

FRACTIONAL HSS DRILLS

Fractional Size	Decimal Equivalent	General Purpose 118° Point	Heavy Duty 135° Split Point	Cobalt 135° Split Point	Fast Spiral 118° Point	Slow Spiral 118° Point	Half Round 118° Point
1/64	.015625	2.16	—	*3.77	2.17	3.26	5.89
1/32	.03125	1.32	—	*3.09	2.39	2.72	4.46
3/64	.046875	1.32	—	*2.22	1.87	2.58	8.42
1/16	.0625	1.29	1.38	2.03	1.85	2.46	8.68
5/64	.078125	1.29	1.38	2.03	1.87	2.46	8.68
3/32	.09375	1.18	1.38	2.03	1.87	2.46	8.68
7/64	.109375	1.24	1.46	2.14	1.88	2.46	9.06
1/8	.1250	1.21	1.46	2.59	1.81	2.38	9.18
9/64	.140625	1.33	1.60	2.62	1.88	2.38	9.91
5/32	.15625	1.36	1.62	2.93	1.96	2.85	10.08
11/64	.171875	1.48	1.75	3.09	2.36	3.20	10.56
3/16	.1875	1.65	1.97	3.44	2.63	3.35	11.43
13/64	.203125	1.82	2.15	4.15	3.01	3.78	12.64
7/32	.21875	2.01	2.39	4.55	3.29	4.43	13.56
15/64	.234375	2.18	2.62	4.84	3.72	4.85	14.53
1/4	.2500	2.30	2.75	5.11	3.54	4.85	19.92
17/64	.265625	2.79	3.31	5.84	4.79	5.84	22.47
9/32	.28125	2.88	3.40	6.13	4.78	6.46	25.07
19/64	.296875	3.34	3.95	7.49	5.54	7.17	27.63
5/16	.3125	3.69	4.35	7.98	5.67	7.90	30.28
21/64	.328125	4.11	4.86	8.79	6.60	8.34	33.17
11/32	.34375	4.55	5.39	9.64	7.00	9.36	36.15
23/64	.359375	5.14	6.11	11.16	8.74	11.17	39.16
3/8	.3750	5.23	6.22	10.99	8.44	11.17	42.13
25/64	.390625	6.01	7.14	12.62	10.15	12.33	45.58
13/32	.40625	6.15	7.33	13.14	9.85	12.83	49.02
27/64	.421875	6.84	8.14	14.55	11.78	14.48	52.46
7/16	.4375	7.14	8.47	14.85	11.56	14.88	55.89
29/64	.453125	8.01	9.47	17.91	12.68	16.91	59.61
15/32	.46875	8.46	10.04	18.24	13.06	18.25	63.33
31/64	.484375	8.93	10.53	18.81	14.28	19.06	67.05
1/2	.5000	8.86	10.56	18.51	13.79	19.06	70.75

* NOT SPLIT POINT

- ALSO AVAILABLE :**
- LETTER SIZES
 - PARABOLIC FLUTE
 - STRAIGHT FLUTE
 - CARBIDE TIPPED
 - TAPER SHANKS
 - SUPERFLUTE
 - TYPE A
 - TYPE C
 - DECIMAL SIZES
 - METRIC SIZES
 - TAPER LENGTHS
 - TYPE M
 - AUTOMOTIVE
 - BRITE OR BLACK FINISH
 - TYPE B

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NO PACKAGE QUANTITY

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WIRE SIZE HSS DRILLS



General Purpose



Slow Spiral



Fast Spiral



Half Round

Wire Size	Decimal Equivalent	General Purpose 118° Point	Heavy Duty 135° Split Point	Cobalt 135° Split Point	Fast Spiral 118° Point	Slow Spiral 118° Point	Half Round 118° Point
1	.2280	2.45	3.14	5.54	3.68	4.99	13.56
2	.2210	2.47	3.19	5.54	3.77	4.99	13.56
3	.2130	2.23	2.86	5.17	3.54	4.80	12.64
4	.2090	2.24	2.89	5.20	3.54	4.80	12.64
5	.2055	2.24	2.89	5.20	3.54	4.80	12.64
6	.2040	2.24	2.89	5.20	3.54	4.80	12.64
7	.2010	1.94	2.53	4.03	2.90	4.14	11.43
8	.1990	1.99	2.55	4.03	2.98	4.14	11.43
9	.1960	1.98	2.55	4.03	2.90	4.14	11.43
10	.1935	1.95	2.53	4.03	2.90	4.14	11.43
11	.1910	1.82	2.35	4.03	2.75	3.87	11.43
12	.1890	1.84	2.37	4.03	2.91	3.87	11.43
13	.1850	1.80	2.30	3.87	2.74	3.63	10.56
14	.1820	1.80	2.30	3.88	2.74	3.63	10.56
15	.1800	1.80	2.30	3.88	2.65	3.63	10.56
16	.1770	1.80	2.30	3.60	2.65	3.63	10.56
17	.1730	1.80	2.30	3.54	2.74	3.63	10.56
18	.1695	1.49	1.91	3.22	2.36	3.20	10.08
19	.1660	1.48	1.89	3.13	2.30	3.20	10.08
20	.1610	1.47	1.89	3.13	2.30	3.20	10.08
21	.1590	1.36	1.74	3.11	2.10	3.09	10.08
22	.1570	1.38	1.75	3.13	2.18	3.09	10.08
23	.1540	1.38	1.73	3.13	2.03	3.09	9.91
24	.1520	1.38	1.73	3.11	1.92	3.09	9.91
25	.1495	1.30	1.67	2.83	1.92	2.98	9.91
26	.1470	1.32	1.69	2.82	1.92	2.98	9.91
27	.1440	1.31	1.67	2.81	1.92	2.98	9.91
28	.1405	1.24	1.54	2.63	1.88	2.98	9.18
29	.1360	1.24	1.53	2.56	1.78	2.46	9.18
30	.1285	1.24	1.53	2.38	1.79	2.46	9.18
31	.1200	1.24	1.51	2.37	1.83	2.46	9.06
32	.1160	1.24	1.51	2.32	1.83	2.46	9.06
33	.1130	1.24	1.51	2.23	1.88	2.46	9.06
34	.1110	1.24	1.51	2.24	1.88	2.46	9.06
35	.1100	1.36	1.51	2.23	1.83	2.46	9.06
36	.1065	1.36	1.50	2.20	1.88	2.46	8.68
37	.1040	1.36	1.51	2.20	1.83	2.46	8.68
38	.1015	1.36	1.51	2.06	1.83	2.46	8.68
39	.0995	1.36	1.51	2.06	1.83	2.46	8.68
40	.0980	1.36	1.51	2.06	1.79	2.46	8.68

