MasterCut Tool Corp.

ISO 9001:2015 CERTIFIED

SOLID CARBIDE JOBBER DRILLS

2 Flute - 118° Four Facet Point

Consider PowerA coatings to run more aggressive speeds and feeds!

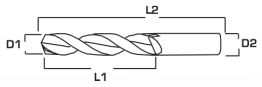
ALSO AVAILABLE IN: POWERA
APPEND "-1" TO THE PART NUMBER FOR POWERA

Harder than our original TiAlN by 1000 HV and with an increase in thermal stability of 200°F (100°C), PowerA will ensure that heat buildup, friction, and edge breakdown are all greatly reduced, resulting in better cutting performance and longer tool life. **PowerA continues to be the coating of choice for tough-to-cut materials.**

** Hardness: 3800 HV*
** Coating Thickness: 2-4 Microns*
** Thermal Stability: 1,650°F or 900°C*

EXCLUSIVE MAP TECHNOLOGY

Cutting Edge Tolerance/Shank Tolerance +.000 - .0002



D1 - Cutting Diameter • L1 - Cutting Length
D2 - Shank Diameter • L2 - Overall Length

UNCOATED

Wire	D1	L1	D2	L2	2 Flute	Sale Price
#70	0.0280	5/16	0.0280	1-1/4	163-601-002*	$12.87
#69	0.0292	5/16	0.0292	1-1/4	163-601-004*	$12.71
#68	0.0310	5/16	0.0310	1-1/4	163-601-006*	$12.53
~	1/32	5/16	1/32	1-1/4	163-601-008*	$9.56
#67	0.0320	5/16	0.0320	1-1/4	163-601-010*	$12.38
#66	0.0330	5/16	0.0330	1-1/4	163-601-012*	$12.21
#65	0.0350	5/8	0.0350	1-1/2	163-601-014*	$12.03
#64	0.0360	5/8	0.0360	1-1/2	163-601-016*	$11.87
#63	0.0370	5/8	0.0370	1-1/2	163-601-018*	$11.60
#62	0.0380	5/8	0.0380	1-1/2	163-601-020*	$11.42
#61	0.0390	5/8	0.0390	1-1/2	163-601-022*	$11.33
~	0.0394	5/8	0.0394	1-1/2	163-601-024*	$13.17
#60	0.0400	3/4	0.0400	1-1/2	163-601-026*	$11.15
#59	0.0410	3/4	0.0410	1-1/2	163-601-028*	$11.15
#58	0.0420	3/4	0.0420	1-1/2	163-601-030*	$11.15
#57	0.0430	3/4	0.0430	1-1/2	163-601-032*	$11.15
#56	0.0465	3/4	0.0465	1-1/2	163-601-034*	$11.15
~	3/64	3/4	3/64	1-1/2	163-601-036*	$11.15
#55	0.0520	3/4	0.0520	1-1/2	163-601-038*	$11.15
#54	0.0550	3/4	0.0550	1-1/2	163-601-040*	$11.27
~	0.0591	3/4	0.0591	1-1/2	163-601-042*	$13.29
#53	0.0595	3/4	0.0595	1-1/2	163-601-044*	$11.27
~	1/16	3/4	1/16	1-1/2	163-601-046	$11.27
#52	0.0635	3/4	0.0635	1-1/2	163-601-048	$11.27
#51	0.0670	3/4	0.0670	1-1/2	163-601-050	$11.27
#50	0.0700	7/8	0.0700	1-3/4	163-601-052	$11.37
#49	0.0730	7/8	0.0730	1-3/4	163-601-054	$11.42
#48	0.0760	7/8	0.0760	1-3/4	163-601-056	$11.93
~	5/64	7/8	5/64	1-3/4	163-601-058	$11.93
#47	0.0785	7/8	0.0785	1-3/4	163-601-060	$11.93
~	0.0787	7/8	0.0787	1-3/4	163-601-062	$14.10
#46	0.0810	7/8	0.0810	1-3/4	163-601-064	$11.93
#45	0.0820	7/8	0.0820	1-3/4	163-601-066	$12.21
#44	0.0860	1	0.0860	2	163-601-068	$12.53
#43	0.0890	1	0.0890	2	163-601-070	$12.53
#42	0.0935	1	0.0935	2	163-601-072	$12.81
~	3/32	1	3/32	2	163-601-074	$13.35
#41	0.0960	1	0.0960	2	163-601-076	$12.92
#40	0.0980	1	0.0980	2	163-601-078	$13.29
~	0.0984	1	0.0984	2	163-601-080	$13.29
#39	0.0995	1-1/4	0.0995	2-1/4	163-601-082	$13.50
#38	0.1015	1-1/4	0.1015	2-1/4	163-601-084	$14.01
#37	0.1040	1-1/4	0.1040	2-1/4	163-601-086	$14.01
#36	0.1065	1-1/4	0.1065	2-1/4	163-601-088	$14.01
~	7/64	1-1/4	7/64	2-1/4	163-601-090	$14.61
#35	0.1100	1-1/4	0.1100	2-1/4	163-601-092	$14.16
#34	0.1110	1-1/4	0.1110	2-1/4	163-601-094	$14.67
#33	0.1130	1-1/4	0.1130	2-1/4	163-601-096	$14.67
#32	0.1160	1-1/4	0.1160	2-1/4	163-601-098	$14.93
~	0.1181	1-1/4	0.1181	2-1/4	163-601-100	$10.83

