



# **BRUBAKER TOOL™**

*Platinum Series*

High Performance Taps



For Titanium & Nickel Alloys

Brubaker Tool has been manufacturing taps for over 130 years. Our company can trace its roots to specialized taps for the railroad industry. This foundation in railroad taps led to the production of quality general purpose and special order taps. Over the past several years Brubaker has gained strength and expanded its presence in high performance, special application taps. Based upon these successes we are proud to introduce our Platinum Series High Performance Taps. Our Platinum Series will enable us to provide our valued customers with high performance taps as a catalog offering with off-the-shelf availability. These taps are designed primarily for use in titanium and nickel alloys.

Our Brubaker Platinum, High Performance Taps are yet another indication of our commitment to quality, growth and the support of application specific manufacturing.

Whether your manufacturing needs call for a standard tap, high performance tap, special geometry, special or standard end mill, we can meet all of your round tool cutting needs. Please call us and let us show you why Brubaker has remained a leading supplier for over 130 years.

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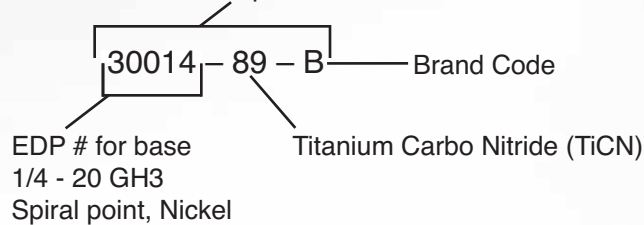
[www.brubakertool.com](http://www.brubakertool.com)

To find a distributor, go to [www.brubakertool.com](http://www.brubakertool.com) and click on the "Distributor Search" button or simply contact customer service.

## Tap Product Numbering System

To simplify our numbering system, our catalog layout and your ordering, we are using an EDP number and a suffix to identify coated or surface treated taps. In all cases, the five digit EDP number by itself will refer to a base part number. For all Platinum series taps, we strongly recommend a surface treatment or coating. Some series are not available bright. In order to get a tap with a coating or surface treatment you must specify a five digit EDP number plus a two digit suffix. For series where we recommend a specific treatment, that treatment will appear with the EDP number and suffix as the standard offering in the series. To order a tap with a surface treatment or coating other than the standard, simply substitute the desired two digit suffix in place of the standard two digit suffix. Available treatments appear in the top right corner of each series.




EXAMPLE: Standard tap and treatment for 1/4-20 GH3 Spiral Point, Platinum



If you want a treatment other than the standard for this series...

- |            |   |
|------------|---|
| 30014-89   | 1) Begin with the standard offering   |
| 30014      | 2) Drop the standard suffix for the series  |
| -89        | 3) Consult the table for the desired suffix, in this case Chromium Carbide (CrC) 90 instead of the Titanium Carbo Nitride (TiCN) 89 |
| 30014-90   | 4) Add the desired treatment suffix in place of the series standard treatment suffix  |
| 30014-90-B | 5) Add the "B" for the Brubaker brand   |

### Surface Treatments and Coatings

TREATMENT	ABBREVIATION	SUFFIX	COLOR CODE
Steam Oxide	SOX	03	
Titanium Carbonitride	TiCN	89	
Chromium Carbide	CrC	90	

### LIMITED WARRANTY

Brubaker Tool warrants to original equipment manufacturers, distributors and industrial and commercial users of its products that each new product which it manufactures or supplies is free from defects in material and workmanship. Its sole obligation under this warranty is limited to furnishing, without additional charge, a replacement for, or, at its option, repairing or issuing credit for any such product which shall, within one year from the date of sale by Brubaker Tool, be returned freight prepaid to Brubaker Tool and which, upon inspection, is determined by Brubaker Tool to be defective in materials or workmanship. The provisions of this warranty shall not apply to any product which has been subjected to misuse, improper operating conditions, or which has been repaired or altered, if such would adversely affect performance of the product. Complete written information with respect to all such matters must be furnished to Brubaker Tool as a prerequisite to its consideration of any claim or complaint under this warranty. The repair, replacement or issuance of credit for parts provided for in this warranty constitutes the Buyer's exclusive remedy. The warranty is in lieu of all other warranties, express or implied, including any implied warranty of merchantability or fitness for a particular purpose. Brubaker Tool has no liability or responsibility on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder. In excess of the cost of replacement or repair as provided herein. In no event shall Brubaker Tool be liable for any special, incidental or consequential damages. Brubaker Tool makes no other warranty, express or implied, except as set forth above; and neither assumes nor authorizes any other person or entity to assume for it any other obligation or liability in connection with any of its products.