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WIRE SIZE HSS DRILLS

Typical Uses:

General Purpose:	Cast Iron, Steel, Steel Forgings, Short Runs
Heavy Duty:	Stainless Steel, Tough Alloy Steel
Cobalt:	Titanium, Asbestos, Graphite, High Temperature Alloys, Glass Filled Epoxies, Clay
Fast Spiral:	Aluminum, Magnesium, Copper, Bronze, Soft Steel, Slate, Wood, Die Casting
Slow Spiral:	Brass, Soft Materials
Half Round:	Brass, Copper, Hard Rubber, Soft Woods, Molded Plastics

Wire Size	Decimal Equivalent	General Purpose 118° Point	Heavy Duty 135° Split Point	Cobalt 135° Split Point *	Fast Spiral 118° Point	Slow Spiral 118° Point	Half Round 118° Point
41	.0960	1.36	1.50	2.03	1.91	2.46	8.68
42	.0935	1.36	1.51	2.00	1.91	2.46	8.68
43	.0890	1.36	1.50	2.00	1.81	2.46	8.68
44	.0860	1.36	1.50	2.00	1.87	2.46	8.68
45	.0820	1.36	1.51	2.00	1.87	2.46	8.68
46	.0810	1.36	1.51	2.00	1.87	2.47	8.68
47	.0785	1.36	1.51	2.00	1.91	2.47	8.68
48	.0760	1.36	1.51	2.00	1.87	2.47	8.68
49	.0730	1.36	1.51	2.00	1.91	2.47	8.68
50	.0700	1.36	1.51	2.00	1.87	2.47	8.68
51	.0670	1.36	1.51	2.00	1.87	2.47	8.68
52	.0635	1.36	1.51	2.00	1.87	2.71	8.68
53	.0595	1.36		2.23	1.87	2.74	8.42
54	.0550	1.36		2.23	1.87	3.57	8.42
55	.0520	1.36		2.23	1.81	3.57	8.42
56	.0465	1.36		2.54	1.87	3.57	8.42
57	.0430	1.36		2.54	1.91	3.57	8.42
58	.0420	1.36		2.55	1.91	3.57	4.06
59	.0410	1.36		2.54	1.91	3.57	3.71
60	.0400	1.36		2.54	1.91	3.57	3.71
61	.0390	1.36		2.93	2.20	3.57	3.80
62	.0380	1.36		2.93	2.20	4.26	3.80
63	.0370	1.36		2.92	2.20	4.26	3.80
64	.0360	1.36		2.93	2.20	2.46	3.80
65	.0350	1.36		2.92	2.08	2.46	3.80
66	.0330	1.36		3.11	2.20	2.46	3.80
67	.0320	1.36		3.09	2.08	2.46	3.80
68	.0310	1.36		3.09	2.08	2.46	3.80
69	.0292	1.53		3.50	2.33	2.51	5.01
70	.0280	1.53		3.50	2.33	2.53	5.01
71	.0260	1.86		3.51	3.05	3.31	5.01
72	.0250	1.86		3.51	2.87	3.31	5.01
73	.0240	1.86		3.51	2.86	3.31	5.01
74	.0225	1.86		3.51	2.87	3.31	5.01
75	.0210	1.86		3.88	2.87	3.31	5.01
76	.0200	1.86		3.86	2.86	3.31	5.01
77	.0180	1.86		3.88	2.87	3.31	5.01
78	.0160	1.86		3.86	2.87	3.31	5.01
79	.0145	2.26		3.88	3.37	3.94	5.01
80	.0135	2.26		3.90	3.37	3.94	5.01

* #53 - #80 NOT SPLIT POINT

- Also available:**
- Extension Drills - Page 22
 - Combination Drill & Countersinks - Page 24