* 135° Point

UNCOATED

Wire	D1	L1	D2	L2	2 Flute	Sale Price
#31	0.1200	1-1/4	0.1200	2-1/4	163-601-102	$11.18
~	1/8	1-1/4	1/8	2-1/4	163-601-104	$10.08
#30	0.1285	1-3/8	0.1285	2-1/2	163-601-106	$10.64
#29	0.1360	1-3/8	0.1360	2-1/2	163-601-108	$11.07
~	0.1378	1-3/8	0.1378	2-1/2	163-601-110	$11.07
#28	0.1405	1-3/8	0.1405	2-1/2	163-601-112	$11.07
~	9/64	1-3/8	9/64	2-1/2	163-601-114	$11.07
#27	0.1440	1-3/8	0.1440	2-1/2	163-601-116	$12.71
#26	0.1470	1-3/8	0.1470	2-1/2	163-601-118	$12.71
#25	0.1495	1-3/8	0.1495	2-1/2	163-601-120	$12.71
#24	0.1520	1-3/8	0.1520	2-1/2	163-601-122	$12.71
#23	0.1540	1-3/8	0.1540	2-1/2	163-601-124	$12.71
~	5/32	1-3/8	5/32	2-1/2	163-601-126	$12.17
#22	0.1570	1-3/8	0.1570	2-1/2	163-601-128	$15.00
~	0.1575	1-3/8	0.1575	2-1/2	163-601-130	$15.00
#21	0.1590	1-3/8	0.1590	2-1/2	163-601-132	$15.00
#20	0.1610	1-3/8	0.1610	2-1/2	163-601-134	$15.00
#19	0.1660	1-5/8	0.1660	2-3/4	163-601-136	$15.00
#18	0.1695	1-5/8	0.1695	2-3/4	163-601-138	$15.00
~	11/64	1-5/8	11/64	2-3/4	163-601-140	$15.00
#17	0.1730	1-5/8	0.1730	2-3/4	163-601-142	$15.32
#16	0.1770	1-5/8	0.1770	2-3/4	163-601-144	$15.32
~	0.1772	1-5/8	0.1772	2-3/4	163-601-146	$15.32
#15	0.1800	1-5/8	0.1800	2-3/4	163-601-148	$15.32
#14	0.1820	1-5/8	0.1820	2-3/4	163-601-150	$15.32
#13	0.1850	1-5/8	0.1850	2-3/4	163-601-152	$15.32
~	3/16	1-5/8	3/16	2-3/4	163-601-154	$14.76
#12	0.1890	1-5/8	0.1890	2-3/4	163-601-156	$16.08
#11	0.1910	1-5/8	0.1910	2-3/4	163-601-158	$16.08
#10	0.1935	1-5/8	0.1935	2-3/4	163-601-160	$16.08
#9	0.1960	1-3/4	0.1960	3	163-601-162	$16.08
~	0.1968	1-3/4	0.1968	3	163-601-164	$16.08
#8	0.1990	1-3/4	0.1990	3	163-601-166	$16.08
#7	0.2010	1-3/4	0.2010	3	163-601-168	$16.08
~	13/64	1-3/4	13/64	3	163-601-170	$16.73
#6	0.2040	1-3/4	0.2040	3	163-601-172	$19.04
#5	0.2055	1-3/4	0.2055	3	163-601-174	$19.04
#4	0.2090	1-3/4	0.2090	3	163-601-176	$19.04
#3	0.2130	1-3/4	0.2130	3	163-601-178	$19.04
~	0.2165	1-3/4	0.2165	3	163-601-180	$19.04
~	7/32	1-3/4	7/32	3	163-601-182	$19.04
#2	0.2210	1-3/4	0.2210	3	163-601-184	$20.57
#1	0.2280	1-3/4	0.2280	3	163-601-186	$20.57
A	0.2340	2	0.2340	3-1/4	163-601-188	$20.57
~	15/64	2	15/64	3-1/4	163-601-190	$20.57
~	0.2362	2	0.2362	3-1/4	163-601-192	$22.97
B	0.2380	2	0.2380	3-1/4	163-601-194	$22.97
C	0.2420	2	0.2420	3-1/4	163-601-196	$22.97
D	0.2460	2	0.2460	3-1/4	163-601-198	$22.97
E	1/4	2	1/4	3-1/4	163-601-200	$21.47

