

www.ultra-tool.com

High-Performance Solid Carbide Round Tools

ULTRATool®

2008 Catalog





Creating Value through Efficiency
by utilizing progressive Quality, Manufacturing,
Human Resource & Technological applications.

SmoothGrind®

Polished cutting surfaces
for extreme sharpness
and lubricity

SmoothCoat®

Sputter-based SuperNitride
PVD coating for superior surface
hardness & uniformity

SmoothContricity®

Precision grinding, tool holding,
and tolerances for minimized TIR

SmoothEdge®

Surface and edge preparation
for lubricity and minimized
tool break-in



The World's finest, purest
sub-micron tungsten
carbide powders

Laser etching for permanent
tool identification

CNC ground chamfer
reduces holder wear



Tool Alliance®

Process control ID# on
product label ensures
total traceability



Sales offices in
Florida & California
Made in the USA for 40 years
Performance Guaranteed

ISO 9001:2000
REGISTERED



ULTRA TOOL®

sales@ultra-tool.com • (800) 854-2431



Next Day shipments on all pre-packaged Ultra-Tool products can be ordered until 6:00 PM EST.

Ultra-Express Reamers must be ordered by 6:00 PM EST for shipment the following business day.

Welcome to Ultra-Tool's Catalog Version 2008.

One of the great difficulties in this business is that we have two distinct customer bases (distributor and consumer) with often conflicting goals. Distributors want their orders filled promptly and accurately, but many would choose an inferior product if it presented the path of least resistance. Consumers want a product that will give them the highest total value for their dollar, yet many never get exposure to the best products in the marketplace (see above comment regarding distribution).

At Ultra-Tool we take great pride in manufacturing solid carbide rotary cutting tools that our consumer base will want to use time and again. Our product is direct evidence of that. Please ask for it by name.

At the same time we are competing harder, and more successfully, than ever for our distributor's business by being a hassle-free vendor. Huge inventories, on-time shipments, streamlined pricing strategies, automated confirmations & shipping details, and more. We're easy, efficient, and profitable to do business with.

This new catalog addresses "both" of our customers. It contains more new products than ever before, built from the ground up (substrate through coating) with awesome technologies that lead the industry. Plus, it's the easiest catalog to use; we've eliminated all breakpoint pricing, a single discount applies to the entire book, and we've added thousands of additional items available with standard coating.

We are extremely proud of the Ultra-Tool product line, and are confident you will enjoy purchasing and using it as much as we enjoy manufacturing it.

Sincerely,

David J. Povich
President

P.S. Make sure to try our other great Tool Alliance brands!



Team-Ultra Product Warranty:

Ultra-Tool International, Inc. warrants that products sold by it shall be free from defects in materials and workmanship. Ultra-Tool will replace, repair, or grant a credit for any product which does not comply with this warranty. Please see Terms & Conditions for additional warranty information.

Ultra-Tool® Catalog & Price List Version 2008

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1

ULTRA-Grain®

Components of Guaranteed Quality

COMPONENT #1: Carbide Substrate From being the first Company to introduce MicroGrain carbide to the mass-market round tool industry through the present day, Tool Alliance® has consistently innovated new powder and grade combinations for demanding applications. We recognize that our material is the very first Significant Characteristic. By creating partnerships with a limited number of tungsten powder and cemented-carbide material suppliers, we are able to guarantee that our customers receive precision-tolerance tools ground from only the purest, finest grades available worldwide. The following photographs of Ultra-Carb® 1 and Ultra-Grain® 1 respectively demonstrate the complexity of the compound we commonly refer to as Cemented Carbide. Taken at magnification of 10,000 X through an SEM (Scanning Electron Microscope), the visible grains are tungsten while the cobalt binder appears as dark shadows. The largest tungsten grains appearing in the Ultra-Carb photo are less than one micron in size. Note that these grades are two samples representing more than a dozen different substrates we use throughout our product lines, each having a particular application niche. Compared to other industry participants, you will find that Tool Alliance offers the best month-to-month and year-to-year consistency in carbide grain structure.



Ultra-Carb® 1

Cobalt Percentage: 6%
Grain Size (µm): ≤ 0.8
Hardness: 93.5 HRa
Fracture Toughness (K1c): 6.6
TRS (GPa): 3.8
Density (gm/cc): 14.90



Ultra-Grain® 1

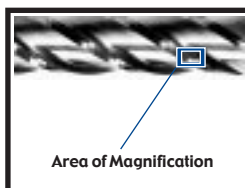
Cobalt Percentage: 10%
Grain Size (µm): ≤ 0.7
Hardness: 92.7 HRa
Fracture Toughness (K1c): 7.9
TRS (GPa): 4.1
Density (gm/cc): 14.30



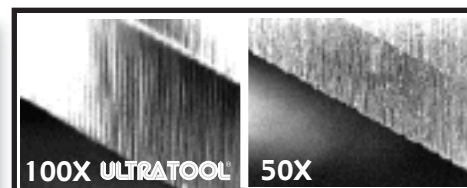
2

SmoothGrind®

COMPONENT #2: The Grinding Process After selecting the best material available, Tool Alliance has perfected the manufacturing technology to optimize 100% of its physical properties. We call this process SmoothGrind®. Years in development, SmoothGrind is the result of a proprietary combination of material, abrasive, coolant, machine-tool, software, and grinding method technologies that produce cutting tools with superior qualitative characteristics. Sharper and longer lasting cutting edges, enhanced work piece finishes, and improved lubricity are just some of the benefits brought to you by the latest solid carbide rotary tooling advances from Tool Alliance. The following photographs display an Ultra-Tool end mill primary relief featuring SmoothGrind (left) versus a major competitor's product (right). To fully demonstrate the difference, the Ultra end mill is shown at double the magnification. Note the straight line of our end mill's primary relief in comparison to the jagged edge of the competing product. Keep in mind the competitive end mill is a very good product that has a large following, yet the difference is substantial.



Area of Magnification



SmoothGrind® Competitor's

3

SmoothContricity®



COMPONENT #3: The Tooling Process All the best physical ingredients are wasted unless they are all pulled together in a comprehensive system that maximizes their respective attributes. Tool Alliance calls this process SmoothContricity®. Our customer base represents the leading edge of machine tool utilization, and SmoothContricity ensures that optimum results can be obtained in a variety of ways; minimized run-out (TIR), industry-leading tolerances on diameter & radius, and 100% Shrink Fit Ready (SFR) shanks. Combined, these attributes allow our consumers to reach full machining potential and position the cutting tool as a systematic contributor to process consistency and repeatability.



Shrink Fit Ready

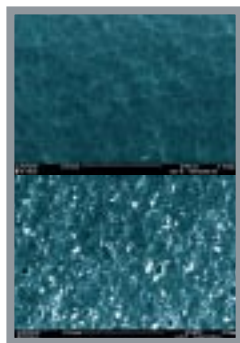
4

SmoothEdge®



COMPONENT #4: The Edge Preparation Process

Our cutting edges are literally too sharp for certain materials. For our carbide inserts and now increasingly for our solid carbide round tools, proper edge preparation can yield huge productivity improvements to "out of the box" tool application. Using a treatment we call SmoothEdge® and performed on machine tools developed in our own R&D lab, we've taken the mystery out of tool "break-in" and provided a consistency that can be counted on time and again. The process ranges from SmoothEdge 1, a microblasting treatment using extremely fine aluminum oxide powder (note: this procedure is standard with any coated product) to SmoothEdge 5, which adds a double cycle of honing & lubricity treatments. All five will sound and run smooth from the first cut and protect your tooling investment from unnecessary potential for chipping during your initial tooling paths. Big productivity gains can be achieved in certain applications as well due to improved chip formation and evacuation. Learn more about SmoothEdge on Page #46.



Our coating @ 2,000X (top).
Everybody else's (bottom).

SmoothCoat® 

COMPONENT #5: The Coating Process The challenge of finding a coating method to leverage 100% of the inherent assets of our carbide grade and grinding technologies was difficult. What we finally discovered was such a perfect fit and so logical for our product lines that we invested heavily into the process we now call **SmoothCoat®**. Much more than simply the standard arc-deposited PVD coating, SmoothCoat involves sputter multi-layering and a multi-step prep & post operation called Micro-Blasting. The advantages of this procedure include relieving of tensile stresses underneath the cutting edge, increased stability of the coating surface, and perhaps most importantly, elevating **SmoothGrind** even another notch by leveling and activating the cemented carbide substrate. The result is a smooth, shiny, tough, and durable surface that can withstand tomorrow's machining requirements and outlast competitive coatings. Additionally, we've made it a standard feature on thousands of our standard catalog items. Our coating services are performed within our own factories for quality & extremely quick turnaround times.

Coating Availability Order by adding the suffix TA, TN, AT, TC, A1, D1, or D2 to the EDP #.



Uncoated



TiAIN



TiN



AlTiN HSN²



TiCN



TiB₂



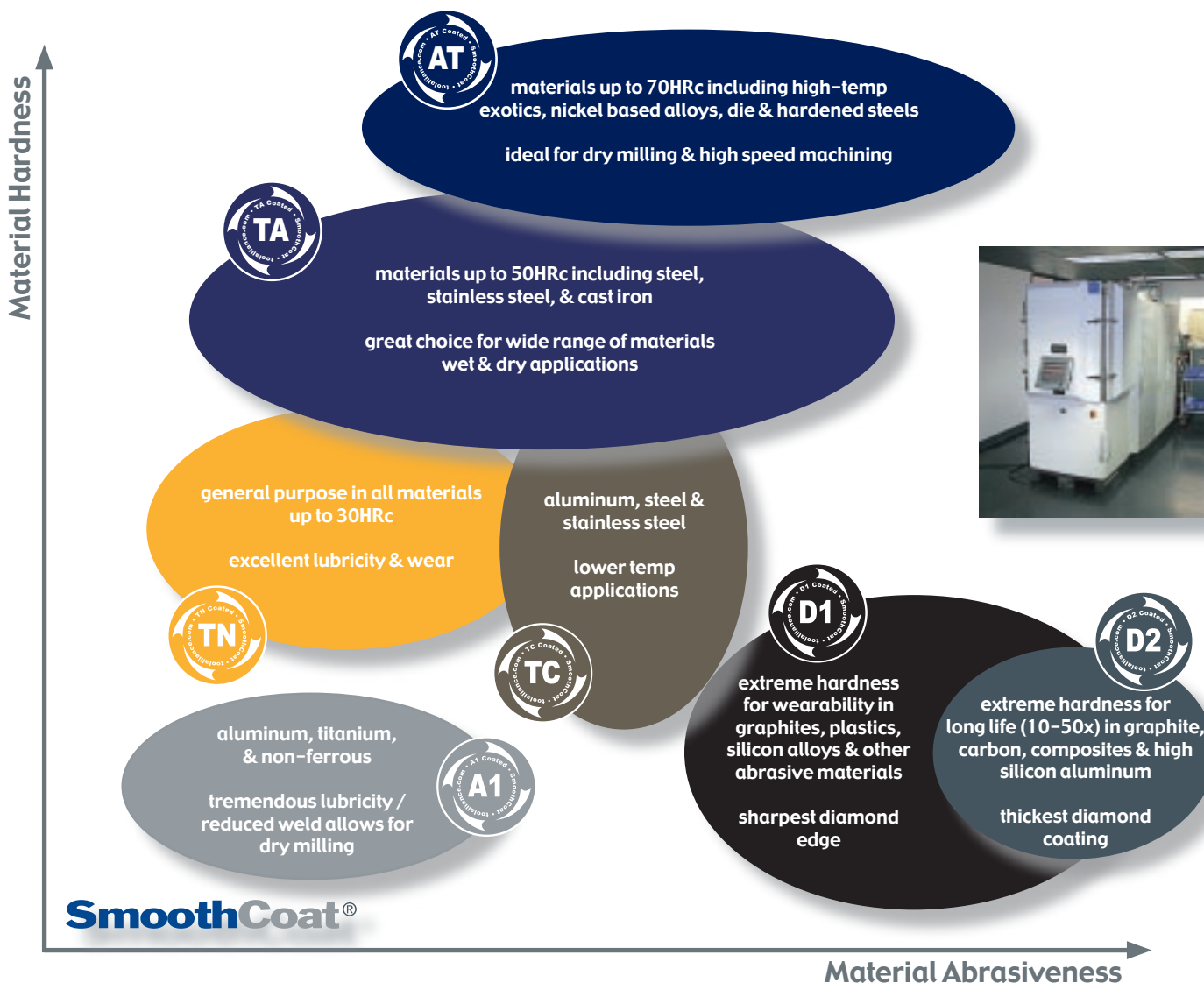
PVD Diamond



CVD Diamond

Standard Coatings available at "Coated" List Price

Premium Coatings available





Single End Standard Length End Mills by ULTRATOOL

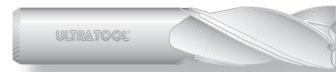
**Series 330 Square End
330B Ball End • Two Flute**



**Series 362 Square End
362B Ball End • Three Flute**



**Series 320 Square End
320B Ball End • Four Flute**



The Ultra-Tool® Series 330, 362, and 320 represents the industry's best value in a general purpose design. These end mills are more than capable of handling 75% of milling applications due to robust geometry, quality craftsmanship, and best-in-class carbide substrate. Most importantly, the Series 330, 362, and 320 all benefit from the Tool Alliance® duo of proprietary & value-added features: SmoothGrind® & SmoothContricity®, with SmoothCoat® and SmoothEdge® available individually for an extra charge. Additionally, radii and clearance necks can be added to any size in as little as one-day lead time.

Standard features:

SmoothGrind® **SmoothContricity®**

Available options:

SmoothCoat® **SmoothEdge®**

Detailed Speeds and Feeds instructions can be located on Page #49.



SFR Ultra-Tool End Mill Specs:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003



Diam	LOC	OAL	Shank	330 EDP#	330B EDP#	362 EDP#	362B EDP#	320 EDP#	320B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/64	3/64	1-1/2	1/8	33001	33101	36201	36301	32001	32101	\$16.60	\$19.50	\$21.20	\$24.00
1/32	3/32	1-1/2	1/8	33002	33102	36202	36302	32002	32102	\$12.40	\$15.20	\$15.80	\$18.60
3/64	3/16	1-1/2	1/8	33003	33103	36203	36303	32003	32103	\$12.40	\$15.20	\$15.80	\$18.60
1/16	3/16	1-1/2	1/8	33004	33104	36204	36304	32004	32104	\$11.50	\$14.30	\$14.90	\$17.70
5/64	1/4	1-1/2	1/8	33005	33105	36205	36305	32005	32105	\$11.50	\$14.30	\$14.90	\$17.70
3/32	3/8	1-1/2	1/8	33006	33106	36206	36306	32006	32106	\$11.20	\$14.00	\$14.60	\$17.40
7/64	1/2	1-1/2	1/8	33007	33107	36207	36307	32007	32107	\$11.20	\$14.00	\$14.60	\$17.40
1/8	1/2	1-1/2	1/8	33008	33108	36208	36308	32008	32108	\$10.10	\$12.90	\$13.20	\$16.00
9/64	1/2	2"	3/16	33009	33109	36209	36309	32009	32109	\$15.50	\$18.90	\$19.50	\$22.90
5/32	9/16	2"	3/16	33010	33110	36210	36310	32010	32110	\$15.50	\$18.90	\$19.50	\$22.90
11/64	9/16	2"	3/16	33011	33111	36211	36311	32011	32111	\$15.50	\$18.90	\$19.50	\$22.90
3/16	5/8	2"	3/16	33012	33112	36212	36312	32012	32112	\$14.40	\$17.80	\$18.40	\$21.80
13/64	5/8	2-1/2	1/4	33013	33113	36213	36313	32013	32113	\$19.50	\$26.10	\$24.40	\$31.00
7/32	5/8	2-1/2	1/4	33014	33114	36214	36314	32014	32114	\$19.50	\$26.10	\$24.40	\$31.00
15/64	3/4	2-1/2	1/4	33015	33115	36215	36315	32015	32115	\$19.50	\$26.10	\$24.40	\$31.00
1/4	3/4	2-1/2	1/4	33016	33116	36216	36316	32016	32116	\$17.20	\$23.80	\$22.10	\$28.70
17/64	3/4	2-1/2	5/16	33017	33117	36217	36317	32017	32117	\$27.20	\$35.30	\$33.80	\$41.80
9/32	3/4	2-1/2	5/16	33018	33118	36218	36318	32018	32118	\$27.20	\$35.30	\$33.80	\$41.80
19/64	13/16	2-1/2	5/16	33019	33119	36219	36319	32019	32119	\$27.20	\$35.30	\$33.80	\$41.80
5/16	13/16	2-1/2	5/16	33020	33120	36220	36320	32020	32120	\$24.10	\$32.10	\$30.70	\$38.70
21/64	13/16	2-1/2	3/8	33021	33121	36221	36321	32021	32121	\$33.20	\$41.80	\$41.30	\$49.80
11/32	13/16	2-1/2	3/8	33022	33122	36222	36322	32022	32122	\$33.20	\$41.80	\$41.30	\$49.80
23/64	1"	2-1/2	3/8	33023	33123	36223	36323	32023	32123	\$33.20	\$41.80	\$41.30	\$49.80
3/8	1"	2-1/2	3/8	33024	33124	36224	36324	32024	32124	\$28.70	\$37.30	\$36.70	\$45.30
25/64	1"	2-3/4	7/16	33025	33125	36225	36325	32025	32125	\$44.10	\$55.30	\$55.30	\$66.40
13/32	1"	2-3/4	7/16	33026	33126	36226	36326	32026	32126	\$44.10	\$55.30	\$55.30	\$66.40
27/64	1"	2-3/4	7/16	33027	33127	36227	36327	32027	32127	\$44.10	\$55.30	\$55.30	\$66.40
7/16	1"	2-3/4	7/16	33028	33128	36228	36328	32028	32128	\$40.70	\$51.90	\$51.90	\$63.00
29/64	1"	3"	1/2	33029	33129	36229	36329	32029	32129	\$51.00	\$62.40	\$63.60	\$75.00
15/32	1"	3"	1/2	33030	33130	36230	36330	32030	32130	\$51.00	\$62.40	\$63.60	\$75.00
31/64	1"	3"	1/2	33031	33131	36231	36331	32031	32131	\$51.00	\$62.40	\$63.60	\$75.00
1/2	1"	3"	1/2	33032	33132	36232	36332	32032	32132	\$47.30	\$58.70	\$59.90	\$71.30
9/16	1-1/4	3-1/2	9/16	33034	33134	36234	36334	32034	32134	\$81.60	\$97.90	\$102.50	\$118.80
5/8	1-1/2	3-1/2	5/8	33036	33136	36236	36336	32036	32136	\$90.20	\$107.90	\$112.80	\$130.60
11/16	1-1/2	4"	3/4	33038	33138	36238	36338	32038	32138	\$136.00	\$156.90	\$170.30	\$191.20
3/4	1-1/2	4"	3/4	33040	33140	36240	36340	32040	32140	\$126.00	\$146.90	\$157.50	\$178.40
7/8	1-1/2	4"	7/8	33044	33144	36244	36344	32044	32144	\$199.00	\$223.00	\$247.60	\$271.70
1"	1-1/2	4"	1"	33048	33148	36248	36348	32048	32148	\$207.50	\$237.60	\$259.10	\$289.10
1-1/4"	2"	4-1/2	1-1/4	33080	33180	36280	36380	32080	32180	\$480.00	\$530.00	\$576.00	\$626.00

Long & Extra Long End Mills by ULTRATOOL

Series 382 Square End
382B Ball End • Two FluteSeries 383 Square End
383B Ball End • Three FluteSeries 384 Square End
384B Ball End • Four Flute

The Ultra-Tool® Series 382, 383, and 384 represents the industry's best value in a extended length or extended reach design. These end mills are more than capable of handling 75% of milling applications due to robust geometry, quality craftsmanship, and best-in-class carbide substrate. Most importantly, the Series 382, 383, and 384 all benefit from the Tool Alliance® duo of proprietary & value-added features: SmoothGrind® & SmoothContricity®, with SmoothCoat® and SmoothEdge® available individually for an extra charge. Additionally, radii and clearance necks can be added to any size in as little as one-day lead time.

Standard features:

SmoothGrind®

SmoothContricity®

Available options:

SmoothCoat®

SmoothEdge®

Detailed Speeds and Feeds instructions can be located on Page #49.



Diam	LOC	OAL	Shank	382 EDP#	382B EDP#	383 EDP#	383B EDP#	384 EDP#	384B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/8	3/4	2"	1/8	38207	38307	38007	38107	38407	38507	\$15.40	\$18.20	\$18.20	\$21.00
1/8	1"	3"	1/8	38208	38308	38008	38108	38408	38508	\$21.50	\$25.50	\$26.90	\$31.00
3/16	1-1/4	3"	3/16	38212	38312	38012	38112	38412	38512	\$24.10	\$29.00	\$30.40	\$35.30
3/16	1"	4"	3/16	38213	38313	38013	38113	38413	38513	\$28.70	\$34.70	\$33.30	\$39.30
1/4	1-1/8	3"	1/4	38215	38315	38015	38115	38415	38515	\$30.40	\$37.00	\$35.80	\$42.30
1/4	1"	4"	1/4	38218	38318	38018	38118	38418	38518	\$31.50	\$39.80	\$37.90	\$46.20
1/4	1-1/2	4"	1/4	38216	38316	38016	38116	38416	38516	\$32.20	\$40.50	\$38.50	\$46.80
1/4	1-1/2	6"	1/4	38217	38317	38017	38117	38417	38517	\$43.40	\$54.30	\$48.70	\$59.60
5/16	1-1/8	3"	5/16	38219	38319	38019	38119	38419	38519	\$37.50	\$45.60	\$44.10	\$52.10
5/16	1-5/8	4"	5/16	38220	38320	38020	38120	38420	38520	\$41.90	\$52.30	\$50.40	\$60.70
5/16	1-1/2	6"	5/16	38221	38321	38021	38121	38421	38521	\$62.20	\$76.50	\$73.10	\$87.40
3/8	1-1/8	3"	3/8	38223	38323	38023	38123	38423	38523	\$42.20	\$50.80	\$49.70	\$58.30
3/8	1"	4"	3/8	38222	38322	38022	38122	38422	38522	\$45.80	\$57.00	\$56.10	\$67.30
3/8	2"	4"	3/8	38224	38324	38024	38124	38424	38524	\$46.40	\$57.60	\$56.70	\$67.90
3/8	1-1/2	6"	3/8	38225	38325	38025	38125	38425	38525	\$65.10	\$82.30	\$73.30	\$90.50
3/8	3"	6"	3/8	38226	38326	38026	38126	38426	38526	\$67.50	\$84.70	\$75.70	\$92.90
7/16	2"	4"	7/16	38228	38328	38028	38128	38428	38528	\$68.20	\$81.30	\$71.00	\$95.60
7/16	1-1/2	6"	7/16	38229	38329	38029	38129	38429	38529	\$84.90	\$104.60	\$97.60	\$117.40
7/16	3"	6"	7/16	38249	38349	38049	38149	38449	38549	\$88.20	\$108.00	\$102.50	\$122.30
1/2	1"	4"	1/2	38230	38330	38030	38130	38430	38530	\$66.40	\$81.90	\$76.70	\$92.20
1/2	1-1/2	4"	1/2	38231	38331	38031	38131	38431	38531	\$67.60	\$83.00	\$80.20	\$95.60
1/2	2"	4"	1/2	38232	38332	38032	38132	38432	38532	\$68.70	\$84.20	\$82.20	\$97.60
1/2	1-1/2	6"	1/2	38233	38333	38033	38133	38433	38533	\$96.20	\$117.30	\$108.20	\$130.60
1/2	3"	6"	1/2	38250	38350	38050	38150	38450	38550	\$97.90	\$119.10	\$119.40	\$141.70
9/16	3"	6"	9/16	38235	38335	38035	38135	38435	38535	\$128.80	\$153.70	\$151.50	\$176.30
5/8	2-1/2	5"	5/8	38236	38336	38036	38136	38436	38536	\$136.30	\$164.00	\$158.60	\$186.40
5/8	1-1/2	6"	5/8	38237	38337	38037	38137	38437	38537	\$137.40	\$165.20	\$159.70	\$187.50
5/8	3"	6"	5/8	38251	38351	38051	38151	38451	38551	\$139.70	\$167.50	\$162.00	\$189.80
3/4	2-1/2	5"	3/4	38240	38340	38040	38140	38440	38540	\$206.10	\$238.50	\$245.60	\$278.00
3/4	1-1/2	6"	3/4	38241	38341	38041	38141	38441	38541	\$217.60	\$249.90	\$257.10	\$289.40
3/4	3"	6"	3/4	38252	38352	38052	38152	38452	38552	\$222.70	\$255.10	\$262.20	\$294.50
1"	2-1/2	5"	1"	38245	38345	38045	38145	38445	38545	\$354.90	\$397.30	\$427.00	\$469.40
1"	2"	6"	1"	38246	38346	38046	38146	38446	38546	\$366.30	\$408.70	\$445.80	\$488.10
1"	3"	6"	1"	38248	38348	38048	38148	38448	38548	\$372.10	\$414.50	\$454.70	\$497.10
1"	4"	6"	1"	38253	38353	38053	38153	38453	38553	\$398.90	\$441.20	\$489.40	\$531.80
1"	4"	7"	1"	38254	38354	38054	38154	38454	38554	\$503.20	\$560.40	\$583.90	\$641.10
1"	3"	8"	1"	38255	38355	38055	38155	38455	38555	\$584.50	\$641.70	\$655.40	\$712.70
1-1/4	3"	6"	1-1/4	38280	38380	38080	38180	38480	38580	\$640.00	\$700.00	\$768.00	\$828.00



Metric Standard Length End Mills by ULTRATOOL

Series 330M Square End
330MB Ball End • Two Flute



Series 362M Square End
362MB Ball End • Three Flute



Series 320M Square End
320MB Ball End • Four Flute



Detailed Speeds and Feeds instructions
can be located on Page #49.