#### WARNING

Any cutting tool may break or shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment at all times in the vicinity of use. Wet or dry grinding of cutting tools produces potentially hazardous dusts or mists; to avoid adverse health effects, use adequate ventilation and read the material Safety Data Sheet for further applicable tool material or grade before grinding.

High Performance

**Spiral Point - Fractional**

- HSS-CV Premium Powder Substrate
- Available only with Plug Chamfer
- TiCN (89) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



**SURFACE TREATMENTS**

- TiCN.....89
- SOX.....03

Size	NC	No. NF	Flutes	GH2	GH3	GH4	GH5	GH7	List Price	Decimal Drill Size	Percent Equiv.	Thread
2	56		2	30000-89-B					\$50.44	#49	0.0730	56%
4	40		3	30001-89-B	30002-89-B				\$32.07	3/32	0.0938	56%
6	32		3	30003-89-B	30004-89-B		30005-89-B		\$26.87	#32	0.1160	54%
8	32		3	30006-89-B	30007-89-B		30008-89-B		\$26.87	9/64	0.1406	58%
10	24		3		30009-89-B		30010-89-B		\$27.40	#20	0.1610	54%
10		32	3	30011-89-B	30012-89-B		30013-89-B		\$27.40	#19	0.1660	59%
1/4	20		3		30014-89-B		30015-89-B	30016-89-B	\$35.48	#3	0.2130	57%
1/4		28	3		30017-89-B	30018-89-B	30019-89-B	30020-89-B	\$35.48	#2	0.2210	63%
5/16	18		3		30021-89-B		30022-89-B	30023-89-B	\$38.67	1	0.2720	56%
5/16		24	3		30024-89-B	30025-89-B	30026-89-B	30027-89-B	\$38.67	9/32	0.2813	58%
3/8	16		3		30028-89-B	30029-89-B	30030-89-B	30031-89-B	\$43.53	21/64	0.3281	58%
3/8		24	3		30032-89-B	30033-89-B	30034-89-B	30035-89-B	\$43.53	11/32	0.3438	58%
7/16	14		3		30036-89-B		30037-89-B	30038-89-B	\$56.25	W	0.3860	56%
7/16		20	3		30039-89-B		30040-89-B	30041-89-B	\$56.25	10.2mm	0.4016	55%
1/2	13		3		30042-89-B		30043-89-B	30044-89-B	\$65.74	11.2mm	0.4409	59%
1/2		20	3		30045-89-B		30046-89-B	30047-89-B	\$65.74	11.8mm	0.4646	55%
9/16	12		3		30048-89-B				\$94.84	1/2	0.5000	58%
9/16		18	3		30049-89-B				\$94.84	33/64	0.5156	65%
5/8	11		3		30050-89-B		30051-89-B	30052-89-B	\$108.37	9/16	0.5625	53%
5/8		18	3		30053-89-B		30054-89-B	30055-89-B	\$108.37	37/64	0.5781	62%
3/4	10		3		30056-89-B		30057-89-B	30058-89-B	\$170.93	43/64	0.6719	60%
3/4		16	3		30059-89-B		30060-89-B	30061-89-B	\$170.93	18.0mm	0.7087	51%

**Material Application Guidelines : Spiral Point - Nickel Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 Hrc	35-45 Hrc
Series																
Best Suited			○								●					●
Cutting Speed			40-60 SFM								5-15 SFM					10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○

High Performance

**Spiral Point - Metric**

- HSS-CV Premium Powder Substrate
- Available only with Plug Chamfer
- TiCN (89) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



**SURFACE TREATMENTS**

- TiCN.....89
- SOX.....03

Size	Pitch(mm)	No. Flutes	GD3	GD4	GD5	GD6	List Price	Drill Size	Decimal Equiv.	Percent Thread
M2.5	0.45	3	30062-89-B				\$54.56	#44	0.0860	54%
M3	0.5	3	30063-89-B				\$37.18	#37	0.1040	55%
M3.5	0.6	3		30064-89-B			\$33.90	#31	0.1200	58%
M4	0.7	3		30065-89-B			\$30.67	#29	0.1360	60%
M5	0.8	3		30066-89-B			\$31.54	#17	0.1730	58%
M6	1.0	3			30067-89-B		\$39.89	#4	0.2090	53%
M7	1.0	3			30068-89-B		\$41.68	1/4	0.2500	50%
M8	1.0	3			30069-89-B		\$43.57	7.25mm	0.2854	57%
M8	1.25	3			30070-89-B		\$43.64	9/32	0.2813	52%
M10	1.25	3			30071-89-B		\$63.04	23/64	0.3594	53%
M10	1.5	3				30072-89-B	\$63.04	9.0mm	0.3543	51%
M12	1.25	3			30073-89-B		\$72.62	7/16	0.4375	54%
M12	1.75	3				30074-89-B	\$72.70	27/64	0.4219	56%

