MaxTool Corp.

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HSS Aircraft Extension Drills

6" Overall Length   **List No. ACF02B06RXX -- HSS M2**

135° Split Quick-Cut Point

12" Overall Length   **List No. ACF02B12RXX -- HSS M2**

Features

* 135° Quick-Cut split point avoids "walk" or "wander"
* Precision ground to insure concentricity of tip & body
* Smooth flutes & surface treated for effective chip flow
* Premium quality high speed steel, special heat treatment to remain sharper cut, & reduce wear
* Penetrates faster with less pressure
* All dimensional & element tolerances conform to one of ASME/ANSI B94.11M,
    NAS 907 - National Aerospace Standards
    USCTI - United States Cutting Tool Institute (formerly MCTI)

Application

Designed for effective drilling in all types of metals, wood & plastic 4" thick or less where the holes are not accessible with regular drills; Not recommended for deep hole applications

Sizes available:

1/16" to 1/2" in 6" lengths & 1/8" to 1/2" in 12" lengths
Standard Drills are HSS M2 fully ground, black oxide
Customer Length, and Drill Sets are available

Material: M2, M35, M42 cobalt HSS

Fractional Sizes (List No.: ACF02B…)

Frac.	Dec.	Flute Length	OAL 6" ACF02B06	OAL 12" ACF02B12	Frac.	Dec.	Flute Length	OAL 6" ACF02B06	OAL 12" ACF02B12
1/16"	0.0625	7/8"	R04		$\frac{19}{64}$	0.2969	3 $\frac{1}{16}$		R19
5/64"	0.0781	1"	R05		$\frac{5}{16}$	0.3125	3 $\frac{3}{16}$		R20
3/32"	0.0938	1-1/4"	R06		$\frac{21}{64}$	0.3281	3 $\frac{5}{16}$		R21
7/64"	0.1094	1-1/2"	R07		$\frac{11}{32}$	0.3438	3 $\frac{7}{16}$		R22
$\frac{1}{8}$	0.1250	1 $\frac{5}{8}$	R08		$\frac{23}{64}$	0.3594	3 $\frac{1}{2}$		R23
$\frac{9}{64}$	0.1406	1 $\frac{3}{4}$	R09		$\frac{3}{8}$	0.3750	3 $\frac{5}{8}$		R24
$\frac{5}{32}$	0.1562	2	R10		$\frac{25}{64}$	0.3906	3 $\frac{3}{4}$		R25
$\frac{11}{64}$	0.1719	2 $\frac{1}{8}$	R11		$\frac{13}{32}$	0.4062	3 $\frac{7}{8}$		R26
$\frac{3}{16}$	0.1875	2 $\frac{5}{16}$	R12		$\frac{27}{64}$	0.4219	3 $\frac{15}{16}$		R27
$\frac{13}{64}$	0.2031	2 $\frac{7}{16}$	R13		$\frac{7}{16}$	0.4375	4 $\frac{1}{16}$		R28
$\frac{7}{32}$	0.2188	2 $\frac{1}{2}$	R14		$\frac{29}{64}$	0.4531	4 $\frac{3}{16}$		R29
$\frac{15}{64}$	0.2344	2 $\frac{5}{8}$	R15		$\frac{15}{32}$	0.4688	4 $\frac{5}{16}$		R30
$\frac{1}{4}$	0.2500	2 $\frac{3}{4}$	R16		$\frac{31}{64}$	0.4844	4 $\frac{3}{8}$		R31
$\frac{17}{64}$	0.2656	2 $\frac{7}{8}$	R17		$\frac{1}{2}$	0.5000	4 $\frac{1}{2}$		R32
$\frac{9}{32}$	0.2812	2 $\frac{15}{16}$	R18						

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HSS Aircraft Extension Drills -- Letter Sizes (List No.: ACL02B…)

Frac.	Dec.	Flute Length	OAL 6" ACL02B06	OAL 12" ACL02B12	Frac.	Dec.	Flute Length	OAL 6" ACL02B06	OAL 12" ACL02B12
A	0.2340	2 5/8	R0A		N	0.3020	3 1/16	R0N	
B	0.2380	2 3/4	R0B		O	0.3160	3 3/16	R0O	
C	0.2420	2 3/4	R0C		P	0.3230	3 5/16	R0P	
D	0.2460	2 3/4	R0D		Q	0.3320	3 7/16	R0Q	
E	0.2500	2 3/4	R0E		R	0.3390	3 7/16	R0R	
F	0.2570	2 7/8	R0F		S	0.3480	3 1/2	R0S	
G	0.2610	2 7/8	R0G		T	0.3580	3 1/2	R0T	
H	0.2660	2 7/8	R0H		U	0.3680	3 5/8	R0U	
I	0.2720	2 7/8	R0I		V	0.3770	3 5/8	R0V	
J	0.2770	2 7/8	R0J		W	0.3860	3 3/4	R0W	
K	0.2810	2 15/16	R0K		X	0.3970	3 3/4	R0X	
L	0.2900	2 15/16	R0L		Y	0.4040	3 7/8	R0Y	
M	0.2950	3 1/16	R0M		Z	0.4130	3 7/8	R0Z	

HSS Aircraft Extension Drills -- Wire Gauge Sizes (List No.: ACN02B …)

Frac.	Dec.	Flute Length	OAL 6" ACN02B06	OAL 12" ACN02B12	Frac.	Dec.	Flute Length	OAL 6" ACN02B06	OAL 12" ACN02B12
52	0.0635	7/8"		R52	26	0.1470	1 7/8		R26
51	0.0670	1"		R51	25	0.1495	1 7/8		R25
50	0.0700	1"		R50	24	0.1520	2		R24
49	0.0730	1"		R49	23	0.1540	2		R23
48	0.0760	1"		R48	22	0.1570	2		R22
47	0.0785	1"		R47	21	0.1590	2 1/8		R21
46	0.0810	1-1/8"		R46	20	0.1610	2 1/8		R20
45	0.0820	1-1/8"		R45	19	0.1660	2 1/8		R19
44	0.0860	1-1/8"		R44	18	0.1695	2 1/8		R18
43	0.0890	1-1/4"		R43	17	0.1730	2 3/16		R17
42	0.0935	1-1/4"		R42	16	0.1770	2 3/16		R16
41	0.0960	1-3/8"		R41	15	0.1800	2 3/16		R15
40	0.0980	1-3/8"		R40	14	0.1820	2 3/16		R14
39	0.0995	1-3/8"		R39	13	0.1850	2 5/16		R13
38	0.1015	1-7/16"		R38	12	0.1890	2 5/16		R12
37	0.1040	1-7/16"		R37	11	0.1910	2 5/16		R11
36	0.1065	1-7/16"		R36	10	0.1935	2 7/16		R10
35	0.1100	1-1/2"		R35	9	0.1960	2 7/16		R09
34	0.1110	1-1/2"		R34	8	0.1990	2 7/16		R08
33	0.1130	1-1/2"		R33	7	0.2010	2 7/16		R07
32	0.1160	1 5/8		R32	6	0.2040	2 1/2		R06
31	0.1200	1 5/8		R31	5	0.2055	2 1/2		R05
30	0.1285	1 5/8		R30	4	0.2090	2 1/2		R04
29	0.1360	1 3/4		R29	3	0.2130	2 1/2		R03
28	0.1405	1 3/4		R28	2	0.2210	2 5/8		R02
27	0.1440	1 7/8		R27	1	0.2280	2 5/8		R01