while the tapered web promotes faster penetration with less force. NOMO® treatment penetrates the surface of the drill, increasing hardness, durability and tool life.

Application: Steel erection, mining, heavy construction. Used in a wide range of manufacturing plants, vehicle, railway and dockyard maintenance. Drill stainless steel, titanium alloys and other hard to drill materials.



XL38-3/8 shank drill in action - tapered web for faster penetration

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XL38-25/64	.3906	3-3/4	5-1/8
XL38-13/32	.4062	3-7/8	5-1/4
XL38-27/64	.4219	3-15/16	5-3/8
XL38-7/16	.4375	4-1/16	5-1/2
XL38-29/64	.4531	4-3/16	5-5/8
XL38-15/32	.4688	4-5/16	5-3/4
XL38-31/64	.4844	4-3/8	5-7/8
XL38-1/2	.5000	4-1/2	6



Black Gold® 3/8" Shank Drills

List No. XG38

Heavy Duty / Black & Gold Surface Treatment /
135° Split Point / HSS

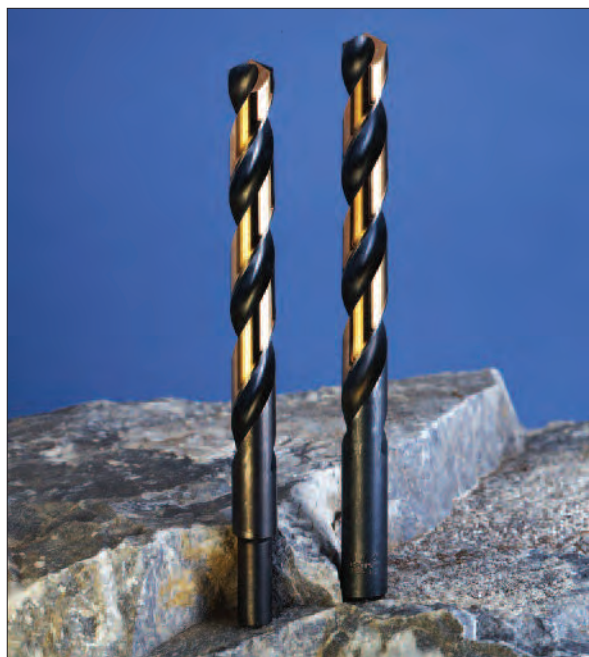


Description: Outperforms ordinary jobber drills by penetrating faster and lasting longer. Functional black and gold surface treatment holds lubricants for smoother drilling. Meets NAS 907B aircraft specifications.

Application: Ideal for 3/8" cordless drills.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XG38-25/64	.3906	3-3/4	5-1/8
XG38-13/32	.4062	3-7/8	5-1/4
XG38-27/64	.4219	3-15/16	5-3/8
XG38-7/16	.4375	4-1/16	5-1/2
XG38-29/64	.4531	4-3/16	5-5/8
XG38-15/32	.4688	4-5/16	5-3/4
XG38-31/64	.4844	4-3/8	5-7/8
XG38-1/2	.5000	4-1/2	6

3/8" reduced shanks make these drills ideal for high performance cordless drilling where the chuck capacity is limited to 3/8".



CHAMPION

3/8" Shank Jobber Drills

List No. 738

118° Point / Black Oxide Treated / HSS

Description: For general purpose drilling in a wide range of materials where chuck capacity is 3/8".

Application: Low carbon steels, steel drop forgings and grey cast iron.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
738-25/64	.3906	3-1/4	5-1/8	738-1/2	.5000	4-1/2	6
738-13/32	.4062	3-7/8	5-1/4	738-17/32	.5312	3-1/8	6
738-27/64	.4219	3-15/16	5-3/8	738-9/16	.5625	3-1/8	6
738-7/16	.4375	4-1/16	5-1/2	738-19/32	.5938	3-1/8	6
738-29/64	.4531	4-3/16	5-5/8	738-5/8	.6250	3-1/8	6
738-15/32	.4687	4-5/16	5-3/4	738-21/32	.6562	3-1/8	6
738-31/64	.4844	4-3/8	5-7/8	738-11/16	.6875	3-1/8	6

CHAMPION

3/8" Shank Screw Machine Drills

List No. 2905

135° Split Point / Black Oxide Treated / HSS

Description: Designed for portable drilling where chuck capacity is 3/8".

Application: Sheet metal and other thin materials.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
2905-7/16	.4375	2-7/16	4-1/8
2905-1/2	.5000	2-7/16	4-1/8

CHAMPION

1/4" Shank Screw Machine Drills

List No. 2705

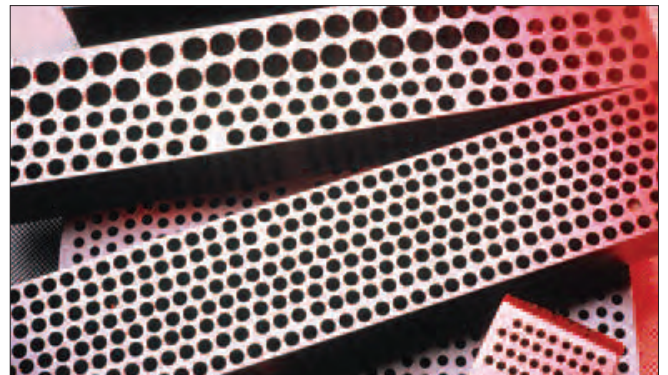
135° Split Point / Black Oxide Treated / HSS

Description: 135° heavy duty split point for self centering and easy penetration.

Application: Designed for portable drilling where chuck capacity is 1/4". For portable drilling of sheet metal and other thin materials.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
2705-5/16	.3125	1-5/8	2-13/16
2705-3/8	.3750	1-13/16	3-1/8
2705-7/16	.4375	2-1/16	3-7/16
2705-1/2	.5000	2-1/4	3-3/4





1/4" Shank Drills

List No. CS14

118° Point / Intermediate Length /
Black Oxide Treated / HSS



Description: Short rigid drill with 1/4" shank.

Application: Popular in the electrical trade. Ideal for sheet metal, mild steel, aluminum and wood.

1/4" reduced shanks are ideal for portable drilling of sheet metal and other thin materials where chuck capacity is limited.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
CS14-9/32	.2812	1-5/8	4
CS14-5/16	.3125	2	4
CS14-3/8	.3750	2	4
CS14-7/16	.4375	2	4
CS14-1/2	.5000	2	4



Silver & Deming Drills

List No. XL12

1/2" Flatted Reduced Shanks / Heavy Duty /
118° Split Point / HSS



Description: Heavy duty split point for self centering and easy penetration. Suitable for portable drilling and drill presses where maximum chuck capacity is 1/2".

Application: Used extensively in maintenance departments, machine shops, body shops and garages.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XL12-33/64	.5156	3-1/8	6
XL12-17/32	.5312	3-1/8	6
XL12-35/64	.5469	3-1/8	6
XL12-9/16	.5625	3-1/8	6
XL12-37/64	.5781	3-1/8	6
XL12-19/32	.5938	3-1/8	6
XL12-39/64	.6094	3-1/8	6
XL12-5/8	.6250	3-1/8	6
XL12-41/64	.6406	3-1/8	6
XL12-21/32	.6562	3-1/8	6
XL12-43/64	.6719	3-1/8	6
XL12-11/16	.6875	3-1/8	6
XL12-45/64	.7031	3-1/8	6

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
XL12-23/32	.7188	3-1/8	6
XL12-47/64	.7344	3-1/8	6
XL12-3/4	.7500	3-1/8	6
XL12-49/64	.7656	3-1/8	6
XL12-25/32	.7812	3-1/8	6
XL12-51/64	.7969	3-1/8	6
XL12-13/16	.8125	3-1/8	6
XL12-53/64	.8281	3-1/8	6
XL12-27/32	.8438	3-1/8	6
XL12-55/64	.8594	3-1/8	6
XL12-7/8	.8750	3-1/8	6
XL12-57/64	.8906	3-1/8	6
XL12-29/32	.9062	3-1/8	6
XL12-59/64	.9219	3-1/8	6
XL12-15/16	.9375	3-1/8	6
XL12-61/64	.9531	3-1/8	6
XL12-31/32	.9688	3-1/8	6
XL12-63/64	.9844	3-1/8	6
XL12-1	1.0000	3-1/8	6
XL12-1-1/16	1.0625	3-1/8	6
XL12-1-1/8	1.1250	3-1/8	6
XL12-1-3/16	1.1875	3-1/8	6
XL12-1-1/4	1.2500	3-1/8	6
XL12-1-5/16	1.3125	3-1/8	6
XL12-1-3/8	1.3750	3-1/8	6
XL12-1-1/2	1.5000	3-1/8	6



XL12-8P 8 piece set includes 9/16 through 1 X 16ths

Note: Silver & Deming drills should not be used to enlarge holes. See SA80 reamer listing on page 54 for enlarging holes.

CHAMPION

BlackGold® Silver & Deming Drills

List No. XG12

118° Split Point / 1/2" Shank / 3 Flatted Shanks

Description: Superior strength and durability. Black and gold surface treatment holds lubricant for smoother drilling.

Application: Low carbon steels, alloyed steels, steel drop forgings, grey cast iron, titanium, stainless steel, nimonic alloys, manganese, spring steels and armor plate.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XG12-33/64	.5156	3-1/8	6
XG12-17/32	.5312	3-1/8	6
XG12-35/64	.5469	3-1/8	6
XG12-9/16	.5625	3-1/8	6
XG12-37/64	.5781	3-1/8	6
XG12-19/32	.5938	3-1/8	6
XG12-39/64	.6094	3-1/8	6
XG12-5/8	.6250	3-1/8	6
XG12-41/64	.6406	3-1/8	6
XG12-21/32	.6562	3-1/8	6
XG12-43/64	.6719	3-1/8	6
XG12-11/16	.6875	3-1/8	6
XG12-45/64	.7031	3-1/8	6
XG12-23/32	.7188	3-1/8	6
XG12-47/64	.7344	3-1/8	6
XG12-3/4	.7500	3-1/8	6
XG12-49/64	.7656	3-1/8	6
XG12-25/32	.7812	3-1/8	6
XG12-51/64	.7969	3-1/8	6
XG12-13/16	.8125	3-1/8	6

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
XG12-53/64	.8281	3-1/8	6
XG12-27/32	.8438	3-1/8	6
XG12-55/64	.8594	3-1/8	6
XG12-7/8	.8750	3-1/8	6
XG12-57/64	.8906	3-1/8	6
XG12-29/32	.9062	3-1/8	6
XG12-59/64	.9219	3-1/8	6
XG12-15/16	.9375	3-1/8	6
XG12-61/64	.9531	3-1/8	6
XG12-31/32	.9688	3-1/8	6
XG12-63/64	.9844	3-1/8	6
XG12-1	1.0000	3-1/8	6
XG12-1-1/16	1.0625	3-1/8	6
XG12-1-1/8	1.1250	3-1/8	6
XG12-1-3/16	1.1875	3-1/8	6
XG12-1-1/4	1.2500	3-1/8	6
XG12-1-5/16	1.3125	3-1/8	6
XG12-1-3/8	1.3750	3-1/8	6
XG12-1-1/2	1.5000	3-1/8	6

CHAMPION

Silver & Deming Drills

List No. 712

1/2" Shank / 118° Point / Black & Bright Finish / HSS

Description: Also known as prentice or blacksmith drills, these 1/2" shank drills have industrial quality metallurgy and geometry for portable and fixed spindle drilling. Popular in CNC applications.

Application: Used in maintenance departments, machine shops, body shops and garages. Note: S&D drills should not be used to enlarge holes. See SA80 reamer listing.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
712-33/64	.5156	3-1/8	6
712-17/32	.5312	3-1/8	6
712-35/64	.5469	3-1/8	6
712-9/16	.5625	3-1/8	6
712-37/64	.5781	3-1/8	6
712-19/32	.5938	3-1/8	6
712-39/64	.6094	3-1/8	6
712-5/8	.6250	3-1/8	6
712-41/64	.6406	3-1/8	6
712-21/32	.6562	3-1/8	6
712-43/64	.6719	3-1/8	6

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
712-11/16	.6875	3-1/8	6
712-45/64	.7031	3-1/8	6
712-23/32	.7188	3-1/8	6
712-47/64	.7344	3-1/8	6
712-3/4	.7500	3-1/8	6
712-49/64	.7656	3-1/8	6
712-25/32	.7812	3-1/8	6
712-51/64	.7969	3-1/8	6
712-13/16	.8125	3-1/8	6
712-53/64	.8281	3-1/8	6
712-27/32	.8438	3-1/8	6

CHAMPION

List No. 712 continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
712-55/64	.8594	3-1/8	6	712-1-7/64	1.1094	3-1/8	6
712-7/8	.8750	3-1/8	6	712-1-1/8	1.1250	3-1/8	6
712-57/64	.8906	3-1/8	6	712-1-9/64	1.1406	3-1/8	6
712-29/32	.9062	3-1/8	6	712-1-5/32	1.1562	3-1/8	6
712-59/64	.9219	3-1/8	6	712-1-11/64	1.1719	3-1/8	6
712-15/16	.9375	3-1/8	6	712-1-3/16	1.1875	3-1/8	6
712-61/64	.9531	3-1/8	6	712-1-13/64	1.2031	3-1/8	6
712-31/32	.9688	3-1/8	6	712-1-7/32	1.2188	3-1/8	6
712-63/64	.9844	3-1/8	6	712-1-15/64	1.2344	3-1/8	6
712-1	1.0000	3-1/8	6	712-1-1/4	1.2500	3-1/8	6
712-1-1/64	1.0156	3-1/8	6	712-1-9/32	1.2812	3-1/8	6
712-1-1/32	1.0312	3-1/8	6	712-1-5/16	1.3125	3-1/8	6
712-1-3/64	1.0469	3-1/8	6	712-1-3/8	1.3750	3-1/8	6
712-1-1/16	1.0625	3-1/8	6	712-1-7/16	1.4375	3-1/8	6
712-1-5/64	1.0781	3-1/8	6	712-1-1/2	1.5000	3-1/8	6
712-1-3/32	1.0938	3-1/8	6				

CHAMPION

Cobalt Heavy Duty Silver & Deming Drills List No. 712C0

1/2" Shank / Heavy Duty / 118° Split Point /
Cobalt Steel / Gold Oxide Finish



Description: Premium grade cobalt steel provides high red hardness, for extreme resistance to heat and abrasion.

Application: Designed to drill stainless, titanium and other tough heat generating materials.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
712C0-17/32	.5312	3-1/8	6	712C0-29/32	.9062	3-1/8	6
712C0-9/16	.5626	3-1/8	6	712C0-15/16	.9375	3-1/8	6
712C0-19/32	.5938	3-1/8	6	712C0-31/32	.9688	3-1/8	6
712C0-5/8	.6250	3-1/8	6	712C0-1	1.000	3-1/8	6
712C0-21/32	.6562	3-1/8	6	712C0-1-1/16	1.0625	3-1/8	6
712C0-11/16	.6875	3-1/8	6	712C0-1-1/8	1.1250	3-1/8	6
712C0-23/32	.7188	3-1/8	6	712C0-1-3/16	1.1875	3-1/8	6
712C0-3/4	.7500	3-1/8	6	712C0-1-1/4	1.2500	3-1/8	6
712C0-25/32	.7812	3-1/8	6	712C0-1-5/16	1.3125	3-1/8	6
712C0-13/16	.8125	3-1/8	6	712C0-1-3/8	1.3750	3-1/8	6
712C0-27/32	.8438	3-1/8	6	712C0-1-7/16	1.4375	3-1/8	6
712C0-7/8	.8750	3-1/8	6	712C0-1-1/2	1.5000	3-1/8	6

Note: "S&D" drills should not be used to enlarge holes.

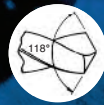
See SA80 reamer listing on page 54 for enlarging larger holes.

CHAMPION

Silver & Deming Drills

List No. US12

1/2" Shank / 118° Point / Black Finish / HSS



Description: "S&D" drills expand the range of 1/2" portable drill chucks.

Application: Ideal for drilling in both low and medium tensile strength materials.

Note: "S&D" drills should not be used to enlarge holes. See SA80 reamer listing.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US12-33/64	.5156	3-1/8	6
US12-17/32	.5312	3-1/8	6
US12-35/64	.5469	3-1/8	6
US12-9/16	.5625	3-1/8	6
US12-37/64	.5781	3-1/8	6
US12-19/32	.5938	3-1/8	6
US12-39/64	.6094	3-1/8	6
US12-5/8	.6250	3-1/8	6
US12-41/64	.6406	3-1/8	6
US12-21/32	.6562	3-1/8	6
US12-43/64	.6719	3-1/8	6
US12-11/16	.6875	3-1/8	6
US12-45/64	.7031	3-1/8	6
US12-23/32	.7188	3-1/8	6
US12-47/64	.7344	3-1/8	6
US12-3/4	.7500	3-1/8	6
US12-49/64	.7656	3-1/8	6
US12-25/32	.7812	3-1/8	6
US12-51/64	.7969	3-1/8	6
US12-13/16	.8125	3-1/8	6
US12-53/64	.8281	3-1/8	6

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
US12-27/32	.8438	3-1/8	6
US12-55/64	.8594	3-1/8	6
US12-7/8	.8750	3-1/8	6
US12-57/64	.8906	3-1/8	6
US12-29/32	.9062	3-1/8	6
US12-59/64	.9219	3-1/8	6
US12-15/16	.9375	3-1/8	6
US12-61/64	.9531	3-1/8	6
US12-31/32	.9688	3-1/8	6
US12-63/64	.9844	3-1/8	6
US12-1	1.0000	3-1/8	6
US12-1-1/16	1.0625	3-1/8	6
US12-1-5/64	1.0781	3-1/8	6
US12-1-3/32	1.0938	3-1/8	6
US12-1-1/8	1.1250	3-1/8	6
US12-1-3/16	1.1875	3-1/8	6
US12-1-1/4	1.2500	3-1/8	6
US12-1-5/16	1.3125	3-1/8	6
US12-1-3/8	1.3750	3-1/8	6
US12-1-1/2	1.5000	3-1/8	6

CHAMPION

Cobalt Screw Machine Drills

List No. 1705C

Heavy Duty / 135° Split Point / Gold Oxide Finish



Description: Heat-resistant premium cobalt high speed steel, often referred to as cobalt sub drills. For use in screw machine operations. The short flute and overall length increase their rigidity, resulting in better hole accuracy and extended tool life.

Application: High tensile materials like stainless steel, titanium, manganese steel, armor plate and inconel.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
1705C-60	.0400	1/2	1-3/8
1705C-59	.0410	1/2	1-3/8
1705C-58	.0420	1/2	1-3/8
1705C-57	.0430	1/2	1-3/8
1705C-56	.0465	1/2	1-3/8
1705C-3/64	.0469	1/2	1-3/8
1705C-55	.0520	5/8	1-5/8
1705C-54	.0550	5/8	1-5/8
1705C-53	.0595	5/8	1-5/8
1705C-1/16	.0625	5/8	1-5/8
1705C-52	.0635	11/16	1-11/16

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
1705C-51	.0670	11/16	1-11/16
1705C-50	.0700	11/16	1-11/16
1705C-49	.0730	11/16	1-11/16
1705C-48	.0760	11/16	1-11/16
1705C-5/64	.0781	11/16	1-11/16
1705C-47	.0785	11/16	1-11/16
1705C-46	.0810	3/4	1-3/4
1705C-45	.0820	3/4	1-3/4
1705C-44	.0860	3/4	1-3/4
1705C-43	.0890	3/4	1-3/4
1705C-42	.0935	3/4	1-3/4



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1705C-3/32	.0938	3/4	1-3/4
1705C-41	.0960	13/16	1-13/16
1705C-40	.0980	13/16	1-13/16
1705C-39	.0995	13/16	1-13/16
1705C-38	.1015	13/16	1-13/16
1705C-37	.1040	13/16	1-13/16
1705C-36	.1065	13/16	1-13/16
1705C-7/64	.1094	13/16	1-13/16
1705C-35	.1100	7/8	1-7/8
1705C-34	.1110	7/8	1-7/8
1705C-33	.1130	7/8	1-7/8
1705C-32	.1160	7/8	1-7/8
1705C-31	.1200	7/8	1-7/8
1705C-1/8	.1250	7/8	1-7/8
1705C-30	.1285	15/16	1-15/16
1705C-29	.1360	15/16	1-15/16
1705C-28	.1405	15/16	1-15/16
1705C-9/64	.1406	15/16	1-15/16
1705C-27	.1440	1	2-1/16
1705C-26	.1470	1	2-1/16
1705C-25	.1495	1	2-1/16
1705C-24	.1520	1	2-1/16
1705C-23	.1540	1	2-1/16
1705C-5/32	.1562	1	2-1/16
1705C-22	.1570	1-1/16	2-1/8
1705C-21	.1590	1-1/16	2-1/8
1705C-20	.1610	1-1/16	2-1/8
1705C-19	.1660	1-1/16	2-1/8
1705C-18	.1695	1-1/16	2-1/8
1705C-11/64	.1719	1-1/16	2-1/8
1705C-17	.1730	1-1/8	2-3/16
1705C-16	.1770	1-1/8	2-3/16
1705C-15	.1800	1-1/8	2-3/16
1705C-14	.1820	1-1/8	2-3/16
1705C-13	.1650	1-1/8	2-3/16
1705C-3/16	.1875	1-1/8	2-3/16
1705C-12	.1890	1-3/16	2-1/4
1705C-11	.1910	1-3/16	2-1/4
1705C-10	.1935	1-3/16	2-1/4
1705C-9	.1960	1-3/16	2-1/4
1705C-8	.1990	1-3/16	2-1/4
1705C-7	.2010	1-3/16	2-1/4
1705C-13/64	.2031	1-3/16	2-1/4
1705C-6	.2040	1-1/4	2-3/8
1705C-5	.2055	1-1/4	2-3/8
1705C-4	.2090	1-1/4	2-3/8
1705C-3	.2130	1-1/4	2-3/8

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1705C-7/32	.2188	1-1/4	2-3/8
1705C-2	.2210	1-5/16	2-7/16
1705C-1	.2280	1-5/16	2-7/16
1705C-A	.2340	1-5/16	2-7/16
1705C-15/64	.2344	1-5/16	2-7/16
1705C-B	.2380	1-3/8	2-1/2
1705C-C	.2420	1-3/8	2-1/2
1705C-D	.2460	1-3/8	2-1/2
1705C-1/4/E	.2500	1-7/16	2-1/2
1705C-F	.2570	1-7/16	2-5/8
1705C-G	.2610	1-7/16	2-5/8
1705C-17/64	.2656	1-7/16	2-5/8
1705C-H	.2660	1-1/2	2-11/16
1705C-I	.2720	1-1/2	2-11/16
1705C-J	.2770	1-1/2	2-11/16
1705C-K	.2810	1-1/2	2-11/16
1705C-9/32	.2812	1-1/2	2-11/16
1705C-L	.2900	1-9/16	2-3/4
1705C-M	.2950	1-9/16	2-3/4
1705C-19/64	.2969	1-9/16	2-3/4
1705C-N	.3020	1-5/8	2-13/16
1705C-5/16	.3125	1-5/8	2-13/16
1705C-O	.3160	1-11/16	2-15/16
1705C-P	.3230	1-11/16	2-15/16
1705C-21/64	.3281	1-11/16	2-15/16
1705C-Q	.3320	1-11/16	3
1705C-R	.3390	1-11/16	3
1705C-11/32	.3438	1-11/16	3
1705C-S	.3480	1-3/4	3-1/16
1705C-T	.3580	1-3/4	3-1/16
1705C-23/64	.3594	1-3/4	3-1/16
1705C-U	.3680	1-13/16	3-1/8
1705C-3/8	.3750	1-13/16	3-1/8
1705C-V	.3770	1-7/8	3-1/4
1705C-W	.3860	1-7/8	3-1/4
1705C-25/64	.3906	1-7/8	3-1/4
1705C-X	.3970	1-15/16	3-5/16
1705C-Y	.4040	1-15/16	3-5/16
1705C-13/32	.4062	1-15/16	3-5/16
1705C-Z	.4130	2	3-3/8
1705C-27/64	.4219	2	3-3/8
1705C-7/16	.4375	2-1/16	3-7/16
1705C-29/64	.4531	2-1/8	3-9/16
1705C-15/32	.4688	2-1/8	3-5/8
1705C-31/64	.4844	2-3/16	3-11/16
1705C-1/2	.5000	2-1/4	3-3/4



Screw Machine Drills

List No. 1705

NAS 907-C / Heavy Duty / 135° Split Point/
HSS / Black Oxide Treated



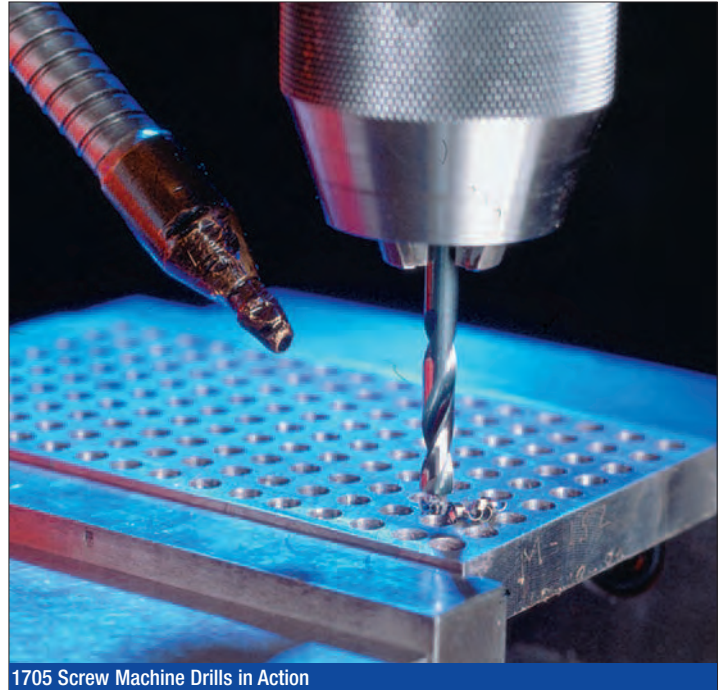
Description: Referred to as "stub drills". The short flute and overall length increase their rigidity, resulting in better hole accuracy and extended tool life.

Application: Recommended for the drilling of sheet metal, stainless steel, truck and mobile home bodies.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1705-60	.0400	1/2	1-3/8	1705-21	.1590	1-1/16	2-1/8
1705-59	.0410	1/2	1-3/8	1705-20	.1610	1-1/16	2-1/8
1705-58	.0420	1/2	1-3/8	1705-19	.1660	1-1/16	2-1/8
1705-57	.0430	1/2	1-3/8	1705-18	.1695	1-1/16	2-1/8
1705-56	.0465	1/2	1-3/8	1705-11/64	.1719	1-1/16	2-1/8
1705-3/64	.0469	1/2	1-3/8	1705-17	.1730	1-1/8	2-3/16
1705-55	.0520	5/8	1-5/8	1705-16	.1770	1-1/8	2-3/16
1705-54	.0550	5/8	1-5/8	1705-15	.1800	1-1/8	2-3/16
1705-53	.0595	5/8	1-5/8	1705-14	.1820	1-1/8	2-3/16
1705-1/16	.0625	5/8	1-5/8	1705-13	.1850	1-1/8	2-3/16
1705-52	.0635	11/16	1-11/16	1705-3/16	.1875	1-1/8	2-3/16
1705-51	.0670	11/16	1-11/16	1705-12	.1890	1-3/16	2-1/4
1705-50	.0700	11/16	1-11/16	1705-11	.1910	1-3/16	2-1/4
1705-49	.0730	11/16	1-11/16	1705-10	.1935	1-3/16	2-1/4
1705-48	.0760	11/16	1-11/16	1705-9	.1960	1-3/16	2-1/4
1705-5/64	.0781	11/16	1-11/16	1705-8	.1990	1-3/16	2-1/4
1705-47	.0785	11/16	1-11/16	1705-7	.2010	1-3/16	2-1/4
1705-46	.0810	3/4	1-3/4	1705-13/64	.2031	1-3/16	2-1/4
1705-45	.0820	3/4	1-3/4	1705-6	.2040	1-1/4	2-3/8
1705-44	.0860	3/4	1-3/4	1705-5	.2055	1-1/4	2-3/8
1705-43	.0890	3/4	1-3/4	1705-4	.2090	1-1/4	2-3/8
1705-42	.0935	3/4	1-3/4	1705-3	.2130	1-1/4	2-3/8
1705-3/32	.0938	3/4	1-3/4	1705-7/32	.2188	1-1/4	2-3/8
1705-41	.0960	13/16	1-13/16	1705-2	.2210	1-5/16	2-7/16
1705-40	.0980	13/16	1-13/16	1705-1	.2280	1-5/16	2-7/16
1705-39	.0995	13/16	1-13/16	1705-A	.2340	1-5/16	2-7/16
1705-38	.1015	13/16	1-13/16	1705-15/64	.2344	1-5/16	2-7/16
1705-37	.1040	13/16	1-13/16	1705-B	.2380	1-3/8	2-1/2
1705-36	.1065	13/16	1-13/16	1705-C	.2420	1-3/8	2-1/2
1705-7/64	.1094	13/16	1-13/16	1705-D	.2460	1-3/8	2-1/2
1705-35	.1100	7/8	1-7/8	1705-1/4/E	.2500	1-7/16	2-1/2
1705-34	.1110	7/8	1-7/8	1705-F	.2570	1-7/16	2-5/8
1705-33	.1130	7/8	1-7/8	1705-G	.2610	1-7/16	2-5/8
1705-32	.1160	7/8	1-7/8	1705-17/64	.2656	1-7/16	2-5/8
1705-31	.1200	7/8	1-7/8	1705-H	.2660	1-1/2	2-11/16
1705-1/8	.1250	7/8	1-7/8	1705-I	.2720	1-1/2	2-11/16
1705-30	.1285	15/16	1-15/16	1705-J	.2770	1-1/2	2-11/16
1705-29	.1360	15/16	1-15/16	1705-K	.2810	1-1/2	2-11/16
1705-28	.1405	15/16	1-15/16	1705-9/32	.2812	1-1/2	2-11/16
1705-9/64	.1406	15/16	1-15/16	1705-L	.2900	1-9/16	2-3/4
1705-27	.1440	1	2-1/16	1705-M	.2950	1-9/16	2-3/4
1705-26	.1470	1	2-1/16	1705-19/64	.2969	1-9/16	2-3/4
1705-25	.1495	1	2-1/16	1705-N	.3020	1-5/8	2-13/16
1705-24	.1520	1	2-1/16	1705-5/16	.3125	1-5/8	2-13/16
1705-23	.1540	1	2-1/16	1705-O	.3160	1-11/16	2-15/16
1705-5/32	.1562	1	2-1/16	1705-P	.3230	1-11/16	2-15/16
1705-22	.1570	1-1/16	2-1/8	1705-21/64	.3281	1-11/16	2-15/16



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1705-Q	.3320	1-11/16	3
1705-R	.3390	1-11/16	3
1705-11/32	.3438	1-11/16	3
1705-S	.3480	1-3/4	3-1/16
1705-T	.3580	1-3/4	3-1/16
1705-23/64	.3594	1-3/4	3-1/16
1705-U	.3680	1-13/16	3-1/8
1705-3/8	.3750	1-13/16	3-1/8
1705-V	.3770	1-7/8	3-1/4
1705-W	.3860	1-7/8	3-1/4
1705-25/64	.3906	1-7/8	3-1/4
1705-X	.3970	1-15/16	3-5/16
1705-Y	.4040	1-15/16	3-5/16
1705-13/32	.4062	1-15/16	3-5/16
1705-Z	.4130	2	3-3/8
1705-27/64	.4219	2	3-3/8
1705-7/16	.4375	2-1/16	3-7/16
1705-29/64	.4531	2-1/8	3-9/16
1705-15/32	.4688	2-1/8	3-5/8
1705-31/64	.4844	2-3/16	3-11/16
1705-1/2	.5000	2-1/4	3-3/4



1705 Screw Machine Drills in Action



BruteLube Cutting Fluid & Wax

List No. XLUB

Description: Multi-purpose cutting and tapping fluid specially formulated to extend tool life and reduce chip welding. Provides a precision finish with closer tolerances on finished work. Complies with OSHA regulations and contains no 1,1,1 Trichloroethane. Formulated to cling to tools for a continuous shield against friction and heat.

List No. XLUB-WAX

Description: Formulated to extend tool life, reduce chip welding and clings to the tool at any angle, including overhead operations. Continuous shield against friction and heat, reducing tool costs and work piece scrap. Provides a close tolerance precision finish. Effective on stainless steel, aluminum, and exotic alloys.



EDP No.	Description
XLUB4	4 oz.
XLUB16	16 oz.
XLUB128	1 gallon
XLUB-WAX-2	2 oz.
XLUB-WAX16	17 oz.
XLUB-STICK-16	16 oz.

See pages 163-164 for BruteLube Material Safety Data Sheets

CHAMPION

Taper Shank Drills

List No. 702

118° Point / Standard Shank / Surface Treated / HSS

Description: For drilling a wide variety of materials where the driving machinery has a taper shank socket and/or arbor.

Furnished with standard shanks.

Application: Low to medium carbon steels, alloyed steels, steel drop forgings and grey cast iron



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	Shank No.
702-1/8	.1250	1-7/8	5-1/8	1
702-9/64	.1406	2-1/8	5-3/8	1
702-5/32	.1562	2-1/8	5-3/8	1
702-11/64	.1719	2-1/2	5-3/4	1
702-3/16	.1875	2-1/2	5-3/4	1
702-13/64	.2031	2-3/4	6	1
702-7/32	.2188	2-3/4	6	1
702-15/64	.2344	2-7/8	6-1/8	1
702-1/4	.2500	2-7/8	6-1/8	1
702-17/64	.2656	3	6-1/4	1
702-9/32	.2812	3	6-1/4	1
702-5/16	.3125	3-1/8	6-3/8	1
702-21/64	.3281	3-1/4	6-1/2	1
702-11/32	.3438	3-1/4	6-1/2	1
702-23/64	.3594	3-1/2	6-3/4	1
702-3/8	.3750	3-1/2	6-3/4	1
702-25/64	.3906	3-5/8	7	1
702-13/32	.4062	3-5/8	7	1
702-27/64	.4219	3-7/8	7-1/4	1
702-7/16	.4375	3-7/8	7-1/4	1
702-29/64	.4531	4-1/8	7-1/2	1
702-15/32	.4688	4-1/8	7-1/2	1
702-31/64	.4844	4-3/8	8-1/4	2
702-1/2	.5000	4-3/8	8-1/4	2
702-33/64	.5156	4-5/8	8-1/2	2
702-17/32	.5312	4-5/8	8-1/2	2
702-35/64	.5469	4-7/8	8-3/4	2
702-9/16	.5625	4-7/8	8-3/4	2
702-37/64	.5781	4-7/8	8-3/4	2
702-19/32	.5938	4-7/8	8-3/4	2
702-39/64	.6094	4-7/8	8-3/4	2
702-5/8	.6250	4-7/8	8-3/4	2
702-41/64	.6406	5-1/8	9	2
702-21/32	.6562	5-1/8	9	2
702-43/64	.6719	5-3/8	9-1/4	2
702-11/16	.6875	5-3/8	9-1/4	2
702-45/64	.7031	5-5/8	9-1/2	2
702-23/32	.7188	5-5/8	9-1/2	2
702-47/64	.7344	5-7/8	9-3/4	2
702-3/4	.7500	5-7/8	9-3/4	2
702-49/64	.7656	6	9-7/8	2
702-25/32	.7812	6	9-7/8	2
702-51/64	.7969	6-1/8	10-3/4	3
702-13/16	.8125	6-1/8	10-3/4	3
702-53/64	.8281	6-1/8	10-3/4	3
702-27/32	.8438	6-1/8	10-3/4	3
702-55/64	.8594	6-1/8	10-3/4	3

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	Shank No.
702-7/8	.8750	6-1/8	10-3/4	3
702-57/64	.8906	6-1/8	10-3/4	3
702-29/32	.9062	6-1/8	10-3/4	3
702-59/64	.9219	6-1/8	10-3/4	3
702-15/16	.9375	6-1/8	10-3/4	3
702-61/64	.9531	6-3/8	11	3
702-31/32	.9688	6-3/8	11	3
702-63/64	.9844	6-3/8	11	3
702-1	1.0000	6-3/8	11	3
702-1-1/64	1.0156	6-1/2	11-1/8	3
702-1-1/32	1.0312	6-1/2	11-1/8	3
702-1-3/64	1.0469	6-5/8	11-1/4	3
702-1-1/16	1.0625	6-5/8	11-1/4	3
702-1-5/64	1.0781	6-7/8	12-1/2	4
702-1-3/32	1.0938	6-7/8	12-1/2	4
702-1-7/64	1.1094	7-1/8	12-3/4	4
702-1-1/8	1.1250	7-1/8	12-3/4	4
702-1-9/64	1.1406	7-1/4	12-7/8	4
702-1-5/32	1.1562	7-1/4	12-7/8	4
702-1-11/64	1.1719	7-3/8	13	4
702-1-3/16	1.1875	7-3/8	13	4
702-1-13/64	1.2031	7-1/2	13-1/8	4
702-1-7/32	1.2188	7-1/2	13-1/8	4
702-1-15/64	1.2344	7-7/8	13-1/2	4
702-1-1/4	1.2500	7-7/8	13-1/2	4
702-1-17/64	1.2656	8-1/2	14-1/8	4
702-1-9/32	1.2812	8-1/2	14-1/8	4
702-1-19/64	1.2969	8-5/8	14-1/4	4
702-1-5/16	1.3125	8-5/8	14-1/4	4
702-1-21/64	1.3281	8-3/4	14-3/8	4
702-1-11/32	1.3438	8-3/4	14-3/8	4
702-1-23/64	1.3594	8-7/8	14-1/2	4
702-1-3/8	1.3750	8-7/8	14-1/2	4
702-1-25/64	1.3906	9	14-5/8	4
702-1-13/32	1.4062	9	14-5/8	4
702-1-27/64	1.4219	9-1/8	14-3/4	4
702-1-7/16	1.4375	9-1/8	14-3/4	4
702-1-29/64	1.4531	9-1/4	14-7/8	4
702-1-15/32	1.4688	9-1/4	14-7/8	4
702-1-31/64	1.4844	9-3/8	15	4
702-1-1/2	1.5000	9-3/8	15	4
702-1-17/32	1.5312	9-3/8	16-3/8	5
702-1-9/16	1.5625	9-5/8	16-5/8	5
702-1-19/32	1.5938	9-7/8	16-7/8	5
702-1-5/8	1.6250	10	17	5
702-1-21/32	1.6562	10-1/8	17-1/8	5
702-1-11/16	1.6875	10-1/8	17-1/8	5



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	Shank No.	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	Shank No.
702-1-23/32	1.7188	10-1/8	17-1/8	5	702-2-7/32	2.2188	10-1/8	17-3/8	5
702-1-3/4	1.7500	10-1/8	17-1/8	5	702-2-1/4	2.2500	10-1/8	17-3/8	5
702-1-25/32	1.7812	10-1/8	17-1/8	5	702-2-5/16	2.3125	10-1/8	17-3/8	5
702-1-13/16	1.8125	10-1/8	17-1/8	5	702-2-3/8	2.3750	10-1/8	17-3/8	5
702-1-27/32	1.8438	10-1/8	17-1/8	5	702-2-7/16	2.4375	11-1/4	18-3/4	5
702-1-7/8	1.8750	10-3/8	17-3/8	5	702-2-1/2	2.5000	11-1/4	18-3/4	5
702-1-29/32	1.9062	10-3/8	17-3/8	5	702-2-9/16	2.5625	11-7/8	19-1/2	5
702-1-15/16	1.9375	10-3/8	17-3/8	5	702-2-5/8	2.6250	11-7/8	19-1/2	5
702-1-31/32	2.0000	10-3/8	17-3/8	5	702-2-11/16	2.6875	11-7/8	20-3/8	5
702-2	2.0312	10-3/8	17-3/8	5	702-2-3/4	2.7500	12-3/4	20-3/8	5
702-2-1/32	2.0625	10-1/4	17-3/8	5	702-2-13/16	2.8125	13-3/8	21-1/8	5
702-2-1/16	2.0938	10-1/4	17-3/8	5	702-2-7/8	2.8750	13-3/8	21-1/8	5
702-2-3/32	2.1250	10-1/4	17-3/8	5	702-2-15/16	2.9375	14	21-3/4	5
702-2-1/8	2.1562	10-1/4	17-3/8	5	702-3	3.0000	14	21-3/4	5
702-2-5/32	2.1875	10-1/4	17-3/8	5	702-3-1/8	3.1250	14-5/8	24-1/2	6
702-2-3/16	2.2188	10-1/4	17-3/8	5	702-3-1/4	3.2500	15-1/2	25-1/2	6



Precision Manufactured Taper Shank Drills



Taper Shank Reducing Sleeves

List No. S1



Description: Steel sleeves are used to adapt taper shank tools where the drill shank is smaller than the machine spindle hole.

Application: Used with Taper Shank Drills #702.

EDP No.	Description	EDP No.	Description
S1-1/2	#1 Hole/#2 Shank	S1-2/5	#2 Hole/#5 Shank
S1-1/3	#1 Hole/#3 Shank	S1-3/4	#3 Hole/#4 Shank
S1-1/4	#1 Hole/#4 Shank	S1-3/5	#3 Hole/#5 Shank
S1-1/5	#1 Hole/#5 Shank	S1-4/5	#4 Hole/#5 Shank
S1-2/3	#2 Hole/#3 Shank	S1-4/6	#4 Hole/#6 Shank
S1-2/4	#2 Hole/#4 Shank	S1-5/6	#5 Hole/#6 Shank



Taper Shank Extension Sockets

List No. S2



Description: Used to adapt taper shank tools where the drill shank is larger than the machine spindle hole. They can be used to extend the length of the drill down from the machine spindle.

Application: Used with Taper Shank Drills #702.

EDP No.	Description	EDP No.	Description
S2-1/2	#1 Hole/#2 Shank	S2-3/4	#3 Hole/#4 Shank
S2-1/3	#1 Hole/#3 Shank	S2-3/5	#3 Hole/#5 Shank
S2-1/4	#1 Hole/#4 Shank	S2-4/3	#4 Hole/#3 Shank
S2-1/5	#1 Hole/#5 Shank	S2-4/4	#4 Hole/#4 Shank
S2-2/2	#2 Hole/#2 Shank	S2-4/5	#4 Hole/#5 Shank
S2-2/3	#2 Hole/#3 Shank	S2-4/6	#4 Hole/#6 Shank
S2-2/4	#2 Hole/#4 Shank	S2-5/3	#5 Hole/#3 Shank
S2-2/5	#2 Hole/#5 Shank	S2-5/4	#5 Hole/#4 Shank
S2-3/2	#3 Hole/#2 Shank	S2-5/5	#5 Hole/#5 Shank
S2-3/3	#3 Hole/#3 Shank	S2-5/6	#5 Hole/#6 Shank



Drill Drift Keys

List No. D1

Multiple Use Ejection Keys



Description: Used to eject taper shank drills & sockets / sleeves from machine spindles.

Application: Used with Taper Shank Drills #702.

EDP No.	Length Inches	Fits Sockets and Sleeves
D1-1015	5	No. 1
D1-2026	6	No. 2
D1-3037	7	No. 3
D1-4068-1/2	8-1/2	No. 4,5,6

Twisted or broken tangs



Morse taper shanks are defined as self driving, that is they are designed and made to drive off the taper — **not the tang.**

The tang is for ejection purposes only. Tang failures are due to a bad fit between the shank and the socket — thus taking the drive off the taper and putting it on the tang.

CHAMPION

Taper Length Drills

List No. 704

118° Point / Straight Shank / HSS / Black Oxide



Description: Taper length drills have approximately the same overall flute lengths as taper shank drills and are longer than Champion 705 drills. Their shanks are of the same nominal diameter as the drill.

Application: Frequently used in lathes and screw machines. For low carbon steels, alloyed steels, steel drop forgings and grey cast iron

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
704-3/64	.0469	1-1/8	2-1/4	704-25/32	.7812	6	9-7/8
704-1/16	.0625	1-3/4	3	704-51/64	.7969	6-1/8	10
704-5/64	.0781	2	3-3/4	704-13/16	.8125	6-1/8	10
704-3/32	.0937	2-1/4	4-1/4	704-53/64	.8281	6-1/8	10
704-7/64	.1094	2-1/2	4-5/8	704-27/32	.8438	6-1/8	10
704-1/8	.1250	2-3/4	5-1/8	704-55/64	.8594	6-1/8	10
704-9/64	.1406	3	5-3/8	704-7/8	.8750	6-1/8	10
704-5/32	.1562	3	5-3/8	704-57/64	.8906	6-1/8	10
704-11/64	.1719	3-3/8	5-3/4	704-29/32	.9062	6-1/8	10
704-3/16	.1875	3-3/8	5-3/4	704-59/64	.9219	6-1/8	10-3/4
704-13/64	.2031	3-5/8	6	704-15/16	.9375	6-1/8	10-3/4
704-7/32	.2187	3-5/8	6	704-61/64	.9531	6-3/8	11
704-15/64	.2344	3-3/4	6-1/8	704-31/32	.9688	6-3/8	11
704-1/4	.2500	3-3/4	6-1/8	704-63/64	.9844	6-3/8	11
704-17/64	.2656	3-7/8	6-1/4	704-1	1.0000	6-3/8	11
704-9/32	.2812	3-7/8	6-1/4	704-1-1/64	1.0156	6-1/2	11-1/8
704-19/64	.2969	4	6-3/8	704-1-1/32	1.0312	6-1/2	11-1/8
704-5/16	.3125	4	6-3/8	704-1-3/64	1.0469	6-5/8	11-1/4
704-21/64	.3281	4-1/8	6-1/2	704-1-1/16	1.0625	6-5/8	11-1/4
704-11/32	.3438	4-1/8	6-1/2	704-1-5/64	1.0781	6-7/8	11-1/2
704-23/64	.3594	4-1/4	6-3/4	704-1-3/32	1.0938	6-7/8	11-1/2
704-3/8	.3750	4-1/4	6-3/4	704-1-7/64	1.1094	7-1/8	11-3/4
704-25/64	.3906	4-3/8	7	704-1-1/8	1.1250	7-1/8	11-3/4
704-13/32	.4062	4-3/8	7	704-1-9/64	1.1406	7-1/4	11-7/8
704-27/64	.4219	4-5/8	7-1/4	704-1-5/32	1.1562	7-1/4	11-7/8
704-7/16	.4375	4-5/8	7-1/4	704-1-11/64	1.1719	7-3/8	12
704-29/64	.4531	4-3/4	7-1/2	704-1-3/16	1.1875	7-3/8	12
704-15/32	.4687	4-3/4	7-1/2	704-1-13/64	1.2031	7-1/2	12-1/8
704-31/64	.4844	4-3/4	7-3/4	704-1-7/32	1.2188	7-1/2	12-1/8
704-1/2	.5000	4-3/4	7-3/4	704-1-15/64	1.2344	7-7/8	12-1/2
704-33/64	.5156	4-3/4	8	704-1-1/4	1.2500	7-7/8	12-1/2
704-17/32	.5312	4-3/4	8	704-1-9/32	1.2812	8-1/2	14-1/8
704-35/64	.5469	4-7/8	8-1/4	704-1-5/16	1.3125	8-5/8	14-1/4
704-9/16	.5625	4-7/8	8-1/4	704-1-11/32	1.3438	8-3/4	14-3/8
704-37/64	.5781	4-7/8	8-3/4	704-1-3/8	1.3750	8-7/8	14-1/2
704-19/32	.5938	4-7/8	8-3/4	704-1-13/32	1.4062	9	14-5/8
704-39/64	.6094	4-7/8	8-3/4	704-1-7/16	1.4375	9-1/8	14-3/4
704-5/8	.6250	4-7/8	8-3/4	704-1-15/32	1.5625	9-1/4	14-7/8
704-41/64	.6406	5-1/8	9	704-1-1/2	1.5000	9-3/8	15
704-21/32	.6562	5-1/8	9	704-1-9/16	1.5625	9-5/8	15-1/4
704-43/64	.6719	5-3/8	9-1/4	704-1-5/8	1.6250	9-7/8	15-5/8
704-11/16	.6875	5-3/8	9-1/4	704-1-3/4	1.7500	10-1/2	16-1/4
704-45/64	.7031	5-5/8	9-1/2				
704-23/32	.7188	5-5/8	9-1/2				
704-47/64	.7344	5-7/8	9-3/4				
704-3/4	.7500	5-7/8	9-3/4				
704-49/64	.7656	6	9-7/8				

CHAMPION

Screw Extractors

List No. X1

Left Hand / Spiral Flute



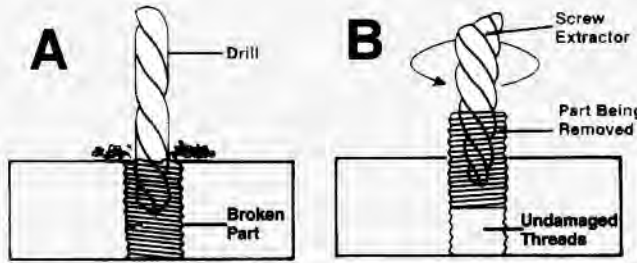
List No. X2

Straight Flute Extractors



Description: For the removal of broken screws, studs, bolts or pipe fittings. The left hand rotation of the tapered flutes forces out almost any right hand threaded part. Penetrating oil can be helpful in removing rusty or corroded parts. Sizes X1 thru X5 are available in an iPac combination pack with the relevant left hand XL5 drill bit.

X2 extractors are used by first hammering them into the broken bolt.



To remove a broken screw:

Drill a hole in the broken screw with the recommended diameter drill (fig. A).

Insert the proper screw extractor into the hole and start a counterclockwise (left-hand) rotation (fig. B).

Please specify X2 to order Straight Flute Screw Extractors

EDP No. / Diameter	Diameter Small End	Diameter Large End	Overall Length	For Bolt Sizes	For Pipe Sizes	Drill Size
X1-1*/ X2-1	.054	5/32	2	3/16 to 1/4	—	5/64
X1-2*/ X2-2	.80	3/16	2-3/8	1/4 to 5/16	—	7/64
X1-3*/ X2-3	1/8	1/4	2-11/16	5/16 to 7/16	—	5/32
X1-4*/ X2-4	3/16	21/64	2-7/8	7/16 to 9/16	—	1/4
X1-5*/ X2-5	1/4	7/16	3-3/8	9/16 to 3/4	1/8, 1/4	19/64
X1-6 / X2-6	3/8	19/32	3-3/4	3/4 to 1-3/8	3/8	13/32
X1-7 / X2-7	1/2	3/4	4-1/8	1 to 1-3/8	1/2	17/32
X1-8	3/4	1	4-3/8	1-3/8 to 1-3/4	3/4	13/16
X1-9	1	1-9/32	4-5/8	1-3/4 to 2-1/8	1	1-1/16
X1-10	1-1/4	1-9/16	5	2-1/8 to 2-1/2	1-1/4	1-5/16
X1-11	1-1/2	1-7/8	5-5/8	2-1/2 to 3	1-1/2	1-9/16
X1-12	1-7/8	2-15/16	6-1/4	3 to 3-1/2	2	1-15/16'

** After X1 series size indicates that size is available in an iPac combination pack with the relevant left hand XL5 drill bit.

Combination Drill & Screw Extractors Sets



EDP No./ Diameter	Includes
X1-XL5LH	XL5LH Drills 5/64, 7/64, 5/32, 1/4, 19/64 and Screw Extractors #1-5
X1-705LH	705LH Drills 5/64, 7/64, 5/32, 1/4, 19/64 and Screw Extractors #1-5

Screw Extractor Sets



EDP No./ Diameter	Includes
X1-1-5	Screw Extractors #1-5
X1-1-6	Screw Extractors #1-6
X2-1-5	Straight Flute Extractors #1-5
X2-1-6	Straight Flute Extractors #1-6

CHAMPION
GETTING TOOL DONE

CHAMPION

18" Longboy Drills

List No. 1800

118° Point / 13" Flute Length / Bright Finish / Straight Shank / HSS

Description: Designed for general purpose drilling in a wide range of materials in deep hole applications where a maximum 13" flute length is required.

Drills 17/32" and larger will not fit into 1/2" chucks.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1800-3/16	.1875	13	18	1800-23/32	.7188	13	18
1800-7/32	.2188	13	18	1800-47/64	.7344	13	18
1800-1/4	.2500	13	18	1800-3/4	.7500	13	18
1800-9/32	.2812	13	18	1800-49/64	.7656	13	18
1800-5/16	.3125	13	18	1800-25/32	.7812	13	18
1800-11/32	.3438	13	18	1800-51/64	.7969	13	18
1800-3/8	.3750	13	18	1800-13/16	.8125	13	18
1800-13/32	.4062	13	18	1800-53/64	.8281	13	18
1800-7/16	.4375	13	18	1800-27/32	.8438	13	18
1800-15/32	.4688	13	18	1800-55/64	.8594	13	18
1800-1/2	.5000	13	18	1800-7/8	.8750	13	18
1800-17/32	.5312	13	18	1800-57/64	.8906	13	18
1800-9/16	.5625	13	18	1800-29/32	.9062	13	18
1800-5/8	.6250	13	18	1800-59/64	.9219	13	18
1800-41/64	.6406	13	18	1800-15/16	.9375	13	18
1800-21/32	.6562	13	18	1800-61/64	.9531	13	18
1800-43/64	.6719	13	18	1800-31/32	.9688	13	18
1800-11/16	.6875	13	18	1800-63/64	.9844	13	18
1800-45/64	.7031	13	18	1800-1	1.0000	13	18

CHAMPION

1/2" Shank Longboy Drills

List No. 1212

118° Point / Bright Finish / HSS

Description: 1/2" reduced shank for use where chuck capacity is limited to 1/2".

Application: Low carbon steels, alloyed steels, steel drop forgings, grey cast iron, wood.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
1212-17/32	.5312	9	12
1212-9/16	.5625	9	12
1212-5/8	.6250	9	12
1212-3/4	.7500	9	12
1212-7/8	.8750	9	12
1212-1	1.0000	9	12



Flute milling of large diameter twist drills

CHAMPION

12" Longboy Drills

List No. 1200

118° Point / 9" Flute Length / Bright Finish / Straight Shank / HSS



Description: Designed for general purpose drilling in a wide range of materials in deep hole applications where a maximum 9" flute length is required.

Drills 17/32" and larger will not fit into 1/2" chucks.

Application: Low carbon steels, alloyed steels, steel drop forgings, grey cast iron, wood.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
1200-1/8	.1250	9	12	1200-23/64	.3594	9	12
1200-9/64	.1406	9	12	1200-3/8	.3750	9	12
1200-5/32	.1562	9	12	1200-25/64	.3906	9	12
1200-11/64	.1719	9	12	1200-13/32	.4062	9	12
1200-3/16	.1875	9	12	1200-27/64	.4219	9	12
1200-13/64	.2031	9	12	1200-7/16	.4375	9	12
1200-7/32	.2187	9	12	1200-29/64	.4531	9	12
1200-15/64	.2344	9	12	1200-15/32	.4687	9	12
1200-1/4	.2500	9	12	1200-31/64	.4844	9	12
1200-17/64	.2656	9	12	1200-1/2	.5000	9	12
1200-9/32	.2812	9	12	1200-17/32	.5312	9	12
1200-19/64	.2969	9	12	1200-9/16	.5625	9	12
1200-5/16	.3125	9	12	1200-5/8	.6250	9	12
1200-21/64	.3281	9	12	1200-3/4	.7500	9	12
1200-11/32	.3437	9	12				

CHAMPION

12" Aircraft Extension Drills

List No. 7012

135° Split Point / Black Oxide Treated / HSS

List No. CS12X* Contractor Series



Description: Flute length is the same as a standard jobber drill. Single piece construction. Spring tempered shanks prevent permanent bending when drilling holes not in direct alignment.