**Material Application Guidelines : Spiral Point - Nickel Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Best Suited			○									●				●
Cutting Speed			40-60 SFM									5-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○

High Performance

**Spiral Flute - Fractional**

- HSS-CV Premium Powder Substrate
- Available only with M/B Chamfer
- TiCN (89) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



**SURFACE TREATMENTS**

- TiCN.....89
- SOX.....03

Size	NC	NF	No. Flutes	GH2	GH3	GH4	GH5	GH7	List Price	Drill Size	Decimal Equiv.	Percent Thread
2	56		2	30700-89-B					\$67.34	#49	0.0730	56%
4	40		3	30701-89-B	30702-89-B				\$42.11	3/32	0.0938	56%
6	32		3	30703-89-B	30704-89-B		30705-89-B		\$34.93	#32	0.1160	54%
8	32		3	30706-89-B	30707-89-B		30708-89-B		\$34.93	9/64	0.1406	58%
10	24		3		30709-89-B		30710-89-B		\$35.81	#20	0.1610	54%
10		32	3	30711-89-B	30712-89-B		30713-89-B		\$35.81	#19	0.1660	59%
1/4	20		3		30714-89-B		30715-89-B	30716-89-B	\$39.41	#3	0.2130	57%
1/4		28	3		30717-89-B	30718-89-B	30719-89-B	30720-89-B	\$39.41	#2	0.2210	63%
5/16	18		3		30721-89-B		30722-89-B	30723-89-B	\$42.25	1	0.2720	56%
5/16		24	3		30724-89-B	30725-89-B	30726-89-B	30727-89-B	\$43.53	9/32	0.2813	58%
3/8	16		3		30728-89-B	30729-89-B	30730-89-B	30731-89-B	\$46.95	21/64	0.3281	58%
3/8		24	3		30732-89-B	30733-89-B	30734-89-B	30735-89-B	\$48.36	11/32	0.3438	58%
7/16	14		3		30736-89-B		30737-89-B	30738-89-B	\$58.28	W	0.3860	56%
7/16		20	3		30739-89-B		30740-89-B	30741-89-B	\$60.03	10.2mm	0.4016	55%
1/2	13		3		30742-89-B		30743-89-B	30744-89-B	\$68.33	11.2mm	0.4409	59%
1/2		20	3		30745-89-B		30746-89-B	30747-89-B	\$70.39	11.8mm	0.4646	55%
9/16	12		3		30748-89-B				\$97.62	1/2	0.5000	58%
9/16		18	3		30749-89-B				\$97.62	33/64	0.5156	65%
5/8	11		4		30750-89-B		30751-89-B	30752-89-B	\$129.58	9/16	0.5625	53%
5/8		18	4		30753-89-B		30754-89-B	30755-89-B	\$129.58	37/64	0.5781	62%
3/4	10		4		30756-89-B		30757-89-B	30758-89-B	\$165.66	43/64	0.6719	60%
3/4		16	4		30759-89-B		30760-89-B	30761-89-B	\$165.66	18.0mm	0.7087	51%

**Material Application Guidelines : Spiral Flute - Nickel Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 Hrc	35-45 Hrc
Series																
Best Suited			○								●					●
Cutting Speed			40-60 SFM								5-15 SFM					10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○

High Performance

**Spiral Flute - Metric**

- HSS-CV Premium Powder Substrate
- Available only with M/B Chamfer
- TiCN (89) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



SURFACE TREATMENTS	
<span style="display:inline-block; width:15px; height:10px; background-color:blue; border:1px solid black;"></span> TiCN.....89	
<span style="display:inline-block; width:15px; height:10px; background-color:black; border:1px solid black;"></span> SOX.....03	

Size	Pitch(mm)	No. Flutes	GD3	GD4	GD5	GD6	List Price	Drill Size	Decimal Equiv.	Percent Thread
M2.5	0.45	3	30762-89-B				\$69.51	#44	0.0860	54%
M3	0.5	3	30763-89-B				\$46.95	#37	0.1040	55%
M3.5	0.6	3		30764-89-B			\$43.26	#31	0.1200	58%
M4	0.7	3		30765-89-B			\$39.18	#29	0.1360	60%
M5	0.8	3		30766-89-B			\$39.95	#17	0.1730	58%
M6	1.0	3			30767-89-B		\$44.10	#4	0.2090	53%
M7	1.0	3			30768-89-B		\$46.61	1/4	0.2500	50%
M8	1.0	3			30769-89-B		\$48.93	7.25mm	0.2854	57%
M8	1.25	3			30770-89-B		\$48.84	9/32	0.2813	52%
M10	1.25	3			30771-89-B		\$66.61	23/64	0.3594	53%
M10	1.5	3				30772-89-B	\$66.61	9.0mm	0.3543	51%
M12	1.25	3			30773-89-B		\$79.73	7/16	0.4375	54%
M12	1.75	3				30774-89-B	\$79.39	27/64	0.4219	56%