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EXTENSION DRILLS & LONGBOYS



Size	Decimal Equivalent	6" Aircraft Extension 135° Split Point	12" Aircraft Extension 135° Split Point	12" Extended 135° Split Point	8" Longboy 118° Point	12" Longboy 118° Point	18" Longboy 118° Point
1/16	.0625	4.08	12.79	2.72	—	20.47	—
5/64	.078125	4.08	12.79	2.72	—	17.86	—
3/32	.09375	3.66	12.79	2.34	12.88	23.89	—
7/64	.109375	3.66	10.05	2.53	10.87	15.61	—
1/8	.1250	3.66	10.05	2.35	10.13	18.25	40.41
9/64	.140625	3.66	10.05	2.45	9.91	19.82	25.92
5/32	.15625	3.66	10.05	2.63	11.16	19.82	40.41
11/64	.171875	4.02	11.13	2.72	11.40	20.65	25.92
3/16	.1875	4.02	11.13	2.92	11.47	20.65	41.99
13/64	.203125	4.88	12.79	3.10	12.46	24.14	31.74
7/32	.21875	4.88	12.79	3.29	12.48	24.14	31.74
15/64	.234375	5.31	13.75	3.48	12.38	24.14	31.74
1/4	.2500	5.31	13.75	3.78	12.80	24.14	42.06
17/64	.265625	11.84	16.35	4.23	11.87	24.14	35.15
9/32	.28125	12.29	17.28	4.42	13.44	24.14	35.15
19/64	.296875	14.44	19.59	4.80	13.54	24.85	35.15
5/16	.3125	15.67	22.02	5.36	13.78	24.85	44.39
21/64	.328125	17.01	23.05	5.55	17.79	25.90	37.25
11/32	.34375	16.83	23.75	6.03	14.55	25.90	37.25
23/64	.359375	18.90	25.58	6.12	16.43	26.57	37.25
3/8	.3750	19.25	27.05	6.40	14.80	26.57	47.60
25/64	.390625	21.48	28.53	6.79	18.67	29.85	40.53
13/32	.40625	20.72	28.53	7.16	16.79	29.85	40.53
27/64	.421875	23.05	30.65	7.55	23.58	31.60	43.74
7/16	.4375	23.32	32.08	8.10	17.76	31.60	55.60
29/64	.453125	25.56	33.98	8.49	20.33	34.74	49.97
15/32	.46875	26.51	36.49	8.95	19.87	34.74	49.97
31/64	.484375	27.49	36.49	9.32	27.25	35.43	52.07
1/2	.5000	27.97	38.53	9.62	19.94	35.43	66.29

- Aircraft extension drills are one-piece extra-long shafts with the same flute length as jobber length drills.
- 12" extended drills are an economical alternative to aircraft extensions with HSS shafts welded to jobber length drills.
- Longboy drills are fluted over a much longer length for certain deep hole drilling applications.
- Additional lengths up to 24" available - Call for price and delivery

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DOUBLE END END MILLS



3/16 Shank, Double End Cobalt

Diameter of Cutter	Length of Cut	Stub (2" Long)			Length of Cut	Standard (2-1/4" Long)		
		2 Flute	2 Flute Ball	4 Flute		2 Flute	2 Flute Ball	4 Flute
1/32	3/64	16.60	24.50	17.60	3/32	18.70	25.60	18.60
3/64	1/16	16.60	24.50	17.60	9/64	18.70	25.60	18.60
1/16	3/32	15.60	22.10	16.00	3/16	16.50	23.40	16.90
5/64	1/8	15.60	22.10	16.00	15/64	16.50	23.40	20.19
3/32	9/64	15.60	22.10	16.00	9/32	16.50	23.40	16.90
7/64	5/32	15.60	22.10	16.00	21/64	16.50	23.40	20.19
1/8	3/16	15.60	22.10	16.00	3/8	16.50	23.40	16.90
9/64	7/32	17.50	24.80	17.10	13/32	17.60	24.50	20.70
5/32	15/64	17.50	24.80	17.10	7/16	17.60	24.50	17.90
11/64	1/4	17.50	24.80	17.10	1/2	17.60	24.50	21.56
3/16	9/32	17.50	24.80	17.10	1/2	17.60	24.50	17.90

Double End Carbide End Mills, Stub Length

Diameter of Cut	Shank Diameter	Length of Cut	Length Overall	2-FLUTE	4-FLUTE
1/32	1/8	1/16	1-1/2	17.01	17.89
3/64	1/8	1/16	1-1/2	17.01	17.89
1/16	1/8	1/8	1-1/2	16.20	17.02
5/64	1/8	1/8	1-1/2	16.20	17.02
3/32	1/8	3/16	1-1/2	16.20	17.02
7/64	1/8	1/4	1-1/2	16.20	17.02
1/8	1/8	1/4	1-1/2	16.20	17.02
9/64	3/16	5/16	2	21.99	23.06
5/32	3/16	5/16	2	21.99	22.50
11/64	3/16	3/8	2	21.99	22.50
3/16	3/16	3/8	2	21.99	22.50
7/32	1/4	1/2	2-1/2	27.27	28.60
1/4	1/4	1/2	2-1/2	27.27	28.60
5/16	5/16	1/2	2-1/2	37.67	39.57
3/8	5/16	1/2	2-1/2	40.28	42.28

ALSO AVAILABLE:

- 4 Flute Ball
- 2 Flute Single End
- 3 Flute
- 4 Flute Single End
- Decimal Sizes .006 - .187
- Single End Carbide
- Metric Sizes
- Ball End Carbide

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COMBINATION DRILL & COUNTERSINKS



PLAIN TYPE COUNTERSINKS

Countersink Size Number	Diameter of Body	Diameter of Drill	Length of Drill	Length Overall Inches	60° R.H. Price Each	82° Angle R.H. Price Each	90° Angle R.H. Price Each
00000	1/8	.010	.010	1¼	8.80	—	33.98
0000	1/8	.015	.015	1¼	8.08	—	33.98
000	1/8	.020	.020	1¼	7.66	—	21.70
00	1/8	.025	.025	1¼	7.66	21.70	21.70
0	1/8	1/32	1/32	1¼	7.66	21.70	21.70
1	1/8	3/64	3/64	1¼	5.18	9.73	9.73
2	3/16	5/64	5/64	1½	5.42	9.96	9.96
3	1/4	7/64	7/64	2	5.64	10.31	10.31
4	5/16	1/8	1/8	2½	5.83	10.70	10.70
4½	3/8	9/64	9/64	2½	8.97	14.67	14.67
5	7/16	3/16	3/16	2¾	9.19	16.32	16.32
6	1/2	7/32	7/32	3	13.87	24.72	24.72
7	5/8	1/4	1/4	3¼	20.02	34.96	34.96
8	3/4	5/16	5/16	3½	27.85	49.04	49.04
9	7/8	11/32	11/32	3¾	52.30	—	—
10	1"	3/8	3/8	3¾	68.66	—	—

BELL TYPE COUNTERSINKS



Countersink Size Number	Diameter of Body	Diameter of Drill	Length of Drill	Diameter of Bell Inches	Length Overall Inches	HSS RH Price Each	M42 RH Price Each	T15 RH Price Each
11	1/8	3/64	3/64	.100	1¼	6.16	16.06	21.52
12	3/16	1/16	1/16	.150	1½	6.45	16.47	22.03
13	1/4	3/32	3/32	.200	2	6.54	16.92	22.63
14	5/16	7/64	7/64	.250	2½	6.75	17.48	23.11
15	7/16	5/32	5/32	.350	2¾	10.28	27.88	36.53
16	1/2	3/16	3/16	.400	3	15.81	43.10	55.63
17	5/8	7/32	7/32	.500	3¼	23.49	64.14	83.51
18	3/4	1/4	1/4	.600	3½	31.47	89.50	119.00

LONGBOY COUNTERSINKS (HSS 60° Angle) FOR LONG REACH APPLICATIONS - 3, 4, 5 & 6" OVERALL

Countersink Size Number	Diameter of Body	Diameter of Drill	Length of Drill	3" Price Each	4" Price Each	5" Price Each	6" Price Each
1	1/8	3/64	3/64	13.59	14.18	19.72	25.79
2	3/16	5/64	5/64	—	15.54	19.89	25.90
3	1/4	7/64	7/64	—	16.35	21.54	26.14
4	5/16	1/8	1/8	—	18.14	23.16	26.77
4 1/2	3/8	9/64	9/64	—	20.39	24.10	29.04
5	7/16	3/16	3/16	—	23.82	27.59	30.98
6	1/2	7/32	7/32	—	—	29.64	35.82
7	5/8	1/4	1/4	—	—	—	66.06
8	3/4	5/16	5/16	—	—	—	71.42

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SINGLE & SIX FLUTE COUNTERSINKS

SINGLE FLUTE COUNTERSINKS



Tool No.	C/L Angles Available	Body Dia.	Shank Dia.	Shank Length	O/A Length	HSS Price
1/8-SF	30° 41° 45° 50° AND 60°	1/8	1/8	-	1½	6.86
3/16-SF		3/16	3/16	-	1½	7.33
1/4-SF		1/4	1/4	-	2	7.63
5/16-SF		5/16	1/4	7/8	1¾	8.96
3/8-SF		3/8	1/4	7/8	1¾	10.37
1/2-SF		1/2	1/4	1½	2½	13.33
5/8-SF		5/8	3/8	1½	2¾	18.94
3/4-SF		3/4	1/2	1½	2½	25.37
1-SF		1	1/2	1½	2¾	38.91
1½-SF		1½	3/4	1½	3	62.44
1½-SF	1½	3/4	1½	3½	85.76	
1½-SF	1½	1	2½	4¾	116.10	
2-SF	2	1	2½	4¾	147.00	
2½-SF	2½	1	2½	4¾	248.87	
3-SF	3	1	2½	5	373.92	

SIX FLUTE COUNTERSINKS

DESIGN - Hutchinson Countersinks are designed to take heavy cuts and produce exceptionally smooth seats.

SHEAR-CUT TEETH - Cutting teeth are arranged to give a shearing cut, eliminating "chatter" possibility.

TRUNCATED END-DIMENSIONS- Diameter at small end of 30° countersinks is approximately one third of the body diameter; of 41° and 45° countersinks it is about one-fifth, and of 60° countersinks it is about one-sixth.