SFR Ultra-Tool End Mill Specs (Metric):
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.008mm



Diam	LOC	OAL	Shank	330M EDP#	330MB EDP#	362M EDP#	362MB EDP#	320M EDP#	320MB EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1.0mm	3	38	3.0	33056	33156	36256	36356	32056	32156	\$13.00	\$15.80	\$16.30	\$19.10
1.5mm	4.5	38	3.0	33058	33158	36258	36358	32058	32158	\$12.10	\$14.90	\$15.10	\$17.90
2.0mm	6.3	38	3.0	33060	33160	36260	36360	32060	32160	\$12.10	\$14.90	\$15.10	\$17.90
2.5mm	9.5	38	3.0	33062	33162	36262	36362	32062	32162	\$11.40	\$14.20	\$14.40	\$17.20
3.0mm	12	38	3.0	33064	33164	36264	36364	32064	32164	\$10.60	\$13.40	\$13.50	\$16.30
3.5mm	12	50	4.0	33065	33165	36265	36365	32065	32165	\$16.40	\$19.80	\$20.40	\$23.90
4.0mm	14	50	4.0	33066	33166	36266	36366	32066	32166	\$15.60	\$19.10	\$19.50	\$22.90
4.5mm	16	50	5.0	33067	33167	36267	36367	32067	32167	\$18.50	\$23.90	\$23.10	\$28.50
5.0mm	16	50	5.0	33068	33168	36268	36368	32068	32168	\$17.30	\$22.70	\$21.60	\$27.10
6.0mm	19	50	6.0	33070	33170	36270	36370	32070	32170	\$17.80	\$23.20	\$22.40	\$27.80
7.0mm	20	60	7.0	30872	30972	36472	36572	30672	30772	\$24.70	\$32.70	\$30.90	\$38.90
8.0mm	20	63	8.0	33074	33174	36274	36374	32074	32174	\$24.90	\$33.50	\$31.20	\$39.80
9.0mm	22	63	9.0	30876	30976	36476	36576	30676	30776	\$33.80	\$42.40	\$42.30	\$50.90
10.0mm	22	70	10.0	33078	33178	36278	36378	32078	32178	\$40.10	\$51.30	\$51.10	\$62.30
12.0mm	25	76	12.0	33082	33182	36282	36382	32082	32182	\$48.10	\$59.60	\$60.60	\$72.00
14.0mm	32	89	14.0	33086	33186	36286	36386	32086	32186	\$85.30	\$101.70	\$106.70	\$123.00
16.0mm	38	89	16.0	33088	33188	36288	36388	32088	32188	\$91.60	\$112.50	\$115.30	\$136.20
18.0mm	38	101	18.0	33090	33190	36290	36390	32090	32190	\$151.70	\$172.60	\$189.70	\$210.60
20.0mm	38	101	20.0	33092	33192	36292	36392	32092	32192	\$174.60	\$198.70	\$218.30	\$242.30
22.0mm	38	101	22.0	33094	33194	36294	36394	32094	32194	\$215.30	\$239.30	\$271.10	\$295.10
25.0mm	38	101	25.0	33097	33197	36297	36397	32097	32197	\$217.60	\$247.60	\$273.40	\$303.40

Metric Extra-Long End Mills by ULTRATOOL

Series 382M Square End
382MB Ball End • Two Flute



Series 383M Square End
383MB Ball End • Three Flute



Series 384M Square End
384MB Ball End • Four Flute



SFR Ultra-Tool End Mill Specs (Metric):
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.008mm



Diam	LOC	OAL	Shank	382M EDP#	382MB EDP#	383M EDP#	383MB EDP#	384M EDP#	384MB EDP#	Square Price	Coated Square	Ball Price	Coated Ball
3.0mm	25	76	3.0	82003	82103	83003	83103	81003	81103	\$22.90	\$26.90	\$27.50	\$31.50
4.0mm	28	76	4.0	82004	82104	83004	83104	81004	81104	\$26.30	\$31.20	\$31.60	\$36.50
5.0mm	32	76	5.0	82005	82105	83005	83105	81005	81105	\$30.80	\$37.40	\$37.00	\$43.60
6.0mm	38	76	6.0	82006	82106	83006	83106	81006	81106	\$32.20	\$38.70	\$38.70	\$45.30
8.0mm	40	101	8.0	82008	82108	83008	83108	81008	81108	\$41.90	\$53.10	\$50.40	\$61.50
10.0mm	50	101	10.0	82010	82110	83010	83110	81010	81110	\$65.90	\$80.20	\$79.10	\$93.40
12.0mm	50	101	12.0	82012	82112	83012	83112	81012	81112	\$71.00	\$86.50	\$85.20	\$100.70
12.0mm	76	152	12.0	82013	82113	83013	83113	81013	81113	\$100.20	\$122.50	\$121.70	\$144.00
14.0mm	76	152	14.0	82014	82114	83014	83114	81014	81114	\$132.30	\$157.20	\$154.90	\$179.80
16.0mm	64	127	16.0	82016	82116	83016	83116	81016	81116	\$156.30	\$188.70	\$187.60	\$219.90
16.0mm	76	152	16.0	82017	82117	83017	83117	81017	81117	\$159.70	\$192.10	\$191.00	\$223.30
18.0mm	76	152	18.0	82018	82118	83018	83118	81018	81118	\$222.70	\$255.10	\$262.20	\$294.50
20.0mm	76	152	20.0	82020	82120	83020	83120	81020	81120	\$326.30	\$363.50	\$362.70	\$429.90
25.0mm	76	152	25.0	82025	82125	83025	83125	81025	81125	\$384.10	\$426.50	\$461.10	\$503.50

ULTRATOOL® Variable Geometry End Mill with Patented "Tuned Flute"

Series 323 • Patented Tuned Flute

Ultra-Grain® Variable Geometry End Mill

new!

4 "Tuned-Flutes" with Radius
& SmoothCoat® ATULTRATOOL®
PERFORMANCE

The Ultra-Tool® Series 323 "Tuned Flute" represents a culmination of design, features, and execution. Our unique patented version of a variable geometry configuration offers industry-leading chatter & vibration reduction, superb part finish, and deep axial cuts. The 323 is ideal for slotting and pocketing, and the same end mill can be utilized for roughing and finishing. Each 323 Tuned Flute is standard with radius & Tool Alliance's proprietary AT coating, and is precision ground from a specialized Ultra-Grain® carbide grade. Most importantly, the Series 323 Tuned Flute benefits from the Tool Alliance® triad of proprietary & value-added features: SmoothGrind®, SmoothCoat® & SmoothConcricity®.

NOTE: The 323TF is designed for maximizing Axial Depth of Cut, and maximizes geometry when used at up to approximately 75% LOC.

This product is manufactured under U.S. Patent No. 7,284,935.

A word about Tool Holding: The 323 Tuned Flute is capable of very high metal removal rates. Shrink fit or milling chuck holders are preferred methods of secure and concentric tool holding. If a set screw style holder must be used, all Series 323 end mills 1/2" and larger in diameter are manufactured with a flat as a standard feature.

1/2"
& up.

Slot Milling



Pocket Milling



Peripheral Milling



Series 323 Tuned Flute.

Surface Feet Per Minute (SFPM) and Feed Per Tooth (FPT)
recommendations by tool diameter and material:

SFR 323 Series End Mill Specs:
Cutting Diam +.000/-0.002
Shank Diam -.0001/-0.0003

ULTRA-Grain®

Diam	LOC	OAL	Shank	Radius	EDP#	Coated Price
1/8	3/8	1-1/2"	1/8	.010	23008	\$20.10
3/16	7/16	2"	3/16	.010	23012	\$25.90
1/4	3/8	2"	1/4	.015	23015	\$33.80
1/4	3/4	2-1/2"	1/4	.015	23016	\$35.00
5/16	13/16	2-1/2"	5/16	.020	23020	\$45.00
3/8	1/2	2"	3/8	.020	23023	\$49.50
3/8	1"	2-1/2"	3/8	.020	23024	\$53.40
7/16	1"	2-3/4"	7/16	.020	23028	\$66.70
1/2	5/8	2-1/2"	1/2	.030	23031	\$87.50
1/2	1-1/4	3"	1/2	.030	23032	\$93.40
5/8	1-1/4	3-1/2"	5/8	.030	23040	\$152.00
3/4	7/8	4"	3/4	.030	23047	\$212.50
3/4	1-1/2	4"	3/4	.030	23048	\$217.50
1"	1-1/2	4"	1"	.030	23064	\$370.00

SFR 323 Series End Mill Specs (Metric):
Cutting Diam +0.000/-0.051mm
Shank Diam -0.002/-0.008mm

ULTRA-Grain®

Diam	LOC	OAL	Shank	Radius	EDP#	Coated Price
3.0mm	12	38	3.0	0.2	23080	\$20.10
4.0mm	14	50	4.0	0.2	23081	\$25.90
5.0mm	16	50	5.0	0.3	23082	\$28.50
6.0mm	19	50	6.0	0.3	23083	\$33.80
8.0mm	20	63	8.0	0.3	23084	\$45.00
10.0mm	22	70	10.0	0.5	23085	\$65.50
12.0mm	16	74	12.0	0.5	23086	\$87.50
12.0mm	30	74	12.0	0.5	23087	\$93.40
14.0mm	32	89	14.0	0.5	23088	\$136.50
16.0mm	38	89	16.0	0.5	23089	\$152.00
20.0mm	38	100	20.0	0.5	23090	\$298.00
25.0mm	38	100	25.0	0.5	23091	\$370.00

Material	SFPM	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"
Steel											
1018 / 1020	400 to 600	.0007	.0012	.0015	.0018	.002	.0025	.003	.0035	.004	.0045
4140	350 to 500	.0005	.001	.0012	.0015	.0018	.0022	.0025	.003	.0035	.004
Stainless Steel											
303	400 to 600	.0007	.001	.0012	.0015	.002	.0025	.003	.0035	.004	.004
304 / 316	300 to 500	.0006	.0008	.001	.0012	.0018	.0022	.0025	.003	.0035	.0038
410 / 420	300 to 500	.0006	.0008	.001	.0012	.0018	.0022	.0025	.003	.0035	.0038
15-5 / 17-4	250 to 400	.0006	.0008	.001	.0012	.0018	.0022	.0025	.003	.0035	.0038
13-8 / 316L	250 to 350	.0005	.0007	.0008	.001	.0012	.0015	.002	.0025	.003	.0035
Tool Steel											
A2 / D2 / H13 / P20	350 to 500	.0005	.0008	.001	.0012	.0018	.0022	.0025	.003	.0035	.0035
Titanium											
6Al-4V	150 to 250	.0005	.0008	.001	.001	.0012	.0018	.002	.002	.003	.003
High Temp Alloys											
Inconel 625	100 to 150	.0005	.0008	.001	.001	.0012	.0015	.002	.002	.0025	.003
Inconel 718	75 to 125	.0005	.0007	.0008	.0009	.0012	.0015	.002	.002	.0025	.0025

Metric Sub-Miniature Square & Ball End Mills; LOC = 1.5, 3.0, and 5.0X Diameter

The Ultra-Tool® line of sub-miniature solid carbide end mills is unmatched in quality and range. Three different length of cut (LOC) to diameter ratios (1.5X, 3.0X, and 5.0X), two & four flute, square & ball nose, plus coated & uncoated. Square & ball prices are identical. These tools match great carbide substrate to superb cutting tool characteristics for total value. Extended clearance necks are available. OAL = 1.5" (38 mm).

Series 330SMS / 330BSMS 2-flute 1.5X
Series 320SMS / 320BSMS 4-flute 1.5X



1.5X

Series 330SMSL / 330BSMSL 2-flute 3X
Series 320SMSL / 320BSMSL 4-flute 3X



3.0X

Series 330SMSXL / 330BSMSXL 2-flute 5X
Series 320SMSXL / 320BSMSXL 4-flute 5X



5.0X



All Sub-Miniatures:
Clearance neck
available in 24 hours

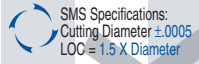
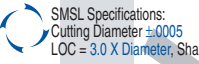
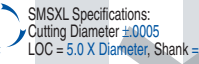
SMS Specifications (Metric):
Cutting Diameter $\pm 0.013\text{mm}$
LOC = 1.5 X Diameter, Shank = 3.0mm

SMSL Specifications (Metric):
Cutting Diameter $\pm 0.013\text{mm}$
LOC = 3.0 X Diameter, Shank = 3.0mm

SMSXL Specifications (Metric):
Cutting Diameter $\pm 0.013\text{mm}$
LOC = 5.0 X Diameter, Shank = 3.0mm

Ø Diam	2 sq	2 ball	4 sq	4 ball	price	coated	2 sq	2 ball	4 sq	4 ball	price	coated	2 sq	2 ball	4 sq	4 ball	price	coated
0.25mm	33272	33372			\$22.10	\$24.90	30113	30139			\$24.20	\$27.00	30417	30517			\$31.50	\$34.30
0.30mm	33273	33373			\$22.10	\$24.90	30114	30140			\$24.20	\$27.00	30418	30518			\$31.50	\$34.30
0.35mm	33274	33374			\$22.10	\$24.90	30115	30141			\$24.20	\$27.00						
0.40mm	33275	33375			\$22.10	\$24.90	30116	30142			\$24.20	\$27.00	30419	30519			\$31.50	\$34.30
0.45mm	33276	33376			\$22.10	\$24.90	30117	30143			\$24.20	\$27.00						
0.50mm	33277	33377			\$21.50	\$24.30	30118	30144			\$23.60	\$26.40	30420	30520	30445	30545	\$31.50	\$34.30
0.55mm	33278	33378			\$21.50	\$24.30	30119	30145			\$23.60	\$26.40						
0.60mm	33279	33379			\$21.50	\$24.30	30120	30146			\$23.60	\$26.40	30421	30521	30446	30546	\$31.50	\$34.30
0.65mm	33280	33380			\$20.10	\$22.90	30121	30147			\$22.10	\$24.90						
0.70mm	33281	33381	32281	32381	\$20.10	\$22.90	30122	30148	30165	30182	\$22.10	\$24.90	30422	30522	30447	30547	\$26.50	\$29.30
0.75mm	33282	33382	32282	32382	\$20.10	\$22.90	30123	30149	30166	30183	\$22.10	\$24.90						
0.80mm	33283	33383	32283	32383	\$17.80	\$20.60	30124	30150	30167	30184	\$19.60	\$22.40	30423	30523	30448	30548	\$26.50	\$29.30
0.85mm	33284	33384	32284	32384	\$17.80	\$20.60	30125	30151	30168	30185	\$19.60	\$22.40						
0.90mm	33285	33385	32285	32385	\$17.80	\$20.60	30126	30152	30169	30186	\$19.60	\$22.40	30424	30524	30449	30549	\$26.50	\$29.30
0.95mm	33286	33386	32286	32386	\$17.80	\$20.60	30127	30153	30170	30187	\$19.60	\$22.40						
1.00mm	33287	33387	32287	32387	\$14.40	\$17.20	30128	30154	30171	30188	\$16.20	\$19.00	30425	30525	30450	30550	\$23.50	\$26.30
1.05mm	33288	33388	32288	32388	\$14.40	\$17.20	30129	30155	30172	30189	\$16.20	\$19.00						
1.10mm	33289	33389	32289	32389	\$14.40	\$17.20	30130	30156	30173	30190	\$16.20	\$19.00	30426	30526	30451	30551	\$23.50	\$26.30
1.15mm	33290	33390	32290	32390	\$14.40	\$17.20	30131	30157	30174	30191	\$16.20	\$19.00						
1.20mm	33291	33391	32291	32391	\$13.60	\$16.40	30132	30158	30175	30192	\$14.90	\$17.70	30427	30527	30452	30552	\$23.50	\$26.30
1.25mm	33292	33392	32292	32392	\$13.60	\$16.40	30133	30159	30176	30193	\$14.90	\$17.70						
1.30mm	33293	33393	32293	32393	\$13.60	\$16.40	30134	30160	30177	30194	\$14.90	\$17.70	30428	30528	30453	30553	\$23.50	\$26.30
1.35mm	33294	33394	32294	32394	\$13.60	\$16.40	30135	30161	30178	30195	\$14.90	\$17.70						
1.40mm	33295	33395	32295	32395	\$13.60	\$16.40	30136	30162	30179	30196	\$14.90	\$17.70	30429	30529	30454	30554	\$23.50	\$26.30
1.45mm	33296	33396	32296	32396	\$13.60	\$16.40	30137	30163	30180	30197	\$14.90	\$17.70						
1.50mm	33297	33397	32297	32397	\$13.60	\$16.40	30138	30164	30181	30198	\$14.90	\$17.70	30430	30530	30455	30555	\$23.50	\$26.30
1.60mm													30431	30531	30456	30556	\$23.50	\$26.30
1.70mm													30432	30532	30457	30557	\$23.50	\$26.30
1.80mm													30433	30533	30458	30558	\$23.50	\$26.30
1.90mm													30434	30534	30459	30559	\$23.50	\$26.30
2.00mm													30435	30535	30460	30560	\$23.50	\$26.30
2.10mm													30436	30536	30461	30561	\$23.50	\$26.30
2.20mm													30437	30537	30462	30562	\$23.50	\$26.30
2.30mm													30438	30538	30463	30563	\$23.50	\$26.30
2.40mm													30439	30539	30464	30564	\$23.50	\$26.30
2.50mm													30440	30540	30465	30565	\$23.50	\$26.30
2.60mm													30441	30541	30466	30566	\$23.50	\$26.30
2.70mm													30442	30542	30467	30567	\$23.50	\$26.30
2.80mm													30443	30543	30468	30568	\$23.50	\$26.30
2.90mm													30444	30544	30469	30569	\$23.50	\$26.30

Decimal Sub-Miniature Square & Ball End Mills; LOC = 1.5, 3.0, and 5.0X Diameter

Diam	Series 330SMS / 330BSMS 2-flute 1.5X Series 320SMS / 320BSMS 4-flute 1.5X						Series 330MSL / 330BSMSL 2-flute 3X Series 320MSL / 320BSMSL 4-flute 3X						Series 330SMSXL / 330BSMSXL 2-flute 5X Series 320SMSXL / 320BSMSXL 4-flute 5X						
																			
					price	coated					price	coated					price	coated	
.005	30000					\$27.50	\$30.30												
.006	30001					\$27.50	\$30.30												
.007	30002					\$26.40	\$29.20												
.008	30003				\$26.40	\$29.20													
.009	30004				\$24.10	\$26.90													
.010	33244	33344			\$22.10	\$24.90	30009	30048			\$24.20	\$27.00	30210	30310			\$31.50	\$34.30	
.011	33245	33345			\$22.10	\$24.90	30010	30049			\$24.20	\$27.00	30211	30311			\$31.50	\$34.30	
.012	33246	33346			\$22.10	\$24.90	30011	30050			\$24.20	\$27.00	30212	30312			\$31.50	\$34.30	
.013	33247	33347			\$22.10	\$24.90	30012	30051			\$24.20	\$27.00	30213	30313			\$31.50	\$34.30	
.014	33298	33398			\$22.10	\$24.90	30013	30052			\$24.20	\$27.00	30214	30314			\$31.50	\$34.30	
.015	33249	33349			\$22.10	\$24.90	30014	30053			\$24.20	\$27.00	30215	30315			\$31.50	\$34.30	
.016	33250	33350			\$21.80	\$24.60	30015	30054			\$24.00	\$26.80	30216	30316			\$31.50	\$34.30	
.017	33251	33351			\$21.80	\$24.60	30016	30055			\$24.00	\$26.80	30217	30317			\$31.50	\$34.30	
.018	33252	33352			\$21.50	\$24.30	30017	30056			\$23.60	\$26.40	30218	30318			\$31.50	\$34.30	
.019	33253	33353			\$21.50	\$24.30	30018	30057			\$23.60	\$26.40	30219	30319			\$31.50	\$34.30	
.020	33254	33354			\$21.50	\$24.30	30019	30040			\$23.60	\$26.40	30220	30320	30263	30363	\$31.50	\$34.30	
.021	33255	33355			\$21.50	\$24.30	30020	30058			\$23.60	\$26.40	30221	30321			\$31.50	\$34.30	
.022	33256	33356			\$21.20	\$24.00	30021	30059			\$23.40	\$26.20	30222	30322			\$31.50	\$34.30	
.023	33257	33357			\$21.20	\$24.00	30022	30060			\$23.40	\$26.20	30223	30323			\$31.50	\$34.30	
.024	33258	33358			\$21.20	\$24.00	30023	30061			\$23.40	\$26.20	30224	30324			\$31.50	\$34.30	
.025	33259	33359	32259	32359	\$20.10	\$22.90	30024	30041	30073	30090	\$22.10	\$24.90	30225	30325	30264	30364	\$29.50	\$32.30	
.026	33260	33360	32260	32360	\$20.10	\$22.90	30025	30062	30074	30091	\$22.10	\$24.90	30226	30326	30265	30365	\$29.50	\$32.30	
.027	33261	33361	32261	32361	\$17.80	\$20.60	30026	30063	30075	30092	\$19.60	\$22.40	30227	30327	30266	30366	\$29.50	\$32.30	
.028	33262	33362	32262	32362	\$17.80	\$20.60	30027	30064	30076	30093	\$19.60	\$22.40	30228	30328	30267	30367	\$29.50	\$32.30	
.029	33263	33363	32263	32363	\$17.80	\$20.60	30028	30065	30077	30094	\$19.60	\$22.40	30229	30329	30268	30368	\$29.50	\$32.30	
.030	33264	33364	32264	32364	\$17.80	\$20.60	30029	30042	30078	30095	\$19.60	\$22.40	30230	30330	30269	30369	\$29.50	\$32.30	
.031	33265	33365	32265	32365	\$14.70	\$17.50	30030	30043	30079	30096	\$16.20	\$19.00	30231	30331	30270	30370	\$26.50	\$29.30	
.032	30005	30574	30470	30570	\$14.70	\$17.50	30031	30066	30080	30097	\$16.20	\$19.00	30232	30332	30271	30371	\$26.50	\$29.30	
.033													30233	30333	30272	30372	\$26.50	\$29.30	
.034													30234	30334	30273	30373	\$26.50	\$29.30	
.035	33266	33366	32266	32366	\$14.40	\$17.20	30047	30067	30081	30098	\$16.20	\$19.00	30235	30335	30274	30374	\$26.50	\$29.30	
.036													30236	30336	30275	30375	\$26.50	\$29.30	
.037	30006	30575	30471	30571	\$14.40	\$17.20	30032	30068	30082	30099	\$15.80	\$18.60	30237	30337	30276	30376	\$26.50	\$29.30	
.038													30238	30338	30277	30377	\$26.50	\$29.30	
.039													30239	30339	30278	30378	\$26.50	\$29.30	
.040	33267	33367	32267	32367	\$14.00	\$16.80	30033	30044	30083	30100	\$15.40	\$18.20	30240	30340	30279	30379	\$23.50	\$26.30	
.041													30241	30341	30280	30380	\$23.50	\$26.30	
.042													30242	30342	30281	30381	\$23.50	\$26.30	
.043													30243	30343	30282	30382	\$23.50	\$26.30	
.044													30244	30344	30283	30383	\$23.50	\$26.30	
.045													30245	30345	30284	30384	\$23.50	\$26.30	
.046	30007	30576	30472	30572	\$13.60	\$16.40	30034	30069	30084	30101	\$14.90	\$17.70	30246	30346	30285	30385	\$23.50	\$26.30	
.047	33268	33368	32268	32368	\$13.60	\$16.40	30035	30045	30085	30108	\$14.90	\$17.70	30247	30347	30286	30386	\$23.50	\$26.30	
.048													30248	30348	30287	30387	\$23.50	\$26.30	
.049													30249	30349	30288	30388	\$23.50	\$26.30	
.050	33269	33369	32269	32369	\$13.60	\$16.40	30036	30070	30086	30109	\$14.90	\$17.70	30250	30350	30289	30389	\$23.50	\$26.30	
.051													30251	30351	30290	30390	\$23.50	\$26.30	
.052													30252	30352	30291	30391	\$23.50	\$26.30	
.053													30253	30353	30292	30392	\$23.50	\$26.30	
.054													30254	30354	30293	30393	\$23.50	\$26.30	
.055	33270	33370	32270	32370	\$13.60	\$16.40	30037	30046	30087	30110	\$14.90	\$17.70	30255	30355	30294	30394	\$23.50	\$26.30	
.056													30256	30356	30295	30395	\$23.50	\$26.30	
.057	30008	30577	30473	30573	\$13.60	\$16.40	30038	30071	30088	30111	\$14.90	\$17.70	30257	30357	30296	30396	\$23.50	\$26.30	
.058													30258	30358	30297	30397	\$23.50	\$26.30	
.059													30259	30359	30298	30398	\$23.50	\$26.30	
.060	33271	33371	32271	32371	\$13.60	\$16.40	30039	30072	30089	30112	\$14.90	\$17.70	30260	30360	30299	30399	\$23.50	\$26.30	
.061													30261	30361	30300	30400	\$23.50	\$26.30	
.062													30262	30362	30308	30408	\$23.50	\$26.30	



Fractional Corner Radius End Mills by ULTRATOOL®

ULTRATOOL®
PERFORMANCE

The Ultra-Tool® Series 330Rad, 362Rad, and 320Rad are tough workhorses that can handle the vast majority of demanding applications. These tools are precision ground from Ultra-Grain®, a premium carbide substrate that couples high hardness with excellent chipping resistance. Choose from 7 different standard radii for your roughing or finishing requirements. Crank up the feed rates even more by adding one of our in-house SmoothCoat® PVD hardcoatings, and / or add SmoothEdge® to eliminate tool break-in.

Series 330RAD

Corner Radius End Mills
Two Flute • Std Length



Diam	LOC	OAL	Shank	.015"	.020"	.030"	.045"	.060"	.090"	.125"	Price	Coated Price
EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#		
1/8	1/2	1-1/2	1/8	31164	31165	31166	31167				\$13.80	\$16.60
3/16	5/8	2"	3/16	31168	31169	31170	31171	31172			\$18.00	\$21.40
1/4	3/4	2-1/2	1/4	31173	31174	31175	31176	31177	31178		\$22.40	\$29.00
5/16	13/16	2-1/2	5/16	31179	31180	31181	31182	31183	31184	31185	\$29.20	\$37.30
3/8	1"	2-1/2	3/8	31186	31187	31188	31189	31190	31191	31192	\$35.50	\$44.10
1/2	1"	3"	1/2	31193	31194	31195	31196	31197	31198	31199	\$65.60	\$77.00
5/8	1-1/2	3-1/2	5/8	31200	31201	31202	31203	31204	31205	31206	\$107.10	\$124.80
3/4	1-1/2	4"	3/4	31207	31208	31209	31210	31211	31212	31213	\$158.60	\$179.50
1"	1-1/2	4"	1"	31214	31215	31217	31218	31219	31220	31221	\$273.10	\$303.10

RAD Specifications:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003
Radius ±.001

ULTRA-Grain®

Series 362RAD

new!

Corner Radius End Mills
Three Flute • Std Length



Diam	LOC	OAL	Shank	.015"	.020"	.030"	.045"	.060"	.090"	.125"	Price	Coated Price
EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#		
1/8	1/2	1-1/2	1/8	31419	31420	31421	31422				\$13.80	\$16.60
3/16	5/8	2"	3/16	31423	31424	31425	31426	31427			\$18.00	\$21.40
1/4	3/4	2-1/2	1/4	31428	31429	31430	31431	31432	31433		\$22.40	\$29.00
5/16	13/16	2-1/2	5/16	31434	31435	31436	31437	31438	31439	31440	\$29.20	\$37.30
3/8	1"	2-1/2	3/8	31441	31442	31443	31444	31445	31446	31447	\$35.50	\$44.10
1/2	1"	3"	1/2	31448	31449	31450	31451	31452	31453	31454	\$65.60	\$77.00
5/8	1-1/2	3-1/2	5/8	31456	31457	31458	31459	31460	31461	31462	\$107.10	\$124.80
3/4	1-1/2	4"	3/4	31463	31464	31465	31466	31467	31468	31469	\$158.60	\$179.50
1"	1-1/2	4"	1"	31470	31471	31472	31473	31474	31475	31476	\$273.10	\$303.10

RAD Specifications:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003
Radius ±.001

ULTRA-Grain®

Series 320RAD

Corner Radius End Mills
Four Flute • Std Length



Diam	LOC	OAL	Shank	.015"	.020"	.030"	.045"	.060"	.090"	.125"	Price	Coated Price
EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#	EDP#		
1/8	1/2	1-1/2	1/8	31101	31110	31119	31128				\$13.80	\$16.60
3/16	5/8	2"	3/16	31102	31111	31120	31129	31138			\$18.00	\$21.40
1/4	3/4	2-1/2	1/4	31103	31112	31121	31130	31139	31148		\$22.40	\$29.00
5/16	13/16	2-1/2	5/16	31104	31113	31122	31131	31140	31149	31158	\$29.20	\$37.30
3/8	1"	2-1/2	3/8	31105	31114	31123	31132	31141	31150	31159	\$35.50	\$44.10
1/2	1"	3"	1/2	31106	31115	31124	31133	31142	31151	31160	\$65.60	\$77.00
5/8	1-1/2	3-1/2	5/8	31107	31116	31125	31134	31143	31152	31161	\$107.10	\$124.80
3/4	1-1/2	4"	3/4	31108	31117	31126	31135	31144	31153	31162	\$158.60	\$179.50
1"	1-1/2	4"	1"	31109	31118	31127	31136	31145	31154	31163	\$273.10	\$303.10

RAD Specifications:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003
Radius ±.001

ULTRA-Grain®



Metric Corner Radius End Mills by ULTRATOOL®

ULTRATOOL®
PERFORMANCE



The Ultra-Tool® Series 330MRad, 362MRad, and 320MRad are tough workhorses that can handle the vast majority of demanding applications. These tools are precision ground from Ultra-Grain®, a premium carbide substrate that couples high hardness with excellent chipping resistance. Choose from 8 different standard radii for your roughing or finishing requirements. Crank up the feed rates even more by adding one of our in-house SmoothCoat® PVD hardcoatings, and / or add SmoothEdge® to eliminate tool break-in.