Application: Designed for drilling holes in aircraft assembly work where long reach is needed.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
7012-60	.0400	11/16	12	7012-46	.0810	1-1/8	12
7012-59	.0410	11/16	12	7012-45	.0820	1-1/8	12
7012-58	.0420	11/16	12	7012-44	.0860	1-1/8	12
7012-57	.0430	3/4	12	7012-43	.0890	1-1/4	12
7012-56	.0465	3/4	12	7012-42	.0935	1-1/4	12
7012-3/64	.0469	3/4	12	7012-3/32	.0938	1-1/4	12
7012-55	.0520	7/8	12	7012-41	.0960	1-3/8	12
7012-54	.0550	7/8	12	7012-40*	.0980	1-3/8	12
7012-53	.0595	7/8	12	7012-39	.0995	1-3/8	12
7012-1/16	.0625	7/8	12	7012-38	.1015	1-7/16	12
7012-52	.0635	7/8	12	7012-37	.1040	1-7/16	12
7012-51	.0670	1	12	7012-36	.1065	1-7/16	12
7012-50	.0700	1	12	7012-7/64	.1094	1-1/2	12
7012-49	.0730	1	12	7012-35	.1100	1-1/2	12
7012-48	.0760	1	12	7012-34	.1110	1-1/2	12
7012-5/64	.0781	1	12	7012-33	.1130	1-1/2	12
7012-47	.0785	1	12	7012-32	.1160	1-5/8	12

*Please specify CS12X when ordering.



List No. 7012 & CS12X* continued



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
7012-31	.1200	1-5/8	12
7012-1/8*	.1250	1-5/8	12
7012-30*	.1285	1-5/8	12
7012-29*	.1360	1-3/4	12
7012-28	.1405	1-3/4	12
7012-9/64	.1406	1-3/4	12
7012-27	.1440	1-7/8	12
7012-26	.1470	1-7/8	12
7012-25	.1495	1-7/8	12
7012-24	.1520	2	12
7012-23	.1540	2	12
7012-5/32	.1562	2	12
7012-22	.1570	2	12
7012-21*	.1590	2-1/8	12
7012-20*	.1610	2-1/8	12
7012-19	.1660	2-1/8	12
7012-18	.1695	2-1/8	12
7012-11/64	.1719	2-1/8	12
7012-17	.1730	2-3/16	12
7012-16	.1770	2-3/16	12
7012-15	.1800	2-3/16	12
7012-14	.1820	2-3/16	12
7012-13	.1850	2-5/16	12
7012-3/16*	.1875	2-5/16	12
7012-12	.1890	2-5/16	12
7012-11*	.1910	2-5/16	12
7012-10*	.1935	2-7/16	12
7012-9	.1960	2-7/16	12
7012-8	.1990	2-7/16	12
7012-7	.2010	2-7/16	12
7012-13/64	.2031	2-7/16	12
7012-6	.2040	2-1/2	12
7012-5	.2055	2-1/2	12
7012-4	.2090	2-1/2	12
7012-3	.2130	2-1/2	12
7012-7/32	.2188	2-1/2	12
7012-2	.2210	2-5/8	12
7012-1*	.2280	2-5/8	12
7012-15/64	.2344	2-5/8	12
7012-1/4*	.2500	2-3/4	12
7012-17/64	.2656	2-7/8	12
7012-9/32	.2812	2-15/16	12
7012-19/64	.2969	3-1/16	12
7012-5/16*	.3125	3-3/16	12
7012-21/64	.3281	3-5/16	12
7012-11/32	.3438	3-7/16	12
7012-23/64	.3594	3-1/2	12

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
7012-3/8*	.3750	3-5/8	12
7012-25/64	.3906	3-3/4	12
7012-13/32	.4062	3-7/8	12
7012-27/64	.4219	3-15/16	12
7012-7/16*	.4375	4-1/16	12
7012-29/64	.4531	4-3/16	12
7012-15/32	.4688	4-5/16	12
7012-31/64	.4844	4-3/8	12
7012-1/2*	.5000	4-1/2	12

*Please specify CS12X when ordering.



Flute milling of taper shank drills



6" Aircraft Extension Drills

List No. 7006

135° Split Point / Black Oxide Treated / HSS

List No. CS6X* Contractor Series



Description: The flute length on these drills is the same as a standard jobber drill. Single piece construction.

Application: For drilling holes in "hard-to-reach" places, especially in aircraft assembly work.

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
7006-60	.0400	11/16	6
7006-59	.0410	11/16	6
7006-58	.0420	11/16	6
7006-57	.0430	3/4	6
7006-56	.0465	3/4	6
7006-3/64	.0469	3/4	6
7006-55	.0520	7/8	6
7006-54	.0550	7/8	6
7006-53	.0595	7/8	6
7006-1/16*	.0625	7/8	6
7006-52	.0635	7/8	6
7006-51	.0670	1	6
7006-50	.0700	1	6
7006-49	.0730	1	6
7006-48	.0760	1	6
7006-5/64*	.0781	1	6
7006-47	.0785	1	6
7006-46	.0810	1-1/8	6
7006-45	.0820	1-1/8	6
7006-44	.0860	1-1/8	6
7006-43	.0890	1-1/4	6
7006-42	.0935	1-1/4	6
7006-3/32*	.0938	1-1/4	6
7006-41	.0960	1-3/8	6
7006-40*	.0980	1-3/8	6
7006-39	.0995	1-3/8	6
7006-38	.1015	1-7/16	6
7006-37	.1040	1-7/16	6
7006-36	.1065	1-7/16	6
7006-7/64*	.1094	1-1/2	6
7006-35	.1100	1-1/2	6
7006-34	.1110	1-1/2	6
7006-33	.1130	1-1/2	6
7006-32	.1160	1-5/8	6
7006-31	.1200	1-5/8	6
7006-1/8*	.1250	1-5/8	6
7006-30*	.1285	1-5/8	6
7006-29*	.1360	1-3/4	6
7006-28	.1405	1-3/4	6
7006-9/64*	.1406	1-3/4	6
7006-27	.1440	1-7/8	6
7006-26	.1470	1-7/8	6
7006-25	.1495	1-7/8	6
7006-24	.1520	2	6
7006-23	.1540	2	6
7006-5/32*	.1562	2	6
7006-22	.1570	2	6

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
7006-21*	.1590	2-1/8	6
7006-20*	.1610	2-1/8	6
7006-19	.1660	2-1/8	6
7006-18	.1695	2-1/8	6
7006-11/64*	.1719	2-1/8	6
7006-17	.1730	2-3/16	6
7006-16	.1770	2-3/16	6
7006-15	.1800	2-31/64	6
7006-14	.1820	2-3/16	6
7006-13	.1850	2-5/16	6
7006-3/16*	.1875	2-5/16	6
7006-12	.1890	2-5/16	6
7006-11*	.1910	2-5/16	6
7006-10*	.1935	2-7/16	6
7006-9	.1960	2-7/16	6
7006-8	.1990	2-7/16	6
7006-7	.2010	2-7/16	6
7006-13/64*	.2031	2-7/16	6
7006-6	.2040	2-1/2	6
7006-5	.2055	2-1/2	6
7006-4	.2090	2-1/2	6
7006-3	.2130	2-1/2	6
7006-7/32*	.2188	2-1/2	6
7006-2	.2210	2-5/8	6
7006-1*	.2280	2-5/8	6
7006-A	.2340	2-5/8	6
7006-15/64*	.2344	2-5/8	6
7006-B	.2380	2-3/4	6
7006-C	.2420	2-3/4	6
7006-D	.2460	2-3/4	6
7006-1/4*	.2500	2-3/4	6
7006-E	.2500	2-3/4	6
7006-F	.2570	2-7/8	6
7006-9/32*	.2812	2-15/16	6
7006-5/16*	.3125	3-3/16	6
7006-3/8*	.3750	3-5/8	6

*Please specify CS6X when ordering.





Hex Shank Multi Step Drills

List No. MSD-HEX

Titanium Nitride Coated / 1/4" Hex Shank / Split Point



Description: Graduated step design creates clean, accurate, bur-free holes of multiple diameters in all sheet metals up to 1/8" thick. Self starting tip eliminates the need for pilot hole drilling. Hex shank for quick fit use in portable power tools.

Application: Junction boxes, switch boxes, metal studs, electrical appliances, lighting fixtures, PVC, plexiglass and auto body repair.

An Entire Drill Set In One Drill



- Titanium Nitride Coated for extended life and increased performance
- Cuts steel plate, stainless steel, sheet metal and tubing
- 1/4" Hex shank for use in QCD (quick change driver)
- Self starting, split-point bites right in, reduces walking
- Step size laser marked onto tool
- 2 flute design provides balanced, symmetrical and faster, cleaner holes
- Great in cordless impact drivers
- Perfect for use in battery powered drills because they cut quickly with low power consumption



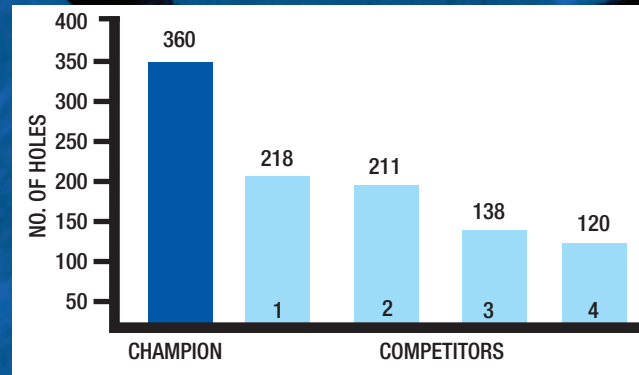
MSD-HEX Performance

65% more holes than the nearest competitor

Life Testing performed on Champion MSD-Hex Drills versus four competitor products.

Test parameters included:

- Fixed force of 50lbs
- 1/2" hole to be drilled
- Maximum time limit of 60 seconds allowed
- Maximum 360 holes per bit recorded



EDP No./ Diameter	Size Range
MSD-HEX-1	1/8-1/2 (13 Step)
MSD-HEX-3	1/4-3/4 (9 Step)
MSD-HEX-4	3/16-7/8 (12 Step)
MSD-HEX-13	1/4x1-1/8 (13 Step)

EDP No./	Contents
MSD-HEX-SET	MSD-HEX-1, MSD-HEX-3, MSD-HEX-4 & QCD

EDP No./	Contents
ELEC-KIT	MSD-HEX-13, CT3 hole cutters(7/8, 1-1/8, 1-3/8) and QCD (Quick Change Driver)

EDP No./	Contents
QCD	Quick change driver for 1/4" & 3/8" hex shank tools

1/4" SHANK EXTENSIONS List No. QCD-EXT-6/12/24

EDP No./	Description
QCD-EXT-6*	6" Extension drive for 1/4" hex shank tools
QCD-EXT-12*	12" Extension drive for 1/4" hex shank tools
QCD-EXT-24*	24" Extension drive for 1/4" hex shank tools

* Will only accommodate 1/4" shanks



MSD-HEX-SET including QCD (quick change driver)



- Industrial quality quick change driver extensions for 1/4" shank tools with hex shanks
- Designed for one-handed quick release
- Carbon steel manufacture for extended tool life
- Fits old and new 1/4" hex shanks with or without power groove

CHAMPION

Multi Step Drills

List No. MSD

2 Flute / HSS / Split Point



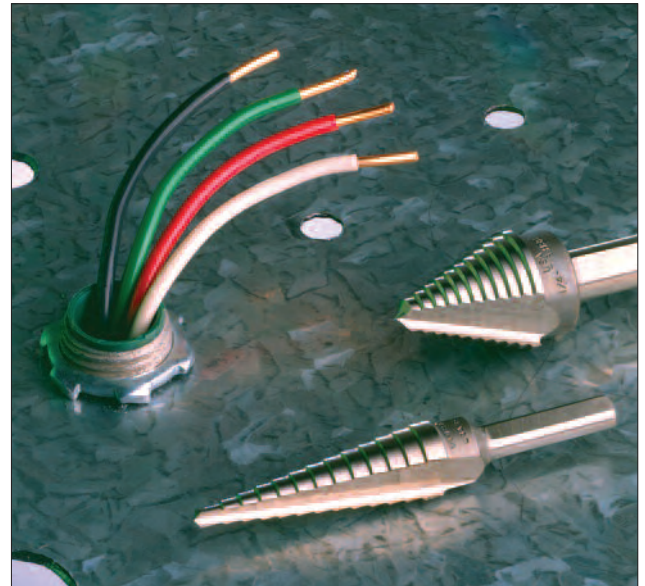
Description: Graduated step design creates clean, accurate, bur-free holes of multiple diameters in all sheet metals up to 1/8" thick. Self starting tip eliminates the need for pilot hole drilling, while the balanced double flute design provides less chattering. Any MSD will fit a 1/2" drill.

Application: Junction boxes, switch boxes, metal studs, electrical appliances, lighting fixtures, PVC, plexiglass and auto body repair.

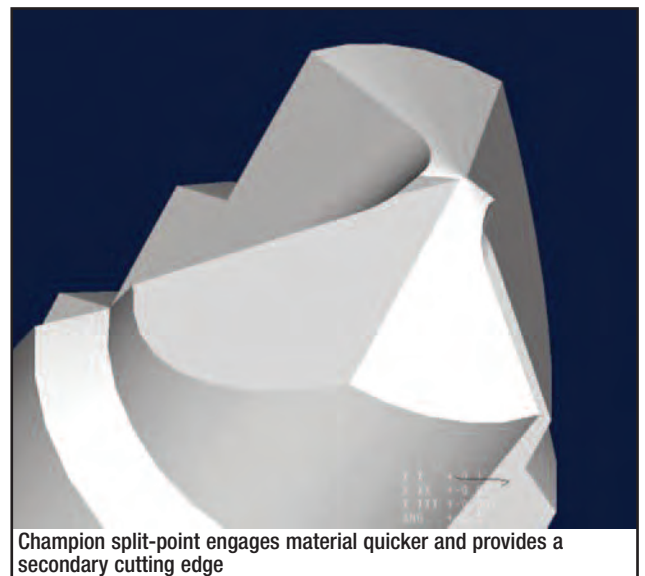
EDP No./ Diameter	No. of Steps	Size Range
MSD-1/2 x 1/8	13	1/8-1/2 x 32nds
MSD-1/2 x 3/16	6	3/16-1/2 x 16ths
MSD-7/8 x 1/4	9	single hole - 7/8
MSD-3/4 x 1/4	9	1/4-3/4 x 16ths
MSD-7/8 x 3/16	12	3/16-7/8 x 16ths
MSD-1-1/8 x 7/16	12	7/16-1-1/8 x 16ths
MSD-3/8	1	single hole - 3/8
MSD-1/2	1	single hole - 1/2
MSD-1x9/16*	9	9/16-1 x 16ths
MSD-1-3/8 x 1/4	10	3/4-1-3/8 x 16ths
MSD-1-1/8 x 1/4	1	single hole - 1-1/8
MSD-1-1/2 x 1/4	11	1/4-1-1/2 x 8ths

*MSD1x9/16 has no drill point

EDP No./	Contents
MSD-SET	MSD-1/2 x 1/8, MSD-1/2 x 3/16, MSD-3/4 x 1/4



MSD-SET



Champion split-point engages material quicker and provides a secondary cutting edge

CROSS REFERENCE:

CHAMPION MSD	UNIBIT®	KLEIN®	VARIBIT®	BOSCH®	MK MORSE®
1/2X1/8	#1	59001	VB1	SDH1	ESD01
7/8X3/16	#4	590014	VB8	SDH2	ESD03
3/4X1/4	#3	59003	VB3	SDH3	ESD04
7/8X1/4	#11	59008	VB7	SDH5	ESD10
3/8	#12	59007	VB6	SDH12	ESD06
1/2	#10	59007	VB6	SDH8	ESD07
1X9/16	#20	59002	VB2	SDH7	ESD08
1/2X3/16	#2	59005	VB4	SDH6	ESD02
1-3/8X1/4	#5	59004	VB12		
1-1/8X1/4	#13	590011	VB11	SDH11	ESD05

CHAMPION

Locksmith Drills

List No. CT705

Carbide Tipped / Straight Flute

Description & Application: For non-precision drilling of hardened steel and safes. Ideal for drilling and extracting broken hardened bolts, such as grade 5 and grade 8.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
CT705-1/8	.1250	1-1/2	2-3/4	CT705-1/4x6	.2500	4-1/4	6
CT705-5/32	.1562	1-7/8	3	CT705-5/16x4	.3125	2-1/2	4
CT705-3/16	.1875	1-7/8	3	CT705-5/16x6	.3125	4-1/4	6
CT705-7/32	.2187	2-1/2	4	CT705-3/8x6	.3750	4	6
CT705-1/4x4	.2500	2-1/2	4	CT705-1/2x6	.5000	4	6

CHAMPION

Die Drills

List No. CT605

Carbide Tipped /118° Point / Straight Flute

Description & Application:

For precision drilling of hardened steel and armor plate in the range of 48 to 65 Rockwell C. Drill body is reduced in size to prevent galling when drilling hard steels.

Use a constant flow of coolant and clear chips frequently. A light feed with steady pressure at 75-100 SFM (surface feed/minute) is recommended.



EDP No. / Diameter	Decimal Equivalent	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Shank Diameter	Flute Length	Overall Length
CT605-3/16	.1875	11/64	1-1/2	3-1/2	CT605-1/2	.5000	15/32	3-1/2	6
CT605-7/32	.2188	13/64	1-3/4	3-3/4	CT605-17/32	.5312	1/2	3-1/2	6
CT605-1/4	.2500	7/32	2	4	CT605-9/16	.5625	17/32	3-1/2	6
CT605-9/32	.2812	1/4	2-1/4	4-1/4	CT605-19/32	.5938	9/16	4	7
CT605-5/16	.3125	9/32	2-1/2	4-1/2	CT605-5/8	.6250	19/32	4	7
CT605-11/32	.3438	5/16	2-3/4	4-3/4	CT605-21/32	.6562	5/8	4-1-2	7-1/2
CT605-3/8	.3750	11/32	3	5	CT605-11/16	.6875	21/32	4-1/2	7-1/2
CT605-13/32	.4062	3/8	3	5-1/4	CT605-23/32	.7188	11/16	4-3/4	8
CT605-7/16	.4375	13/32	3	5-1/2	CT605-3/4	.7500	11/16	4-3/4	1
CT605-15/32	.4688	7/16	3-1/4	5-3/4					

CHAMPION

Glass & Tile Drills

List No. CT505

High Temperature Brazed Carbide Spear Point / Tool Steel Body

Description & Application: Drill glass, tile, porcelain and ceramic. Use constant flow of coolant and clear chips frequently. A light feed with steady pressure at 25 SFM(300 to 600 RPM) is recommended.

Material should be backed with wood or rubber for support during drill breakthrough. Avoid vibration and excessive stress. Keep drill sharp to eliminate excessive pressure.



EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
CT505-1/8	.1250	7/64	2-1/2	CT505-7/16	.4375	3/8	3-1/2
CT505-3/16	.1875	5/32	2-1/2	CT505-1/2	.5000	7/16	3-1/2
CT505-1/4	.2500	7/32	2-1/2	CT505-9/16	.5625	1/2	4
CT505-5/16	.3123	1/4	2-3/4	CT505-5/8	.6250	9/16	4
CT505-3/8	.3750	5/16	3-1/8				

CHAMPION
CUTTING TOOL CORP.

CHAMPION

Carbide Tipped Jobber Drills

List No. 705CT

Non-Ferrous Applications / 118° Drill Point

Description & Application: For drilling cast iron, cast steel, bronze, hard copper, aluminum and other hard and abrasive nonferrous materials.

Not recommended for use in steel.



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705CT-1/8	.1250	1-5/8	2-3/4
705CT-9/64	.1406	1-3/4	2-7/8
705CT-5/32	.1562	2	3-1/8
705CT-11/64	.1719	2-1/8	3-1/4
705CT-3/16	.1875	2-5/16	3-1/2
705CT-13/64	.2031	2-7/16	3-5/8
705CT-7/32	.2188	2-1/2	3-3/4
705CT-15/64	.2344	2-5/8	3-7/8
705CT-1/4	.2500	2-3/4	4
705CT-17/64	.2656	2-7/8	4-1/8
705CT-9/32	.2812	2-15/16	4-1/4
705CT-19/64	.2969	3-1/16	4-3/8
705CT-5/16	.3125	3-3/16	4-1/2

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
705CT-21/64	.3281	3-5/16	4-5/8
705CT-11/32	.3438	3-7/16	4-3/4
705CT-23/64	.3594	3-1/2	4-7/8
705CT-3/8	.3750	3-5/8	5
705CT-25/64	.3906	3-3/4	5-1/8
705CT-13/32	.4062	3-7/8	5-1/4
705CT-27/64	.4219	3-15/16	5-3/8
705CT-7/16	.4375	4-1/16	5-1/2
705CT-29/64	.4531	4-3/16	5-5/8
705CT-15/32	.4688	4-5/16	5-3/4
705CT-31/64	.4844	4-3/8	5-7/8
705CT-1/2	.5000	4-1/2	6

CHAMPION

Solid Carbide Drills

List No. 105

118° Drill Point

Description: For nonferrous applications where extreme rigidity is necessary to maintain drilling accuracy or where high drilling temperatures cause the braze of a carbide tip to soften and fail. Not recommended for use in steel.

Application: Cast iron, aluminum, copper, plastics, bronze and other abrasive materials.



EDP No./ Diameter	Flute Length	Overall Length
105-1/32	1/2	1-1/4
105-3/64	3/4	1-1/2
105-1/16	3/4	1-1/2
105-5/64	7/8	1-3/4
105-3/32	1	2
105-7/64	1-1/4	2-1/4
105-1/8	1-1/4	2-1/4
105-9/64	1-3/8	2-1/2
105-5/32	1-3/8	2-1/2
105-11/64	1-5/8	2-3/4
105-3/16	1-5/8	2-3/4
105-13/64	1-3/4	3
105-7/32	1-3/4	3
105-15/64	2	3-1/4
105-1/4	2	3-1/4
105-17/64	2-1/8	3-1/2
105-9/32	2-1/8	3-1/2

EDP No./ Diameter	Flute Length	Overall Length
105-19/64	2-3/8	3-3/4
105-5/16	2-3/8	3-3/4
105-21/64	2-1/2	4
105-11/32	2-1/2	4
105-23/64	2-3/4	4-1/4
105-3/8	2-3/4	4-1/4
105-25/64	2-7/8	4-1/2
105-13/32	2-7/8	4-1/2
105-27/64	2-7/8	4-1/2
105-7/16	2-7/8	4-1/2
105-29/64	3	4-3/4
105-15/32	3	4-3/4
105-31/64	3	4-3/4
105-1/2	3	4-3/4



Double End Sheeter Drills

List No. 1805

135° Split Point / Black Steam Oxide Surface Treated / HSS



Description: For drilling sheet metal. The split point insures proper centering and easy penetration, while the short flute and overall length provide rigidity.

Application: Metal building erection, automobile and truck manufacturing and auto body repair.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
1805-30	.1285	1/2	2
1805-7/64	.1093	1/2	2
1805-1/8	.1250	1/2	2
1805-9/64	.1406	1/2	2
1805-5/32	.1562	1/2	2

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
1805-3/16	.1875	1/2	2
1805-7/32	.2187	1/2	2
1805-1/4	.2500	1/2	2



Corrugated Construction Drills

List No. 2005

135° Split Point / Black & Bright Finish/ HSS



Description: 135° split point and short high helix flute design for self centering, easy penetration and efficient chip removal.

Application: For use in the erection and assembly of corrugated metal buildings.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
2005-1X2-1/4	.2280	1-5/16	2-1/4
2005-1X3	.2280	1-5/16	3

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
2005-1X4-1/2	.2280	1-5/16	4-1/2
2005-1X6	.2280	1-5/16	6



Pilot Drill for Hole Saws

List No. 705-Pilot

118° Split Point / Bright Finish / HSS



Description: Triple slab 1/4" pilot drills feature a self centering 118° split point to fit most styles of hole saw arbors. Notches ground into the shank allow adjustment for varying depth hole saws.

Application: Used with hole saws.

EDP No. / Diameter	Decimal Equivalent	Flute Length	Overall Length
705-Pilot	.2500	1-5/16	4
705-Pilot-iPac	.2500	1-5/16	4

CHAMPION

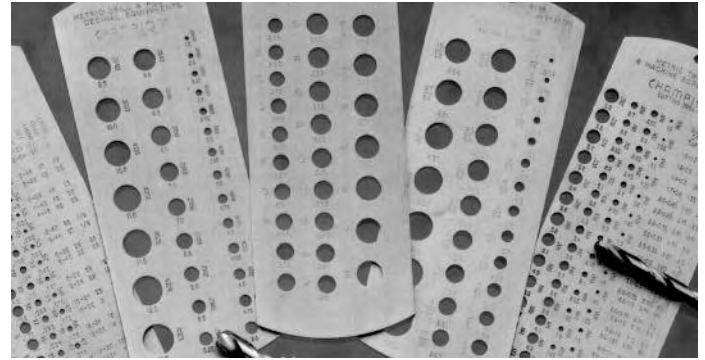
Drill Gauge Plates

High Quality Hardened Steel/ Stain Resistant
Satin Chrome Finish

Description: High quality hardened steel, stain resistant, satin. chrome finish.

Application: Offers a quick and accurate method of checking drill and rod sizes.

EDP No.	Description
G60	1 - 60
G29	1/16 - 1/2 x 64ths
G26	A - Z
GM57	1.0 - 5.9mm
GM30	1.5 - 12.5mm



BruteLube Cutting Fluid & Wax

List No. XLUB

Description: Multi-purpose cutting and tapping fluid specially formulated to extend tool life and reduce chip welding. Provides a precision finish with closer tolerances on finished work. Complies with OSHA regulations and contains no 1,1,1 Trichloroethane. Formulated to cling to tools for a continuous shield against friction and heat.

List No. XLUB-WAX

Description: Formulated to extend tool life, reduce chip welding and clings to the tool at any angle, including overhead operations. Continuous shield against friction and heat, reducing tool costs and work piece scrap. Provides a close tolerance precision finish. Effective on stainless steel, aluminum, and exotic alloys.



EDP No.	Description
XLUB4	4 oz.
XLUB16	16 oz.
XLUB128	1 gallon
XLUB-WAX-2	2 oz.
XLUB-WAX-16	17 oz.
XLUB-STICK-16	16 oz.

See pages 163-164 for BruteLube Material Safety Data Sheets



Hex Shank Bridge Reamers

List No. XL86

Left Hand Spiral Flute / Right Hand Cut / HSS

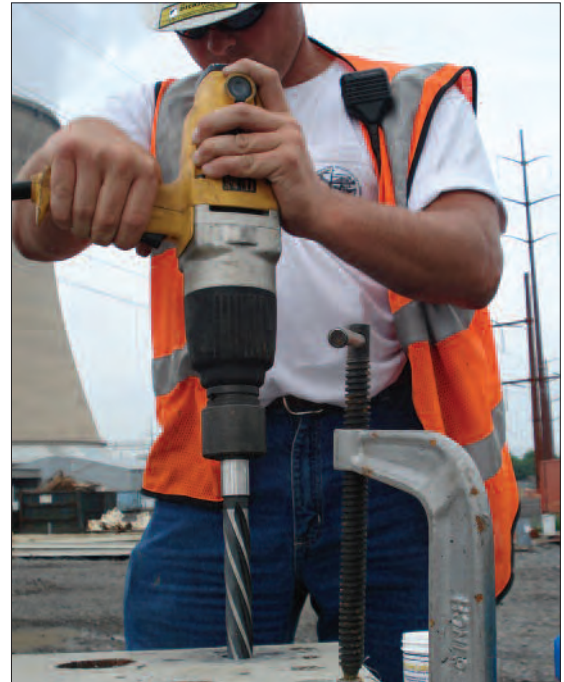


Description: Use in rotary impact sockets, high helix is faster & chips less than standard helix in impact wrench applications. Shank diameter for each reamer matches socket size for bolt which will be driven through the newly reamed hole.

Application: Aligning & enlarging holes in heavy duty structural steel applications

EDP No./ Diameter	Point Diameter	Flute Length	Overall Length	Hex Dia.
XL86-11/16	11/32	5-3/4	9-3/16	1-1/16
XL86-13/16	35/64	6-3/8	9-3/4	1-1/4
XL86-15/16	11/16	7	10-13/16	1-7/16
XL86-1-1/16	13/16	7	10-15/16	1-5/8
XL86-1-3/16	57/64	7	10-31/32	1-13/16
XL86-1-5/16	1-1/16	7	11-5/16	2
XL86-1-3/8	1-1/16	7-3/8	10	2
XL86-1-7/16	1-1/8	7-3/8	10	2
XL86-1-1/2	1-1-3/16	7-3/8	10	2
XL86-1-9/16	1-1/4	7-3/8	10	2
XL86-1-5/8	1-5/16	7-1/2	13	2

- Designed for aligning and enlarging holes in heavy duty structural steel bridge and ship building
- Hex shank is engineered to enable use in impact sockets for pneumatic and electric power tools
- Heavy duty reaming of irregular and misaligned holes
- Operator can use same power tool for reaming and driving the structural bolts



Hex Shank Car Reamers

List No. HX80

Straight Flute / Right Hand Cut / HSS



Description: Short length for use in tight areas.

Application: For use in electric and pneumatic tools & sockets.

List No. HX82

Left Hand Spiral Flute / Right Hand Cut / HSS



Description: Spiral flute for ejecting chips forward and away from the operator. Short length for use in tight areas.

Application: For use in electric and pneumatic tools & sockets.

EDP No. / Diameter	Point Diameter	Flute Length	Overall Length	Hex Dia.	EDP No. / Diameter	Point Diameter	Flute Length	Overall Length	Hex Dia.
HX80-11/16	11/32	5-3/16	7	1-1/16	HX82-11/16	11/32	5-3/16	7	1-1/16
HX80-13/16	35/64	5-3/16	7	1-1/4	HX82-13/16	35/64	5-3/16	7	1-1/4
HX80-15/16	11/16	5-3/16	7	1-7/16	HX82-15/16	11/16	5-3/16	7	1-7/16
HX80-1-1/16	13/16	5-3/16	7	1-5/8	HX82-1-1/16	13/16	5-3/16	7	1-5/8
HX80-1-3/16	57/64	5-3/16	7	1-13/16					

Hex shank sizes are the same size as the required nut size

CHAMPION

Bridge Reamers

List No. 980

Taper Shank / Straight Flute / Right Hand Cut / HSS



Description: Engineered for heavy duty use in the reaming of off size, misshapen or misaligned holes in structural steel. Easy to hand regrind and when bound in the hole are easy to dislodge. Can be used in RB65E magnetic drill presses.

Application: Bridge building, steel erection and ship building industries.

EDP No./ Diameter	Point Diameter	Overall Length	Flute Length	Shank No.
980-7/16	1/4	8-1/4	4-3/8	2
980-1/2	9/32	9	5-1/8	2
980-9/16	11/32	9	5-1/8	2
980-5/8	3/8	10	6-1/8	2
980-11/16	25/64	11-3/4	7-1/8	3
980-3/4	7/16	12	7-3/8	3
980-13/16	1/2	12	7-3/8	3
980-7/8	9/16	12	7-3/8	3

EDP No./ Diameter	Point Diameter	Overall Length	Flute Length	Shank No.
980-15/16	5/8	12	7-3/8	3
980-1	11/16	12	7-3/8	3
980-1-1/16	3/4	12	7-3/8	3
980-1-1/8	13/16	12	7-3/8	3
980-1-3/16	7/8	12	7-3/8	3
980-1-1/4	15/16	13	7-3/8	4
980-1-5/16	1	13	7-3/8	4

CHAMPION

Bridge Reamers

List No. 982

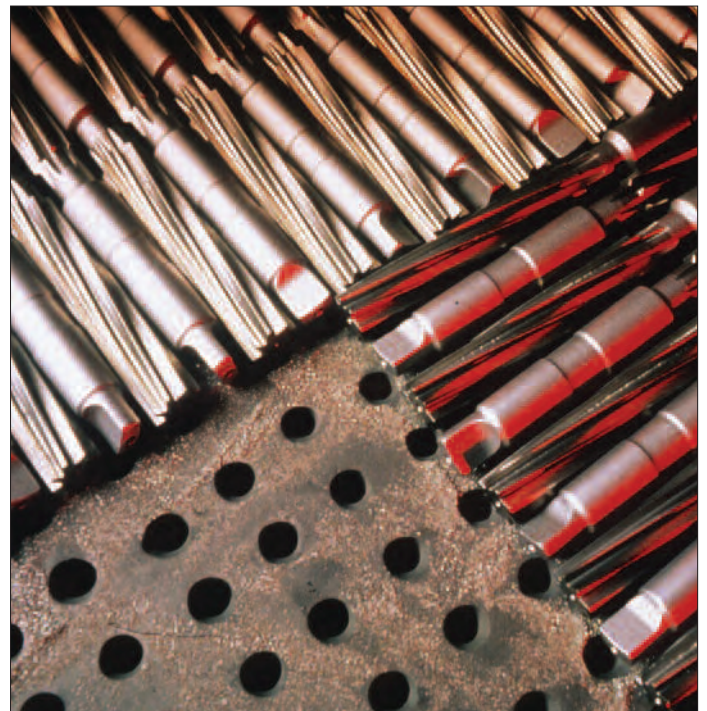
Taper Shank / Left Hand Spiral Flute / Right Hand Cut / HSS



Description: Cut with a shearing action, sending chips forward and generally give superior hole quality and bind less than the straight flute design. Can be used in RB65 and RB65E magnetic drill presses.

Application: Bridge building, erection and ship building industries. Not for use with regular hand drills - used with power tools with Morse taper spindles.

EDP No. / Diameter	Point Diameter	Overall Length	Flute Length	Shank No.
982-7/16	1/4	8-1/4	4-3/8	2
982-1/2	9/32	9	5-1/8	2
982-9/16	11/32	9	5-1/8	2
982-5/8	3/8	10	6-1/8	2
982-11/16	25/64	11-3/4	7-1/8	3
982-3/4	7/16	12	7-3/8	3
982-13/16	1/2	12	7-3/8	3
982-7/8	9/16	12	7-3/8	3
982-15/16	5/8	12	7-3/8	3
982-1	13/16	12	7-3/8	3
982-1-1/16	3/4	12	7-3/8	3
982-1-1/8	13/16	12	7-3/8	3
982-1-3/16	7/8	12	7-3/8	3
982-1-1/4	15/16	13	7-3/8	4
982-1-5/16	1	13	7-3/8	4
982-1-3/8	1-1/16	13	7-3/8	4
982-1-7/16	1-1/8	13	7-3/8	4
982-1-1/2	1-3/16	13	7-3/8	4
982-1-9/16	1-1/4	13	7-3/8	4
982-1-5/8	1-5/16	14-3/8	7-1/2	4





Maintenance Reamers

List No. SA80

1/2" Straight Shank* / Left Hand Helix / Right Hand Cut / Collar Stop / HSS



Description: Enlarge and align existing holes. Effortlessly fits into small holes.

Application: Used in steel erection, automotive, truck & trailer manufacturing and repair. Quickly aligns structural steel. Cuts stainless steel & tough alloys. Deburs welded & punched holes. Ideal for maintenance & repair. Reduce cutting speeds and feeds when cutting aluminum.

EDP No./ Diameter	Decimal Equivalent	No. of Flutes	Point Diameter	Flute Length	Overall Length
SA80-5/16*	.3125	4	.176	3	4-3/4
SA80-3/8*	.3750	4	.188	3	5
SA80-7/16*	.4375	4	.218	3-1/4	5-1/4
SA80-1/2	.5000	5	.230	3-15/16	5-15/16
SA80-9/16	.5625	5	.2925	3-15/16	5-15/16
SA80-5/8	.6250	5	.259	4-1/2	6-9/16
SA80-.652	.6520	5	.293	4-3/4	6-9/16
SA80-11/16	.6875	5	.3125	4-1/2	6-9/16
SA80-3/4	.7500	5	.453	4-15/16	7
SA80-.776	.7760	5	.461	5-3/16	7
SA80-13/16	.8125	5	.5155	4-15/16	7
SA80-7/8	.8750	5	.580	5-3/16	7-1/4
SA80-15/16	.9375	5	.6425	5-3/16	7-1/4
SA80-1	1.0000	5	.708	5-3/16	7-1/4
SA80-1-1/16	1.0625	5	.753	5-7/16	7-1/4
SA80-1-1/8**	1.1250	5	.810	5-7/16	7-1/4
SA80-1-1/4**	1.2500	5	.930	5-11/16	7-1/2
SA80-1-3/8**	1.3750	5	.930	5-11/16	7-1/2
SA80-1-1/2**	1.5000	5	1.185	5-11/16	7-1/2

*Shank diameter same as reamer diameter.

**3/4" flatted shank

Sizes .652 and .776 are specifically for shoulder bolts used on truck frames.



Chucking Reamers

List No. 970

Fractional / Straight Shank / Straight Flute / HSS



Description: For close tolerance machine reaming of a wide range of materials.

Application: Used in turret lathes and drill presses as well as other standing machinery.

EDP No. / Diameter	Decimal Equiv	Flute Length	Overall Length	EDP No. / Diameter	Decimal Equiv	Flute Length	Overall Length
970-3/64	.0469	1/2	2-1/2	970-3/16	.1875	1-1/8	4-1/2
970-1/16	.0625	1/2	2-1/2	970-13/64	.2031	1-1/4	5
970-5/64	.0781	3/4	3	970-7/32	.2188	1-1/4	5
970-3/32	.0938	3/4	3	970-15/64	.2344	1-1/2	6
970-7/64	.1094	7/8	3-1/2	970-1/4	.2500	1-1/2	6
970-1/8	.1250	7/8	3-1/2	970-17/64	.2656	1-1/2	6
970-9/64	.1406	1	4	970-9/32	.2812	1-1/2	6
970-5/32	.1562	1	4	970-19/64	.2969	1-1/2	6
970-11/64	.1719	1-1/8	4-1/2	970-5/16	.3125	1-1/2	6



EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
970-21/64	.3281	1-1/2	6
970-11/32	.3438	1-1/2	6
970-23/64	.3594	1-3/4	7
970-3/8	.3750	1-3/4	7
970-25/64	.3906	1-3/4	7
970-13/32	.4062	1-3/4	7
970-27/64	.4219	1-3/4	7
970-7/16	.4375	1-3/4	7
970-29/64	.4531	1-3/4	7
970-15/32	.4688	1-3/4	7
970-31/64	.4844	2	8
970-1/2	.5000	2	8
970-17/32	.5313	2	8
970-9/16	.5625	2	8
970-19/32	.5938	2	8
970-5/8	.6250	2-1/4	9
970-21/32	.6562	2-1/4	9

EDP No./ Diameter	Decimal Equivalent	Flute Length	Overall Length
970-11/16	.6875	2-1/4	9
970-23/32	.7188	2-1/4	9
970-3/4	.7500	2-1/2	9-1/2
970-25/32	.7812	2-1/2	9-1/2
970-13/16	.8125	2-1/2	9-1/2
970-27/32	.8438	2-1/2	9-1/2
970-7/8	.8750	2-5/8	10
970-29/32	.9062	2-5/8	10
970-15/16	.9375	2-5/8	10
970-31/32	.9688	2-5/8	10
970-1	1.0000	2-3/4	10-1/2
970-1-1/16	1.0625	2-3/4	10-1/2
970-1-1/8	1.1250	2-7/8	11
970-1-3/16	1.1875	2-7/8	11
970-1-1/4	1.2500	3	11-1/2
970-1-3/8	1.3750	3-1/4	12
970-1-1/2	1.5000	3-1/2	12-1/2

Chucking Reamers

List No. 970L

Letter Size / Straight Shank / Straight Flute / HSS



Description: For close tolerance machine reaming of a wide range of materials.

Application: Used in turret lathes and drill presses as well as other standing machinery.

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
970L-A	.2340	6	.2265	1-1/2	6
970L-B	.2380	6	.2329	1-1/2	6
970L-C	.2420	6	.2329	1-1/2	6
970L-D	.2460	6	.2329	1-1/2	6
970L-E	.2500	6	.2405	1-1/2	6
970L-F	.2570	6	.2485	1-1/2	6
970L-G	.2610	6	.2485	1-1/2	6
970L-H	.2660	6	.2485	1-1/2	6
970L-I	.2720	6	.2485	1-1/2	6
970L-J	.2770	6	.2485	1-1/2	6
970L-K	.2810	6	.2485	1-1/2	6
970L-L	.2900	6	.2792	1-1/2	6
970L-M	.2950	6	.2792	1-1/2	6

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
970L-N	.3020	6	.2792	1-1/2	6
970L-O	.3160	6	.2792	1-1/2	6
970L-P	.3230	6	.2792	1-1/2	6
970L-Q	.3320	6	.2792	1-1/2	6
970L-R	.3390	6	.2792	1-1/2	6
970L-S	.3480	6	.3105	1-3/4	6
970L-T	.3580	6	.3105	1-3/4	7
970L-U	.3680	6	.3105	1-3/4	7
970L-V	.3770	6	.3105	1-3/4	7
970L-W	.3860	6	.3105	1-3/4	7
970L-X	.3970	6	.3105	1-3/4	7
970L-Y	.4040	6	.3105	1-3/4	7
970L-Z	.4130	6	.3730	1-3/4	7

Chucking Reamers

List No. 970W

Wire Gauge / Straight Shank / Straight Flute / HSS

Description: For close tolerance machine reaming of a wide range of materials.

Application: Used in turret lathes and drill presses.



EDP No./ Size	Decimal Equivalent	No. of Flutes	Shank Diameter	Flute Length	Overall Length
970W-1	.2280	6	.2173	1-1/2	6
970W-2	.2210	6	.2173	1-1/2	6
970W-3	.2130	6	.2075	1-1/4	5
970W-4	.2090	6	.2016	1-1/4	5
970W-5	.2055	6	.2016	1-1/4	5
970W-6	.2040	6	.1945	1-1/4	5
970W-7	.2010	6	.1945	1-1/4	5
970W-8	.1990	6	.1895	1-1/4	5
970W-9	.1960	6	.1895	1-1/4	5
970W-10	.1935	6	.1860	1-1/4	5
970W-11	.1910	6	.1860	1-1/4	5
970W-12	.1890	6	.1805	1-1/8	4-1/2
970W-13	.1850	6	.1805	1-1/8	4-1/2
970W-14	.1820	6	.1755	1-1/8	4-1/2
970W-15	.1800	6	.1755	1-1/8	4-1/2
970W-16	.1770	6	.1704	1-1/8	4-1/2
970W-17	.1730	6	.1645	1-1/8	4-1/2
970W-18	.1695	6	.1595	1-1/8	4-1/2
970W-19	.1660	6	.1595	1-1/8	4-1/2
970W-20	.1610	6	.1530	1-1/8	4-1/2
970W-21	.1590	6	.1530	1-1/8	4-1/2
970W-22	.1570	6	.1510	1	4
970W-23	.1540	4	.1460	1	4
970W-24	.1520	4	.1460	1	4
970W-25	.1495	4	.1430	1	4
970W-26	.1470	4	.1430	1	4
970W-27	.1440	4	.1350	1	4
970W-28	.1405	4	.1350	1	4
970W-29	.1360	4	.1275	1	4
970W-30	.1285	4	.1190	7/8	3-1/2
970W-31	.1200	4	.1110	7/8	3-1/2
970W-32	.1160	4	.1110	7/8	3-1/2
970W-33	.1130	4	.1045	7/8	3-1/2
970W-34	.1110	4	.1045	7/8	3-1/2
970W-35	.1100	4	.1020	7/8	3-1/2
970W-36	.1065	4	.1020	7/8	3-1/2
970W-37	.1040	4	.0940	7/8	3-1/2
970W-38	.1015	4	.0940	7/8	3-1/2
970W-39	.0995	4	.0918	7/8	3-1/2
970W-40	.0980	4	.0918	7/8	3-1/2
970W-41	.0960	4	.0918	7/8	3-1/2
970W-42	.0935	4	.0870	3/4	3
970W-43	.0890	4	.0800	3/4	3
970W-44	.0860	4	.0800	3/4	3
970W-45	.0820	4	.0761	3/4	3
970W-46	.0810	4	.0761	3/4	3
970W-47	.0785	4	.0710	3/4	3

EDP No./ Size	Decimal Equivalent	No. of Flutes	Shank Diameter	Flute Length	Overall Length
970W-48	.0760	4	.0710	3/4	3
970W-49	.0730	4	.0650	3/4	3
970W-50	.0700	4	.0650	3/4	3
970W-51	.0670	4	.0650	3/4	3
970W-52	.0635	4	.0575	1/2	2-1/2
970W-53	.0595	4	.0575	1/2	2-1/2
970W-54	.0550	4	.0500	1/2	2-1/2
970W-55	.0520	4	.0500	1/2	2-1/2
970W-56	.0465	4	.0445	1/2	2-1/2
970W-57	.0430	4	.0380	1/2	2-1/2
970W-58	.0420	4	.0380	1/2	2-1/2
970W-59	.0410	4	.0380	1/2	2-1/2
970W-60	.0400	4	.0380	1/2	2-1/2



Specify series 972 for spiral flute straight shank chucking reamers.



Specify series 962 for spiral flute taper shank chucking reamers.



Specify series 960 for straight flute taper shank chucking reamers.



CHAMPION

Chucking Reamers

List No. 970D

Decimal / Straight Shank / Straight Flute / HSS



Description: For close tolerance machine reaming of a wide range of materials.

Application: Chucking reamers are commonly used in turret lathes and drill presses as well as other standing machinery.

EDP No./ Diameter	No of Flutes	Shank Diameter	Flute Length	Overall Length
970D-.1230	4	.1190	7/8	3-1/2
970D-.1240	4	.1190	7/8	3-1/2
970D-.1247	4	.1190	7/8	3-1/2
970D-.1260	4	.1190	7/8	3-1/2
970D-.1855	4	.1805	1-1/8	4-1/2
970D-.1865	6	.1805	1-1/8	4-1/2
970D-.1870	6	.1805	1-1/8	4-1/2
970D-.1885	6	.1805	1-1/8	4-1/2
970D-.2480	6	.2405	1-1/8	4-1/2
970D-.2490	6	.2405	1-1/8	4-1/2
970D-.2495	6	.2405	1-1/2	6
970D-.2510	6	.2405	1-1/2	6
970D-.3105	6	.2792	1-1/2	6
970D-.3115	6	.2792	1-1/2	6

EDP No./ Diameter	No of Flutes	Shank Diameter	Flute Length	Overall Length
970D-.3120	6	.2792	1-1/2	6
970D-.3135	6	.2792	1-1/2	6
970D-.3730	6	.3015	1-3/4	7
970D-.3740	6	.3015	1-3/4	7
970D-.3745	6	.3015	1-3/4	7
970D-.3760	6	.3015	1-3/4	7
970D-.4355	6	.3730	1-3/4	7
970D-.4365	6	.3730	1-3/4	7
970D-.4370	6	.3730	1-3/4	7
970D-.4385	6	.3730	1-3/4	7
970D-.4980	6	.4355	2	8
970D-.4990	6	.4355	2	8
970D-.4995	6	.4355	2	8
970D-.5010	6	.4355	2	8

CHAMPION

Hand Reamers

List No. 950

Straight Flute / HSS



Description: The square shank can be held securely in a tap handle, reamer wrench, or vise. Ground with a starting chamfer to provide easy entry of the reamer into the hole.

Application: Designed for hand use for the final sizing and finishing of a predrilled hole.

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
950-1/8	.1250	4	1/8	1-1/2	3
950-5/32	.1562	6	5/32	1-5/8	3-1/4
950-3/16	.1875	6	3/16	1-3/4	3-1/2
950-7/32	.2188	6	7/32	1-7/8	3-3/4
950-1/4	.2500	6	1/4	2	4
950-9/32	.2812	6	9/32	2-1/8	4-1/4
950-5/16	.3125	6	5/16	2-1/4	4-1/2
950-11/32	.3438	6	11/32	2-3/8	4-3/4
950-3/8	.3750	6	3/8	2-1/2	5
950-13/32	.1062	6	13/32	2-5/8	5-1/4
950-7/16	.4375	6	7/16	2-3/4	5-1/2
950-15/32	.4688	6	15/32	2-7/8	5-3/4
950-1/2	.5000	6	1/2	3	6
950-17/32	.5313	6	17/32	3-1/8	6-1/4
950-9/16	.5625	6	9/16	3-1/4	6-1/2
950-19/32	.5938	6	19/32	3-3/8	6-3/4
950-5/8	.6250	6	5/8	3-1/2	7
950-21/32	.6562	8	21/32	3-11/16	7-3/8
950-11/16	.6875	8	11/16	3-7/8	7-3/4
950-23/32	.7188	8	23/32	4-1/16	8-1/8
950-3/4	.7500	8	3/4	3/16	8-3/8
950-25/32	.7812	8	25/32	4-3/8	8-3/4

EDP No. / Size	Decimal Equivalent	No. Of Flutes	Shank Diameter	Flute Length	Overall Length
950-13/16	.8125	8	13/16	4-9/16	9-1/8
950-27/32	.8438	8	27/32	4-11/16	9-3/8
950-7/8	.8750	8	7/8	4-7/8	9-3/4
950-29/32	.9062	8	29/32	5	10
950-15/16	.8375	8	15/16	5-1/8	10-1/4
950-1	1.0000	8	1	5-7/16	10-7/8
950-1-1/16	1.0625	10	1-1/16	5-3/8	11-1/4
950-1-1/8	1.1250	10	1-1/8	5-13/16	11-5/8
950-1-3/16	1.1875	10	1-3/16	6	12
950-1-1/4	1.2500	10	1-1/4	6-1/8	12-1/4
950-1-5/16	1.3125	10	1-5/16	6-1/4	12-1/2
950-1-3/8	1.3750	12	1-3/8	6-5/16	12-5/8
950-1-7/16	1.4375	10	1-7/16	6-7/16	12-7/8
950-1-1/2	1.5000	12	1-1/2	6-1/2	13

CHAMPION

Hand Reamers List No. 952 Spiral Flute / HSS



Description & Application: The left hand spiral flute design pushes chips forward out of the hole, and allows the reamer to be used in holes that have an interruption. Ground with a starting chamfer to provide easy entry of the reamer into the hole.

EDP No./ Diameter	Decimal Equivalent	No. of Flutes	Shank Diameter	Flute Length	Overall Length	EDP No./ Diameter	Decimal Equivalent	No. of Flutes	Shank Diameter	Flute Length	Overall Length
952-1/4	.2500	6	1/4	2	4	952-13/16	.8125	8	13/16	4-9/16	9-1/8
952-5/16	.3125	6	5/16	2-1/4	4-1/2	952-27/32	.8438	8	27/32	4-11/16	9-3/8
952-3/8	.3750	6	3/8	2-1/2	5	952-7/8	.8750	8	7/8	4-7/8	9-3/4
952-7/16	.4375	6	7/16	2-3/4	5-1/2	952-29/32	.9062	8	29/32	5	10
952-1/2	.5000	6	1/2	3	6	952-15/16	.8375	8	15/16	5-1/8	10-1/4
952-17/32	.5312	6	17/32	3-1/8	6-1/4	952-1	1.0000	8	1	5-7/16	10-7/8
952-9/16	.5625	6	9/16	3-1/4	6-1/2	952-1/16	1.0625	10	1-1/16	5-3/8	11-1/4
952-19/32	.5938	6	19/32	3-3/8	6-3/4	952-1-1/8	1.1250	10	1-1/8	5-13/16	11-5/8
952-5/8	.6250	6	5/8	3-1/2	7	952-1-3/16	1.1875	10	1-3/16	6	12
952-21/32	.6562	8	21/32	3-11/16	7-3/8	952-1-1/4	1.2500	10	1-1/4	6-1/8	12-1/4
952-11/16	.6875	8	11/16	3-7/8	7-3/4	952-1-5/16	1.3125	10	1-5/16	6-1/4	12-1/2
952-23/32	.7188	8	23/32	4-1/16	8-1/8	952-1-3/8	1.3750	12	1-3/8	6-5/16	12-5/8
952-3/4	.7500	8	3/4	4-3/16	8-3/8	952-1-7/16	1.4375	10	1-7/16	6-7/16	12-7/8
952-25/32	.7812	8	25/32	4-3/8	8-3/4	952-1-1/2	1.5000	12	1-1/2	6-1/2	13

CHAMPION

Adjustable Hand Reamers List No. 900 High Speed Steel Blades



Description: The most economical tool for precisely reaming a small number of odd-sized holes. Adjustable to precisely fit a range of sizes, eliminating the need for single purpose, special diameter reamers. Worn blades can be easily replaced by the user. For hand use only.

Application: Used widely for automotive and aircraft maintenance and railway repair.

EDP No./ Diameter	Size Range Inches	Size Range mm	Overall Length
900-8/A	1/4 - 9/32	6.30 - 7.15	3-1/4
900-7/A	9/32 - 5/16	7.15 - 8.00	3-1/2
900-6/A	5/16 - 11/32	8.00 - 8.75	4-1/8
900-5/A	11/32 - 3/8	8.75 - 9.50	4-3/8
900-4/A	3/8 - 13/32	9.50 - 10.25	4-3/4
900-3/A	13/32 - 7/16	10.25 - 11.00	5
900-2/A	7/16 - 15/32	11.00 - 12.00	5-1/4
900-A	15/32 - 17/32	12.00 - 13.50	5-1/2
900-B	17/32 - 19/32	13.50 - 15.00	5-3/4
900-C	19/32 - 21/32	15.00 - 16.75	6-1/2
900-D	21/32 - 23/32	16.75 - 18.25	6-3/4
900-E	23/32 - 25/32	18.25 - 19.75	7
900-F	25/32 - 27/32	19.75 - 21.50	7-3/8
900-G	27/32 - 15/16	21.50 - 23.75	8
900-H	15/16 - 1-1/16	23.75 - 27.00	9
900-I	1-1/16 - 13/16	27.00 - 30.25	10
900-J	1-3/16 - 1-11/32	30.25 - 34.25	11
900-K	1-11/32 - 1-1/2	34.25 - 38.00	12
900-L	1-1/2 - 1-13/16	38.00 - 46.00	14
900-M	1-13/16 - 2-7/32	46.00 - 56.00	16
900-N	2-7/32 - 2-3/4	56.00 - 70.00	18
900-O	2-3/4 - 3-11/32	70.00 - 85.00	20

Replacement blades (900RB) are available.



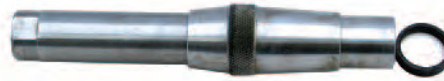
CHAMPION

Extension Pilots for Adjustable Reamers

List No. 900P

Description: Screw on extension pilots with tapered guide sleeves are used with adjustable reamers.

Application: for the in-line reaming of two holes such as king pins and piston bushings.



EDP No./ Size	Pilot Length	EDP No./ Size	Pilot Length
900P-A	5	900P-I	5-3/4
900P-B	5	900P-J	5-3/4
900P-C	5-1/4	900P-K	5-3/4
900P-D	5-3/4	900P-L	5-3/4
900P-E	5-3/4	900P-M	9
900P-F	5-3/4	900P-N	9
900P-G	5-3/4	900P-O	9
900P-H	5-3/4		

CHAMPION

Taper Pin Reamers

List No. 776

Straight Flute / Square Drive / HSS

Description: Taper pin hand reamers have a square shank for use by hand in tap and reamer wrenches. These reamers have a taper of 1/4" per foot.

Application: Often used as "mini" bridge reamers or for deburring the back of holes. The straight flute draws the chips back toward the power source. Used to ream holes by hand into which standard taper pins will fit.



List No. 778

Slow Spiral / Square Drive / HSS



List No. 777

Fast Spiral / Round Shank / HSS

Description: These reamers have a taper of 1/4" per foot, and are used to ream holes by machine into which standard taper pins will fit.

Application: Same as other taper pin reamers but at higher production rates.