HIGH SPEED STEEL

Tool No.	C/L Angles Available	Body Dia.	Shank Dia.	Shank Length	O/A Length	Price Each
CK-1/8	30° 41° 45° 50° AND 60°	1/8	1/8	-	1½	7.54
CK-3/16		3/16	3/16	-	1½	8.10
CK-1/4		1/4	3/16	3/4	1½	8.14
CK-5/16		5/16	1/4	7/8	1¾	9.99
CK-3/8		3/8	1/4	7/8	1¾	11.14
CK-1/2		1/2	3/8	1½	2¾	14.10
CK-5/8		5/8	3/8	1½	2¾	20.19
CK-3/4		3/4	1/2	1½	2¾	26.96
CK-7/8		7/8	1/2	1½	2¾	35.36
CK-1		1	1/2	1½	2¾	41.49



CARBIDE

Tool No.	C/L Angles Available	Body Dia.	Shank Dia.	Shank Length	O/A Length	Price Each
CK-1/8-W	30° 41° 45° 50° AND 60°	1/8	1/8	-	1½	9.81
CK-3/16-W		3/16	3/16	-	2	12.34
CK-1/4-W		1/4	1/4	-	2	15.77
CK-5/16-W		5/16	1/4	2	2¾	23.61
CK-3/8-W		3/8	1/4	2	2¾	30.51
CK-1/2-W		1/2	3/8	2	2¾	42.47
CK-5/8-W		5/8	3/8	2	2¾	58.37
CK-3/4-W		3/4	1/2	2	2¾	71.44
CK-7/8-W		7/8	1/2	2	2¾	105.00
CK-1-W		1	1/2	2	3	120.99

DOUBLE END Six Flute Countersinks



HIGH SPEED STEEL

Tool No.	C/L Angles Available	Diameter	O/A Length	Price Each
CK-1/8-DE	30° 41° 45° 50° 60°	1/8	1½	12.86
CK-3/16-DE		3/16	2	14.01
CK-1/4-DE		1/4	2	14.36
CK-3/8-DE		3/8	2½	24.26
CK-1/2-DE		1/2	3	35.19
CK-5/8-DE		5/8	3¾	52.76

CARBIDE

Tool No.	C/L Angles Available	Diameter	O/A Length	Price Each
CK-1/8-W-DE	30° 41° 45° 50° 60°	1/8	1½	17.61
CK-3/16-W-DE		3/16	2	25.37
CK-1/4-W-DE		1/4	2	34.59
CK-3/8-W-DE		3/8	2½	77.53
CK-1/2-W-DE		1/2	3	107.44
CK-5/8-W-DE		5/8	3¾	89.20

WILLIAM T. HUTCHINSON CO.

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ROTARY FILE SETS – COUNTERSINK SETS



SET #4E 52.24
1/8" Solid Carbide
1/8" Shank



SET #16E 194.24
1/2" Carbide Head
1/4" Shank



SET #14E 196.97
3/8" Carbide 6 flutes
1/2" Carbide 8 flutes



SET #8E 100.50
1/4" Solid Carbide
1/4" Shank

All rotary file sets furnished in convenient cases.
Individual rotary files also available.

SIX FLUTE CHATTERLESS COUNTERSINK SETS

Set #27 - Chatterless Countersink Set containing 1/4, 3/8, 1/2 and 3/4 inch diameter cutters. Specify Center Line Angle desired.

High Speed Steel \$60.34

Set #27W - Chatterless Countersink Set containing a 1/4, 3/8, 1/2, and 3/4 inch Carbide Countersink. Specify Center Line Angle desired.

Carbide \$160.20

Set #29 - Chatterless Countersink Set containing 1/4, 3/8, 1/2, 5/8, 3/4 and 1 inch diameter cutters. Specify Center Line Angle desired.

High Speed Steel \$122.01



C/L ANGLES AVAILABLE:
30°, 41°, 45°, 50° and 60°



SINGLE FLUTE COUNTERSINK SETS

Set #35 - Contains a 1/4, 1/2, 3/4, 1 and 1 1/4 inch diameter HSS Single Flute Countersink. Specify Center Line Angle desired.

High Speed Steel \$158.06

Set #36W - Contains a 1/4, 3/8, 1/2, 5/8 and 3/4 inch diameter Carbide Single Flute Countersink. Specify Center Line Angle desired.

Carbide \$373.93

Set #37 - Contains a 1/4, 3/8, 1/2, 5/8, 3/4, 1, 1 1/4, 1 1/2, 1 3/4 and 2 inch HSS Single Flute Countersink. Specify Center Line Angle desired

High Speed Steel \$525.86

FOR INDIVIDUAL COUNTERSINKS, SEE PAGE 25

WILLIAM T. HUTCHINSON CO.