Series 330MRAD

Corner Radius End Mills
Two Flute • Std Length



MRAD Specifications:
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.007mm
Radius ±0.025mm



Diam	LOC	OAL	Shank	0.2mm EDP#	0.3mm EDP#	0.5mm EDP#	1.0mm EDP#	1.5mm EDP#	2.0mm EDP#	2.5mm EDP#	3.0mm EDP#	Price	Coated Price
3.0mm	12	38	3.0	31292	31293	31294	31295					\$13.80	\$16.60
4.0mm	14	50	4.0	31296	31297	31298	31299	31300				\$18.00	\$21.40
5.0mm	16	50	5.0	31301	31302	31303	31304	31305	31306			\$19.60	\$25.10
6.0mm	19	50	6.0	31307	31308	31309	31310	31311	31312	31313		\$22.40	\$27.80
8.0mm	20	63	8.0	31314	31315	31316	31317	31318	31319	31320	31321	\$29.20	\$37.80
10.0mm	22	70	10.0	31322	31323	31324	31325	31326	31327	31328	31329	\$47.60	\$58.70
12.0mm	25	76	12.0	31330	31331	31332	31333	31334	31335	31336	31337	\$65.60	\$77.00
16.0mm	38	89	16.0	31338	31339	31340	31341	31342	31343	31344	31345	\$107.10	\$128.00
20.0mm	38	101	20.0	31346	31347	31348	31349	31350	31351	31352	31353	\$218.30	\$242.30
25.0mm	38	101	25.0	31354	31355	31356	31357	31358	31359	31360	31361	\$273.10	\$303.10

Series 362MRAD **new!**

Corner Radius End Mills
Three Flute • Std Length



MRAD Specifications:
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.007mm
Radius ±0.025mm



Diam	LOC	OAL	Shank	0.2mm EDP#	0.3mm EDP#	0.5mm EDP#	1.0mm EDP#	1.5mm EDP#	2.0mm EDP#	2.5mm EDP#	3.0mm EDP#	Price	Coated Price
3.0mm	12	38	3.0	31477	31478	31479	31480					\$13.80	\$16.60
4.0mm	14	50	4.0	31481	31482	31483	31484	31485				\$18.00	\$21.40
5.0mm	16	50	5.0	31486	31487	31488	31489	31490	31491			\$19.60	\$25.10
6.0mm	19	50	6.0	31492	31493	31494	31495	31496	31497	31498		\$22.40	\$27.80
8.0mm	20	63	8.0	31499	31500	31501	31502	31503	31504	31505	31506	\$29.20	\$37.80
10.0mm	22	70	10.0	31507	31508	31509	31510	31511	31512	31513	31514	\$47.60	\$58.70
12.0mm	25	76	12.0	31515	31516	31517	31518	31519	31520	31521	31522	\$65.60	\$77.00
16.0mm	38	89	16.0	31523	31524	31525	31526	31527	31528	31529	31530	\$107.10	\$128.00
20.0mm	38	101	20.0	31531	31532	31533	31534	31535	31536	31537	31538	\$218.30	\$242.30
25.0mm	38	101	25.0	31539	31540	31541	31542	31543	31544	31545	31546	\$273.10	\$303.10

Series 320MRAD

Corner Radius End Mills
Four Flute • Std Length



MRAD Specifications:
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.007mm
Radius ±0.025mm



Diam	LOC	OAL	Shank	0.2mm EDP#	0.3mm EDP#	0.5mm EDP#	1.0mm EDP#	1.5mm EDP#	2.0mm EDP#	2.5mm EDP#	3.0mm EDP#	Price	Coated Price
3.0mm	12	38	3.0	31222	31223	31224	31225					\$13.80	\$16.60
4.0mm	14	50	4.0	31226	31227	31228	31229	31230				\$18.00	\$21.40
5.0mm	16	50	5.0	31231	31232	31233	31234	31235	31236			\$19.60	\$25.10
6.0mm	19	50	6.0	31237	31238	31239	31240	31241	31242	31243		\$22.40	\$27.80
8.0mm	20	63	8.0	31244	31245	31246	31247	31248	31249	31250	31251	\$29.20	\$37.80
10.0mm	22	70	10.0	31252	31253	31254	31255	31256	31257	31258	31259	\$47.60	\$58.70
12.0mm	25	76	12.0	31260	31261	31262	31263	31264	31265	31266	31267	\$65.60	\$77.00
16.0mm	38	89	16.0	31268	31269	31270	31271	31272	31273	31274	31275	\$107.10	\$128.00
20.0mm	38	101	20.0	31276	31277	31278	31279	31280	31281	31282	31283	\$218.30	\$242.30
25.0mm	38	101	25.0	31284	31285	31286	31287	31288	31289	31290	31291	\$273.10	\$303.10



ULTRATOOL® Two-Flute Specialty End Mill for Aluminum

Series 330AL Ultra-Grain® End Mill 2 Flute • 45 Degree RH Spiral



SFR 330AL Series End Mill Specs:
Cutting Diam +.0000/- .0003
Shank Diam +.0000/- .0003



Clearance neck
available in 24 hours

Series 330AL Tech Spec:

Surface Feet Per Minute (SFM) and Feed Per Tooth (FPT) recommendations for slot milling by tool diameter are located in the right-hand column. Axial depth of cut should be equal or less than the tool diameter. Increase speed & feed 20% when using stub lengths. For finishing work, increase S&F's up to 50%, with axial DOC up to 1.5x & radial DOC not exceeding 15% of tool diameter.

- Incredible diameter tolerance for finishing work.
- The 330AL offers improved ramping, plunging, and slotting capabilities versus the 333AL.
- Assure optimal conditions by maintaining large volume of coolant flow (note: A1 coating is superb for DRY machining in many applications).
- Minimal TIR—design best utilized by proper fixturing and rigidity & accuracy of set-up.



A1 coating includes SE3
for the 330AL Series.
Watch the chips fly!



SmoothCoat® A1 (TiB2) is specifically engineered for the AL Series, offering superb increases in lubricity and longevity while reducing chip weld and galling. We highly recommend using A1 coating for medium to long production runs. Environmentally, A1 allows for dry or low coolant use in many milling applications.



ULTRATOOL® PERFORMANCE



Ultra-Tool® products are
Shrink Fit Ready (SFR).

The Ultra-Tool® Series 330AL End Mill is designed specifically for the highest possible efficiency in the milling of aluminum. The 330AL will allow full machine capacity roughing and close tolerance finishing of aluminum and other non-ferrous materials. SmoothEdge 3 now included with A1 coating! **new!** One low price for Square and Rads!

Diam	LOC	OAL	Shank	Square EDP#	.010 Rad EDP#	.020 Rad EDP#	.030 Rad EDP#	.060 Rad EDP#	.090 Rad EDP#	.125 Rad EDP#	Price	A1 Coated	Feed (FPT) Inch/Tooth@ 1200-1600 SFM
1/8	1/4	1-1/2	1/8	11104	11747						\$14.00	\$17.80	.002 - .004
1/8	1/2	1-1/2	1/8	11139	11748						\$14.20	\$18.00	.002 - .004
3/16	3/8	2"	3/16	11107	11749						\$19.30	\$24.30	.002 - .004
3/16	5/8	2"	3/16	11142	11750						\$19.90	\$24.90	.002 - .004
1/4	3/8	2-1/2	1/4	11110		11751	11765	11781			\$27.50	\$36.50	.003 - .005
1/4	1/2	2"	1/4	39750		11752	11766	11782			\$26.10	\$35.10	.003 - .005
1/4	1"	2-1/2	1/4	39710		11753	11767	11783			\$33.00	\$41.90	.003 - .005
1/4	2"	4"	1/4	39751		11754	11768	11784			\$55.30	\$67.30	.003 - .005
5/16	1/2	2-1/2	5/16	11113		11755	11769				\$35.80	\$47.80	.004 - .006
5/16	3/4	2-1/2	5/16	11148		11756	11770				\$36.50	\$48.50	.004 - .006
5/16	1-3/8	3"	5/16	39752		11757	11771				\$57.20	\$69.10	.004 - .006
3/8	5/8	2-1/2	3/8	11116		11758	11772	11785			\$38.80	\$50.80	.005 - .007
3/8	3/4	2-1/2	3/8	39753		11759	11773	11786			\$39.90	\$51.90	.005 - .007
3/8	1-1/8	2-1/2	3/8	39711		11760	11774	11787			\$45.30	\$57.30	.005 - .007
3/8	2"	4"	3/8	39754		11761	11775	11788			\$65.90	\$83.90	.005 - .007
1/2	3/4	3"	1/2	39755		11762	11776	11789			\$65.00	\$81.90	.006 - .009
1/2	1-1/4	3"	1/2	39712		11763	11777	11790			\$68.50	\$85.40	.006 - .009
1/2	2"	4"	1/2	39756		11764	11778	11791			\$101.70	\$124.70	.006 - .009
5/8	1-3/4	3-1/2	5/8	39713			11779	11792	11798		\$128.80	\$155.80	.008 - .012
5/8	3"	6"	5/8	39757			11780	11793	11799		\$199.20	\$241.20	.008 - .012
3/4	1-3/4	4"	3/4	39714				11794	11800	11804	\$172.30	\$202.30	.010 - .014
3/4	3"	6"	3/4	39758				11795	11801	11805	\$279.40	\$325.30	.010 - .014
1"	1-7/8	4"	1"	39715				11796	11802	11806	\$287.70	\$332.70	.012 - .018
1"	3"	6"	1"	39759				11797	11803	11807	\$445.90	\$510.90	.012 - .018

SFR 330AL Series Specs (Metric):
Cutting Diam +0.000/-0.007mm
Shank Diam +0.000/-0.007mm

Diam	LOC	OAL	Shank	Square EDP#	0.5mm Rad EDP#	1.0mm Rad EDP#	3.0mm Rad EDP#	Price	A1 Coated	Feed (FPT) mm/Tooth@ 365 - 485 MPM*
3.0mm	6	38	3.0	11504	11701			\$14.00	\$17.80	0.05 - 0.10
3.0mm	12	38	3.0	11525	11702			\$14.20	\$18.00	0.05 - 0.10
4.0mm	9	50	4.0	11507	11703			\$17.00	\$22.00	0.05 - 0.10
4.0mm	12	50	4.0	11528	11704			\$17.50	\$22.50	0.05 - 0.10
5.0mm	9	50	5.0	11510	11705			\$20.30	\$26.30	0.05 - 0.10
5.0mm	14	50	5.0	11531	11706			\$20.90	\$26.90	0.05 - 0.10
6.0mm	12	63	6.0	11513	11707	11720		\$29.50	\$38.50	0.08 - 0.13
6.0mm	25	63	6.0	39760	11708	11721		\$33.00	\$42.00	0.08 - 0.13
6.0mm	50	101	6.0	39761	11709	11722		\$55.30	\$67.30	0.08 - 0.13
8.0mm	14	63	8.0	11516	11710	11723		\$38.50	\$50.50	0.10 - 0.15
8.0mm	25	63	8.0	39716	11711	11724		\$39.80	\$51.80	0.10 - 0.15
8.0mm	50	101	8.0	39762	11712	11725		\$65.90	\$80.90	0.10 - 0.15
10.0mm	16	70	10.0	11519	11713	11726		\$56.50	\$70.50	0.13 - 0.18
10.0mm	30	70	10.0	39717	11714	11727		\$59.00	\$73.00	0.13 - 0.18
10.0mm	50	101	10.0	39763	11715	11728		\$83.00	\$105.00	0.13 - 0.18
12.0mm	19	74	12.0	11522	11716	11729		\$64.50	\$81.50	0.15 - 0.23
12.0mm	32	74	12.0	39718	11717	11730		\$68.50	\$85.40	0.15 - 0.23
12.0mm	50	101	12.0	39764	11718	11731		\$101.70	\$124.70	0.15 - 0.23
14.0mm	44	89	14.0	39765	11719	11732		\$114.00	\$137.90	0.20 - 0.30
16.0mm	44	89	16.0	39719		11733	11740	\$128.80	\$155.80	0.20 - 0.30
16.0mm	64	127	16.0	39766		11734	11741	\$199.20	\$241.20	0.20 - 0.30
18.0mm	50	101	18.0	39767		11735	11742	\$197.50	\$227.50	0.25 - 0.35
20.0mm	50	101	20.0	39720		11736	11743	\$218.20	\$250.00	0.25 - 0.35
20.0mm	76	152	20.0	39768		11737	11744	\$350.90	\$405.90	0.25 - 0.35
25.0mm	50	101	25.0	39721		11738	11745	\$287.70	\$332.70	0.30 - 0.45
25.0mm	76	152	25.0	39769		11739	11746	\$445.90	\$510.90	0.30 - 0.45

*Note: Metric speeds & feeds listed in millimeters per tooth & meters per minute.



Face Milling



End Milling



Slot Milling



Pocket Milling



Peripheral Milling

ULTRA TOOL® Three-Flute Specialty End Mill for Aluminum

new!

Series 333AL
Ultra-Grain® End Mill
3 Flute • 45 Degree RH Spiral

SFR 333AL Series End Mill Specs:
Cutting Diam +.0000/- .0003
Shank Diam +.0000/- .0003



Clearance neck
available in 24 hours

Series 333AL Tech Spec:

Surface Feet Per Minute (SFM) and Feed Per Tooth (FPT) recommendations for slot milling by tool diameter are located in the right-hand column. Axial depth of cut should be equal or less than the tool diameter. Increase speed & feed 20% when using stub lengths. For finishing work, increase S&F's up to 50%, with axial DOC up to 1.5x & radial DOC not exceeding 15% of tool diameter.

- Incredible diameter tolerance for finishing work.
- The 333AL offers improved feed rates, work piece finish, and stability over the 330AL.
- Assure optimal conditions by maintaining large volume of coolant flow (note: A1 coating is superb for DRY machining in many applications).
- Minimal TIR—design best utilized by proper fixturing and rigidity & accuracy of set-up.



A1 coating includes SE3
for the 333AL Series.
Watch the chips fly!



SmoothCoat® A1 (TiB2) is specifically engineered for the AL Series, offering superb increases in lubricity and longevity while reducing chip weld and galling. We highly recommend using A1 coating for medium to long production runs. Environmentally, A1 allows for dry or low coolant use in many milling applications.



The Ultra-Tool® Series 333AL End Mill is designed specifically for the highest possible efficiency in the milling of aluminum. The 333AL will allow full machine capacity roughing and close tolerance finishing of aluminum and other non-ferrous materials. SmoothEdge 3 now included with A1 coating!
One low price for Square and Rads!

Diam	LOC	OAL	Shank	EDP#	EDP#	Square Rad	.010 Rad	.020 Rad	.030 Rad	.060 Rad	.090 Rad	.125 Rad	Price	A1 Coated	Feed (FPT) Inch/Tooth @ 1200-1600 SFM
1/8	1/4	1-1/2	1/8	11544	11640								\$15.40	\$19.20	.002-.004
1/8	1/2	1-1/2	1/8	11545	11641								\$15.60	\$19.40	.002-.004
3/16	3/8	2"	3/16	11546	11642								\$21.30	\$26.30	.002-.004
3/16	5/8	2"	3/16	11547	11643								\$21.90	\$26.90	.002-.004
1/4	3/8	2-1/2	1/4	11548		11644	11658	11674					\$30.30	\$39.30	.003-.005
1/4	1/2	2"	1/4	11549		11645	11659	11675					\$28.70	\$37.70	.003-.005
1/4	1"	2-1/2	1/4	11550		11646	11660	11676					\$36.20	\$45.20	.003-.005
1/4	2"	4"	1/4	11551		11647	11661	11677					\$60.80	\$72.80	.003-.005
5/16	1/2	2-1/2	5/16	11552		11648	11662						\$39.30	\$51.30	.004-.006
5/16	3/4	2-1/2	5/16	11553		11649	11663						\$40.20	\$52.20	.004-.006
5/16	1-3/8	3"	5/16	11554		11650	11664						\$62.80	\$74.80	.004-.006
3/8	5/8	2-1/2	3/8	11555		11651	11665	11678					\$42.60	\$54.60	.005-.007
3/8	3/4	2-1/2	3/8	11556		11652	11666	11679					\$43.90	\$55.90	.005-.007
3/8	1-1/8	2-1/2	3/8	11557		11653	11667	11680					\$49.80	\$61.80	.005-.007
3/8	2"	4"	3/8	11558		11654	11668	11681					\$72.40	\$90.40	.005-.007
1/2	3/4	3"	1/2	11559		11655	11669	11682					\$71.40	\$88.40	.006-.009
1/2	1-1/4	3"	1/2	11560		11656	11670	11683					\$75.20	\$92.20	.006-.009
1/2	2"	4"	1/2	11561		11657	11671	11684					\$111.70	\$134.70	.006-.009
5/8	1-3/4	3-1/2	5/8	11562			11672	11685	11691				\$141.80	\$168.80	.008-.012
5/8	3"	6"	5/8	11563			11673	11686	11692				\$219.20	\$261.20	.008-.012
3/4	1-3/4	4"	3/4	11564				11687	11693	11697			\$189.30	\$219.30	.010-.014
3/4	3"	6"	3/4	11565				11688	11694	11698			\$307.40	\$353.30	.010-.014
1"	1-7/8	4"	1"	11566				11689	11695	11699			\$316.70	\$361.70	.012-.018
1"	3"	6"	1"	11567				11690	11696	11700			\$490.90	\$555.90	.012-.018

SFR 333AL Series Specs (Metric):
Cutting Diam +0.000/-0.007mm
Shank Diam +0.000/-0.007mm

Diam	LOC	OAL	Shank	EDP#	EDP#	Square Rad	0.5mm Rad	1.0mm Rad	3.0mm Rad	Price	A1 Coated	Feed (FPT) mm/Tooth @ 365-485 MPM*
3.0mm	6	38	3.0	11568	11594					\$15.40	\$19.20	0.05-0.10
3.0mm	12	38	3.0	11569	11595					\$15.60	\$19.40	0.05-0.10
4.0mm	9	50	4.0	11570	11596					\$18.70	\$23.70	0.05-0.10
4.0mm	12	50	4.0	11571	11597					\$19.30	\$24.30	0.05-0.10
5.0mm	9	50	5.0	11572	11598					\$22.30	\$28.30	0.05-0.10
5.0mm	14	50	5.0	11573	11599					\$22.90	\$28.90	0.05-0.10
6.0mm	12	63	6.0	11574	11600	11613				\$32.50	\$41.50	0.08-0.13
6.0mm	25	63	6.0	11575	11601	11614				\$36.20	\$45.20	0.08-0.13
6.0mm	50	101	6.0	11576	11602	11615				\$60.80	\$72.80	0.08-0.13
8.0mm	14	63	8.0	11577	11603	11616				\$42.40	\$54.40	0.10-0.15
8.0mm	25	63	8.0	11578	11604	11617				\$44.00	\$55.80	0.10-0.15
8.0mm	50	101	8.0	11579	11605	11618				\$72.40	\$88.90	0.10-0.15
10.0mm	16	70	10.0	11580	11606	11619				\$62.10	\$76.10	0.13-0.18
10.0mm	30	70	10.0	11581	11607	11620				\$65.00	\$79.00	0.13-0.18
10.0mm	50	101	10.0	11582	11608	11621				\$91.30	\$113.30	0.13-0.18
12.0mm	19	74	12.0	11583	11609	11622				\$71.00	\$88.00	0.15-0.23
12.0mm	32	74	12.0	11584	11610	11623				\$75.20	\$92.20	0.15-0.23
12.0mm	50	101	12.0	11585	11611	11624				\$111.70	\$134.70	0.15-0.23
14.0mm	44	89	14.0	11586	11612	11625				\$124.40	\$149.30	0.20-0.30
16.0mm	44	89	16.0	11587		11626	11633			\$141.80	\$168.80	0.20-0.30
16.0mm	64	127	16.0	11588		11627	11634			\$219.20	\$261.20	0.20-0.30
18.0mm	50	101	18.0	11589		11628	11635			\$217.50	\$247.50	0.25-0.35
20.0mm	50	101	20.0	11590		11629	11636			\$240.20	\$272.00	0.25-0.35
20.0mm	76	152	20.0	11591		11630	11637			\$386.00	\$440.90	0.25-0.35
25.0mm	50	101	25.0	11592		11631	11638			\$316.70	\$361.70	0.30-0.45
25.0mm	76	152	25.0	11593		11632	11639			\$490.90	\$555.90	0.30-0.45

*Note: Metric speeds & feeds listed in millimeters per tooth & meters per minute.



Face Milling

End Milling

Slot Milling

Pocket Milling

Peripheral Milling

Five-Flute Fractional & Metric Specialty End Mill by ULTRATOOL®

new! **Series 355**
Ultra-Grain® End Mill
5 Flute • 45 Degree RH Spiral
Honed • Coated



- Primary Usage: Finishing operation in steel, stainless, titanium & high-temp alloys.
- Order with either the AT or A1 coating suffix.
- Utilize our A1 (TiB2) in Titanium grades 5553 & 6Al-4V, and AT (HSN²) in all other materials.
- Assure optimal conditions by maintaining large volume of coolant flow.
- Minimal TIR—design best utilized by proper fixturing and rigidity & accuracy of set-up.
- Our hone minimizes tool break-in time. Optimum tool condition should be reached within the initial few passes.



Ultra-Tool® products are
Shrink Fit Ready (SFR).

The Ultra-Tool® Series 355 End Mill is designed for the highest efficiency in the milling / finishing of steel, stainless, titanium and high-temp alloys. Precision-ground from Ultra-Grain® for top strength, the 355 features a proprietary OD hone to minimize tool break-in and the latest generation of SmoothCoat® AlTiN or TiB2 Super-Nitride PVD coating.

SmoothEdge®

ULTRA-Grain®

SE4



SFR 355 Series End Mill Specs:
Cutting Diam +.000/- .002
Shank Diam -.0000/- .0003

Diam	LOC	OAL	Shank	Square EDP#	Rad	Radius EDP#	AT Coated	A1 Coated
1/8	1/2	1-1/2	1/8	31550	.010	31560	\$19.80	\$22.80
3/16	5/8	2"	3/16	31551	.010	31561	\$26.40	\$29.90
1/4	3/4	2-1/2	1/4	31552	.015	31562	\$35.00	\$42.00
5/16	13/16	2-1/2	5/16	31553	.020	31563	\$45.00	\$53.50
3/8	1"	2-1/2	3/8	31554	.020	31564	\$54.80	\$63.80
7/16	1"	2-3/4	7/16	31555	.020	31565	\$68.50	\$80.50
1/2	1"	3"	1/2	31556	.030	31566	\$83.40	\$95.40
5/8	1-1/2	3-1/2	5/8	31557	.030	31567	\$145.40	\$163.40
3/4	1-1/2	4"	3/4	31558	.030	31568	\$216.50	\$241.50
1"	1-1/2	4"	1"	31559	.030	31569	\$363.80	\$393.80

SFR 355 Series Specs (Metric):
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.007mm

Diam	LOC	OAL	Shank	Square EDP#	Rad	Radius EDP#	AT Coated	A1 Coated
3.0mm	12	38	3.0	31570	0.2	31580	\$19.80	\$22.80
4.0mm	14	50	4.0	31571	0.2	31581	\$26.40	\$29.90
5.0mm	16	50	5.0	31572	0.3	31582	\$27.50	\$33.50
6.0mm	19	50	6.0	31573	0.3	31583	\$34.00	\$40.00
8.0mm	20	63	8.0	31574	0.3	31584	\$45.00	\$53.50
10.0mm	22	70	10.0	31575	0.5	31585	\$68.70	\$80.70
12.0mm	25	74	12.0	31576	0.5	31586	\$83.40	\$95.40
16.0mm	38	89	16.0	31577	0.5	31587	\$145.40	\$163.40
20.0mm	38	101	20.0	31578	0.5	31588	\$309.40	\$334.50
25.0mm	38	101	25.0	31579	0.5	31589	\$363.80	\$393.80



Series 355 Tech Spec:

Surface Feet Per Minute (SFM) and Feed Per Tooth (FPT) recommendations for peripheral milling by tool diameter are located below. Axial depth of cut should be equal or less than the tool diameter, with radial DOC not exceeding 20% of tool diameter.



Face Milling



End Milling



Slot Milling



Pocket Milling



Peripheral Milling

Material	SFM	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
Steel										
1018 / 1020	250 to 400	.0007	.0012	.0015	.0018	.002	.003	.0035	.004	.0045
4140	200 to 350	.0005	.001	.0012	.0015	.0018	.0025	.003	.0035	.004
Stainless Steel										
303	250 to 400	.0007	.001	.0012	.0015	.002	.003	.0035	.004	.004
304 / 316	200 to 350	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
410 / 420	200 to 350	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
15-5 / 17-4	150 to 300	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
13-8 / 316L	150 to 350	.0005	.0007	.0008	.001	.0012	.002	.0025	.003	.0035
Tool Steel										
A2 / D2 / H13 / P20	150 to 300	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0035
Titanium										
6Al-4V	75 to 200	.0005	.0008	.001	.001	.0012	.002	.002	.0035	.004
High Temp Alloys										
Inconel 625	75 to 150	.0005	.0008	.001	.001	.0012	.002	.002	.0025	.003
Inconel 718	75 to 125	.0005	.0007	.0008	.0009	.0012	.002	.002	.0025	.0025

ULTRATOOL® HR Series Fractional & Metric Corner Radius End Mills

Series 330HR • 362HR • 320HR

Ultra-Grain® End Mill
Honed • Radius • Coated



ULTRATOOL®
PERFORMANCE

ULTRA-Grain®



Ultra-Tool® products are
Shrink Fit Ready (SFR).

- Primary Usage: Roughing operation in steel, stainless, titanium & high-temp alloys.
- Order with either the AT or A1 coating suffix.
- Utilize our A1 (TiB2) in Titanium grades 5553 & 6Al-4V, and AT (HSN2) in all other materials.
- Assure optimal conditions by maintaining large volume of coolant flow.
- Minimal TIR—design best utilized by proper fixturing and rigidity & accuracy of set-up.
- Our hone minimizes tool break-in time. Optimum tool condition should be reached within the initial few passes.