CALIBER INDUSTRIAL SUPPLY

5500 Tomken Rd, Unit #2
Mississauga, ON L4W 2Z4
www.caliberindustrial.com
sales@caliberindustrial.com

Mississauga: 905.624.5524
Toronto: 416.626.7151
Toll Free: 1.800.465.5743
Fax: 905.602.8758

Spring 2022 Promotions

Wire	D1	L1	D2	L2	2 Flute	Sale Price
~	0.2559	2	0.2559	3-1/4	163-601-202	$25.50
F	0.2570	2	0.2570	3-1/4	163-601-204	$25.50
G	0.2610	2-1/8	0.2610	3-1/2	163-601-206	$25.50
~	17/64	2-1/8	17/64	3-1/2	163-601-208	$24.17
H	0.2660	2-1/8	0.2660	3-1/2	163-601-210	$27.09
I	0.2720	2-1/8	0.2720	3-1/2	163-601-212	$27.80
~	0.2756	2-1/8	0.2756	3-1/2	163-601-214	$27.80
J	0.2770	2-1/8	0.2770	3-1/2	163-601-216	$27.80
K	0.2810	2-1/8	0.2810	3-1/2	163-601-218	$27.80
~	9/32	2-1/8	9/32	3-1/2	163-601-220	$26.72
L	0.2900	2-1/8	0.2900	3-1/2	163-601-222	$31.74
M	0.2950	2-3/8	0.2950	4	163-601-224	$31.74
~	0.2953	2-3/8	0.2953	4	163-601-226	$31.74
~	19/64	2-3/8	19/64	4	163-601-228	$28.85
N	0.3020	2-3/8	0.3020	4	163-601-230	$32.06
~	5/16	2-3/8	5/16	4	163-601-232	$29.15
~	0.3150	2-3/8	0.3150	4	163-601-234	$34.32
O	0.3160	2-3/8	0.3160	4	163-601-236	$35.24
P	0.3230	2-3/8	0.3230	4	163-601-238	$35.24
~	21/64	2-3/8	21/64	4	163-601-240	$33.39
Q	0.3320	2-3/8	0.3320	4	163-601-242	$38.09
~	0.3346	2-3/8	0.3346	4	163-601-244	$38.09
R	0.3390	2-3/8	0.3390	4	163-601-246	$38.09
~	11/32	2-3/8	11/32	4	163-601-248	$34.47
S	0.3480	2-3/8	0.3480	4	163-601-250	$42.45
~	0.3543	2-3/4	0.3543	4-1/4	163-601-252	$42.45
T	0.3580	2-3/4	0.3580	4-1/4	163-601-254	$42.45
~	23/64	2-3/4	23/64	4-1/4	163-601-256	$39.71
U	0.3680	2-3/4	0.3680	4-1/4	163-601-258	$43.65
~	0.3740	2-3/4	0.3740	4-1/4	163-601-260	$43.65

Wire	D1	L1	D2	L2	2 Flute	Sale Price
~	3/8	2-3/4	3/8	4-1/4	163-601-262	$39.56
V	0.3770	2-3/4	0.3770	4-1/4	163-601-264	$50.76
W	0.3860	2-7/8	0.3860	4-1/2	163-601-266	$50.76
~	25/64	2-7/8	25/64	4-1/2	163-601-268	$48.11
~	0.3937	2-7/8	0.3937	4-1/2	163-601-270	$56.24
X	0.3970	2-7/8	0.3970	4-1/2	163-601-272	$56.24
Y	0.4040	2-7/8	0.4040	4-1/2	163-601-274	$56.24
~	13/32	2-7/8	13/32	4-1/2	163-601-276	$51.23
Z	0.4130	2-7/8	0.4130	4-1/2	163-601-278	$67.16
~	0.4134	2-7/8	0.4134	4-1/2	163-601-280	$60.83
~	27/64	2-7/8	27/64	4-1/2	163-601-282	$60.83
~	0.4331	2-7/8	0.4331	4-1/2	163-601-284	$71.87
~	7/16	2-7/8	7/16	4-1/2	163-601-286	$59.19
~	0.4527	3	0.4527	4-3/4	163-601-288	$74.28
~	29/64	3	29/64	4-3/4	163-601-290	$74.28
~	15/32	3	15/32	4-3/4	163-601-292	$70.68
~	0.4724	3	0.4724	4-3/4	163-601-294	$83.31
~	31/64	3	31/64	4-3/4	163-601-296	$83.31
~	0.4921	3	0.4921	4-3/4	163-601-298	$84.45
~	1/2	3	1/2	4-3/4	163-601-300	$77.03
~	17/32	4	17/32	6	163-601-302	$128.42
~	9/16	4	9/16	6	163-601-304	$141.89
~	19/32	4	19/32	6	163-601-306	$157.41
~	5/8	4	5/8	6	163-601-308	$164.79
~	21/32	4	21/32	6	163-601-310	$181.47
~	11/16	4	11/16	6	163-601-312	$187.13
~	23/32	4	23/32	6	163-601-314	$204.84
~	3/4	4	3/4	6	163-601-316	$222.80
~	7/8	4	7/8	6	163-601-320	$261.33
~	1	4	1	6	163-601-322	$279.50