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HSS CHUCKING REAMERS

SERIES 700 - Straight Flute
SERIES 700C - Straight Flute Cobalt



SERIES 740 - Right Hand Spiral Flute



High Speed Steel - Straight Shank - Right Hand Cut
Fractional - Wire Gage - Letter - Over & Under - Dowel Pin - Metric

Size	Decimal	Price		
		700	740	700C
1/32	.0312	13.32	13.32	15.35
67	.0320	14.10	—	15.35
66	.0330	14.10	—	15.35
65	.0350	14.10	—	15.35
64	.0360	14.10	—	15.35
63	.0370	14.10	—	15.35
62	.0380	14.10	—	15.35
61	.0390	14.10	—	15.35
1mm	.0394	14.10	16.23	—
60	.0400	14.10	16.23	15.11
59	.0410	14.10	16.23	15.11
58	.0420	14.10	16.23	15.11
57	.0430	14.10	16.23	15.11
56	.0465	14.10	16.23	15.11
3/64	.0469	14.10	16.23	15.11
55	.0520	14.10	16.23	15.11
54	.0550	14.10	16.23	15.11
1.5mm	.0591	14.10	16.23	—
53	.0595	14.10	16.23	15.11
1/16	.0625	14.10	16.23	15.11
52	.0635	14.10	16.23	15.11
51	.0670	11.35	13.08	12.17
50	.0700	11.35	13.08	12.17
49	.0730	11.35	13.08	12.17
48	.0760	11.35	13.08	12.17
5/64	.0781	11.35	13.08	12.17
47	.0785	11.35	13.08	12.17
2mm	.0787	11.35	13.08	—
46	.0810	11.35	13.08	12.17
45	.0820	11.35	13.08	12.17
44	.0860	11.35	13.08	12.17
43	.0890	11.35	13.08	12.17
42	.0935	11.35	13.08	12.17
3/32	.0937	10.25	12.96	12.17
41	.0960	11.48	13.18	12.27
40	.0980	11.48	13.18	12.27
2.5mm	.0984	11.48	13.18	—

Size	Decimal	Price		
		700	740	700C
39	.0995	11.48	13.18	12.27
38	.1015	11.48	13.18	12.27
37	.1040	11.48	13.18	12.27
36	.1065	11.48	13.18	12.27
7/64	.1094	11.84	13.56	12.64
35	.1100	11.84	13.56	12.64
34	.1110	11.84	13.56	12.64
33	.1130	11.84	13.56	12.64
32	.1160	11.84	13.56	12.64
3mm	.1181	11.84	13.56	—
31	.1200	11.84	13.56	12.64
.1240	.1240	11.84	13.56	12.64
1/8	.1250	9.44	12.24	10.11
.1260	.1260	11.84	13.56	12.64
30	.1285	11.84	13.56	12.64
29	.1360	14.10	16.23	15.11
3.5mm	.1378	14.10	16.23	—
28	.1405	14.10	16.23	15.11
9/64	.1406	14.10	16.23	15.11
27	.1440	14.10	16.23	15.11
26	.1470	14.10	16.23	15.11
25	.1495	14.10	16.23	15.11
24	.1520	14.10	16.23	15.11
23	.1540	14.10	16.23	15.11
5/32	.1562	14.10	16.23	15.11
22	.1570	14.10	16.23	15.11
4mm	.1575	14.10	16.23	—
21	.1590	15.09	17.32	16.12
20	.1610	15.09	17.32	16.12
19	.1660	15.09	17.32	16.12
18	.1695	15.09	17.32	16.12
11/64	.1719	15.09	17.32	16.12
17	.1730	15.09	17.32	16.12
16	.1770	15.09	17.32	16.12
4.5mm	.1772	15.09	17.32	16.12
15	.1800	15.09	17.32	16.12
14	.1820	15.09	17.32	16.12

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HSS CHUCKING REAMERS

SERIES 700 - Straight Flute
SERIES 700C - Straight Flute Cobalt



SERIES 740 - Right Hand Spiral Flute



High Speed Steel - Straight Shank - Right Hand Cut
Fractional - Wire Gage - Letter - Over & Under - Dowel Pin - Metric

Size	Decimal	Price			Size	Decimal	Price		
		700	740	700C			700	740	700C
13	.1850	15.09	17.32	16.12	K	.2810	20.37	22.43	27.33
.1865	.1865	15.09	17.32	16.12	9/32	.2812	19.36	21.02	25.96
3/16	.1875	13.56	16.46	14.54	L	.2900	20.37	22.43	27.33
.1885	.1885	15.09	17.32	16.14	M	.2950	20.37	22.43	27.33
12	.1890	15.09	17.32	16.14	7.5mm	.2953	20.37	22.43	27.33
11	.1910	16.89	19.43	19.50	19/64	.2969	20.37	22.43	27.33
10	.1935	16.89	19.43	19.50	N	.3020	20.37	22.43	27.33
9	.1960	16.89	19.43	19.50	.3115	.3115	19.36	21.29	25.96
5mm	.1968	16.89	19.43	19.50	5/16	.3125	18.36	20.19	24.58
8	.1990	16.89	19.43	19.50	.3135	.3135	19.36	21.29	25.96
7	.2010	16.89	19.43	19.50	8mm	.3150	20.37	22.43	—
13/64	.2031	16.89	19.43	19.50	O	.3160	20.37	22.43	27.33
6	.2040	16.89	19.43	19.50	P	.3230	21.81	23.99	29.44
5	.2055	16.89	19.43	19.50	21/64	.3281	21.81	23.99	29.44
4	.2090	16.89	19.43	19.50	Q	.3320	21.81	23.99	29.44
3	.2130	16.89	19.43	19.50	8.5mm	.3346	21.81	23.99	—
5.5mm	.2165	16.89	19.43	—	R	.3390	21.81	23.99	29.44
7/32	.2187	16.89	19.43	19.50	11/32	.3437	21.81	23.99	29.44
2	.2210	16.89	19.43	19.50	S	.3480	22.00	24.20	29.95
1	.2280	17.34	19.95	19.50	9mm	.3543	22.00	24.20	—
A	.2340	17.34	19.95	19.50	T	.3580	22.00	24.20	29.95
15/64	.2344	17.34	19.95	19.50	23/64	.3594	22.00	24.20	29.95
6mm	.2362	18.28	20.10	20.16	U	.3680	22.00	24.20	29.95
B	.2380	18.28	20.10	20.16	.3740	.3740	20.89	22.97	28.41
C	.2420	18.28	20.10	20.16	9.5mm	.3740	20.89	22.97	—
D	.2460	18.28	20.10	18.32	3/8	.3750	19.80	21.78	26.92
.2490	.2490	16.46	21.45	18.13	.3760	.3760	20.89	22.97	28.41
1/4	.2500	15.54	17.11	16.36	V	.3770	23.91	26.34	36.47
.2510	.2510	16.46	21.45	18.32	W	.3860	23.91	26.34	36.47
6.5mm	.2559	18.28	20.10	—	25/64	.3906	23.91	26.34	36.47
F	.2570	18.28	20.10	20.16	10mm	.3937	23.91	26.34	—
G	.2610	18.28	20.10	20.16	X	.3970	23.91	26.34	36.47
17/64	.2656	20.37	22.43	27.33	Y	.4040	24.83	27.32	36.47
H	.2660	20.37	22.43	27.33	13/32	.4062	24.83	27.32	36.47
I	.2720	20.37	22.43	27.33	Z	.4130	24.83	27.32	36.47
7mm	.2756	20.37	22.43	—	10.5mm	.4134	24.83	27.32	—
J	.2770	20.37	22.43	27.33	27/64	.4219	24.83	27.32	36.47