The Ultra-Tool® Series 330HR, 362HR, & 320HR (Honed / Radius) End Mill is designed for the highest efficiency in the milling / roughing of steel, stainless, titanium and high-temp alloys. Precision-ground from Ultra-Grain® for top strength, these end mills feature a standard corner radius, a proprietary OD hone to minimize tool break-in & add strength, and the latest generation of SmoothCoat® AlTiN (AT) or TiB2 (A1) SuperNitride PVD coating. The HR Series is a Home-Run for performance.

SmoothEdge®

HR Series End Mill Specs:
Cutting Diam +.000/-0.002
Shank Diam -.0000/-0.0003
Radius ±.001



Diam	LOC	OAL	Shank	Radius	330HR EDP#	362HR EDP#	320HR EDP#	AT Coated	A1 Coated
1/8	1/2	1-1/2	1/8	.015	31362	31363	31364	\$19.40	\$22.40
3/16	5/8	2"	3/16	.015	31365	31366	31367	\$25.50	\$29.00
1/4	3/4	2-1/2	1/4	.015	31368	31369	31370	\$34.00	\$41.00
5/16	13/16	2-1/2	5/16	.015	31371	31372	31373	\$43.50	\$52.00
3/8	1"	2-1/2	3/8	.020	31374	31375	31376	\$52.00	\$61.00
1/2	1"	3"	1/2	.020	31377	31378	31379	\$79.40	\$91.40
5/8	1-1/2	3-1/2	5/8	.030	31380	31381	31382	\$136.40	\$154.40
3/4	1-1/2	4"	3/4	.030	31383	31384	31385	\$205.50	\$230.50
1"	1-1/2	4"	1"	.045	31386	31387	31388	\$335.00	\$365.00

HR Series Specs (Metric):
Cutting Diam +0.000/-0.051mm
Shank Diam +0.000/-0.007mm
Radius ±0.025mm

Diam	LOC	OAL	Shank	Radius	330HR EDP#	362HR EDP#	320HR EDP#	AT Coated	A1 Coated
3.0mm	12	38	3.0	0.2	31389	31390	31391	\$19.40	\$22.80
4.0mm	14	50	4.0	0.2	31392	31393	31394	\$25.50	\$29.00
5.0mm	16	50	5.0	0.3	31395	31396	31397	\$26.50	\$33.50
6.0mm	19	50	6.0	0.3	31398	31399	31400	\$33.00	\$40.00
8.0mm	20	63	8.0	0.5	31401	31402	31403	\$43.50	\$52.00
10.0mm	22	70	10.0	0.5	31404	31405	31406	\$64.50	\$76.50
12.0mm	25	74	12.0	0.5	31407	31408	31409	\$79.40	\$91.40
16.0mm	38	89	16.0	0.5	31410	31411	31412	\$136.40	\$154.40
20.0mm	38	101	20.0	1.0	31413	31414	31415	\$290.00	\$315.00
25.0mm	38	101	25.0	1.0	31416	31417	31418	\$335.00	\$365.00

HR Series Tech Spec:

Surface Feet Per Minute (SFM) and Feed Per Tooth (FPT) recommendations for slot milling by tool diameter are located below. Axial depth of cut should be equal or less than the tool diameter. For finishing work, increase S&F's up to 50%, with axial DOC up to 1.5x & radial DOC not exceeding 15% of tool diameter.



Face Milling



End Milling



Slot Milling



Pocket Milling



Peripheral Milling



WET

Material	SFM	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
Steel										
1018 / 1020	250 to 400	.0007	.0012	.0015	.0018	.002	.003	.0035	.004	.0045
4140	200 to 350	.0005	.001	.0012	.0015	.0018	.0025	.003	.0035	.004
Stainless Steel										
303	250 to 400	.0007	.001	.0012	.0015	.002	.003	.0035	.004	.004
304 / 316	200 to 350	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
410 / 420	200 to 350	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
15-5 / 17-4	150 to 300	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0038
13-8 / 316L	150 to 350	.0005	.0007	.0008	.001	.0012	.002	.0025	.003	.0035
Tool Steel										
A2 / D2 / H13 / P20	150 to 300	.0005	.0008	.001	.0012	.0015	.0025	.003	.0035	.0035
Titanium										
6Al-4V	75 to 200	.0005	.0008	.001	.001	.0012	.002	.002	.0035	.004
High Temp Alloys										
Inconel 625	75 to 150	.0005	.0008	.001	.001	.0012	.002	.002	.0025	.003
Inconel 718	75 to 125	.0005	.0007	.0008	.0009	.0012	.002	.002	.0025	.0025

Stub Length End Mills by ULTRATOOL

Series 332 Square End
332B Ball End
Stub Length • Two Flute



Series 322 Square End
322B Ball End
Stub Length • Four Flute



Detailed Speeds and Feeds instructions
can be located on Page #49.

SFR Ultra-Tool End Mill Specs:
Cutting Diam +.000/-0.002
Shank Diam +.0000/-0.0003

Diam	LOC	OAL	Shank	332 EDP#	332B EDP#	322 EDP#	322B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/32	1/16	1-1/2	1/8	33202	33302	32202	32302	\$13.00	\$15.80	\$16.30	\$19.10
3/64	1/8	1-1/2	1/8	33203	33303	32203	32303	\$13.00	\$15.80	\$16.30	\$19.10
1/16	1/8	1-1/2	1/8	33204	33304	32204	32304	\$10.30	\$13.20	\$12.90	\$15.70
5/64	1/8	1-1/2	1/8	33205	33305	32205	32305	\$10.30	\$13.20	\$12.90	\$15.70
3/32	3/16	1-1/2	1/8	33206	33306	32206	32306	\$9.80	\$12.60	\$12.30	\$15.10
7/64	3/16	1-1/2	1/8	33207	33307	32207	32307	\$9.80	\$12.60	\$12.30	\$15.10
1/8	1/4	1-1/2	1/8	33208	33308	32208	32308	\$9.50	\$12.30	\$11.80	\$14.60
5/32	3/8	2"	3/16	33210	33310	32210	32310	\$13.40	\$16.80	\$16.60	\$20.10
3/16	3/8	2"	3/16	33212	33312	32212	32312	\$12.60	\$16.10	\$15.80	\$19.20
7/32	7/16	2"	1/4	33214	33314	32214	32314	\$16.80	\$22.20	\$20.90	\$26.30
1/4	1/2	2"	1/4	33216	33316	32216	32316	\$16.50	\$22.00	\$20.70	\$26.10
5/16	1/2	2"	5/16	33220	33320	32220	32320	\$22.60	\$28.90	\$28.30	\$34.60
3/8	5/8	2-1/2	3/8	33224	33324	32224	32324	\$27.90	\$36.50	\$34.80	\$43.40
7/16	3/4	2-1/2	7/16	33228	33328	32228	32328	\$40.10	\$51.30	\$50.10	\$61.30
1/2	3/4	2-1/2	1/2	33232	33332	32232	32332	\$46.00	\$57.50	\$57.50	\$68.90
5/8	3/4	3-1/2	5/8	33236	33336	32236	32336	\$85.90	\$103.60	\$105.90	\$123.70
3/4	1"	4"	3/4	33240	33340	32240	32340	\$114.50	\$135.40	\$143.10	\$164.00
1"	1"	4"	1"	33248	33348	32248	32348	\$197.20	\$227.30	\$240.50	\$270.50

Double End Stub Length End Mills by ULTRATOOL

Series 336 Square End • 336B Ball End
Two Flute • Stub Length • Double End



Series 326 Square End • 326B Ball End
Four Flute • Stub Length • Double End



SFR Ultra-Tool End Mill Specs:
Cutting Diam +.000/-0.002
Shank Diam +.0000/-0.0003

Diam	LOC	OAL	Shank	336 EDP#	336B EDP#	326 EDP#	326B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/32	3/32	1-1/2	1/8	33602	33702	32602	32702	\$23.30	\$27.50	\$29.20	\$33.40
3/64	1/8	1-1/2	1/8	33603	33703	32603	32703	\$23.30	\$27.50	\$29.20	\$33.40
1/16	1/8	1-1/2	1/8	33604	33704	32604	32704	\$23.30	\$27.50	\$29.20	\$33.40
5/64	1/8	1-1/2	1/8	33605	33705	32605	32705	\$23.30	\$27.50	\$29.20	\$33.40
3/32	3/16	1-1/2	1/8	33606	33706	32606	32706	\$23.30	\$27.50	\$29.20	\$33.40
7/64	3/16	1-1/2	1/8	33607	33707	32607	32707	\$23.30	\$27.50	\$29.20	\$33.40
1/8	1/4	1-1/2	1/8	33608	33708	32608	32708	\$14.50	\$18.70	\$18.20	\$22.40
9/64	5/16	2"	3/16	33609	33709	32609	32709	\$25.70	\$30.90	\$32.20	\$37.40
5/32	5/16	2"	3/16	33610	33710	32610	32710	\$25.70	\$30.90	\$32.20	\$37.40
11/64	5/16	2"	3/16	33611	33711	32611	32711	\$25.70	\$30.90	\$32.20	\$37.40
3/16	3/8	2"	3/16	33612	33712	32612	32712	\$21.10	\$26.20	\$26.30	\$31.50
13/64	1/2	2-1/2	1/4	33613	33713	32613	32713	\$30.00	\$39.80	\$37.50	\$47.30
7/32	1/2	2-1/2	1/4	33614	33714	32614	32714	\$30.00	\$39.80	\$37.50	\$47.30
15/64	1/2	2-1/2	1/4	33615	33715	32615	32715	\$30.00	\$39.80	\$37.50	\$47.30
1/4	1/2	2-1/2	1/4	33616	33716	32616	32716	\$27.30	\$37.20	\$34.20	\$44.00
5/16	1/2	2-1/2	5/16	33620	33720	32620	32720	\$34.00	\$46.00	\$42.50	\$54.50
3/8	9/16	2-1/2	3/8	33624	33724	32624	32724	\$36.10	\$49.00	\$45.30	\$58.10
7/16	5/8	2-3/4	7/16	33628	33728	32628	32728	\$52.10	\$68.90	\$65.20	\$81.90
1/2	5/8	3"	1/2	33632	33732	32632	32732	\$61.40	\$78.60	\$76.70	\$93.90
5/8	3/4	3-1/2	5/8	33636	33736	32636	32736	\$114.50	\$141.10	\$143.10	\$169.80
3/4	1"	4"	3/4	33640	33740	32640	32740	\$160.30	\$191.60	\$200.40	\$231.70

Double End Standard Length End Mills by ULTRATOOL

Series 334 Square End • 334B Ball End Two Flute • Standard Length • Double End



Series 324 Square End • 324B Ball End Four Flute • Standard Length • Double End



SFR Ultra-Tool End Mill Specs:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003

Diam	LOC	OAL	Shank	334 EDP#	334B EDP#	324 EDP#	324B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/32	3/32	2"	1/8	33402	33502	32402	32502	\$27.70	\$31.90	\$34.50	\$38.70
3/64	1/8	2"	1/8	33403	33503	32403	32503	\$27.70	\$31.90	\$34.50	\$38.70
1/16	3/16	2"	1/8	33404	33504	32404	32504	\$27.70	\$31.90	\$34.50	\$38.70
3/32	3/8	2"	1/8	33406	33506	32406	32506	\$27.70	\$31.90	\$34.50	\$38.70
1/8	3/8	2"	1/8	33408	33508	32408	32508	\$20.10	\$24.30	\$25.10	\$29.30
5/32	7/16	3"	3/16	33410	33510	32410	32510	\$28.70	\$35.90	\$35.80	\$43.10
3/16	1/2	3"	3/16	33412	33512	32412	32512	\$24.70	\$31.90	\$30.80	\$38.10
7/32	9/16	3"	1/4	33414	33514	32414	32514	\$33.80	\$44.80	\$42.30	\$52.10
1/4	5/8	3"	1/4	33416	33516	32416	32516	\$31.80	\$41.70	\$39.80	\$49.60
9/32	11/16	3"	5/16	33418	33518	32418	32518	\$44.10	\$56.70	\$55.20	\$67.20
5/16	3/4	3"	5/16	33420	33520	32420	32520	\$37.90	\$50.00	\$47.40	\$59.50
11/32	3/4	4"	3/8	33422	33522	32422	32522	\$58.70	\$75.40	\$74.60	\$91.30
3/8	1"	4"	3/8	33424	33524	32424	32524	\$50.40	\$67.10	\$63.00	\$79.70
7/16	1"	4"	7/16	33428	33528	32428	32528	\$69.60	\$91.10	\$87.00	\$108.50
1/2	1"	4"	1/2	33432	33532	32432	32532	\$78.20	\$101.40	\$97.70	\$120.90
9/16	1-1/4	6"	9/16	33434	33534	32434	32534	\$143.10	\$180.50	\$168.90	\$206.20
5/8	1-1/2	6"	5/8	33436	33536	32436	32536	\$183.60	\$224.80	\$217.60	\$259.20
3/4	1-1/2	6"	3/4	33440	33540	32440	32540	\$257.60	\$306.10	\$303.40	\$351.90
7/8	1-1/2	6"	7/8	33444	33544	32444	32544	\$423.60	\$479.40	\$492.30	\$548.10
1"	1-1/2	6"	1"	33448	33548	32448	32548	\$452.20	\$515.80	\$526.70	\$590.20

Double End 3/8" Shank End Mills by ULTRATOOL

Series 338 Square End • 338B Ball End Two Flute • Double End • Standard Length • 3/8" Shank With Standard Weldon Flat



Series 328 Square End • 328B Ball End Four Flute • Double End • Standard Length • 3/8" Shank With Standard Weldon Flat



SFR Ultra-Tool End Mill Specs:
Cutting Diam +.000/- .002
Shank Diam +.0000/- .0003

Diam	LOC	OAL	Shank	338 EDP#	338B EDP#	328 EDP#	328B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/8	3/8	3"	3/8	33808	33908	32808	32908	\$45.80	\$58.70	\$53.90	\$66.70
5/32	7/16	3"	3/8	33810	33910	32810	32910	\$45.80	\$58.70	\$53.90	\$66.70
3/16	1/2	3"	3/8	33812	33912	32812	32912	\$45.80	\$58.70	\$53.90	\$66.70
7/32	9/16	3"	3/8	33814	33914	32814	32914	\$45.80	\$58.70	\$53.90	\$66.70
1/4	5/8	3"	3/8	33816	33916	32816	32916	\$45.80	\$58.70	\$53.90	\$66.70
9/32	11/16	4"	3/8	33818	33918	32818	32918	\$52.70	\$69.40	\$61.90	\$78.60
5/16	3/4	4"	3/8	33820	33920	32820	32920	\$52.70	\$69.40	\$61.90	\$78.60
11/32	3/4	4"	3/8	33822	33922	32822	32922	\$52.70	\$69.40	\$61.90	\$78.60
3/8	3/4	4"	3/8	33824	33924	32824	32924	\$52.70	\$69.40	\$61.90	\$78.60

Detailed Speeds and Feeds instructions
can be located on Page #49.

Standard features:

SmoothGrind® SmoothContricity®

Available options:

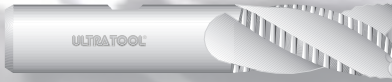
SmoothCoat® SmoothEdge®



ULTRATOOL® Solid Carbide Roughing End Mills

Series 395

Sinusoidal Roughing End Mill
30 Degree RH Spiral • Four Flutes



Ultra-Tool 395 Specs:
Cutting Diam +.0000/- .0035
Shank Diam +.0000/- .0003

The Ultra-Tool® Rougher Series 395 is a true roughing end mill featuring sinusoidal geometry & radial relief for optimal strength. Designed & engineered for maximum stock removal at very high operating speeds, the 395 is specifically targeted for medium to high tensile steels, stainless, and related high-temperature alloys. Weldon flat and 45° corner chamfer are standard. Coated price includes your choice of TiCN, TiN, AlTiN, or TiAlN.

ULTRA-Grain®

SFR Ultra-Tool 395 Specs (Metric):
Cutting Diam +0.000/-0.089mm
Shank Diam +0.000/-0.007mm

Diam	LOC	OAL	Shank	EDP#	Price	Coated Price
6.0mm	19	50	6.0	39791	\$37.30	\$43.90
8.0mm	20	63	8.0	39792	\$50.10	\$58.10
10.0mm	22	70	10.0	39793	\$74.50	\$85.60
12.0mm	25	76	12.0	39794	\$100.70	\$112.20
16.0mm	38	89	16.0	39795	\$172.30	\$190.10
20.0mm	38	101	20.0	39796	\$270.80	\$294.80
25.0mm	50	101	25.0	39797	\$420.80	\$450.80

Diam	LOC	OAL	Shank	EDP#	Price	Coated Price
1/4	3/8	2"	1/4	39780	\$33.30	\$38.70
1/4	3/4	2-1/2	1/4	39703	\$37.30	\$43.90
5/16	7/16	2-1/2	5/16	39781	\$42.90	\$50.90
5/16	13/16	2-1/2	5/16	39704	\$50.10	\$58.10
3/8	1/2	2-1/2	3/8	39782	\$51.60	\$60.10
3/8	1"	2-1/2	3/8	39705	\$58.10	\$66.70
1/2	5/8	2-1/2	1/2	39783	\$82.80	\$94.20
1/2	1"	3"	1/2	39706	\$100.70	\$112.20
1/2	2"	4"	1/2	39784	\$156.30	\$171.80
5/8	3/4	3-1/2	5/8	39785	\$139.40	\$157.20
5/8	1-1/2	3-1/2	5/8	39707	\$172.30	\$190.10
5/8	2-1/2	5"	5/8	39786	\$271.90	\$299.70
3/4	7/8	4"	3/4	39787	\$188.40	\$209.30
3/4	1-1/2	4"	3/4	39708	\$236.40	\$257.30
3/4	2-1/2	5"	3/4	39788	\$368.70	\$401.00
1"	1-1/4	4"	1"	39709	\$312.60	\$342.60
1"	2"	4"	1"	39789	\$420.80	\$450.80
1"	3-1/4	6"	1"	39790	\$492.90	\$535.20

N/C Tolerance Solid Carbide End Mills by ULTRATOOL®

Series 170 Square End • 170B Ball End
Two Flute • N/C Tolerance +.001 / -.000
Tight Tolerance • Standard Length



ULTRA-Grain®

Series 180 Square End • 180B Ball End
Four Flute • N/C Tolerance +.001 / -.000
Tight Tolerance • Standard Length



SFR Ultra-Tool N/C Specs:
Cutting Diam +.001/- .000
Shank Diam +.0000/- .0003

Diam	LOC	OAL	Shank	170 EDP#	170B EDP#	180 EDP#	180B EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/32	3/32	1-1/2	1/8	17002	17102	18002	18102	\$21.50	\$24.30	\$26.90	\$29.80
3/64	3/16	1-1/2	1/8	17003	17103	18003	18103	\$21.50	\$24.30	\$26.90	\$29.80
1/16	3/16	1-1/2	1/8	17004	17104	18004	18104	\$17.20	\$20.00	\$20.60	\$23.40
5/64	1/4	1-1/2	1/8	17005	17105	18005	18105	\$17.20	\$20.00	\$20.60	\$23.40
3/32	3/8	1-1/2	1/8	17006	17106	18006	18106	\$16.20	\$19.10	\$19.50	\$22.30
1/8	1/2	1-1/2	1/8	17008	17108	18008	18108	\$15.80	\$18.60	\$18.90	\$21.70
5/32	9/16	2"	3/16	17010	17110	18010	18110	\$24.70	\$28.10	\$29.60	\$33.00
3/16	5/8	2"	3/16	17012	17112	18012	18112	\$21.00	\$24.40	\$25.20	\$28.70
7/32	5/8	2-1/2	1/4	17014	17114	18014	18114	\$27.70	\$34.30	\$33.20	\$39.80
1/4	3/4	2-1/2	1/4	17016	17116	18016	18116	\$24.10	\$30.70	\$29.00	\$35.50
9/32	3/4	2-1/2	5/16	17018	17118	18018	18118	\$39.50	\$47.60	\$47.40	\$55.40
5/16	13/16	2-1/2	5/16	17020	17120	18020	18120	\$34.50	\$42.50	\$41.40	\$49.40
3/8	1"	2-1/2	3/8	17024	17124	18024	18124	\$44.20	\$52.80	\$53.10	\$61.70
7/16	1"	2-3/4	7/16	17028	17128	18028	18128	\$63.60	\$74.70	\$75.00	\$86.20
1/2	1"	3"	1/2	17032	17132	18032	18132	\$71.00	\$82.50	\$85.20	\$96.70
9/16	1-1/4	3-1/2	9/16	17034	17134	18034	18134	\$124.50	\$140.90	\$149.40	\$165.80
5/8	1-1/2	3-1/2	5/8	17036	17136	18036	18136	\$126.10	\$143.80	\$151.30	\$169.10
3/4	1-1/2	4"	3/4	17040	17140	18040	18140	\$188.90	\$209.80	\$226.70	\$247.60
1"	1-1/2	4"	1"	17048	17148	18048	18148	\$320.60	\$350.60	\$384.70	\$414.80

ULTRATOOL Solid Carbide Chamfer Mills

Series 330CH
Two Flute Chamfer Mill
60° and 90° Included Angles



Series 320CH
Four Flute Chamfer Mill
60° and 90° Included Angles



Diam	OAL	60° EDP#	90° EDP#	Price	Coated Price
new! 1/8	1-1/2	39259	39289	\$12.00	\$14.80
3/16	2"	39260	39290	\$20.00	\$23.50
1/4	2-1/2	39261	39291	\$24.90	\$31.50
5/16	2-1/2	39264	39294	\$31.50	\$39.50
3/8	2-1/2	39262	39292	\$33.80	\$42.40
1/2	3"	39263	39293	\$56.70	\$68.20
3.0mm	38	39265	39295	\$12.00	\$14.80
4.0mm	50	39266	39296	\$19.00	\$22.50
6.0mm	50	39267	39297	\$23.50	\$29.00
8.0mm	63	39268	39298	\$31.50	\$39.50
10.0mm	70	39269	39299	\$42.50	\$53.70
12.0mm	74	39270	39300	\$56.70	\$68.20

Diam	OAL	60° EDP#	90° EDP#	Price	Coated Price
new! 1/8	1-1/2	39459	39489	\$12.00	\$14.80
3/16	2"	39460	39490	\$20.00	\$23.50
1/4	2-1/2	39461	39491	\$24.90	\$31.50
5/16	2-1/2	39464	39494	\$31.50	\$39.50
3/8	2-1/2	39462	39492	\$33.80	\$42.40
1/2	3"	39463	39493	\$56.70	\$68.20
3.0mm	38	39465	39495	\$12.00	\$14.80
4.0mm	50	39466	39496	\$19.00	\$22.50
6.0mm	50	39467	39497	\$23.50	\$29.00
8.0mm	63	39468	39498	\$31.50	\$39.50
10.0mm	70	39469	39499	\$42.50	\$53.70
12.0mm	74	39470	39500	\$56.70	\$68.20

Multi-Pack Solid Carbide End Mills by ULTRATOOL

Series 330MP • 330BMP
Multi-Pack of 50 End Mills
Square or Ball • Two Flutes



Series 362MP • 362BMP
Multi-Pack of 50 End Mills
Square or Ball • Three Flutes



Series 320MP • 320BMP
Multi-Pack of 50 End Mills
Square or Ball • Four Flutes



Ultra's multi-packs are packaged in a patented case with a lock-down shank mechanism. Each Multi-Pack contains 50 identical tools from Series 330, 362, or 320 and includes either square or ball ends.



Diam	LOC	OAL	Shank	330MP EDP#	330BMP EDP#	362MP EDP#	362BMP EDP#	320MP EDP#	320BMP EDP#	Square Price	Coated Square	Ball Price	Coated Ball
1/64	3/64	1-1/2	1/8	34200	34300	34220	34320	34240	34340	\$716.10	\$856.40	\$895.30	\$1035.50
0.5mm	1.5	38	3.0	34201	34301	34221	34321	34241	34341	\$716.10	\$856.40	\$895.30	\$1035.50
1/32	3/32	1-1/2	1/8	34202	34302	34222	34322	34242	34342	\$555.30	\$695.50	\$694.10	\$834.30
1.0mm	3.0	38	3.0	34203	34303	34223	34323	34243	34343	\$555.30	\$695.50	\$694.10	\$834.30
3/64	3/16	1-1/2	1/8	34204	34304	34224	34324	34244	34344	\$555.30	\$695.50	\$694.10	\$834.30
1.5mm	4.5	38	3.0	34205	34305	34225	34325	34245	34345	\$515.20	\$655.40	\$644.00	\$784.20
1/16	3/16	1-1/2	1/8	34206	34306	34226	34326	34246	34346	\$515.20	\$655.40	\$644.00	\$784.20
5/64	1/4	1-1/2	1/8	34207	34307	34227	34327	34247	34347	\$515.20	\$655.40	\$644.00	\$784.20
2.0mm	6.3	38	3.0	34208	34308	34228	34328	34248	34348	\$515.20	\$655.40	\$644.00	\$784.20
3/32	3/8	1-1/2	1/8	34209	34309	34229	34329	34249	34349	\$502.30	\$642.60	\$628.00	\$768.20
2.5mm	9.5	38	3.0	34210	34310	34230	34330	34250	34350	\$502.30	\$642.60	\$628.00	\$768.20
7/64	1/2	1-1/2	1/8	34211	34311	34231	34331	34251	34351	\$502.30	\$642.60	\$628.00	\$768.20
3.0mm	12.0	38	3.0	34212	34312	34232	34332	34252	34352	\$452.20	\$592.50	\$565.30	\$705.50
1/8	1/2	1-1/2	1/8	34213	34313	34233	34333	34253	34353	\$452.20	\$592.50	\$565.30	\$705.50

ULTRATOOL® Monolith™ Series End Mills for Aluminum

The three Series of Monolith end mills by Ultra-Tool represent a culmination of decades of experience and craftsmanship in solid carbide grinding. Extended reach applications are notoriously difficult, but each respective Monolith Series combines the best of SmoothGrind, SmoothConcricity, SmoothEdge and SmoothCoat to maximize success rates. The 330ML and 333ML hold size and concentricity to a maximum of .0003 deviation, even at a 12" reach!

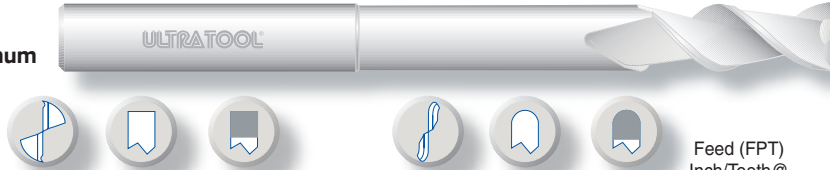
new!