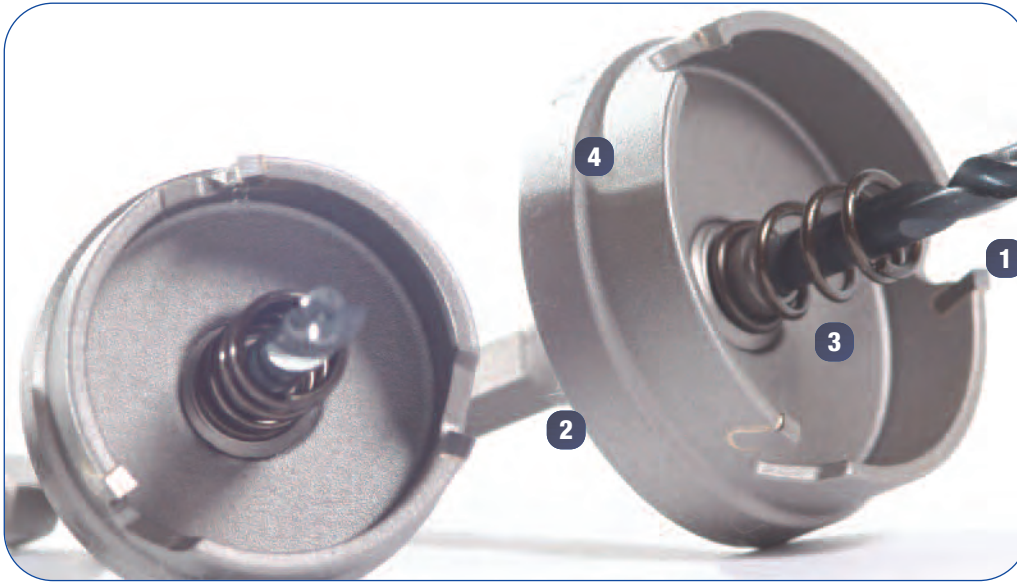
No. 776 Straight Flute	No. 777 Fast Spiral	No. 778 Slow Spiral	Nominal Diameter		Flute Length	Overall Length
			Small End	Large End		
776-7/0	777-7/0	778-7/0	.0497	.0666	13/16	1-13/16
776-6/0	777-6/0	778-6/0	.0611	.0806	15/16	1-15/16
776-5/0	777-5/0	778-5/0	.0719	.0966	1-3/16	2-3/16
776-4/0	777-4/0	778-4/0	.0869	.1142	1-5/16	2-5/16
776-3/0	777-3/0	778-3/0	.1029	.1302	1-5/16	2-5/16
776-2/0	777-2/0	778-2/0	.1137	.1462	1-9/16	2-9/16
776-0	777-0	778-0	.1287	.1638	1-11/16	2-15/16
776-1	777-1	778-1	.1447	.1798	1-11/16	2-15/16
776-2	777-2	778-2	.1605	.2008	1-15/16	3-3/16
776-3	777-3	778-3	.1813	.2294	2-5/16	3-11/16
776-4	777-4	778-4	.2071	.2604	2-9/16	4-1/16
776-5	777-5	778-5	.2409	.2994	2-13/16	4-5/16
776-6	777-6	778-6	.2773	.3540	3-11/16	5-7/16
776-7	777-7	778-7	.3297	.4220	4-7/16	6-5/16
776-8	777-8	778-8	.3971	.5050	5-3/16	7-3/16
776-9	777-9	778-9	.4805	.6066	6-1/16	8-5/16
776-10	777-10	778-10	.5799	.7216	6-13/16	9-5/16

CHAMPION

Carbide Tipped Hole Cutters List No. CT3

Description: Three carbide tips, pilot drill and ejector spring. Features a 1/4" hex shank.

Application: Sheet metal up to 1/8" thick. Electrical, HVAC, and sheet metal trades.



1 Special tungsten carbide teeth

- Excellent wear and heat resistance
- Cuts stainless steel and tough alloys

2 One piece construction

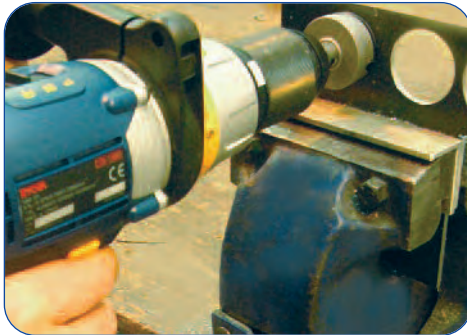
- No Assembly Required
- Stable accurate drilling

3 Ejector spring (Standard)

- Ejects the slug, thus saving time

4 Safety collar stop

- Prevents over penetration for safer, faster operation.



Applications

- Junction / Switch Boxes
- Metal Studs
- Electrical Appliances
- Lighting Fixtures
- Auto Body Repair
- Truck / Trailer Frames
- Ductile Pipe

The CT3 CARBIDE TIPPED HOLE CUTTER is the ideal solution for drilling holes in sheet metal when using cordless drills

- Perfect for use in battery powered drills because they cut quickly and use very little power
- Engineered for cutting thin materials up to 1/8" with fast, clean cuts everytime
- Cut stainless steel, sheet metal and tubing
- 1/4" Hex Shank for use in QCD (quick-change driver)
- See page 147 of the sets section for the full range of CT3 plastic cased sets

Up to 150 holes with each cutter in Stainless Steel

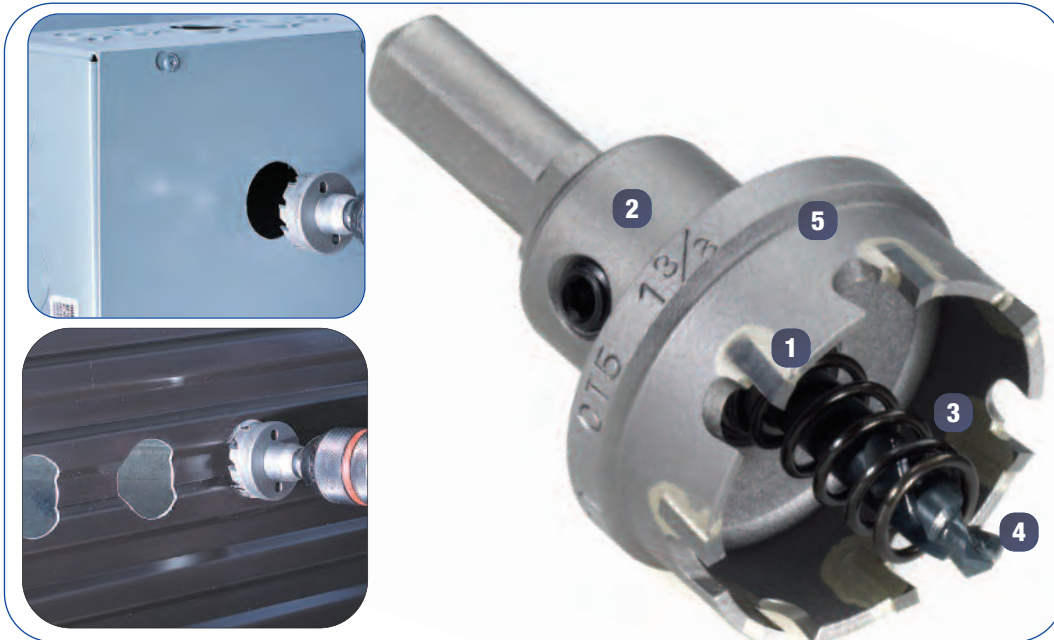
EDP No. / Size	EDP No. / Size	EDP No. / Size	Description
CT3-5/8	CT3-1-1/16	CT3-PILOT	Pilot Drill (1-9/16" OAL)
CT3-11/16	CT3-1-1/8	CT3-SCREW	Screw for CT3 Hole Cutter
CT3-3/4	CT3-1-3/16	CT3-SPRING	Spring for CT3 Hole Cutter
CT3-13/16	CT3-1-1/4		
CT3-7/8	CT3-1-5/16		
CT3-15/16	CT3-1-3/8		
CT3-1			
EDP No. / Size	Contents		
ELEC-KIT	MSD-HEX-13, CT3-7/8, CT3-1-1/8, CT3-1-3/8 and QCD		

CHAMPION

Carbide Tipped Hole Cutters List No. CT5

Description: Carbide tipped hole cutter cuts up to 3/16" thick.

Application: For cutting steel plate, iron, aluminum, copper, cast iron, stainless steel, FRP and plastics up to 3/16" thick. Ideal for electrical, mechanical and HVAC contractors.



1 Special tungsten carbide teeth with NEW carbide tip pocket

- Excellent wear and heat resistance
- Cuts stainless steel and tough alloys
- Tip pocket for quicker chip extraction

2 One piece construction

- No Assembly Required
- Stable accurate drilling

3 Strong, heat resistant ejector spring

- Ejects the slug saving time

4 NEW Stepped pilot drill

- Reduces tip impact

5 Safety collar stop

- Prevents over penetration for safer, faster operation.

Applications

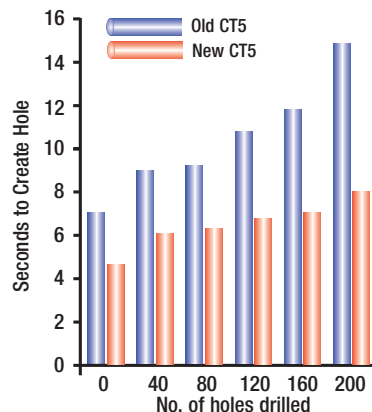
- Junction / Switch Boxes
- Metal Studs
- Appliances
- Auto Body Repair
- Truck Body Repair

- **NEW DESIGN FOR LONGER LIFE AND FASTER CUTTING**
- Perfect portable tool for the professional electrician, plumber, mechanic and contractor
- Extremely productive tool that is a cost effective alternative to bi-metal holesaws
- For cutting steel plate, iron, aluminum, copper, cast iron, stainless steel, FRP (i.e fiberglass) and plastics
- 9/16" to 2-5/8" have 3/8" shank, 2-3/4" to 5" have 1/2" shank
- See page 147 of the sets section for the full range of CT5 plastic cased sets

EDP No. / Size	EDP No. / Size	EDP No. / Size	EDP No. / Size
CT5-9/16	CT5-1-3/8	CT5-2-1/4	CT5-3-1/4
CT5-5/8	CT5-1-7/16	CT5-2-5/16	CT5-3-3/8
CT5-11/16	CT5-1-1/2	CT5-2-3/8	CT5-3-1/2
CT5-3/4	CT5-1-9/16	CT5-2-7/16	CT5-3-5/8
CT5-13/16	CT5-1-5/8	CT5-2-1/2	CT5-3-3/4
CT5-7/8	CT5-1-11/16	CT5-2-9/16	CT5-3-7/8
CT5-15/16	CT5-1-3/4	CT5-2-5/8	CT5-4
CT5-1	CT5-1-13/16	CT5-2-11/16	CT5-4-1/8
CT5-1-1/16	CT5-1-7/8	CT5-2-3/4	CT5-4-1/4
CT5-1-1/8	CT5-1-15/16	CT5-2-13/16	CT5-4-3/8
CT5-1-3/16	CT5-2	CT5-2-7/8	CT5-4-1/2
CT5-1-7/32	CT5-2-1/16	CT5-2-15/16	CT5-4-3/4
CT5-1-1/4	CT5-2-1/8	CT5-3	CT5-5
CT5-1-5/16	CT5-2-3/16	CT5-3-1/8	

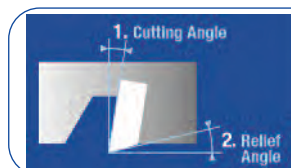
PERFORMANCE COMPARISON
NEW CT5 to PREVIOUS CT5 (2")
Material: SUS304 Stainless Steel
Material thickness: 1/8" - Speed: 800 rpm

60%
Faster Cutting
(up to 100 holes)
20%
More Holes



* Sizes 9/16 thru 2-9/16 have 3/8" (10mm) shanks * Sizes 2-5/8 thru 5 have 1/2" (13mm) shanks

EDP No. / Size	Description
CT5-PILOT	Pilot Drill (1-7/8" OAL)
CT5CO-PILOT	Cobalt Pilot Drill for stainless steel
CT5-SCREW	Screw for CT5 Hole Cutter
CT5-SPRING	Spring for CT5 Hole Cutter
CT5-PILOT-TCT	Carbide Tipped Pilot Drill for abrasive materials



Smooth Cutting Geometry

Champion hole cutters are made with ultra-hard tungsten carbide teeth for cutting stainless and tough alloys. Relief angle permits discharge of metal chips for smooth cutting.

See Page 147 of the Sets section for the full range of CT5 plastic cased sets

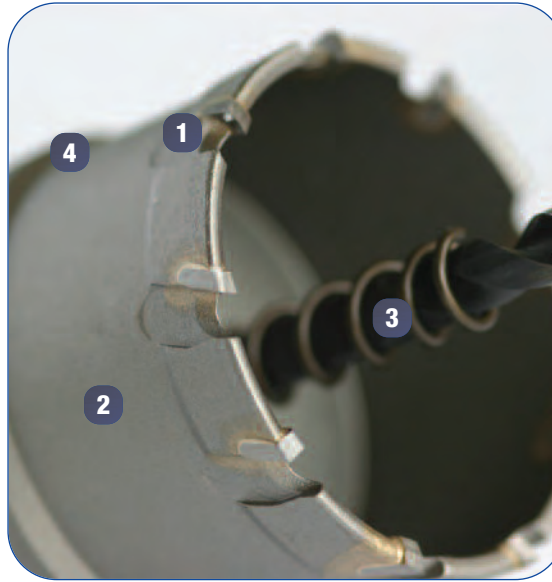


CHAMPION

Carbide Tipped Hole Cutters List No. CT7

Description: The perfect, portable tool for the professional electrician plumber, mechanic and general contractor.

Application: An extremely productive tool that is a cost effective alternative to bi-metal holesaws for drilling holes in steel and other materials up to 1" thick.



1 Special tungsten carbide teeth

- Excellent wear and heat resistance
- Cuts stainless steel and tough alloys

2 One piece construction

- No Assembly Required
- Stable accurate drilling

3 Ejector spring (Standard)

- Ejects the slug saving time

4 Safety collar stop

- Prevents over penetration for safer, faster operation.

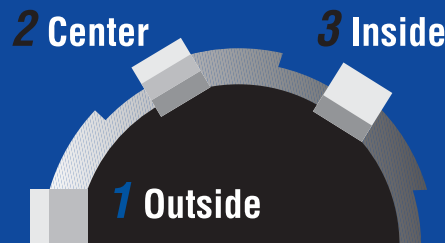
- Perfect portable tool for the professional electrician, plumber, mechanic and contractor
- Productive tool that is a cost effective alternative to bi-metal holesaws
- For cutting steel plate, iron, aluminum, copper, cast iron, stainless steel, FRP (i.e fiberglass) and plastics up to 1" thick
- 9/16" to 3" have 3/8" shank, 3-1/4" to 4-1/2" have 1/2" shank
- See page 147 of the sets section for the full range of CT7 plastic cased sets

Applications

- Junction / Switch Boxes
- Metal Studs
- Appliances
- Auto Body Repair
- Truck / Trailer Frames
- Ductile Pipe

EDP No. / Size	EDP No. / Size	EDP No. / Size	Description
CT7-9/16	CT7-1-13/16	CT7-PILOT	Pilot Drill (2-7/8" OAL)
CT7-5/8	CT7-1-7/8	CT7CO-PILOT	Cobalt Pilot Drill for stainless steel
CT7-11/16	CT7-1-15/16	CT7-SCREW	Screw for CT7 Hole Cutter
CT7-3/4	CT7-2	CT7-SPRING	Spring for CT7 Hole Cutter
CT7-13/16	CT7-2-1/8	CT7-PILOT-TCT	Carbide Tipped Pilot Drill for abrasive materials
CT7-7/8	CT7-2-1/4		
CT7-15/16	CT7-2-3/8		
CT7-1	CT7-2-1/2		
CT7-1-1/16	CT7-2-9/16		
CT7-1-1/8	CT7-2-5/8		
CT7-1-3/16	CT7-2-3/4		
CT7-1-1/4	CT7-2-7/8		
CT7-1-5/16	CT7-3		
CT7-1-3/8	CT7-3-1/4		
CT7-1-7/16	CT7-3-1/2		
CT7-1-1/2	CT7-3-5/8		
CT7-1-9/16	CT7-4		
CT7-1-5/8	CT7-4-1/8		
CT7-1-11/16	CT7-4-1/4		
CT7-1-3/4	CT7-4-1/2		

Triple Edge Cutting System



Champion CT7 hole cutters feature two sets of three cutting blades, each with different geometries. This unique system balances the cutting forces enabling rapid, smooth drilling with better control.

CHAMPION

Carbide Tipped Hole Cutters

List No. CT9

Description: 2" Depth of cut hole cutter. Features carbide tips, and heavy duty one piece design.

Application: Recommended for drilling steel door lockset holes where extra cutting depth is required.



1 Special tungsten carbide teeth

- Excellent wear and heat resistance
- Cuts stainless steel and tough alloys

2 One piece construction

- No Assembly Required
- Stable accurate drilling

3 Extra length tool body

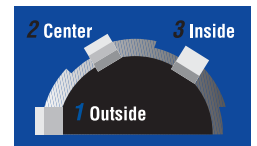
- For extra length of cutting

THE CHOICE FOR DRILLING LOCKSET AND DEADBOLT HOLES IN STEEL DOORS

- 2" depth for drilling thick materials
- 3/8" shanks
- 2-1/8" designed for door knob, 1-1/2" designed for dead bolt
- See page 147 of the sets section for the full range of CT9 plastic cased sets

EDP No. / Size	Shank Diameter	EDP No. / Size	Description
CT9-1-1/2	3/8	CT9-PILOT	Pilot Drill (4" OAL)
CT9-2-1/8	3/8	CT9-SCREW	Screw for CT9 Hole Cutter

Triple Edge Cutting System



CT9 hole cutters feature triple-cutting geometry for smooth, fast cutting. The unique geometry delivers rapid chip removal and better control.

CHAMPION

Carbide Tipped Hole Cutter Accessories

CT-EXT Hole Cutter Extensions

List No. CT-EXT

- Extend CT5 and CT7 hole cutters by 4"
- Precision machined tool steel
- Will extend the reach of all 3/8" and 1/2" shank tools



EDP No. / Size	Description
CT-EXT-3/8	5" x 3/8" shank extension for 3/8" shank CT5/CT7 cutters
CT-EXT-1/2	5" x 1/2" shank extension for 1/2" shank CT5/CT7 cutters

QCD Quick-Change Driver

List No. QCD

- Dual 1/4" and 3/8" drill and drive chuck
- 3/8" tools lock into position 1 / 1/4" tools lock into position 2
- Industrial quality with minimal runout (wobble)
- Fits all accessory types, all brands
- Fits old and new hex shanks with or without power groove



EDP No. / Size	Description
QCD	Quick Change Driver for 1/4" and 3/8" hex shank tools

QCD-EXT Quick-Change Driver Extensions

List No. QCD-EXT

- Industrial quality quick change extensions for 1/4" shank tools
- Designed for one-handed quick release
- Carbon steel manufacture for extended tool life
- Fits old and new 1/4" hex shanks with or without power groove



EDP No. / Size	Description
QCD-EXT-6*	6" Extension drive for 1/4" hex shank tools
QCD-EXT-12*	12" Extension drive for 1/4" hex shank tools
QCD-EXT-24*	24" Extension drive for 1/4" hex shank tools

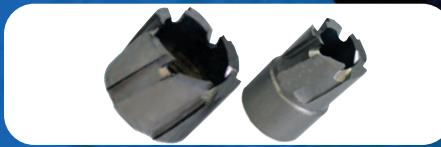
* Will only accommodate 1/4" hex shanks

CHAMPION
CUTTING TOOL CORP.



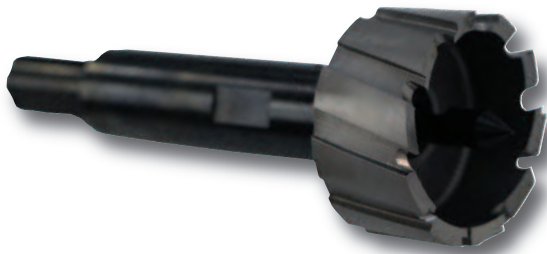
Sheet Metal Cutters

List No. SMC
High Speed Steel / Surface Treated



Description: Produces fast, bur-free holes. Used mostly in hand held portable drills but can be used in a drill press.

Application: Sheet metal, plate materials and plastics up to 1/2" thick. Ideal for electrical/conduit, automotive frame and bodywork, PDR (paintless dent repair) and HVAC.



SMC CUTTERS

- Fast cutting sheet metal cutters.
- Bur free holes in sheet metal, plate materials and plastics up to 1/2" thick.
- Surface treated high speed steel.
- 2 depth of cut options - 1/4" and 1/2".
- Full range of pilots and arbors available.

1/4" Depth of Cut - 3/8-24 Thread - Use With Arbor SMC-ARBOR-1	1/2" Depth of Cut - 1/2-20 Thread - Use With Arbor SMC-ARBOR-2
EDP No. / Size	EDP No. / Size
SMC-1/4	SMC-13/16
SMC-5/16	SMC-7/8
SMC-3/8	SMC-15/16
SMC-7/16	SMC-1
SMC-1/2	SMC-1-1/16
SMC-9/16	SMC-1-1/8
SMC-5/8	SMC-1-3/16
SMC-3/4	SMC-1-1/4
	SMC-1-3/8
	SMC-1-1/2

Sheet Metal Cutters - X-PAC

List No. SMC-XPAC

Description: Fully Assembled SMC-Cutter, SMC-ARBOR-1, SMC-PILOT-1 and SMC-WASHER-1

EDP No. / Size
SMC-XPAC-1/4
SMC-XPAC-5/16
SMC-XPAC-3/8

ARBORS

EDP No. / Size	Description
SMC-ARBOR-1	Arbor for sizes 1/4" thru 3/4"
SMC-ARBOR-2	Arbor for sizes 13/16" thru 1-1/2"

PILOTS

EDP No. / Size	Description
SMC-PILOT-1	Pilot for sizes 1/4" thru 3/4"
SMC-PILOT-2	Pilot for sizes 13/16" thru 1-1/2"

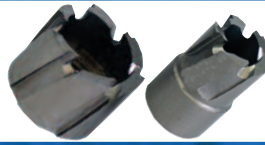
SMC Cutter Speeds

Size	STEEL	STAINLESS STEEL	ALUMINUM
1/4 to 1/2	500-900 RPM	350-800 RPM	1250-2500 RPM
9/16 to 13/16	300-500 RPM	250-350 RPM	750-1200 RPM
7/8 to 1-1/8	250-300 RPM	170-250 RPM	550-700 RPM
1-3/16 to 1-1/2	150-250 RPM	120-180 RPM	400-550 RPM



Description: Produces fast, bur-free holes. Used mostly in hand held portable drills but can be used in a drill press.

Application: Sheet metal, plate materials and plastics up to 1/2" thick. Ideal for electrical/conduit, automotive frame and bodywork, PDR (paintless dent repair) and HVAC.



EDP No. / Size	Contents
SMC-SET-1	13 Piece set contains SMC Sizes 1/4 to 3/4", Arbor, Pilot, Hex Key, Small & Large Washer and Center Punch
SMC-SET-2	12 Piece set contains SMC sizes 13/16 to 1-1/2", Arbor, Pilot, 1 Hex Washer, 1 Center Punch and 2 Hex Keys

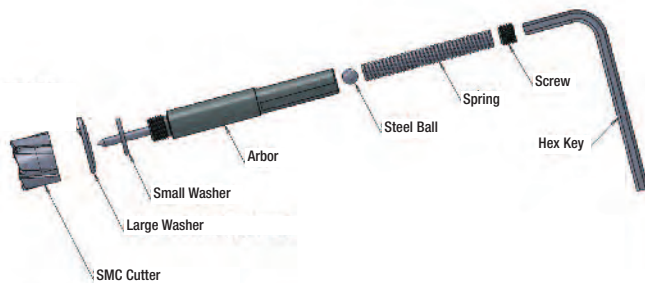


SMC-SET-1

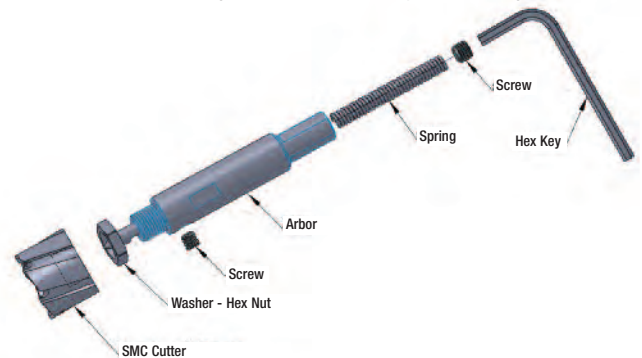


SMC-SET-2

Cutter and arbor connection diagram for cutters with 1/4 depth of cut - using SMC-ARBOR-1



Cutter and arbor connection diagram for cutters with 1/2 depth of cut - using SMC-ARBOR-2



ACCESSORIES

EDP No. / Size	Description
SMC-HEX-3.0M	Hex Key for use with SMC-ARBOR-2
SMC-HEX-4.0M	Hex Key for use with SMC-ARBOR-1 and 2
SMC-PUNCH	Punch for use with SMC-ARBOR-1 and 2
SMC-WASHER-1	Washer for use with SMC-ARBOR-1
SMC-WASHER-2	Washer for use with SMC-ARBOR-1
SMC-WASHER-HEX	Washer for use with SMC-ARBOR-2

EDP No. / Size	Description
SMC-SPRING	Spring for use with SMC-ARBOR-1 and 2
SMC-M6-SCREW	Screw for use with SMC-ARBOR-2 and SMC-HEX-3.0M
SMC-M8-SCREW	Screw for use with SMC-ARBOR-1 and 2 and SMC-HEX-4.0M
SMC-BALL	Ball for use with SMC-ARBOR-1



Carbide Burs



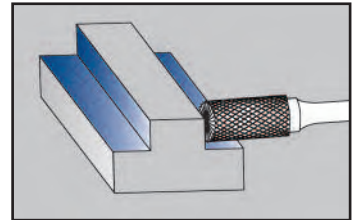
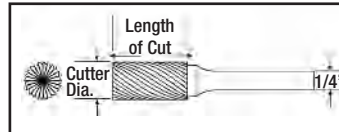
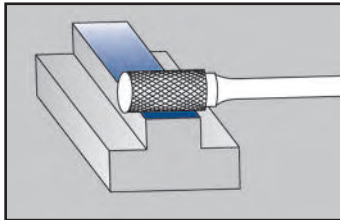
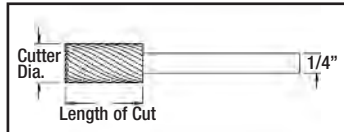
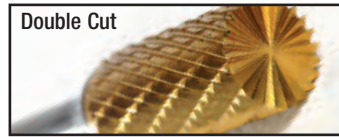
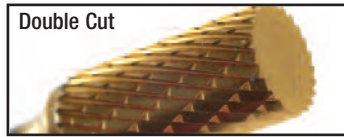
Description: Carbide burs are one of the most versatile metal working tools. Used in virtually every industry, burs are used in mold and pattern making, die sinking, tool making and maintenance.

Application: Used widely in the automotive, aerospace, foundry, power station and engineering industries.

THE QUALITY TO MEET THE MOST DEMANDING JOBS

Manufactured from C2 tungsten carbide, Champion carbide burs are precision machine ground using diamond wheels and automated machinery. Producing consistent geometry, sharp cutting edges and vibration free performance. Standard 1/4" shanks unless specified differently. Most Champion double cut Carbide Burs are Titanium Nitride Coated for superior surface finish and long life. Miniature, Non-Ferrous & Long Burs are not Titanium Nitride Coated.

SA Cylinder Shape



USE FOR DEBURRING

USE FOR INTERIOR COUNTER WORK

Cutter Details		List / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/8	1/2	SA11	-	-
1/8	5/8	SA12	-	-
5/32	5/8	SA13	-	-
3/16	5/8	SA14	-	-
1/4	5/8	SA1***	-	-
1/4	1	SA1L	-	-
1/4	3/4	-	SA1NF	-
1/4	1/2	-	-	SA1-L6*
5/16	3/4	SA2	-	-
3/8	3/4	SA3***	SA3NF	SA3-L6*
3/8	1	SA3L	-	-
3/8	1-1/2	SA3X	-	-
7/16	1	SA4	-	-
1/2	1	SA5***	SA5NF	SA5-L6*
5/8	1	SA6	SA6NF	-
3/4	1/2	SA15	-	-
3/4	3/4	SA16	-	-
3/4	1	SA7	SA7NF	-
3/4	1	-	SA7NF-3/8**	-
7/8	1	SA8	-	-
1	1	SA9	-	-

Cutter Details		List / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/8	1/2	SB11	-	-
1/8	5/8	SB12	-	-
5/32	5/8	SB13	-	-
3/16	5/8	SB14	-	-
1/4	5/8	SB1***	-	-
1/4	1	SB1L	-	-
5/16	3/4	SB2	-	-
3/8	3/4	SB3***	-	-
3/8	1	SB3L	-	-
3/8	1-1/2	SB3X	-	-
7/16	1	SB4	-	-
1/2	1	SB5***	-	-
5/8	1	SB6***	-	-
3/4	1/2	SB15	-	-
3/4	3/4	SB16	-	-
3/4	1	SB7***	-	-
7/8	1	SB8	-	-
1	1	SB9	-	-

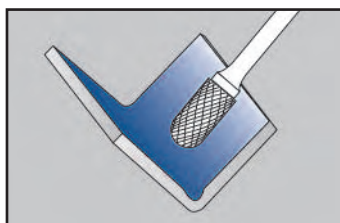
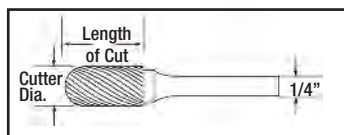
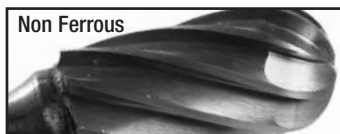
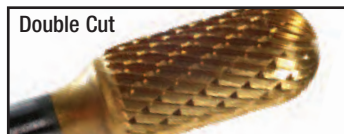
* 6" overall length

** 3/8" shank

*** Available without Titanium Nitride Coating. Specify US (uncoated) when ordering.

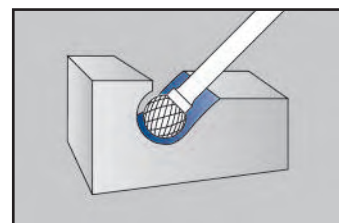
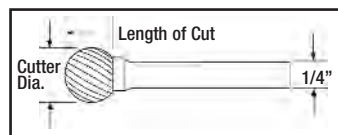


SC Cylinder Radius End



USE FOR SURFACE MILLING/
CONTOURING

SD Ball Shape



USE FOR CONTOURING / HOLE
DEBURRING / MILLING

Cutter Details		List / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/8	1/2	SC11***	-	-
1/8	5/8	SC12	-	-
5/32	5/8	SC13	-	-
3/16	5/8	SC14	-	-
1/4	5/8	SC1***	-	-
1/4	1/2	-	-	SC1-L6*
1/4	3/4	-	SC1NF	-
5/16	3/4	SC2	-	-
3/8	3/4	SC3***	SC3NF	SC3-L6*
3/8	1	SC3L	-	-
3/8	1-1/2	SC3X	-	-
7/16	1	SC4	-	-
1/2	1	SC5***	SC5NF	SC5-L6*
5/8	1	SC6	SC6NF	-
3/4	1/2	SC15	-	-
3/4	3/4	SC16	-	-
3/4	1	SC7***	SC7NF	-
3/4	1	-	SC7NF-3/8**	-
1	1	SC9	-	-

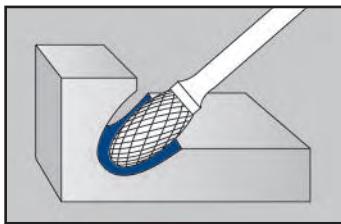
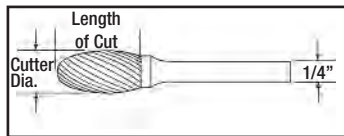
Cutter Details		List / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/8	3/32	SD11	-	-
3/16	1/8	SD14***	-	-
1/4	7/32	SD1***	SD1NF	SD1-L6*
5/16	1/4	SD2***	-	-
3/8	5/16	SD3***	SD3NF	SD3-L6*
7/16	3/8	SD4	-	-
1/2	7/16	SD5***	SD5NF	SD5-L6*
5/8	9/16	SD6	SD6NF	-
3/4	11/16	SD7***	SD7NF	-
3/4	11/16	-	SD7NF-3/8**	-
1	15/16	SD9	-	-

* 6" overall length
 ** 3/8" shank
 *** Available without Titanium Nitride Coating.
 Specify US (uncoated) when ordering.





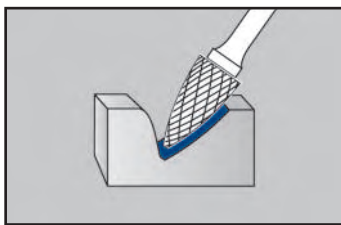
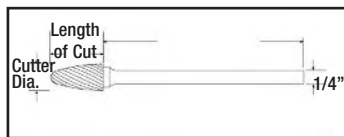
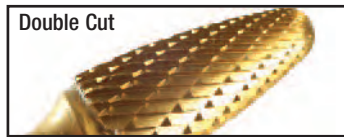
SE Oval Shape



USE FOR CONTOURING

CUTTER DETAILS		LIST / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
3/16	5/16	SE11	-	-
1/4	3/8	SE1***	-	SE1-L6*
3/8	5/8	SE3***	SE3NF	SE3-L6*
1/2	7/8	SE5***	SE5NF	SE5-L6*
5/8	1	SE6***	SE6NF	-
3/4	1	SE7	SE7NF	-
3/4	1	-	SE7NF-3/8**	-

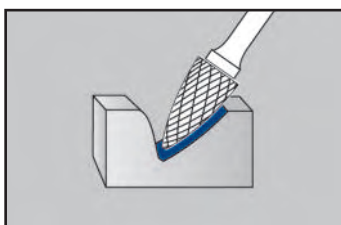
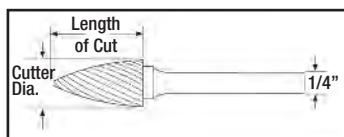
SF Tree Shape Radius End



USE FOR WORK ON NARROW CONTOURS

CUTTER DETAILS		LIST / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/8	1/2	SF11	-	-
1/4	3/4	SF1***	SF1NF	-
1/4	1/2	-	-	SF1-L6*
3/8	3/4	SF3***	SF3-NF	SF3-L6*
7/16	1	SF4	-	-
1/2	3/4	SF13	-	-
1/2	1	SF5***	SF5-NF	SF5-L6*
5/8	1	SF6	SF6-NF	-
3/4	1	SF7	-	-
3/4	1-1/4	SF14	SF14-NF	-
3/4	1-1/4	-	SF14-NF-3/8**	-
3/4	1-1/2	SF15	-	-

SG Tree Shape



USE FOR NARROW CONTOURS & MILLING

CUTTER DETAILS		LIST / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/4	5/8	SG1***	-	-
1/4	1/2	-	-	SG1-L6*
5/16	3/4	SG2	-	-
3/8	3/4	SG3***	-	SG3-L6*
1/2	3/4	SG13***	-	-
1/2	1	SG5***	-	SG5-L6*
5/8	1	SG6	-	-
3/4	1	SG7	-	-
3/4	1-1/2	SG15	-	-

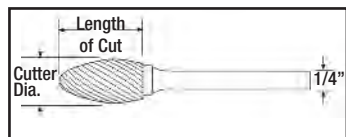
* 6" overall length

** 3/8" shank

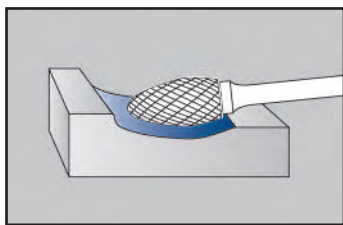
*** Available without Titanium Nitride Coating. Specify US (uncoated) when ordering.



SH Flame Shape

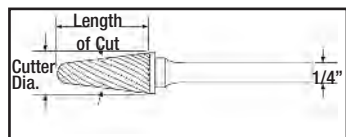
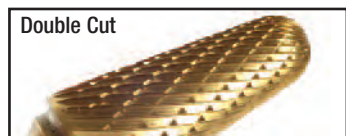


USE FOR CONTOURING

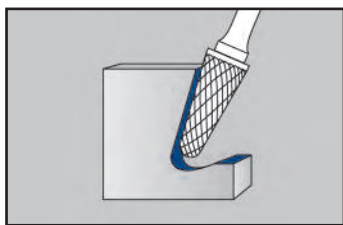


CUTTER DETAILS		LIST / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/4	5/8	SH1***	-	-
5/16	3/4	SH2	-	SH2-L6
1/2	1-1/4	SH5***	-	SH5-L6
5/8	1-7/16	SH6	-	-
3/4	1-5/8	SH7***	-	-

SL SL14° Taper Radius End

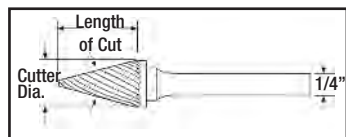
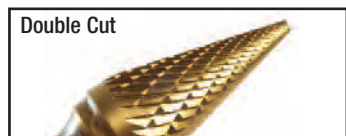


USE FOR NARROW CONTOURS / SURFACE MACHINING

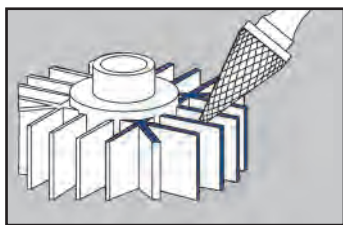


CUTTER DETAILS		LIST / EDP No.		
Cutter Diameter	Length of Cut	Double Cut	Non Ferrous	Long Series
1/4	5/8	SL1***	-	SL1-L6
5/16	7/8	SL2	-	-
3/8	1-1/16	SL3***	SL3-NF	SL3-L6
1/2	1-1/8	SL4***	SL4-NF	SL4-L6
5/8	1-3/16	SL5	SL5-NF	-
5/8	1-5/16	SL6	SL6-NF	-
3/4	1-1/2	SL7	SL7-NF	-
3/4	1-1/2	-	SL7-NF-3/8	-

SM Cone Shape



USE FOR NARROW CONTOURS / SURFACE MACHINING



CUTTER DETAILS			LIST / EDP No.	
Cutter Diameter	Length of Cut	Included Angle	Double Cut	Non Ferrous
1/4	1/2	22°	SM1	-
1/4	3/4	14°	SM2***	-
1/4	1	10°	SM3***	-
3/8	5/8	28°	SM4***	-
1/2	7/8	28°	SM5***	-
5/8	1	31°	SM6	-

* 6" overall length

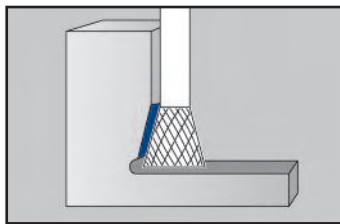
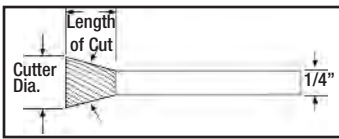
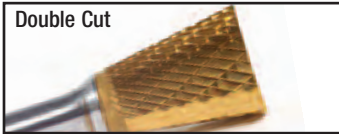
** 3/8" shank

*** Available without Titanium Nitride Coating

Specify US (uncoated) when ordering



SN Inverted Cone Shape

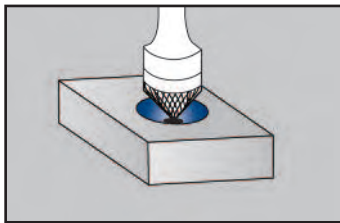
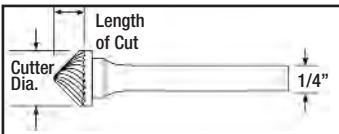
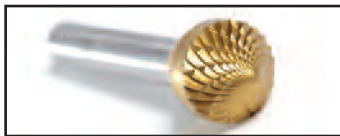


EDGE MACHINING FROM THE REAR IN HARD TO REACH AREAS

CUTTER DETAILS			LIST / EDP NO.
Cutter Diameter	Length of Cut	Included Angle	Double Cut
1/4	5/16	10°	SN1***
3/8	3/8	13°	SN2
1/2	1/2	28°	SN4***
5/8	3/4	18°	SN6
3/4	5/8	30°	SN7

*** Available without Titanium Nitride Coating. Specify US (uncoated) when ordering.

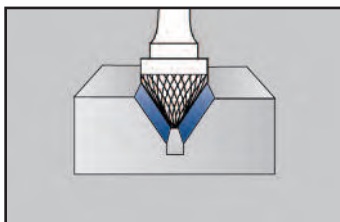
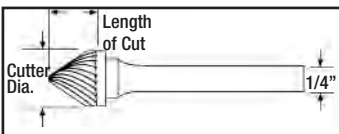
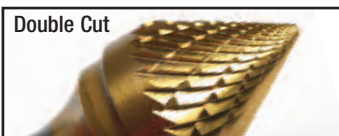
SK 90° Cone Shape



MACHINING OF ACUTE ANGLE AREAS / COUNTERSINKING

CUTTER DETAILS		LIST / EDP NO.
Cutter Diameter	Length of Cut	Double Cut
1/4	1/8	SK1
3/8	3/16	SK3
1/2	1/4	SK5
5/8	5/16	SK6
3/4	3/8	SK7
1	1/2	SK9

SJ 60° Cone Shape



MACHINING OF ACUTE ANGLE AREAS / COUNTERSINKING

CUTTER DETAILS		LIST / EDP NO.
Cutter Diameter	Length of Cut	Double Cut
1/4	3/16	SJ1
3/8	5/16	SJ3
1/2	7/16	SJ5
5/8	9/16	SJ6
3/4	11/16	SJ7
1	15/16	SJ9

CHAMPION

Combi Bur

Description: Designed to reduce downtime and cover multi-application processes for metal removal. Exclusive new shape engineered for deburring, edging and blending with a single bur.

Application: Ideal for complex parts where different shapes are required.

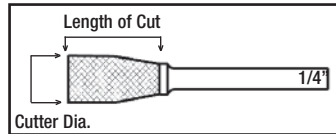


The Versatile Bur

- A bur that can be used on a wide range of materials and processes
- Reduced downtime for the end user
- Special tooth geometry manufactured using the latest CNC technology
- The highest quality sintered tungsten carbide for consistent quality

Cutter Details

Bur Type and List No.	Cutter Diameter	Length of Cut
SD5C0	1/2"	3/4"



CHAMPION

Radius Burs

Description: Multi-application burs to cover almost all general metal removal work. Exclusive inverted curve design, suitable for use across a wide range of jobs and reduces the need for consumable and tool changes, saving you time as well as money.

Application: Use on a wide variety of materials including titanium, bronze, stainless steel, cast iron, brass and more.

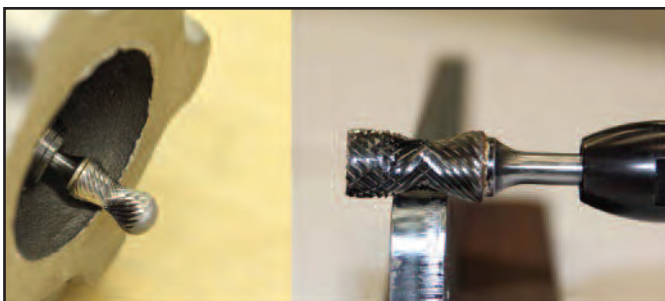
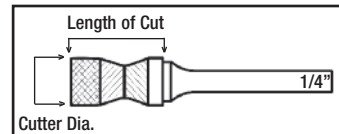
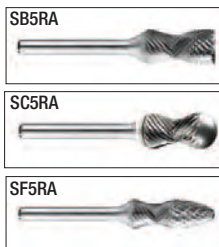


The Inverted Versatile Bur

- Unique inverted curve - ideal for creating a smooth radius on sharp corners
- Unique guide system - for ease of control on sharp edges
- Special tooth geometry - for smooth cutting action using all faces and rapid material removal
- The highest quality sintered tungsten carbide and CNC machining for consistent quality

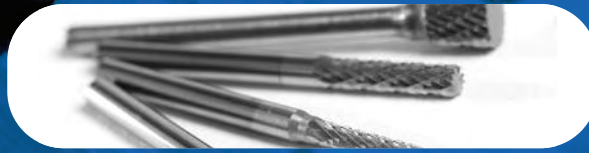
Cutter Details

Bur Type and List No.	Cutter Diameter	Length of Cut
SB5RA	1/2"	1"
SC5RA	1/2"	1"
SF5RA	1/2"	1-1/4"





Miniature Burs



Description: Miniature Burs have 1/8" shank diameter and 1-1/2" overall length.

Application: Miniature burs are ideal for engraving and use in Dremel like power tools (often called pencil grinders).

CUTTER DETAILS			LIST / EDP NO.
Cut Style	Cutter Diameter	Length of Cut	Double Cut
SA	1/16	1/4	SA41
	3/32	7/16	SA42
	1/8	9/16	SA43
	1/4	1/2	SA51
SB	1/8	9/16	SB-43 End Cut Only
	1/8	Double End	SB-43 End Cut Only
	1/4	3/16	SB51
SC	3/32	7/16	SC41
	1/8	9/16	SC42
	1/4	1/2	SC51
SD	3/32	3/32	SD41
	1/8	1/8	SD42
	1/4	7/32	SD51
SE	1/8	7/32	SE41
	1/4	3/8	SE51
SF	1/8	1/4	SF41
	1/8	1/2	SF42
	1/4	1/2	SF51

CUTTER DETAILS			LIST / EDP NO.
Cut Style	Cutter Diameter	Length of Cut	Double Cut
SG	1/8	1/4	SG41
	1/8	5/16	SG42
	1/8	3/8	SG43
	1/8	1/2	SG44
	1/4	1/2	SG51
SH	1/8	1/4	SH41
SJ	1/8	3/32	SJ42
SL	1/8	3/8	SL41
	1/4	1/2	SL42
SM	1/8	11/32	SM41
	1/8	7/16	SM42
	1/8	5/8	SM43
SN	1/4	1/2	SN51
	1/4	1/4	SN51



Fiberglass Routers - Carbide



Description: Solid carbide fiberglass routers.

Application: Use to shape, cut or remove excess material in fiberglass, plastics and other non-metallic materials. Ideally suited for the production of fiberglass circuit boards and in the boating, aerospace and RV industries.

LIST / EDP NO.	CUTTER DIAMETER	SHANK DIAMETER	FLUTE LENGTH	OVERALL LENGTH
FGR-1	1/16	1/8	3/16	1-1/2
FGR-1-1	3/32	1/8	3/8	1-1/2
FGR-2	1/8	1/8	1/2	1-1/2
FGR-3	3/16	3/16	5/8	2
FGR-4	3/16	1/4	5/8	2
FGR-5	1/4	1/4	3/4	2
FGR-6	1/4	1/4	3/4	2-1/2
FGR-6-1	1/4	1/4	1	3
FGR-7	5/16	5/16	1	2-1/2
FGR-8	3/8	3/8	1	2-1/2
FGR-9	1/2	1/2	1	3

Please specify FGR-A (No End Cut), FGR-B (Bur End), FGR-C (End Mill Cut) or FGR-D (Drill End) when ordering.
Ordering Example: FGR-A-6-1.



Square Tool Bits

Square Turning Tools
High Speed / Cobalt



Brazed Carbide Tool Bits

Single Point Turning Tools
Straight / Lead Angle / Square Nose /
Pointed Nose / Threading / Cut Off



Square Tool Bits

Size	Overall Length	Size	Overall Length
1/8*	2-1/2	5/8*	4-1/2
3/16*	2-1/2	3/4*	5
1/4*	2-1/2	7/8*	6
5/16*	2-1/2	1*	7
3/8*	3	1-1/4*	8
1/2*	4		

* Please specify 515 or 516 when ordering.

Square Tool Bits High Speed

List No.515*

High Speed Steel / 10° Bevel

Description: Premium grade of high speed steel for long life and high performance.

Application: Heavy duty machining of hard and tough materials.

Square Tool Bits Cobalt

List No.516*

M35 5% Cobalt / 10° Bevel

Description: M35 cobalt steel for greater wear resistance.

Application: Heavy duty machining of hard and tough materials.

Brazed Carbide Tool Bits

Grade 883 / EDP No.	Grade 370 / EDP No.	Width	Shank Dimension Height	Shank Dimension Length
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Straight Turning Tools - List No.AR - For turning to square shoulder



AR4-883	AR4-370	1/4	1/4	2
AR5-883	AR5-370	5/16	5/16	2-1/4
AR6-883	AR6-370	3/8	3/8	2-1/2
AR7-883	AR7-370	7/16	7/16	3
AR8-883	AR8-370	1/2	1/2	3-1/2
AR10-883	AR10-370	5/8	5/8	4
AR12-883	AR12-370	3/4	3/4	4-1/2
AR16-883	AR16-370	1	1	7
AR20-883	AR20-370	1-1/4	1-1/4	8
AR44-883	AR44-370	1/2	1/2	9

Grade 883 / EDP No.	Grade 370 / EDP No.	Width	Shank Dimension Height	Shank Dimension Length
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Straight Turning Tools - List No.AL - For facing to square shoulder



AL4-883	AL4-370	1/4	1/4	2
AL5-883	AL5-370	5/16	5/16	2-1/4
AL6-883	AL6-370	3/8	3/8	2-1/2
AL7-883	AL7-370	7/16	7/16	3
AL8-883	AL8-370	1/2	1/2	3-1/2
AL10-883	AL10-370	5/8	5/8	4
AL12-883	AL12-370	3/4	3/4	4-1/2
AL16-883	AL16-370	1	1	7
	AL20-370	1-1/4	1-1/4	8

Lead Angle Turning Tools - List No.BR -

For rough turning where square shoulder is not required



BR4-883	BR4-370	1/4	1/4	2
BR5-883	BR5-370	5/16	5/16	2-1/4
BR6-883	BR6-370	3/8	3/8	2-1/2
BR7-883	BR7-370	7/16	7/16	3
BR8-883	BR8-370	1/2	1/2	3-1/2
BR10-883	BR10-370	5/8	5/8	4
BR12-883	BR12-370	3/4	3/4	4-1/2
BR16-883	BR16-370	1	1	7
BR20-883	BR20-370	1-1/4	1-1/4	8

Lead Angle Turning Tools - List No.BL -

For rough turning where square shoulder is not required



BL4-883	BL4-370	1/4	1/4	2
BL5-883	BL5-370	5/16	5/16	2-1/4
BL6-883	BL6-370	3/8	3/8	2-1/2
BL7-883	BL7-370	7/16	7/16	3
BL8-883	BL8-370	1/2	1/2	3-1/2
BL10-883	BL10-370	5/8	5/8	4
BL12-883	BL12-370	3/4	3/4	4-1/2
BL16-883	BL16-370	1	1	7
BL20-883	BL20-370	1-1/4	1-1/4	8

Square Nose Tools - List No.C -

For chamfering



C4-883	C4-370	1/4	1/4	2
C5-883	C5-370	5/16	5/16	2-1/4
C6-883	C6-370	3/8	3/8	2-1/2
C7-883	C7-370	7/16	7/16	3
C8-883	C8-370	1/2	1/2	3-1/2
C10-883	C10-370	5/8	5/8	4
C12-883	C12-370	3/4	3/4	4-1/2
C16-883	C16-370	1	1	7
C20-883	C20-370	1-1/4	1-1/4	8
C44-883	C44-370	1/2	1/2	9

Pointed Nose Tools - List No.D -

For undercutting and chamfering



D4-883	D4-370	1/4	1/4	2
D5-883	D5-370	5/16	5/16	2-1/4
D6-883	D6-370	3/8	3/8	2-1/2
D7-883	D7-370	7/16	7/16	3
D8-883	D8-370	1/2	1/2	3-1/2
D10-883	D10-370	5/8	5/8	4
D12-883	D12-370	3/4	3/4	4-1/2
D16-883	D16-370	1	1	7

Threading Tools - List No.E -

For universal threading 30° chamfering, notching and undercutting



E4-883	E4-370	1/4	1/4	2
E5-883	E5-370	5/16	5/16	2-1/4
E6-883	E6-370	3/8	3/8	2-1/2
E7-883	E7-370	7/16	7/16	3
E8-883	E8-370	1/2	1/2	3-1/2
E10-883	E10-370	5/8	5/8	4
E12-883	E12-370	3/4	3/4	4-1/2

Brazed Carbide Tool Bits

List No.883**

Description: Series 883 is equivalent to C2 grade.

Application: Commonly used for turning non-ferrous materials such as brass & aluminum as well as cast iron.

Brazed Carbide Tool Bits

List No.370**

Description: Series 370 is equivalent to C6 grade.

Application: For use on steel.

** Please specify 883 / 370 when ordering.



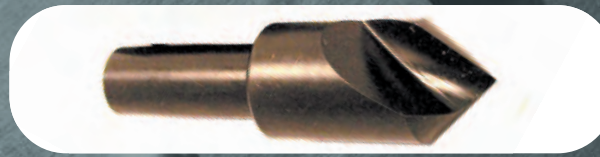
Single Flute Countersinks

List No. XL801

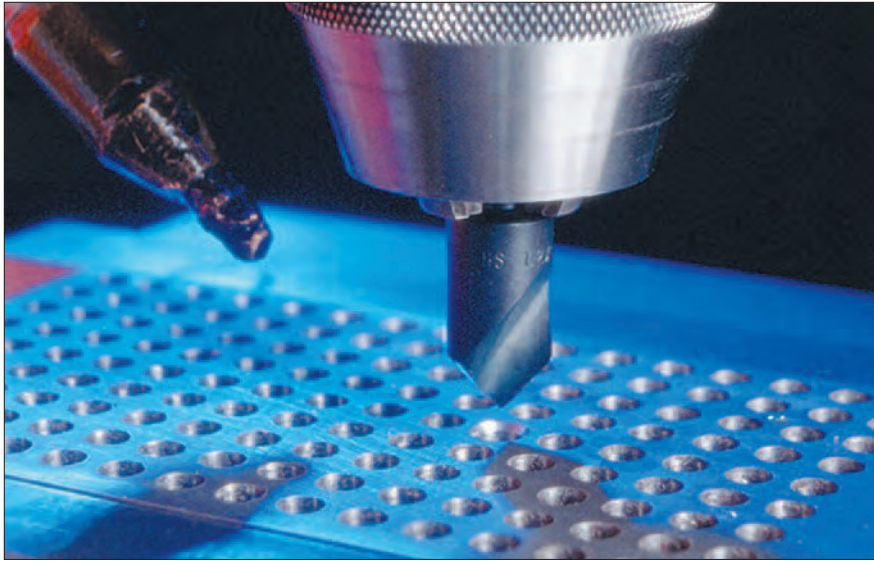
High Hook / HSS

Description: Self centering and good for non-rigid machining set up. Also able to countersink a wide range of hole sizes with one tool size.

Application: For use in a portable drill, drill press or Bridgeport type machine



60°	82°	EDP No./Diameter			Shank Diameter	Overall Length
		90°	100°	120°		
XL801-1/4x60	XL801-1/4x82	XL801-1/4x90	XL801-1/4x100	XL801-1/4x120	1/4	1-1/2
XL801-3/8x60	XL801-3/8x82	XL801-3/8x90	XL801-3/8x100	XL801-3/8x120	1/4	1-3/4
XL801-1/2x60	XL801-1/2x82	XL801-1/2x90	XL801-1/2x100	XL801-1/2x120	3/8	2
XL801-5/8x60	XL801-5/8x82	XL801-5/8x90	XL801-5/8x100	XL801-5/8x120	3/8	2-1/4
XL801-3/4x60	XL801-3/4x82	XL801-3/4x90	XL801-3/4x100	XL801-3/4x120	1/2	2-5/8
XL801-1x60	XL801-1x82	XL801-1x90	XL801-1x100	XL801-1x120	1/2	2-3/4
XL801-1-1/4x60	XL801-1-1/4x82	XL801-1-1/4x90	XL801-1-1/4x100	XL801-1-1/4x120	1/2	2-3/4
XL801-1-1/2x60	XL801-1-1/2x82	XL801-1-1/2x90	XL801-1-1/2x100	XL801-1-1/2x120	3/4	2-7/8
XL801-2x60	XL801-2x82	XL801-2x90	XL801-2x100	XL801-2x120	3/4	3-1/4



If angle is not specified - 82° will be supplied.