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SERIES 700C - Straight Flute Cobalt



SERIES 740 - Right Hand Spiral Flute



High Speed Steel - Straight Shank - Right Hand Cut
Fractional - Wire Gage - Letter - Over & Under - Dowel Pin - Metric

Size	Decimal	Price			Size	Decimal	Price		
		700	740	700C			700	740	700C
11mm	.4331	24.83	27.32	—	18.5mm	.7283	47.55	—	—
.4365	.4365	23.59	27.32	36.47	19mm	.7480	52.67	—	—
7/16	.4375	23.59	25.93	34.68	3/4	.7500	45.58	49.83	66.99
.4385	.4385	23.59	27.32	36.47	19.5mm	.7677	53.96	—	—
11.5mm	.4528	27.04	29.74	—	25/32	.7812	49.17	54.04	72.25
29/64	.4531	27.04	29.74	41.81	20mm	.7874	54.29	—	—
15/32	.4687	27.04	29.74	41.81	20.5mm	.8071	54.29	—	—
12mm	.4724	27.04	29.74	—	13/16	.8125	49.17	54.04	72.25
31/64	.4844	27.04	29.74	41.81	21mm	.8268	54.29	—	—
12.5mm	.4921	27.04	29.74	—	27/32	.8437	58.14	63.97	85.47
.4990	.4990	25.67	29.74	41.81	21.5mm	.8465	63.30	—	—
1/2	.5000	25.67	28.23	39.71	22mm	.8661	63.30	—	—
.5010	.5010	25.67	29.74	41.81	7/8	.8750	63.30	65.42	87.47
13mm	.5118	33.49	—	—	22.5mm	.8858	64.63	—	—
17/32	.5312	31.90	35.10	46.92	23mm	.9055	64.63	—	—
13.5mm	.5315	33.49	—	—	29/32	.9062	64.11	70.53	94.25
14mm	.5512	32.30	—	—	23.5mm	.9252	69.24	—	—
9/16	.5625	30.78	33.85	45.24	15/16	.9375	64.11	70.53	94.25
14.5mm	.5709	32.30	—	—	24mm	.9449	69.24	—	—
15mm	.5906	32.30	—	—	24.5mm	.9646	69.24	—	—
19/32	.5937	30.78	33.85	45.24	31/32	.9687	71.82	78.98	105.55
15.5mm	.6102	37.70	—	—	25mm	.9843	73.50	—	—
5/8	.6250	36.04	42.72	52.78	1	1.0000	72.48	78.98	106.53
16mm	.6299	37.70	—	—	1-1/16	1.0625	80.35	88.39	118.09
16.5mm	.6496	37.70	—	—	1-1/8	1.1250	85.38	93.95	125.51
21/32	.6562	40.16	41.55	59.66	1-3/16	1.1875	100.02	110.01	147.03
17mm	.6693	42.60	—	—	1-1/4	1.2500	105.99	116.60	155.80
11/16	.6875	40.61	44.65	59.66	1-5/16	1.3125	123.63	135.98	181.72
17.5mm	.6890	45.75	—	—	1-3/8	1.3750	129.91	142.93	190.99
18mm	.7087	45.75	—	—	1-7/16	1.4375	139.33	153.26	204.81
23/32	.7187	45.30	49.83	66.60	1-1/2	1.5000	150.01	164.99	220.54