**Material Application Guidelines : Spiral Flute - Nickel Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Best Suited			○									●				●
Cutting Speed			40-60 SFM									5-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

BEST	●
GOOD	○



## High Performance

### Spiral Point - Fractional

- HSS-CV Premium Powder Substrate
- Available only with Plug Chamfer
- CrC (90) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



#### SURFACE TREATMENTS

- CrC.....90
- SOX.....03

Size	NC	NF	No. Flutes	GH2	GH3	GH4	GH5	GH7	List Price	Drill Size	Decimal Equiv.	Percent Thread
2	56		2	30800-90-B					\$55.48	#49	0.0730	56%
4	40		3	30801-90-B	30802-90-B				\$35.28	3/32	0.0938	56%
6	32		3	30803-90-B	30804-90-B		30805-90-B		\$27.40	#32	0.1160	54%
8	32		3		30806-90-B		30807-90-B		\$27.40	9/64	0.1406	58%
10	24		3		30808-90-B		30809-90-B		\$29.27	#20	0.1610	54%
10		32	3		30810-90-B		30811-90-B		\$29.27	#19	0.1660	59%
1/4	20		3		30812-90-B		30813-90-B		\$37.86	#3	0.2130	57%
1/4		28	3		30814-90-B		30815-90-B		\$37.86	#2	0.2210	63%
5/16	18		3		30816-90-B		30817-90-B		\$41.31	I	0.2720	56%
5/16		24	3		30818-90-B		30819-90-B		\$41.31	9/32	0.2813	58%
3/8	16		3		30820-90-B		30821-90-B		\$46.49	21/64	0.3281	58%
3/8		24	3		30822-90-B		30823-90-B		\$46.49	11/32	0.3438	58%
7/16	14		3		30824-90-B		30825-90-B		\$60.07	W	0.3860	56%
7/16		20	3		30826-90-B		30827-90-B		\$60.07	10.2mm	0.4016	55%
1/2	13		3		30828-90-B		30829-90-B		\$70.21	11.2mm	0.4409	59%
1/2		20	3		30830-90-B		30831-90-B		\$70.21	11.8mm	0.4646	55%

### Material Application Guidelines : Spiral Point - Titanium Alloy Series

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Series																
Best Suited												●				○
Cutting Speed												10-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○



High Performance

**Spiral Point - Metric**

- HSS-CV Premium Powder Substrate
- Available only with Plug Chamfer
- CrC (90) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



**SURFACE TREATMENTS**

- CrC.....90
- SOX.....03

Size	Pitch(mm)	No. Flutes	GD3	GD4	GD5	GD6	List Price	Drill Size	Decimal Equiv.	Percent Thread
M2.5	0.45	3	30832-90-B				\$58.34	#44	0.0860	54%
M3	0.5	3	30833-90-B				\$39.66	#37	0.1040	55%
M3.5	0.6	3		30834-90-B			\$36.16	#31	0.1200	58%
M4	0.7	3		30835-90-B			\$32.75	#29	0.1360	60%
M5	0.8	3		30836-90-B			\$33.57	#17	0.1730	58%
M6	1.0	3			30837-90-B		\$42.51	#4	0.2090	53%
M7	1.0	3			30838-90-B		\$44.46	1/4	0.2500	50%
M8	1.0	3			30839-90-B		\$46.47	7.25mm	0.2854	57%
M8	1.25	3			30840-90-B		\$46.54	9/32	0.2813	52%
M10	1.25	3			30841-90-B		\$67.17	23/64	0.3594	53%
M10	1.5	3				30842-90-B	\$67.17	9.0mm	0.3543	51%
M12	1.25	3			30843-90-B		\$77.46	7/16	0.4375	54%
M12	1.75	3				30844-90-B	\$77.55	27/64	0.4219	56%

**Material Application Guidelines : Spiral Point - Titanium Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Series																
Best Suited												●				○
Cutting Speed												10-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○

High Performance

**Spiral Flute - Fractional**

- HSS-CV Premium Powder Substrate
- Available only with M/B Chamfer
- CrC (90) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