Four Flute Machine Countersinks

List No. 800

Description: Countersink, chamfer or debur existing holes. Additional shank length for use in screw machines and turret lathes.

Application: For machine countersinking and chamfering a variety of steels and alloys.



60°	EDP No./Diameter		Shank Diameter	Overall Length
	82°	90°		
800-1/2x60	800-1/2x82	800-1/2x90	1/2	3-7/8
800-5/8x60	800-5/8x82	800-5/8x90	1/2	4
800-3/4x60	800-3/4x82	800-3/4x90	1/2	4-1/8
800-7/8x60	800-7/8x82	800-7/8x90	1/2	4-1/4
800-1x60	800-1x82	800-1x90	1/2	4-3/8

CHAMPION

Three Flute Countersinks List No. 799



Description: As with the single flute countersinks they are designed for use with chatter free performance and are used mostly in portable applications.

Application: For machine countersinking and chamfering a variety of steels and alloys.

60°	82°	EDP No./Diameter			Shank Diameter	Overall Length
		90°	100°	120°		
799-1/4X60	799-1/4X82	799-1/4X90	799-1/4X100	799-1/4X120	1/4	1-7/16
799-3/8X60	799-3/8X82	799-3/8X90	799-3/8X100	799-3/8X120	1/4	1-21/32
799-1/2X60	799-1/2X82	799-1/2X90	799-1/2X100	799-1/2X120	1/4	1-27/32
799-5/8X60	799-5/8X82	799-5/8X90	799-5/8X100	799-5/8X120	3/8	2-3/32
799-3/4X60	799-3/4X82	799-3/4X90	799-3/4X100	799-3/4X120	1/2	2-13/32
799-1X60	799-1X82	799-1X90	799-1X100	799-1X120	1/2	2-13/16

CHAMPION

Large Four Flute Countersinks List No. 799L



Description: For the countersinking of large diameter holes.

Good for mild steel and use in standard portable hand held drills.

Application: For machine countersinking and chamfering a variety of steels and alloys.

60°	EDP No./Diameter		Shank Diameter	Overall Length
	82°	90°		
799L-1-1/4X60	799L-1-1/4X82	799L-1-1/4X90	1/2	2-1/8
799L-1-1/2X60	799L-1-1/2X82	799L-1-1/2X90	3/4	2-3/8
799L-1-3/4X60	799L-1-3/4X82	799L-1-3/4X90	3/4	2-5/8
799L-2X60	799L-2X82	799L-2X90	3/4	2-7/8

CHAMPION

Combined Drill and Countersinks List No. 798

Plain Style / 60° included angle / HSS



Description: Often referred to as center drills.

Application: Designed for drilling the center holes in the ends of material that will be held on machine center. Most common style used.

EDP No./Diameter	Body Diameter	Drill Diameter	Drill Length	Overall Length
798-00	1/8	.025	.030	1-1/8
798-0	1/8	1/32	.038	1-1/8
798-1	1/8	3/64	3/64	1-1/4
798-2	3/16	5/64	5/64	1-7/8
798-3	1/4	7/64	7/64	2

EDP No./Diameter	Body Diameter	Drill Diameter	Drill Length	Overall Length
798-4	5/16	1/8	1/8	2-1/8
798-5	7/16	3/16	3/16	2-3/4
798-6	1/2	7/32	7/32	3
798-7	5/8	1/4	1/4	3-1/4
798-8	3/4	5/16	5/16	3-1/2



Combined Drill and Countersinks

List No. 796

Bell Style / 60° and 90° Included Angles / HSS

Description: Use where parts to be machined will pass through a number of subsequent handlings & danger of marring edges of the center holes may exist.

Application: Designed for drilling the center holes in the ends of material that will be held on machine center.



EDP No./ Size	Body Diameter	Point Dia.	Drill Length	Overall Length	Point Length	EDP No./ Size	Body Diameter	Point Dia.	Drill Length	Overall Length	Point Length
796-11	1/8	3/64	3/64	1-1/4	.100	796-15	7/16	5/32	5/32	2-3/4	.350
796-12	3/16	1/16	1/16	1-7/8	.150	796-16	1/2	3/16	3/16	3	.400
796-13	1/4	3/32	3/32	2	.200	796-17	5/8	7/32	7/32	3-1/4	.500
796-14	5/16	7/64	7/64	2-1/8	.250	796-18	3/4	1/4	1/4	3-1/2	.600



Combined Drill & Countersinks

List No. 795

Extra Long / HSS

Description: Often referred to as center drills.

Application: Designed for drilling the center holes in the ends of material that will be held on machine center.



EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter	EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
795-1X3	1/8	3/64	3/64	3	795-4X4	5/16	1/8	1/8	4
795-1X4	1/8	3/64	3/64	4	795-4X5	5/16	1/8	1/8	5
795-1X5	1/8	3/64	3/64	5	795-4X6	5/16	1/8	1/8	6
795-1X6	1/8	3/64	3/64	6	795-5X4	7/16	9/64	3/16	4
795-2X4	3/16	5/64	5/64	4	795-5X5	7/16	9/64	3/16	5
795-2X5	3/16	5/64	5/64	5	795-5X6	7/16	9/64	3/16	6
795-2X6	3/16	5/64	5/64	6	795-6X5	1/2	7/32	7/32	5
795-3X4	1/4	7/64	7/64	4	795-6X6	1/2	7/32	7/32	6
795-3X5	1/4	7/64	7/64	5	795-7X6	5/8	1/4	1/4	6
795-3X6	1/4	7/64	7/64	6	795-8X6	3/4	5/16	5/16	6



Carbide Combined Drill and Countersinks

List No. 198

Plain Style / 60° included angle / Solid Carbide

Description: Often referred to as center drills.

Application: Designed for drilling the center holes in the ends of material that will be held on machine center. Most common style used.



EDP No./ Size	Body Diameter	Drill Diameter	Overall Length
198-1	1/8	3/64	1-1/4
198-2	3/16	5/64	1-7/8
198-3	1/4	7/64	2

EDP No./ Size	Body Diameter	Drill Diameter	Overall Length
198-4	5/16	1/8	2-1/8
198-5	7/16	3/16	2-3/4
198-6	1/2	7/32	3



Zero Flute Countersinks (Deburring Tools)

List No. CSK
82° Piloted



Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Ideal for use in portable applications and materials, including metal, plastic, wood & aluminum. Ideal for glass, window and door frame installations.



Champion's high speed steel zero flute countersinks (deburring tools) offer superior quality, unique designs and outstanding performance, yielding excellent workpiece finish.

These tools can be easily sharpened by use of a small mounted grinding wheel inserted in the hole.

EDP No./ Size	Screw Size	Shank Diameter	Overall Length	Body Diameter	Pilot Diameter
CSK8-1	1/4	3/8	2	33/64	1/4
CSK8-2	1/4	3/8	2	33/64	17/64
CSK10-1	5/16	3/8	2-3/16	41/64	5/16
CSK10-2	5/16	3/8	2-3/16	41/64	21/64
CSK12-1	3/8	1/2	2-5/8	49/64	3/8
CSK12-2	3/8	1/2	2-5/8	49/64	25/64
CSK14-1	7/16	1/2	2-3/4	53/64	7/16
CSK14-2	7/16	1/2	2-3/4	53/64	29/64
CSK16-1	1/2	1/2	2-13/16	15/16	1/2
CSK16-2	1/2	1/2	2-13/16	15/16	33/64



Zero Flute Countersinks (Deburring Tools)

List No. CSK
82° Pilotless / Round Shank



Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Ideal for use in portable applications and materials, including metal, plastic, wood & aluminum. Ideal for the glass and window design industry. Windows & door frames, store front installers & glaziers



EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
CSK3S	.073 to 15/64	1/4	1-3/4	1/4
CSK18	3/16 to 17/32	1/4	1-7/8	9/16
CSK26	.307 to 25/32	1/2	2-5/8	13/16
CSK26A	.307 to 25/32	1/4	2-1/16	13/16
CSK36	.431 to 7/8	1/2	2-13/16	1-1/8
CSK48	1/2 to 1-15/32	1/2	3-1/2	1-1/2

EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
CSK5S	Nos. 4,5	1/4	1-1/2	17/64
CSK6S	No. 6	1/4	1-1/2	19/64
CSK8S	No. 8	1/4	1-5/8	11/32
CSK10S	No. 10	1/4	1-5/8	25/64



Zero Flute Countersinks (Deburring Tools)

List No. CSK-SH

1/4" Hex Shank



Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Ideal for use in portable applications and materials, including metal, plastic, wood & aluminum. Ideal for the glass and window design industry. Windows & door frames, store front installers & glaziers

EDP No./ Size	Screw Size	Shank Diameter	Overall Length	Body Diameter	EDP No./ Size	Screw Size	Shank Diameter	Overall Length	Body Diameter
CSK-3SH	Nos. 2,3,4	Hex	1-27/32	1/4	CSK-18SH	Nos. 10,12,14	Hex	2-5/16	9/16
CSK-8SH	Nos. 5,6,8	Hex	2	11/32					



Zero Flute Countersinks

List No. CSKA

100°



Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Used in a wide variety of materials, including metal, plastic and wood. Ideal for the glass and window design industry.

EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
CSKA8	3/32 to 1/4	1/4	1-1/2	17/64
CSKA14	1/8 to 27/64	1/4	1-11/16	7/16
CSKA18	3/16 to 35/64	1/4	1-7/8	9/16

TECHNICAL INFORMATION ON COUNTERSINKS

HOW TO CHOOSE THE RIGHT SIZE COUNTERSINK (DIAMETER)

A simple rule of thumb is to choose a countersink which is larger than the bolt size of hole.

Countersink diameter = 1.5 x Bolt Size (hole) diameter. Example: For a 1/4-20 bolt, multiply the diameter (.250) x 1.5 = .375. This equates to a 3/8" countersink.

HOW TO CALCULATE COUNTERSINK SPEEDS

Countersinking is usually performed at 1/3 the RPM of drilling. First calculate drilling speed by using the formula below. Then simply divide by 3.

Formula: SFM (surface feet/minute) x 3.82 / Cutter Diameter (decimal equivalent) / 3

Material	Surface Feet / Minute (SFM)	Sample Calculations for 1/4" Countersink Speed (RPM)
Aluminum	200 - 250	225 (SFM) x 3.82 / .2500 / 3 = 1,146 RPM
Mild Steel	100 - 110	115 (SFM) x 3.82 / .2500 / 3 = 586 RPM
Stainless Steel	30 - 100	(65 (SFM) x 3.82 / .2500) / 3 = 381 RPM

* We recommend BruteLube to enhance performance and extend tool life for all cutting tools.

CHAMPION

Zero Flute Countersinks

List No. DBK

90°



Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Use in a wide variety of materials, including metal, plastic and wood. Ideal for the glass and window design industry.

EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
DBK4*	1/64 to 11/64	3/16	1-1/2	NA
DBK6*	1/16 to 11/64	3/16	1-1/2	NA
DBK8*	1/8 to 15/64	1/4	1-3/4	NA
DBK14	5/32 to 13/32	1/4	1-11/16	7/16
DBK18	3/16 to 17/32	1/4	1-7/8	9/16
DBK26	5/16 to 25/32	1/2	2-19/32	13/16
DBK26A	5/16 to 25/32	1/4	2-1/32	13/16
DBK36	9/16 to 1-3/32	1/2	2-13/16	1-1/8
DBK48	1/2 to 1-15/32	1/2	3-1/2	1-1/2

*Double ended.



CHAMPION

Zero Flute Countersinks

List No. DCB

60°



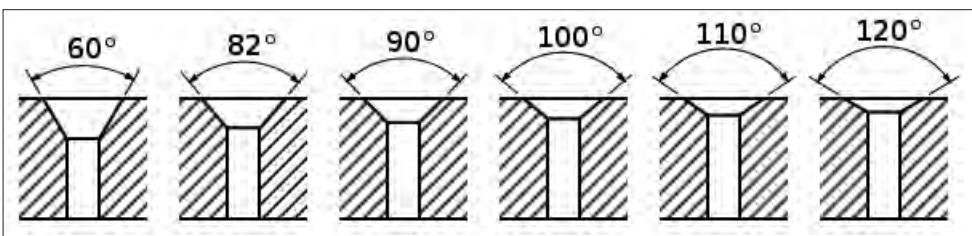
Description: Chatterless finish, single cutting edge for fast stock removal, free-cutting, easily sharpened.

Application: Use in a wide variety of materials, including metal, plastic and wood. Ideal for the glass and window design industry.

EDP No./ Size	Diameter of Cut	Shank Diameter	Overall Length	Body Diameter
DCB6*	3/32 to 11/64	3/16	1-1/2	N/A
DCB8*	1/8 to 15/64	1/4	1-3/4	N/A
DCB14	3/16 to 13/32	1/4	1-3/4	7/16
DCB18	5/16 to 17/32	1/4	1-15/16	9/16
DCB26	7/16 to 25/32	1/2	2-11/16	13/16
DCB26A	7/16 to 25/32	1/4	2-1/8	13/16
DCB36	11/16 to 1-3/32	1/2	2-7/8	1-1/8

*Double ended.

- Chatterless finish
- Single cutting edge for fast stock removal
- Free-cutting
- Easily sharpened
- Ideal for use in portable applications





Combination Drill & Taps

List No. DT22
2 Flute / 118° Point / HSS

List No. DT22M
Metric Drills & Taps

Description: Combination drill and tap available in standard, metric and titanium coated.

Application: Create holes and tap in a single operation. No center drilling or punching required.



List No. DT22T
Titanium Nitride Coated



- Ideal for use in Multi-Spindle heads with reversing capability and in RotoBrute™ variable speed/reverse magnetic drills when used with tapping heads
- Tapered neck design reduces drill & tap breakage
- 118° Split point permits holes and threads to be cut at high speeds
- Produces a class 2B fit. No special holders or collets required

EDP No. / Diameter	Overall Length	Drill Length	Drill Diameter	Tap Length	EDP No. / Diameter	Overall Length	Drill Length	Drill Diameter	Tap Length
DT22-4-40	1-7/8	1/4	.0910	3/8	DT22M-3X.5	1-5/16	9/32	.1015	3/16
DT22-4-48	1-7/8	1/4	.0945	3/8	DT22M-3.5X0.6	2	5/16	.1178	3/16
DT22-5-40	1-15/16	9/32	.1040	13/32	DT22M-4X.7	2-1/8	3/8	.1340	1/4
DT22-5-44	1-15/16	9/32	.1060	13/32	DT22M-4.5X7.5	2-3/8	13/32	.1520	5/8
DT22-6-32	2	5/16	.1115	7/16	DT22M-5X.8	2-3/8	13/32	.1700	1/4
DT22-6-40	2	5/16	.1170	7/16	DT22M-6X1	2-1/2	17/32	.2030	5/16
DT22-8-32	2-1/8	3/8	.1375	1/2	DT22M-7X1	2-27/32	11/16	.2420	15/16
DT22-8-36	2-1/8	3/8	.1405	1/2	DT22M-8X1.25	2-27/32	11/16	.2730	15/16
DT22-10-24	2-3/8	13/32	.1545	5/8	DT22M-10X1.5	3.375	13/16	.3440	15/16
DT22-10-32	2-3/8	13/32	.1635	5/8	DT22M-12X1.75	4-1/16	1-1/8	.4140	1-1/16
DT22-12-24	2-3/8	15/32	.1805	21/32					
DT22-12-28	2-3/8	15/32	.1860	21/32					
DT22-1/4-20	2-1/2	17/32	.2080	25/32					
DT22-1/4-28	2-1/2	17/32	.2220	25/32					
DT22-5/16-18	2-27/32	11/16	.2660	15/16					
DT22-5/16-24	2-27/32	11/16	.2770	15/16					
DT22-3/8-16	3-3/8	13/16	.3225	1-1/16					
DT22-3/8-24	3-3/8	13/16	.3395	1-1/16					
DT22-7/16-14	3-3/4	1	.3770	1-1/4					
DT22-7/16-20	3-3/4	1	.3955	1-1/4					
DT22-1/2-13	4-1/16	1-1/8	.4350	1-3/8					
DT22-1/2-20	4-1/16	1-1/8	.4580	1-3/8					

CHAMPION

Combination Drill & Taps

List No. DT22HEX - DT22HEXM

2 Flute / 135° SPlit Point / HSS / Black & Gold / Hex Shank



Description: Hex Shank, split point combination drill and tap available in standard and metric sizes

Application: Create holes and tap in a single operation. No center drilling or punching required, hex shank makes it ideally suited to cordless drills.

- Create the hole and thread in a single operation. No center drilling or punching required
- Its tapered neck design significantly reduces drill & tap breakage
- A 135° split point permits hole and thread to be cut at high speeds
- Available in standard, metric, and machine screw tap sizes
- Superior strength and durability provided by high molybdenum, high speed steel
- Functional black and gold surface treatment holds lubricant for smoother drilling
- 1/4" and 11/32" Hex Shank can be used in QCD (Quick Change Driver)



EDP No./ Diameter	Drill Diameter	Drill Length (inches)	Overall Length (inches)	Thread Length (inches)
DT22HEX-6-32*	7/64	5/16	2-5/16	7/16
DT22HEX-8-32*	29	5/16	2-1/2	1/2
DT22HEX-10-24*	25	5/16	2-1/2	5/8
DT22HEX-10-32*	21	5/16	2-1/2	5/8
DT22HEX-12-24*	17	3/8	2-3/8	11/16
DT22HEX-1/4-20*	6	7/16	2-7/8	3/4
DT22HEX-1/4-28*	3	7/16	2-7/8	3/4
DT22HEX-5/16-18*	G	1/2	3-1/4	15/16
DT22HEX-5/16-24*	I	1/2	3-1/4	15/16
DT22HEX-3/8-16**	5/16	3/4	3-1/2	1-1/16
DT22HEX-3/8-24**	Q	3/4	3-1/2	1-1/16
DT22HEX-7/16-14**	U	3/4	3-7/8	1-1/4
DT22HEX-7/16-20**	25/64	3/4	3-7/8	1-1/4
DT22HEX-1/2-13**	27/64	1	4	1-3/8
DT22HEX-1/2-20**	29/64	1	4	1-3/8

* 1/4" Hex Shank
** 11/32" Hex Shank

EDP No./ Diameter	Drill Diameter	Drill Length (inches)	Overall Length (inches)	Thread Length (inches)
DT22HEX-M4X.7*	30	5/16	2-7/16	1/2
DT22HEX-M5X.8*	19	3/8	2-1/2	9/16
DT22HEX-M6X1*	9	3/8	2-3/4	11/16
DT22HEX-M8X1.25*	17/64	1/2	3-1/8	7/8
DT22HEX-M10X1.5**	Q	3/4	3-1/4	15/16
DT22HEX-M12X1.75*	Y	7/8	3-5/8	1-1/16

* 1/4" Hex Shank
** 11/32" Hex Shank

DT22HEX is ideal for the following industries:

- Electrical
- Maintenance
- Industrial
- Automotive

DT22HEX is ideal for the following materials:

- Aluminum
- Steel / Stainless Steel
- Bronze / Brass
- Cast Iron
- Zinc

DT22Hex are available in 5, 6 and 10 piece plastic cased sets. Refer to page 143.



DT22HEX-SET10



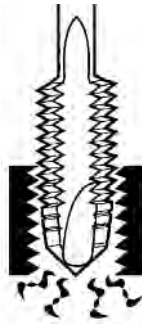
Spiral Point Taps

List No. XL22

Plug Style / Three Flute / Heavy Duty / Surface Treated

Description: Spiral point taps eject chips forward. Necked design for deeper, more trouble free tapping. Freer coolant flow to cutting edges. Heavier core for less breakage. Three flutes for 50% less tooth load. Promotes faster tapping and extended tool life. Good for stainless steel.

Application: Recommended for all through-hole applications. Used on low through high carbon steel, alloyed steels, steel drop forgings, grey cast iron, titanium, stainless steel, nimonic alloys, manganese, spring steels



Commonly referred to as “gun taps”, spiral point quickly shears and ejects chips ahead of the tap. They are recommended for tapping stainless steel and tough alloys.

EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
XL22-4-40	H2	3	9/16	2
XL22-6-32	H3	3	11/16	2
XL22-6-40	H2	3	11/16	2
XL22-8-32	H3	3	3/4	2-1/8
XL22-8-36	H2	3	3/4	2-1/8
XL22-10-24	H3	3	7/8	2-3/8
XL22-10-32	H3	3	7/8	2-3/8
XL22-12-24	H3	3	15/16	2-3/8
XL22-12-28	H3	3	15/16	2-3/8
XL22-1/4-20	H3	3	1	2-1/2
XL22-1/4-28	H3	3	1	2-1/2
XL22-5/16-18	H3	3	1-1/8	2-3/4
XL22-5/16-24	H3	3	1-1/8	2-3/4
XL22-3/8-16	H3	3	1-1/4	2-15/16
XL22-3/8-24	H3	3	1-1/4	2-15/16
XL22-7/16-14	H3	3	1-7/16	3-5/32
XL22-7/16-20	H3	3	1-7/16	3-5/32
XL22-1/2-13	H3	3	1-21/32	3-3/8
XL22-1/2-20	H3	3	1-21/32	3-3/8
XL22-5/8-11	H3	3	1-13/16	3-13/16
XL22-5/8-18	H3	3	1-13/16	3-13/16
XL22-3/4-10	H3	3	2	4-1/4
XL22-3/4-16	H3	3	2	4-1/4



Spiral Point Taps Titanium Nitride Coated

List No. XL22T

Plug Style / Three Flute / Heavy Duty

Description: Titanium Nitride surface treatment for longer tap life and less breakage. Three flute design reduces torque while the neck promotes coolant flow to the cutting edges. TiN coating gives increased surface hardness, increased durability and high lubricity.

Application: Permits tapping of high tensile martensitic stainless steels and titanium alloys at high speeds.



EDP No. / Size	H Limits	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	H Limits	No. of Flutes	Length of Thread	Overall Length
XL22T-4-40	H2	3	9/16	2	XL22T-5/16-24	H3	3	1-1/8	2-3/4
XL22T-6-32	H3	3	11/16	2	XL22T-3/8-16	H3	3	1-1/4	2-15/16
XL22T-6-40	H2	3	11/16	2	XL22T-3/8-24	H3	3	3/4	2-15/16
XL22T-8-32	H3	3	3/4	2-1/8	XL22T-7/16-14	H3	3	1-7/16	3-5/32
XL22T-8-36	H2	3	3/4	2-1/8	XL22T-7/16-20	H3	3	1-7/16	3-5/32
XL22T-10-24	H3	3	7/8	2-3/8	XL22T-1/2-13	H3	3	1-21/32	3-3/8
XL22T-10-32	H3	3	7/8	2-3/8	XL22T-1/2-20	H3	3	1-21/32	3-3/8
XL22T-12-24	H3	3	15/16	2-3/8	XL22T-5/8-11	H3	3	1-13/16	3-13/16
XL22T-12-28	H3	3	15/16	2-3/8	XL22T-5/8-18	H3	3	3-13/16	3-13/16
XL22T-1/4-20	H3	3	1	2-1/2	XL22T-3/4-10	H3	3	2	4-1/4
XL22T-1/4-28	H3	3	1-1/8	2-3/4	XL22T-3/4-16	H3	3	2	4-1/4
XL22T-5/16-18	H3	3	1-1/8	2-3/4					

CHAMPION

Spiral Point Taps

List No.321

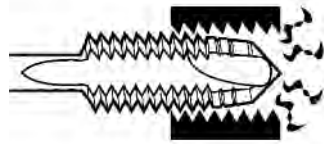
Plug Style / Standard "H" Limits / HSS



Description: Spiral point taps cut with a shearing action that shoots the chips ahead of the tap.

Application: For tapping of "through holes" or deep blind holes where a shoulder exists for chips to collect.

Spiral point quickly shears and ejects chips ahead of the tap.



EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
321-0-80	H1	2	5/16	1-5/8
321-1-64	H1	2	3/8	1-11/16
321-1-72	H1	2	3/8	1-11/16
321-2-56	H2	2	7/16	1-3/4
321-2-64	H2	2	7/16	1-3/4
321-3-48	H2	2	1/2	1-13/16
321-3-56	H2	2	1/2	1-13/16
321-4-40	H2	2	9/16	1-7/8
321-4-48	H2	2	9/16	1-7/8
321-4-36	H2	2	9/16	1-7/8
321-5-40	H2	2	5/8	1-15/16
321-5-44	H2	2	5/8	1-15/16
321-6-32	H2	2	11/16	2
321-6-40	H2	2	11/16	2
321-8-32	H2	2	3/4	2-1/8

EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
321-8-36	H2	2	3/4	2-1/8
321-10-24	H3	2	7/8	2-3/8
321-10-32	H3	2	7/8	2-3/8
321-12-24	H3	2	15/16	2-3/8
321-12-28	H3	2	15/16	2-3/8
321-1/4-20	H3	2	1	2-1/2
321-1/4-28	H3	2	1	2-1/2
321-5/16-18	H3	2	1-1/8	2-23/32
321-5/16-24	H3	2	1-1/8	2-23/32
321-3/8-16	H3	3	1-1/4	2-15/16
321-3/8-24	H3	3	1-1/4	2-15/16
321-7/16-14	H3	3	1-7/16	3-5/32
321-7/16-20	H3	3	1-7/16	3-5/32
321-1/2-13	H3	3	1-21/32	3-3/8
321-1/2-20	H3	3	1-21/32	3-3/8
321-5/8-11	H3	3	1-13/16	3-13/16
321-5/8-18	H3	3	1-13/16	3-13/16
321-3/4-10	H3	3	2	4-1/4
321-3/4-16	H3	3	2	4-1/4

CHAMPION

Metric Spiral Point Taps

List No.321M

Metric / Plug Style / Ground Thread / HSS



Description: Spiral point taps cut with a shearing action that shoots the chips ahead of the metric tap.

Application: For tapping of "through holes" or deep blind holes where a shoulder exists for chips to collect. Good for stainless steel.

EDP No. / Size	D Limits	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	D Limits	No. of Flutes	Length of Thread	Overall Length
321M-1.6x.35	3	2	5/16	1-5/8	321M-8x1.25	5	2	1-1/8	2-23/32
321M-2x.4	3	2	7/16	1-3/4	321M-10x1.25	5	3	1-1/4	2-15/16
321M-2.2x.45	3	2	7/16	1-3/4	321M-10x1.5	6	3	1-1/4	2-15/16
321M-2.5x.45	3	2	1/2	1-13/16	321M-12x1.25	5	3	1-21/32	3-3/8
321M-3x.5	3	2	5/8	1-15/16	321M-12x1.75	6	3	1-21/32	3-3/8
321M-3.5x.6	4	2	11/16	2	321M-14x1.5	6	3	1-21/32	3-19/32
321M-4x.7	4	2	3/4	2-1/8	321M-14x2	7	3	1-21/32	3-19/32
321M-4.5x.75	4	2	7/8	2-3/8	321M-16x1.5	6	3	1-13/16	3-13/16
321M-5x.8	4	2	7/8	2-3/8	321M-16x2	7	3	1-13/16	3-13/16
321M-6x1	5	2	1	2-1/2	321M-18x2.5	7	3	1-13/16	4-1/32
321M-7x1	5	2	1-1/8	2-23/32	321M-20x2.5	7	3	2	4-15/32
321M-8x1	5	3	1-1/8	2-23/32					

CHAMPION

Spiral Point Taps TiN Coated List No. 321T

Plug Style / Titanium Nitride Coated / HSS

Description: Cut with a shearing action that shoots the chips ahead of the tap. TiN coating gives increased surface hardness, greater durability & high lubricity.

Application: For tapping of "through holes" or deep blind holes where a shoulder exists for chips to collect.



EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
321T-6-32	H3	2	11/16	2
321T-8-32	H3	2	3/4	2-1/8
321T-8-36	H2	2	3/4	2-1/8
321T-10-24	H3	2	7/8	2-3/8
321T-10-32	H3	2	7/8	2-3/8
321T-12-24	H3	2	15/16	2-3/8
321T-12-28	H3	2	15/16	2-3/8
321T-1/4-20	H3	2	1	2-1/2
321T-1/4-28	H3	2	1	2-1/2
321T-5/16-18	H3	2	1-1/8	2-23/32
321T-5/16-24	H3	2	1-1/8	2-23/32
321T-3/8-16	H3	3	1-1/4	2-15/16
321T-3/8-24	H3	3	1-1/4	2-15/16
321T-7/16-14	H3	3	1-7/16	3-5/32
321T-7/16-20	H3	3	1-7/16	3-5/32
321T-1/2-13	H3	3	1-21/32	3-3/8
321T-1/2-20	H3	3	1-21/32	3-3/8
321T-5/8-11	H3	3	1-13/16	3-13/16
321T-5/8-18	H3	3	1-13/16	3-13/16
321T-3/4-10	H3	3	2	4-1/4
321T-3/4-16	H3	3	2	4-1/4



CHAMPION

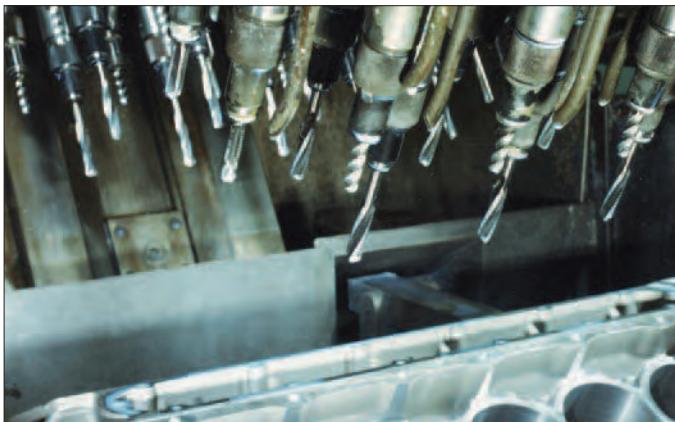
High Speed Hand Taps List No. 308

Standard "H" Limits / Ground Thread



Description: High quality high speed hand tap.

Application: Operated in tap wrenches or production tapping heads for general purpose tapping supplied in standard "H" limits that will provide an adequate "class of fit" for standard tapping applications.



EDP No./ Diameter	H Limits	No of Flutes	Length of Thread	Overall Length
308-0-80	H1	2	5/16	1-5/8
308-1-64	H1	2	3/8	1-11/16
308-1-72	H1	2	3/8	1-11/16
308-2-56	H2	3	7/16	1-3/4
308-2-64	H2	3	7/16	1-3/4
308-3-48	H2	3	1/2	1-13/16
308-3-56	H2	3	1/2	1-13/16
308-4-40	H2	3	9/16	1-7/8
308-4-48	H2	3	9/16	1-7/8
308-4-36	H2	3	9/16	1-7/8
308-5-40	H2	3	5/8	1-15/16
308-5-44	H2	3	5/8	1-15/16
308-6-32*	H3	3	11/16	2



* Available in iPac Tap & Drill combination pack with either XL5 or XGO jobber drill bits.

CHAMPION

List No. 308 continued



EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length	EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
308-6-40	H2	3	11/16	2	308-5/8-11	H3	4	1-13/16	3-13/16
308-8-32*	H3	4	3/4	2-1/8	308-5/8-18	H3	4	1-13/16	3-13/16
308-8-36	H2	4	3/4	2-1/8	308-11/16-11	H3	4	1-13/16	4-1/32
308-10-24*	H3	4	7/8	2-3/8	308-11/16-16	H3	4	1-13/16	4-1/32
308-10-32*	H3	4	7/8	2-3/8	308-3/4-10	H3	4	2	4-1/4
308-12-24*	H3	4	15/16	2-3/8	308-3/4-16	H3	4	2	4-1/4
308-12-28	H3	4	15/16	2-3/8	308-7/8-9	H4	4	2-7/32	4-11/16
308-1/4-20*	H3	4	1	2-1/2	308-7/8-14	H4	4	2-7/32	4-11/16
308-1/4-28	H3	4	1	2-1/2	308-1-8	H4	4	2-1/2	5-1/8
308-5/16-18*	H3	4	1-1/8	2-23/32	308-1-12	H4	4	2-1/2	5-1/8
308-5/16-24	H3	4	1-1/8	2-23/32	308-1-14	H4	4	2-1/2	5-1/8
308-3/8-16*	H3	4	1-1/4	2-15/16	308-1-1/8-7	H4	4	2-9/16	5-7/16
308-3/8-24	H3	4	1-1/4	2-15/16	308-1-1/8-12	H4	4	2-9/16	5-7/16
308-7/16-14*	H3	4	1-7/16	3-5/32	308-1-1/4-7	H4	4	2-9/16	5-3/4
308-7/16-20	H3	4	1-7/16	3-5/32	308-1-1/4-12	H4	6	2-9/16	5-3/4
308-1/2-13*	H3	4	1-21/32	3-3/8	308-1-3/8-6	H4	4	3	6-1/16
308-1/2-20	H3	4	1-21/32	3-3/8	308-1-3/8-12	H4	6	3	6-1/16
308-9/16-12	H3	4	1-21/32	3-19/32	308-1-1/2-6	H4	4	3	6-3/8
308-9/16-18	H3	4	1-21/32	3-19/32	308-1-1/2-12	H4	6	3	6-3/8

CHAMPION

Left Hand High Speed Hand Taps

List No. 308LH

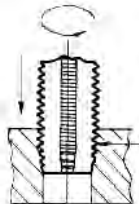
Left Hand / Standard "H" Limits / Ground Thread



Description: High quality left hand high speed hand tap.

Application: Operated in tap wrenches or production tapping heads for general purpose tapping supplied in standard "H" limits that will provide an adequate "class of fit" for standard tapping applications.

EDP No. / Size	H Limits	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	H Limits	No. of Flutes	Length of Thread	Overall Length
308LH-10-32	H3	4	7/8	2-3/8	308LH-1/2-13	H3	4	1-21/32	3-3/8
308LH-1/4-20	H3	4	1	2-1/2	308LH-1/2-20	H3	4	1-21/32	3-3/8
308LH-1/4-28	H3	4	1	2-1/2	308LH-9/16-12	H3	4	1-21/32	3-19/32
308LH-5/16-18	H3	4	1-1/8	2-23/32	308LH-9/16-18	H3	4	1-21/32	3-19/32
308LH-5/16-24	H3	4	1-1/8	2-23/32	308LH-5/8-11	H3	4	1-13/16	3-13/16
308LH-3/8-16	H3	4	1-1/4	2-15/16	308LH-5/8-18	H3	4	1-13/16	3-13/16
308LH-3/8-24	H3	4	1-1/4	2-15/16	308LH-3/4-10	H3	4	2	4-1/4
308LH-7/16-14	H3	4	1-7/16	3-5/32	308LH-3/4-16	H3	4	2	4-1/4
308LH-7/16-20	H3	4	1-7/16	3-5/32	308LH-7/8-9	H4	4	2-7/32	4-11/16
					308LH-7/8-14	H4	4	2-7/32	4-11/16
					308LH-1-8	H4	4	2-1/2	5-1/8
					308LH-1-12	H4	4	2-1/2	5-1/8
					308LH-1-14	H4	4	2-1/2	5-1/8



Cuts threads with a left hand rotation used in applications where left hand studs or fasteners are required.

Please specify taper, plug, bottom or set when ordering.

CHAMPION
CUTTING TOOL CORP.



Metric High Speed Hand Taps

List No. 308M

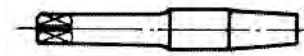
Metric / Ground Thread / HSS

Description: High quality metric high speed hand tap.

Application: Operated in tap wrenches or production tapping heads for general purpose tapping supplied in standard "H" limits that will provide an adequate "class of fit" for standard tapping applications.

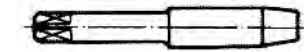


EDP No./ Size	D Limits	No. of Flutes	Overall Length	Thread Length
308M-1.6x.35	3	2	1-5/8	5/16
308M-1.8x.35	3	2	1-11/16	3/8
308M-2x.4	3	3	1-3/4	7/16
308M-2.2x.45	3	3	1-3/4	7/16
308M-2.5x.45	3	3	1-13/16	1/2
308M-3x.5	3	3	1-15/16	5/8
308M-3.5x6	3	3	2	11/16
308M-4x.7	4	4	2-1/8	3/4
308M-4.5x.75	4	4	2-3/8	7/8
308M-5x.8	4	4	2-3/8	7/8
308M-6x1	5	4	2-1/2	1
308M-7x1	5	4	2-23/32	1-1/8
308M-8x1.0	5	4	2-23/32	1-1/8
308M-8x1.25	5	4	2-23/32	1-1/8
308M-10x1.25	5	4	2-15/16	1-1/4
308M-10x1.5	6	4	2-15/16	1-1/4
308M-12x1.25	5	4	3-3/8	1-21/32
308M-12x1.75	6	4	3-3/8	1-21/32
308M-14x1.5	6	4	3-19/32	1-21/32
308M-14x2	7	4	3-19/32	1-21/32
308M-16x1.5	6	4	3-13/16	1-13/16
308M-16x2	7	4	3-13/16	1-13/16
308M-18x1.5	6	4	4-1/32	1-13/16
308M-20x2.5	7	4	4-15/32	2
308M-22x2.5	7	4	4-11/16	2-7/32
308M-24x3	8	4	4-29/32	2-7/32
308M-27x3	8	4	5-1/8	2-1/2
308M-30x3.5	9	4	5-7/16	2-9/16
308M-33x3.5	9	4	5-3/4	2-9/16
308M-36x4	9	4	6-1/16	3
308M-39x4	9	6	6-11/16	3-3/16
308M-42x4.5	10	6	7	3-3/16
308M-45x4.5	10	6	7-5/16	3-9/16
308M-48x5	11	6	7-5/8	3-9/16
308M-52x5	11	6	8	3-9/16
308M-56x5.5	11	6	8-1/4	3-9/16



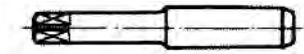
Taper taps

Distribute the cutting load across 7–10 threads. Used for starting a threaded hole.



Plug taps

Most commonly used, distribute the load across 3–5 threads of chamfer.



Bottoming taps

Have only 1-1/2 threads of chamfer and are used to tap to the bottom of a blind hole.

Please specify:

T (taper), P (plug), B (bottom) or S (set) when ordering. If not specified then plug style will be supplied.





Carbon Steel Hand Taps

List No. 302

List No. 302M

Metric Hand Taps

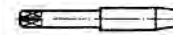
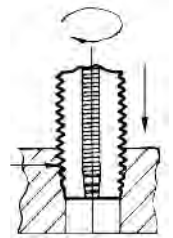
Plug Style

Description/Application: For hand tapping in maintenance and repair work and for re-threading applications where extreme thread accuracy and tolerance is not critical.



EDP No./ Size	No. of Flutes	Length of Thread	Overall Length
302-4-40	3	9/16	1-7/8
302-4-48	3	9/16	1-7/8
302-5-40	3	5/8	1-15/16
302-5-44	3	5/8	1-15/16
302-6-32	3	11/16	2
302-6-40	3	11/16	2
302-8-32	4	3/4	2-1/8
302-8-36	4	3/4	2-1/8
302-10-24	4	7/8	2-3/8
302-10-32	4	7/8	2-3/8
302-12-24	4	15/16	2-3/8
302-12-28	4	15/16	2-3/8
302-1/4-20	4	1	2-1/2
302-1/4-28	4	1	2-1/2
302-5/16-18	4	1-1/8	2-23/32
302-5/16-24	4	1-1/8	2-23/32
302-3/8-16	4	1-1/4	2-15/16
302-3/8-24	4	1-1/4	2-15/16
302-7/16-14	4	1-7/16	3-5/32
302-7/16-20	4	1-7/16	3-5/32
302-1/2-13	4	1-21/32	3-3/8
302-1/2-20	4	1-21/32	3-3/8
302-9/16-12	4	1-21/32	3-19/32
302-9/16-18	4	1-21/32	3-19/32
302-5/8-11	4	1-13/16	3-13/16
302-5/8-18	4	1-13/16	3-13/16
302-3/4-10	4	2	4-1/4
302-3/4-16	4	2	4-1/4
302-7/8-9	4	2-7/32	4-11/16
302-7/8-14	4	2-7/32	4-11/16
302-1-8	4	2-1/2	5-1/8
302-1-12	4	2-1/2	5-1/8
302-1-14	4	2-1/2	5-1/8
302-1-1/8-7	4	2-9/16	5-7/16
302-1-1/8-12	4	2-9/16	5-7/16
302-1-1/4-7	4	2-9/16	5-3/4
302-1-1/4-12	6	2-9/16	5-3/4
302-1-3/8-6	4	3	6-1/16
302-1-3/8-12	6	3	6-1/16
302-1-1/2-6	4	3	6-3/8
302-1-1/2-12	6	3	6-3/8

Please specify T (taper), P (plug), B (bottom) or S (set) when ordering. If not specified then plug style will be supplied.



Taper taps

Distribute the cutting load across 7–10 threads. Used for starting a threaded hole.

Plug taps

Most commonly used, distribute the load across 3–5 threads of chamfer.

Bottoming taps

Have only 1 to 1-1/2 threads of chamfer and are used to tap to the bottom of a blind hole.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
302M-3X.5-P	3	5/8	1-5/16
302M-3X.6-P	3	5/8	1-5/16
302M-4X.7-P	4	3/4	2-1/8
302M-4X.75-P	4	3/4	2-1/8
302M-5X.8-P	4	15/16	2-3/8
302M-5X.9-P	4	15/16	2-3/8
302M-6X1-P	4	1	2-1/2
302M-7X1-P	4	1-1/8	2-1/2
302M-8X1.25-P	4	1-1/8	2-23/32
302M-9X1-P	4	1-1/4	2-7/8
302M-9X1.25-P	4	1-1/4	2-7/8
302M-10X1.25-P	4	1-1/4	2-15/16
302M-10X1.5-P	4	1-1/4	2-15/16
302M-11X1.5-P	4	1-7/16	3-5/32
302M-12X1.5-P	4	1-21/32	3-3/8
302M-12X1.75-P	4	1-21/32	3-3/8
302M-14X1.25-P	4	1-21/32	3-21/32
302M-14X2-P	4	1-21/32	3-21/32
302M-16X1.5-P	4	1-13/16	3-13/16
302M-16X2-P	4	1-13/16	3-13/16
302M-18X1.5-P	4	1-13/16	4-1/32
302M-18X2.5-P	4	1-13/16	4-1/32

List 302M is only available in plug style.



Heavy Duty Spiral Flute Taps

List No. XL46



Description: Spiral flute taps are designed to tap "blind holes", improved chip lifting for faster tapping and increased threading accuracy.

Application: Heavy duty design cuts easily through steel alloys.

EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
XL46-6-32	3	2	11/16	2
XL46-8-32	3	3	3/4	2-1/8
XL46-10-24	3	3	7/8	2-3/8
XL46-10-32	3	3	7/8	2-3/8
XL46-12-24	3	3	15/16	2-3/8
XL46-1/4-20	3	3	1	2-1/2
XL46-1/4-28	3	3	1	2-1/2
XL46-5/16-18	3	3	1-1/8	2-23/32
XL46-5/16-24	3	3	1-1/8	2-23/32
XL46-3/8-16	3	3	1-1/4	2-15/16
XL46-3/8-24	3	3	1-1/4	2-15/16
XL46-7/16-14	3	3	1-7/16	3-5/32
XL46-7/16-20	3	3	1-7/16	3-5/32
XL46-1/2-13	3	3	1-21/32	3-3/8
XL46-1/2-20	3	3	1-21/32	3-3/8

Specify plug or bottoming when ordering.



Pulley Taps

List No. 3006

4 Flute / Ground Thread / Plug Style / HSS



Description: Originally designed to provide extra reach to tap the oil cups and set screw holes of pulley parts. The long shank permits tapping other long reach applications.

Application: Designed to provide extra reach to tap the oil cups and set screws holes of pulley parts, the long shank permits tapping other long reach applications.

EDP No./ Size 6" OAL	H Limits	No. of Flutes	Length of Thread	Dia. of Shank
3006-1/4-20	H3	4	1	.255
3006-5/16-18	H3	4	1-1/8	.318
3006-3/8-16	H3	4	1-1/4	.381
3006-7/16-14	H3	4	1-7/16	.444
3006-1/2-13	H3	4	1-21/32	.507
3006-5/8-11	H3	4	1-13/16	.633

CHAMPION

Nut Taps List No. 1308

Standard "H" Taps / 4 FLute / Plug Style / HSS

Description: These taps are characterized by long thread length, long chamfers and longer shanks. The shanks are smaller than the minor diameter of the thread for chip removal and clearance.

Application: For tapping deeper than the threaded portion, nut taps were originally designed for tapping nuts.



EDP No./ Size	H Limits	No. of Flutes	Length of Thread	Overall Length
1308-1/4-20	H3	4	1-5/8	5
1308-5/16-18	H3	4	1-13/16	5-1/2
1308-3/8-16	H3	4	2	6
1308-1/2-13	H3	4	2-1/2	7

CHAMPION

8 Thread High Speed Hand Taps List No. 3088

8 Thread Special / Ground Thread

Description: High speed steel special "8 thread" series taps all feature 8 threads per inch.

Application: Engineered specifically for liquid transmission equipment found extensively in the oil fields.



EDP No. / Size	H Limits	No. of Flutes	Length of Thread	Overall Length
3088-1-1/8	H5	4	2-9/16	5-7/16
3088-1-1/4	H5	4	2-9/16	5-3/4
3088-1-3/8	H5	4	3	6-1/16
3088-1-1/2	H5	4	3	6-3/8
3088-1-5/8	H6	6	3-3/16	6-11/16
3088-1-3/4	H6	6	3-3/16	7
3088-1-7/8	H6	6	3-9/16	7-5/16
3088-2	H6	6	3-9/16	7-5/8
3088-2-1/8	H6	6	3-9/16	8
3088-2-1/4	H6	6	3-9/16	8-1/4
3088-2-3/8	H6	6	4	8-1/2
3088-2-1/2	H6	6	4	8-3/4
3088-2-5/8	H6	6	4	8-3/4
3088-2-3/4	H8	6	4	9-1/4
3088-2-7/8	H8	8	4	9-1/4
3088-3	H8	8	4-9/16	9-3/4
3088-3-1/4	H8	8	4-9/16	10
3088-3-1/2	H8	8	4-15/16	3-1/2
3088-3-3/4	H8	8	5-5/16	10-1/2
3088-4	H8	8	5-5/16	10-3/4



Specify taper, plug, bottoming or set when ordering.

CHAMPION

Taper Pipe Taps

List No. 324

NPT / Regular Hook / 3/4" taper/ft. / Ground Thread / HSS



Description: Designed to produce threads where mated parts are not required to withstand high fluid or gas pressures & where the use of a sealing compound or tape is acceptable to produce a leakproof thread.

Application: For tapping of pipe and pipe fittings.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
324-1/16-27	4	11/16	2-1/8	324-3/4-14	5	1-3/8	3-1/4
324-1/8-27	4	3/4	2-1/8	324-1-11-1/2	5	1-3/4	3-3/4
324-1/4-18	4	1-1/16	2-7/16	324-1-1/4-11-1/2	5	1-3/4	4
324-3/8-18	4	1-1/16	2-9/16	324-1-1/2-11-1/2	7	1-3/4	4-1/4
324-1/2-14	4	1-3/8	3-1/8	324-2-11-1/2	7	1-3/4	4-1/2

CHAMPION

High Hook Taper Pipe Taps

List No. 324H

NPT / High Hook / 3/4" taper/ft. / Ground Thread / HSS



Description: Designed for ductile materials which normally produce long continuous chips, such as aluminum, free machining stainless, mild steels and plastics.

Application: For tapping of pipe and pipe fittings.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
324H-1/16-27	4	11/16	2-1/8	324H-3/4-14	5	1-3/8	3-1/4
324H-1/8-27	4	3/4	2-1/8	324H-1-11-1/2	5	1-3/4	3-3/4
324H-1/4-18	4	1-1/16	2-7/16	324H-1-1/4-11-1/2	5	1-3/4	4
324H-3/8-18	4	1-1/16	2-9/16	324H-1-1/2-11-1/2	7	1-3/4	4-1/4
324H-1/2-14	4	1-3/8	3-1/8	324H-2-11-1/2	7	1-3/4	4-1/2

CHAMPION

Low Hook Taper Pipe Taps

List No. 324L

NPT / Low Hook / 3/4" taper/ft. /Ground Thread / HSS



Description: Designed for the tapping of pipe and pipe fittings in castings and similar materials that produce granular chips.

Application: For tapping of pipe and pipe fittings.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
324L-1/16-27	4	11/16	2-1/8	324L-3/4-14	5	1-3/8	3-1/4
324L-1/8-27	4	3/4	2-1/8	324L-1-11-1/2	5	1-3/4	3-3/4
324L-1/4-18	4	1-1/16	2-7/16	324L-1-1/4-11-1/2	5	1-3/4	4
324L-3/8-18	4	1-1/16	2-9/16	324L-1-1/2-11-1/2	7	1-3/4	4-1/4
324L-1/2-14	4	1-3/8	3-1/8	324L-2-11-1/2	7	1-3/4	4-1/2

CHAMPION

Interrupted Thread Taper Pipe Taps

List No. 324I

NPT / Ground Thread / HSS

Description: For threading a wide variety of materials, both ferrous and non ferrous, where chip disposal is a problem.

Application: For materials which are difficult to work in, such as stainless steel, titanium and bronzes.



The first few threads are full and the balance interrupted, to reduce drag while taper pipe threading. Easier for the lubricant to reach the cutting edges. Reduces the friction and tapping torque.

EDP No./ Size	No. of Flutes	Length of Thread	Overall Length	EDP No./ Size	No. of Flutes	Length of Thread	Overall Length
324I-1/8-27	5	3/4	2-1/8	324I-1-11-1/2	5	1-3/4	3-3/4
324I-1/4-18	5	1-1/16	2-7/16	324I-1-1/4-11-1/2	5	1-3/4	4
324I-3/8-18	5	1-1/16	2-9/16	324I-1-1/2-11-1/2	7	1-3/4	4-1/4
324I-1/2-14	5	1-3/8	3-1/8	324I-2-11-1/2	7	1-3/4	4-1/2
324I-3/4-14	5	1-3/8	3-1/4				

CHAMPION

Straight Pipe Taps

List No. 325

NPS / Ground Thread / HSS

Description: Identical with Taper style but have a straight thread.

Application: For tapping holes or couplings. For low pressure work to assemble with taper threaded pipe or fittings to secure a tight joint when a sealer is used.



EDP No. / Size	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
325-1/8-27	4	3/4	2-1/8	325-1/2-14	4	1-3/8	3-1/8
325-1/4-18	4	1-1/16	2-7/16	325-3/4-14	5	1-3/8	3-1/4
325-3/8-18	4	1-1/16	2-9/16	325-1-11-1/2	5	1-3/4	3-3/4

CHAMPION

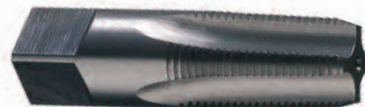
Carbon Steel Taper Pipe Taps

List No. 304

NPT / 3/4" taper/ft. / Carbon Steel

Description: Nominal size is that of the pipe fitting to be tapped.

Application: Rethreading, cleaning up damaged and rusty threads.



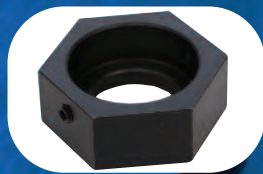
Diameter of tap increases from the entering end of the thread portion at the rate of 3/4" per foot; the angle formed by the sides of the thread is 60°.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length	EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
304-1/8-27	4	3/4	2-1/8	304-1-11-1/2	5	1-3/4	3-3/4
304-1/4-18	4	1-1/16	2-7/16	304-1-1/4-11-1/2	5	1-3/4	4
304-3/8-18	4	1-1/16	2-9/16	304-1-1/2-11-1/2	6	1-3/4	4-1/4
304-1/2-14	4	1-3/8	3-1/8	304-2-11-1/2	6	1-3/4	4-1/2
304-3/4-14	5	1-3/8	3-1/4				



Hex Converter for Round Dies

List No. 3305



Description: Hexagon adaptors for round dies permit the use of round adjustable dies with a wrench when the use of a die stock is impractical.

Application: Enables round dies to be held securely in an open end wrench or in a vise.

EDP No./ Size	O.D.	Size Across Flats
3305-13/16	13/16	1
3305-1	1	1-1/4
3305-1-1/2	1-1/2	2
3305-2	2	2-1/2



"T" Handle Tap Wrenches

List No. 3002 / 2002



Description: For use with taps or reamers with squared shanks in hand operations.

"T" Handle Tap Wrenches

List No. 3002 "T" Handle

EDP No./ Size	Range
3002-1	1/16-1/4
3002-2	7/32-1/2

List No. 3002 "T" Handle Ratchet Style

EDP No./ Size	Range
3002-3	1/16-1/4
3002-4	7/32-1/2

List No. 2002 "T" Handle Contractor Series

EDP No./ Size	Size Range
2002-1	0-1/4
2002-2	1/4-1/2

Note: When starting a tap by hand, care should be taken to assure that the tap and the drilled hole are correctly aligned or failure of the tap or crossed threads will result.



CHAMPION

Bar Handle Tap Wrenches List No. 3001

Description: For use with taps or reamers with squared shanks in hand operations.



EDP No./ Size	Length	Tap Range
3001-0	7-1/2	1/16-1/4
3001-15	11-1/2	5/32-1/2
3001-13	15-1/2	5/32-3/4
3001-7	19-1/2	1/4-1-1/8
3001-8	42-1/2	3/4-1-5/8
3001-22	56-1/2	1-2-1/2

CHAMPION

Round Die Stocks List No. 3291

Description: Die stock for use with round dies.



EDP No./ Size	Overall Length
3291x13/16	6-1/4"
3291x1	9"
3291x1-1/2	14"
3291x2	23"

CHAMPION

Hex Die Stocks List No. 3292

Description: Hex die stocks for use with CS30, CS30M dies.



EDP No./ Size	Overall Length
3292x1	9-1/2"
3292x1-7/16	13"

CHAMPION

Hexagon Rethreading Dies

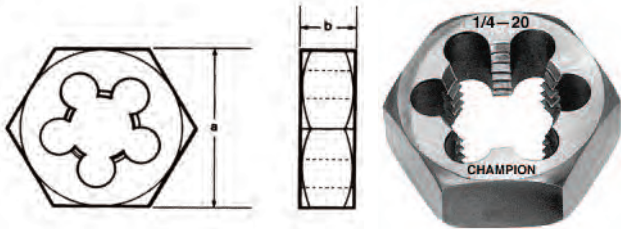
List No. 330 / List No. 330LH

Carbon Steel



Description: Use with any open end, box or adjustable wrench. Chamfered on both sides, double the life of the single chamfer style. Often referred to as thread chasers.

Application: For dressing over bruised or rusty threads.



EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
330-6-32	19/32	1/4
330-8-32	19/32	1/4
330-10-24	19/32	1/4
330-10-32	19/32	1/4
330-12-24	19/32	1/4
330-1/4-20	19/32	1/4
330-1/4-28	19/32	1/4
330-5/16-18	11/16	5/16
330-5/16-24	11/16	5/16
330-3/8-16	25/32	3/8
330-3/8-24	25/32	3/8
330-7/16-14	7/8	7/16
330-7/16-20	7/8	7/16
330-1/2-13	1-1/16	1/2
330-1/2-20	1-1/16	1/2
330-9/16-12	1-1/16	1/2
330-9/16-18	1-1/16	1/2
330-5/8-11	1-1/4	5/8
330-5/8-18	1-1/4	5/8
330-11/16-11	1-7/16	3/4
330-11/16-16	1-7/16	3/4

EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
330-3/4-10	1-7/16	3/4
330-3/4-16	1-7/16	3/4
330-7/8-9	1-5/8	7/8
330-7/8-14	1-5/8	7/8
330-1-8	1-13/16	1
330-1-12	1-13/16	1
330-1-14	1-13/16	1
330-1-1/8-7	2	1
330-1-1/8-12	2	1
330-1-1/4-7	2-3/16	1
330-1-1/4-12	2-3/16	1
330-1-3/8-6	2-3/8	1
330-1-3/8-12	2-3/8	1
330-1-1/2-6	2-9/16	1
330-1-1/2-12	2-9/16	1
330-1-3/4-5	3	1
330-1-3/4-12	3	1
330-2-4-1/2	3-7/16	1-1/4
330-2-12	3-7/16	1-1/4
330-2-1/4-4-1/2	3-3/4	1-1/4
330-2-1/4-12	3-3/4	1-1/4
330-2-1/2-4	4-1/4	1-7/16
330-2-1/2-12	4-1/4	1-7/16
330-1/8NPT	1-1/16	3/8
330-1/4NPT	1-1/4	5/8
330-3/8NPT	1-7/16	5/8
330-1/2NPT	1-5/8	3/4
330-3/4NPT	2	13/16
330-1 NPT	2-3/8	1

Specify List No. 330LH for left hand hex dies.
Available from 1/4-20 thru 1-14.