Series 330ML

Solid Carbide Ext. Reach End Mill for Aluminum

2 Flutes • Tight Tolerance • Minimal TIR

Available in Square or Ball End
Standard Clearance Neck



Diam	LOC	LOR	OAL	Neck	Shank
3/8	1/2	2-1/8	4"	.355	3/8
3/8	1/2	3-3/8	6"	.355	3/8
1/2	5/8	2-1/4	4"	.475	1/2
1/2	5/8	3-3/8	6"	.475	1/2
1/2	5/8	4-1/2	8"	.475	1/2
5/8	3/4	2-3/8	4"	.593	5/8
5/8	3/4	3-3/8	6"	.593	5/8
5/8	3/4	4-1/2	8"	.593	5/8
3/4	1"	3-3/8	6"	.712	3/4
3/4	1"	4-1/2	8"	.712	3/4
3/4	1"	7"	12"	.712	3/4
1"	1-1/4	3-3/8	6"	.950	1"
1"	1-1/4	4-1/2	8"	.950	1"
1"	1-1/4	7"	12"	.950	1"
1-1/4	1-1/2	3-3/8	6"	1.20	1-1/4
1-1/4	1-1/2	4-1/2	8"	1.20	1-1/4
1-1/4	1-1/2	7"	12"	1.20	1-1/4
1-1/2	2"	3-3/8	6"	1.25	1-1/4
1-1/2	2"	4-1/2	8"	1.25	1-1/4
1-1/2	2"	7"	12"	1.25	1-1/4

Square EDP#	Square Price	A1 Coated
11900	\$72.50	\$89.50
11901	\$94.50	\$121.50
11902	\$110.00	\$133.00
11903	\$147.50	\$180.50
11904	\$185.00	\$237.00
11905	\$165.00	\$192.00
11906	\$220.00	\$262.00
11907	\$285.00	\$347.00
11908	\$310.00	\$360.00
11909	\$400.00	\$470.00
11910	\$560.00	\$650.00
11911	\$490.00	\$550.00
11912	\$632.50	\$722.50
11913	\$890.00	\$1010.00
11914	\$660.00	\$740.00
11915	\$855.00	\$965.00
11916	\$1210.00	\$1350.00
11917	\$790.00	\$890.00
11918	\$1020.00	\$1150.00
11919	\$1450.00	\$1610.00

Ball EDP#	Ball Price	A1 Coated
11920	\$87.00	\$104.00
11921	\$114.00	\$141.00
11922	\$132.00	\$155.00
11923	\$175.00	\$208.00
11924	\$220.00	\$272.00
11925	\$198.00	\$225.00
11926	\$264.00	\$306.00
11927	\$340.00	\$402.00
11928	\$372.00	\$422.00
11929	\$478.00	\$548.00
11930	\$668.00	\$758.00
11931	\$588.00	\$648.00
11932	\$755.00	\$845.00
11933	\$1060.00	\$1180.00
11934	\$790.00	\$870.00
11935	\$1020.00	\$1130.00
11936	\$1445.00	\$1585.00
11937	\$950.00	\$1050.00
11938	\$1230.00	\$1350.00
11939	\$1735.00	\$1895.00

Feed (FPT)
Inch/Tooth@
1200-1600
SFM



A1 coating includes SE3 for the Monolith Series. Watch the chips fly!



new!

Series 333ML

Solid Carbide Ext. Reach End Mill for Aluminum

3 Flutes • Tight Tolerance • Minimal TIR

Available in Square or Corner Radius End
Standard Clearance Neck



Diam	LOC	LOR	OAL	Neck	Shank
3/8	1/2	2-1/8	4"	.355	3/8
3/8	1/2	3-3/8	6"	.355	3/8
1/2	5/8	2-1/4	4"	.475	1/2
1/2	5/8	3-3/8	6"	.475	1/2
1/2	5/8	4-1/2	8"	.475	1/2
5/8	3/4	2-3/8	4"	.593	5/8
5/8	3/4	3-3/8	6"	.593	5/8
5/8	3/4	4-1/2	8"	.593	5/8
3/4	1"	3-3/8	6"	.712	3/4
3/4	1"	4-1/2	8"	.712	3/4
3/4	1"	7"	12"	.712	3/4
1"	1-1/4	3-3/8	6"	.950	1"
1"	1-1/4	4-1/2	8"	.950	1"
1"	1-1/4	7"	12"	.950	1"
1-1/4	1-1/2	3-3/8	6"	1.20	1-1/4
1-1/4	1-1/2	4-1/2	8"	1.20	1-1/4
1-1/4	1-1/2	7"	12"	1.20	1-1/4
1-1/2	2"	3-3/8	6"	1.25	1-1/4
1-1/2	2"	4-1/2	8"	1.25	1-1/4
1-1/2	2"	7"	12"	1.25	1-1/4

Square EDP#	Square Price	A1 Coated
11940	\$79.50	\$96.50
11941	\$104.00	\$131.00
11942	\$120.00	\$143.00
11943	\$162.50	\$195.50
11944	\$203.50	\$255.50
11945	\$181.50	\$208.50
11946	\$242.00	\$284.00
11947	\$312.50	\$374.50
11948	\$340.00	\$390.00
11949	\$440.00	\$510.00
11950	\$610.00	\$700.00
11951	\$540.00	\$600.00
11952	\$695.00	\$785.00
11953	\$980.00	\$1100.00
11954	\$725.00	\$805.00
11955	\$940.00	\$1030.00
11956	\$1320.00	\$1460.00
11957	\$870.00	\$970.00
11958	\$1120.00	\$1250.00
11959	\$1600.00	\$1760.00

Radius EDP#	Rad Price	A1 Coated
11960	\$79.50	\$96.50
11961	\$104.00	\$131.00
11962	\$120.00	\$143.00
11963	\$162.50	\$195.50
11964	\$203.50	\$255.50
11965	\$181.50	\$208.50
11966	\$242.00	\$284.00
11967	\$312.50	\$374.50
11968	\$340.00	\$390.00
11969	\$440.00	\$510.00
11970	\$610.00	\$700.00
11971	\$540.00	\$600.00
11972	\$695.00	\$785.00
11973	\$980.00	\$1100.00
11974	\$725.00	\$805.00
11975	\$940.00	\$1030.00
11976	\$1320.00	\$1460.00
11977	\$870.00	\$970.00
11978	\$1120.00	\$1250.00
11979	\$1600.00	\$1760.00

Feed (FPT)
Inch/Tooth@
1200-1600
SFM

- Incredible diameter tolerance for finishing work.
- Assure optimal conditions by maintaining large volume of coolant flow (note: A1 coating is superb for DRY machining in many applications).
- Minimal TIR / extra-long design to be utilized by best-in-class toolholding, fixturing, rigidity & accuracy of set-up.

SmoothCoat® A1 (TiB2) is specifically engineered for the AL Series, offering superb increases in lubricity and longevity while reducing chip weld and galling. We highly recommend using A1 coating for medium to long production runs. Environmentally, A1 allows for dry or low coolant use in many milling applications.



Monolith™ Series End Mill for Steels & Exotics

new!

Series 323ML

Solid Carbide Extended Reach End Mill for Steels & Exotics • 4 Flute • AT Coated
Tight Tolerance • Minimal TIR • Neck Corner Radius • Variable Helix
 This product is manufactured under
 U.S. Patent No. 7,284,935



Diam	LOC	LOR	OAL	Neck	Rad	Shank	EDP#	AT Coated
3/8	1/2	2-1/8	4"	.355	.020	3/8	23025	\$96.50
3/8	1/2	3-3/8	6"	.355	.020	3/8	23026	\$131.00
1/2	5/8	2-1/4	4"	.475	.030	1/2	23033	\$143.00
1/2	5/8	3-3/8	6"	.475	.030	1/2	23034	\$195.50
1/2	5/8	4-1/2	8"	.475	.030	1/2	23035	\$255.50
5/8	3/4	2-3/8	4"	.593	.030	5/8	23041	\$208.50
5/8	3/4	3-3/8	6"	.593	.030	5/8	23042	\$284.00
5/8	3/4	4-1/2	8"	.593	.030	5/8	23043	\$374.50
3/4	1"	3-3/8	6"	.712	.030	3/4	23049	\$390.00
3/4	1"	4-1/2	8"	.712	.030	3/4	23050	\$510.00

Diam	LOC	LOR	OAL	Neck	Rad	Shank	EDP#	AT Coated
3/4	1"	7"	12"	.712	.030	3/4	23051	\$700.00
1"	1-1/4	3-3/8	6"	.950	.030	1"	23065	\$600.00
1"	1-1/4	4-1/2	8"	.950	.030	1"	23066	\$785.00
1"	1-1/4	7"	12"	.950	.030	1"	23067	\$1100.00
1-1/4	1-1/2	3-3/8	6"	1.20	.030	1-1/4	23068	\$805.00
1-1/4	1-1/2	4-1/2	8"	1.20	.030	1-1/4	23069	\$1030.00
1-1/4	1-1/2	7"	12"	1.20	.030	1-1/4	23070	\$1460.00
1-1/2	2"	3-3/8	6"	1.25	.030	1-1/4	23071	\$970.00
1-1/2	2"	4-1/2	8"	1.25	.030	1-1/4	23072	\$1250.00
1-1/2	2"	7"	12"	1.25	.030	1-1/4	23073	\$1760.00

ULTRA TOOL® Corner Rounding End Mills

Series 235

Carbide Radius Mills

Single End • 4 Straight Flutes • RH Cutting



Series 233

Solid Carbide Radius Mills

Double-Ended • 3 Straight Flutes • RH Cutting



Radius Mill Specifications:
 Radius ±.0005
 Pilot Diameter ±.0005



Radius Mill Specifications:
 Radius ±.0005
 Pilot Diameter ±.0005



Radius Decimal	Radius Fract	Pilot Diam	Body Diam	Shank Diam	OAL	EDP#	Price	Coated Price
.0312	1/32	1/8	3/16	3/16	2"	23500	\$43.00	\$46.40
.0625	1/16	1/8	1/4	1/4	2-1/2	23501	\$51.40	\$57.90
.0938	3/32	3/16	3/8	3/8	2-1/2	23502	\$81.80	\$90.40
.125	1/8	1/4	1/2	1/2	3"	23503	\$117.00	\$128.40
.1562*	5/32	7/16	3/4	3/8	3"	23514	\$133.80	\$151.60
.1875*	3/16	3/8	3/4	3/8	3"	23504	\$133.80	\$151.60
.250*	1/4	1/2	1"	1/2	3"	23505	\$163.30	\$186.20
.3125*	5/16	3/8	1"	1/2	3"	23515	\$163.30	\$186.20
.375*	3/8	1/2	1-1/4	3/4	3"	23506	\$284.10	\$318.50

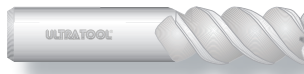
*Two-piece brazed construction; solid-carbide head w/steel shank.

Radius Dec	Radius Fract/Metric	Pilot Diam	Shank Diam	OAL	EDP#	Price	Coated Price
.010	-	.100	1/8	2"	23316	\$38.00	\$42.30
.0156	1/64	.090	1/8	2"	23317	\$38.00	\$42.30
.020	-	.080	1/8	2"	23318	\$38.00	\$42.30
.025	-	.070	1/8	2"	23319	\$38.00	\$42.30
.0312	1/32	.060	1/8	2"	23320	\$38.00	\$42.30
.035	-	.140	1/4	2-1/2	23321	\$53.00	\$63.00
.0394	1.0mm	.140	1/4	2-1/2	23322	\$53.00	\$63.00
.0469	3/64	.140	1/4	2-1/2	23323	\$53.00	\$63.00
.050	-	.140	1/4	2-1/2	23324	\$53.00	\$63.00
.055	-	.090	1/4	2-1/2	23325	\$53.00	\$63.00
.0591	1.5mm	.090	1/4	2-1/2	23326	\$53.00	\$63.00
.0625	1/16	.090	1/4	2-1/2	23327	\$53.00	\$63.00
.070	-	.090	1/4	2-1/2	23328	\$53.00	\$63.00
.075	-	.090	1/4	2-1/2	23329	\$53.00	\$63.00
.0781	5/64	.115	3/8	2-1/2	23330	\$88.00	\$100.90
.0787	2.0mm	.115	3/8	2-1/2	23331	\$88.00	\$100.90
.0938	3/32	.115	3/8	2-1/2	23332	\$88.00	\$100.90
.0984	2.5mm	.115	3/8	2-1/2	23333	\$88.00	\$100.90
.1094	7/64	.115	3/8	2-1/2	23334	\$88.00	\$100.90
.1181	3.0mm	.115	3/8	2-1/2	23335	\$88.00	\$100.90
.125	1/8	.115	3/8	2-1/2	23336	\$88.00	\$100.90
.1406	9/64	.120	1/2	3"	23337	\$138.00	\$155.20
.1562	5/32	.120	1/2	3"	23338	\$138.00	\$155.20
.1575	4.0mm	.120	1/2	3"	23339	\$138.00	\$155.20
.1718	11/64	.120	1/2	3"	23340	\$138.00	\$155.20
.1875	3/16	.120	1/2	3"	23341	\$138.00	\$155.20
.1969	5.0mm	.120	5/8	3-1/2	23342	\$158.00	\$184.60
.2031	13/64	.120	5/8	3-1/2	23343	\$158.00	\$184.60
.2188	7/32	.120	5/8	3-1/2	23344	\$158.00	\$184.60
.2344	15/64	.120	5/8	3-1/2	23345	\$158.00	\$184.60
.2362	6.0mm	.120	5/8	3-1/2	23346	\$158.00	\$184.60
.250	1/4	.120	5/8	3-1/2	23347	\$158.00	\$184.60
.2812	9/32	.120	3/4	4"	23348	\$210.50	\$242.00
.2969	19/64	.120	3/4	4"	23349	\$210.50	\$242.00
.3125	5/16	.120	3/4	4"	23350	\$210.50	\$242.00

ULTRA TOOL® 3-Flute High Helix End Mill

Series 320-60

3 Flutes • High 60 Degree Helix



Ultra-Tool End Mill Specs:
 Cutting Diam +.000/- .002
 Shank Diam +.0000/- .0003

The high-helix design is ideal for all peripheral milling applications. In light depths of cut this tool can be used for all materials from aluminum to exotic alloys. The 60° helix will provide an excellent surface finish and reduce cutting loads.

Diam	LOC	OAL	Shank	Flutes	EDP#	Price	Coated Price
1/8	1/2	1-1/2	1/8	3	31008	\$22.50	\$25.30
3/16	5/8	2"	3/16	3	31012	\$26.60	\$30.00
1/4	3/4	2-1/2	1/4	3	31016	\$34.70	\$41.30
5/16	13/16	2-1/2	5/16	3	31020	\$45.60	\$53.60
3/8	7/8	2-1/2	3/8	3	31024	\$56.10	\$64.70
1/2	1"	3"	1/2	3	31032	\$88.50	\$99.90
5/8	1-1/2	3-1/2	5/8	3	31036	\$175.10	\$192.90
3/4	1-1/2	4"	3/4	3	31040	\$245.00	\$265.90
1"	1-1/2	4"	1"	3	31048	\$405.00	\$435.10



Twist Drills by ULTRATOOL



Series 510 • Fractional
Jobbers Length • 25° Helix
118° Four-Facet Point



Diam	LOF	OAL	EDP#	Price	Coated Price
1/64	1/4	1-1/4	51001	\$17.90	\$21.80
1/32	5/16	1-1/4	51002	\$11.00	\$14.00
3/64	3/4	1-1/2	51003	\$11.00	\$14.00
1/16	3/4	1-1/2	51004	\$11.30	\$14.30
5/64	7/8	1-3/4	51005	\$11.60	\$14.80
3/32	1"	2"	51006	\$12.00	\$15.20
7/64	1-1/4	2-1/4	51007	\$13.40	\$17.40
1/8	1-1/4	2-1/4	51008	\$13.80	\$17.80
9/64	1-3/8	2-1/2	51009	\$15.80	\$20.70
5/32	1-3/8	2-1/2	51010	\$18.40	\$23.20
11/64	1-5/8	2-3/4	51011	\$20.40	\$25.30
3/16	1-5/8	2-3/4	51012	\$20.70	\$25.50
13/64	1-3/4	3"	51013	\$24.70	\$31.20
7/32	1-3/4	3"	51014	\$27.30	\$33.90
15/64	2"	3-1/4	51015	\$29.50	\$37.80
1/4	2"	3-1/4	51016	\$31.50	\$39.80
17/64	2-1/8	3-1/2	51017	\$36.20	\$46.50
9/32	2-1/8	3-1/2	51018	\$39.70	\$50.00
19/64	2-3/8	3-3/4	51019	\$42.30	\$52.70
5/16	2-3/8	3-3/4	51020	\$45.60	\$55.90
21/64	2-1/2	4"	51021	\$49.20	\$60.40
11/32	2-1/2	4"	51022	\$54.30	\$65.40
23/64	2-3/4	4-1/4	51023	\$60.40	\$77.60
3/8	2-3/4	4-1/4	51024	\$59.60	\$76.70
25/64	2-7/8	4-1/2	51025	\$75.00	\$94.80
13/32	2-7/8	4-1/2	51026	\$80.60	\$100.30
27/64	2-7/8	4-1/2	51027	\$88.80	\$108.50
7/16	2-7/8	4-1/2	51028	\$94.90	\$115.80
29/64	3"	4-3/4	51029	\$104.20	\$126.50
15/32	3"	4-3/4	51030	\$110.20	\$132.50
31/64	3"	4-3/4	51031	\$115.10	\$137.40
1/2	3"	4-3/4	51032	\$109.90	\$132.30
17/32	4"	6"	51033	\$182.90	\$207.80
9/16	4"	6"	51034	\$196.40	\$221.30
19/32	4"	6"	51035	\$225.60	\$253.40
5/8	4"	6"	51036	\$228.20	\$255.90
21/32	4"	6"	51037	\$258.20	\$290.50
11/16	4"	6"	51038	\$262.50	\$294.80
3/4	4"	6"	51039	\$306.30	\$338.60
13/16	4"	6"	51181	\$418.50	\$455.70
7/8	4"	6"	51182	\$443.70	\$480.90
15/16	4"	6"	51183	\$448.80	\$486.00
1"	4"	6"	51184	\$412.20	\$454.50

Series 510 • Wire Gage

Diam	LOF	OAL	EDP#	Price	Coated Price
1	1-3/4	3-1/4	51101	\$29.80	\$38.10
2	1-3/4	3"	51102	\$28.40	\$35.00
3	1-3/4	3"	51103	\$26.70	\$33.20
4	1-3/4	3"	51104	\$26.00	\$32.60
5	1-3/4	3"	51105	\$25.30	\$31.90
6	1-3/4	3"	51106	\$25.10	\$31.60
7	1-3/4	3"	51107	\$24.00	\$30.60
8	1-3/4	3"	51108	\$23.70	\$30.30
9	1-3/4	3"	51109	\$23.00	\$29.60
10	1-5/8	2-3/4	51110	\$22.50	\$29.10
11	1-5/8	2-3/4	51111	\$22.30	\$28.90
12	1-5/8	2-3/4	51112	\$22.00	\$28.50
13	1-5/8	2-3/4	51113	\$21.50	\$26.40

14	1-5/8	2-3/4	51114	\$21.30	\$26.20
15	1-5/8	2-3/4	51115	\$21.20	\$26.10
16	1-5/8	2-3/4	51116	\$20.90	\$25.10
17	1-5/8	2-3/4	51117	\$20.60	\$25.50
18	1-5/8	2-3/4	51118	\$20.10	\$24.90
19	1-5/8	2-3/4	51119	\$20.00	\$24.80
20	1-3/8	2-1/2	51120	\$19.30	\$24.10
21	1-3/8	2-1/2	51121	\$19.10	\$24.00
22	1-3/8	2-1/2	51122	\$18.90	\$23.70
23	1-3/8	2-1/2	51123	\$18.10	\$23.00
24	1-3/8	2-1/2	51124	\$17.40	\$22.30
25	1-3/8	2-1/2	51125	\$16.80	\$21.70
26	1-3/8	2-1/2	51126	\$16.50	\$21.30
27	1-3/8	2-1/2	51127	\$16.50	\$21.30
28	1-3/8	2-1/2	51128	\$15.80	\$20.70
29	1-3/8	2-1/2	51129	\$15.60	\$20.40
30	1-3/8	2-1/4	51130	\$14.90	\$19.80
31	1-1/4	2-1/4	51131	\$14.70	\$18.70
32	1-1/4	2-1/4	51132	\$14.40	\$18.40
33	1-1/4	2-1/4	51133	\$14.00	\$18.00
34	1-1/4	2-1/4	51134	\$14.00	\$18.00
35	1-1/4	2-1/4	51135	\$13.60	\$17.60
36	1-1/4	2-1/4	51136	\$13.40	\$17.40
37	1-1/4	2-1/4	51137	\$13.40	\$17.40
38	1-1/4	2-1/4	51138	\$13.40	\$17.40
39	1-1/4	2-1/4	51139	\$13.40	\$17.40
40	1"	2"	51140	\$12.60	\$15.80
41	1"	2"	51141	\$12.00	\$15.20
42	1"	2"	51142	\$12.00	\$15.20
43	1"	2"	51143	\$11.60	\$14.80
44	1"	2"	51144	\$11.60	\$14.80
45	7/8	1-3/4	51145	\$11.60	\$14.80
46	7/8	1-3/4	51146	\$11.60	\$14.80
47	7/8	1-3/4	51147	\$11.60	\$14.80
48	7/8	1-3/4	51148	\$11.30	\$14.50
49	7/8	1-3/4	51149	\$11.30	\$14.50
50	7/8	1-3/4	51150	\$11.30	\$14.50
51	3/4	1-1/2	51151	\$11.30	\$14.50
52	3/4	1-1/2	51152	\$11.30	\$14.50
53	3/4	1-1/2	51153	\$11.10	\$14.10
54	3/4	1-1/2	51154	\$11.10	\$14.10
55	3/4	1-1/2	51155	\$11.00	\$14.00
56	3/4	1-1/2	51156	\$11.00	\$14.00
57	3/4	1-1/2	51157	\$11.00	\$14.00
58	3/4	1-1/2	51158	\$11.00	\$14.00
59	3/4	1-1/2	51159	\$11.00	\$14.00
60	3/4	1-1/2	51160	\$11.00	\$14.00
61	5/8	1-1/2	51161	\$11.50	\$14.50
62	5/8	1-1/2	51162	\$11.80	\$14.80
63	5/8	1-1/2	51163	\$11.80	\$14.80
64	5/8	1-1/2	51164	\$11.80	\$14.80
65	5/8	1-1/2	51165	\$12.10	\$15.10
66	5/16	1-1/4	51166	\$12.10	\$15.10
67	5/16	1-1/4	51167	\$12.10	\$15.10
68	5/16	1-1/4	51168	\$12.10	\$15.10
69	5/16	1-1/4	51169	\$12.60	\$15.60
70	5/16	1-1/4	51170	\$16.10	\$20.10
71	5/16	1-1/4	51171	\$16.60	\$20.60
72	5/16	1-1/4	51172	\$16.60	\$20.60
73	1/4	1-1/4	51173	\$17.30	\$21.30
74	1/4	1-1/4	51174	\$17.30	\$21.30
75	1/4	1-1/4	51175	\$17.30	\$21.30
76	1/4	1-1/4	51176	\$17.30	\$21.30
77	1/4	1-1/4	51177	\$17.30	\$21.30
78	1/4	1-1/4	51178	\$17.90	\$21.90
79	1/4	1-1/4	51179	\$17.90	\$21.90
80	1/4	1-1/4	51180	\$17.90	\$21.90

Series 510 • Letter Sizes

Diam	LOF	OAL	EDP#	Price	Coated Price
A	2"	3-1/4	51041	\$30.70	\$39.00
B	2"	3-1/4	51042	\$31.20	\$39.50
C	2"	3-1/4	51043	\$31.90	\$40.20
D	2"	3-1/4	51044	\$32.60	\$40.90
E	2"	3-1/4	51045	\$33.80	\$42.10
F	2"	3-1/2	51046	\$36.20	\$46.50
G	2-1/8	3-1/2	51047	\$36.20	\$46.50
H	2-1/8	3-1/2	51048	\$37.60	\$47.90
I	2-1/8	3-1/2	51049	\$38.40	\$48.70
J	2-1/8	3-1/2	51050	\$39.50	\$49.80
K	2-1/8	3-1/2	51051	\$39.70	\$50.00
L	2-1/8	3-1/2	51052	\$41.10	\$51.40
M	2-3/8	3-3/4	51053	\$42.30	\$52.70
N	2-3/8	3-3/4	51054	\$45.60	\$55.90
O	2-3/8	3-3/4	51055	\$48.30	\$59.50
P	2-3/8	4"	51056	\$49.20	\$60.40
Q	2-1/2	4"	51085	\$53.10	\$64.20
R	2-1/2	4"	51086	\$54.30	\$65.40
S	2-1/2	4"	51087	\$57.30	\$68.50
T	2-3/4	4-1/4	51088	\$60.40	\$77.60
U	2-3/4	4-1/4	51089	\$63.50	\$80.60
V	2-3/4	4-1/4	51090	\$67.10	\$86.80
W	2-7/8	4-1/2	51057	\$67.10	\$86.80
X	2-7/8	4-1/2	51058	\$78.70	\$98.40
Y	2-7/8	4-1/2	51059	\$78.70	\$98.40
Z	2-7/8	4-1/2	51060	\$87.60	\$107.40

Series 510 • Metric

Diam	LOF	OAL	EDP#	Price	Coated Price
1.0mm	13	38	51061	\$11.50	\$14.50
1.5mm	19	38	51062	\$11.10	\$14.10
2.0mm	22	44	51063	\$11.60	\$14.60
2.5mm	25	50	51064	\$12.60	\$15.60
3.0mm	32	57	51065	\$14.40	\$18.40
3.5mm	35	63	51066	\$15.80	\$20.70
4.0mm	35	63	51067	\$18.90	\$23.70
4.5mm	41	70	51068	\$20.90	\$25.70
5.0mm	44	76	51069	\$23.30	\$29.90
5.5mm	44	76	51070	\$26.70	\$33.20
6.0mm	50	82	51071	\$30.60	\$38.90
6.5mm	50	82	51072	\$36.10	\$46.40
7.0mm	54	89	51073	\$39.30	\$49.60
7.5mm	60	95	51074	\$42.30	\$52.70
8.0mm	60	95	51075	\$48.30	\$59.50
8.5mm	63	101	51076	\$53.10	\$64.10
9.0mm	70	108	51077	\$57.30	\$74.50
9.5mm	70	108	51078	\$63.50	\$80.60
10.0mm	73	114	51079	\$75.00	\$94.80
10.5mm	73	114	51080	\$87.60	\$107.40
11.0mm	73	114	51081	\$88.80	\$108.50
11.5mm	76	120	51082	\$104.20	\$126.50
12.0mm	76	120	51083	\$115.10	\$137.40
12.5mm	76	120	51084	\$117.40	\$139.70

Series 700 • Drill Sets
Series 510 Drills In Metal Indexes

Set	EDP#	Price
#1	51185	\$192.90
6 Tools • 1/16, 1/8, 3/16, 1/4, 5/16, 3/8		
#2	51186	\$590.20
21 Tools • 1/16 to 3/8 by 1/64ths		
#3	51187	\$901.60
60 Tools • #1 to #60		
#4	51188	\$678.50
15 Tools • 1/16 to 1/2 by 1/32nds		

ULTRATOOL Brad Point Drills

Series 510BR • Wire Gage

Series 510BR • Letter Sizes

new!