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CAP SCREW COUNTERBORES



HIGH SPEED STEEL - STRAIGHT SHANK

Size	Description	Style No.	Pilot Dia.	Pilot Length	Flute Dia.	Flute Length	Shank Dia.	Overall Length	Price Each
4	Std.	500	.1120	1/8	.1830	9/16	.1562	3 $\frac{3}{8}$	21.82
	1/64 O/S	400	.1270	1/8	.1990	9/16	.1562	3 $\frac{3}{8}$	21.82
	1/32 O/S	300	.1430	1/8	.2150	9/16	.1562	3 $\frac{3}{8}$	21.82
5	Std.	500	.1250	5/32	.2050	5/8	.1875	4 $\frac{1}{8}$	21.82
	1/64 O/S	400	.1400	5/32	.2210	5/8	.1875	4 $\frac{1}{8}$	21.82
	1/32 O/S	300	.1560	5/32	.2370	5/8	.1875	4 $\frac{1}{8}$	21.82
6	Std.	500	.1380	3/16	.2270	3/4	.2188	4 $\frac{5}{8}$	23.11
	1/64 O/S	400	.1530	3/16	.2430	3/4	.2188	4 $\frac{5}{8}$	23.11
	1/32 O/S	300	.1690	3/16	.2590	3/4	.2188	4 $\frac{5}{8}$	23.11
8	Std.	500	.1640	7/32	.2700	3/4	.2500	5	24.76
	1/64 O/S	400	.1790	7/32	.2860	3/4	.2500	5	24.76
	1/32 O/S	300	.1950	7/32	.3020	3/4	.2500	5	24.76
10	Std.	500	.1900	1/4	.3120	7/8	.2812	5 $\frac{1}{4}$	25.29
	1/64 O/S	400	.2050	1/4	.3280	7/8	.2812	5 $\frac{1}{4}$	25.29
	1/32 O/S	300	.2210	1/4	.3440	7/8	.2812	5 $\frac{1}{4}$	25.29
1/4	Std.	500	.2500	9/32	.3800	1	.3125	5 $\frac{5}{8}$	26.57
	1/64 O/S	400	.2650	9/32	.3960	1	.3125	5 $\frac{5}{8}$	26.57
	1/32 O/S	300	.2810	9/32	.4120	1	.3125	5 $\frac{5}{8}$	26.57
5/16	Std.	500	.3125	5/16	.4740	1	.3750	6 $\frac{1}{8}$	33.20
	1/64 O/S	400	.3280	5/16	.4890	1	.3750	6 $\frac{1}{8}$	33.20
	1/32 O/S	300	.3430	5/16	.5040	1	.3750	6 $\frac{1}{8}$	33.20
3/8	Std.	500	.3750	3/8	.5690	1 $\frac{1}{4}$.5000	6 $\frac{1}{2}$	35.66
	1/64 O/S	400	.3900	3/8	.5850	1 $\frac{1}{4}$.5000	6 $\frac{1}{2}$	35.66
	1/32 O/S	300	.4060	3/8	.6010	1 $\frac{1}{4}$.5000	6 $\frac{1}{2}$	35.66
7/16	Std.	500	.4370	7/16	.6610	1 $\frac{1}{4}$.5000	7	42.85
	1/64 O/S	400	.4520	7/16	.6760	1 $\frac{1}{4}$.5000	7	42.85
	1/32 O/S	300	.4680	7/16	.6910	1 $\frac{1}{4}$.5000	7	42.85
1/2	Std.	500	.5000	1/2	.7550	1 $\frac{1}{2}$.5000	7 $\frac{1}{2}$	49.07
	1/64 O/S	400	.5150	1/2	.7710	1 $\frac{1}{2}$.5000	7 $\frac{1}{2}$	49.07
	1/32 O/S	300	.5310	1/2	.7870	1 $\frac{1}{2}$.5000	7 $\frac{1}{2}$	49.07
5/8	Std.	500	.6250	5/8	.9690	1 $\frac{1}{2}$.6250	7 $\frac{5}{8}$	80.04
	1/64 O/S	400	.6400	5/8	.9840	1 $\frac{1}{2}$.6250	7 $\frac{5}{8}$	80.04
	1/32 O/S	300	.6560	5/8	1.0000	1 $\frac{1}{2}$.6250	7 $\frac{5}{8}$	80.04
3/4	Std.	500	.7500	3/4	1.1560	1 $\frac{5}{8}$.7500	7 $\frac{3}{4}$	93.13
	1/64 O/S	400	.7650	3/4	1.1720	1 $\frac{5}{8}$.7500	7 $\frac{3}{4}$	93.13
	1/32 O/S	300	.7810	3/4	1.1880	1 $\frac{5}{8}$.7500	7 $\frac{3}{4}$	93.13
7/8	Std.	500	.8750	7/8	1.3440	1 $\frac{7}{8}$.8750	8	113.41
	1/64 O/S	400	.8910	7/8	1.3590	1 $\frac{7}{8}$.8750	8	113.41
	1/32 O/S	300	.9060	7/8	1.3750	1 $\frac{7}{8}$.8750	8	113.41
1	Std.	500	1.0000	1	1.5310	2	1	8 $\frac{1}{2}$	143.87
	1/64 O/S	400	1.0150	1	1.5470	2	1	8 $\frac{1}{2}$	143.87
	1/32 O/S	300	1.0310	1	1.5630	2	1	8 $\frac{1}{2}$	143.87

O/S = Oversize

Sets Available On Request

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