Standard Drill Recommendations		Feed Rate (I.P.R.)				
Material Group	Speed SFM	1/16"	1/8"	1/4"	1/2"	3/4"
Aluminum/ Aluminum Alloys	*300-600*	*0.0008*	*0.003*	*0.007*	*0.012*	*0.015*
Aluminum Alloyed Si > 10%	*150-400*	*0.0008*	*0.002*	*0.006*	*0.010*	*0.012*
Soft Cast Irons	*200-300*	*0.001*	*0.003*	*0.005*	*0.010*	*0.012*
Medium Cast Irons	*125-225*	*0.001*	*0.003*	*0.005*	*0.008*	*0.010*
Malleable Cast Irons	*65-200*	*0.0005*	*0.002*	*0.004*	*0.007*	*0.010*
Brass	*200-300*	*0.0007*	*0.002*	*0.003*	*0.004*	*0.006*
Bronze	*150-250*	*0.0007*	*0.002*	*0.003*	*0.004*	*0.006*
Coppers/ Copper Alloys	*150-300*	*0.001*	*0.003*	*0.006*	*0.010*	*0.012*
Magnesium	*300-600*	*0.001*	*0.003*	*0.007*	*0.012*	*0.015*
Nickel Alloys	*75-200*	*0.001*	*0.003*	*0.005*	*0.009*	*0.012*
Free Machining Stainless Steels	*100-150*	*0.001*	*0.003*	*0.005*	*0.008*	*0.012*
Work Hardening Stainless Steels	*50-100*	*0.0005*	*0.002*	*0.004*	*0.006*	*0.010*
Low Carbon Steels	*150-300*	*0.001*	*0.002*	*0.004*	*0.007*	*0.012*
Medium Carbon Steels	*100-200*	*0.001*	*0.002*	*0.003*	*0.006*	*0.010*
High Tensile (35-40 Rc) Steels	*75-150*	*0.001*	*0.002*	*0.003*	*0.004*	*0.005*
High Tensile (40-45 Rc) Steels	*50-100*	*0.0007*	*0.001*	*0.002*	*0.003*	*0.004*
High Tensile (45 Rc+) Steels	*25-75*	*0.0005*	*0.0007*	*0.001*	*0.002*	*0.003*
Tool Steels	*40-100*	*0.001*	*0.0015*	*0.003*	*0.005*	*0.008*
Soft Titanium	*80-125*	*0.001*	*0.002*	*0.004*	*0.006*	*0.010*
Titanium Alloys Hard Titanium	*40-100*	*0.0007*	*0.001*	*0.002*	*0.005*	*0.008*

5 Axis Barrel milling/Circle segment cutters made to order in material specific geometries. Ask for a quote!

Straight Flute Drill Kit

Designed for both production and reparation drilling in high tensile strength materials.
Suitable for drilling out broken drills, taps, bolts, screws, studs, weldments and more!

Micrograin Carbide Substrate
Capable of drilling up to 65RcH
Excellent Heat & Wear Resistance
Solid Construction

Problem Solver For:
- ✓Machinists
- ✓Maintenance Depts.
- ✓Mold & Die Makers
- ✓Mechanics
- ✓Installation Crews

List $271.24

INCLUDED IN SET (Part # 163-104-9767):

Diameter D1	Length of Cut L1	Shank Diameter D2	Overall Length L2	Uncoated 2 Flute
1/8	5/8	1/8	1-1/2	163-604-004
3/16	5/8	3/16	2	163-604-012
1/4	3/4	1/4	2	163-604-020
5/16	3/4	5/16	2-1/2	163-604-028
3/8	1	3/8	2-1/2	163-604-036

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