Series 510BR • Fractional

Jobsbers Length • 25° Helix w/Brad Point for wood, plastics, composites, fiberglass



Diam	LOF	OAL	EDP#	Price	D1 Coated
3/64	3/4	1-1/2	51203	\$15.40	\$24.90
1/16	3/4	1-1/2	51204	\$15.90	\$25.40
5/64	7/8	1-3/4	51205	\$16.30	\$25.80
3/32	1"	2"	51206	\$16.80	\$26.30
7/64	1-1/4	2-1/4	51207	\$18.80	\$29.80
1/8	1-1/4	2-1/4	51208	\$19.40	\$30.40
9/64	1-3/8	2-1/2	51209	\$22.20	\$34.20
5/32	1-3/8	2-1/2	51210	\$25.80	\$37.80
11/64	1-5/8	2-3/4	51211	\$28.60	\$40.60
3/16	1-5/8	2-3/4	51212	\$29.00	\$41.00
13/64	1-3/4	3"	51213	\$34.60	\$51.70
7/32	1-3/4	3"	51214	\$38.30	\$55.40
15/64	2"	3-1/4	51215	\$41.30	\$58.40
1/4	2"	3-1/4	51216	\$44.10	\$61.20
17/64	2-1/8	3-1/2	51217	\$50.70	\$68.80
9/32	2-1/8	3-1/2	51218	\$55.60	\$73.70
19/64	2-3/8	3-3/4	51219	\$59.30	\$78.40
5/16	2-3/8	3-3/4	51220	\$63.90	\$82.00
21/64	2-1/2	4"	51221	\$68.90	\$93.00
11/32	2-1/2	4"	51222	\$76.10	\$100.20
23/64	2-3/4	4-1/4	51223	\$84.60	\$108.70
3/8	2-3/4	4-1/4	51224	\$83.50	\$107.60
25/64	2-7/8	4-1/2	51225	\$105.00	\$135.10
13/32	2-7/8	4-1/2	51226	\$112.90	\$143.00
27/64	2-7/8	4-1/2	51227	\$124.40	\$154.50
7/16	2-7/8	4-1/2	51228	\$132.90	\$163.00
29/64	3"	4-3/4	51229	\$145.90	\$186.00
15/32	3"	4-3/4	51230	\$154.30	\$194.40
31/64	3"	4-3/4	51231	\$161.20	\$201.30
1/2	3"	4-3/4	51232	\$153.90	\$194.00
17/32	4"	6"	51233	\$238.00	\$293.10
9/16	4"	6"	51234	\$255.40	\$310.50
19/32	4"	6"	51235	\$293.30	\$348.40
5/8	4"	6"	51236	\$296.70	\$351.80
21/32	4"	6"	51237	\$335.70	\$405.80
11/16	4"	6"	51238	\$341.30	\$411.40
3/4	4"	6"	51239	\$398.20	\$468.30
13/16	4"	6"	51291	\$544.10	\$624.20
7/8	4"	6"	51292	\$576.90	\$657.00
15/16	4"	6"	51293	\$583.50	\$673.60
1"	4"	6"	51294	\$577.10	\$667.20

Ultra's D1 PVD Diamond coating is the perfect compliment for drilling abrasive and soft materials with our special brad style point. The smoothness of our sputter based process helps evacuate the material up and out of the hole with superb lubricity. The hardness of D1's multi-layered surface lends outstanding wear characteristics when making holes in the types of material for which the brad point is designed. Add D1 as a suffix to the EDP #.



Diam	LOF	OAL	EDP#	Price	D1 Coated
1	1-3/4	3-1/4	51301	\$41.80	\$58.90
2	1-3/4	3"	51302	\$39.80	\$56.90
3	1-3/4	3"	51303	\$37.40	\$54.50
4	1-3/4	3"	51304	\$36.40	\$53.50
5	1-3/4	3"	51305	\$35.50	\$52.60
6	1-3/4	3"	51306	\$35.20	\$52.30
7	1-3/4	3"	51307	\$33.60	\$50.70
8	1-3/4	3"	51308	\$33.20	\$50.30
9	1-3/4	3"	51309	\$32.20	\$49.30
10	1-5/8	2-3/4	51310	\$31.50	\$48.60
11	1-5/8	2-3/4	51311	\$31.30	\$48.40
12	1-5/8	2-3/4	51312	\$30.80	\$47.90
13	1-5/8	2-3/4	51313	\$30.10	\$46.20
14	1-5/8	2-3/4	51314	\$29.90	\$46.00
15	1-5/8	2-3/4	51315	\$29.70	\$45.80
16	1-5/8	2-3/4	51316	\$29.30	\$45.40
17	1-5/8	2-3/4	51317	\$28.90	\$45.00
18	1-5/8	2-3/4	51318	\$28.20	\$44.30
19	1-5/8	2-3/4	51319	\$28.00	\$44.10
20	1-3/8	2-1/2	51320	\$27.10	\$43.20
21	1-3/8	2-1/2	51321	\$26.80	\$42.90
22	1-3/8	2-1/2	51322	\$26.50	\$42.60
23	1-3/8	2-1/2	51323	\$25.40	\$41.50
24	1-3/8	2-1/2	51324	\$24.40	\$40.50
25	1-3/8	2-1/2	51325	\$23.60	\$39.70
26	1-3/8	2-1/2	51326	\$23.10	\$39.20
27	1-3/8	2-1/2	51327	\$23.10	\$39.20
28	1-3/8	2-1/2	51328	\$22.20	\$38.30
29	1-3/8	2-1/2	51329	\$21.90	\$38.00
30	1-3/8	2-1/4	51330	\$20.90	\$37.00
31	1-1/4	2-1/4	51331	\$20.60	\$32.70
32	1-1/4	2-1/4	51332	\$20.20	\$32.30
33	1-1/4	2-1/4	51333	\$19.60	\$31.70
34	1-1/4	2-1/4	51334	\$19.60	\$31.70
35	1-1/4	2-1/4	51335	\$19.10	\$31.20
36	1-1/4	2-1/4	51336	\$18.80	\$30.90
37	1-1/4	2-1/4	51337	\$18.80	\$30.90
38	1-1/4	2-1/4	51338	\$18.80	\$30.90
39	1-1/4	2-1/4	51339	\$18.80	\$30.90
40	1"	2"	51340	\$17.70	\$27.20
41	1"	2"	51341	\$16.80	\$26.30
42	1"	2"	51342	\$16.80	\$26.30
43	1"	2"	51343	\$16.30	\$25.80
44	1"	2"	51344	\$16.30	\$25.80
45	7/8	1-3/4	51345	\$16.30	\$25.80
46	7/8	1-3/4	51346	\$16.30	\$25.80
47	7/8	1-3/4	51347	\$16.30	\$25.80
48	7/8	1-3/4	51348	\$15.90	\$25.40
49	7/8	1-3/4	51349	\$15.90	\$25.40
50	7/8	1-3/4	51350	\$15.90	\$25.40
51	3/4	1-1/2	51351	\$15.90	\$25.40
52	3/4	1-1/2	51352	\$15.90	\$25.40
53	3/4	1-1/2	51353	\$15.60	\$25.10
54	3/4	1-1/2	51354	\$15.60	\$25.10
55	3/4	1-1/2	51355	\$15.40	\$24.90
56	3/4	1-1/2	51356	\$15.40	\$24.90
57	3/4	1-1/2	51357	\$15.40	\$24.90
58	3/4	1-1/2	51358	\$15.40	\$24.90
59	3/4	1-1/2	51359	\$15.40	\$24.90
60	3/4	1-1/2	51360	\$15.40	\$24.90

Diam	LOF	OAL	EDP#	Price	D1 Coated
A	2"	3-1/4	51241	\$43.00	\$60.10
B	2"	3-1/4	51242	\$43.70	\$60.80
C	2"	3-1/4	51243	\$44.70	\$61.80
D	2"	3-1/4	51244	\$45.70	\$62.80
E	2"	3-1/4	51245	\$47.40	\$64.50
F	2"	3-1/2	51246	\$50.70	\$68.80
G	2-1/8	3-1/2	51247	\$50.70	\$68.80
H	2-1/8	3-1/2	51248	\$52.70	\$70.80
I	2-1/8	3-1/2	51249	\$53.80	\$71.90
J	2-1/8	3-1/2	51250	\$55.30	\$73.40
K	2-1/8	3-1/2	51251	\$55.60	\$73.70
L	2-1/8	3-1/2	51252	\$57.60	\$75.70
M	2-3/8	3-3/4	51253	\$59.30	\$77.40
N	2-3/8	3-3/4	51254	\$63.90	\$82.00
O	2-3/8	3-3/4	51255	\$67.70	\$91.80
P	2-3/8	4"	51256	\$68.90	\$93.00
Q	2-1/2	4"	51285	\$74.40	\$98.50
R	2-1/2	4"	51286	\$76.10	\$100.20
S	2-1/2	4"	51287	\$80.30	\$104.40
T	2-3/4	4-1/4	51288	\$84.60	\$108.70
U	2-3/4	4-1/4	51289	\$88.90	\$113.00
V	2-3/4	4-1/4	51290	\$94.00	\$124.10
W	2-7/8	4-1/2	51257	\$94.00	\$124.10
X	2-7/8	4-1/2	51258	\$110.20	\$140.30
Y	2-7/8	4-1/2	51259	\$110.20	\$140.30
Z	2-7/8	4-1/2	51260	\$122.70	\$152.80

Series 510BR • Metric

Drill Specifications (mm):
Diameter +0.000/-0.008mm
Point Angle $\pm 1^\circ$



Diam	LOF	OAL	EDP#	Price	D1 Coated
1.0mm	13	38	51261	\$16.10	\$25.60
1.5mm	19	38	51262	\$15.60	\$25.10
2.0mm	22	44	51263	\$16.30	\$25.80
2.5mm	25	50	51264	\$17.70	\$27.20
3.0mm	32	57	51265	\$20.20	\$31.20
3.5mm	35	63	51266	\$22.20	\$34.20
4.0mm	35	63	51267	\$26.50	\$42.60
4.5mm	41	70	51268	\$29.30	\$45.40
5.0mm	44	76	51269	\$32.70	\$49.80
5.5mm	44	76	51270	\$37.40	\$54.50
6.0mm	50	82	51271	\$42.90	\$60.00
6.5mm	50	82	51272	\$50.60	\$68.70
7.0mm	54	89	51273	\$55.10	\$73.20
7.5mm	60	95	51274	\$59.30	\$77.40
8.0mm	60	95	51275	\$67.70	\$91.80
8.5mm	63	101	51276	\$74.40	\$98.50
9.0mm	70	108	51277	\$80.30	\$104.40
9.5mm	70	108	51278	\$88.90	\$113.00
10.0mm	73	114	51279	\$105.00	\$135.10
10.5mm	73	114	51280	\$122.70	\$152.80
11.0mm	73	114	51281	\$124.40	\$154.50
11.5mm	76	120	51282	\$145.90	\$186.00
12.0mm	76	120	51283	\$161.20	\$201.30
12.5mm	76	120	51284	\$164.40	\$204.50



3 Flute Drills by ULTRATOOL

Series 540

3 Flute • Jobbers Length
150° Drill Point • 30° RH Helix



SFR Drill Specifications:
Diameter +.0000/-0.0003
Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/16	3/4	1-1/2	54004	\$12.90	\$15.50
5/64	7/8	1-3/4	54005	\$13.30	\$16.10
3/32	1"	2"	54006	\$13.80	\$16.60
7/64	1-1/4	2-1/4	54007	\$15.40	\$19.40
1/8	1-1/4	2-1/4	54008	\$15.80	\$19.90
9/64	1-3/8	2-1/2	54009	\$18.20	\$23.10
5/32	1-3/8	2-1/2	54010	\$21.10	\$26.00
11/64	1-5/8	2-3/4	54011	\$23.50	\$28.40
3/16	1-5/8	2-3/4	54012	\$23.70	\$28.60
13/64	1-3/4	3"	54013	\$28.30	\$34.90
7/32	1-3/4	3"	54014	\$31.40	\$38.00
15/64	2"	3-1/4	54015	\$33.90	\$42.20
1/4	2"	3-1/4	54016	\$36.20	\$44.50
17/64	2-1/8	3-1/2	54017	\$41.70	\$52.00
9/32	2-1/8	3-1/2	54018	\$45.60	\$55.90
19/64	2-3/8	3-3/4	54019	\$48.70	\$59.00
5/16	2-3/8	3-3/4	54020	\$52.50	\$62.80
21/64	2-1/2	4"	54021	\$56.60	\$67.80
11/32	2-1/2	4"	54022	\$62.40	\$73.50
23/64	2-3/4	4-1/4	54023	\$69.50	\$86.70
3/8	2-3/4	4-1/4	54024	\$68.50	\$85.70
25/64	2-7/8	4-1/2	54025	\$86.30	\$106.00
13/32	2-7/8	4-1/2	54026	\$92.70	\$112.40
27/64	2-7/8	4-1/2	54027	\$102.10	\$121.80
7/16	2-7/8	4-1/2	54028	\$109.10	\$128.90
29/64	3"	4-3/4	54029	\$119.80	\$142.20
15/32	3"	4-3/4	54030	\$126.70	\$149.00
31/64	3"	4-3/4	54031	\$132.40	\$154.70
1/2	3"	4-3/4	54032	\$126.40	\$148.80
17/32	4"	6"	54034	\$210.30	\$235.20
9/16	4"	6"	54036	\$225.80	\$250.70
19/32	4"	6"	54038	\$259.50	\$287.20
5/8	4"	6"	54040	\$262.30	\$290.10
21/32	4"	6"	54042	\$296.90	\$329.20
11/16	4"	6"	54044	\$302.20	\$334.50
3/4	4"	6"	54048	\$352.20	\$384.50
13/16	4"	6"	54052	\$481.20	\$518.40
7/8	4"	6"	54056	\$510.20	\$547.40
15/16	4"	6"	54060	\$510.20	\$552.60
1"	4"	6"	54064	\$474.00	\$516.30

Series 540 • Wire Gage

Diam	LOF	OAL	EDP#	Price	Coated Price
1	1-3/4	3-1/4	54101	\$34.30	\$42.60
2	1-3/4	3"	54102	\$32.70	\$39.30
3	1-3/4	3"	54103	\$30.70	\$37.30
4	1-3/4	3"	54104	\$29.90	\$36.50
5	1-3/4	3"	54105	\$29.10	\$35.70
6	1-3/4	3"	54106	\$28.80	\$35.40
7	1-3/4	3"	54107	\$27.60	\$34.20
8	1-3/4	3"	54108	\$27.30	\$33.90
9	1-3/4	3"	54109	\$26.50	\$33.10
10	1-5/8	2-3/4	54110	\$25.90	\$32.50
11	1-5/8	2-3/4	54111	\$25.70	\$32.30
12	1-5/8	2-3/4	54112	\$25.20	\$31.80
13	1-5/8	2-3/4	54113	\$24.80	\$29.60
14	1-5/8	2-3/4	54114	\$24.50	\$29.40
15	1-5/8	2-3/4	54115	\$24.40	\$29.30
16	1-5/8	2-3/4	54116	\$24.00	\$28.80
17	1-5/8	2-3/4	54117	\$23.70	\$28.50
18	1-5/8	2-3/4	54118	\$23.10	\$28.00
19	1-5/8	2-3/4	54119	\$22.90	\$27.80
20	1-3/8	2-1/2	54120	\$22.10	\$27.00
21	1-3/8	2-1/2	54121	\$22.00	\$26.80
22	1-3/8	2-1/2	54122	\$21.70	\$26.50
23	1-3/8	2-1/2	54123	\$20.80	\$25.70
24	1-3/8	2-1/2	54124	\$20.10	\$24.90
25	1-3/8	2-1/2	54125	\$19.30	\$24.20
26	1-3/8	2-1/2	54126	\$18.90	\$23.80
27	1-3/8	2-1/2	54127	\$18.90	\$23.80
28	1-3/8	2-1/2	54128	\$18.20	\$23.10
29	1-3/8	2-1/2	54129	\$17.90	\$22.80
30	1-3/8	2-1/4	54130	\$17.20	\$22.00
31	1-1/4	2-1/4	54131	\$17.20	\$22.00
32	1-1/4	2-1/4	54132	\$16.50	\$20.50
33	1-1/4	2-1/4	54133	\$16.10	\$20.10
34	1-1/4	2-1/4	54134	\$16.10	\$20.10
35	1-1/4	2-1/4	54135	\$15.70	\$19.70
36	1-1/4	2-1/4	54136	\$15.40	\$19.40
37	1-1/4	2-1/4	54137	\$15.40	\$19.40
38	1-1/4	2-1/4	54138	\$15.40	\$19.40
39	1-1/4	2-1/4	54139	\$15.40	\$19.40
40	1"	2"	54140	\$14.50	\$17.30
41	1"	2"	54141	\$14.50	\$17.30
42	1"	2"	54142	\$13.80	\$16.60
43	1"	2"	54143	\$13.30	\$16.10
44	1"	2"	54144	\$13.30	\$16.10
45	7/8	1-3/4	54145	\$13.30	\$16.10
46	7/8	1-3/4	54146	\$13.30	\$16.10
47	7/8	1-3/4	54147	\$13.30	\$16.10
48	7/8	1-3/4	54148	\$13.00	\$15.80
49	7/8	1-3/4	54149	\$13.00	\$15.80
50	7/8	1-3/4	54150	\$12.90	\$15.70
51	3/4	1-1/2	54151	\$12.90	\$15.70
52	3/4	1-1/2	54152	\$12.90	\$15.70

Series 540 • Letter Sizes

Diam	LOF	OAL	EDP#	Price	Coated Price
A	2"	3-1/4	54174	\$35.30	\$43.50
B	2"	3-1/4	54175	\$35.90	\$44.20
C	2"	3-1/4	54176	\$36.70	\$45.00
D	2"	3-1/4	54177	\$37.40	\$45.70
E	2"	3-1/4	54178	\$38.80	\$47.10
F	2"	3-1/2	54179	\$41.70	\$52.00
G	2-1/8	3-1/2	54180	\$41.70	\$52.00
H	2-1/8	3-1/2	54181	\$43.20	\$53.50
I	2-1/8	3-1/2	54182	\$44.20	\$54.50
J	2-1/8	3-1/2	54183	\$45.40	\$55.70
K	2-1/8	3-1/2	54184	\$45.60	\$55.90
L	2-1/8	3-1/2	54185	\$47.30	\$57.60
M	2-3/8	3-3/4	54186	\$48.70	\$59.00
N	2-3/8	3-3/4	54187	\$52.40	\$62.70
O	2-3/8	3-3/4	54188	\$55.50	\$66.70
P	2-3/8	4"	54189	\$56.60	\$67.80
Q	2-1/2	4"	54190	\$61.00	\$72.70
R	2-1/2	4"	54191	\$62.40	\$73.50
S	2-1/2	4"	54192	\$65.90	\$77.00
T	2-3/4	4-1/4	54193	\$69.50	\$86.60
U	2-3/4	4-1/4	54194	\$73.00	\$90.10
V	2-3/4	4-1/4	54195	\$77.10	\$96.90
W	2-7/8	4-1/2	54196	\$77.10	\$96.90
X	2-7/8	4-1/2	54197	\$90.50	\$110.20
Y	2-7/8	4-1/2	54198	\$90.50	\$110.20
Z	2-7/8	4-1/2	54199	\$100.80	\$120.50

Series 540 • Metric

SFR Drill Specifications (mm):
Diameter +0.000/-0.008mm
Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1.5mm	19	38	54215	\$12.80	\$15.40
2.0mm	22	44	54220	\$13.30	\$16.10
2.5mm	25	50	54225	\$14.50	\$17.30
3.0mm	32	57	54230	\$16.50	\$20.50
3.5mm	35	63	54235	\$18.20	\$23.10
4.0mm	35	63	54240	\$21.70	\$26.50
4.5mm	41	70	54245	\$24.00	\$28.80
5.0mm	44	76	54250	\$26.80	\$33.40
5.5mm	44	76	54255	\$30.70	\$37.30
6.0mm	50	82	54260	\$35.20	\$43.50
6.5mm	50	82	54265	\$41.50	\$51.90
7.0mm	54	89	54270	\$45.10	\$55.40
7.5mm	60	95	54275	\$48.70	\$59.00
8.0mm	60	95	54280	\$55.50	\$66.70
8.5mm	63	101	54285	\$61.00	\$72.20
9.0mm	70	108	54290	\$65.90	\$83.00
9.5mm	70	108	54295	\$73.00	\$92.60
10.0mm	73	114	54300	\$86.30	\$105.90
10.5mm	73	114	54305	\$100.80	\$120.50
11.0mm	73	114	54310	\$102.10	\$121.80
11.5mm	76	120	54315	\$119.80	\$142.20
12.0mm	76	120	54320	\$132.40	\$154.70
12.5mm	76	120	54325	\$135.00	\$157.30



Solid Carbide Straight Flute Drills by ULTRA TOOL

Series 570
Micro-Hole Drill
135° Four-Facet Point


SFR Drill Specifications:
Diameter +.0000/-0.0003
Point Angle $\pm 1^\circ$

Diam	LOF	OAL	EDP#	Price	Coated Price
3/64	3/8	1-1/2	57003	\$12.40	\$15.00
1/16	3/8	1-1/2	57004	\$12.40	\$15.00
5/64	1/2	2"	57005	\$12.80	\$15.60
3/32	1/2	2"	57006	\$13.00	\$15.80
7/64	5/8	2-1/4	57007	\$14.40	\$18.40
1/8	5/8	2-1/4	57008	\$16.00	\$20.00
9/64	5/8	2-1/2	57009	\$17.30	\$22.20
5/32	3/4	2-1/2	57010	\$18.10	\$23.00
11/64	3/4	2-1/2	57011	\$21.20	\$26.10
3/16	3/4	2-1/2	57012	\$22.40	\$27.30
13/64	1"	2-1/2	57013	\$26.00	\$32.60
7/32	1"	2-1/2	57014	\$26.80	\$33.40
15/64	1"	2-1/2	57015	\$28.50	\$35.10
1/4	1"	2-1/2	57016	\$32.10	\$38.70
17/64	1"	2-1/2	57017	\$41.50	\$49.50
9/32	1"	2-1/2	57018	\$43.10	\$51.10
19/64	1-1/4	2-1/2	57019	\$45.70	\$53.70
5/16	1-1/4	2-1/2	57020	\$47.30	\$55.30
21/64	1-1/4	3"	57021	\$51.00	\$59.60
11/32	1-1/4	3"	57022	\$56.30	\$64.90
23/64	1-1/4	3"	57023	\$61.60	\$70.20
3/8	1-1/4	3"	57024	\$64.00	\$72.60
25/64	1-1/4	3"	57025	\$72.20	\$83.40
13/32	1-1/4	3"	57026	\$80.10	\$91.30
27/64	1-1/4	3"	57027	\$87.60	\$98.80
7/16	1-1/4	3"	57028	\$87.60	\$98.80
29/64	1-1/4	3"	57029	\$93.50	\$105.00
15/32	1-1/4	3"	57030	\$94.70	\$106.20
31/64	1-1/4	3"	57031	\$95.60	\$107.10
1/2	1-1/4	3"	57032	\$97.10	\$108.50
9/16	1-1/2	3-1/2	57034	\$128.30	\$144.60
5/8	1-1/2	3-1/2	57036	\$142.60	\$160.30
3/4	1-1/2	4"	57040	\$162.20	\$184.10

Series 570 • Wire Gage

Diam	LOF	OAL	EDP#	Price	Coated Price
1	1"	2-1/2	57101	\$28.50	\$35.10
2	1"	2-1/2	57102	\$28.50	\$35.10
3	1"	2-1/2	57103	\$26.50	\$33.10
4	1"	2-1/2	57104	\$26.50	\$33.10
5	1"	2-1/2	57105	\$26.50	\$33.10
6	1"	2-1/2	57106	\$26.50	\$33.10
7	1"	2-1/2	57107	\$25.10	\$31.60
8	1"	2-1/2	57108	\$25.10	\$31.60
9	1"	2-1/2	57109	\$24.40	\$31.00
10	3/4	2-1/2	57110	\$24.40	\$31.00
11	3/4	2-1/2	57111	\$24.20	\$30.80
12	3/4	2-1/2	57112	\$24.20	\$30.80
13	3/4	2-1/2	57113	\$22.40	\$27.30
14	3/4	2-1/2	57114	\$22.40	\$27.30
15	3/4	2-1/2	57115	\$21.60	\$26.50
16	3/4	2-1/2	57116	\$21.60	\$26.50
17	3/4	2-1/2	57117	\$21.60	\$26.50
18	3/4	2-1/2	57118	\$21.20	\$26.10
19	3/4	2-1/2	57119	\$21.20	\$26.10
20	3/4	2-1/2	57120	\$20.70	\$25.60
21	3/4	2-1/2	57121	\$20.70	\$25.60
22	3/4	2-1/2	57122	\$19.90	\$24.80
23	5/8	2-1/2	57123	\$18.10	\$23.00
24	5/8	2-1/2	57124	\$18.10	\$23.00
25	5/8	2-1/2	57125	\$18.10	\$23.00
26	5/8	2-1/2	57126	\$18.10	\$23.00
27	5/8	2-1/2	57127	\$17.50	\$22.40
28	5/8	2-1/2	57128	\$17.30	\$22.20
29	5/8	2-1/2	57129	\$16.30	\$21.20
30	5/8	2-1/4	57130	\$16.30	\$21.20
31	5/8	2-1/4	57131	\$15.40	\$19.50
32	5/8	2-1/4	57132	\$14.60	\$18.70
33	5/8	2-1/4	57133	\$14.60	\$18.70
34	5/8	2-1/4	57134	\$14.60	\$18.70
35	5/8	2-1/4	57135	\$14.60	\$18.70
36	5/8	2-1/4	57136	\$14.40	\$18.40
37	5/8	2-1/4	57137	\$14.40	\$18.40
38	5/8	2-1/4	57138	\$14.40	\$18.40
39	5/8	2-1/4	57139	\$14.40	\$18.40
40	1/2	2"	57140	\$14.40	\$17.20
41	1/2	2"	57141	\$14.40	\$17.20
42	1/2	2"	57142	\$13.00	\$15.80
43	1/2	2"	57143	\$13.00	\$15.80
44	1/2	2"	57144	\$13.00	\$15.80
45	1/2	2"	57145	\$13.00	\$15.80
46	1/2	2"	57146	\$13.00	\$15.80
47	1/2	2"	57147	\$13.00	\$15.80
48	1/2	2"	57148	\$12.80	\$15.60
49	3/8	2"	57149	\$12.80	\$15.60
50	3/8	2"	57150	\$12.80	\$15.60
51	3/8	1-1/2	57151	\$12.80	\$15.60
52	3/8	1-1/2	57152	\$12.80	\$15.60
53	3/8	1-1/2	57153	\$12.40	\$15.00
54	3/8	1-1/2	57154	\$12.40	\$15.00
55	3/8	1-1/2	57155	\$12.40	\$15.00
56	3/8	1-1/2	57156	\$12.40	\$15.00
57	3/8	1-1/2	57157	\$12.40	\$15.00
58	3/8	1-1/2	57158	\$12.40	\$15.00
59	3/8	1-1/2	57159	\$12.40	\$15.00
60	3/8	1-1/2	57160	\$12.40	\$15.00

Series 570 • Letter Sizes

Diam	LOF	OAL	EDP#	Price	Coated Price
A	1"	2-1/2	57161	\$32.80	\$39.40
B	1"	2-1/2	57162	\$40.90	\$47.50
C	1"	2-1/2	57163	\$42.20	\$48.80
D	1"	2-1/2	57164	\$42.90	\$49.40
E	1"	2-1/2	57165	\$45.70	\$52.30
F	1"	2-1/2	57166	\$48.10	\$56.10
G	1"	2-1/2	57167	\$50.10	\$58.10
H	1"	2-1/2	57168	\$50.70	\$58.70
I	1"	2-1/2	57169	\$51.30	\$59.30
J	1"	2-1/2	57170	\$52.00	\$60.00
K	1"	2-1/2	57171	\$52.50	\$60.50
L	1"	2-1/2	57172	\$54.00	\$62.00
M	1"	2-1/2	57173	\$54.40	\$62.40
N	1-1/4	2-1/2	57174	\$56.00	\$64.00
O	1-1/4	2-1/2	57175	\$61.30	\$69.90
P	1-1/4	2-1/2	57176	\$61.90	\$70.50
Q	1-1/4	3"	57177	\$65.80	\$74.30
R	1-1/4	3"	57178	\$67.20	\$75.80
S	1-1/4	3"	57179	\$70.50	\$79.00
T	1-1/4	3"	57180	\$73.80	\$82.40
U	1-1/4	3"	57181	\$77.70	\$86.30
V	1-1/4	3"	57182	\$85.00	\$96.20
W	1-1/4	3"	57183	\$88.40	\$99.60
X	1-1/4	3"	57184	\$95.50	\$106.70
Y	1-1/4	3"	57185	\$96.20	\$107.30
Z	1-1/4	3"	57186	\$100.70	\$111.90

Series 570 • Metric Sizes

SFR Drill Specifications (mm):
Diameter +0.000/-0.008mm
Point Angle $\pm 1^\circ$

Diam	LOF	OAL	EDP#	Price	Coated Price
1.0mm	9.5	38	57061	\$12.40	\$15.00
1.5mm	9.5	38	57062	\$12.40	\$15.00
2.0mm	12	50	57063	\$13.00	\$15.80
2.5mm	12	50	57064	\$14.40	\$17.20
3.0mm	16	57	57065	\$15.40	\$19.50
3.5mm	16	63	57066	\$17.30	\$22.20
4.0mm	19	63	57067	\$19.90	\$24.80
4.5mm	19	63	57068	\$21.60	\$26.50
5.0mm	25	63	57069	\$25.10	\$31.60
5.5mm	25	63	57070	\$26.80	\$33.40
6.0mm	25	63	57071	\$32.20	\$38.70
6.5mm	25	63	57072	\$41.50	\$49.50
7.0mm	25	63	57073	\$43.10	\$51.10
7.5mm	25	63	57074	\$45.70	\$53.70
8.0mm	32	63	57075	\$47.30	\$55.90
8.5mm	32	76	57076	\$56.30	\$64.90
9.0mm	32	76	57077	\$59.70	\$68.30
9.5mm	32	76	57078	\$64.00	\$72.60
10.0mm	32	76	57079	\$79.20	\$90.40
10.5mm	32	76	57080	\$87.20	\$98.40
11.0mm	32	76	57081	\$87.60	\$98.80
11.5mm	32	76	57082	\$90.10	\$101.50
12.0mm	32	76	57083	\$95.60	\$107.10
12.5mm	32	76	57084	\$97.10	\$108.50
14.0mm	38	89	57085	\$128.30	\$144.60
16.0mm	38	89	57086	\$142.60	\$160.30
20.0mm	38	102	57088	\$188.90	\$213.00

Ultra-Tool® Drills are manufactured to a diameter tolerance 40% tighter than industry standards, feature unique high-productivity geometry with SmoothGrind® finishes, and are precision ground from an exclusive Ultra-Carb® material with superb wear characteristics.