List No. CS107P includes NC, NF, and metric taps and dies.

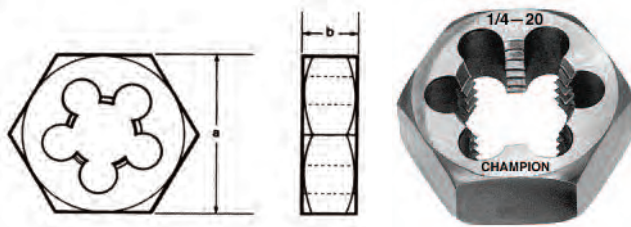
CHAMPION

Hexagon Rethreading Dies

List No. 330M

Metric / Carbon Steel

Description: Use with any open end, box or adjustable wrench. Chamfered on both sides, double the life of the single chamfer style. Often referred to as thread chasers.
Application: For dressing over bruised or rusty threads.



EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
330M-3.5x.6	0.710	1/4
330M-4x.7	0.710	1/4
330M-4.5x.75	0.710	1/4
330M-5x.8	0.710	1/4
330M-6x1	0.710	1/4
330M-7x1	0.820	5/16
330M-8x1	0.820	5/16

EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
330M-8x1.25	0.820	5/16
330M-10x1.5	0.920	7/16
330M-12x1.25	1.100	1/2
330M-12x1.75	1.100	1/2
330M-14x1.5	1.300	1/2
330M-14x2	1.300	5/8
330M-16x2	1.300	5/8
330M-18x1.5	1.480	11/16
330M-18x2.5	1.480	11/16
330M-20x1.5	1.480	5/8
330M-20x2.5	1.480	11/16
330M-22x2.5	1.670	13/16
330M-24x3	2.050	15/16
330M-27x3	2.220	1-1/16

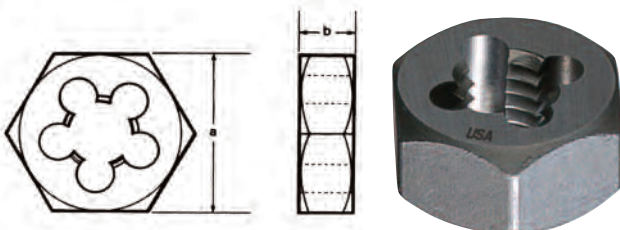
CHAMPION

Hexagon Rethreading Dies

List No. 3308

8 Thread Special / Carbon Steel

Description: Use with any open end, box or adjustable wrench. Chamfered on both sides, double the life of the single chamfer style. Often referred to as thread chasers.
Application: For dressing over bruised or rusty threads.



EDP No. / Size	No. of Flutes
3308-1-1/8	2-1/2
3308-1-1/4	2-1/2
3308-1-3/8	2-1/2
3308-1-1/2	2-1/2
3308-1-5/8	3
3308-1-3/4	3

EDP No./ Size	(A) Size Across Flats
3308-1-7/8	3
3308-2	3
3308-2-1/8	4
3308-2-1/4	4
3308-2-3/8	4
3308-2-1/2	4
3308-2-5/8	5
3308-2-3/4	5
3308-2-7/8	5
3308-3	5
3308-3-1/4	6
3308-3-1/2	6
3308-3-3/4	6
3308-4	6

CHAMPION

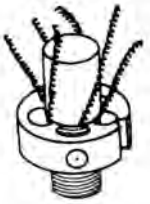
Screw Adjustable Round Dies

List No. 328
High Speed Steel



Description: To cut new threads by hand in a die stock.

Application: Can be adjusted for a tight or loose class of fit by the use of a set screw which can also be used to compensate for tool wear.



EDP No./ Size				
13/16" O.D.	1" O.D.	1-1/2" O.D.	2" O.D.	
328-6-32x13/16	328-6-32x1	-	-	
328-6-40x13/16	-	-	-	
328-8-32x13/16	328-8-32x1	-	-	
328-8-36-13/16	-	-	-	
328-10-24x13/16	328-10-24x1	-	-	
328-10-32x13/16	328-10-32x1	-	-	
328-12-24x13/16	328-12-24x1	-	-	
328-12-28x13/16	-	-	-	
328-1/4-20x13/16	328-1/4-20x1	328-1/4-20x1-1/2	-	
328-1/4-28x13/16	328-1/4-28x1	328-1/4-28x1-1/2	-	
328-5/16-18x13/16	328-5/16-18x1	328-5/16-18x1-1/2	-	
328-5/16-24x13/16	328-5/16-24x1	328-5/16-24x1-1/2	-	
-	328-3/8-16x1	328-3/8-16x1-1/2	-	
-	328-3/8-24x1	328-3/8-24x1-1/2	-	
-	328-7/16-14x1	328-7/16-14x1-1/2	-	
-	328-7/16-20x1	328-7/16-20x1-1/2	-	
-	-	328-1/2-13x1-1/2	-	
-	-	328-1/2-20x1-1/2	-	
-	-	328-9/16-12x1-1/2	-	
-	-	328-9/16-18x1-1/2	-	
-	-	328-5/8-11x1-1/2	328-5/8-11x2	
-	-	328-5/8-18x1-1/2	328-5/8-18x2	
-	-	-	328-3/4-10x2	
-	-	-	328-3/4-16x2	
-	-	-	328-7/8-9x2	
-	-	-	328-7/8-14x2	
-	-	-	328-1-8x2	
-	-	-	328-1-12x2	
-	-	-	328-1-14x2	

CHAMPION

Hexagon Rethreading Dies

List No. CS30

Carbon Steel

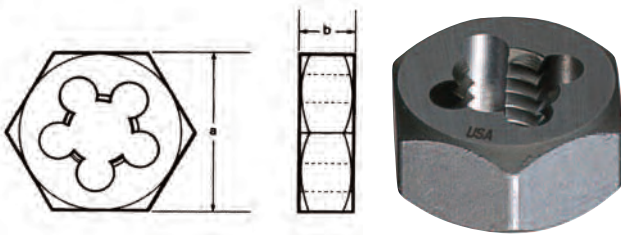
List No. CS30M

Metric Carbon Steel



Description: For rethreading worn or rusty threads.

Application: Ideal for maintenance in the shop or field.



EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
CS30-4-40	1	3/8
CS30-6-32	1	3/8
CS30-8-32	1	3/8
CS30-10-24	1	3/8
CS30-10-32	1	3/8
CS30-12-24	1	3/8
CS30-1/4-20	1	3/8
CS30-1/4-28	1	3/8
CS30-5/16-18	1	3/8
CS30-5/16-24	1	3/8
CS30-3/8-16	1	3/8
CS30-3/8-24	1	3/8
CS30-7/16-14	1	3/8
CS30-7/16-20	1	3/8
CS30-1/2-13	1	3/8
CS30-1/2-20	1	3/8
CS30-9/16-12	1-7/16	5/8
CS30-9/16-18	1-7/16	5/8
CS30-5/8-11	1-7/16	5/8
CS30-5/8-18	1-7/16	5/8
CS30-3/4-10	1-7/16	3/4
CS30-3/4-16	1-7/16	3/4
CS30-7/8-9	1-7/8	3/4
CS30-7/8-14	1-7/8	3/4
CS30-1-8	1-7/8	3/4
CS30-1-12	1-7/8	3/4
CS30-1-14	1-7/8	3/4

EDP No./ Size	(A) Size Across Flats	(B) Die Thickness
CS30M-3X.5	1	3/8
CS30M-3X.6	1	3/8
CS30M-4X.7	1	3/8
CS30M-4X.75	1	3/8
CS30M-5X.8	1	3/8
CS30M-5X.9	1	3/8
CS30M-6X1	1	3/8
CS30M-7X1	1	3/8
CS30M-8X1.25	1	3/8
CS30M-9X1	1	3/8
CS30M-9X1.25	1	3/8
CS30M-10X1.25	1	3/8
CS30M-10X1.5	1	3/8
CS30M-11X1.5	1	3/8
CS30M-12X1.5	1	3/8
CS30M-12X1.75	1	3/8
CS30M-14X1.25	1-7/16	5/8
CS30M-14X2	1-7/16	3/4
CS30M-16X1.5	1-7/16	3/4
CS30M-16X2	1-7/8	3/4
CS30M-18X1.5	1-7/8	3/4
CS30M-18X2.5	1-7/8	3/4
CS30M-1/8-28-BSP	1	3/8



Solid Carbide End Mills

List No. 106

Two Flute / Single End / Right Hand Helix / Center Cutting



Description: Can be used to plunge cut. Recommended for slotting applications.

Application: Milling cast irons, non-ferrous light metals and plastics.

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length	EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
106-1/32	1/8	3/32	1-1/2	106-3/8	3/8	7/8	2-1/2
106-1/16	1/8	3/16	1-1/2	106-7/16	7/16	1	2-3/4
106-3/32	1/8	3/8	1-1/2	106-1/2	1/2	1	3
106-1/8	1/8	1/2	1-1/2	106-9/16	9/16	1-1/4	3-1/2
106-5/32	3/16	9/16	2	106-5/8	5/8	1-1/4	3-1/2
106-3/16	3/16	5/8	2	106-3/4	3/4	1-1/2	4
106-1/4	1/4	3/4	2-1/2	106-7/8	7/8	1-1/2	4
106-5/16	5/16	13/16	2-1/2	106-1	1	1-1/2	4



Solid Carbide End Mills

List No. 107

Two Flute / Double End / Right Hand Helix / Center Cutting



Description: Recommended for slotting applications and plunge cutting.

Application: Plunge cutting, slotting, pocketing and profiling of cast irons, aluminum, copper, magnesium, plastics, composites & brass.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
107-1/8	1/8	1/4	1-1/2	107-9/32	5/16	1/2	2-1/2
107-5/32	3/16	5/16	2	107-5/16	5/16	1/2	2-1/2
107-3/16	3/16	3/8	2	107-3/8	3/8	9/16	2-1/2
107-7/32	1/4	1/2	2-1/2	107-7/16	7/16	9/16	2-3/4
107-1/4	1/4	1/2	2-1/2	107-1/2	1/2	5/8	3



Corner Rounding End Mills

List No. 625

Single End / HSS



Description: Formed radius cutters are designed to create an end radius in ferrous and non-ferrous materials.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
625-1/16x3/8	3/8	7/16	2-1/2	625-5/16x7/8	7/8	1-1/8	3-1/2
625-3/32x3/8	3/8	1/2	2-1/2	625-3/8x3/4	3/4	1-1/4	3-1/2
625-1/8x1/2	1/2	5/8	3	625-3/8x7/8	7/8	1-1/4	3-3/4
625-5/32x1/2	1/2	3/4	3	625-7/16x3/4	3/4	1-3/8	3-3/4
625-3/16x3/4	3/4	7/8	3-1/8	625-7/16x1	1	1-3/8	4
625-1/4x3/4	3/4	1	3-1/4	625-1/2x3/4	3/4	1-1/2	3-7/8
625-5/16x3/4	3/4	1-1/8	3-1/4	625-1/2x1	1	1-1/2	4-1/8

CHAMPION

High Speed End Mills

List No. 600

Single End / 2 Flute / Center Cutting / HSS / Right Hand Helix



Description: Center cutting ability and wide deep flutes. For milling of keyways, slots and pockets.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, carbon steel, alloy steel, tool steel & cast iron.

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
600-1/8X3/8	3/8	3/8	2-5/16
600-3/16X3/8	3/8	7/16	2-5/16
600-1/4X3/8	3/8	1/2	2-5/16
600-5/16X3/8	3/8	9/16	2-5/16
600-3/8X3/8	3/8	9/16	2-5/16
600-7/16X3/8	3/8	13/16	2-1/2
600-1/2X3/8	3/8	13/16	2-1/2
600-1/2X1/2	1/2	1	3
600-9/16X1/2	1/2	1-1/8	3-1/8
600-5/8X1/2	1/2	1-1/8	3-1/8
600-5/8X5/8	5/8	1-5/16	3-7/16
600-11/16X1/2	1/2	1-5/16	3-5/16
600-11/16X5/8	5/8	1-5/16	3-7/16
600-3/4X1/2	1/2	1-5/16	3-5/16
600-3/4X5/8	5/8	1-5/16	3-7/16
600-3/4X3/4	3/4	1-5/16	3-9/16

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
600-13/16X5/8	5/8	1-1/2	3-5/8
600-7/8X5/8	5/8	1-1/2	3-5/8
600-7/8X7/8	7/8	1-1/2	3-3/4
600-1X5/8	5/8	1-1/2	3-5/8
600-1X3/4	3/4	1-1/2	3-3/4
600-1X7/8	7/8	1-1/2	3-3/4
600-1X1	1	1-5/8	4-1/8
600-1-1/8X7/8	7/8	1-5/8	3-7/8
600-1-1/8X1	1	1-5/8	4-1/8
600-1-1/4X7/8	7/8	1-5/8	3-7/8
600-1-1/4X1	1	1-5/8	4-1/8
600-1-1/4X1-1/4	1-1/4	1-5/8	4-1/8
600-1-3/8X1	1	1-5/8	4-1/8
600-1-1/2X1	1	1-5/8	4-1/8
600-1-1/2X1-1/4	1-1/4	1-5/8	4-1/8
600-1-3/4X1-1/4	1-1/4	1-5/8	4-1/8
600-2X1-1/4	1-1/4	1-5/8	4-1/8

CHAMPION

TiN Coated End Mills

List No. 600T

Single End / 2 Flute / Center Cutting / HSS



Description: TiN coating increases surface hardness and lubricity which protects the cutting edge, reducing abrasive wear and friction.

Application: For production profiling and milling of keyways, slots and pockets

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
600T-1/8X3/8	3/8	3/8	2-1/16
600T-3/16X3/8	3/8	7/16	2-5/16
600T-1/4X3/8	3/8	1/2	2-5/16
600T-5/16X3/8	3/8	9/16	2-5/16
600T-3/8X3/8	3/8	9/16	2-5/16
600T-7/16X3/8	3/8	13/16	2-1/2
600T-1/2X3/8	3/8	13/16	2-1/2
600T-1/2X1/2	1/2	1	3
600T-9/16X1/2	1/2	1-1/8	3-1/8
600T-5/8X1/2	1/2	1-1/8	3-1/8
600T-5/8X5/8	5/8	1-5/16	3-7/16
600T-1/16X1/2	1/2	1-5/16	3-5/16
600T-11/16X5/8	5/8	1-5/16	3-7/16
600T-3/4X1/2	1/2	1-5/16	3-5/16
600T-3/4X5/8	5/8	1-5/16	3-7/16
600T-3/4X3/4	3/4	1-5/16	3-9/16
600T-13/16X5/8	5/8	1-1/2	3-5/8
600T-7/8X5/8	5/8	1-1/2	3-5/8

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
600T-7/8X7/8	7/8	1-1/2	3-3/4
600T-1X5/8	5/8	1-1/2	3-5/8
600T-1X3/4	3/4	1-1/2	3-3/4
600T-1X7/8	7/8	1-1/2	3-3/4
600T-1X1	1	1-5/8	4-1/8
600T-1-1/8X7/8	7/8	1-5/8	3-7/8
600T-1-1/8X1	1	1-5/8	4-1/8
600T-1-1/4X7/8	7/8	1-5/8	3-7/8
600T-1-1/4X1	1	1-5/8	4-1/8
600T-1-1/4X1-1/4	1-1/4	1-5/8	4-1/8
600T-1-3/8X1	1	1-5/8	4-1/8
600T-1-1/2X1	1	1-5/8	4-1/8
600T-1-1/2X1-1/4	1-1/4	1-5/8	4-1/8
600T-1-3/4X1-1/4	1-1/4	1-5/8	4-1/8
600T-2X1-1/4	1-1/4	1-5/8	4-1/8

CHAMPION
CUTTING TOOL CORP.



Cobalt End Mills

List No. 600C0

Single End / 2 Flute / Center Cutting / M42 Cobalt



Description: For the milling of keyways, slots and pockets in high tensile martensitic stainless steels and tough materials where the high "red hardness" and wear resistance of cobalt steel is needed to provide effective operation and long life.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, austenitic alloys, nickel alloys, stainless steel and titanium alloys.

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length	EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
600C0-1/8X3/8	3/8	3/8	2-5/16	600C0-1/2X1/2	1/2	1	3
600C0-3/16X3/8	3/8	7/16	2-5/16	600C0-5/8X5/8	5/8	1-5/16	3-7/16
600C0-1/4X3/8	3/8	1/2	2-5/16	600C0-3/4X3/4	3/4	1-5/16	3-9/16
600C0-5/16X3/8	3/8	9/16	2-5/16	600C0-1X3/4	3/4	1-1/2	3-3/4
600C0-3/8X3/8	3/8	9/16	2-5/16	600C0-1-1/4X1	1	1-5/8	4-1/8



TiN Coated End Mills

List No. XL600

Single End / 2 Flute / Center Cutting / M42 Cobalt



Description: For milling of tough, high strength alloys, these tools are made from a high cobalt steel to resist the stress and heat generated at the cutting edge.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, austenitic alloys, nickel alloys, stainless steel and titanium alloys.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
XL600-1/8X3/8	3/8	3/8	2-5/16	XL600-1/2X1/2	1/2	1	3
XL600-3/16X3/8	3/8	7/16	2-5/16	XL600-5/8X5/8	5/8	1-5/16	3-7/16
XL600-1/4X3/8	3/8	1/2	2-5/16	XL600-3/4X3/4	3/4	1-5/16	3-9/16
XL600-5/16X3/8	3/8	9/16	2-5/16	XL600-1X3/4	3/4	1-1/2	3-3/4
XL600-3/8X3/8	3/8	9/16	2-5/16	XL600-1-1/4X1	1	1-5/8	4-1/8



High Speed End Mills

List No. 602

Double End / 2 Flute / Center Cutting / HSS / Right Hand Helix



Description: Economical general purpose milling of keyways, slots and pockets. Center cutting and wide deep flutes.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, carbon steel, alloy steel, tool steel & cast iron.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
602-1/8X3/8	3/8	3/8	3-1/16	602-7/16X1/2	1/2	13/16	3-3/4
602-5/32X3/8	3/8	7/16	3-1/8	602-15/32X1/2	1/2	13/16	3-3/4
602-3/16X3/8	3/8	7/16	3-1/8	602-1/2X1/2	1/2	13/16	3-3/4
602-7/32X3/8	3/8	1/2	3-1/8	602-9/16X5/8	5/8	1-1/8	4-1/2
602-1/4X3/8	3/8	1/2	3-1/8	602-5/8X5/8	5/8	1-1/8	4-1/2
602-9/32X3/8	3/8	9/16	3-1/8	602-11/16X3/4	3/4	1-5/16	5
602-5/16X3/8	3/8	9/16	3-1/8	602-3/4X3/4	3/4	1-5/16	5
602-11/32X3/8	3/8	9/16	3-1/8	602-7/8X7/8	7/8	1-9/16	5-1/2
602-3/8X3/8	3/8	9/16	3-1/8	602-1X1	1	1-5/8	5-7/8
602-13/32X1/2	1/2	13/16	3-3/4				

CHAMPION

Cobalt End Mills List No. 602C0

Double End / 2 Flute / Center Cutting / M42 Cobalt

Description: For milling keyways, slots and pockets in high tensile martensitic stainless steels and tough materials where the high "red hardness" and wear resistance of cobalt steel is needed to provide effective operation and long tool life.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, austenitic alloys, nickel alloys, stainless steel and titanium alloys.



EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
602C0-1/8	3/8	3/8	3-1/16
602C0-3/16	3/8	7/16	3-1/8
602C0-1/4	3/8	1/2	3-1/8
602C0-5/16	3/8	9/16	3-1/8
602C0-3/8	3/8	9/16	3-1/8
602C0-7/16	1/2	13/16	3-3/4

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
602C0-1/2	1/2	13/16	3-3/4
602C0-5/8	5/8	1-1/8	4-1/2
602C0-3/4	3/4	1-5/16	5
602C0-7/8	7/8	1-9/16	5-1/2
602C0-1	1	1-5/8	5-7/8

CHAMPION

High Speed End Mills List No. 604

Ball Nose / Single End / 2 Flute / Center Cutting / HSS

Description: Engineered for milling radius bottom slots and fillets, rounding the bottom of holes and all general purpose radius milling. Designed to plunge cut.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, austenitic alloys, nickel alloys, stainless steel and titanium alloys.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
604-1/8x3/8	3/8	3/8	2-1/16
604-3/16x3/8	3/8	1/2	2-3/8
604-1/4x3/8	3/8	5/8	2-7/16
604-5/16x3/8	3/8	3/4	2-1/2
604-3/8x3/8	3/8	3/4	2-1/2
604-7/16x1/2	1/2	1	3
604-1/2x1/2	1/2	1	3
604-9/16x1/2	1/2	1-1/8	3-1/8
604-5/8x1/2	1/2	1-1/8	3-1/8

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
604-5/8x5/8	5/8	1-3/8	3-1/2
604-3/4x1/2	1/2	1-5/16	3-5/16
604-3/4x3/4	3/4	1-5/8	3-7/8
604-7/8x7/8	7/8	2	4-1/4
604-1x1	1	2-1/4	4-3/4
604-1-1/8x1	1	2-1/4	4-3/4
604-1-1/4x1-1/4	1-1/4	2-1/2	5
604-1-1/2x1-1/4	1-1/4	2-1/2	5

CHAMPION

High Speed End Mills List No. 605

Ball Nose / Double End / 2 Flute / Center Cutting / HSS / Right Hand Helix

Description: For milling radius bottom slots and fillets, rounding the bottom of holes and all general purpose radius milling. Designed to plunge cut.

Application: Plunge cutting, profile, slotting, contouring & pocketing of aluminum, austenitic alloys, nickel alloys, stainless steel & titanium alloys.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
605-1/8x3/8	3/8	3/8	3-1/16
605-3/16x3/8	3/8	7/16	3-1/8
605-1/4x3/8	3/8	1/2	3-1/8
605-5/16x3/8	3/8	9/16	3-1/8
605-3/8x3/8	3/8	9/16	3-1/8

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
605-7/16x1/2	1/2	13/16	3-3/4
605-1/2x1/2	1/2	13/16	3-3/4
605-5/8x5/8	5/8	1-1/8	4-1/2
605-3/4x3/4	3/4	1-5/16	5
605-1x1	1	1-5/8	5-7/8

CHAMPION

High Speed End Mills

List No. 601

Single End / Multi Flute / HSS / Center Cutting / Right Hand Helix



Description: Non-Center Cut for general purpose profiling and milling of slots and pockets where "plunge" cutting is not required. Manufactured to a (+) tolerance on diameter, they produce a finer finish on work that has previously been roughed out.

Application: Profile & slotting of copper alloys, cast irons, alloy steels & tool steel. Good for finishing in all materials.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
601-1/8X3/8	3/8	3/8	2-5/16	4	601-7/8X5/8	5/8	1-7/8	4	6
601-3/16X3/8	3/8	1/2	2-3/8	4	601-7/8X7/8	7/8	1-7/8	4-1/8	4
601-1/4X3/8	3/8	5/8	2-7/16	4	601-1X5/8	5/8	1-7/8	4	6
601-5/16X3/8	3/8	3/4	2-1/2	4	601-1X3/4	3/4	1-7/8	4-1/8	4
601-3/8X3/8	3/8	3/4	2-1/2	4	601-1X7/8	7/8	1-7/8	4-1/8	4
601-7/16X3/8	3/8	1	2-11/16	4	601-1X1	1	2	4-1/2	4
601-1/2X3/8	3/8	1	2-11/16	4	601-1-1/8X7/8	7/8	2	4-1/4	6
601-1/2x1/2	1/2	1-1/4	3-1/4	4	601-1-1/8X1	1	2	4-1/2	6
601-9/16X1/2	1/2	1-3/8	3-3/8	4	601-1-1/4X7/8	7/8	2	4-1/4	6
601-5/8X1/2	1/2	1-3/8	3-3/8	4	601-1-1/4X1	1	2	4-1/2	6
601 5/8x5/8	5/8	1-5/8	3-3/4	4	601-1-1/4x1-1/4	1-1/4	2	4-1/2	6
601-11/16X1/2	1/2	1-5/8	3-5/8	4	601-1-3/8X1	1	2	4-1/2	6
601-11/16x5/8	5/8	1-5/8	3-3/4	4	601-1-1/2X1	1	2	4-1/2	6
601-3/4X1/2	1/2	1-5/8	4-5/8	4	601-1-1/2X1-1/4	1-1/4	2	4-1/2	6
601-3/4x5/8	5/8	1-5/8	3-3/4	4	601-1-3/4X1-1/4	1-1/4	2	4-1/2	6
601-3/4x3/4	3/4	1-5/8	3-7/8	4	601-2X1-1/4	1-1/4	2	4-1/2	8
601-13/16X5/8	5/8	1-7/8	4	6					

CHAMPION

TiN Coated End Mills

List No. 601T

Single End / Multi Flute / HSS



Description: For high production profiling and milling of keyways, slots and pockets. Titanium nitride offers extreme hardness and lubricity which protects the cutting edge, reducing abrasive wear and friction. TiN coating offers increased surface hardness, increased durability and high lubricity

Application: Profiling and slotting of carbon steel, cast iron, die steels, stainless steel, Inconel, hardened steel and titanium. Good for finishing in many materials.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
601T-1/8X3/8	3/8	3/8	2-1/16	4	601T-7/8X5/8	5/8	1-7/8	4	6
601T-3/16X3/8	3/8	1/2	2-3/8	4	601T-7/8X7/8	7/8	1-7/8	4-1/8	4
601T-1/4X3/8	3/8	5/8	2-7/16	4	601T-1X5/8	5/8	1-7/8	4	6
601T-5/16X3/8	3/8	3/4	2-1/2	4	601T-1X3/4	3/4	1-7/8	4-1/8	4
601T-3/8X3/8	3/8	3/4	2-1/2	4	601T-1X7/8	7/8	1-7/8	4-1/8	4
601T-7/16X3/8	3/8	1	2-11/16	4	601T-1X1	1	2	4-1/2	4
601T-1/2X3/8	3/8	1	2-11/16	4	601T-1-1/8X7/8	7/8	2	4-1/4	6
601T-1/2x1/2	1/2	1-1/4	3-1/4	4	601T-1-1/8X1	1	2	4-1/2	6
601T-9/16X1/2	1/2	1-3/8	3-3/8	4	601T-1-1/4X7/8	7/8	2	4-1/4	6
601T-5/8X1/2	1/2	1-3/8	3-3/8	4	601T-1-1/4X1	1	2	4-1/2	6
601T-5/8x5/8	5/8	1-5/8	3-3/4	4	601T-1-1/4x1-1/4	1-1/4	2	4-1/2	6
601T-11/16X1/2	1/2	1-5/8	3-5/8	4	601T-1-3/8X1	1	2	4-1/2	6
601T-11/16x5/8	5/8	1-5/8	3-3/4	4	601T-1-1/2X1	1	2	4-1/2	6
601T-3/4X1/2	1/2	1-5/8	4-5/8	4	601T-1-1/2X1-1/4	1-1/4	2	4-1/2	6
601T-3/4x5/8	5/8	1-5/8	3-3/4	4	601T-1-3/4X1-1/4	1-1/4	2	4-1/2	6
601T-3/4x3/4	3/4	1-5/8	3-7/8	4	601T-2X1-1/4	1-1/4	2	4-1/2	8
601T-13/16X5/8	5/8	1-7/8	4	6					

CHAMPION

Cobalt End Mills

List No. 601CO

Single End / Multi Flute / Center Cutting / M42 Cobalt



Description: For the milling of keyways, slots and pockets in high tensile martensitic stainless steels and tough materials where the high "red hardness" and wear resistance of cobalt steel is needed to provide effective operation and long tool life.

Application: Profiling and slotting of carbon steel, cast iron, die steels, stainless steel, Inconel, hardened steel and titanium. Good for finishing in many materials.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
601CO-1/8X3/8	3/8	3/8	2-5/16	4
601CO-3/16X3/8	3/8	1/2	2-3/8	4
601CO-1/4X3/8	3/8	5/8	2-7/16	4
601CO-5/16X3/8	3/8	3/4	2-1/2	4
601CO-3/8X3/8	3/8	3/4	2-1/2	4
601CO-1/2X1/2	1/2	1-1/4	3-1/4	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
601CO-5/8X5/8	5/8	1-5/8	3-3/4	4
601CO-3/4X3/4	3/4	1-5/8	3-7/8	4
601CO-1X3/4	3/4	1-7/8	4-1/8	4
601CO-1-1/4X1	1	2	4-1/2	6
601CO-1-1/2X1-1/4	1-1/4	2	4-1/2	6



TiN Coated Cobalt End Mills

List No. XL606

Single End / Multi Flute / Center Cutting / M42 Cobalt



Description: For milling of tough, high strength alloys. Made from M42 cobalt to resist the stress and heat generated in the milling of high tensile alloys.

Application: Profiling and slotting of carbon steel, cast iron, die steels, stainless steel, Inconel, hardened steel and titanium. Good for finishing in many materials.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
XL606-1/8X3/8	3/8	3/8	2-5/16	4
XL606-3/16X3/8	3/8	1/2	2-3/8	4
XL606-1/4X3/8	3/8	5/8	2-7/16	4
XL606-5/16X3/8	3/8	3/4	2-1/2	4
XL606-3/8X3/8	3/8	3/4	2-1/2	4
XL606-1/2X1/2	1/2	1-1/4	3-1/4	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
XL606-5/8X5/8	5/8	1-5/8	3-3/4	4
XL606-3/4X3/4	3/4	1-5/8	3-7/8	4
XL606-1X3/4	3/4	1-7/8	4-1/8	4
XL606-1-1/4X1	1	2	4-1/2	6
XL606-1-1/2X1-1/4	1-1/4	2	4-1/2	6

CHAMPION

High Speed End Mills

List No. 606

Single End / 4 Flute / Center Cutting / HSS / Right Hand Helix



Description: For general purpose milling of slots and pockets where plunge cutting and a fine surface finish is required.

Application: Plunge cutting, profile & slotting of copper alloys, cast irons, alloy steels & tool steel.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
606-1/8x3/8	3/8	3/8	2-5/16	4
606-3/16x3/8	3/8	1/2	2-3/8	4
606-1/4x3/8	3/8	5/8	2-7/16	4
606-5/16x3/8	3/8	3/4	2-1/2	4
606-3/8x3/8	3/8	3/4	2-1/2	4
606-1/2x1/2	1/2	1-1/4	3-1/4	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
606-5/8x5/8	5/8	1-5/8	3-3/4	4
606-3/4x3/4	3/4	1-5/8	3-7/8	4
606-1x1	1	2	4-1/2	4
606-1-1/4x1-1/4	1-1/4	2	4-1/2	4
606-1-1/2x1-1/4	1-1/4	2	4-1/2	4



High Speed End Mills List No. 603

Double End / 4 Flute / HSS

Description: For economical profiling and milling of slots and pockets where plunge cutting is not required. Multi flute mills produce a finer surface finish on work that has previously been roughed out.

Application: Profiling and slotting of copper alloys, cast irons, alloy steels and tool steel.



EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length	EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
603-1/8x3/8	3/8	3/8	3-1/16	603-7/16x1/2	1/2	1	4-1/8
603-5/32x3/8	3/8	7/16	3-1/8	603-15/32x1/2	1/2	1	4-1/8
603-3/16x3/8	3/8	1/2	3-1/4	603-1/2x1/2	1/2	1	4-1/8
603-7/32x3/8	3/8	9/16	3-1/4	603-9/16x5/8	5/8	1-3/8	5
603-1/4x3/8	3/8	5/8	3-3/8	603-5/8x5/8	5/8	1-3/8	5
603-9/32x3/8	3/8	11/16	3-3/8	603-11/16x3/4	3/4	1-5/8	5-5/8
603-5/16x3/8	3/8	3/4	3-1/2	603-3/4x3/4	3/4	1-5/8	5-5/8
603-11/32x3/8	3/8	3/4	3-1/2	603-13/16x7/8	7/8	1-7/8	6-1/8
603-3/8x3/8	3/8	3/4	3-1/2	603-7/8x7/8	7/8	1-7/8	6-1/8
603-13/32x1/2	1/2	1	4-1/8	603-1x1	1	1-7/8	6-3/8



High Speed End Mills List No. 607

Double End / 4 Flute / Center Cutting / HSS

Description: Designed for the general purpose milling of slots and pockets where plunge cutting and a fine surface finish is required.

Application: Profiling and slotting of copper alloys, cast irons, alloy steels and tool steel.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
607-1/8x3/8	3/8	3/8	3-1/16	607-1/2x1/2	1/2	1	4-1/8
607-3/16x3/8	3/8	1/2	3-1/4	607-5/8x5/8	5/8	1-3/8	5
607-1/4x3/8	3/8	5/8	3-3/8	607-3/4x3/4	3/4	1-5/8	5-5/8
607-5/16x3/8	3/8	3/4	3-1/2	607-7/8x7/8	7/8	1-7/8	6-1/8
607-3/8x3/8	3/8	3/4	3-1/2	607-1x1	1	1-7/8	6-3/8



Cobalt End Mills List No. 607C0

Double End / 4 Flute / Center Cutting / M42 Cobalt / Right Hand Helix

Description: For milling of keyways, slots and pockets in high tensile martensitic stainless steels and tough materials where the high "red hardness" and wear resistance of cobalt steel is needed to provide effective operation and long tool life.

Application: Plunge cutting, profiling and slotting of austenitic alloys, high tensile steels, nickel alloys, titanium alloys & stainless steel.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
607C0-1/8x3/8	3/8	3/8	3-1/16	607C0-1/2x1/2	1/2	1	4-1/8
607C0-3/16x3/8	3/8	1/2	3-1/4	607C0-5/8x5/8	5/8	1-3/8	5
607C0-1/4x3/8	3/8	5/8	3-3/8	607C0-3/4x3/4	3/4	1-5/8	5-5/8
607C0-5/16x3/8	3/8	3/4	3-1/2	607C0-7/8x7/8	7/8	1-7/8	6-1/8
607C0-3/8x3/8	3/8	3/4	3-1/2	607C0-1x1	1	1-7/8	6-3/8

CHAMPION

Cobalt Roughing End Mills

List No. 609

Single End / Multi Flute / M42 Cobalt

Description: Radius form cutting edges where each flute cuts shorter and thicker chips that can be carried away from the work easily. Rapid chip removal allows these mills to make deep cuts and remove large amounts of stock with less horsepower than conventional mills.

Application: Profiling and slotting of steel alloys, stainless steel and non-ferrous materials. Good for finishing in all materials.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
609-1/2x3	1/2	1-1/4	3-1/4	4
609-5/8x3	5/8	1-5/8	3-3/4	4
609-3/4x3	3/4	1-5/8	3-7/8	4
609-3/4x5	3/4	3	5-1/4	4
609-1x4	1	2	4-1/2	5
609-1x6	1	4	6-1/2	5
609-1-1/4x4	1-1/4	2	4-1/2	5

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
609-1-1/4x6	1-1/4	4	6-1/2	5
609-1-1/2x4	1-1/4	2	4-1/2	6
609-1-1/2x6	1-1/4	4	6-1/2	6
609-2x7	2	4	7-3/4	8
609-2x9	2	6	9-3/4	8
609-2x11	2	8	11-3/4	8

CHAMPION

Long End Mills

List No. 608

Single End / Multi Flute / HSS / Long Length / Right Hand Helix

Description: For deep milling and profiling applications. Have a length of cut two to three times that of a standard end mill.

Application: Profile & slotting of copper alloys, cast irons, alloy steels & tool steel. Good for finishing in all materials



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
608-1/4x3/8	3/8	1-1/4	3-1/16	4
608-5/16x3/8	3/8	1-3/8	3-1/8	4
608-3/8x3/8	3/8	1-1/2	3-1/4	4
608-7/16x1/2	1/2	1-3/4	3-3/4	4
608-1/2x1/2	1/2	2	4	4
608-5/8x5/8	5/8	2-1/2	4-5/8	4
608-3/4x3/4	3/4	3	5-1/4	4
608-7/8x7/8	7/8	3-1/2	5-3/4	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
608-1x1	1	4	6-1/2	4
608-1-1/8x1	1	4	6-1/2	6
608-1-1/4x1	1	4	6-1/2	6
608-1-1/4x1-1/4	1-1/4	4	6-1/2	6
608-1-1/2x1	1	4	6-1/2	6
608-1-1/2x1-1/4	1-1/4	4	6-1/2	6
608-1-3/4x1-1/4	1-1/4	4	6-1/2	6
608-2x1-1/4	1-1/4	4	6-1/2	8

CHAMPION

Extra Long End Mills

List No. 620

Single End / Multi Flute / HSS / Extra Long / Non-Center Cut

Description: For deep milling and face milling applications. Series 620 end mills have a length of cut three to four times that of a standard end mill.

Application: Profile & slotting of copper alloys, cast irons, alloy steels & tool steel. Good for finishing in all materials.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
620-1/4x3/8	3/8	1-3/4	3-9/16	4
620-5/16x3/8	3/8	2	3-3/4	4
620-3/8x3/8	3/8	2-1/2	4-1/4	4
620-1/2x1/2	1/2	3	5	4
620-5/8x5/8	5/8	4	6-1/8	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
620-3/4x3/4	3/4	4	6-1/4	4
620-7/8x7/8	7/8	5	7-1/4	4
620-1x1	1	6	8-1/2	4
620-1-1/4x1-1/4	1-1/4	6	8-1/2	6
620-1-1/2x1-1/4	1-1/4	8	10-1/2	6



Miniature End Mills

List No. 610

Stub Length / 2 Flute / Double End / HSS



Description: For milling of small diameter slots, pockets and engravings. The short flute resists breakage.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, carbon steel, alloy steel, tool steel and cast iron.

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length	EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
610-1/32x3/16	3/16	3/64	1-7/8	610-1/8x3/16	3/16	3/16	2
610-3/64x3/16	3/16	1/16	1-7/8	610-9/64x3/16	3/16	7/32	2
610-1/16x3/16	3/16	3/32	2	610-5/32x3/16	3/16	15/64	2
610-5/64x3/16	3/16	1/8	2	610-11/64x3/16	3/16	17/64	2
610-3/32x3/16	3/16	9/64	2	610-3/16x3/16	3/16	9/32	2
610-7/64x3/16	3/16	11/64	2				



Miniature End Mills

List No. 611 Regular Length / 2 Flute / Double End / HSS



Description: For milling of small diameter slots, pockets and engravings. The short flute resists breakage.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, carbon steel, alloy steel, tool steel and cast iron.

List No. 614 Regular Length / 4 Flute / Double End / HSS



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
611-1/32x3/16	3/16	3/32	2	611-1/8x3/16*	3/16	3/8	2-1/4
611-3/64x3/16	3/16	9/64	2	611-9/64x3/16	3/16	27/64	2-1/4
611-1/16x3/16*	3/16	3/16	2-1/4	611-5/32x3/16*	3/16	7/16	2-1/4
611-5/64x3/16	3/16	15/64	2-1/4	611-11/64x3/16	3/16	1/2	2-1/4
611-3/32x3/16*	3/16	9/32	2-1/4	611-3/16x3/16*	3/16	1/2	2-1/4
611-7/64x3/16	3/16	21/64	2-1/4				

* Please specify 614 (4 Flute) when ordering



Miniature End Mills

List No. 613

Stub Length / 4 Flute / Double End / HSS



Description: For milling of small diameter slots, pockets and engravings. The short flute resists breakage.

Application: Plunge cutting, slotting, pocketing and profiling of aluminum, carbon steel, alloy steel, tool steel and cast iron.

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length
613-1/16x3/16	3/16	3/32	2	613-5/32x3/16	3/16	15/64	2
613-1/8x3/16	3/16	3/16	2	613-3/16x3/16	3/16	9/32	2



XLV High Performance End Mills

List No. XLVC TiAlN Coated / 45° Chamfer

List No. XLVR TiAlN Coated / Corner Radius

Description: A true multi-purpose end mill ideal for slotting, sidemilling, semi-finishing and finishing. Four flute end mills which feature heavy duty core and end geometry for high volume material removal rates. Manufactured from sub-micron carbide, and TiAlN coated for superior performance.

Application: Chatter-free machining in a wide range of materials including cast irons, stainless steels, titanium alloys, carbon alloys and high temp alloys. Ideal for machining small and large parts in the aerospace, medical, and automotive industries. Excellent in slotting operations up to 1.25D axial depth and profiling up to .5D axial.



XLVC - Corner Chamfer

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length
XLVC-1/4	1/4	3/4	2-1/2
XLVC-3/8	3/8	7/8	2-1/2
XLVC-1/2	1/2	1-1/4	3
XLVC-5/8	5/8	1-1/4	3-1/2
XLVC-3/4	3/4	1-1/2	4
XLVC-1	1	1-1/2	4

All have 45° corner chamfer

XLVR - Corner Radius

EDP No./ Diameter	Shank Diameter	Flute Length	Overall Length	Radius
XLVR-1/4	1/4	3/4	2-1/2	0.015"
XLVR-3/8	3/8	7/8	2-1/2	0.015"
XLVR-1/2	1/2	1-1/4	3	0.030"
XLVR-5/8	5/8	1-1/4	3-1/2	0.030"
XLVR-3/4	3/4	1-1/2	4	0.030"
XLVR-1	1	1-1/2	4	0.030"

CHAMPION

Solid Carbide End Mills

List No. 166

4 Flute / Square End / Right Hand Helix / Center Cutting

Description: A general purpose end mill commonly used on more difficult to machine materials than the 2 flute design. Stiffer construction results in minimal deflection. The 4 flute design provides good wear resistance for excellent size control.



EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
166-1/16	1/8	3/16	1-1/2	4
166-3/32	1/8	3/8	1-1/2	4
166-1/8	1/8	1/2	1-1/2	4
166-5/32	3/16	9/16	2	4
166-3/16	3/16	5/8	2	4
166-1/4	1/4	3/4	2-1/2	4
166-5/16	5/16	13/16	2-1/2	4
166-3/8	3/8	7/8	2-1/2	4

EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
166-7/16	7/16	1	2-3/4	4
166-1/2	1/2	4	3	4
166-9/16	9/16	1-1/4	3-1/2	4
166-5/8	5/8	1-1/4	3-1/2	4
166-3/4	3/4	1-1/2	4	4
166-7/8	7/8	1-1/2	4	4
166-1	1	1-1/2	4	4

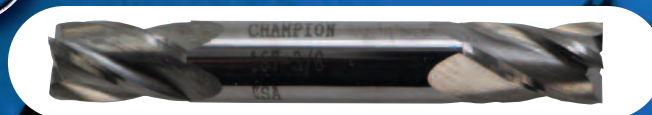
CHAMPION

Solid Carbide End Mills

List No. 167

4 Flute / Double End / Right Hand Helix / Center Cutting

Description: A general purpose end mill commonly used on more difficult to machine materials than the 2 flute design. Rigid construction results in minimal deflection. The 4 flute design provides good wear resistance for excellent size control.



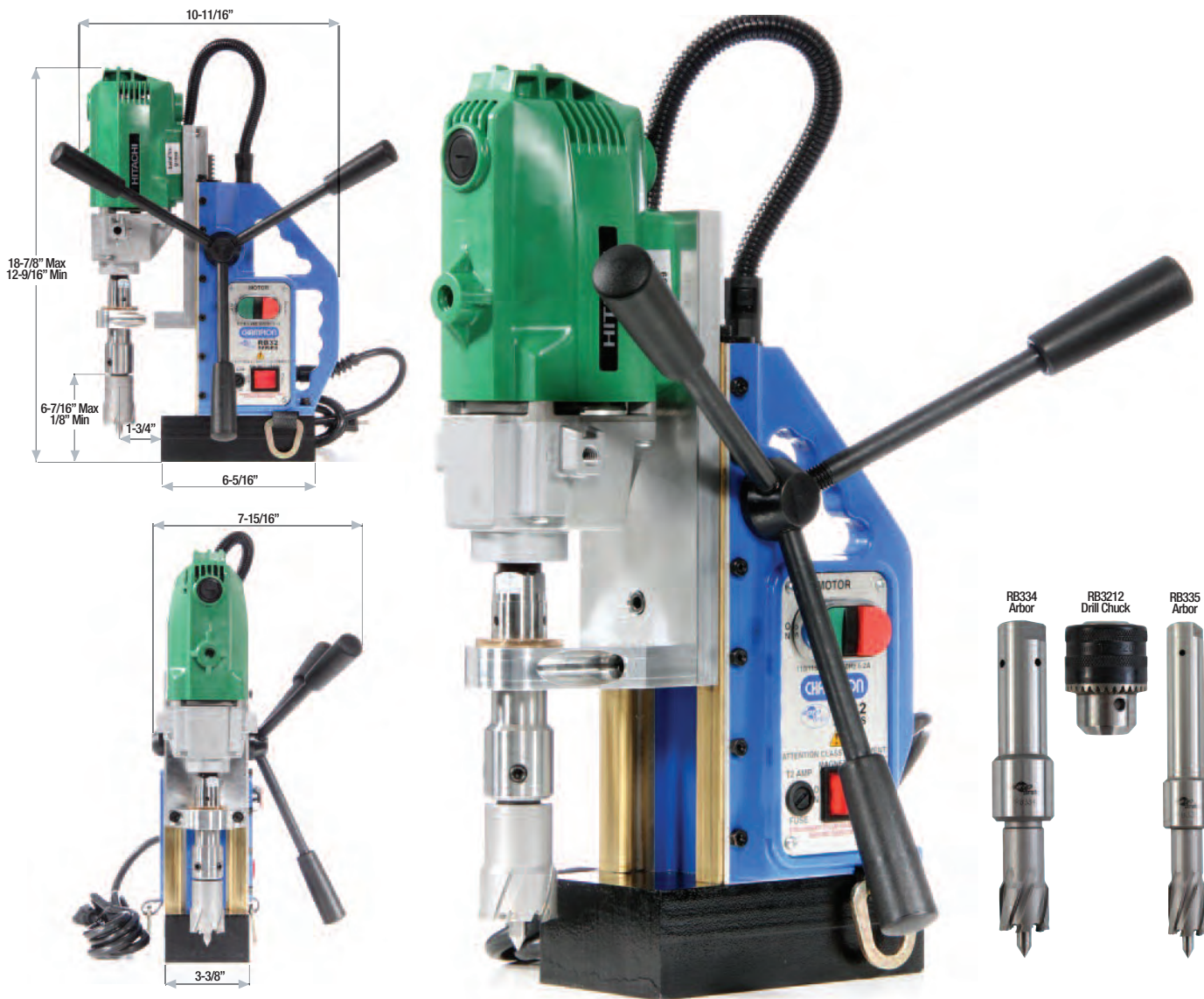
EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes	EDP No. / Diameter	Shank Diameter	Flute Length	Overall Length	No. of Flutes
167-1/8	1/8	1/4	1-1/2	4	167-9/32	5/16	1/2	2-1/2	4
167-5/32	3/16	5/16	2	4	167-5/16	5/16	1/2	2-1/2	4
167-3/16	3/16	3/8	2	4	167-3/8	3/8	9/16	2-1/2	4
167-7/32	1/4	1/2	2-1/2	4	167-7/16	7/16	9/16	2-3/4	4
167-1/4	1/4	1/2	2-1/2	4	167-1/2	1/2	5/8	3	4



MiniBrute Magnetic Drill Press RB32

Applications

A lightweight drill for drilling holes up to 1-3/8" diameter. Ideal for steel fabrication and erection industry, truck / trailer frame fabrication, plant maintenance, refineries, power generation, mining, construction, bridge work and ship building.



Features

- Weighs only 28 lbs
- Magnetic strength 2,200 lbs
- Cutter capacity:
1-3/8" Diameter x 1-3/16" Depth
- Built-in fluid reservoir
- Reversible feed handle
- 6" vertical travel
- 1 Speed motor - 550 RPM
- 2" Depth of cut when used with RB335 arbor

Advantages

- Lighter weight makes handling and transport easier and safer
- Delivers the coolant to work place and cutter
- Left hand use and operating in restrictive areas
- Utilizes S&D drills up to 3/4"

Included

- Carrying case
- Safety strap
- D-handle
- Safety guard
- Chuck key
- Hex keys and spanner wrenches
- Arbors (see arbor section)

Arbors & Chucks

INCLUDED

- RB334 3/4" arbor
- RB3212 1/2" drill chuck (and safety screw)

OPTIONS AVAILABLE

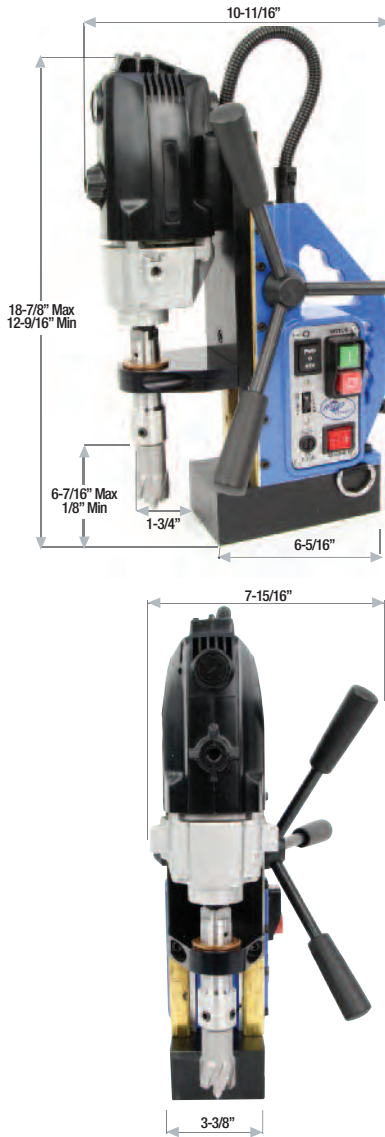
- RB335 3/4" arbor for drilling 2" depth



MiniBrute Magnetic Drill Press

RB32-VSR

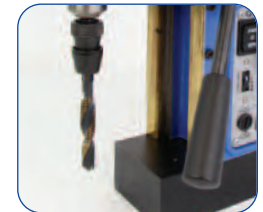
Applications
Lightweight magnetic drill press for steel fabrication, welding, steel erection, construction, mining, bridge industries. Cut holes up to 1-3/8" diameter with annular cutters or up to 3/4" diameter with twist drills. Variable speed and reverse features make the RB32-VSR ideal for tapping holes, when used with the RB32-Tapper attachment



RB32-VSR With Tap



RB32-VSR With Twist Drill



RB32-VSR Combination Drill & Tap



Features

- Weighs only 28 lbs
- Magnetic strength 2,200 lbs
- Cutter capacity: 1-3/8" Diameter x 1-3/16" Depth
- Built-in fluid reservoir
- Reversible feed handle
- 6" vertical travel
- Variable Speed - 0-550 RPM
- New and improved control panel provides easy operation of motor direction, speed and magnet on/off.
- 2" Depth of cut when used with RB335 arbor

Advantages

- Lighter weight makes handling and transport easier and safer
- Delivers the coolant to work place and cutter
- Left hand use and operating in restrictive areas
- Utilizes S&D drills up to 3/4"

Included

- Carrying case
- Safety strap
- D-handle
- Safety guard
- Chuck key
- Hex keys and spanner wrenches
- Arbors (see Arbor section)

Arbors & Chucks

INCLUDED

- RB334 3/4" arbor
- RB3212 1/2" drill chuck (and safety screw)

OPTIONS AVAILABLE

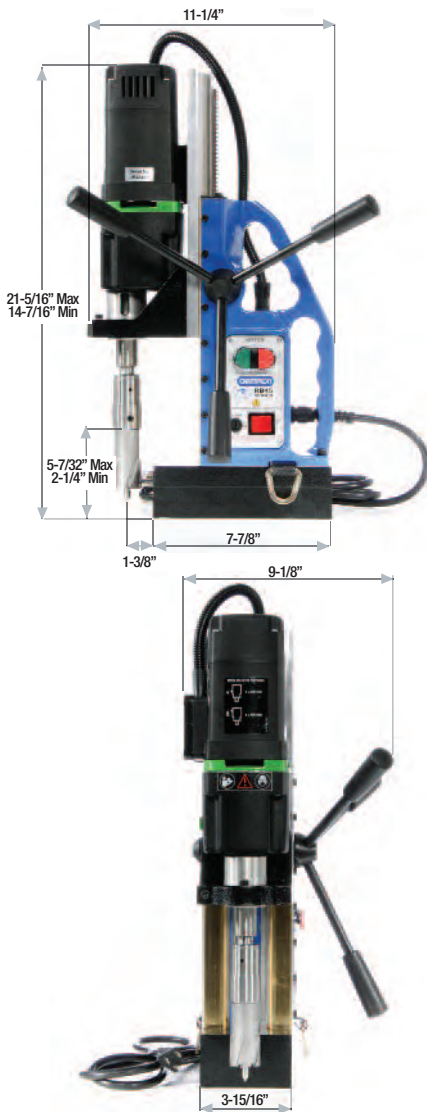
- RB335 3/4" arbor for drilling 2" depth
- RB32-Tapper
- RB925 to RB944 tapping collets



MidiBrute Magnetic Drill Press RB45

Applications

A mid-sized drill for cutting holes up to 2" diameter with annular cutters. With a high vertical travel, it can be used with taper shank drills, jobber drills, and Silver & Deming drills. Ideal for steel fabrication and erection industry, truck/trailer frame fabrication, plant maintenance, refineries, power generation, mining, construction, bridge work and ship building.



Features

- Weighs only 44 lbs
- Magnetic strength 3,300 lbs
- Cutter capacity: 2" Diameter x 2" Depth
- Built-in fluid reservoir
- Reversible feed handle
- 8" vertical travel
- 2 Speed motor: 450/250 PRM

Advantages

- Delivers the coolant to work place and cutter
- Left hand use and operating in restrictive areas
- Utilize S&D drills up to 1"

Included

- Carrying case
- Safety strap
- RB433 #2MT arbor
- D-handle
- Safety guard
- Drift key
- Hex keys and spanner wrenches

Arbors & Chucks

INCLUDED

- RB433 3/4" arbor

OPTIONS AVAILABLE

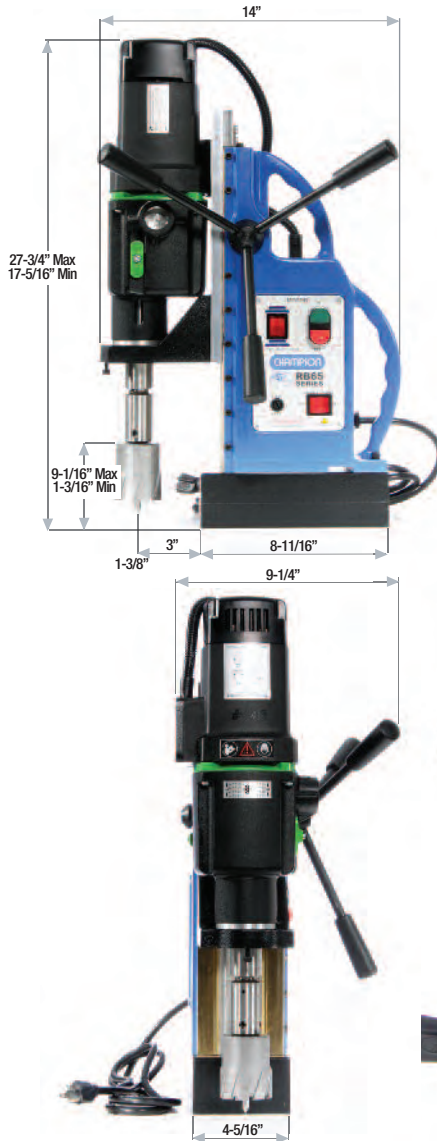
- RB4512 drill chuck / #2MT arbor



MegaBrute Magnetic Drill Press RB65E

Applications

Heavy-duty magnetic drill press for steel fabrication, welding, steel erection, construction, mining, bridge industries. Cut holes up to 4" diameter with annular cutters or up to 1-1/4" diameter with twist drills. Utilizes a #3 Morse taper spindle which enables use with taper shank drills and bridge reamers. A variety of annular cutter arbors and drill chucks are available for straight shank twist drills.