SURFACE TREATMENTS	
<span style="display:inline-block; width:15px; height:10px; background-color:lightblue; border:1px solid black;"></span> CrC.....90	
<span style="display:inline-block; width:15px; height:10px; background-color:black; border:1px solid black;"></span> SOX.....03	

Size	NC	NF	No. Flutes	GH2	GH3	GH4	GH5	GH7	List Price	Drill Size	Decimal Equiv.	Percent Thread
2	56		2	30900-90-B					\$72.74	#49	0.0730	56%
4	40		3	30901-90-B	30902-90-B				\$45.49	3/32	0.0938	56%
6	32		3	30903-90-B	30904-90-B		30905-90-B		\$37.31	#32	0.1160	54%
8	32		3		30906-90-B		30907-90-B		\$37.31	9/64	0.1406	58%
10	24		3		30908-90-B		30909-90-B		\$38.24	#20	0.1610	54%
10		32	3		30910-90-B		30911-90-B		\$38.24	#19	0.1660	59%
1/4	20		3		30912-90-B		30913-90-B		\$42.11	#3	0.2130	57%
1/4		28	3		30914-90-B		30915-90-B		\$42.11	#2	0.2210	63%
5/16	18		3		30916-90-B		30917-90-B		\$46.49	1	0.2720	56%
5/16		24	3		30918-90-B		30919-90-B		\$46.49	9/32	0.2813	58%
3/8	16		3		30920-90-B		30921-90-B		\$51.64	21/64	0.3281	58%
3/8		24	3		30922-90-B		30923-90-B		\$51.64	11/32	0.3438	58%
7/16	14		3		30924-90-B		30925-90-B		\$64.08	W	0.3860	56%
7/16		20	3		30926-90-B		30927-90-B		\$64.08	10.2mm	0.4016	55%
1/2	13		3		30928-90-B		30929-90-B		\$75.17	11.2mm	0.4409	59%
1/2		20	3		30930-90-B		30931-90-B		\$75.17	11.8mm	0.4646	55%

**Material Application Guidelines : Spiral Flute - Titanium Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Series																
Best Suited												●				○
Cutting Speed												10-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

BEST	●
GOOD	○



High Performance

**Spiral Flute - Metric**

- HSS-CV Premium Powder Substrate
- Available only with M/B Chamfer
- CrC (90) is the standard Coating for this series
- Alternate Coatings/Treatments available upon request
- Allow up to 2 weeks for non-standard Treatments/Coatings other than Steam Oxide (03).



**SURFACE TREATMENTS**

- CrC.....90
- SOX.....03

Size	Pitch(mm)	No. Flutes	GD3	GD4	GD5	GD6	List Price	Drill Size	Decimal Equiv.	Percent Thread
M2.5	0.45	3	30932-90-B				\$76.05	#44	0.0860	54%
M3	0.5	3	30933-90-B				\$51.69	#37	0.1040	55%
M3.5	0.6	3		30934-90-B			\$47.33	#31	0.1200	58%
M4	0.7	3		30935-90-B			\$43.08	#29	0.1360	60%
M5	0.8	3		30936-90-B			\$43.98	#17	0.1730	58%
M6	1.0	3			30937-90-B		\$48.52	#4	0.2090	53%
M7	1.0	3			30938-90-B		\$50.99	1/4	0.2500	50%
M8	1.0	3			30939-90-B		\$53.53	7.25mm	0.2854	57%
M8	1.25	3			30940-90-B		\$53.76	9/32	0.2813	52%
M10	1.25	3			30941-90-B		\$73.22	23/64	0.3594	53%
M10	1.5	3				30942-90-B	\$73.22	9.0mm	0.3543	51%
M12	1.25	3			30943-90-B		\$87.23	7/16	0.4375	54%
M12	1.75	3				30944-90-B	\$87.32	27/64	0.4219	56%

**Material Application Guidelines : Spiral Flute - Titanium Alloy Series**

Work Material	Aluminum		Cast iron		Steel			Alloy Steel	Stainless Steel			High Nickel	Titanium Alloy	Die Steel	Hardened Steel	
	Wrought	Casting	Gray	Ductile Malleable	Low Carbon	Medium Carbon	High Carbon		300 Series	400 Series	PH Series				<35 HrC	35-45 HrC
Series																
Best Suited												●				○
Cutting Speed												10-15 SFM				10-25 SFM
Material Examples	6160 7075				1008 1018	1035 1045	1050 1055	4140 4340	303 304-316		17-4PH 15-5PH	Inconel Monel	6Al4V	D2, S7		

**BEST** ●  
**GOOD** ○



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