Stub Length Drills

Series 520

 Short Length • 25° RH Helix
 Two-Flute • 118° Four-Facet Point

 SFR Drill Specifications:
 Diameter +.0000/- .0003
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/8	5/8	2"	52008	\$13.70	\$16.50
9/64	5/8	2"	52009	\$15.80	\$19.20
5/32	3/4	2-1/2	52010	\$16.90	\$21.80
11/64	3/4	2-1/2	52011	\$18.70	\$23.50
3/16	3/4	2-1/2	52012	\$20.40	\$25.20
13/64	3/4	2-1/2	52013	\$22.90	\$29.50
7/32	1"	2-1/2	52014	\$24.20	\$30.80
15/64	1"	2-1/2	52015	\$25.30	\$31.90
1/4	1"	2-1/2	52016	\$26.60	\$33.20
17/64	1"	2-1/2	52017	\$28.40	\$36.50
9/32	1"	2-1/2	52018	\$30.00	\$38.10
19/64	1-1/4	2-3/4	52019	\$33.80	\$41.80
5/16	1-1/4	2-3/4	52020	\$37.40	\$45.40
21/64	1-1/4	2-3/4	52021	\$40.30	\$48.90
11/32	1-1/4	3"	52022	\$43.30	\$51.90
23/64	1-1/4	3"	52023	\$46.80	\$55.40
3/8	1-1/4	3"	52024	\$47.40	\$56.00
25/64	1-1/4	3"	52025	\$52.10	\$63.30
13/32	1-1/4	3"	52026	\$57.50	\$68.70
27/64	1-1/4	3"	52027	\$60.50	\$71.60
7/16	1-1/4	3"	52028	\$64.20	\$75.30
29/64	1-1/4	3"	52029	\$69.20	\$80.60
15/32	1-1/4	3"	52030	\$71.20	\$82.70
31/64	1-1/4	3"	52031	\$74.20	\$85.60
1/2	1-1/4	3"	52032	\$75.60	\$87.00

Series 520 • Metric Sizes

 SFR Drill Specifications (mm):
 Diameter +0.000/-0.008mm
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
3.0mm	16	50	52064	\$15.20	\$18.00
3.5mm	16	50	52065	\$16.40	\$19.90
4.0mm	19	63	52066	\$18.60	\$23.50
4.5mm	19	63	52067	\$20.40	\$25.20
5.0mm	19	63	52068	\$22.90	\$29.50
5.5mm	19	63	52069	\$24.20	\$30.80
6.0mm	25	63	52070	\$26.60	\$33.20
6.5mm	25	63	52071	\$28.40	\$36.50
7.0mm	25	63	52072	\$30.00	\$38.10
7.5mm	32	70	52073	\$33.80	\$41.80
8.0mm	32	70	52074	\$40.30	\$48.90
8.5mm	32	70	52075	\$43.30	\$51.90
9.0mm	32	76	52076	\$46.80	\$55.40
9.5mm	32	76	52077	\$47.40	\$56.00
10.0mm	32	76	52078	\$52.10	\$63.30
10.5mm	32	76	52079	\$60.50	\$71.60
11.0mm	32	76	52080	\$64.20	\$75.30
11.5mm	32	76	52081	\$69.20	\$80.60
12.0mm	32	76	52082	\$71.20	\$82.70
12.5mm	32	76	52083	\$75.70	\$87.10

Drill-Mills by ULTRA TOOL®

Series 535

 Drill-Mill
 Two-Flute 30° RHS/RHC
 90° Four-Facet Point

 SFR Drill-Mill Specifications:
 Diameter +.000/- .002
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/8	1/2	1-1/2	53508	\$14.10	\$16.90
3/16	5/8	2"	53512	\$19.30	\$22.80
1/4	3/4	2-1/2	53516	\$23.10	\$29.70
5/16	13/16	2-1/2	53520	\$32.40	\$40.40
3/8	1"	2-1/2	53524	\$40.50	\$49.00
1/2	1"	3"	53532	\$63.30	\$74.70
5/8	1-1/2	3-1/2	53536	\$122.80	\$140.60
3/4	1-1/2	4"	53540	\$178.60	\$199.50

Series 536

 Drill-Mill
 Four-Flute 30° RHS/RHC
 90° Four-Facet Point

 SFR Drill-Mill Specifications:
 Diameter +.000/- .002
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/8	1/2	1-1/2	53608	\$14.10	\$16.90
3/16	5/8	2"	53612	\$19.30	\$22.80
1/4	3/4	2-1/2	53616	\$23.10	\$29.70
5/16	13/16	2-1/2	53620	\$32.40	\$40.40
3/8	1"	2-1/2	53624	\$40.50	\$49.00
1/2	1"	3"	53632	\$63.30	\$74.70
5/8	1-1/2	3-1/2	53636	\$122.80	\$140.60
3/4	1-1/2	4"	53640	\$178.60	\$199.50

Spade Flute Drills

Series 530

Short Length • Flat Drill • 118° Point


 SFR Drill Specifications:
 Diameter +.0000/- .0003
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/16	3/8	1-1/2	53004	\$12.80	\$15.40
3/32	7/16	1-1/2	53006	\$12.80	\$15.60
1/8	1/2	1-1/2	53008	\$12.80	\$15.60
5/32	9/16	2"	53010	\$16.40	\$19.90
3/16	11/16	2"	53012	\$17.50	\$20.90
7/32	11/16	2"	53014	\$20.30	\$25.70
1/4	13/16	2"	53016	\$22.90	\$28.30
9/32	7/8	2"	53018	\$28.10	\$34.40
5/16	7/8	2-1/2	53020	\$31.60	\$39.60
11/32	15/16	2-1/2	53022	\$37.80	\$46.40
3/8	1-1/8	2-1/2	53024	\$40.40	\$49.00
13/32	1-1/8	2-1/2	53026	\$45.70	\$56.90
7/16	1-3/16	2-3/4	53028	\$48.40	\$59.50
15/32	1-3/16	3"	53030	\$52.80	\$63.90
1/2	1-5/16	3"	53032	\$58.00	\$69.40

Series 530 • Metric Sizes

 SFR Drill Specifications (mm):
 Diameter +0.000/-0.008mm
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
3.0mm	13	38	53064	\$12.80	\$15.60
4.0mm	17	50	53066	\$17.50	\$20.90
5.0mm	17	50	53068	\$20.30	\$25.70
6.0mm	21	50	53070	\$22.90	\$29.50
7.0mm	22	50	53072	\$28.10	\$34.40
8.0mm	24	63	53074	\$31.60	\$40.20
9.0mm	28	63	53076	\$40.40	\$49.00
10.0mm	28	63	53078	\$45.70	\$56.90
11.0mm	30	70	53080	\$48.40	\$59.50
12.0mm	32	76	53082	\$58.00	\$69.40

Slow Spiral Drills

Series 550

15° Slow Helix • 135° Four-Facet Point


 SFR Drill Specifications:
 Diameter +.0000/- .0003
 Point Angle ±1°

Diam	LOF	OAL	EDP#	Price	Coated Price
1/8	7/8	2"	55008	\$17.70	\$20.50
9/64	7/8	2"	55009	\$18.10	\$21.50
5/32	1"	2"	55010	\$19.30	\$22.80
11/64	1"	2"	55011	\$21.30	\$24.70
3/16	1-1/8	2-1/2	55012	\$25.50	\$30.30
13/64	1-1/8	2-1/2	55013	\$28.50	\$35.10
7/32	1-1/4	2-1/2	55014	\$32.00	\$38.60
15/64	1-1/4	2-1/2	55015	\$35.00	\$41.60
1/4	1-3/8	2-1/2	55016	\$35.90	\$42.50
9/32	1-1/2	3"	55018	\$41.10	\$49.20
5/16	1-5/8	3"	55020	\$52.30	\$60.30
11/32	1-3/4	3"	55022	\$59.90	\$68.50
3/8	1-3/4	3"	55024	\$69.70	\$78.20
13/32	2"	3-1/2	55026	\$86.10	\$100.40
7/16	2-1/8	3-1/2	55028	\$103.40	\$117.70
15/32	2-1/8	4"	55030	\$118.40	\$133.90
1/2	2-1/4	4"	55032	\$124.70	\$140.20

Combined Drill & Countersink Center Drills by ULTRATOOL®

Series 560

Combined Drill & Countersink
Double End • 60°/82°/90° Incl. Angle • RH Cut



SFR Center Drill Specifications:
Body Diameter +.0000/- .0003
Drill Diameter +.003/- .000
Point / C'sink Angle ±1°



Series 750 - Sets

Combined Drill & Countersink Sets
Includes 1 ea. #1 • #2 • #3 • #4 • #5 • #6

Included Angle	EDP#	Price	Coated
60°	76060	\$264.00	\$326.80
82°	76082	\$264.00	\$326.80
90°	76090	\$264.00	\$326.80

The Ultra-Tool® Series 560 Combined Drill & Countersink is the high-productivity center drilling alternative to equivalent HSS designs, featuring a slight helix for great chip evacuation. Available in 3 different countersinking angles.

Tool	Body Diam	Drill Diam	OAL	60°	82°	90°	Price	Coated Price
#00	1/8	.025	1-1/2	56099	56199	56299	\$19.50	\$23.70
#0	1/8	1/32	1-1/2	56000	56100	56200	\$18.30	\$22.50
#1	1/8	3/64	1-1/2	56001	56101	56201	\$17.10	\$21.30
#2	3/16	5/64	2"	56002	56102	56202	\$26.90	\$32.00
#3	1/4	7/64	2"	56003	56103	56203	\$30.60	\$38.70
#4	5/16	1/8	2-1/2	56004	56104	56204	\$41.80	\$53.80
#5	7/16	3/16	2-3/4	56005	56105	56205	\$62.10	\$78.80
#6	1/2	7/32	3"	56006	56106	56206	\$85.20	\$102.30
#7	5/8	1/4	3-1/2	56007	56107	56207	\$134.40	\$161.10
#8	3/4	5/16	4"	56008	56108	56208	\$177.20	\$208.50

Specialty Drills by ULTRATOOL®

Series 555

Parabolic Drill

2 Flutes • 118° Four Facet Point • 33° Helix



The Ultra Series 555 Parabolic Drill is ideal for heavy feed drilling in most materials. The open fluting, thick web construction, and fast helix design makes for excellent deep hole drilling results.

Diam	LOF	OAL	EDP#	Price	Coated Price
1/16	3/4	1-1/2	15501	\$16.10	\$18.70
3/32	1"	2"	15503	\$17.00	\$19.90
1/8	1-1/4	3"	15505	\$32.20	\$36.20
5/32	1-1/2	3"	15507	\$38.20	\$43.00
3/16	2"	4"	15509	\$42.70	\$48.70
7/32	2-1/2	4"	15511	\$47.40	\$55.70
1/4	3"	4-1/2	15513	\$54.10	\$65.00
9/32	3-1/4	4-1/2	15514	\$63.40	\$77.70
5/16	3-1/4	4-3/4	15515	\$67.40	\$81.70
11/32	4"	6"	15516	\$110.60	\$127.80
3/8	4"	6"	15517	\$113.80	\$131.00
13/32	4"	6"	15518	\$151.10	\$170.80
7/16	4"	6"	15519	\$151.10	\$170.80
15/32	4"	6"	15520	\$158.80	\$181.10
1/2	4"	6"	15521	\$158.80	\$181.10

SFR Drill Specifications:
Diameter +.0000/- .0003
Point Angle ±1°

Series 585

Quad Drill

2 Straight Flutes • Four Margins • 135° Point



The Ultra Series 585 Quad Drill features four lands that create a burnishing action for unsurpassed hole straightness and concentricity. Provided with a self-centering point designed for steel and cast iron.

Diam	LOF	OAL	EDP#	Price	Coated Price
1/8	7/8	2"	15852	\$18.90	\$21.70
5/32	1"	2"	15855	\$23.00	\$26.40
3/16	1"	2-1/2"	15858	\$28.50	\$33.40
7/32	1-1/4	2-1/2"	15861	\$34.00	\$40.60
1/4	1-3/8	2-1/2"	15865	\$37.20	\$43.80
9/32	1-1/2	3"	15878	\$56.50	\$64.50
5/16	1-5/8	3"	15881	\$58.00	\$66.00
11/32	1-3/4	3"	15884	\$72.20	\$80.80
3/8	1-7/8	3"	15887	\$76.20	\$84.80
13/32	2"	3-1/2"	15890	\$99.20	\$113.60
7/16	2-1/8	4"	15893	\$102.00	\$116.30
15/32	2-1/8	4"	15896	\$106.50	\$122.00
1/2	2-1/4	4"	15899	\$113.10	\$128.60

SFR Drill Specifications:
Diameter +.0000/- .0003
Point Angle ±1°

ULTRATOOL® Spotting Drills

Series 525

Short Length • 25° RH Helix
90°/120°/140° Four-Facet Point • Constant Web
No OD Clearance • Produces True Centers

new!



Additional sizes and angles!



SFR Drill Specifications:
Diameter +.0000/- .0003
Point Angle ±1°

Diam	LOF	OAL	90° EDP#	120° EDP#	140° EDP#	Price	Coated Price
1/8	1/2	2"	52580	52581	52582	\$16.00	\$18.80
3/16	5/8	2"	52585	52586	52587	\$20.00	\$23.50
1/4	3/4	2-1/2	52516	52515	52514	\$24.80	\$31.40
5/16	3/4	2-1/2	52590	52591	52592	\$30.00	\$38.00
3/8	1"	2-1/2	52524	52525	52526	\$32.50	\$41.10
1/2	1"	3"	52532	52533	52534	\$56.00	\$67.50
5/8	1-1/4	3-1/2	52540	52541	52542	\$107.40	\$125.10
3/4	1-1/2	4"	52548	52549	52550	\$170.00	\$190.90

Series 525

Metric Sizes

SFR Drill Specifications (mm):
Diameter +0.000/-0.008mm
Point Angle ±1°

Diam	LOF	OAL	90° EDP#	120° EDP#	140° EDP#	Price	Coated Price
3.0mm	12	57	52588	52589	52594	\$16.00	\$18.80
5.0mm	16	63	52595	52596	52593	\$20.00	\$23.50
6.0mm	19	63	52506	52507	52505	\$24.80	\$31.40
8.0mm	19	63	52508	52509	52504	\$32.50	\$41.10
10.0mm	25	70	52510	52511	52503	\$51.00	\$62.20
12.0mm	25	76	52512	52513	52502	\$56.00	\$67.50
16.0mm	32	89	52517	52518	52519	\$107.40	\$125.10
20.0mm	38	102	52521	52522	52523	\$170.00	\$190.90

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About the technology partners of Tool Alliance®

Our technology partners are second to none. We find premiere firms, the technological leaders in their respective industries, throughout the world and work with them in progressive, win-win relationships to bring our customers the very finest components and characteristics that we build into our products. Constant reinvestment into our company-owned factories promise long-term stability & consistency in delivering Performance & Solutions to carbide rotary tooling consumers everywhere.



Coating system



Substrate, abrasive, coolants & workholding



Grinding centers



5-axis VMC control



Robotics



CNC grinder control

ULTRATOOL® Fractional & Metric-Sized Reamers

Series 400 • Fractional Sizes
Standard Length • Straight Flute • RH Cut
Solid Carbide



Series 450 • Fractional Sizes
Long Length • Straight Flute • RH Cut
Steel Shank w/Carbide Head



Diam	LOC	OAL	Flutes	Shank	EDP#	Price	Coated
1/32	1/2	1-1/2	4	1/32	40002	\$31.50	\$34.50
3/64	1/2	1-1/2	4	1/32	40003	\$32.40	\$35.40
1/16	1/2	1-1/2	4	3/64	40004	\$33.30	\$36.30
5/64	1/2	2"	4	1/16	40005	\$34.20	\$37.20
3/32	1/2	2"	4	5/64	40006	\$35.10	\$38.10
7/64	5/8	2-1/4	4	3/32	40007	\$37.80	\$41.80
1/8	5/8	2-1/4	4	7/64	40008	\$39.20	\$43.20
9/64	3/4	2-1/2	4	1/8	40009	\$43.20	\$48.20
5/32	3/4	2-1/2	4	9/64	40010	\$45.50	\$50.50
11/64	7/8	2-3/4	4	5/32	40011	\$50.90	\$55.90
3/16	7/8	2-3/4	4	11/64	40012	\$53.60	\$58.60
13/64	1"	3"	6	3/16	40013	\$58.90	\$66.00
7/32	1"	3"	6	3/16	40014	\$58.90	\$66.00
15/64	1"	3"	6	7/32	40015	\$61.60	\$68.70
1/4	1"	3"	6	7/32	40016	\$61.60	\$68.70
17/64	1-1/8	3-1/4	6	1/4	40017	\$68.90	\$79.00
9/32	1-1/8	3-1/4	6	1/4	40018	\$68.90	\$79.00
19/64	1-1/8	3-1/4	6	9/32	40019	\$79.70	\$89.80
5/16	1-1/8	3-1/4	6	9/32	40020	\$79.70	\$89.80
21/64	1-1/4	3-1/2	6	5/16	40021	\$89.50	\$101.00
11/32	1-1/4	3-1/2	6	5/16	40022	\$89.50	\$101.00
23/64	1-1/4	3-1/2	6	11/32	40023	\$100.00	\$111.50
3/8	1-1/4	3-1/2	6	11/32	40024	\$100.00	\$111.50
25/64	1-1/2	4"	6	3/8	40025	\$111.60	\$126.00
13/32	1-1/2	4"	6	3/8	40026	\$111.60	\$126.00
27/64	1-1/2	4"	6	13/32	40027	\$118.80	\$133.20
7/16	1-1/2	4"	6	13/32	40028	\$118.80	\$133.20
29/64	1-1/2	4"	6	7/16	40029	\$122.40	\$138.00
15/32	1-1/2	4"	6	7/16	40030	\$122.40	\$138.00
31/64	1-1/2	4"	6	15/32	40031	\$133.20	\$148.80
1/2	1-1/2	4"	6	15/32	40032	\$133.20	\$148.80

Diam	LOC	OAL	Flutes	Shank	EDP#	Price	Coated
1/8*	7/8	3-1/2	4	7/64	45008	\$43.60	\$48.60
9/64*	7/8	4"	4	1/8	45009	\$47.70	\$54.00
5/32*	1"	4"	4	9/64	45010	\$51.30	\$57.60
11/64*	1"	4-1/2	4	5/32	45011	\$56.30	\$62.60
3/16*	1"	4-1/2	4	11/64	45012	\$59.00	\$65.30
13/64	1-1/4	5"	6	3/16	45013	\$66.20	\$77.50
7/32	1-1/4	5"	6	3/16	45014	\$66.20	\$77.50
15/64	1-1/4	6"	6	7/32	45015	\$68.00	\$79.30
1/4	1-1/4	6"	6	7/32	45016	\$68.00	\$79.30
17/64	1-1/4	6"	6	15/64	45017	\$75.20	\$90.00
9/32	1-1/4	6"	6	15/64	45018	\$75.20	\$90.00
19/64	1-1/2	6"	6	1/4	45019	\$83.30	\$98.10
5/16	1-1/2	6"	6	1/4	45020	\$83.30	\$98.10
21/64	1-1/2	6"	6	19/64	45021	\$97.70	\$115.00
11/32	1-1/2	6"	6	19/64	45022	\$97.70	\$115.00
23/64	1-1/2	7"	6	5/16	45023	\$106.20	\$126.50
3/8	1-1/2	7"	6	5/16	45024	\$106.20	\$126.50
25/64	1-3/4	7"	6	11/32	45025	\$118.80	\$147.00
13/32	1-3/4	7"	6	11/32	45026	\$118.80	\$147.00
27/64	1-3/4	7"	6	3/8	45027	\$126.00	\$154.20
7/16	1-3/4	7"	6	3/8	45028	\$126.00	\$154.20
29/64	1-3/4	8"	6	13/32	45029	\$133.20	\$168.00
15/32	1-3/4	8"	6	13/32	45030	\$133.20	\$168.00
31/64	1-3/4	8"	6	7/16	45031	\$142.20	\$177.00
1/2	1-3/4	8"	6	7/16	45032	\$142.20	\$177.00
9/16	1-7/8	9"	6	31/64	45034	\$156.60	\$199.00
5/8	1-7/8	9"	6	17/32	45036	\$175.00	\$218.50
11/16	2"	9-1/2	6	9/16	45038	\$213.80	\$261.00
3/4	2"	9-1/2	6	5/8	45040	\$251.60	\$298.80
7/8	2"	10"	8	3/4	45044	\$318.60	\$377.00
1"	2"	10"	8	3/4	45048	\$382.50	\$441.00

Series 400 • Metric Sizes

Diam	LOC	OAL	Flutes	Shank	EDP#	Price	Coated
1.0mm	12	38	4	0.7mm	40050	\$31.50	\$34.50
1.5mm	12	38	4	1.0mm	40051	\$33.30	\$36.30
2.0mm	12	51	4	1.5mm	40052	\$34.20	\$37.20
2.5mm	16	57	4	2.2mm	40053	\$37.80	\$41.80
3.0mm	16	57	4	2.5mm	40054	\$39.20	\$43.20
3.5mm	19	63	4	3.0mm	40055	\$43.20	\$48.20
4.0mm	19	63	4	3.5mm	40056	\$45.50	\$50.50
4.5mm	25	70	4	4.0mm	40057	\$53.60	\$58.60
5.0mm	25	76	6	4.5mm	40058	\$58.90	\$66.00
5.5mm	25	76	6	4.5mm	40059	\$58.90	\$66.00
6.0mm	25	76	6	5.0mm	40060	\$61.60	\$68.70
6.5mm	28	76	6	6.3mm	40061	\$68.90	\$79.00
7.0mm	28	82	6	6.3mm	40062	\$68.90	\$79.00
7.5mm	28	82	6	7.1mm	40063	\$79.70	\$89.80
8.0mm	28	82	6	7.1mm	40064	\$79.70	\$89.80
8.5mm	32	89	6	7.1mm	40065	\$89.50	\$101.00
9.0mm	32	89	6	8.0mm	40066	\$100.00	\$111.50
9.5mm	32	89	6	8.0mm	40067	\$100.00	\$111.50
10.0mm	38	101	6	8.0mm	40068	\$111.60	\$126.00
10.5mm	38	101	6	10.0mm	40069	\$118.80	\$133.20
11.0mm	38	101	6	10.0mm	40070	\$118.80	\$133.20
11.5mm	38	101	6	10.0mm	40071	\$122.40	\$138.00
12.0mm	38	101	6	10.0mm	40072	\$122.40	\$138.00
12.5mm	38	101	6	10.0mm	40073	\$133.20	\$148.80

Series 450 • Metric Sizes

Diam	LOC	OAL	Flutes	Shank	EDP#	Price	Price
3.0mm*	22	89	4	2.5mm	45049	\$43.60	\$48.60
4.0mm*	25	101	4	3.5mm	45050	\$51.30	\$57.60
5.0mm	32	127	6	4.5mm	45051	\$66.20	\$77.50
6.0mm	32	152	6	5.5mm	45052	\$68.00	\$79.30
7.0mm	32	152	6	6.0mm	45053	\$75.20	\$90.00
8.0mm	38	152	6	6.0mm	45054	\$83.30	\$98.10
9.0mm	38	178	6	8.0mm	45055	\$106.20	\$126.50
10.0mm	44	178	6	8.0mm	45056	\$118.80	\$147.00
11.0mm	44	178	6	9.5mm	45057	\$118.80	\$147.00
12.0mm	44	203	6	10.0mm	45058	\$133.20	\$168.00
14.0mm	47	228	6	12.0mm	45059	\$156.60	\$199.00
16.0mm	47	228	6	13.5mm	45060	\$175.00	\$218.50
18.0mm	50	241	6	15.0mm	45061	\$251.60	\$298.80
20.0mm	50	254	8	18.0mm	45062	\$312.30	\$370.70
25.0mm	50	254	8	18.0mm	45063	\$382.50	\$441.00

*Solid Carbide, one-piece construction

Reamer Specs: 45° Lead
Cutting Diam +.0002/-0.000
Shank Diam +.0005/-0.005

Reamer Specs (Metric): 45° Lead
Cutting Diam +0.005/-0.000mm
Shank Diam +0.013/-0.013mm

new!