Features

- Weighs 55 lbs
- Magnetic strength 4,400 lbs
- Cutter capacity:
4" Diameter x 3" Depth
- Built-in fluid reservoir
- Reversible feed handle
- 11-1/2" Vertical travel
- #3 Morse Taper Spindle
- 4 Speed Motor: 110/175/245/385

Advantages

- Excellent machine for all fabrication shops
- Enables greatest selection of cutters available
- Left hand use and operating in restrictive areas
- Allows the use of twist drills up to 1- 1/4"

Included

- Carrying case
- Safety strap
- RB634 3/4" arbor
- D-handle
- Safety guard
- Drift key
- Hex keys and spanner wrenches

Arbors & Chucks

INCLUDED

- RB634 3/4" arbor

OPTIONS AVAILABLE

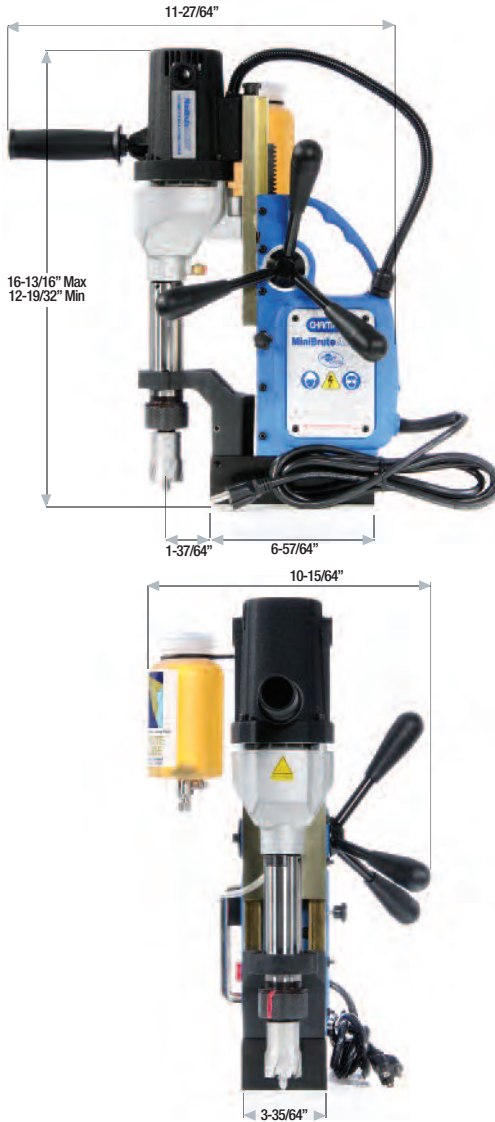
- RB635 1-1/4" arbor
- RB633 3/4" arbor
- RB632 1-1/4" arbor
- RB6512 1/2" drill chuck
- RB6534 3/4" drill chuck



MiniBrute Magnetic Drill Press AC35

Applications

A lightweight drill for drilling holes up to 1-3/8" diameter. Ideal for steel fabrication and erection industry, truck/trailer frame fabrication, plant maintenance, refineries, power generation, mining, construction, bridge work and ship building.



Features

- Weighs 23 lbs
- Magnetic Strength 2,200 lbs
- Cutter capacity: 1-3/8" diameter x 2" depth
- Utilizes S&D drills up to 3/4"
- Vertical travel - 3-1/8"
- Standard external fluid reservoir
- Quick change cutter arbor
- 1 Speed Motor: 600 RPM

Advantages

- Easy to maneuver
- Less fill ups
- Annular cutters changed quickly with no tools
- Ideal for use with carbide tipped annular cutters

Included

- Carrying case
- Hex keys
- Safety chain
- External coolant bottle
- Safety guard
- Quick release arbor enables cutter change in seconds

Arbors & Chucks

- INCLUDED**
- AC3502LQ quick-release 3/4" Arbor
- OPTIONS AVAILABLE**
- AC3502-M 3/4" 2 Set Screw Arbor
 - AC-ADAPTOR-OC
 - AC35-451220 drill chuck
 - AC35-461220 adaptor



MightiBrute Magnetic Drill Press AC50

Applications

A lightweight magnetic drill press for steel fabrication, welding, steel erection, construction, mining, bridge industries. Cut holes up to 2-1/8" diameter with annular cutters or up to 1" diameter with twist drills.



Features

- Weighs only 33 lbs.
- Magnetic Strength 3,370 lbs.
- Cutter capacity: 2-1/8" diameter x 2" depth
- Quick change 3/4" cutter arbor
- Vertical travel - 8"
- 1100W 2 Speed Motor: 450/300 RPM
- External cooling system

Advantages

- Lightweight and powerful.
- Cutter changes made in seconds
- Can be used with twist drills up to 1" as well as high speed or carbide tipped annular cutters.

Included

- Carrying case
- Safety guard
- Removable handle
- Safety chain

Arbors & Chucks

INCLUDED

- Built-in arbor

OPTIONS AVAILABLE

- QX1234 drill chuck adapter
- AC50-ADAPTER-NHO cutter arbor for Nitto Kohki® and Hougen® cutters

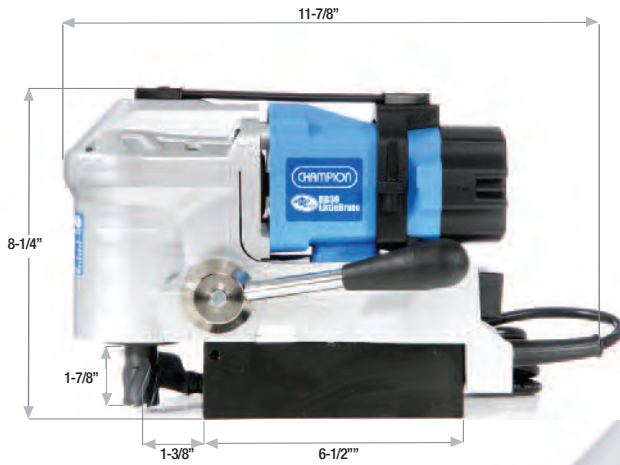


LittleBrute Magnetic Drill Press RB30

Applications

A low-profile magnetic drill ideal for tight spaces such as wheel arches and truck and trailer frame drilling.

Additional industries include utilities, steel fabrication, bridge work and ship building.



Features

- Height: 8-1/4"
- Weighs only 25 lbs
- Magnetic Strength 3,300 lbs
- Cutter capacity 1-3/8" diameter x 1-3/16" depth
- LED light for improved visibility
- No-volt release switch for motor on/off
- Gearbox housing doubles as a guard
- Removable handle for use on both sides
- 1 Speed Motor: 650 RPM

Advantages

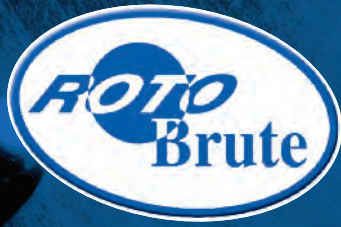
- Ideal for use in difficult to access areas
- Ideal for truck and wheel arches, girders and machine assembly
- Light and easy to maneuver

Included

- Carrying case
- Cutting fluid
- M8 wrench
- M2.5 hex key
- M4 hex key
- Safety guard
- Removable handle
- Safety Chain

Arbors & Chucks

- INCLUDED
- Built in arbor



Pipe Saddle

List No. RB-SADDLE

Pipe Saddle



EDP No.	Weight	Size	Ratchet Strap	Inner Settings	Outer Settings
RB-SADDLE	6 lbs	8-1/2 x 5 x 1-1/2"	1" x 72"	2" - 4-1/2"	4-1/2" - 8"

Champion's RotoBrute pipe saddle enables Rotobrute magnetic drill presses to be used on convex surfaces, steel pipe and tubing. Providing non-slip positioning and centered hole location. Easily assembled by sliding the machine onto the saddle and tightening with adjustable ratchet straps.

- Industry Applications**
- Maintenance Facilities
 - Railroad Industry
 - Refineries
 - Steel Fabrication
 - Pipeline and Oil Fields
 - Power Utilities



Magnetic Wand

List No. RMX7



Description: Magnetic clean up tool.

Application: Quickly and easily pick up sharp metal chips, fasteners and small parts. Safely dispose of them by pulling back the handle.

EDP No.	Description
RMX7	RotoMag Magnetic wand





Mag Drill Press Arbors, Drill Chucks and Tapping Attachments

RB32 - Arbors and Drill Chuck Attachments



RB334 Arbor

Standard arbor for RB32.

1/2-20 threaded hole threads on to RB32, 3/4" arbor hole diameter.

For use with XL100, CT150, CT150STK annular cutters.

Maximum depth of cut is 1-3/16".



RB3212 Drill Chuck

1/2" drill chuck for RB32.

1/2"-20 internal thread drill chuck.



RB335 Arbor

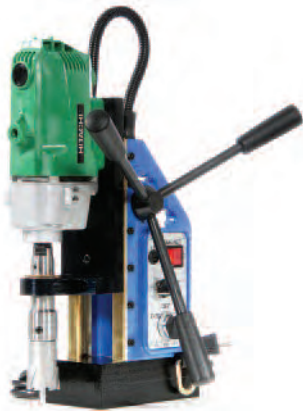
Optional arbor for RB32.

1/2-20 threaded hole threads on to RB32, 3/4" arbor hole diameter.

For use with 1" and 2" depth of cut - XL100, XL200, CT150, CT200, CT150STK, CT200STK annular cutters.



RB32-VSR - Arbors and Drill Chucks and Tapping Attachment



RB334 Arbor

Details As Above



RB3212 Chuck Adaptor

Details As Above



RB335 Arbor

Details As Above



Shown Assembled With Tapping Attachments

RB32-Tapper

RB32-Tapper

Optional tapping attachment for RB32-VSR.

Threads to RB32-VSR with 1/2-20 thread.

Used with #2 collet adaptors.

RB-925 to RB-944 collet adaptors are used with RB32-Tapper for holding taps from 0 through to 3/4" diameter.



RB32-VSR Quick Change Tapping Collets

EDP No.	Tap Sizes	EDP No.	Tap Sizes
RB-925	0-6	RB-935	5/8"
RB-926	#8	RB-936	11/16"
RB-927	#10	RB-937	3/4"
RB-928	#12	RB-938	13/16"
RB-929	#14 & 1/4"	RB-939	7/8"
RB-930	5/16"	RB-940	1/8" Small Shank NPT
RB-931	3/8"	RB-941	1/8" Large Shank NPT
RB-932	1/4" NPT	RB-942	1/4"
RB-933	3/8" NPT	RB-943	3/8"
RB-934	1/2" NPT	RB-944	1/2"



RB45 - Arbors and Drill Chuck Attachments



RB433 Arbor

Standard arbor for the RB45.

#2 Morse taper fits directly into RB32 and allows the use of 3/4" shank cutters up to 2" depth of cut.

For use with XL100, XI200, CT150 and CT200 annular cutters.



RB4512 Chuck

Optional 1/2" drill chuck for RB45 mag drill, comes with #2 Morse taper shank.





Mag Drill Press Arbors, Drill Chucks and Tapping Attachments

RB65E - Arbors and Drill Chuck Attachments



RB634 Arbor

Included with RB65E.

#3 Morse taper shank, 3/4" hole diameter.

For use with all 3/4" shank annular cutters up to 2-1/4" diameter.



RB635 Arbor

Optional arbor for RB65E.

#3 Morse taper shank, 3/4" hole diameter.

For use with XL100, XL200, XL300, CT150, CT200, CT300, CT400, CT150STK, CT200STK from 2-5/16" to 4" diameter which have a 1-1/4" shank.



RB633 Arbor

Optional arbor for RB65E.

#3 Morse taper shank, 3/4" hole diameter.

For use with XL300, CT300, CT400, CT150STK and CT200STK up to 2-1/4" diameter which have a 3/4" shank. For use with cutters up to 4" depth of cut.



RB632 Arbor

Optional arbor for RB65E

#3 Morse taper shank, 1-1/4" hole diameter.

For use with XL100, XL200, XL300, CT150, CT200, CT300, CT400, CT150STK and CT200STK from 2-5/16" diameter and larger, which have a 1-1/4" shank. For use with cutters up to 4" depth of cut.



RB6512 Drill Chuck

Optional 1/2" drill chuck for RB65E.

#3 Morse taper shank arbor to Jacobs taper mounted drill chuck.



RB6534 Drill Chuck

Optional 3/4" drill chuck for RB65E.

#3 Morse taper shank arbor to Jacobs taper mounted drill chuck.



AC35 - Arbors and Drill Chuck Attachments



AC3502LQ Arbor

Standard "quick-change" arbor for AC35.

3/4" arbor hole diameter.

For use with 1" and 2" depth of cut - XL100, XL200, CT150STK and CT200STK cutters.



AC3502-M Arbor

Optional traditional set screw arbor for AC35.

3/4" arbor hole diameter.

For use with 1" and 2" depth of cut - XL100, XL200, CT150STK and CT200STK cutters.



AC35-451220 & AC35-461220

1/2" drill chuck for AC35. 1/2"-20 internal thread drill chuck.

Requires AC35-461220 for mounting to AC35 motor.



AC50 - Drill Chuck & Adaptor



QX1234 Drill Chuck

1/2" drill chuck and adaptor for AC50 magnetic drill press.

3/4" weldon shank threaded to 1/2" drill chuck.



AC50-ADAPTOR-NHO

Optional arbor specially designed to adapt Hougén® and Nitto Kohki® brand cutters for use on the AC50.





Carbide Tipped Annular Cutters

List No. CT150 / CT200 / CT300 / CT400

Description: Maximize cutting performance of any portable magnetic drill press. Their superior "Triple Edge" cutting action outperforms ordinary high speed steel annular cutters and twist drills 6:1.

Application: Cut holes in cast iron, steel and ultra hard or exotic alloys with the added ability to produce overlapping and interrupted holes easily.



Time Saving Features

- Ultra hard carbide teeth permit faster cutting even in tough materials and shapes
- Cut clean, bur free holes.
- Precision pilot pins eject the center as a plug of steel.
- Features Weldon style flats for fast loading and better rigidity.



Triple Edge cutting features

The CT series features two sets of three cutting tips each with different geometries, balancing the cutting forces. This enables higher feed rates and smoother drilling, with better control in structural steel and steel plate.



CT150 vs Standard HS Annular Cutter Comparison

CT Advantage

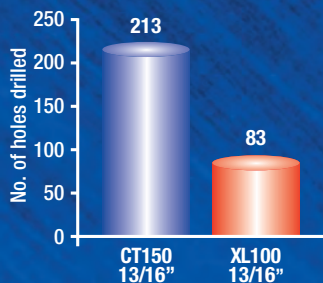
256%

Material used - Construction Steel (25mm)

AC35 Magnetic drill press used -

920 watts @ 600 RPM.

Comparisons stopped when no more holes could be bored at the same force.



Diameter	List CT150 1-3/8" Depth of Cut	List CT200 2" Depth of Cut	List CT300 3" Depth of Cut	List CT400 4" Depth of Cut
9/16	CT150-9/16	CT200-9/16		
5/8	CT150-5/8	CT200-5/8		
11/16	CT150-11/16	CT200-11/16		
3/4	CT150-3/4	CT200-3/4	CT300-3/4	CT400-3/4
13/16	CT150-13/16	CT200-13/16	CT300-13/16	CT400-13/16
7/8	CT150-7/8	CT200-7/8	CT300-7/8	CT400-7/8
15/16	CT150-15/16	CT200-15/16	CT300-15/16	CT400-15/16
1	CT150-1	CT200-1	CT300-1	CT400-1
1-1/16	CT150-1-1/16	CT200-1-1/16	CT300-1-1/16	CT400-1-1/16
1-1/8	CT150-1-1/8	CT200-1-1/8	CT300-1-1/8	CT400-1-1/8
1-3/16	CT150-1-3/16	CT200-1-3/16	CT300-1-3/16	CT400-1-3/16
1-1/4	CT150-1-1/4	CT200-1-1/4	CT300-1-1/4	CT400-1-1/4
1-5/16	CT150-1-5/16	CT200-1-5/16	CT300-1-5/16	CT400-1-5/16
1-3/8	CT150-1-3/8	CT200-1-3/8	CT300-1-3/8	CT400-1-3/8
1-7/16	CT150-1-7/16	CT200-1-7/16		
1-1/2	CT150-1-1/2	CT200-1-1/2	CT300-1-1/2	CT400-1-1/2
1-9/16	CT150-1-9/16	CT200-1-9/16		
1-5/8		CT200-1-5/8	CT300-1-5/8	CT400-1-5/8
1-11/16		CT200-1-11/16		
1-3/4		CT200-1-3/4	CT300-1-3/4	CT400-1-3/4
1-13/16		CT200-1-13/16		
1-7/8		CT200-1-7/8		
1-15/16		CT200-1-15/16		
2		CT200-2	CT300-2	CT400-2
2-1/8		CT200-2-1/8	CT300-2-1/8	
2-1/4		CT200-2-1/4	CT300-2-1/4	
2-3/8		CT200-2-3/8*	CT300-2-3/8**	
2-1/2		CT200-2-1/2*	CT300-2-1/2**	
2-5/8		CT200-2-5/8*	CT300-2-5/8**	
2-3/4		CT200-2-3/4*	CT300-2-3/4**	
2-7/8			CT300-2-7/8**	
3		CT200-3*	CT300-3**	
3-1/8			CT300-3-1/8**	
3-1/4		CT200-3-1/4*	CT300-3-1/4**	
3-3/8			CT300-3-3/8**	
3-1/2		CT200-3-1/2*	CT300-3-1/2**	
3-5/8			CT300-3-5/8**	
3-3/4			CT300-3-3/4**	
3-7/8			CT300-3-7/8**	
4		CT200-4*	CT300-4**	

Annular cutters up to 2-1/4" diameter have a 3/4" shank. Cutters 2-5/16" and larger have a 1-1/4" shank.

* CT200-PIN-1-1/4" for CT200 > 2-1/4" diameter

** CT300-PIN-1-1/4" for CT300 > 2-1/4" diameter





High Speed Annular Cutters

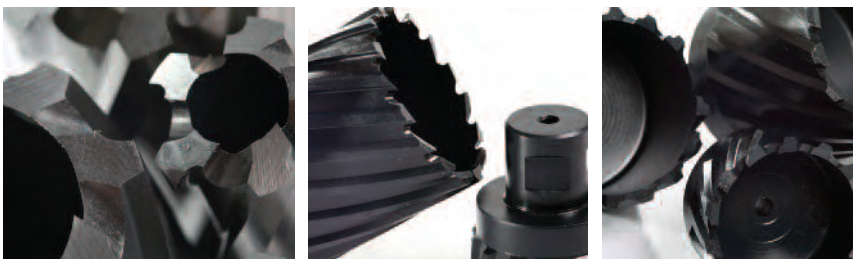
List No. XL100 / XL200 / XL300

Description: High speed steel annular cutters (M2) which feature Champion's exclusive PLUS20 surface treatment, providing cleaner cuts, positive slug ejection and longer tool life.

Application: Used in conjunction with Champion Magnetic Drill presses



PLUS20
The PLUS20 coating on XLSERIES Champion Cutters gives 20% more tool life and 20% higher performance than standard high speed annular cutters.



Diameter	List XL100 1" Depth of Cut	List XL200 2" Depth of Cut	List XL300 3" Depth of Cut
7/16	XL100-7/16	XL200-7/16	
1/2	XL100-1/2	XL200-1/2	
17/32	XL100-17/32	XL200-17/32	
9/16	XL100-9/16	XL200-9/16	
5/8	XL100-5/8	XL200-5/8	
21/32	XL100-21/32		
11/16	XL100-11/16	XL200-11/16	
23/32	XL100-23/32		
3/4	XL100-3/4	XL200-3/4	XL300-3/4
25/32	XL100-25/32		
13/16	XL100-13/16	XL200-13/16	XL300-13/16
7/8	XL100-7/8	XL200-7/8	XL300-7/8
15/16	XL100-15/16	XL200-15/16	XL300-15/16
1	XL100-1	XL200-1	XL300-1
1-1/16	XL100-1-1/16	XL200-1-1/16	XL300-1-1/16
1-1/8	XL100-1-1/8	XL200-1-1/8	XL300-1-1/8
1-3/16	XL100-1-3/16	XL200-1-3/16	XL300-1-3/16
1-1/4	XL100-1-1/4	XL200-1-1/4	XL300-1-1/4
1-5/16	XL100-1-5/16	XL200-1-5/16	XL300-1-5/16
1-3/8	XL100-1-3/8	XL200-1-3/8	XL300-1-3/8
1-7/16	XL100-1-7/16	XL200-1-7/16	XL300-1-7/16
1-1/2	XL100-1-1/2	XL200-1-1/2	XL300-1-1/2
1-9/16	XL100-1-9/16	XL200-1-9/16	XL300-1-9/16
1-5/8	XL100-1-5/8	XL200-1-5/8	XL300-1-5/8
1-11/16	XL100-1-11/16	XL200-1-11/16	XL300-1-11/16
1-3/4	XL100-1-3/4	XL200-1-3/4	XL300-1-3/4
1-13/16	XL100-1-13/16	XL200-1-13/16	XL300-1-13/16
1-7/8	XL100-1-7/8	XL200-1-7/8	XL300-1-7/8
1-15/16	XL100-1-15/16	XL200-1-15/16	XL300-1-15/16
2	XL100-2	XL200-2	XL300-2
2-1/16	XL100-2-1/16	XL200-2-1/16	XL300-2-1/16
2-1/8	XL100-2-1/8	XL200-2-1/8	XL300-2-1/8
2-3/16	XL100-2-3/16	XL200-2-3/16	XL300-2-3/16
2-1/4	XL100-2-1/4	XL200-2-1/4	XL300-2-1/4
2-5/16	XL100-2-5/16	XL200-2-5/16	XL300-2-5/16
2-3/8	XL100-2-3/8	XL200-2-3/8	XL300-2-3/8
2-7/16	XL100-2-7/16	XL200-2-7/16	XL300-2-7/16
2-1/2	XL100-2-1/2	XL200-2-1/2	XL300-2-1/2
2-9/16	XL100-2-9/16	XL200-2-9/16	XL300-2-9/16
2-5/8	XL100-2-5/8	XL200-2-5/8	XL300-2-5/8
2-11/16	XL100-2-11/16	XL200-2-11/16	XL300-2-11/16
2-3/4	XL100-2-3/4	XL200-2-3/4	XL300-2-3/4
2-13/16	XL100-2-13/16	XL200-2-13/16	XL300-2-13/16
2-7/8	XL100-2-7/8	XL200-2-7/8	XL300-2-7/8
2-15/16	XL100-2-15/16	XL200-2-15/16	XL300-2-15/16
3	XL100-3	XL200-3	XL300-3
3-1/16	XL100-3-1/16	XL200-3-1/16	XL300-3-1/16
3-1/8	XL100-3-1/8	XL200-3-1/8	XL300-3-1/8
3-3/16	XL100-3-3/16	XL200-3-3/16	XL300-3-3/16
3-1/4	XL100-3-1/4	XL200-3-1/4	XL300-3-1/4
3-5/16	XL100-3-5/16	XL200-3-5/16	XL300-3-5/16
3-3/8	XL100-3-3/8	XL200-3-3/8	XL300-3-3/8
3-7/16	XL100-3-7/16	XL200-3-7/16	XL300-3-7/16
3-1/2	XL100-3-1/2	XL200-3-1/2	XL300-3-1/2
3-9/16	XL100-3-9/16	XL200-3-9/16	XL300-3-9/16
3-5/8	XL100-3-5/8	XL200-3-5/8	XL300-3-5/8
3-11/16	XL100-3-11/16	XL200-3-11/16	XL300-3-11/16
3-3/4	XL100-3-3/4	XL200-3-3/4	XL300-3-3/4
3-13/16	XL100-3-13/16	XL200-3-13/16	XL300-3-13/16
3-7/8	XL100-3-7/8	XL200-3-7/8	XL300-3-7/8
3-15/16	XL100-3-15/16	XL200-3-15/16	XL300-3-15/16
4	XL100-4	XL200-4	XL300-4

716 thru 2-1/4 cutters have 3/4 shank
2-3/8 thru 4" cutters have 1-1/4 shank





Carbide Tipped Stack Cut Annular Cutters

List No. CT150STK

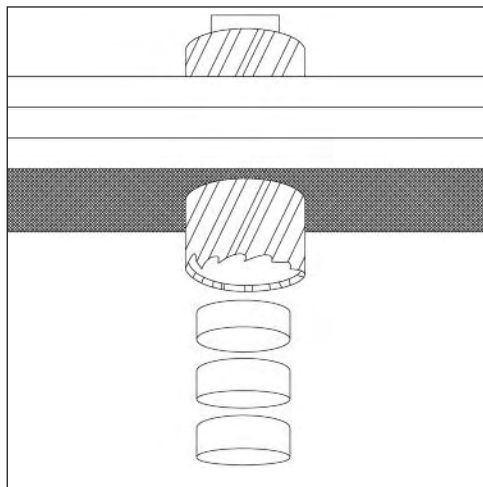


Description: Carbide tipped “stack cut” annular cutters feature a special tooth grind which enables drilling multiple plates at one time.

Application: Can be used with all magnetic drills in steel fabrication, truck and trailer frame drilling.

CT150STK Description: Engineered for drilling multiple plates at one time up to 1-3/8” depth. Stack plate (or laminate) drilling is often used when drilling multiple truck frames (truck frame extensions). CT150STK together with the RotoBrute RB30 are extremely effective to maximize cutting performance.

Diameter	CT150STK 1-3/8” Depth of Cut
5/8	CT150STK-5/8
11/16	CT150STK-11/16
3/4	CT150STK-3/4
13/16	CT150STK-13/16
7/8	CT150STK-7/8
15/16	CT150STK-15/16
1	CT150STK-1



Carbide Tipped Stack Cut Annular Cutters

List No. CT200STK



Description: Stack cutting annular cutters available for drilling multiple layers without stopping to remove center plugs.

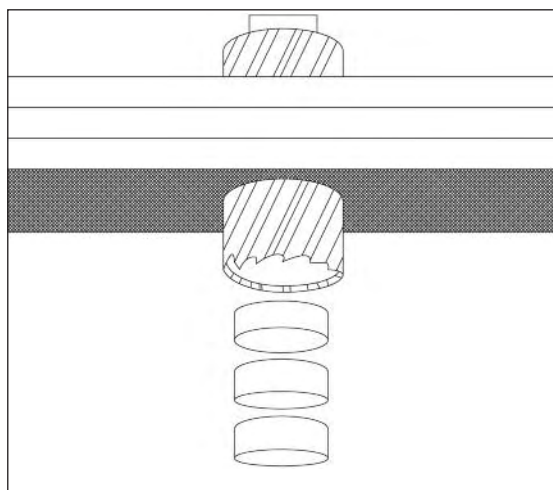
Stack cut tooth geometry cutters will smoothly penetrate multiple layers where non-modified cutters cannot.

Application: For use with the RB32, RB32VSR, RB45, RB65E AC35 and AC50 magnetic drill presses.

CT200STK Description: CT200STK cut up to 2” depth. Extremely effective with both RotoBrute AC35 an AC50 magnetic drill presses.

Manufactured with special inner diameter grind (ID) they cut cylindrical steel slugs without leaving the traditional “top hat brim”. This enables multiple slugs to build up inside the cutter, which are cleanly ejected when the final plate is drilled.

Diameter	CT200STK 2” Depth of Cut
13/16	CT200STK-13/16
7/8	CT200STK-7/8
15/16	CT200STK-15/16
1	CT200STK-1
1-1/16	CT200STK-1-1/16
1-1/8	CT200STK-1-1/8
1-3/16	CT200STK-1-3/16
1-1/4	CT200STK-1-1/4





HSS Titanium Nitride Coated Annular Cutters

List No. XL100T / XL200T

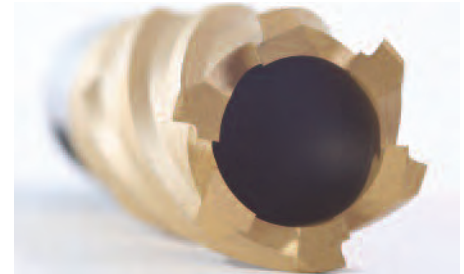
Description: High speed steel annular cutters with Titanium Nitride coating for higher speeds and longer tool life.

Application: XLT Series cutters are recommended for materials up to 325 Brinell hardness.



Diameter	List XL100T 1" Depth of Cut	List XL200T 2" Depth of Cut
7/16	XL100T-7/16	XL200T-7/16
1/2	XL100T-1/2	XL200T-1/2
17/32	XL100T-17/32	XL200T-17/32
9/16	XL100T-9/16	XL200T-9/16
5/8	XL100T-5/8	XL200T-5/8
11/16	XL100T-11/16	XL200T-11/16
3/4	XL100T-3/4	XL200T-3/4
13/16	XL100T-13/16	XL200T-13/16
7/8	XL100T-7/8	XL200T-7/8
15/16	XL100T-15/16	XL200T-15/16
1	XL100T-1	XL200T-1
1-1/16	XL100T-1-1/16	XL200T-1-1/16
1-1/8	XL100T-1-1/8	XL200T-1-1/8
1-3/16	XL100T-1-3/16	XL200T-1-3/16
1-1/4	XL100T-1-1/4	XL200T-1-1/4
1-5/16	XL100T-1-5/16	XL200T-1-5/16

Diameter	List XL100T 1" Depth of Cut	List XL200T 2" Depth of Cut
1-3/8	XL100T-1-3/8	XL200T-1-3/8
1-7/16	XL100T-1-7/16	XL200T-1-7/16
1-1/2	XL100T-1-1/2	XL200T-1-1/2
1-9/16	XL100T-1-9/16	XL200T-1-9/16
1-5/8	XL100T-1-5/8	XL200T-1-5/8
1-11/16	XL100T-1-11/16	XL200T-1-11/16
1-3/4	XL100T-1-3/4	XL200T-1-3/4
1-13/16	XL100T-1-13/16	XL200T-1-13/16
1-7/8	XL100T-1-7/8	XL200T-1-7/8
1-15/16	XL100T-1-15/16	XL200T-1-15/16
2	XL100T-2	XL200T-2
2-1/16	XL100T-2-1/16	XL200T-2-1/16
2-1/8	XL100T-2-1/8	XL200T-2-1/8
2-3/16	XL100T-2-3/16	XL200T-2-3/16
2-1/4	XL100T-2-1/4	XL200T-2-1/4



7/16 thru 2-1/4 cutters have 3/4 shank



Pilot Pins for High Speed Steel & Carbide Tipped Annular Cutters

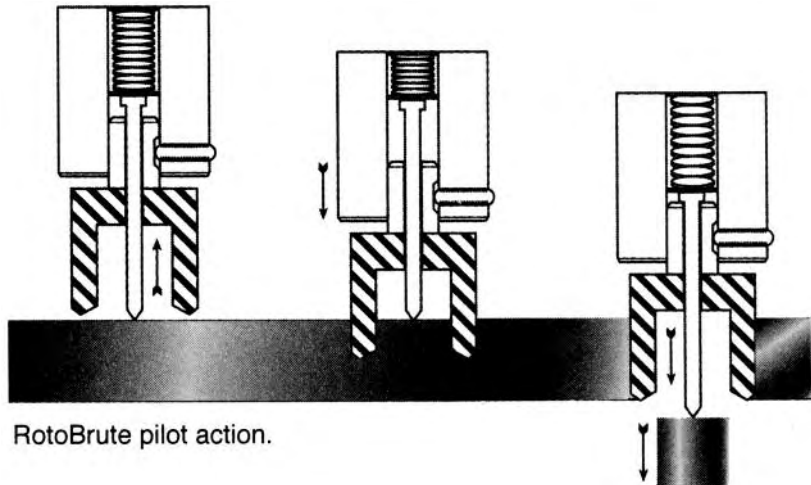
Description: Rotobruite pins slide through the center of the annular cutter to:

- Help the operator set the precise location to drill
- Guide a steady flow of cutting fluid to the cutting edges
- Eject the slug when the cutter has completed the hole



HSS Annular Cutter Pilot Pins	
EDP No.	Description
XL100P	1/4 diameter pilot pins for XL100 cutters
XL100P-7/16	Pilot pins for XL100-7/16 cutters
XL200P	1/4 diameter pilot pins for XL200 cutters
XL200P-7/16	Pilot pins for XL200-7/16 cutters
XL300P	1/4 diameter pilot pins for XL300 cutters

Carbide Tipped Annular Cutter Pilot Pins	
EDP No.	Description
CT150P	5/16 diameter pilot pins for CT150 cutters
CT150-PIN	Pilot pins for CT150 9/16 and 5/8 cutters
CT200P	5/16 diameter pilot pins for CT200 cutters
CT200-PIN	Pilot pins for CT200 9/16 and 5/8 cutters
CT200-PIN-1-1/4	Pilot pins for CT200 > 2-1/4" diameter
CT300P	5/16 diameter pilot pins for CT300 cutters
CT300-PIN-1-1/4	Pilot pins for CT300 > 2-1/4" diameter
CT400P	5/16 diameter pilot pins for CT400 cutters



RotoBrute pilot action.

PROLINE

Rotary Masonry Drills

List No. CM6

Fast Spiral / Regular Length / Carbide Tipped



Description: Use in standard rotary power tools. Performs well in masonry materials that produce a fine powder when drilled.

Application: Light to medium hard building materials, including brick and cinder block.

EDP No./ Diameter	Shank Diameter	Overall Length
CM6-3/16	5/32	3
CM6-7/32	5/32	4
CM6-1/4	1/4	4
CM6-9/32	1/4	4

EDP No./ Diameter	Shank Diameter	Overall Length
CM6-5/16	1/4	4
CM6-3/8	1/4	4
CM6-7/16	1/4	4

PROLINE

Rotary Masonry Drills

List No. CM66

6" Length / Fast Spiral / Long Length / Carbide Tipped



Description: Use in standard rotary power tools. Performs well in materials that produce a fine powder when drilled.

Application: Light to medium hard building materials, including brick and cinder block.

EDP No./ Diameter	Shank Diameter	Overall Length
CM66-1/4	1/4	6
CM66-9/32	1/4	6
CM66-5/16	1/4	6
CM66-3/8	1/4	6
CM66-7/16	1/4	6
CM66-1/2x1/4	1/4	6
CM66-1/2x3/8	3/8	6

EDP No./ Diameter	Shank Diameter	Overall Length
CM66-9/16	3/8	6
CM66-5/8	1/2	6
CM66-11/16	1/2	6
CM66-3/4	1/2	6
CM66-13/16	1/2	6
CM66-7/8	1/2	6
CM66-1	1/2	6

PROLINE

Masonry Drills

List No. CSC4

Short Length / Carbide Tipped / Deep Flute



Description: Contractor Series masonry drills for rotary and percussion drilling of concrete, brick, terra cotta, sandstone, cinder block, ceramic tile and slate.

Application: Light to medium hard building materials.

EDP No. / Diameter	Shank Diameter	Overall Length
CSC4-1/8	1/8	3
CSC4-3/16	3/16	4
CSC4-7/32	7/32	4
CSC4-1/4	1/4	4

EDP No. / Diameter	Shank Diameter	Overall Length
CSC4-5/16	1/4	4
CSC4-3/8	1/4	4
CSC4-7/16	1/4	4
CSC4-1/2X1/4	1/4	4

PROLINE

Masonry Drills

List No. CSC6

6" Length / Carbide Tipped / Deep Flute



Description: Contractor Series masonry drills for rotary and percussion drilling of concrete, brick, terra cotta, sandstone, cinderblock, ceramic tile and slate.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
CSC6-1/4	1/4	6	CSC6-1/2x1/4	1/4	6
CSC6-5/16	1/4	6	CSC6-1/2x3/8	3/8	6
CSC6-3/8	1/4	6	CSC6-5/8	1/4	6
CSC6-7/16	1/4	6	CSC6-3/4	1/4	6

PROLINE

Rotary Masonry Drills

List No. CM8

Deep Flute / Regular Length / Carbide Tipped



Description: Use in standard power tools. Deep flute design is most effective in materials that produce a coarse powder or gravel when drilled.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
CM8-1/8	1/8	2-1/2	CM8-1/4	1/4	4
CM8-9/64	9/64	2-1/2	CM8-9/32	1/4	4
CM8-5/32	5/32	2-3/4	CM8-5/16	1/4	4
CM8-11/64	11/64	2-3/4	CM8-3/8	1/4	4
CM8-3/16	3/16	3	CM8-7/16	1/4	4
CM8-7/32	7/32	4			

PROLINE

Rotary Masonry Drills

List No. CM86

Deep Flute / Long Length / Carbide Tipped



Description: Use in standard power tools. The deep flute design is most effective in materials that produce a coarse powder or gravel when drilled.

Application: Light to medium hard building materials.

EDP No. / Diameter	Shank Diameter	Overall Length	EDP No. / Diameter	Shank Diameter	Overall Length
CM86-3/16	3/16	6	CM86-9/16	3/8	6
CM86-1/4	1/4	6	CM86-5/8	1/2	6
CM86-9/32	1/4	6	CM86-11/16	1/2	6
CM86-5/16	1/4	6	CM86-3/4	1/2	6
CM86-3/8	1/4	6	CM86-13/16	1/2	6
CM86-7/16	1/4	6	CM86-7/8	1/2	6
CM86-1/2X1/4	1/4	6	CM86-1	1/2	6
CM86-1/2X3/8	3/8	6			

PROLINE

List No. CM86 continued



EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
CM86-1-1/8	1/2	6	CM86-1-5/16	1/2	6
CM86-1-3/16	1/2	6	CM86-1-3/8	1/2	6
CM86-1-1/4	1/2	6	CM86-1-1/2	1/2	6

PROLINE

12" Rotary Masonry Drills

List No. CM12

Deep Flute / Long Length / Carbide Tipped



Description: Extra length carbide tipped rotary masonry drills are for use in standard three jaw chuck power tools.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
CM12-3/16	3/16	12	CM12-3/4	1/2	12
CM12-1/4	1/4	12	CM12-7/8	1/2	12
CM12-5/16	5/16	12	CM12-1	1/2	12
CM12-3/8	5/16	12	CM12-1-1/8	1/2	12
CM12-7/16	7/16	12	CM12-1-3/16	1/2	12
CM12-1/2	3/8	12	CM12-1-1/4	1/2	12
CM12-9/16	3/8	12	CM12-1-3/8	1/2	12
CM12-5/8	1/2	12	CM12-1-1/2	1/2	12

PROLINE

18" Rotary Masonry Drills

List No. CM18

Deep Flute / Extra Long Length / Carbide Tipped



Description: Extra length carbide tipped rotary masonry drills are for use in standard three jaw chuck power tools.

Application: Light to medium hard building materials.

EDP No. / Diameter	Shank Diameter	Overall Length	EDP No. / Diameter	Shank Diameter	Overall Length
CM18-1/4	1/4	18	CM18-7/8	1/2	18
CM18-5/16	5/16	18	CM18-1	1/2	18
CM18-3/8	5/16	18	CM18-1-1/8	1/2	18
CM18-1/2	3/8	18	CM18-1-3/16	1/2	18
CM18-9/16	3/8	18	CM18-1-1/4	1/2	18
CM18-5/8	1/2	18	CM18-1-3/8	1/2	18
CM18-3/4	1/2	18	CM18-1-1/2	1/2	18

PROLINE

24" Rotary Masonry Drills List No. CM24

Deep Flute / Extra Length / Carbide Tipped



Description: Extra length carbide tipped rotary masonry drills are for use in standard three jaw chuck power tools.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
CM24-1/4	1/4	24	CM24-7/8	1/2	24
CM24-5/16	5/16	24	CM24-1	1/2	24
CM24-3/8	5/16	24	CM24-1-1/8	1/2	24
CM24-1/2	3/8	24	CM24-1-3/16	1/2	24
CM24-9/16	3/8	24	CM24-1-1/4	1/2	24
CM24-5/8	1/2	24	CM24-1-3/8	1/2	24
CM24-3/4	1/2	24	CM24-1-1/2	1/2	24

PROLINE

Tapcon® Style Bits List No. TCB



Description: For use with Tapcon style concrete anchors and screws.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length	EDP No./ Diameter	Shank Diameter	Overall Length
TCB-5/32 X 3-1/2	5/32	3 1/2	TCB-3/16 X 4-1/2	3/16	4 1/2
TCB-5/32 X 4-1/2	5/32	4 1/2	TCB-3/16 X 5-1/2	3/16	5 1/2
TCB-5/32 X 5-1/2	5/32	5 1/2	TCB-3/16 X 6-1/2	3/16	6 1/2
TCB-3/16 X 3-1/2	3/16	3 1/2			

Note: TAPCON® is a registered trademark of ITW Buildex

PROLINE

Tapcon® Style SDS-Plus Drills List No. CM95T



Description: Hex under SDS-Plus Shank fits directly into most common concrete screw anchor installation tools.

Application: Light to medium hard building materials.

EDP No. / Diameter	Shank Diameter	Overall Length
CM95T-3/16 X 2 X 5	3/16	5
CM95T-3/16 X 4 X 7	3/16	7
CM95T-5/32 X 2 X 5	5/32	5
CM95T-5/32 X 4 X 7	5/32	7



PROLINE

Rotary Rebar Cutters

List No. CM79

1/2" Shank / Carbide Tipped



Description: Easy drilling through embedded rebar and surrounding concrete. Use in any 1/2" capacity or larger drill motor with a three jaw chuck and no load speed of 440 rpm.

Application: Drill first with a hammer drill bit (1) until reaching rebar. Replace bit with CM79 then penetrate rebar (2). After completion of rebar drilling, complete drilling with hammer bit(3).

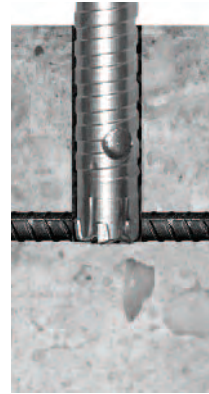
EDP No./ Diameter	Shank Diameter	Overall Length
CM79-1/2	1/2	12
CM79-5/8	1/2	12
CM79-3/4	1/2	12
CM79-7/8	1/2	12
CM79-1	1/2	12
CM79-1-1/8	1/2	12
CM79-1-1/4	1/2	12
CM79-1-3/8*	1/2	12
CM79-1-1/2*	1/2	12
CM79-1-3/4*	1/2	12
CM79-2*	1/2	12
CM79-2-1/2*	1/2	12
CM79-3*	1/2	12

*2-piece style rebar cutter that includes shank and core drill.

Rebar Step 1



Rebar Step 2



Rebar Step 3



PROLINE

SDS-Plus Rebar Drills

List No. CM79SDS

SDS-Plus Shank / Carbide Tipped



Description: Easy drilling through embedded rebar and surrounding concrete. Use in any sds plus power tool.

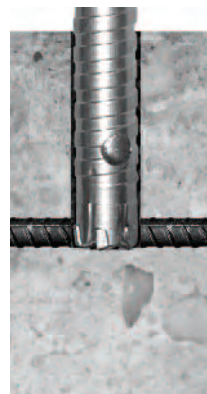
Application: Drill first with a hammer drill bit (1) until reaching rebar. Replace bit with CM79SDS then penetrate rebar using rotary only (2). After completion of rebar drilling, complete drilling with hammer bit (3).

EDP No. / Diameter	Overall Length
CM79SDS-3/8X8	8
CM79SDS-3/8X12	12
CM79SDS-7/16	12
CM79SDS-1/2	12
CM79SDS-9/16	12
CM79SDS-5/8	12
CM79SDS-11/16	12
CM79SDS-3/4	12
CM79SDS-13/16	12
CM79SDS-7/8	12
CM79SDS-1	12

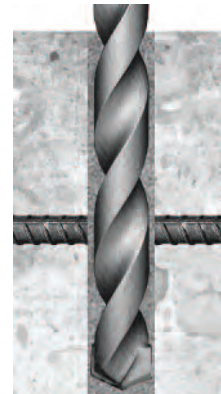
Rebar Step 1



Rebar Step 2



Rebar Step 3



Ensure hammer action is turned off when using CM79SDS on rebar - use rotary action only.

PROLINE

Multi Purpose Rotary Bits List No. CM-MPB

Description: Specially designed carbide tip, flute and heat treatment for penetrating a variety of materials. Ideal for cordless drills, corded drills & drill presses

Application: Variety of applications including concrete, stone, plastics, wood and metal.

Unique carbide geometry for fast penetration.



EDP No. / Diameter	Shank Diameter	Overall Length
CM-MPB-1/8	1/8	2-1/2
CM-MPB-5/32	5/32	2-3/4
CM-MPB-3/16	3/16	3
CM-MPB-3/16x6	3/16	6
CM-MPB-1/4	1/4	4
CM-MPB-1/4x6	1/4	6
CM-MPB-5/16	1/4	4
CM-MPB-3/8	1/4	4
CM-MPB-1/2	1/4	6

CM-MPB-SET5 5 Pc. Plastic Set

EDP No. / Diameter
CM-MPB-1/8
CM-MPB-5/32
CM-MPB-3/16
CM-MPB-1/4
CM-MPB-5/16



CM-MPB-SET7 7 Pc. Plastic Set

EDP No. / Diameter
CM-MPB-1/8
CM-MPB-5/32
CM-MPB-3/16
CM-MPB-1/4
CM-MPB-5/16
CM-MPB-3/8
CM-MPB-1/2

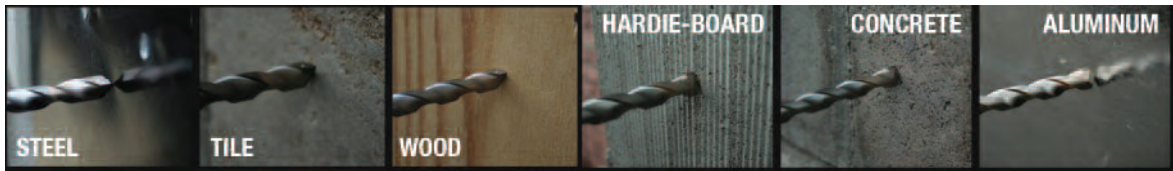


APPLICATIONS

- Pipe & electrical mounts
- Machinery mounts
- Door & window frames
- Roofing & brackets

MATERIALS

- Concrete, stone & masonry
- Ceramic Tile & marble
- Brick & granite
- Plastics
- Fiberglass & plexiglass
- Glass
- Wood



PROLINE

Percussion Masonry Drills List No. CM85

Heavy Duty / Straight Shank / Carbide Tipped

Description: For use in rotary percussion tools and in drill motors with 3 jaw chucks. Specially heat-treated alloy steel body, combined with tough percussion tips, keep bits sharp longer.

Application: Light to medium hard building materials.



EDP No. / Diameter	Shank Diameter	Overall Length
CM85-3/16X3	3/16	3
CM85-1/4X4	1/4	4
CM85-1/4X6	1/4	6
CM85-7/32X4	1/4	4
CM85-9/32X6	1/4	6
CM85-5/16X4	1/4	4
CM85-5/16X6	1/4	6
CM85-5/16X12	1/4	12
CM85-3/8X4	1/4	4
CM85-3/8X6	1/4	6
CM85-3/8X12	3/8	12
CM85-7/16X6	1/4	6

EDP No. / Diameter	Shank Diameter	Overall Length
CM85-1/2X1/4X6	1/4	6
CM85-1/2X3/8X6	3/8	6
CM85-1/2X3/8X12	3/8	12
CM85-9/16X6	1/2	6
CM85-5/8X6	1/2	6
CM85-5/8X12	1/2	12
CM85-11/16X6	1/2	6
CM85-3/4X6	1/2	6
CM85-3/4X12	1/2	12
CM85-7/8X6	1/2	6
CM85-1X6	1/2	6

PROLINE

SDS Plus Hammer Bits List No. CM95



List No. CM9



Description: Versatile slot drive system hammer bits fit most rotary hammers. Vacuum brazed with pure copper at 1900°F. Vacuum heat treated tool body to 50RC. BC20 grade carbide. CM95 has reinforced flutes and chisel shaped carbide tip. CM9 has standard tip and flute geometry.

Application: For use in concrete and hard masonry materials.

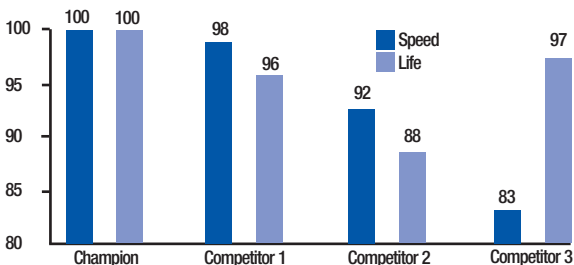
EDP No./ Diameter	Usable Length	Overall Length	EDP No./ Diameter	Usable Length	Overall Length
CM95-5/32X2X4*	2	4	CM95-3/8X22X24	22	24
CM95-5/32X4X6†*	4	6	CM95-7/16X4X6	4	6
CM95-3/16X2X4†*	2	4	CM95-7/16X10X12	10	12
CM95-3/16X4X6†*	4	6	CM95-1/2X4X6†*	4	6
CM95-3/16X6X8†*	6	8	CM95-1/2X8X10	8	10
CM95-3/16X10X12	10	12	CM95-1/2X10X12*	10	12
CM95-7/32X4X6†	4	6	CM95-1/2X16X18	16	18
CM95-7/32X6X8†	6	8	CM95-1/2X22X24	22	24
CM95-7/32X9X11†	9	11	CM95-9/16X4X6*	4	6
CM95-7/32X12X14	12	14	CM95-5/8X6X8†*	6	8
CM95-7/32X14X16	14	16	CM95-5/8X10X12*	10	12
CM95-1/4X2X4†*	2	4	CM95-5/8X16X18	16	18
CM95-1/4X4X6†*	4	6	CM95-5/8X22X24	22	24
CM95-1/4X6X8*	6	8	CM95-11/16X6X8	6	8
CM95-1/4X9X11	9	11	CM95-3/4X6X8*	6	8
CM95-1/4X12X14	12	14	CM95-3/4X10X12*	10	12
CM95-1/4X14X16	14	16	CM95-3/4X16x18	16	18
CM95-5/16X4X6†*	4	6	CM95-3/4X22x24	22	24
CM95-5/16X10X12	10	12	CM95-27/32x6X8	6	8
CM95-3/8X4X6†*	4	6	CM95-7/8X6X8*	6	8
CM95-3/8X8X10	8	10	CM95-7/8X10X12*	10	12
CM95-3/8X10X12*	10	12	CM95-1X8X10*	8	10
CM95-3/8X16X18	16	18	CM95-1X16X18	16	18

CM95 ATTRIBUTES

- Aggressive, durable carbide tip (1) allows easy centering and fast drilling
- Dynamic, chisel shaped bit head (2) ensures swift penetration
- Patented, reinforced flute geometry reduces vibration, transfers more impact energy to the cutting face and quickly channels debris from the hole
- Balance of tip and flute geometry ensure perfectly round holes giving superior anchoring
- 4 cutter CM95X range has a solid tip giving added strength

SDS Plus Bit - 1/4x6 (CM95)

MACHINE - BOSCH GBH2-20 / MATERIAL - Concrete C45/55
RPM - 750 min-1 / PRESSURE - 100-120 N / DRILLING DEPTH - 3inch



† Available in 25 piece bulk pack. Specify CM95B.

* Available in CM9 - Please specify when ordering



MAIN USES

- Highway rails
- Structural supports
- Pipe mounts
- Electrical mounts
- Bridge construction
- HVAC mounts
- Machinery mounts
- Door & window frames
- Roofing
- Brackets

MATERIALS

ALL PRODUCTS

- Concrete & stone
- Masonry
- Grout filled block
- Hollow block
- Solid brick
- Hollow brick
- Cement board
- Granite

PROLINE

SDS Plus Hammer Bits List No. CM95X Solid Tip Cross-Head

Description: Features a solid tip cross head design with centering tips for strength and easy start up.

Application: For use in concrete and hard masonry materials.



CM95X Solid Tip Cross Head - Side View



CM95X Solid Tip Cross Head - Plan View

- Made in Germany - world renowned for quality of product
- "Solid-Tip" Technology cuts through rebar (1)
- 4 Cutter head from Champion cuts faster and lasts longer (2)
- Modern heat treat and brazing processes ensuring proper hardness, toughness and durability for maximum life
- Centering point for improved positioning (4)
- Shortened conical shaped dust tracks for fast debris removal (3)
- Reinforced core and special flute for maximum energy transfer and reduced vibration

MAIN USES

- Highway rails • Structural supports • Pipe mounts
- Electrical mounts • Bridge construction • HVAC mounts
- Machinery mounts • Door & window frames • Roofing • Brackets

MATERIALS

- Concrete & stone • Masonry • Grout filled block • Hollow block
- Solid brick • Hollow brick • Cement board • Granite

EDP No./ Diameter	Usable Length	Overall Length
CM95X-3/16X2X4	2	4
CM95X-3/16X4X6	4	6
CM95X-3/16X6X8	6	8
CM95X-3/16X8X10	8	10
CM95X-3/16X10X12	10	12
CM95X-1/4X2X4	2	4
CM95X-1/4X4X6	4	6
CM95X-1/4X6X8	19	21
CM95X-1/4X8X10	6	8
CM95X-1/4X10X12	10	12
CM95X-5/16X4X6	4	6
CM95X-5/16X10X12	10	12
CM95X-5/16X16X18	16	18
CM95X-3/8X4X6	4	6
CM95X-3/8X10X12	10	12
CM95X-3/8X16X18	16	18
CM95X-7/16X4X6	4	6
CM95X-7/16X10X12	10	12
CM95X-7/16X16X18	16	18
CM95X-1/2X4X6	4	6
CM95X-1/2X10X12	10	12
CM95X-1/2X16X18	16	18
CM95X-9/16X4X6	4	6
CM95X-9/16X10X12	10	12
CM95X-9/16X16X18	16	18

- Popular sizes available in bulk packs

PROLINE

SDS-Plus Stop Bits List No. CM95-STOP

SDS-Plus Shank / Centering Point / Collar Stop

Description: Designed to work with the most popular sizes of drop-in anchors. Provides controlled drilling depth in masonry and concrete. Flute extends all the way to collar-stop. Centering tip for easy start up.

Application: Versatile tool in masonry applications: installing cable trays and struts, suspending conduit in electrical and air systems, pipe support and suspended lighting and much more.



Bit Size	Anchor Specification
CM95-STOP-3/8x1-1/16	1/4" Drop in Anchor
CM95-STOP-1/2x13/16	3/8" Drop in Anchor - Short
CM95-STOP-1/2x1-11/16	3/8" Drop in Anchor
CM95-STOP-5/8x1-1/16	1/2" Drop in Anchor - Short
CM95-STOP-5/8x2-1/16	1/2" Drop in Anchor

- Large diameter stop collar / ring avoids over penetration into concrete
- Flute extends all the way to an undercut stop ring enhancing dust extraction
- Centering tip for quicker spot drilling
- Carbide tip SDS Plus Shank

PROLINE

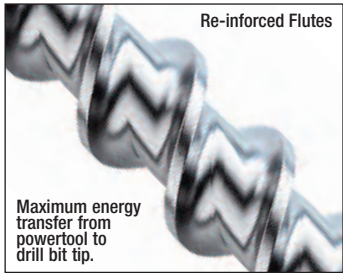
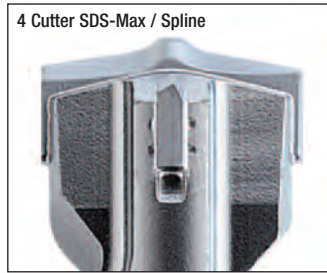
SDS-Max Hammer Bits

List No. CM96

4 Cutter Cross-Head

Description: Innovative 4-Cutter cross head design SDS Max hammer bits. Unique carbide geometry and centering tips for easy start up and drilling.

