

Spiral Flute

Styles 1093, 1094 • High-Spiral

DRILLING

FEATURES

USCT1 302	HSS SUBSTRATE
GENERAL PURPOSE	BRIGHT
BLIND HOLES	PLUG 3-5
GROUND THREAD	BOTTOMING 1½-2

APPLICATIONS

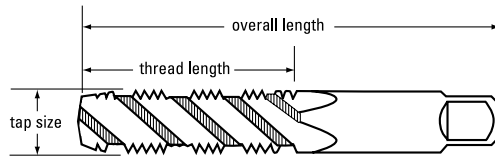
ALLOY-TOOL STEEL
CARBON STEEL
STAINLESS STEEL



Style 1093 Plug Chamfer Bright



Style 1094 Bottoming Chamfer Bright



Tapping speeds are listed on page 131.

HOLE FINISHING

THREADING

Tap Size and Pitch	Thread Form	Decimal Equiv.	Metric Equiv.	No of Flutes	H-Limit	Overall Length		Thread Length		Order Number			
						in	mm	in	mm	Plug 1093 Bright	Plug 1093 TiN	Bottoming 1094 Bright	Bottoming 1094 TiN
4-40	UNC	.1120	2.84	2	H2	1.875	47.63	.463	11.75	C58515		C58516	C55566
6-32	UNC	.1380	3.51	2	H3	2.000	50.80	.688	17.46	C58532	C55571	C58533	C55570
8-32	UNC	.1640	4.17	3	H3	2.125	53.98	.750	19.05	C58538	C55573	C58539	C55572
10-24	UNC	.1900	4.83	3	H3	2.375	60.33	.875	22.23	C58544	C55575	C58545	
10-32	UNF	.1900	4.83	3	H3	2.375	60.33	.875	22.23	C58546	C55577	C58547	C55576
1/4-20	UNC	.2500	6.35	3	H3	2.500	63.50	1.000	25.40	C58562		C58563	
1/4-28	UNF	.2500	6.35	3	H3	2.500	63.50	1.000	25.40	C58564		C58565	
5/16-18	UNC	.3125	7.94	3	H3	2.719	69.06	1.125	28.58	C58570		C58571	
5/16-24	UNF	.3125	7.94	3	H3	2.719	69.06	1.125	28.58	C58572		C58573	
3/8-16	UNC	.3750	9.53	3	H3	2.938	74.61	1.250	31.75	C58581		C58582	
3/8-24	UNF	.3750	9.53	3	H3	2.938	74.61	1.250	31.75	C58583		C58584	
1/2-13	UNC	.5000	12.70	3	H3	3.375	85.73	1.656	42.07	C58613		C58614	
1/2-20	UNF	.5000	12.70	3	H3	3.375	85.73	1.656	42.07	C58615		C58616	

Metric Sizes

Tap Size and Pitch	Decimal Equiv.	Metric Equiv.	No of Flutes	H-Limit	Overall Length		Thread Length		Order Number			
					in	mm	in	mm	Plug 1093 Bright	Plug 1093 TiN	Bottoming 1094 Bright	Bottoming 1094 TiN
M3 X 0.5	.1181	3.0	2	D3	1.938	49.21	.625	15.88	C58800		C58801	C58901
M4 X 0.7	.1575	4.0	3	D4	2.125	53.98	.750	19.05	C58804	C58904	C58805	C58905
M5 X 0.8	.1969	5.0	3	D4	2.375	60.33	.875	22.23	C58806	C58906	C58807	C58907
M6 X 1.0	.2362	6.0	3	D5	2.500	63.50	1.000	25.40	C58808	C58908	C58809	C58909
M8 X 1.25	.3150	8.0	3	D5	2.719	69.06	1.125	28.58	C58810	C58910	C58811	C58911
M10 X 1.5	.3937	10.0	3	D8	2.938	74.61	1.250	31.75	C58812	C58912	C58813	C58913
M12 X 1.75	.4724	12.0	3	D6	3.375	85.73	1.656	42.07			C58815	

MILLING

OTHER TOOLS

