



by Ultra-Dex



ISO	MATERIAL	HARDNESS	GRADE	Vc (SFM)*	INDEXABLE DRILL DIAMETER (INCH)		
					0.5620"-0.7499"	0.7500" - 1.4999"	1.5000" - 2.2500"
					Fz = IPR (INCH PER REVOLUTION)*		
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 275 BHN or ≤ 28 HRC	HP 600	350-900	.0015-.0060	.0020-.0075	.0030-.0120
	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 17-4 PH	≤ 375 BHN or ≤ 40 HRC		260-750	.0020-.0070	.0020-.0085	.0030-.0095
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F	≤ 275 BHN or ≤ 28 HRC	HP 600	230-700	.0018-.0040	.0030-.0065	.0030-.0085
	STAINLESS STEELS (DIFFICULT) 304, 304L, 316, 316L	≤ 275 BHN or ≤ 28 HRC		260-750	.0018-.0040	.0030-.0065	.0030-.0085
K	GRAY IRONS Class 20, 30, 40 ,50, 60, G3000, G3500	≤ 220 BHN or ≤ 19 HRC	HK 356	285-1000	.0025-.0055	.0035-.0070	.0040-.0085
	DUCTILE IRONS D&M series, 250, 300, 350, 400, 60-40-18, 65-45-12	≤ 260 BHN or ≤ 26 HRC		230-740	.0020-.0050	.0028-.0065	.0030-.0070
N	NON-FERROUS Aluminum, Aluminum cast, Brass, Copper, Bronze, Non Metallic	≤ 271 BHN or ≤ 28 HRC	HN 300	600-1150	.0020-.0075	.0030-.0090	.0045-.0115
H	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2"	≤ 375 BHN or ≤ 55 HRC	HP 600	80-275	.0018-.0065	.0020-.0075	.0030-.0080
S	HR SUPER ALLOYS Inconel 718, Waspaloy, Hastelloy, Inconel 625, Stellite 31, Haynes 25, Rene 41	≤ 275 BHN or ≤ 28 HRC	HP 600	55-270	.0016-.0032	.0020-.0055	.0025-.0060
	TITANIUM 6AL-4V, ASTM 1, 2, 3, 6AL-2S	≤ 275 BHN or ≤ 28 HRC		95-460	.0019-.0055	.0020-.0065	.0025-.008

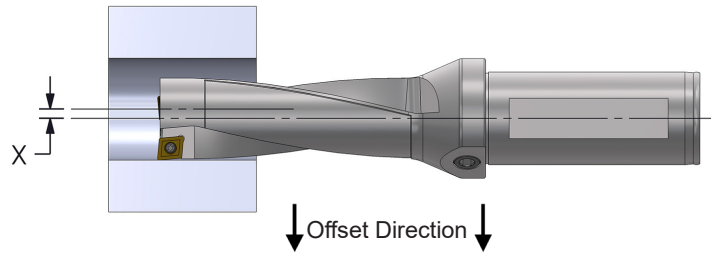
Recommendations

Productivity and tooling performance is not only influenced by grade and geometry, but also by clamping the tool securely and accurately as possible.

- It is recommended to use precision holders i.e. hydraulic, shrink fit
- It is recommended to use internal coolant – minimum recommended pressure 145 psi

*Speeds & feeds are starting recommendations only. Factors such as machine type, fixture, tooling rigidity, available horsepower, coolant delivery method and others will affect the performance significantly.

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Our Drills offer the ability to offset in turning applications to help with tolerance optimization and creation of holes larger than the drill diameter.

PATRIOT HIGH PERFORMANCE

Designation	Offset (Max)
PD1-0562-3D-075	.007
PD1-0594-3D-075	.005
PD1-0609-3D-075	.005
PD1-0625-3D-075	.015
PD1-0669-3D-075	.011
PD1-0687-3D-075	.009
PD1-0709-3D-075	.007
PD1-0734-3D-100	.019
PD1-0750-3D-100	.017
PD1-0787-3D-100	.011
PD1-0812-3D-100	.009
PD1-0844-3D-100	.005
PD1-0875-3D-100	.004
PD1-0937-3D-125	.023
PD1-0984-3D-125	.019
PD1-1000-3D-125	.017
PD1-1062-3D-125	.009
PD1-1125-3D-125	.004
PD1-1181-3D-125	.035
PD1-1250-3D-125	.027
PD1-1312-3D-125	.021
PD1-1375-3D-125	.013
PD1-1437-3D-125	.008
PD1-1500-3D-150	.039
PD1-1625-3D-150	.027
PD1-1750-3D-150	.015
PD1-1875-3D-150	.051
PD1-2000-3D-150	.039
PD1-2125-3D-150	.023

REVERE*

Designation	Offset (Max)
UD-0437-2D-063	.018
UD-0468-2D-063	.016
UD-0500-2D-063	.014
UD-0531-2D-063	.023
UD-0562-2D-063	.021
UD-0593-2D-063	.019
UD-0625-2D-063	.023
UD-0656-2D-063	.021
UD-0687-2D-063	.019
UD-0719-2D-063	.017
UD-0750-2D-075	.024
UD-0781-2D-075	.022
UD-0812-2D-075	.021
UD-0844-2D-075	.019
UD-0875-2D-075	.017
UD-0906-2D-075	.015
UD-0937-2D-075	.013
UD-0968-2D-075	.011
UD-1000-2D-100	.029
UD-1031-2D-100	.027
UD-1062-2D-100	.025
UD-1094-2D-100	.023

REVERE*

Designation	Offset (Max)
UD-1125-2D-100	.021
UD-1156-2D-100	.020
UD-1187-2D-100	.018
UD-1219-2D-100	.016
UD-1250-2D-125	.035
UD-1312-2D-125	.031
UD-1343-2D-125	.029
UD-1375-2D-125	.027
UD-1437-2D-125	.023
UD-1500-2D-125	.019
UD-1562-2D-125	.015
UD-1625-2D-125	.011
UD-1687-2D-125	.008
UD-1750-2D-150	.040
UD-1812-2D-150	.036
UD-1875-2D-150	.032
UD-1937-2D-150	.028
UD-2000-2D-150	.024
UD-2125-2D-150	.017
UD-2250-2D-150	.009
UD-2375-2D-150	.001

*2XD Only