Application: For use in concrete and hard masonry materials. Ideal for pipe, electrical, cable and wiring clearances. Also ceiling & wall cavities



- Unique carbide geometry & centering tips - fast start up and drilling
- Modern heat-treat and brazing processes ensuring proper combination of product hardness, toughness and durability resulting in maximum life
- BC20 grade of carbide - designed specifically for relevant materials
- Dynamic tip geometry enhances hole roundness and rebar cutting
- 4 Cutter head from Champion cuts faster and lasts longer
- Centering point for improved positioning
- Shortened conical shaped dust tracks for fast debris removal
- Patented, reinforced core and special flute for maximum energy transfer and reduced vibrations



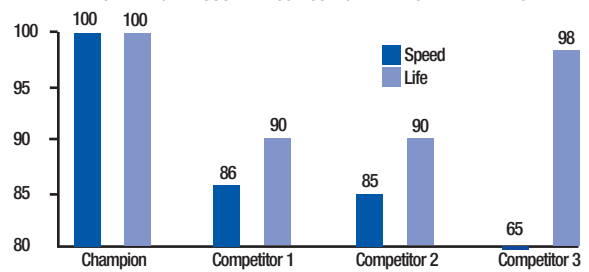
EDP No./ Diameter	Usable Length	Overall Length
CM96-1/2X8X13*	8	13
CM96-1/2X16X21*	16	21
CM96-9/16X8X13*	8	13
CM96-9/16X16X21*	16	21
CM96-5/8X8X13	8	13
CM96-5/8X16X21	16	21
CM96-5/8X31X36	31	36
CM96-11/16X16X21	16	21
CM96-3/4X8X13	8	13
CM96-3/4X17X21	17	21
CM96-3/4X31X36	31	36
CM96-7/8X8X13	8	13
CM96-7/8X17X21	17	21
CM96-7/8X31X36	31	36
CM96-1X8X13	8	13
CM96-1X17X21	17	21
CM96-1X31X36	31	36
CM96-1-1/8X10X15	10	15
CM96-1-1/8X12X17	12	17
CM96-1-1/8X17X21	17	21
CM96-1-1/8X31X36	31	36
CM96-1-1/4X10X15	10	15
CM96-1-1/4X18X23	18	23
CM96-1-3/8X18X23	18	23
CM96-1-1/2X18X23	18	23

SDS-Max Bit - 1x21 (CM96)

MACHINE - MAKITA HR4500 / MATERIAL - Concrete C45/55

RPM - 240 min-1 / PRESSURE - 200-250 N / DRILLING DEPTH - 7 inch

* 2 Cutter Heads



PROLINE

Hammer Bit Quick Change Adaptors



Description/Application: Quickly and easily adapt spline and SDS-Max drive roto-hammer power tools to use standard SDS-Plus hammer bits.

EDP No.	Description
CM96-SDS-PLUS	SDS-Max to SDS-Plus Power Bit Adaptor
CM97-SDS-PLUS	Spline to SDS-Plus Power Bit Adaptor



PROLINE

Spline Shank Hammer Bits

List No. CM97

Single Point

Description: Single point, carbide tipped splines held to very close tolerances assure perfect fit and improve impact transmission for faster drilling. Vacuum brazed with pure copper at 1900.

Application: For use in concrete and hard masonry materials.



EDP No./ Diameter	Usable Length	Overall Length	EDP No./ Diameter	Usable Length	Overall Length
CM97-3/8X3X8	3	8	CM97-3/4X11X16	11	16
CM97-3/8X5X10	5	10	CM97-3/4X17X22	17	22
CM97-3/8X8X13	8	13	CM97-3/4X24X29	24	29
CM97-3/8X11X16	11	16	CM97-3/4X31X36	31	36
CM97-7/16X8X13	8	13	CM97-7/8X11X16	11	16
CM97-1/2X5X10	5	10	CM97-7/8X17X22	17	22
CM97-1/2X8X13	8	13	CM97-7/8X31X36	31	36
CM97-1/2X11X16	11	16	CM97-1X11X16	11	16
CM97-1/2X17X22	17	22	CM97-1X17X22	17	22
CM97-1/2X24X29	24	29	CM97-1X31X36	31	36
CM97-1/2X31X36	31	36	CM97-1-1/8X11X16	11	16
CM97-9/16X5X10	5	10	CM97-1-1/8X17X22	17	22
CM97-9/16X8X13	8	13	CM97-1-1/4X11X16	11	16
CM97-5/8X5X10	5	10	CM97-1-1/4X17X22	17	22
CM97-5/8X8X13	8	13	CM97-1-1/4X31X36	31	36
CM97-5/8X11X16	11	16	CM97-1-3/8X11X16	11	16
CM97-5/8X17X22	17	22	CM97-1-3/8X17X22	17	22
CM97-5/8X24X29	24	29	CM97-1-1/2X11X16	11	16
CM97-5/8X31X36	31	36	CM97-1-1/2X17X22	17	22
CM97-11/16X8X13	8	13	CM97-1-3/4X17X22	17	22
CM97-3/4X5X10	5	10	CM97-2X17X22	17	22

PROLINE

Spline Shank Hammer Bits

List No. CM98

Quad Point

Description: Spline shanks held to very close tolerances assure perfect fit and improve impact transmission for faster drilling. Vacuum brazed with pure copper at 1900°F. Vacuum heat treated tool body to 50RC. HL20 grade carbide.

Application: For use in concrete and hard masonry materials.



EDP No. / Diameter	Shank Diameter	Overall Length	EDP No. / Diameter	Shank Diameter	Overall Length
CM98-5/8X5X10	5	10	CM98-1-1/8X11X16	11	16
CM98-5/8X11X16	11	16	CM98-1-1/8X17X22	17	22
CM98-5/8X17X22	17	22	CM98-1-1/4X11X16	11	16
CM98-5/8X24X29	24	29	CM98-1-1/4X17X22	17	22
CM98-5/8X31X36	31	36	CM98-1-3/8X11X16	11	16
CM98-3/4X5X10	5	10	CM98-1-3/8X17X22	17	22
CM98-3/4X11X16	11	16	CM98-1-1/2X17X22	17	22
CM98-3/4X17X22	17	22	CM98-1-3/4X18X23	18	23
CM98-3/4X24X29	24	29	CM98-2X18X23	18	23
CM98-3/4X31X36	31	36			
CM98-7/8X11X16	11	16			
CM98-7/8X17X22	17	22			
CM98-1X11X16	11	16			
CM98-1X18X23	18	23			
CM98-1X31X36	31	36			

- Quad Point Advantages:**
- 50% improved bit life • Rounder, more accurate holes
 - 60% less vibration • 30% less noise
 - Resists rebar hits • Extends hammer life
 - Less operator fatigue

PROLINE Hammer Chisels

Demolition tools engineered for high performance masonry removal in electric power tools. These tools are used in a broad range of applications including road construction, pavement work, bridge construction, utility installation, demolition and a variety of maintenance functions.



HEAD STYLES

Bull (moil) Point: General concrete demolition.

Flat Chisels: General concrete demolition. Available in narrow (1") & wide (2", 3") versions for cutting pavement overlay.

Clay Spade: Clay and other rock-free soil cutting.

Asphalt Cutter: Asphalt, hardpan and compacted soil cutting.

Bushing Tool: Roughing up or concrete surface removal.

SHANK TYPES

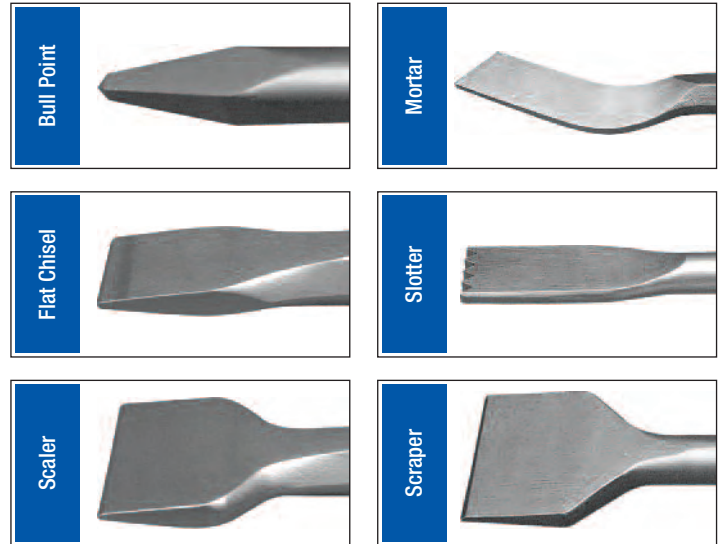
CM96 SDS Max-Chisels: For large rotary hammers with SDS-Max drive.

CM97 Spline Shank Chisels: For large rotary hammers with spline drive.

CM90 1-1/8" Breaker Chisels: For electric breakers requiring 1-1/8" notched shanks.

CM95 SDS-Plus Chisels: For SDS-Plus Hammer Drills.

CM91 3/4" Hex Shank Chisels: For demolition hammers which use 3/4" accessories.

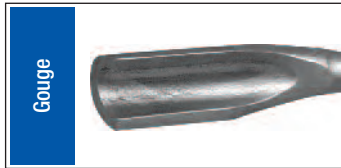


List No. CM96

SDS-Max Chisels

EDP No.	Shank Diameter	Qty
CM96-01	Bull Point 11"	Each
CM96B-01	Bull Point 11"	Box/20
CM96-02	Bull Point 12"	Each
CM96B-02	Bull Point 12"	Box/20
CM96-03	Bull Point 16"	Each
CM96B-03	Bull Point 16"	Box/20
CM96-04	Bull Point 18"	Each
CM96B-04	Bull Point 18"	Box/20
CM96-05	Flat Chisel 1" x 11"	Each
CM96B-05	Flat Chisel 1" x 11"	Box/20
CM96-06	Flat Chisel 1" x 12"	Each
CM96B-06	Flat Chisel 1" x 12"	Box/20
CM96-07	Flat Chisel 1" x 16"	Each
CM96B-07	Flat Chisel 1" x 16"	Box/20
CM96-08	Flat Chisel 1" x 18"	Each
CM96B-08	Flat Chisel 1" x 18"	Box/20
CM96-09	Flat Chisel 1" x 24"	Each
CM96-10	Scaler 1-5/8 x 12"	Each
CM96-11	Scaler 2" x 12"	Each
CM96-12	Scaler 3" x 12"	Each
CM96-13	Mortar 1-1/8" x 12"	Each
CM96-14	Slotter 1-1/4" x 12"	Each
CM96-15	Scraper 2" x 12"	Each
CM96-16	Gouge 1" x 12"	Each
CM96-17	Ground Rod Driver 3/4" x 10"	Each
CM96-18	Bushing Tool 1-3/4" x 10"	Each
CM96-19	Bushing Shank 16"*	Each
CM96-20	Bushing Head 16 Teeth	Each
CM96-21	Asphalt Cutter 5" x 20"	Each
CM96-22	Clay Spade	Each

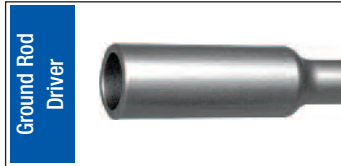
Proline™ chisels are oil quenched and shot blasted for additional stress relief and anti-rust lacquered in natural finish. Laser marked shanks ensure positive identification.



Gouge



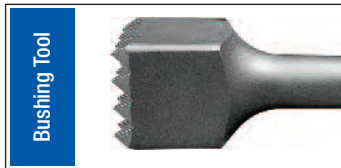
Asphalt Cutter



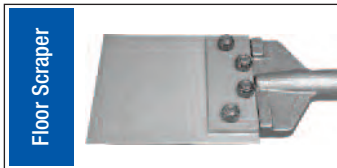
Ground Rod Driver



Clay Spade



Bushing Tool



Floor Scraper

List No. CM97

Spline Shank Chisel

EDP No.	Shank Diameter	Qty
CM97-01	Bull Point 12"	Each
CM97B-01	Bull Point 12"	Box/20
CM97-02	Bull Point 16"	Each
CM97B-02	Bull Point 16"	Box/20
CM97-03	Bull Point 18"	Each
CM97B-03	Bull Point 18"	Box/20
CM97-04	Flat Chisel 1" x 12"	Each
CM97B-04	Flat Chisel 1" x 12"	Box/20
CM97-05	Flat Chisel 1" x 16"	Each
CM97B-05	Flat Chisel 1" x 16"	Box/20
CM97-06	Flat Chisel 1" x 18"	Each
CM97B-06	Flat Chisel 1" x 18"	Box/20
CM97-07	Slotter 1-1/4" x 12"	Each
CM97-08	Clay Spade 4-1/2" x 20"	Each
CM97-09	Scaler 1-5/8" x 12"	Each
CM97-10	Scaler 2" x 12"	Each
CM97-11	Scaler 3" x 12"	Each
CM97-12	Scraper 2" x 12"	Each
CM97-13	Ground Rod Driver 3/4" x 10"	Each
CM97-14	Bushing Tool 1-3/4" x 10"	Each
CM97-15*	Bushing Shank 16"	Each
CM97-16	Mortar 1-1/8" x 12"	Each

List No. CM90 1-1/8" Breaker Chisels

EDP No.	Shank Diameter	Qty
CM90-01	Bull Point 20"	Each
CM90-02	Flat Chisel 1-3/8" x 20"	Each
CM90-03	Scaler 3" x 12"	Each
CM90-04	Asphalt Cutter 5" x 20"	Each

List No. CM95

SDS-Plus Chisels

EDP No./	Description	Qty.
CM95-01	Bull Point 10"	Each
CM95-02	Flat Chisel 3/4" x 10"	Each
CM95-03	Scaler 1-5/8" x 10"	Each

List No. CM91

3/4" Hex Demolition Chisels

EDP No.	Shank Diameter	Qty
CM91-01	Bull Point 12"	Each
CM91-02	Bull Point 16"	Each
CM91-03	Bull Point 18"	Each
CM91-04	Flat Chisel 1" x 12"	Each
CM91-05	Flat Chisel 1" x 16"	Each
CM91-06	Flat Chisel 1" x 18"	Each
CM91-07	Ground Rod Driver 3/4" x 10"	Each
CM91-08	Scraper 2" x 12"	Each
CM91-09	Scaler 2" x 12"	Each
CM91-10	Scaler 3" x 12"	Each
CM91-11	Bushing Tool 1-3/4" x 10"	Each
CM91-12	Asphalt Cutter 5" x 20"	Each
CM91-13	Clay Spade 4-1/2" x 20"	Each
CM91-14	Bushing Shank 16"*	Each

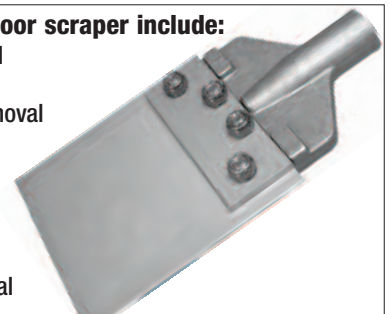
List No. CM99 Floor Scraper & Accessories

EDP No./	Description	Qty
CM99-01*	Scraper Complete 2.0mm Complete	Each
CM99-03*	Repair Kit (18Pc) Floor Scraper	Each
CM99-14	Floor Scraper & 3/4 Hex Shank 16"	Each
CM99-15	Floor Scraper & Spline Shank 16"	Each
CM99-19	Floor Scraper & SDS-Max Shank 16"	Each
CM99-02-M12*	Floor Scraper Replacement Blade	Each
CM99-03-M12*	Repair Kit (18pc) Floor Scraper	Each

* Shank not included

Common uses for floor scraper include:

- Ceramic tile removal
- Thinset removal
- Carpet adhesive removal
- VCT removal
- Wood floor removal
- Vinyl floor removal
- Epoxy floor removal
- Mastic removal
- Tile adhesive removal



PROLINE

Hammer Core Bits

List No. CM89HC

Carbide Tipped / Heavy Wall / Heat Treated Tool Steel



Description: Produce holes significantly larger than the rated power drive. Cutting the circumference of the hole leaves the center as a solid, so concrete removal is reduced for large size holes.

Application: Light to medium hard building materials.



- Used in rotary hammers operating in the rotary hammer mode.
- Core bodies are machined from one single piece of steel.
- Cutting tips are put in at irregular intervals to avoid setting up a sympathetic vibration when producing the hole.
- Each tooth presents itself to a random & new section of concrete as opposed to the piece previously hit by another tooth.

EDP No./ Diameter	Usable Length	Core Tolerance
CM89HC-1-3/4	4	1.61-1.55
CM89HC-2	4	2.08-2.03
CM89HC-2-5/8	4	2.63-2.58
CM89HC-3-1/8	4	3.19-3.13
CM89HC-3-1/2	4	3.58-3.52
CM89HC-4	4	4.13-4.07
CM89HC-5	4	5.12-5.06

- Multiple teeth assure faster cutting and debris evacuation from cutting path.
- Teeth set with negative and positive rake to cut concrete and screening.
- Tooth edges faced to act as secondary cutter area to reduce snagging.
- Centering bit is recommended for best results.



Bit Size	Pipe Sizes /Types
1-3/4	1-1/4" Cu, EMT, 1" Rigid, IMC Sched. 40
2	1-1/2" Cu, EMT, Rigid, IMC Sched. 40
2-5/8	2" Cu, EMT, Rigid, IMC Sched. 40
3	2-1/2" Cu, EMT Rigid, IMC Sched. 40
3-1/8	3" Cu, EMT, Rigid, IMC Sched. 40
4	3-1/2" Cu, EMT Rigid, IMC Sched. 40
5	4" Cu, EMT, Rigid, IMC Sched. 40

Shank Adaptors & Extension for Core Drills



EDP No.	Description	Overall Length
CM96-HC7	SDS Max Adaptor	7
CM97-HC7	Spline Adaptor	7
HC11-EXT	Extension for Core Adaptors	11

Pilot Drills

Pilot / Center Bit for Core Drill:



EDP No.	Description	Overall Length
CM89HC-DRILL	15/32 Pilot / Centering Bit	6
CM89HC-TS	Threaded Shank Stud	

PROLINE

Porcelain Tile Carbide Drills

List No. PTC

P100 Grade Carbide

For Fastener Range - Small Diameter 3/16"-5/16"

Description: Carbide tipped, professional porcelain tile drill. Specially ground tip, enables immediate penetration and stops drill wandering on tile.

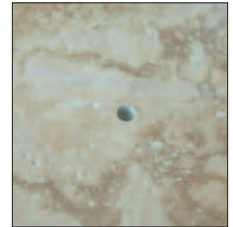
Application: For Class 5, the toughest industrial and residential wall and floor tile. Also works effectively on granite, marble and glass. A constant flow of water must be used.



EDP No./ Diameter	Overall Length	Shank Diameter
PTC-3/16	5-3/4	3/8
PTC-1/4	5-3/4	3/8
PTC-9/32	5-3/4	3/8
PTC-5/16	5-3/4	3/8



Easy Start Up & Rapid Penetration



Accurate Holes

PROLINE

Diamond Mini Hole Cutters

List No. PTC3

Vacuum Brazed / Reverse Spiral / Slug Ejection Slot

Description: High performance range of diamond grit mini hole cutters. Vacuum brazed for high performance. Hardened steel body gives strength. Reverse spiral flute for continuous water flow. Integral slug removal slot

Application: Ideal for porcelain tiles (including Grade 5+), granite, marble, slate, glass, travertine, fiber, ceramic, agglomerate/cement, quarry and terracota.



Bit Size	Application
PTC3-3/16*	Wall anchors
PTC3-1/4*	Wall anchors
PTC3-5/16*	Wall anchors
PTC3-3/8*	Wall anchors
PTC3-1/2	Through holes
PTC3-5/8	Through holes
PTC3-3/4	Through holes
PTC3-1	Through holes
PTC3-1-3/8	Through holes
PTC-WFG	Water feed guide

* Available in 5 piece bulk packs.



- Hardened steel body - gives strength and stability.
- Vacuum brazed diamond tip - excellent wear properties.
- Raised cutting edge for increased speed of cut.
- Incredibly strong bond system - ensures diamond grit retention.
- Reverse spiral - ensures water is constantly at cutting face.
- Integral slug removal slot - east slug removal.
- Ideal for - installing shower surrounds, basins, water supply pipes, hand towel rail holders and drilling applications on ares of high public traffic such as shopping malls, airports, hotels and restaurants.



PTC-WFG

PROLINE

Diamond Multi Purpose Cutters

List No. PTC4

Vacuum Brazed Diamond Tips / Thin Walled Ejection Slots



Description: Vacuum brazed diamond tip for fast penetration and long tool life. Thin wall construction for rapid penetration and removal of chips.

Application: non-ferrous materials including hard tile, granite, travertine, marble, plastics, cement board, fiberglass, decking, laminates, brick, paving, thin sheet metal, aluminum and more. Use wet, dry or lubricated.

EDP No./ Diameter

PTC4-3/4

PTC4-7/8

PTC4-1

PTC4-1-1/8

PTC4-1-1/4

PTC4-1-3/8

PTC4-1-1/2

PTC4-1-3/4

PTC4-2

PTC4-2-1/4

PTC4-2-1/2

PTC4-3

PTC4-3-1/4

PTC4-3-11/32

PTC4-3-1/2

PTC4-4

Vacuum brazed diamond tips

- Latest brazing technology gives high strength bond between body and diamond.
- Able to resist excessive heat generated when drilling hard materials.
- Longevity of use and consistent, fast penetration.

Thin wall design and diamond tip design

- Thin walled body enables rapid penetration and reduction of heat build up during cutting action.

Ejection Slots

- Multiple ejection slots for waste material clearance ease of material slugs removal.



Drilling Wet

Porcelain and quarry tiles, ceramic tiles, class 5 tiles, granite, travertine, marble, reinforced glass and cement, stone and sheetrock.



Drilling Dry

Glass, polymers, fibreglass, decking, plywood, mdf, plastics, laminates, acrylic, brick & paving.



Drilling With Lubrication

Thin sheet metal, virton and aluminum.

PROLINE

Diamond Multi Purpose Cutter Arbors

List No. PTC4-ARBOR



Description: Arbors for use with PTC4 multi purpose cutters and holesaws.

Application: Only use pilot with woods and plastics, do not use on metals or tiles.

EDP No./ Diameter

Description

PTC4-ARBOR-1

Hex shank arbor for sizes 3/4 thru 1-1/8

PTC4-ARBOR-2

Hex shank arbor for sizes 1-1/4 thru 4

PTC4-ARBOR-SDS-1

SDS shank arbor for sizes 3/4 thru 1-1/8

PTC4-ARBOR-SDS-2

SDS shank arbor for sizes 1-1/4 thru 4

PTC4-PILOT

Pilot drill for PTC4 arbors



PROLINE

Bellhanger Drills List No. 8048 12", 18", 24" & 30" Lengths

Description: Slow spiral wood bits with small hole near the point for attaching fishing wire to be pulled back through the hole.

Application: Used by telephone, burglar alarm and cable TV installers for the drilling of wire feed holes.



EDP No./ Diameter	Overall Length	EDP No./ Diameter	Overall Length
8048-1/4x12	12	8048-3/8x30	30
8048-1/4x18	18	8048-7/16x12	12
8048-1/4x24	24	8048-7/16x18	18
8048-1/4x30	30	8048-1/2x12	12
8048-5/16x12	12	8048-1/2x18	18
8048-5/16x18	18	8048-1/2x24	24
8048-5/16x24	24	8048-9/16x18	18
8048-3/8x12	12	8048-5/8x18	18
8048-3/8x18	18	8048-11/16x18	18
8048-3/8x24	24	8048-3/4x18	18

PROLINE

Electricians Power Drills List No. 8518 Mono Spur / Double Twist

Description: Clean fast holes produced when used with a standard power tool. Front end spur pulls drill through wood.

Application: All wood applications.



EDP No. / Diameter	Shank Diameter	Overall Length	EDP No. / Diameter	Shank Diameter	Overall Length
8518-5/8	5/16	9	8518-7/8	5/16	9
8518-11/16	5/16	9	8518-1	5/16	9
8518-3/4	5/16	9	8518-1-1/8*	7/16	9
8518-13/16	5/16	9	8518-1-1/4*	7/16	9



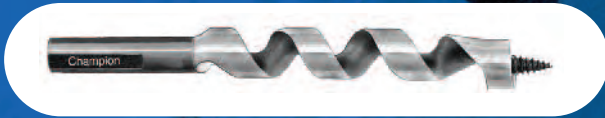
* Use 8700 extension

PROLINE

Auger Drills

List No. 8006

Auger / Single Flute



Description: Single flute auger drills for general purpose boring.

Application: Most types of wood.

Sizes 1/4 & 5/16 have 1/4" shank; 3/8 thru 1" have 3/8" shank.

EDP No./ Diameter	Flute Length	Overall Length	EDP No./ Diameter	Flute Length	Overall Length
8006-1/4	5	8	8006-13/16	5	8
8006-5/16	5	8	8006-7/8	5	8
8006-3/8	5	8	8006-15/16	5	8
8006-7/16	5	8	8006-1	5	8
8006-1/2	5	8			
8006-9/16	5	8			
8006-5/8	5	8			
8006-11/16	5	8			
8006-3/4	5	8			

PROLINE

Auger Extensions

List No. 8700 1/2" Shank fits 7/16" Shank Augers

List No. 8800 3/8" Shank fits 5/16" Shank Augers



Description: Adaptor which extends the reach of auger drills.

Use with 8800 extension except where noted*.

EDP No./ Diameter	Length	Shank Diameter	EDP No./ Diameter	Length	Shank Diameter
8700-12	12	1/2	8800-18	18	3/8
8700-18	18	1/2	8800-24	24	3/8
8700-24	24	1/2			

PROLINE

17" Auger Drills

List No. 8018

Auger / Single Flute / 7/16" Shank



Description: Power ship augers designed with a single cutting edge and side lip.

Application: Designed to withstand heavy duty use found in construction applications.

Use with 8700 extension except where noted *(Use 8800 extension).

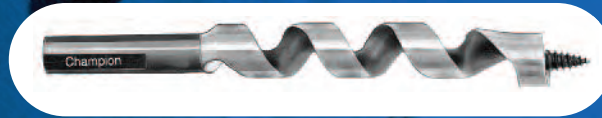
EDP No. / Diameter	Shank Diameter	Overall Length	EDP No. / Diameter	Shank Diameter	Overall Length
8018-3/8*	12	17	8018-7/8	12	17
8018-7/16*	12	17	8018-15/16	12	17
8018-1/2*	12	17	8018-1	12	17
8018-9/16	12	17	8018-1-1/16	12	17
8018-5/8	12	17	8018-1-1/8	12	17
8018-11/16	12	17	8018-1-1/4	12	17
8018-3/4	12	17	8018-1-3/8	12	17
8018-13/16	12	17	8018-1-1/2	12	17

* 5/16 Shank

PROLINE

Auger Bits List No. 8606

Single Flute / Heavy Duty / 1/2" Shank



Description: Single flute auger drills for general purpose boring.

Application: Most types of wood.

EDP No./ Diameter	Flute Length	Overall Length
8606-1/2	4	6
8606-9/16	4	6
8606-5/8	4	6
8606-11/16	4	6
8606-3/4	4	6
8606-13/16	4	6
8606-7/8	4	6

EDP No./ Diameter	Flute Length	Overall Length
8606-15/16	4	6
8606-1	4	6
8606-1-1/8	4	6
8606-1-1/4	4	6
8606-1-3/8	4	6
8606-1-1/2	4	6

PROLINE

Wood Boring Bits List No. 8001

Spade Style



Description: General purpose wood boring bits.

Application: Light to medium hard building materials.

EDP No./ Diameter	Shank Diameter	Overall Length
8001-1/4	7/32	6
8001-5/16	7/32	6
8001-3/8	7/32	6
8001-7/16	7/32	6
8001-1/2	7/32	6
8001-9/16	7/32	6
8001-5/8	7/32	6
8001-11/16	7/32	6
8001-3/4	7/32	6

EDP No./ Diameter	Shank Diameter	Overall Length
8001-13/16	7/32	6
8001-7/8	7/32	6
8001-15/16	7/32	6
8001-1	7/32	6
8001-1-1/8	7/32	6
8001-1-1/4	7/32	6
8001-1-3/8	7/32	6
8001-1-1/2	7/32	6

PROLINE

Wood Boring Bits List No. 8016

16" Spade Style



Description: General purpose wood boring bits.

Application: Light to medium hard building materials.

EDP No. / Diameter	Shank Diameter	Overall Length
8016-1/4	7/32	16
8016-3/8	7/32	16
8016-1/2	7/32	16
8016-5/8	7/32	16

EDP No. / Diameter	Shank Diameter	Overall Length
8016-3/4	7/32	16
8016-7/8	7/32	16
8016-1	7/32	16



13 Piece Metal Cased Sets



1/16 thru 1/4 x 64ths

EDP No.	Description
13C	405 Bright HSS Drills
113C	705 Black HSS Drills
113C0	705C Cobalt HSS Drills
113LH	705LH Left Hand Drills
113C-SP	705SP Split Point Drills
113T-C	700T TiN Coated Drills
113-XGO	XGO BlackGold Drills
113-XL5	XL5 Brute Platinum Drills
113-XL28	XL28 Brute Mechanics Drills
P13C	US5 Black HSS Drills
113-MT	Empty Case

15 Piece Metal Cased Sets



1/16 thru 1/2 x 32nds

EDP No.	Description
15C	405 Bright HSS Drills
115C	705 Black HSS Drills
115C0	705C Cobalt HSS Drills
115LH	705LH Left Hand Drills
115C-SP	705SP Split Point Drills
115T-C	700T TiN Coated Drills
115-XGO	XGO BlackGold Drills
115-XG38	XGO & XG38 3/8" Shank Drills
115-XL5	XL5 Brute Platinum Drills
115-XL28	XL28 Brute Mechanics Drills
115-XL38	XL5 & XL38 Brute 3/8" Shank
P15C	US5 Black Drills
P15HD	USHD Black HSS Drills
115-MT	Empty Case

21 Piece Metal Cased Sets



1/16 thru 3/8 x 64ths

EDP No.	Description
21C	405 Bright HSS Drills
121C	705 Black HSS Drills
121C0	705C Cobalt HSS Drills
121LH	705LH Left Hand Drills
121C-SP	705SP Split Point Drills
121T-C	700T TiN Coated Drills
121-XGO	XGO BlackGold Drills
121-XL5	XL5 Brute Platinum Drills
121-XL28	XL28 Brute Mechanics Drills
P21C	US5 Black HSS Drills
P21C-3/8	US5 & 738 3/8" Shank Drills
P21HD	USHD Black Drills
121-MT	Empty Case

7 Piece Drill Sets



1/16 thru 1/4 x 32nds

EDP No.	Description
107P	705 Black HSS Drills
107C0	705C Cobalt HSS Drills
107LH	705LH Left Hand Drills
107P-XL5	XL5 Brute Platinum Drills

20 Piece Metal Cased Sets



Micro Drills - Wire Gauge 61 thru 80

EDP No.	Description
20C	405 Bright HSS Drills
120C	705 Black HSS Drills
120C0	705C Cobalt HSS Drills
120-MT	Empty Case

26 Piece Metal Cased Sets



A thru Z

EDP No.	Description
26C	405 Bright HSS Drills
126C	705 Black HSS Drills
126-XL5	XL5 Brute Platinum Drills
126C0	705C Cobalt HSS Drills
126C-SP	705SP Split Point Drills
126-XGO	XGO BlackGold Drills
126-MT	Empty Case



29 Piece Metal Cased Sets



1/16 thru 1/2 x 64ths

EDP No.	Description
29C	405 Bright HSS Drills
129C	705 Black HSS Drills
129CO	705C Cobalt HSS Drills
129LH	705LH Left Hand Drills
129C-SP	705SP Split Point Drills
129T-C	700T TiN Coated Drills
129-3/8C	705 & 738 3/8" Shank Drills
129SM	1705 Screw Machine Drills
129-XG0	XG0 BlackGold Drills
129C-XL5	XL5 Brute Platinum Drills
129-XL28	XL28 Brute Mechanics Drills
129-XG38	XG0 & XG38 3/8" Shank Drills
129C-XL38	XL5 & XL38 Brute 3/8" Shank
P29C	US5 Black Contractor Drills
P29C-3/8	US5 & 738 3/8" Shank Drills
P29HD	USHD Black Contractor Drills
129-MT	Empty Case

29 Piece Twister Sets

29 Piece drill sets in durable plastic cases. Includes 1/16 thru 1/2 x 64ths. Water resistant for use in damp environments.



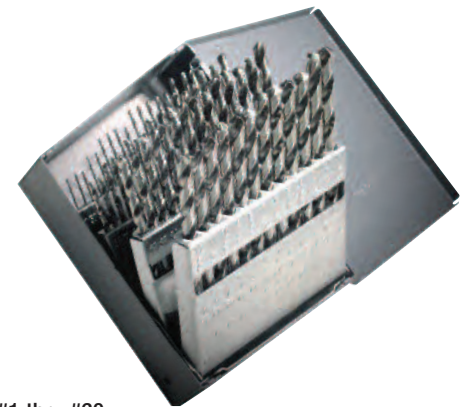
EDP No.	Description
TWISTER-XL5	XL5 Brute Platinum Drills
TWISTER-XL28	XL28 Brute Mechanics Drills
TWISTER-XG0	XG0 BlackGold Drills
TWISTER-705C	705C Cobalt Drills
TWISTER-US5-29	US5 General Purpose
TWISTER-USHD-29	USHD General Purpose Split Point
TWISTER-XG38	XG38 BlackGold 3/8 Shank Drills
TWISTER-XM28-29	XM28 Mechanics Length Drills
TWISTER-705-29	705 Black HSS Drills
TWISTER-705SP-29	705SP Split Point Drills

Metric Drill Sets



EDP No.	Description
M11C	708 1-6mm X .5mm
M11-XL8	XL8 1-6mm X .5mm
M25C	708 1-13mm X .5mm
M25-XL8	XL8 1-13mm X .5mm
M11-MT	Empty Case
M25-MT	Empty Case

60 Piece Metal Cased Sets



#1 thru #60

EDP No.	Description
60C	405 Bright HSS Drills
160C	705 Black HSS Drills
160CO	705C Cobalt HSS Drills
160C-SP	705SP Split Point Drills
160C-XL5	XL5 Brute Platinum Drills
160SM	1705 Screw Machine Drills
160-XG0	XG0 BlackGold Drills
160-MT	Empty Case

115 Piece Metal Cased Sets



1/16 thru 1/2 X 64ths, #1 thru #60, A thru Z

EDP No.	Description
SS50C	405 Bright HSS Drills
SS150C	705 Black HSS Drills
SS150CO	705C Cobalt HSS Drills
SS150-SP	705SP Split Point Drills
SS150-XL5	XL5 Brute Platinum Drills
SS150-XG0	XG0 BlackGold Drills
SS150-MT	Empty Case



Taper Shank Drill Sets S&D Drill Sets LH Drill & Screw Extractor Set



16 Piece Taper Shank Drill Set



EDP No.	Description
702-1016	33/64 - 3/4 x 64ths
702-2016	49/64 - 1 x 64ths
702-1016-MT	Empty Case
702-2016-MT	Empty Case

8 Piece S&D Drills



9/16 thru 1 x 16ths in metal cases

EDP No.	Description
712-8C	712 HSS Drills
712C0-8C	712C0 Cobalt Drills
XL12-8C	XL12 Brute Platinum Drills
US12-8C	US12 HSS Contactor Drills
712-8-MT	Empty Case

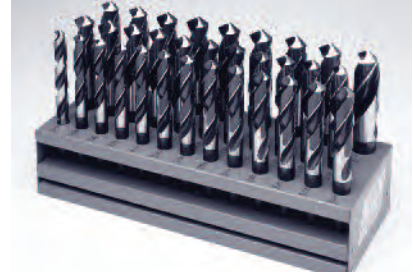
8 Piece S&D Drills



9/16 thru 1 x 16ths in plastic cases

EDP No.	Description
712-8P	712 HSS Drills
712C0-8P	712C0 Cobalt Drills
XL12-8P	XL12 Brute Platinum Drills
XG12-8P	XG12 BlackGold Drills
US12-8P	US12 HSS Contactor Drills
712-8P-MT	Empty Case

33 Piece Silver & Deming Sets



33/64 thru 1 x 64ths (includes 1/2" jobber drill)

EDP No.	Description
712-33	712 HSS Drills
XL12-33	XL12 Brute Platinum Drills
712-33-MT	Empty Case

LH Drill & Screw Extractor Sets



EDP No.	Description
X1-XL5LH	XL5LH Drills 5/64, 7/64, 5/32, 1/4, 19/64 and screw extractors #1-5
X1-705LH	705LH Drills 5/64, 7/64, 5/32, 1/4, 19/64 and screw extractors #1-5

Screw Extractor Sets Tap & Drill Indexes Drill & Tap Sets



Screw Extractor Sets



EDP No.	Description
X1-1-5	Spiral Flute Extractors #1 thru #5
X1-1-6	Spiral Flute Extractors #1 thru #6
X2-1-5	Straight Flute Extractors #1 thru #5
X2-1-6	Straight Flute Extractors #1 thru #6

36 Piece Tap & Drill Indexes



TD36 Series

36 Piece Combination NC/NF Sets Contain - Taps: 6-32 & 40, 8-32 & 36, 10-24, & 32, 12-24 & 28, 1/4-20 & 28, 5/16-18 & 24, 3/8-16 & 24, 7/16-14 & 20, 1/2-13 & 20. Drills: #36, #29, #25, #16, #7, F, 5/16, U, 27/64, #33, #29, #21, #15, #3, I, Q, 25/64, 29/64.

EDP No.	Description
TD36-XL	XL5 Drills / XL22 NC & NF Taps
TD36	705 Drills / 308 NC & NF Taps
TD36-MT	36 Piece Empty Case Only

18 Piece Tap & Drill Indexes



TD18 Series

18 Piece NC Sets Contain - Taps: 6-32, 8-32, 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13. Drills: #36, #29, #25, #21, #7, F, 5/16, U, 27/64.

TD18NF Series

18 Piece NF Sets Contain - Taps: 6-40, 8-36, 10-32, 12-28, 1/4-28, 5/16-24, 3/8-24, 7/16-20, 1/2-20. Drills: #33, #29, #21, #15, #3, I, Q, 25/64, 29/64.

EDP No.	Description
TD18-XL	XL5 Drills / XL22 NC Taps
TD18NF-XL	XL5 Drills / XL22 NF Taps
TD18	705 Drills / 308 NC Taps
TD18-XG0	XG0 Drills / 308 NC Taps
TD18-NF	705 Drills / 308 NF Taps
TD18B-MT	18 Piece Empty Case Only
TD18NF-MT	18 Piece NF Empty Case Only



TD18M Series

18 Piece Metric Sets Contain - Taps: 2.5x.45, 3.0x.50, 3.5x.60, 4.0x.70, 5.0x.80, 6.0x1.0, 8.0x1.25, 10x1.50, 12.0x1.75 Drills: #46, #39, #32, #30, #19, #8, H, Q, 13/32.

EDP No.	Description
TD18M	705 Drills / 308M Metric Taps
TD18M-XL	XL5 Drills / 321M Metric Taps
TD18M-MT	18 Piece Metric Case Only

Combination Drill & Tap Sets



DT22 Series

Create hole and threads in a single pass. No center drilling or punching required.

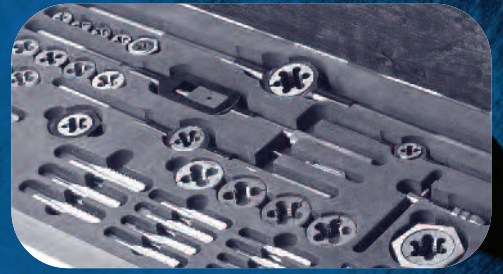
EDP No.	Description
DT22-SET	6 Piece - 8-32, 10-24, 12-24, 1/4-20, 5/16-18, 3/8-16
DT22M-SET	5 Piece - 4x.7, 5x.8, 6x1, 8x1.25, 10x1.5



DT22HEX Series

Hex shank, 135° split point, black & gold surface treatment - can be used in QCD (Quick change driver)

EDP No.	Description
DT22HEX-SET-MET6	6 Piece - M4x.7, M5x.8, M6x1, M8x1.25, M10x1.5, M12x1.75
DT22HEX-SET-MS5	5 Piece - 6-32, 8-32, 10-24, 10-32, 12-24
DT22HEX-SET-NC5	5 Piece - 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13
DT22HEX-SET10	10 Piece - 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13
DT22HEX-SET-NF5	5 Piece - 1/4-28, 5/16-24, 3/8-24, 7/16-20, 1/2-20



Tap & Die Sets in Hardwood Boxes



S32 Series Tap & Die Sets 1/4 - 1

Champion 32 piece tap & die sets contain the following: 1/8 NPT pipe tap; plug taps / round dies: 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13, 5/8-11, 3/4-10, 7/8-9, 1-8.
Accessories: 3305 1". 1-1/2 & 2 hex adaptors for round dies, 3291 1, 1-1/2 & 2 round die stocks, 3002-2 "T"-handle, 3001-7 bar handle tap wrench and screwdriver.
Weight: 23lbs.
Dimensions: 25-1/2"L x 11-3/4" x 2"H

EDP No.	Description
S32JR	302 carbon Taps & 327 carbon dies
S32-LTD	308 HS Taps & 327 carbon dies
S32-ULTRA	308 HS Taps & 328 HS Dies

S32 Series Metric Tap & Die Sets 6 - 24mm

S32M-LTD 32 piece metric tap & die sets contain the following: 324-1/8 NPT pipe tap: plug taps/round dies: 6.0x1.0, 7.0x1.0, 8.0x1.25, 10.0x1.5, 12.0x1.75, 14x2.0, 16x2.0, 20x2.5, 22x2.5, 24x3.0.
Accessories: 3305 1, 1-1/2 & 2 hex adaptors for round dies, 3002-2 "T" handle tap wrench, 3291 1, 1-1/2 & 2 round die stocks, 3001-7 bar handle tap wrench and screwdriver.
Weight: 13lbs.
Dimensions: 25-1/2"L x 11-3/4" x 2"H

EDP No.	Description
S32M-LTD	308M HS taps & 327M carbon Dies



S40 Series Tap & Die Sets #4 - 1/2

Champion 40 piece tap & die sets contain the following: 1/8 NPT pipe tap; plug taps / round dies: 4-40, 6-32, 8-32, 10-24, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, and 1/2-20.
Accessories: 3305-1 hex adaptor for round dies, 3002-1 "T" handle, 3002-1 die stock and screwdriver.
Weight: 13lbs.
Dimensions: 18"L x 7-1/2" x 1-1/2"H

EDP No.	Description
S40JR	302 carbon taps & 327 carbon dies
S40-LTD	308 HS taps & 327 carbon dies
S40-ULTRA	308 HS taps & 328 HS dies

S40 Series Metric Tap & Die Sets 2.5 - 12mm

S40M-LTD 40 piece metric tap & die sets contain the following: 324-1/8 NPT pipe tap: plug taps/round dies: 2.50x.45, 3.0x.50, 3.5x.60, 4.0x.70, 5.0x.80, 5.5x.90, 6.0x.75, 6.0x1.0, 7.0x.75, 7.0x1.0, 8.0x1.0, 8.0x1.25, 10.0x1.25, 10.0x1.5, 12.0x1.25, 12.0x1.75.
Accessories: 3305-1 hex adaptor for round dies, 3002-1 "T" handle tap wrench, 3291-1 round die stock, 3001-15 bar handle tap wrench and screwdriver.
Weight: 23 lbs.
Dimensions: 18"L x 7-1/2" x 1-1/2"H

EDP No./	Description
S40M-LTD	308M HS taps & 327M carbon dies



S51 Series Tap & Die Sets 1/4 - 1

Champion 51 piece tap & die sets contain the following: 1/8 NPT pipe tap; taps/dies: 1/4-20, 1/4-28, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 9/16-12, 9/16-18, 5/8-11, 5/8-18, 3/4-10, 3/4-16, 7/8-9, 7/8-14, 1-8, 1-14.
Accessories: 3305-1, 1-1/2 & 2 hex adaptor for round dies, 3002-2 "T" handle, 3291-1, 1-1/2 & 2 die stocks, 3001-7 bar handle tap wrench and screwdriver.
Weight: 34lbs.
Dimensions: 28-1/2"L x 14-1/2"D x 2-1/2"H

EDP No.	Description
S51JR	302 carbon taps & 327 carbon dies
S51-LTD	308 HS taps & 327 carbon dies
S51-ULTRA	308 HS taps & 328 HS dies

Note: Plug style taps supplied as standard in all sets.



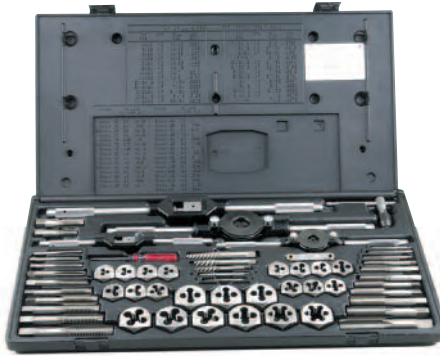
Tap & Die Sets Tap Kits Die Sets



Contractor Tap & Die Sets



EDP No.	Description
CS40P	302 taps & CS30 dies
302 plug taps / CS30 hex dies: 4-40, 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 1/8-27 NPT pipe tap and die.	
Accessories: die stock, 2 tap wrenches, screw pitch gauge and screwdriver in molded plastic case.	



EDP No.	Description
CS60P	302 taps & CS30 dies
302 plug tap / CS30 hex die: 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 9/16-12, 9/16-18, 5/8-11, 5/8-18, 3/4-10, 3/4-16: X1#1 thru #5 screw extractors; 304-1/8-27 NPT, 304-1/4-18NPT pipe taps; CS30- 1/8-27NPT, CS30-1/4-18NPT pipe die.	
Accessories: 2001-6 (1/2-3/4) bar tap wrenches; 3292x1, 3292x1-7/16 die stocks; 2002-1 (#4-1/4) T-handle tap wrench; screw pitch gauge; screwdriver.	



EDP No.	Description
CS40MP	302M taps & CS30M dies
Carbon taps and hex dies in metric sizes: 3x.5, 3x.6, 4x.7, 4x.75, 5x.8, 5x.9, 6x1.0, 7x1.0, 8x1.25, 9x1.0, 9x1.25, 10x1.25, 10x1.5, 11x1.5, 12x1.5, 12x1.75; 1/8-28BSP pipe tap, 1/8-28BSP pipe die.	
Accessories: die stocks, tap wrenches, metric screw pitch gauge and screwdriver.	



EDP No.	Description
CS107P	302 taps & CS30 dies 302M taps & CS30M dies
Contains all the items listed in CS60P plus 1 each:	
302M plug tap / CS30M hex die: 3x.6, 4x.7, 4x.75, 5x.8, 5x.9, 6x1.0, 7x1.0, 8x1.25, 9x1.0, 9x1.25, 10x1.25, 10x1.5, 11x1.5, 12x1.5, 14x1.25, 14x2.0, 16x1.5, 16x2.0, 18x1.5, 18x2.5; 304-1/8-28BSP, 304-1/4-19BSP pipe taps; CS30-1/8-28BSP, CS30-1/4-19BSP pipe die.	
Accessories: metric screw pitch gauge.	

Tap Kits in Metal Boxes



Conveniently organizes the most popular high speed taps in a durable steel case which fits any toolbox. The Tap Kit isolates each tap, which prevents chipping.

EDP No.	Description
308-10C	10 Piece 308 1/4 -1/2
321-10C	10 Piece 321 1/4 -1/2
XL22-10C	10 Piece XL22 1/4 -1/2
XL22T-10C	10 Piece XL22T 1/4 -1/2
308-19C	19 Piece 308 #0 - #12
321-19C	19 Piece 321 #0 - #12
TK10-MT	10 Piece tap empty case
TK19-MT	19 Piece tap empty case

Hexagon Die Sets



EDP No.	Description
330-10NC	10 Piece 1/4 - 1 NC
330-10NF	10 Piece 1/4 - 1 NF
330-20	20 Piece 1/4 - 1 NC/NF
330-20M	4-27mm 330M dies



Multi Step Drill Sets



EDP No.	Description
MSD-SET	1 Piece each MSD - 1/2x1/8, 1/2x3/16, 3/4x1/4

Carbide Bur Kits



EDP No.	Description
BK8P	Industrial Series 8 Piece Bur Kit in Plastic Case: SA5, SC3, SC5, SD5, SF3, SF5, SG3, SL4
BK8P-RE	Automotive Series 8 Piece Bur Kit in Plastic Case: SA3, SA5, SC1, SC3, SD1, SD3, SF3, SF5
US-BK8P	Contractor Series 8 Piece Bur Kit in Plastic Case: USA5, USC3, USC5, USD5, USF3, USF5, USG3, USL4
BK5PT-NF	Non-Ferrous 5 Piece Bur Kit in Plastic Case: SA5NF, SC3NF, SF3NF, SC5NF, SD5NF

SA80 Reamer Set



EDP No.	Description
SA80-SET	3 Piece SA80: 1/2, 5/8 & 3/4
SA80P-SET4	4 Piece SA80: 3/8, 1/2, 5/8 & 3/4

Hex Shank Multi Step Drill Sets



EDP No.	Description
MSD-HEX-SET	1 Piece each MSD-HEX-1, MSD-HEX-3, MSD-HEX-4 and QCD
ELEC-KIT	1 Pc. ea MSD-HEX-13, CT3-7/8, CT3-1-1/8, CT3-1-3/8 and QCD

Adjustable Hand Reamer Sets



EDP No.	Description
900-9	4 Piece 1/4 - 3/8
900-44	11 Piece 15/32 - 1-1/2
900-45	8 Piece 15/32 - 1-1/16
900-46	3 Piece 3/8 - 15/32

Sheet Metal Cutter Sets



EDP No.	Description
SMC-SET-1	13 Piece set includes SMC Sheet Metal Cutters 1/4 to 3/4", Arbor, Pilot, Hex Key, Washers and Center Punch
SMC-SET-2	12 Piece set includes SMC Sheet Metal Cutters 13/16 to 1-1/2", Arbor, Pilot, Hex Washer, Center Punch and Hex Keys



CT3 Hole Cutter Set



EDP No.	Description
ELEC-KIT	MSD-HEX-13, CT3-7/8, CT3-1-1/8, CT3-1-3/8 and QCD in plastic case
CT3P-SET-1	7/8 (2ea.), 1-1/8 (2ea.), 1-3/8 and QCD in plastic case
CT3P-SET-2	MSD-HEX-13, CT3-7/8, CT3-1-1/8, CT3-1-3/8 and QCD in plastic case

CT5 Hole Cutter Set



EDP No.	Description
CT5P-SET-A	3 Piece Set: 7/8, 1-1/8, 1-3/8, pilot & spring in plastic case
CT5P-SET-B	6 Piece Set: 7/8, 1-1/8, 1-3/8, 1-3/4, 2, 2-1/2, pilot & spring in plastic case
CT5P-SET-1	5 Piece Electrical Conduit Set: 7/8, 1-1/8, 1-3/8, 1-3/4 and 2 in plastic case
CT5P-CONDUIT-1	7 Piece Electrical Conduit Set: 7/8, 1-1/8, 1-7/32, 1-3/8, 1-3/4, 2, 2-1/2 in plastic case

CT5 Master Electrician Set



EDP No.	Description
CT5P-ELECTRICAL-1	10 Piece Master Electrical Set: 7/8, 1-1/8, 1-3/8, 1-3/4, 2, 2-1/2, 3, 3-5/8, 4-1/8 and 4-1/2 in plastic case

CT7 Plumbers Set



EDP No.	Description
CT7P-PLUMBER-1	6 Piece Plumber Set: 3/4, 7/8, 1-1/8, 1-1/2, 1-3/4, 2-1/4 in plastic case
CT7P-PLUMBER-2	12 Piece Plumber Set: 3/4, 7/8, 1-1/8, 1-1/2, 1-3/4, 2-1/4, 2-9/16, 3, 3-1/2, 4, 4-1/4, 4-1/2 in plastic case

CT7 Hole Cutter Set



EDP No.	Description
CT7P-SET-4	5 Piece General Maintenance Set: 5/8, 3/4, 7/8, 1 and 1-1/8 in plastic case
CT7P-SET-5	5 Piece Bolt Clearance Set: 9/16, 11/16, 13/16, 15/16 and 1-1/16 in plastic case
CT7P-SET-6	5 Piece Electrical Conduit Set: 7/8, 1-1/8, 1-3/8, 1-3/4 and 2 in plastic case
CT7P-SPRINKLER-SET	1-3/16, 1-1/4, 1-1/2, 1-3/4, 2 and 2-1/8 in plastic case

CT7 Master Electrical and Mechanical Sets



EDP No.	Description
CT7P-MECHANICAL-1	12 Piece Master Mechanical Set: 5/8, 3/4, 7/8, 1, 1-1/8, 1-1/4, 1-3/8, 1-1/2, 1-3/4, 2, 2-1/2 and 3 in plastic case
CT7P-ELECTRICAL-1	10 Piece Master Electrical Set: 7/8, 1-1/8, 1-3/8, 1-3/4, 2, 2-1/2, 3, 3-5/8, 4-1/8, 4-1/2 in plastic case

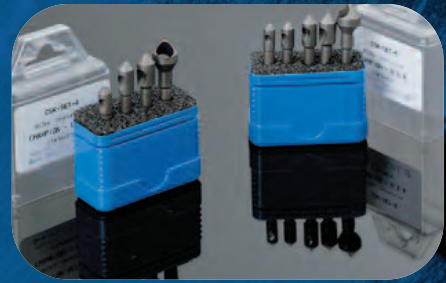
CT7/CT9 Lockset Kit



EDP No.	Description
CT9P-DOOR-SET	CT7-7/8, CT7-1, CT9-1-1/2, CT9-2-1/8 in plastic case



Countersink Sets Annular Cutter Sets PTC Diamond Cutter Sets SDS Plus Bit Sets



Zero Flute Countersink Sets



EDP No.	Description
CSK-SET-1	82° CSK5S, CSK6S, CSK8S, CSK10S, CSK8-1, CSK10S-1, CSK12-1, CSK14-1, CSK16-1, Pilots w/basic diameters
CSK-SET-2	82° CSK5S, CSK6S, CSK8S, CSK10S, CSK8-2, CSK10S-2, CSK12-2, CSK14-2, CSK16-2, Pilots w/1/64 oversize diameters
CSK-SET-3	82° CSK5S, CSK6S, CSK8S, CSK10S
CSK-SET-4	82° CSK6S, CSK8S, CSK10S, CSK18
CSK-SET-5	CSK5S, CSK6S, CSK8S, CSK10S, CSK18
CSK-SH-SET	CSK-3SH, CSK-8SH, CSK-18SH

6 Piece Annular Cutter Sets



Includes 9/16, 11/16, 13/16, 15/16, 1-1/16 & Pilot Pin

EDP No.	Description
XL100-SET	1 inch depth of cut
XL100T-SET	1 inch depth of cut TiN coated
XL200-SET	2 inches depth of cut
XL200T-SET	2 inches depth cut TiN coated

3 Piece Annular Cutter Sets



Includes 13/16, 15/16, 1-1/16 & CT150P Pilot Pin

EDP No.	Description
CT150-SET	Carbide Tipped. 1-3/8 inch depth of cut

Diamond Mini Hole Cutter Set



EDP No.	Description
PTC3-SET-5	5 Piece -3/16, 1/4 (2), 5/16 & 3/8"

Multi-Purpose Bit Sets



EDP No.	Description
CM-MPB-SET	5 Piece: 1/8x6, 5/32x6, 3/16x6, 1/4x6, 5/16x6
CM-MPB-SET7	7 Piece: 1/8x6, 5/32x6, 3/16x6, 1/4x6, 5/16x6, 3/8x6, 1/2x6

SDS Plus Bit Sets



EDP No.	Description
CM95X-SET5	CM95X - 3/16, 1/4, 5/16, 3/8, 1/2
CM95-SET5	CM95 - 3/16, 1/4, 5/16, 3/8, 1/2
CM9-SET5	CM9 - 3/16, 1/4, 5/16, 3/8, 1/2
CM95-SET7-LTD	CM95 - 5/32, 3/16, 1/4, 3/8, 1/2 CM95X - 1/4, 3/8
CM95-SET7	CM95 - 5/32, 3/16, 1/4 (2), 3/8 (2), 1/2

Deburring Tool Sets



EDP No.	Description
DCB-SET	60° DCB6, DCB8, DCB14, DCB18, DCB26, DCB36
DBK-SET	90° DBK6, DBK8, DBK14, DBK18, DBK26, DBK36



Wood Boring Bit Set



EDP No.	Description
8001-SET	3/8, 1/2, 5/8, 3/4, 7/8 and 1 Flat wood bits.

Brute Platinum Drill Dispensers



EDP No.	Description
D1-XL5	264 Piece Fractional Drills
D2-XL5	720 Piece Wire Gauge Drills
D3-XL5	258 Piece Letter Drills
D4-XL5	1242 Pc. Fractional, Wire & Letter
D1-XL8	1.0 mm - 13.0 mm Metric Drills
D1-XL5-LTD	126 Piece Fractional Drills

Drill Displays



One package of each size 1/16 thru 1/2 x 64ths

EDP No.	Description
DIS-705	705 Black HSS Drills
DIS-705C	705C Cobalt HSS Drills
DIS-705SP	705SP Split Point Drills
DIS-700T	700T TiN Coated Drills
DIS-XL28	XL28 Brute Mechanics Drills
DIS-XL5	XL5 Brute Platinum Drills
DIS-XG0	XG0 BlackGold Drills
DIS-US5	US5 Black Contractor Drills
DIS-MT	Countertop Empty Drill Display

Taper Shank Drill Dispenser



EDP No.	Description
D1-702	702 Drills from 1/8 thru 1
D1-702-MT	702 Empty Dispenser

Empty Metric Drill Dispensers



EDP No.	Description
DM1	Dispenser for 1 - 13mm x 0.5mm
DM2	Dispenser for 1 - 6.9mm x 0.1mm

Empty Drill Dispensers

EDP No.	Description
D1	3 Drawer for Fractional Drills 1/16 thru 1/2 x 64ths
D2	4 Drawer for Wire Gauge Drills #1 thru #60
D3	3 Drawer for Letter Size Drills A thru Z
D4	4 Drawer for Fractional Wire Gauge and Letter Drills

Empty Tap Dispensers

EDP No.	Description
TDC-1	3 Drawer for Fractional Taps 1/4 thru 1
TDC-2	5 Drawer for Machine Screw Taps #2 thru #12

DISTRIBUTOR SUPPORT



Merchandising

One of the best ways to enhance your showroom, regardless of space limitations is with display modules and signage. Tap into our expertise and we will help mix and match the right cutting tool modules to cater to the professionals, industries, markets or trades you serve.

- 35 Display Modules Available (see full list opposite)
- Retro Counter Top Drill Displays
- iPac Individual Product Packaging System
- RollFlex Standing Display
- Vertical/Horizontal Header Cards
- Decimal Card Holders



Product Resources

Champion provides the following extensive product and technical resources so you can learn more about our cutting tools.

- Product Literature
- Product Videos
- Technical Documentation
- Speed & Feed Calculators
- FAQ Database
- Highly trained customer service staff

For further information on any of our products or services, or to find the nearest distributor, please contact your Champion sales representative or customer service at 516-536-8200.

DISPLAY MODULES

EDP No.	Description
DIS-XL5	264 Piece XL5 1/16" thru 1/2" Brute Platinum Jobber Drills
DIS-XL28	264 Piece XL28 1/16" thru 1/2" Brute Platinum Mechanics Length Drills
DIS-XG0	264 Piece XG0 1/16" thru 1/2" Black Gold Drills
DIS-CT150M	14 Piece CT150 9/16" thru 1-1/16" Carbide Tipped Annular Cutters and Pilot Pins
DIS-CT200M	14 Piece CT200 9/16" thru 1-1/16" Carbide Tipped Annular Cutters and Pilot Pins
DIS-RBM	24 Piece XL100 and XL200 1/2" thru 1-1/16" HSS Annular Cutters and Pilot Pins
DIS-CT3M	14 Piece CT3 5/8" thru 1-3/8" Carbide Tipped Hole Cutters (Sheet Metal) and Pilot
DIS-CT5M	16 Piece CT5 9/16" thru 2" Carbide Tipped Hole Cutters (Thin Steel) and Pilot
DIS-CT7M	15 Piece CT7 5/8" thru 2" Carbide Tipped Hole Cutters (Thick Steel) and Pilot
DIS-SA80M	15 Piece SA80 3/8" thru 1" Car Reamers
DIS-TWISTER-XL5	12 Piece XL5 Twister Sets
DIS-TWISTER-XL28	12 Piece XL28 Twister Sets
DIS-TWISTER-XG0	12 Piece XG0 Twister Sets
DIS-COUNTERSINK	90 Piece 82° HS countersinks: CSK zero flute, 799 3 flute and XL801 single flute.
DIS-BUR-IPAC	36 Piece Double Cut Burs
DIS-USBUR-IPAC	36 Piece Uncoated Burs
DIS-MSDM	21 Piece Multi-Step Drills
DIS-CM-MPB	90 Piece CM-MPB Multi-Purpose Bits
DIS-CM-MPB-2	96 Piece CM-MPB Multi-Purpose Drill Bits, 1/8" thru 1/2", CM-MPB-SET5(6), CM-MPB-SET7(6)
DIS-CM95X	54 Piece CM95X Solid Head SDS Plus Hammer Bits
DIS-CM95	83 Piece CM95 SDS Plus Hammer Bits
DIS-CM96	26 Piece CM96 SDS Max Hammer Bits, 1/2" thru 1-1/2"
DIS-CM97	36 Piece CM97 Spline Hammer Bits, 3/8" thru 1"
DIS-CM98	17 Piece CM98 Spline Hammer Bits - QX Head
DIS-PTC3	44 Piece PTC3 3/16" thru 1-3/8" Diamond Drills
DIS-PTC4	21 Piece PTC4 3/4" thru 4" Multi Purpose Hole Cutters
DIS-CM79	2 Piece CM79 Shank Rotary Rebar Cutters, 2 each of sizes 1/2" thru 1-1/8"
DIS-CM89HC	19 Piece CM89 Hammer Core Drills, 1 each core drills 1-3/4" thru 5", 6" center drills, SDS-Max and Spline adaptors.
DIS-DT22HEX-10-iPac	55 Piece Set DT22HEX Combination Drill and Tap, #6-32 thru 1/2"-13
DIS-DT22HEX-15-iPac	65 Piece Display DT22HEX Combination Drill and Tap, #6-32 thru 1/2"-13
06450	144 Piece iPac XL5 Brute Platinum Jobber Drill Merchandiser
06510	144 Piece iPac XL28 Brute Platinum Mechanics Drill Merchandiser
06480	144 Piece iPac XG0 Black Gold Jobber Drill Merchandiser
06540	180 Piece iPac XL5/308 & X1/XL5LH Merchandiser
06565	180 Piece iPac XG0/308 & X1/XL5LH Merchandiser

iPac Packaging



The Champion iPac system provides you with professional grade cutting tools in individual packs. The iPac range includes twist drills, taps, and screw extractors.

Twist Drills

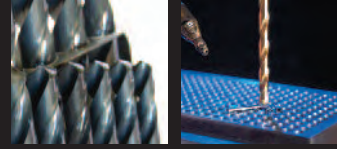
Individual and twin packs available in 29 sizes from 1/16" thru 1/2".

Combination Taps and Drills

Combination packs available in 10 separate application packs from tap size 6-32 thru 1/2-13 with corresponding drill size.

Combination Screw Extractors and Left Hand Drills

Combination screw extractor/twist drill packs available from #1 thru #5.



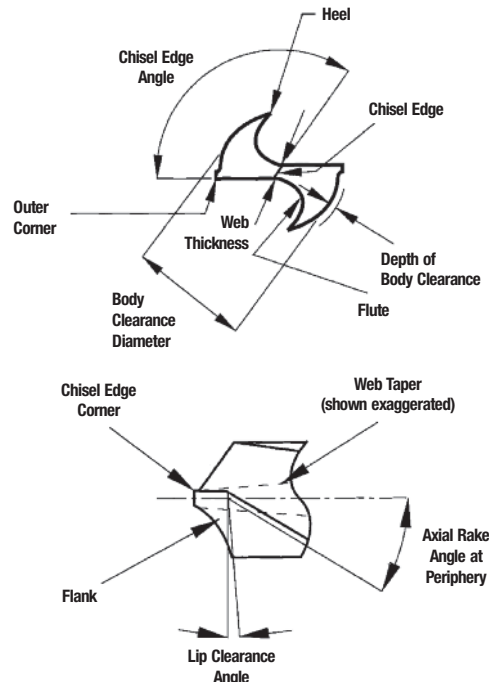
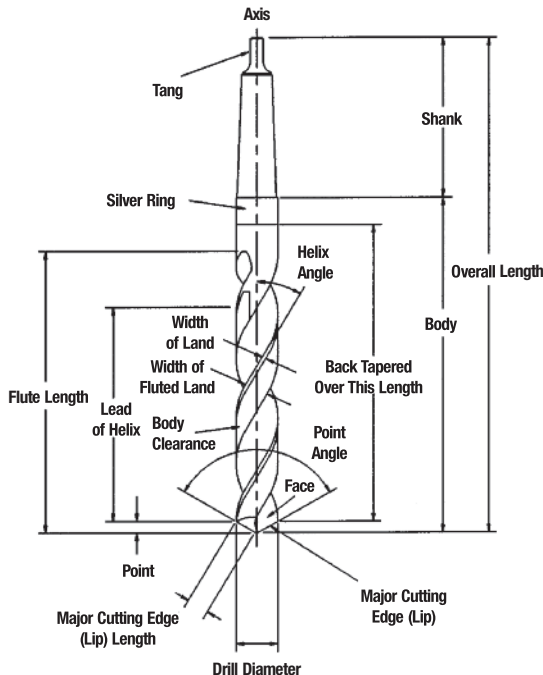
Technical Tips / Drills

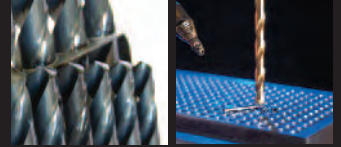
1. The most common mistake when drilling is to over-speed and under feed the tool. This will generate excess heat at the cutting edge, prematurely dulling the drill. Brute drills are designed to be fed heavily. If speed is increased an increase to feed is also appropriate. This will ensure that a "healthy" chip is being formed, and you will achieve good drilling results.
2. The workpiece must be held rigid and the machine spindle should have no play.
3. The chuck in which a straight shank drill is held must be good quality. If the drill slips in the chuck and the feed is automatic, breakage of the drill may occur.
4. Use recommended lubricants to enhance the life of the drill and ensure that the lubricant always reaches the drill point.
5. Do not allow the flutes of a drill to become choked with chips, especially in the holes. When drilling deeper than 4 x diameter, withdrawal of the drill to clear chips may be required.
6. When the drill is reground ensure that all wear is removed and check that the correct point geometry is produced. Always keep drills sharp; frequent regrinding is good economy.

When drilling a particular material at a given speed and feed, the drill's performance is governed by its quality and the following other important factors:

- MATERIAL BEING DRILLED
- DEPTH OF HOLE
- THROUGH OR BLIND HOLE
- COOLANT USED
- CONDITION OF THE MACHINE
- MACHINE POWER CAPACITY
- CHOICE OF TOOL HOLDING
- STABILITY OF WORK HOLDING
- HORIZONTAL OR VERTICAL DRILLING
- STATIONARY OR REVOLVING DRILL
- CHIP CONTROL

Drill Nomenclature





Trouble Shooting / Drills

1. OUTER CORNERS BREAK DOWN.

Cutting Speed too high / Hard spots in material / No cutting fluid at drill point / Flutes clogged with chips / Drill was used to enlarge an existing hole - Reamer should be used to enlarge holes.

2. CUTTING LIPS CHIPPED

Too much feed / Lip relief too great / Drill was used to enlarge an existing hole - Reamer should be used to enlarge holes.

3. CHECKS OR CRACKS IN CUTTING LIPS

Overheated or too quickly cooled while sharpening or drilling.

4. MARGIN CHIPS

Oversize jig bushing

5. DRILL BREAKS

Point improperly ground / Feed too heavy / Spring or back lash in drill press, fixture or work / Drill is dull / Flutes clogged with chips.

6. TANG BREAKS

Imperfect fit between taper shank and socket caused by dirt or chips, or burred or badly worn sockets.

7. DRILL BREAKS WHEN DRILLING BRASS OR WOOD

Flutes clogged with chips / Improper type of drill

8. DRILL SPLITS UP CENTER

Lip relief too small / Too much feed

9. DRILL WILL NOT ENTER WORK

Drill is dull / Lip relief is too small / Too heavy a web

10. HOLE ROUGH

Point improperly ground or dull / No cutting compound at drill point / Improper cutting fluid / Feed too great / Fixture not rigid

11. HOLE OVERSIZE

Unequal angle or length of the cutting edges - or both / Loose spindle

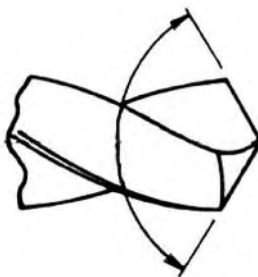
12. CHIP SHAPE CHANGES WHEN DRILLING

Drill becomes dull or cutting lips chipped

13. LARGE CHIP COMING OUT OF ONE FLUTE, SMALL CHIP OUT OF THE OTHER

Point incorrectly ground, one lip is doing all the cutting.

Drill Tip Geometry



118° Conventional Point

- General use
- Not self centering
- For stationary drills
- performs better in softer materials than hard metal

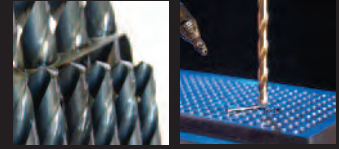


135° Split Point

- Self centering (won't walk)
- For portable drills
- For harder materials
- Requires less force than 118°



TECHNICAL Drills



Material Application Chart

Material	Carbon Steel			Alloyed Steels			Steel Drop Forgings Heat Treated			Grey Cast Iron		
	Low	Medium	High							Soft	Medium	Hard
Hardness Brinell	85-125	125-175	175-225	<200	200-300	>300	330-370	370-420	>420	85-125	125-175	175-225
Hardness RC	-	1-9	9-22	<16	16-39	>39	35-40	40-44	>44	-	1-9	9-22
SFM	80-95	70-85	45-65	60-90	40-70	20-30	30-40	20-30	10-20	80-95	70-85	45-65

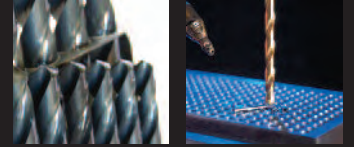
Product Categories - Best / Better / Good Suitability

BRUTE -	Best	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5
	Better												
	Good												
SCREW - MACHINE	Best	1705	1705	1705C	1705	1705C	1705C	1705	1705C	1705C	1705	1705C	1705C
	Better			1705		1705						1705	1705
	Good			2905		2905						2905	2905
JOBBER -	Best	700T	700T	700T	700T	700T	705C	705C	705C	705C	700T	700T	700T
	Better	XG0	XG0	705SP	XG0	705SP					XG0	705SP	705SP
	Good	US5	US5	705P	US5	705P					US5	705P	705P
JOBBER - (METRIC)	Best	708	708	708	708	708					708	XL8	XL8
	Better	XL8	XL8	XL8	XL8	XL8					XL8	708	708
	Good						XL8	XL8	XL8	XL8			
JOBBER - (LEFT HAND)	Best	705LH	705LH	XL5LH	705LH	XL5LH					705LH	XL5LH	XL5LH
	Better	XL5LH	XL5LH	705LH	XL5LH	705LH	XL5LH	XL5LH	XL5LH	XL5LH	XL5LH	705LH	705LH
	Good						705LH	705LH	705LH	705LH			
MECHANICS -	Best	XL28	XL28	XM28	XM28	XM28					XL28	XM28	XM28
	Better						XL28	XL28	XL28	XL28			
	Good						XM28	XM28	XM28	XM28			
3/8 SHANK -	Best	XG38	XG38	XL38	XG38	XL38					XG38	XL38	XL38
	Better	738	738	XG38	738	XG38	738	XL38	XL38	XL38	738	XG38	XG38
	Good			738		738	XG38	XG38	XG38	XG38		738	738
S&D -	Best	XL12	XL12	712C0	XL12	712C0	712C0	712C0	712C0	712C0	XL12	712C0	712C0
	Better	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12
	Good	712	712	US12	712	US12	712	712	712	712	712	US12	US12
TAPER - LENGTH	Best	704	704	704	704	704	704	704	704	704	704	704	704
	Better												
	Good												



CHAMPION

TECHNICAL Drills



Material Application Chart

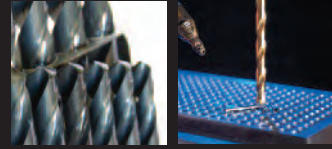
Material Level	Titanium			Stainless Steel			Steel		Steel		
	T175A	Ti150A-RS120	140A-RC-130B & Ti 6AL 4V	300	400	Matenistic 416, 420, 416 PlusK, 400F, 416SE 440F	Heat Resisting	Nimonic Alloys	Manganese	Spring Steels	Armor Plate
Hardness Brinell	300-440	300-440	300-440	120-220	200-300	135 thru 450	175-225	200-300	125-220	402	200-350
Hardness RC	33-46	33-46	33-46	1-16	16-33	1 thru 47	9-21	16-33	1-21	43	16-37
SFM	50-60	40-50	30-40	20-40	40-70	20 thru 50	10-25	10-20	10-12	15-30	30-40

Product Categories - Best / Better / Good Suitability

BRUTE -	Best	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5	XL5
	Better											
	Good											
SCREW -	Best	1705C	1705C	1705C	1705C	1705C	1705C	1705C	1705C	1705C	1705C	1705C
	Better									1705		
	Good									2905		
JOBBER -	Best	705C	705C	705C	705C	705C	705C	705C	705C	700T	705C	705C
	Better									705SP		
	Good									705P		
JOBBER - (METRIC)	Best									XL8		
	Better									708		
	Good	XL8	XL8	XL8	XL8	XL8	XL8	XL8	XL8		XL8	XL8
JOBBER - (LEFT HAND)	Best							XL5	XL5	XL5LH		
	Better	XL5LH	XL5LH	XL5LH	XL5LH	XL5LH	XL5LH			705LH	XL5LH	XL5LH
	Good	705LH	705LH	705LH	705LH	705LH	705LH			705LH	705LH	
MECHANICS -	Best									XM28		
	Better	XL28	XL28	XL28	XL28	XL28	XL28	XL28	XL28		XL28	XL28
	Good	XM28	XM28	XM28	XM28	XM28	XM28	XM28	XM28		XM28	XM28
3/8 SHANK -	Best									XL38		
	Better	XL38	XL38	XL38	XL38	XL38	XL38	XL38	XM38	XG38	XL38	XL38
	Good	XG38	XG38	XG38	XG38	XG38	XG38	XL38	XM38	738	XG38	XG38
S&D -	Best	712C0	712C0	712C0	712C0	712C0	712C0	712C0	712C0	XL12	712C0	712C0
	Better	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12	XG12
	Good	712	712	712	712	712	712	712	712	712	712	712
TAPER - LENGTH	Best	704	704	704	704	704	704	704	704	704	704	704
	Better											
	Good											



TECHNICAL Drills



Decimal Equivalents / Drill Sizes

Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.	Drill Size	Decimal Equiv.
80	.0135	36	.1065	D	.2460	13.5mm	.5315
79	.0145	7/64"	.1094	1/4" E	.2500	35/64"	.5469
1/64"	.0156	35	.1100	6.5mm	.2559	14.0mm	.5512
78	.0160	34	.1100	F	.2570	9/16"	.5625
77	.0180	33	.1130	G	.2610	14.5mm	.5709
.5mm	.0197	32	.1160	17/64"	.2656	37/64"	.5781
76	.0200	3.0mm	.1181	H	.2660	15.0mm	.5906
75	.0210	31	.1200	I	.2720	19/32"	.5938
74	.0225	1/8"	.1250	7.0mm	.2756	39/64"	.6094
73	.0240	30	.1285	J	.2770	15.5mm	.6102
72	.0250	29	.1360	K	.2810	5/8"	.6250
71	.0260	3.5mm	.1378	9/32"	.2812	16.0mm	.6299
70	.0280	28	.1405	L	.2900	41/64"	.6406
69	.0292	9/64"	.1406	M	.2950	16.5mm	.6496
68	.0310	27	.1440	7.5mm	.2953	21/32"	.6562
1/32"	.0312	26	.1470	19/64"	.2969	17.0mm	.6693
67	.0320	25	.1495	N	.3020	43/64"	.6719
66	.0330	24	.1520	5/16"	.3125	11/16"	.6875
65	.0350	23	.1540	8.0mm	.3150	17.5mm	.6890
64	.0360	5/32"	.1562	O	.3160	45/64"	.7031
63	.0370	22	.1570	P	.3230	18.0mm	.7067
62	.0380	4.0mm	.1575	21/64"	.3281	23/32"	.7188
61	.0390	21	.1590	Q	.3320	18.5mm	.7283
1.0mm	.0394	20	.1510	8.5mm	.3346	47/64"	.7344
60	.0400	19	.1660	R	.3390	19.0mm	.7480
59	.0410	18	.1695	11/32"	.3438	3/4"	.7500
58	.0420	11/64"	.1719	S	.3480	49/64"	.7656
57	.0430	17	.1730	9.0mm	.3543	19.5mm	.7677
56	.0465	16	.1770	T	.3580	25/32"	.7812
3/64"	.0469	4.5mm	.1772	23/64"	.3594	20.0mm	.7874
55	.0520	15	.1800	U	.3680	51/64"	.7969
54	.0560	14	.1820	9.5mm	.3740	20.5mm	.8071
1.5mm	.0591	13	.1850	3/8"	.3750	13/16"	.8125
53	.0595	3/16"	.1875	V	.3770	21.0mm	.8268
1/16"	.0625	12	.1890	W	.3860	53/64"	.8281
52	.0635	11	.1910	25/64"	.3906	27/32"	.8438
51	.0670	10	.1935	10.0mm	.3937	21.5mm	.8465
50	.0700	9	.1960	X	.3970	55/64"	.8594
49	.0730	5.0mm	.1969	Y	.4040	22.0mm	.8661
48	.0760	8	.1990	13/32"	.4062	7/8"	.8750
5/64"	.0781	7	.2010	Z	.4130	22.5mm	.8858
47	.0785	13/64"	.2031	10.5mm	.4134	57/64"	.8906
2.0mm	.0787	6	.2040	27/64"	.4219	23.0mm	.9055
46	.0810	5	.2055	11.0mm	.4331	29/32"	.9062
45	.0820	4	.2090	7/16"	.4375	59/64"	.9219
44	.0860	3	.2130	11.5mm	.4528	23.5mm	.9252
43	.0890	5.5mm	.2165	29/64"	.4531	15/16"	.9375
42	.0935	7/32"	.2188	15/32"	.4688	24.0mm	.9449
3/32"	.0938	2	.2210	12.0mm	.4724	61/64"	.9531
41	.0960	1	.2280	31/64"	.4844	24.5mm	.9646
40	.0980	A	.2340	12.5mm	.4921	31/32"	.9688
2.5mm	.0984	15/64"	.2344	1/2"	.5000	25.0mm	.9843
39	.0995	6.0mm	.2362	13.0mm	.5118	63/64"	.9844
38	.1015	B	.2380	33/64"	.5156	1"	1.000
37	.1040	C	.2420				



Technical Tips / Taps

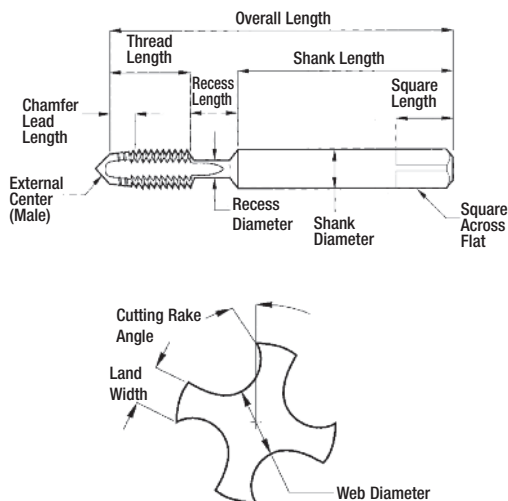
Spiral point taps

Spiral point taps have straight, shallow flutes and are often referred to as "gun" taps. The gun nose or spiral point is designed to drive the chips forward. The relatively shallow flutes ensure that the sectional strength is maximized. They also act to allow lubricant to reach the cutting edges. This type of tap is recommended for threading through holes and may be used in blind hole applications where there is sufficient space to accommodate the chips.

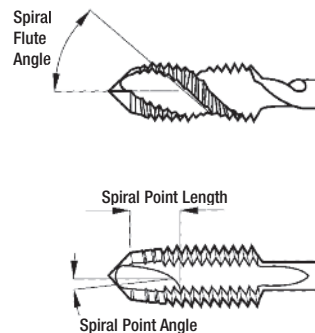
General hints on Tapping

1. Select the correct design of tap for the component material and type of hole, i.e. through or blind.
2. Ensure the component is securely clamped, lateral movement may cause tap breakage or poor quality threads.
3. Size matters. For optimal performance it is important to use the right size drill before tapping.
Please call 800-645-3957 to order a free Champion decimal equivalency card (DC-1) card.
4. Select the correct cutting speed.
5. Use appropriate cutting fluid for correct application.
6. In CNC applications ensure that the pitch value chosen for the program is correct. When using a tapping attachment, 95% to 97% of the pitch is recommended to allow the tap to generate its own pitch.
7. Where possible hold the tap in a good quality torque limiting tapping attachment, which ensures free axial movement of the tap and presents it squarely to the hole. It also protects the tap from breakage if accidentally "bottomed" in a blind hole.
8. Ensure smooth entry of the tap into the hole, as an uneven feed may cause "bell mouching".

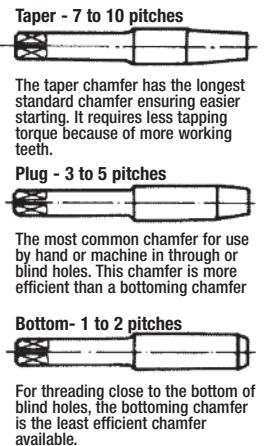
Tap Nomenclature



Spiral Tap Nomenclature

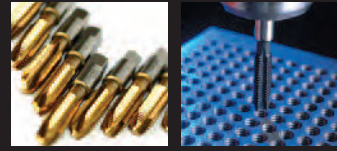


Tap Chamfers





TECHNICAL Taps

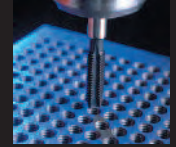


Trouble Shooting / Taps		
TROUBLE	PROBABLE CAUSES	REMEDY
Breakage	<p>Hole too small</p> <p>Tap Hitting Bottom</p> <p>Misalignment</p> <p>Tapping too deep</p> <p>Dull tap</p> <p>Cramped condition</p>	<p>Use correct drill size</p> <p>Consult Tap Drill Chart</p> <p>Correct adjustment</p> <p>Exercise more care</p> <p>Use positive reverse</p> <p>Drill hole deeper</p> <p>Make correction</p> <p>Use spiral point or serial taps</p> <p>Sharpen tap</p> <p>Check tap holder and alignment</p>
Chipping	<p>Inadequate lubrication</p> <p>Hitting bottom of hole or chips packed in bottom of hole</p> <p>Hard spots in work</p> <p>Loading</p>	<p>Consult lubrication chart if lubrication engineer</p> <p>Check reversing stop</p> <p>Drill hole deeper</p> <p>Check hole for work hardening</p> <p>Check lubrication / Use surface treated taps</p>
Torn or Rough Threads	<p>Incorrect hook, relief, or chamfer</p> <p>Inadequate lubrication</p> <p>Dull tap</p> <p>Loading</p>	<p>Grind correctly</p> <p>Increase flow - see that it is getting into the hole</p> <p>Resharpen tap</p> <p>Use surface treated taps / check lubrication</p>
Tapping Oversize or Bell-Mouth Holes	<p>Loose spindle or worn holders</p> <p>Misalignment</p> <p>Excessive thrust</p> <p>Loading</p>	<p>Repair machine, tap holders or work holders</p> <p>Correct condition</p> <p>Adjust pressure if air driven / use more care if manual</p> <p>Use surface treated taps</p>
Excessive Wear	<p>Inadequate lubrication</p> <p>Sand in cored holes</p> <p>Abrasive material</p>	<p>Check lubrication engineer</p> <p>Clean hole before tapping</p> <p>If Bakelite, etc : use oversize tap with surface treatment</p>



CHAMPION

TECHNICAL Taps



Tap Drill Sizes

Tap Size	Tap Drill Size	Prob % of Thread	Tap Size	Tap Drill Size	Prob % of Thread
0-80	56	74	3/8-24	Q	75
	3/64	71		8.5mm	70
1-64	54	81	7/16-14	U	75
	53	59	7/16-20	W	75
1-72	1.50mm	68		25/64"	68
	53	67	1/2-13	27/64"	75
2-56	51	74		11.0mm	64
	50	62	1/2-20	11.4mm	74
2-64	50	70		29/64"	67
	49	56	9/16-12	15/32	84
3-48	48	78		31/64"	69
	5/64"	70	9/16-18	1/2	82
3-56	46	69		33/64"	60
	45	56	5/8-11	17/32	76
4-40	44	74		35/64"	63
	43	65	5/8-18	9/16	82
4-48	2.35mm	72		37/64	60
	42	61	11/16-11	19/32	75
5-40	39	71	11/16-16	5/8"	75
	38	65	3/4-10	41/64"	81
5-44	38	72		21/32"	69
	37	63	3/4-16	11/16"	72
6-32	36	72		17.5mm	70
	7/64"	64	7/8-9	49/64"	73
6-40	33	69		25/32"	62
	32	60	7/8-14	51/64"	79
8-32	3.40mm	74		13/16"	62
	29	62	1-8	7/8"	74
8-36	29	70		57/64"	64
	9/64"	60	1-12	29/32"	82
10-24	3.70mm	76		59/64"	68
	25	69	1-14	59/64"	79
10-32	5/32"	75		15/16"	62
	21	68	1-1/8-7	63/64"	73
12-24	11/64"	75		1	65
	17	73	1-1/8-12	1-1/32"	82
12-28	16	77		1-3/64"	67
	15	70	1-1/4-7	1-3/32"	81
1/4-20	9	77		1-7/64"	73
	7	70		1-1/8"	64
1/4-28	13/64"	66	1-1/4-12	1-5/32"	81
	3	70		1-11/64	67
5/16-18	5.50mm	67	1-3/8-6	1-13/64	81
	F	72		1-19/64"	66
5/16-24	G	66	1-3/8-12	1-9/32"	81
	6.80mm	78		1-19/64	66
3/8-16	I	70	1-1/2-6	1-11/32"	69
	5/16"	74		1-23/64"	62
0	69	1-1/2-12	1-13/32"	80	
			1-27/64"	66	

Metric Tap Drill Sizes

Tap Size	Tap Drill Size	Prob % of Thread	Tap Size	Tap Drill Size	Prob % of Thread
1.6x.35	1.25mm	69	9.0x1.25	7.75mm	73
1.8x.35	1.45mm	69	10x1.5	8.50mm	71
2.0x.4	1.60mm	69		Q	75
	52	66	10x1.25	8.70mm	73
2.2x.45	1.75mm	70		11/32"	71
2.5x.45	2.05mm	69	11x1.5	9.50mm	70
	46	67		3/8"	71
3.0x2.5	2.50mm	68	12x1.75	10.20mm	74
	40	70		Y	71
3.5x6	2.90mm	68	12x1.25	10.80mm	67
	33	72		27/64"	72
4.0x.7	3.30mm	69	14x2.0	12.00mm	72
	30	73		15/32"	76
4.5x.75	3.70mm	74	14x1.5	12.50mm	71
	26	70	16x2.0	14.00mm	72
5.0x.8	4.20mm	69		35/64"	76
	19	68	16x1.5	14.50mm	71
5.5x.9	4.60mm	68	18x2.5	15.50mm	73
	14	67		39/64"	74
6.0x.75	5.30mm	74	18x1.5	16.50mm	70
	4	73	20x2.5	17.50mm	73
6.0x1.0	5.00mm	70		11/16"	74
	9	71	22x2.5	19.50mm	73
7.0x.75	6.30mm	74		49/64"	75
	D	72	24x3.0	21.00mm	73
7.0x1.0	6.00mm	70		53/64"	72
	15/64"	73	27x3.0	24.00mm	73
8.0x1.25	6.70mm	74		15/16"	78
	17/64"	71	30x3.5	26.50mm	74
8.0x1.0	7.00mm	69		1-3/64	73
	J	66	33x3.5	29.50mm	74
				1-11/64"	72

Pipe Tap Drill Sizes

Tap Size	NPT Tap Drill	NPS Tap Drill
1/16-27	D	1/4"
1/8-27	Q	11/32"
1/4-18	7/16"	7/16"
3/8-18	9/16"	37/64"
1/2-14	45/64"	23/32"
3/4-14	29/32"	59/64"
1-11-1/2	1-9/64"	1-5/32"
1-1/4-11-1/2	1-31/64"	1-1/2
1-1/2-11-1/2	1-47/64	1-3/4
2-11-1/2	2-13/64"	2-7/32
2-1/2-8	2-5/8"	2-21/32"



TECHNICAL

Carbide Burs

Carbide Tipped Hole Cutters



Carbide Bur Application & Speed Recommendations

SOLID CARBIDE BUR APPLICATION INFORMATION

Material Check List	Suitability	
	Double Cut	Non Ferrous
Aluminum		YES
Brass	YES	YES
Bronze	YES	
Cast Iron	YES	
Copper		YES
Carbon Fiber		YES
Fiberglass	YES	
Inconel	YES	
Magnesium		YES
Plastics	YES	
Hard Rubber	YES	
Steel - 45-55Rc	YES	
Steel - 55-60Rc	YES	
Steel - Carbon	YES	
Steel - Nickel Chrome	YES	
Steel - Stainless	YES	
Steel - Weldments	YES	
Titanium	YES	
Zinc		YES

SOLID CARBIDE BUR SPEED RECOMMENDATIONS

Bur Diameter	Recommended Cutting Speed (RPM)	Maximum Cutting Speed (RPM)
1/16	60,000 - 90,000	100,000
1/8	40,000 - 70,000	90,000
3/16	35,000 - 60,000	80,000
1/4	30,000 - 50,000	70,000
5/16	20,000 - 40,000	68,000
3/8	20,000 - 40,000	66,000
7/16	15,000 - 40,000	58,000
1/2	15,000 - 40,000	50,000
5/8	12,000 - 25,000	40,000
3/4	10,000 - 20,000	33,000
1	7,500 - 20,000	25,000
1-1/8	7,000 - 13,000	20,000
1-1/2	5,000 - 10,000	17,000
1-3/4	4,500 - 9,000	14,000
2	4,000 - 8,000	12,500

General Information on Bur Use

1. Do not use carbide burs in a portable drill motors. Portable Drill motors run at much lower speeds.
2. It may be recommended to adjust the bur speed as shown under maximum recommended operating speeds for optimum performance.

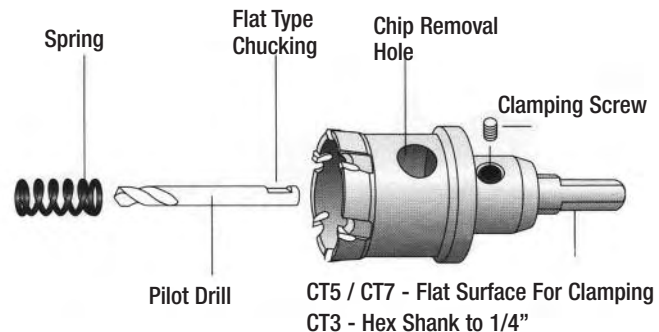
Use slower speeds for harder materials.
 Use higher speeds when using small burs.
 Use slower speeds when using long series burs.

3. Running burs below recommended speeds may cause chipping.
4. Do not use worn out tools and collets as they will also cause chipping.
5. Running burs too fast will cause teeth to wear prematurely.
6. Apply constant pressure and movements when in use.

Carbide Tipped Hole Cutters - CT3 / CT5 / CT7

SPEED RECOMMENDATIONS

Diameter	Steel	Stainless Steel
9/16 to 13/16	700 - 1000	300 - 700
7/8 to 1-3/16	500 - 800	200 - 450
1-1/4 to 1-9/16	300 - 600	175 - 315
1-5/8 to 2	200 - 500	120 - 225
2-1/16 to 2-3/8	200 - 400	95 - 195
2-7/16 to 3	150 - 300	80 - 150
3-1/16 to 6	100 - 200	60 - 120



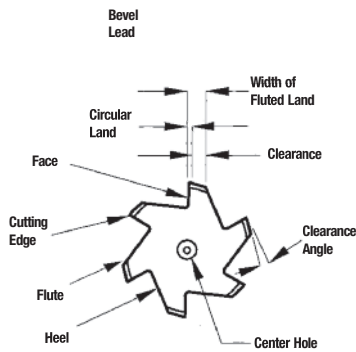
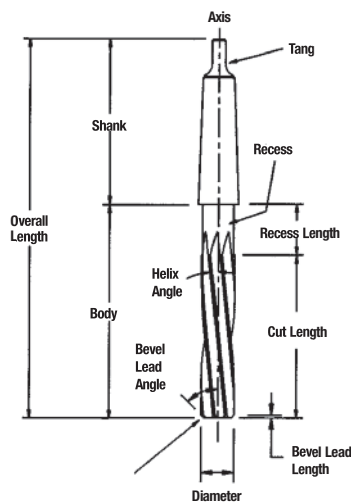


Technical Tips / Reamers

General Hints on Reaming

To obtain the best results when using reamers it is essential to make them "work". It is a common fault to prepare holes for reaming with too little stock left in. If insufficient stock is left in the hole before reaming then the reamer will rub, quickly show wear and will result in loss of diameter. It is equally important for performance not to leave too much stock in the hole.

1. Select the optimum type of reamer and the optimum speeds and feeds for the application. Ensure that pre-drilled holes are the correct diameter.
2. The workpiece must be held rigid and the machine spindle should have no play.
3. The chuck in which a straight shank reamer is held must be good quality. If the reamer slips in the chuck and the feed is automatic, breakage of the reamer may occur.
4. Keep tool overhang from machine spindle to a minimum.
5. Use recommended lubricants to enhance the life of the reamer and ensure the fluid reaches the cutting edges.
6. Do not allow the flutes of a reamer to become blocked with chips.
7. Keep reamers sharp. Frequent regrinding is good economy, but it is important to understand that reamers cut only on the bevel and taper leads and not on the lands. Consequently only these leads need regrinding. Accuracy of regrinding is important to hole quality and tool life.



Technical Tips / End Mills

General Hints on Milling

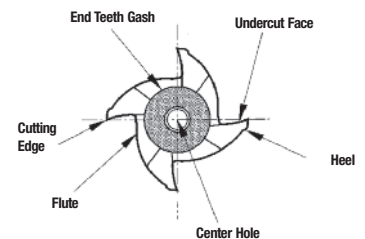
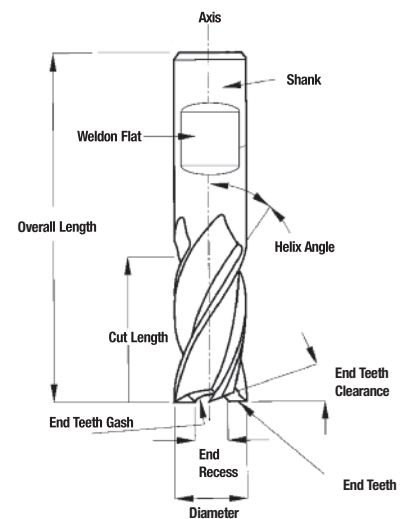
A liberal supply of cutting liquid (emulsion) should be used.

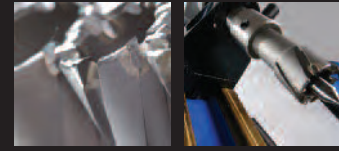
Adaptation to the machine tool

Conventional milling machines usually have a limited number of selectable speed and feed rates.

The recommendations made must therefore be adapted to the values applicable to the machine being used. Adaptation should be done so that the recommended rate of feed per tooth is changed as little as possible.

It is particularly important that the rate of feed per tooth does not increase for diameters < 3/8".





Annular Cutter Material and Speed Recommendations

Use the following table when using annular cutters in fixed machine tools.

Type of Material		Brinell Hardness	Cutting Speed (sfm)	Cutter Dia. Inches	Surface Feet per Minute									
					Revolutions per minute (RPM)									
					10	20	30	40	50	60	70	80	90	100
Aluminum	Wrought & Cast	*30-150	500-1000	.7500	51	102	153	204	255	306	357	407	458	509
	Die Cast 360.0, 380.0	*40-125	450-600	.8750	44	87	131	175	218	262	306	349	393	437
	383.0, 413.0 390.0, 392.0	*40-125 *40-125	450-600 75-100	1.0000	38	76	115	153	191	229	267	306	344	382
Brass & Bronze		-	300-600	1.1250	34	68	102	136	170	204	238	272	306	340
Cast Iron	Soft	120-150	75-125	1.2500	31	61	92	122	153	183	214	244	275	306
	Medium	160-220	50-100	1.3750	28	56	83	111	139	167	194	222	250	278
	Chilled	230-300	30-50	1.5000	25	51	76	102	127	153	178	204	229	255
Malleable Iron	Ferretic	110-160	100-130	1.6250	24	47	71	94	118	141	165	188	212	235
	Pearlitic	160-220	75-100	1.7500	22	44	65	87	109	131	153	175	196	218
	Temperature Martensite	200-320	30-60	1.8750	20	41	61	81	102	122	143	163	183	204
Magnesium		*50-90	8	2.0000	19	38	57	76	95	115	134	153	172	191
Nickel Alloys	200-230	80-170	60-80	2.1250	18	36	54	72	90	108	126	144	162	180
	Monel 400-404	115-240	35-50	2.2500	17	34	51	68	85	102	119	136	153	170
	Monel K500, 502	150-330	20-40	2.3750	16	32	48	64	80	96	113	129	145	161
Steel Free Machining		-	105-130	2.5000	15	31	46	61	76	92	107	122	138	153
Carbon Steel	10xx, 12xx, xx10, xx20	125-160	90-110	2.6250	15	29	44	58	73	87	102	116	131	146
Steel Alloys Soft		170-210	65-90	2.7500	14	28	42	56	69	83	97	111	125	139
Steel Alloys Medium		220-250	55-75	2.8750	13	27	40	53	66	80	93	106	120	133
Steel Alloys Hard		260-300 325-400	35-50 30-40	3.0000	13	25	38	51	64	76	89	102	115	127
Tool Steel		210-250	35-60	3.1250	12	24	37	49	61	73	86	98	110	122
Forgings		-	40-50	3.2500	12	24	35	47	59	71	82	94	106	118
Armor Plate		200-250 250-300	40-55 30-45	3.3750	11	23	34	45	57	68	79	91	102	113
Stainless Steel Ferritic	430/405	135-185	90-125	3.5000	11	22	33	44	55	64	76	87	98	109
	430F			3.6250	11	21	32	42	53	63	74	84	95	105
Stainless Steel Austenitic	Lower BHN	135-185	55-75	3.7500	10	20	31	41	51	61	71	81	92	102
	Higher BHN			225-275	40-70	3.8750	10	20	30	39	49	59	69	79
Stainless Steel Nitronic (Low Alloy)		275-325	25-35	4.0000	10	19	29	38	48	57	67	76	86	95
Stainless Steel Martensitic	By Hardness Range	135-185	70-125											
		501	45-110											
		416/440F	35-55											
Stainless Steel Hardening	By Hardness Range	150-200	45-55											
		17-4 PH	35-45											

Arbor Preparation

When using a drill press, ensure that a support system is in place for the arbor and that it is not worn out.

Surface Preparation

The material must be at least 3/8" thick. The machine's magnetic base must be clear of chips and debris and must be securely attached to a clean workpiece.

The magnet will be prevented from obtaining optimal holding power if it is used on an uneven surface or there is a large debris buildup. This may cause the drill to shift or lift during operation.

Pipe / Convex Surface Drilling

Champion magnetic drill presses can be used to drill such surfaces, but you need a support system. Champion stocks the RB-Saddle for such circumstances.

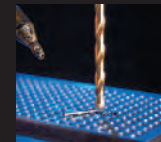
Machine Maintenance

For the best performance, always maintain your drill as instructed in your Champion machine operator's manual. Champion magnetic drill presses feature a slide/gibway system that requires periodic adjustments to maintain rigidity and optimal performance. Worn or damaged parts should be replaced to reduce the possibility of injury. Champion stocks a full range of replacement parts.

**CHAMPION**

TECHNICAL

BruteLube Fluid



BruteLube Fluid Material Data Sheet

IDENTIFICATION

Product Name: BruteLube

Chemical Family: Hydrocarbon Mixture

CAS#: Not Applicable to this mixture

Manufacturer: Champion Cutting Tool Corp, 10 Madison Avenue, Rockville Centre, NY 11570 Tel: (516) 536-8200

Emergency Phone Number: (800) 424-9300 CHEMTREC (Transportation Emergencies)

COMPOSITIONAL INFORMATION

Ingredients Exposure Limit

Severely Hydrotreated Naphthenic Distillate 5 mg/cubic meter (OSHA PEL 8 hour work day)

Paraffinic Distillate 5 mg/cubic meter (OSHA PEL 8 hour work day)

10 mg/cubic meter (ACGIH TLV/STEL)

Chlorinated Paraffin* Not established

Chlorinated Fatty Acid* Not established

*contains corrosion and stain inhibitor

PHYSICAL DATA

Flash Point (PM CC)Over 300 degrees Fahrenheit

Density (20 degrees C.) 7.7 pounds per gallon

Vapor Pressure (60 degrees F.) Less than Ether

ROUTE(S) OF EXPOSURE AND EFFECTS

Eye Contact: Contact with the eye may cause moderate irritation.

Skin Contact: Prolonged or repeated exposure may cause defatting of the skin resulting in moderate irritation.

Inhalation: Excessive exposures at elevated temperatures may cause irritation to eyes, nose, mucous membranes and the respiratory system. Excessive exposures may also cause dizziness and other central nervous system effects.

Ingestion: This product has a low order of acute toxicity. Pulmonary aspiration hazard if swallowed and vomiting occurs.

REACTIVITY

Reaction with water Non-reactive

Hazardous Polymerization Non-reactive

Stability Stable

Incompatible Materials Strong oxidizing and reducing agents.

Hazardous Decomposition Products Carbon dioxide, carbon monoxide, hydrogen chloride and oxides of sulfur.

PROTECTION INFORMATION

Respiratory: Use with adequate ventilation. Ventilate as needed to comply with exposure limit. In event of vapor concentrations exceeding the time weighted exposure limit use a NIOSH approved cartridge respirator or gas mask.

Skin: Impervious gloves are optional.

Eyes: Splash proof chemical goggles or face shield is optional.

SPILL OR LEAK PROCEDURES

Prevent ignition, stop leak, ventilate area, contain spill by diking or impounding. Add sand, earth, or other suitable absorbent to spill area. Keep product out of sewers and waterways. Wear respiratory protection for large spill, leak or release. Dispose of according to local, state and federal regulations.

FIRST AID PROCEDURES

Eye Contact: Flush with water for 15 minutes. Obtain medical assistance if irritation persists.

Skin Contact: Wash with soap and water until no odor remains.

Inhalation: Move person to fresh air. If not breathing, give artificial respiration and obtain medical assistance.

Ingestion: Do not induce vomiting. Do not give liquids. Obtain medical assistance. Small amounts entering the mouth should be rinsed out until no taste remains.

FIRE FIGHTING PROCEDURES & EXTINGUISHING MEDIA

Use foam, water spray (fog), dry chemical carbon dioxide or vaporizing liquid for this type of product depending on size or potential size of fire and circumstances related to the situation. Plan fire protection and response strategy through consultation with local fire protection authorities or appropriate specialists. Wear self contained breathing apparatus to protect against decomposition products.

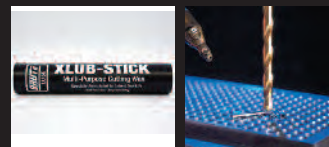
The information and recommendations contained herein are, to the best of our knowledge and belief, accurate and reliable as of the date issued. We do not warrant or guarantee their accuracy or reliability, and shall not be liable for any loss or damage arising out of the use there of. The information and recommendations are offered for the user's consideration and examination, and it is the user's responsibility to satisfy itself that they are suitable and complete for its particular use.

NOTE: CONTENTS OF BRUTELUBE ARE NOT LISTED AS A CARCINOGEN BY NTP OR IARC. CONTENTS ARE NOT OSHA REGULATED.

**CHAMPION**

TECHNICAL

BruteLube Wax



BruteLube Wax Material Data Sheet

I. PRODUCT AND MANUFACTURER INFORMATION

Product name BruteLube Multi-Purpose Cutting Wax
Chemical name
Synonyms
CAS number NE
Manufacturer Champion Cutting Tool Corp.
10 Madison Avenue, Rockville Centre, NY 11570
516-536-8200
Emergency phone number
Date of last revision 7/9/03

II. HAZARDOUS INGREDIENTS

HAZARDOUS COMPONENT	CAS NUMBER	% OPTIONAL	OSHA PEL	ACGIH TLV	CHEMICAL AND/OR COMMON NAME(S)
MINERAL OIL	(CAS 64742-52-5)		350 PPM	350 PPM	

III. PHYSICAL AND CHEMICAL CHARACTERISTICS

Boiling point @ 760mm Hg >700 F
Vapor pressure at 20°C <1
Vapor density (air = 1) ND
Solubility in water NOT SOLUBLE
Appearance and odor YELLOW OPAQUE SOLID
Specific gravity (H₂O = 1.0) 0.85
Melting point 172 F
Evaporation rate (butyl acetate = 1) <1

IV. FIRE AND EXPLOSION HAZARD DATA

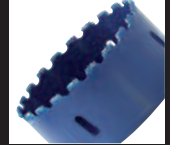
Combustible/Not combustible NOT COMBUSTIBLE
Flammable/Not flammable NOT FLAMMABLE
Pyrophoric/Not pyrophoric NOT PYROPHORIC
Explosive/Not explosive NOT EXPLOSIVE
Flash point (test method) >450 F
Flammable limits (in Air % by volume) NA NA NA
Extinguishing media FOAM OR DRY CHEMICAL
Special fire-fighting procedures or equipment SAME AS FOR PETROLEUM PRODUCTS
Unusual fire and explosion hazards NONE

V. REACTIVITY DATA

Material is stable/unstable STABLE
Conditions to avoid AVOID STRONG ACIDS OR BASES
Incompatibility (materials to avoid) AVOID STRONG ACIDS OR BASES
Hazardous decomposition or by-products NONE KNOWN
Hazardous polymerization will/will not occur WILL NOT OCCUR

VI. HEALTH HAZARD DATA

Threshold limit value NE
Primary route(s) of entry
Known Hazards Under 29 CFR 1910.1200
Mutagenic (genetic defects) NONE
Reproductive NONE
Systemic NONE
Teratogenic (birth defects) NONE



PTC3 Porcelain Tile Diamond Drills

General Usage Tips

PRACTICE DRILLING LOOSE TILES

Drilling hard tile is a difficult application made easy by using PTC3 diamond drills. However, there are certain techniques that will help you to achieve continued efficient drilling. Use spare tiles to practice your technique.

BASIC TECHNIQUES

1. Always ensure that the tile is supported if drilling loose tiles.
2. Always ensure that a constant supply of water is present at the cutting edge.
3. Always use a ground fault circuit interrupter (GFCI) when using a corded power tool in the presence of water. Drill in "Rotary Mode" only.
4. The optimum running speed for the drill is 900-1000 rpm.
5. To start, present the diamond drill bit at a 45° angle to the tile. Run the power tool at the recommended speed before contact and ensure water is present.
6. Apply steady pressure upon contact to prevent the PTC3 from walking.
7. After initially creating a 'half moon' shaped cut in the tile bring the drill up to the vertical position.
8. Rotate the drill slightly as it cuts to create relief around the hole and ease the exit of the slug.
9. Do not drill the supporting material with this diamond drill.

DRILLING WALL MOUNTED TILES

1. Follow the procedures laid out above but there is greater emphasis placed on the presence of water in this situation due to gravity.
2. Either seek assistance from a colleague to constantly spray / pour water on the cutting edge or use an accessory that enables a constant flow of water from above. Such as the PTC-WFG water feed guide.
3. The reverse spiral design feature means that less water is required than alternative drills, as the reverse spiral draws the water in.

DRILLING FLOOR TILES

1. Follow the procedures laid out above but in this instance the water used will form a pool at the cutting point. Ensure though that there is always water present.
2. The reverse spiral design feature means that less water is required than with alternative drills as the reverse spiral draws the water in.

PTC4 Diamond Multi Purpose Cutters

USAGE / HINTS / TIPS

PRACTICE DRILLING LOOSE MATERIAL

Drilling hard materials is a difficult application made easy by using PTC4 multi purpose hole cutters. However, there are certain techniques that will help you to achieve continued efficient drilling. If you are regularly drilling the same materials then you will have odd sections available to you. Use these to practice your technique. As with new materials, maybe practice on loose sections.

BASIC TECHNIQUES

1. Always ensure that the material is on a flat bed / supporting material if drilling loose materials.
2. Always ensure that a constant supply of coolant is present at the cutting edge if the material requires it.
3. A cordless power tool is the ideal type of drill to use. If using a corded drill, always use a ground fault circuit interrupter (GFCI).
4. The optimum running speed for the drill for PTC4 multi purpose hole cutters is 900-1000rpm.
5. Do NOT use hammer action when using diamond holesaws.

WET DRILLING - (porcelain and quarry tiles, Class 5, granite, travertine, marble, reinforced glass and cement, stone)

1. If drilling WET - remove the pilot drill from the adaptor - the material does not suit its use.
2. To start, present the diamond holesaw at a 45° angle to the material. Run the power tool at the recommended speed before contact and ensure water is present.
3. Ensure a good amount of pressure is applied upon contact to stop the diamond drill 'walking'.
4. After initially creating a 'half moon' shaped cut in the tile bring the drill up to the vertical position.
5. Ensure a constant flow of water at the cutting edge.
6. Rotate the drill slightly as it cuts to create relief around the hole and ease the exit of the slug.
7. If drilling into a tile or similar material already fixed to a vertical support then ensure that a constant flow of water is present as gravity will draw the water away. You may need additional help to achieve this.

DRY DRILLING - (glass, polymers, fibreglass, decking, plywood, mdf, plastics, laminates, perspex, brick, paving)

1. Use the holesaw with the pilot drill attached as you would a standard bi-metal holesaw.

LUBRICATED DRILLING - (cast iron, virton, aluminum - we recommend the use of BruteLube or BruteLube Wax)

1. Use the holesaw with the pilot drill attached as you would a standard bi-metal holesaw.
2. Ensure first, that the full diameter of the area to be drilled is covered in a suitable lubricant for the material being drilled. Also place the same lubricant onto the cutting edges of the holesaw.
3. Failure to lubricate the holesaw and material will result in accelerated heat generation, loss of tool life and potential tool failure.



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