Available with
TA coating!





ULTRATOOL® Standard Length Solid Carbide Reamers

Series 410

Standard Length • Straight Flute • RH Cut

Series 410R

Standard Length • RH Spiral • RH Cut

Series 410L

Standard Length • LH Spiral • RH Cut



Now it's easier than ever to purchase the Ultra-Tool® line of precision carbide reamers (featuring the industry's tightest tolerances). We've eliminated all quantity breaks and published one low price. Best of all, uncoated, in-stock semis (up to 6 pieces) are guaranteed to ship the day after we receive an order or we'll pay for standard next day delivery (see Terms & Conditions). We've even added a pricing column for SmoothCoat TA, our most versatile TiAlN coating. Performed in-house, TA will add only 1-3 business days to delivery and includes SmoothEdge 1 edge prep.

Decimal Sizes



Metric Sizes



Group	Diam Range	LOC	OAL	Flutes	Shank	Price	Coated	Shank	Flutes	OAL	LOC	Diam Range	Group
1	.0312 - .0394	1/2	1-1/2	4	.0312	\$35.00	\$38.00	0.7mm	4	38	9	0.80 - 1.00mm	1
2	.0395 - .0484	1/2	1-1/2	4	.0312	\$36.00	\$39.00	0.7mm	4	38	9	1.01 - 1.23mm	2
3	.0485 - .0574	1/2	1-1/2	4	.0469	\$36.50	\$39.50	1.0mm	4	38	9	1.24 - 1.46mm	3
4	.0575 - .0654	1/2	1-1/2	4	.0469	\$37.00	\$40.00	1.0mm	4	38	9	1.47 - 1.66mm	4
5	.0655 - .0804	1/2	2"	4	.0625	\$38.00	\$41.50	1.5mm	4	51	12	1.67 - 2.04mm	5
6	.0805 - .0964	1/2	2"	4	.0781	\$39.00	\$42.50	1.5mm	4	51	12	2.05 - 2.45mm	6
7	.0965 - .1124	5/8	2-1/4	4	.0938	\$42.00	\$46.00	2.2mm	4	57	16	2.46 - 2.85mm	7
8	.1125 - .1284	5/8	2-1/4	4	.1094	\$43.50	\$47.50	2.5mm	4	57	16	2.86 - 3.26mm	8
9	.1285 - .1444	3/4	2-1/2	4	.1250	\$48.00	\$53.00	3.0mm	4	63	19	3.27 - 3.67mm	9
10	.1445 - .1594	3/4	2-1/2	4	.1406	\$50.50	\$55.50	3.5mm	4	63	19	3.68 - 4.05mm	10
11	.1595 - .1744	7/8	2-3/4	4	.1562	\$56.50	\$61.50	3.5mm	4	70	22	4.06 - 4.43mm	11
12	.1745 - .1914	7/8	2-3/4	4	.1719	\$59.50	\$64.50	4.0mm	4	70	22	4.44 - 4.86mm	12
13	.1915 - .2234	1"	3"	6	.1875	\$65.50	\$72.50	4.5mm	6	76	25	4.87 - 5.67mm	13
14	.2235 - .2544	1"	3"	6	.2188	\$68.50	\$75.50	5.0mm	6	76	25	5.68 - 6.46mm	14
15	.2545 - .2844	1-1/8	3-1/4	6	.2500	\$76.50	\$83.50	6.3mm	6	82	28	6.47 - 7.22mm	15
16	.2845 - .3164	1-1/8	3-1/4	6	.2812	\$88.50	\$99.50	7.1mm	6	82	28	7.23 - 8.04mm	16
17	.3165 - .3484	1-1/4	3-1/2	6	.3125	\$99.50	\$110.50	7.1mm	6	89	32	8.05 - 8.85mm	17
18	.3485 - .3794	1-1/4	3-1/2	6	.3438	\$111.00	\$123.00	8.0mm	6	89	32	8.86 - 9.64mm	18
19	.3795 - .4104	1-1/2	4"	6	.3750	\$124.00	\$136.00	8.0mm	6	101	38	9.65 - 10.42mm	19
20	.4105 - .4414	1-1/2	4"	6	.4062	\$132.00	\$147.00	10.0mm	6	101	38	10.43 - 11.21mm	20
21	.4415 - .4724	1-1/2	4"	6	.4375	\$136.00	\$152.00	10.0mm	6	101	38	11.22 - 12.00mm	21
22	.4725 - .5054	1-1/2	4"	6	.4688	\$148.00	\$164.00	10.0mm	6	101	38	12.01 - 12.84mm	22

Group ranges 1-7 feature male-centers on both ends. Group ranges 8-22 feature female-centers on both ends.

Solid Carbide Economy Reamers by ULTRATOOL®

Series 411 • Decimal Sizes

 Economy Reamers • Straight Flute • RH Cut
 Oversized Shanks with Neck Clearance


The 411 Series is ground from an oversized, common shank diameter to offer superb reaming capabilities at a lower price point than typical "reduced shank" type reamers ground between centers. Solid carbide construction. Available with TA coating. Flute length equals one-half length of reach.



Group	Diam Range	LOR	OAL	Flutes	Shank	Price	Coated	Group	Diam Range	LOR	OAL	Flutes	Shank	Price	Coated
1	.0470 - .0622	3/4	1-1/2	4	1/16	\$23.20	\$26.20	16	.2810 - .2966	2-1/4	3-3/4	6	19/64	\$59.50	\$70.50
2	.0623 - .0778	1"	2"	4	5/64	\$23.80	\$26.80	17	.2967 - .3122	2-1/4	3-3/4	6	5/16	\$62.40	\$73.40
3	.0779 - .0935	1-1/4	2-1/4	4	3/32	\$24.40	\$28.40	18	.3123 - .3278	2-3/8	4"	6	21/64	\$64.70	\$76.70
4	.0936 - .1091	1-1/4	2-1/4	4	7/64	\$25.20	\$29.20	19	.3279 - .3435	2-3/8	4"	6	11/32	\$70.20	\$82.20
5	.1092 - .1247	1-1/4	2-1/4	4	1/8	\$28.50	\$32.50	20	.3436 - .3591	2-3/8	4"	6	23/64	\$74.50	\$86.50
6	.1248 - .1403	1-1/2	2-1/2	4	9/64	\$31.20	\$36.20	21	.3592 - .3747	2-3/8	4"	6	3/8	\$80.20	\$92.20
7	.1404 - .1559	1-1/2	2-1/2	4	5/32	\$32.80	\$37.80	22	.3748 - .3903	2-7/8	4"	6	25/64	\$90.50	\$105.50
8	.1560 - .1716	1-3/4	2-3/4	4	11/64	\$36.80	\$41.80	23	.3904 - .4059	2-7/8	4"	6	13/32	\$102.00	\$117.00
9	.1717 - .1872	1-3/4	2-3/4	4	3/16	\$38.50	\$43.50	24	.4060 - .4216	2-7/8	4"	6	27/64	\$112.00	\$127.00
10	.1873 - .2028	2"	3"	4	13/64	\$41.00	\$48.00	25	.4217 - .4372	2-7/8	4"	6	7/16	\$115.00	\$130.00
11	.2029 - .2185	2"	3"	4	7/32	\$44.10	\$51.10	26	.4373 - .4528	2-7/8	4"	6	29/64	\$120.00	\$136.00
12	.2186 - .2341	2"	3"	4	15/64	\$46.40	\$53.40	27	.4529 - .4685	2-7/8	4"	6	15/32	\$121.00	\$137.00
13	.2342 - .2497	2"	3"	4	1/4	\$50.40	\$57.40	28	.4686 - .4841	2-7/8	4"	6	31/64	\$124.00	\$140.00
14	.2498 - .2653	2-1/4	3-1/2	6	17/64	\$51.90	\$62.90	29	.4842 - .4997	2-7/8	4"	6	1/2	\$125.00	\$141.00
15	.2654 - .2809	2-1/4	3-1/2	6	9/32	\$55.60	\$66.60								

LOR equals flute length (1/2 LOR) plus neck clearance (1/2 LOR).

Long Length • Steel Shank / Carbide Head Reamers by ULTRATOOL®

Series 453

Long Length • Straight Flute • RH Cut

0° HELIX
RH
4, 6, or 8
Flutes

Series 453R

Long Length • RH Spiral • RH Cut

12° HELIX
RH SPIRAL
4, 6, or 8
Flutes

Series 453L

Long Length • LH Spiral • RH Cut

12° HELIX
LH SPIRAL
4, 6, or 8
Flutes

Now it's easier than ever to purchase the Ultra-Tool® line of precision carbide reamers (featuring the industry's tightest tolerances). We've eliminated all quantity breaks and published one low price. Best of all, uncoated, in-stock semis (up to 6 pieces) are guaranteed to ship the day after we receive an order or we'll pay for standard next day delivery (see Terms & Conditions). We've even added a pricing column for SmoothCoat TA, our most versatile TiAlN coating. Performed in-house, TA will add only 1-3 business days to delivery and includes SmoothEdge 1 edge prep.

Decimal Sizes



Reamer Specs: 45° Lead
Cutting Diam +.0002/-0.000
Shank Diam +.0005/-0.0005



Metric Sizes



Reamer Specs (Metric): 45° Lead
Cutting Diam +0.005/-0.000mm
Shank Diam +0.013/-0.013mm

Group	Diam Range	LOC	OAL	Flutes	Shank	Price	Coated	Shank	Flutes	OAL	LOC	Diam Range	Group
1*	.1105 - .1284	7/8	3-1/2	4	.1094	\$48.50	\$53.50	2.5mm	4	89	22	2.81 - 3.26mm	1*
2*	.1285 - .1444	7/8	4"	4	.1250	\$53.00	\$58.00	3.0mm	4	102	22	3.27 - 3.67mm	2*
3*	.1445 - .1594	1"	4"	4	.1406	\$57.00	\$63.50	3.5mm	4	102	25	3.68 - 4.05mm	3*
4*	.1595 - .1744	1"	4-1/2	4	.1562	\$62.50	\$71.00	3.5mm	4	114	25	4.06 - 4.43mm	4*
5*	.1745 - .1914	1"	4-1/2	4	.1719	\$65.50	\$74.00	4.0mm	4	114	25	4.44 - 4.86mm	5*
6	.1915 - .2234	1-1/4	5"	6	.1875	\$73.50	\$82.00	4.5mm	6	127	32	4.87 - 5.67mm	6
7	.2235 - .2544	1-1/4	6"	6	.2188	\$75.50	\$86.50	5.5mm	6	152	32	5.68 - 6.46mm	7
8	.2545 - .2844	1-1/4	6"	6	.2344	\$83.50	\$94.50	6.0mm	6	152	32	6.47 - 7.22mm	8
9	.2845 - .3164	1-1/2	6"	6	.2500	\$92.50	\$103.50	6.0mm	6	152	32	7.23 - 8.04mm	9
10	.3165 - .3484	1-1/2	6"	6	.2969	\$108.50	\$123.50	7.5mm	6	152	38	8.05 - 8.85mm	10
11	.3485 - .3794	1-1/2	7"	6	.3125	\$118.00	\$138.00	8.0mm	6	178	38	8.86 - 9.64mm	11
12	.3795 - .4104	1-3/4	7"	6	.3438	\$132.00	\$154.00	8.0mm	6	178	44	9.65 - 10.42mm	12
13	.4105 - .4414	1-3/4	7"	6	.3750	\$140.00	\$162.00	9.5mm	6	178	44	10.43 - 11.21mm	13
14	.4415 - .4724	1-3/4	8"	6	.4062	\$148.00	\$176.00	10.0mm	6	203	44	11.22 - 12.00mm	14
15	.4725 - .5054	1-3/4	8"	6	.4375	\$158.00	\$186.00	11.0mm	6	203	44	12.01 - 12.84mm	15
16	.5055 - .5670	1-7/8	9"	6	.4844	\$174.00	\$210.00	12.0mm	6	229	48	12.85 - 14.40mm	16
17	.5671 - .6300	1-7/8	9"	6	.5312	\$194.50	\$236.50	13.5mm	6	229	48	14.41 - 16.00mm	17
18	.6301 - .6930	2"	9-1/2	6	.5625	\$237.50	\$279.50	14.0mm	6	241	51	16.01 - 17.60mm	18
19	.6931 - .7560	2"	9-1/2	6	.6250	\$279.50	\$323.50	15.0mm	6	241	51	17.61 - 19.20mm	19
20	.7561 - .7870	2"	10"	8	.6250	\$340.50	\$384.50	15.0mm	8	254	51	19.21 - 19.99mm	20
21	.7871 - .8190	2"	10"	8	.7500	\$347.00	\$397.00	18.0mm	8	254	51	20.00 - 20.80mm	21
22	.8191 - .8500	2"	10"	8	.7500	\$350.50	\$400.50	18.0mm	8	254	51	20.81 - 21.59mm	22
23	.8501 - .8820	2"	10"	8	.7500	\$354.00	\$409.00	18.0mm	8	254	51	21.60 - 22.40mm	23
24	.8821 - .9120	2"	10"	8	.7500	\$415.00	\$470.00	18.0mm	8	254	51	22.41 - 23.16mm	24
25	.9121 - .9440	2"	10"	8	.7500	\$418.00	\$478.00	18.0mm	8	254	51	23.17 - 23.98mm	25
26	.9441 - .9760	2"	10"	8	.7500	\$422.50	\$482.50	18.0mm	8	254	51	23.99 - 24.79mm	26
27	.9761 - 1.010	2"	10"	8	.7500	\$425.00	\$485.00	18.0mm	8	254	51	24.80 - 25.65mm	27

*Solid Carbide construction on these sizes only; All 453, 453R, & 453L Series feature female-centers on both ends.

ULTRATOOL® Extra-Long Small Diameter Solid Carbide Reamers

The Ultra-Tool® Series 453XL is a 6" overall extra-long reamer. Precision ground with 6 straight flutes, the 453XL allows increased reach and tight tolerances on smaller hole diameters. Available with TA coating.



Reamer Specs: 45° Lead
Cutting Diam +.0002/-0.000
Shank Diam +.0005/-0.0005

Series 453XL

Extra-Long Length Reamers • Straight Flute • RH Cut

ULTRATOOL

Decimal Sizes

Group	Diam Range	LOC	OAL	Flutes	Shank
1	.0395 - .0484	7/8	6"	6	.0312
2	.0485 - .0574	7/8	6"	6	.0469
3	.0575 - .0654	7/8	6"	6	.0469
4	.0655 - .0804	7/8	6"	6	.0625
5	.0805 - .0964	7/8	6"	6	.0781
6	.0965 - .1124	7/8	6"	6	.0938
7	.1125 - .1284	7/8	6"	6	.1094
8	.1285 - .1444	7/8	6"	6	.1250
9	.1445 - .1594	1"	6"	6	.1406
10	.1595 - .1744	1"	6"	6	.1562
11	.1745 - .1914	1"	6"	6	.1719
12	.1915 - .2234	1-1/4	6"	6	.1875

Solid carbide construction with male centers.

Metric Sizes

Shank	Flutes	OAL	LOC	Diam Range	Group
0.7mm	6	152	22	1.00 - 1.23mm	1
1.0mm	6	152	22	1.24 - 1.45mm	2
1.0mm	6	152	22	1.46 - 1.66mm	3
1.5mm	6	152	22	1.67 - 2.04mm	4
1.9mm	6	152	22	2.05 - 2.45mm	5
2.2mm	6	152	22	2.46 - 2.85mm	6
2.5mm	6	152	22	2.86 - 3.26mm	7
3.0mm	6	152	22	3.27 - 3.66mm	8
3.5mm	6	152	25	3.67 - 4.05mm	9
3.5mm	6	152	25	4.06 - 4.43mm	10
4.0mm	6	152	25	4.44 - 4.86mm	11
4.5mm	6	152	32	4.87 - 5.67mm	12



Solid Carbide Fiberglass Routers by ULTRATOOL



Series 220

No End Cut

Series 221

Burr Style End

Series 222

End Mill Style

Series 223

135° Drill Point

Series 224

Fish Tail Cut

Ultra's D1 PVD Diamond coating is the perfect complement for routing abrasive materials with our 220 Series. The smoothness of our sputter based process helps evacuate the material up and out of the cut with superb lubricity. The hardness of D1's multi-layered surface lends outstanding wear characteristics when routing in the types of material for which the Series is designed. Add D1 as a suffix to the EDP #.



Diam	LOC	OAL	Shank	220 EDP#	Price	D1 Coated	221 EDP#	222 EDP#	223 EDP#	224 EDP#	Price	D1 Coated
1/8	1/2	1-1/2	1/8	22001	\$9.50	\$19.20	22101	22201	22301	22401	\$11.80	\$21.50
3/16	5/8	2"	3/16	22002	\$14.30	\$25.50	22102	22202	22302	22402	\$18.60	\$29.80
1/4	3/4	2-1/2	1/4	22003	\$16.10	\$29.90	22103	22203	22303	22403	\$21.00	\$34.80
1/4A	1"	3"	1/4	22007	\$20.90	\$34.70	22107	22207	22307	22407	\$27.30	\$41.10
5/16	1"	2-1/2	5/16	22004	\$27.40	\$44.50	22104	22204	22304	22404	\$36.50	\$54.30
3/8	1"	2-1/2	3/8	22005	\$31.50	\$49.70	22105	22205	22305	22405	\$40.50	\$58.70
1/2	1"	3"	1/2	22006	\$51.50	\$76.50	22106	22206	22306	22406	\$65.50	\$90.50
Metric Diameters												
6.0mm	19	63	6.0mm	22008	\$16.10	\$29.90	22108	22208	22308	22408	\$21.00	\$34.80
6.0mm	25	76	6.0mm	22009	\$20.90	\$34.70	22109	22209	22309	22409	\$27.30	\$41.10
8.0mm	25	63	8.0mm	22010	\$27.40	\$44.50	22110	22210	22310	22410	\$36.50	\$54.30
10.0mm	25	70	10.0mm	22011	\$42.80	\$65.50	22111	22211	22311	22411	\$53.50	\$76.20
12.0mm	25	76	12.0mm	22012	\$51.50	\$76.50	22112	22212	22312	22412	\$65.50	\$90.50



Router Specifications:
Cutting Diam +.000/-0.005
Shank Diam +.0000/-0.0003



Router Specifications (Metric):
Cutting Diam +0.000/-0.127mm
Shank Diam +0.000/-0.007

ULTRATOOL Carbide Boring Bars

Series 471

Solid Carbide Jig Boring Tool
Straight Flute • Straight Shank • RH Cut



Tool #	Min Hole Diam	Max Hole Depth	OAL	Shank Diam	EDP#	Price	Coated Price
F-0	.090	1/2	1-1/2	1/8	47100	\$20.70	\$23.50
F-1	.120	5/8	1-1/2	1/8	47101	\$20.70	\$23.50
F-2	.150	3/4	2"	3/16	47102	\$28.50	\$32.00
F-3	.180	1"	2"	3/16	47103	\$28.70	\$32.20
F-4	.210	1-1/4	2-1/2	1/4	47104	\$33.70	\$40.30
F-5	.240	1-1/4	2-1/2	1/4	47105	\$34.40	\$41.00
F-6	.270	1-1/4	2-1/2	5/16	47106	\$47.40	\$55.40
F-7	.300	1-1/4	2-1/2	5/16	47107	\$48.30	\$56.30
F-8	.330	1-1/2	2-1/2	3/8	47108	\$51.40	\$60.00
F-9	.360	1-1/2	2-1/2	3/8	47109	\$52.10	\$60.70

ULTRATOOL Carbide Grinding Tools

Series 290

45° Lead Chamfer & End-Cutting • RH Cut
Reduced Neck Diameter for Clearance
Solid Carbide Construction



Diam	LOC	Shank	Neck Length	OAL	Tool#	EDP#	Price	Coated Price
1/16	3/32	1/8	3/8	1-1/2	XA	29001	\$16.70	\$19.50
3/32	3/32	1/8	3/8	1-1/2	XB	29002	\$16.40	\$19.20
1/8	1/8	1/8	1/2	1-1/2	XC	29003	\$16.10	\$18.90
5/32	3/16	3/16	5/8	2"	XD	29004	\$22.90	\$26.40
3/16	3/16	3/16	5/8	2"	XF	29005	\$23.10	\$26.60
7/32	7/32	1/4	3/4	2"	XH	29006	\$27.30	\$32.80
1/4	1/4	1/4	3/4	2"	XE	29007	\$26.90	\$32.40



Tool Alliance®



Project 74 is a new initiative from Tool Alliance to create efficiency in and encourage greater amounts of Tungsten recovery and recycling. Tens of thousands of cutting tool consumers have boxes, buckets, and barrels of used carbide hard scrap consisting of inserts, end mills, drills, and the like. Project 74, named after Tungsten's element number, is designed to allow consumers and distributors alike to exchange scrap for new products offered by Ultra-Tool®, Mil-Tec®, RoundTool Laboratories®, Tungsten ToolWorks®, or Routco® brands of solid carbide rotary tools.

Although Tool Alliance companies do not use reclaimed materials for their own products, recycled Tungsten is used in a variety of industries such as oil and natural gas drilling, road construction, mining, and lower end types of cutting tools. Importantly every reclaimed kilo or pound used for these purposes is one less that must be mined from the Earth. As most of the world's Tungsten is under control of a single foreign government, conservation not only is beneficial from an environmental standpoint, but protects against pricing fluctuations caused by artificial constraints of supply and contributes to improved national security.

Additionally, Tool Alliance has been advised by our CPA's that credits received under this program may be treated as "like kind exchange" and therefore non-taxable transactions. Consult your own tax expert for proper treatment under your local tax jurisdictions.

Every pound of hard scrap submitted will entitle the consumer to a spot price of Tool Alliance credits. Credits will be available for use after final testing and weight analysis is concluded. Market spot price, credit redemption rules, packing slips and address labels are available at toolalliance.com or your Inside Sales Representative.

Please note this program is for solid Tungsten Carbide hard scrap only. Sort out all high-speed and other non-carbide materials (such as brazed tools) before shipment. Failure to do so could result in delay of credit receipt and a substantial sorting charge. Please allow up to 12 weeks for proper allocation of credits to account.

ULTRATOOL Carbide Countersinks

ULTRA-Grain®

Series 910 Carbide Six-Flute Countersinks For use in hardened materials



*Set 910 consists of 1/4, 3/8, 1/2, 5/8, and 3/4" sizes in a custom-made, reusable steel index.

Diam	Shank	OAL	60° EDP#	82° EDP#	90° EDP#	100° EDP#	910 Price	Coated
1/8	1/8	1-1/2	91008	91708	91808	91864	\$12.60	\$15.40
3/16	3/16	2"	91012	91712	91812	91860	\$13.40	\$16.90
1/4	1/4	2"	91016	91716	91816	91865	\$18.50	\$24.00
3/8	1/4	2-5/8	91024	91724	91824	91863	\$26.30	\$35.30
1/2	1/4	2-5/8	91032	91732	91832	91866	\$38.30	\$49.80
5/8	3/8	2-3/4	91036	91736	91836	91867	\$56.10	\$71.60
3/4	3/8	2-3/4	91040	91740	91840	91868	\$78.70	\$96.60
1"	1/2	3"	91048	91748	91848	91855	\$127.60	\$150.50
1-1/4	3/4	3-1/4	91050	91750	91850	91856	\$199.50	\$248.10
1-1/2	3/4	3-1/4	91054	91754	91854	91857	\$297.90	\$361.20
Set*	5-piece		80360	80382	80390	80392	\$228.10	\$287.50

Series 911 Carbide Single-Flute Countersinks For use in soft materials



*Set 911 consists of 1/4, 3/8, 1/2, 5/8, and 3/4" sizes in a custom-made, reusable steel index.

Diam	Shank	OAL	60° EDP#	82° EDP#	90° EDP#	100° EDP#	911 Price	Coated
1/8	1/8	1-1/2	91108	91508	91608	91869	\$12.60	\$15.40
3/16	3/16	2"	91112	91512	91612	91870	\$13.40	\$16.90
1/4	1/4	2"	91116	91516	91616	91871	\$18.50	\$24.00
3/8	1/4	2-5/8	91124	91524	91624	91872	\$26.30	\$35.30
1/2	1/4	2-5/8	91132	91532	91632	91873	\$38.30	\$49.80
5/8	3/8	2-3/4	91136	91536	91636	91874	\$56.10	\$71.60
3/4	3/8	2-3/4	91140	91540	91640	91875	\$78.70	\$96.60
1"	1/2	3"	91148	91548	91648	91876	\$127.60	\$150.50
1-1/4	3/4	3-1/4	91150	91550	91650	91877	\$199.50	\$248.10
Set*	5-piece		80460	80482	80490	80492	\$228.10	\$287.50

Series 912 Carbide Three-Flute Countersinks For use in general purpose materials



*Set 912 consists of 1/4, 3/8, 1/2, 5/8, and 3/4" sizes in a custom-made, reusable steel index.

Diam	Shank	OAL	60° EDP#	82° EDP#	90° EDP#	100° EDP#	912 Price	Coated
1/8	1/8	1-1/2	91208	91308	91408	91878	\$12.60	\$15.40
3/16	3/16	2"	91212	91312	91412	91879	\$13.40	\$16.90
1/4	1/4	2"	91216	91316	91416	91880	\$18.50	\$24.00
3/8	1/4	2-5/8	91224	91324	91424	91881	\$26.30	\$35.30
1/2	1/4	2-5/8	91232	91332	91432	91882	\$38.30	\$49.80
5/8	3/8	2-3/4	91236	91336	91436	91883	\$56.10	\$71.60
3/4	3/8	2-3/4	91240	91340	91440	91884	\$78.70	\$96.60
1"	1/2	3"	91248	91348	91448	91885	\$127.60	\$150.50
1-1/4	3/4	3-1/4	91250	91350	91450	91886	\$199.50	\$248.10
Set*	5-piece		80560	80582	80590	80592	\$228.10	\$287.50

All countersinks 3/8" and higher are two-piece construction; carbide head induction-brazed to hardened steel shank. Note OAL may vary slightly due to angle differences.

ULTRATOOL Carbide Center Laps

Series 913 Carbide Center Laps w/60° Included Angle



Diam	Shank	OAL	Flutes	EDP#	Price	Coated
1/4	1/4	2"	6	90016	\$18.50	\$24.00
5/16	1/4	2-5/8	6	90020	\$26.00	\$35.00
3/8	1/4	2-5/8	6	90024	\$26.30	\$35.30
1/2	1/4	2-5/8	6	90032	\$38.30	\$49.80
5/8	3/8	2-3/4	8	90040	\$62.40	\$77.90
3/4	3/8	2-3/4	10	90048	\$92.40	\$110.30

5/16" and larger are two-piece construction; solid carbide head w/ steel shank.



Our Countersink, Drill, and Burr Sets are housed in metal, reusable indexes custom manufactured for Ultra-Tool®.

Solid Carbide ULTRA TOOL Keyseat Cutters

Series 610

Solid Carbide Keyseat Cutters One-Piece Construction



Ultra's Series 610 Keyseat Cutter is all solid, all the time. Not only is there no braze joint to fail, but we use a premium carbide grade with superb Transverse Rupture Strength to mitigate breakage. Utilizing our Express Service we offer special face widths, radii, extended necks, reduced shanks and more with extremely quick turnaround times. Plus, the Series 610 is now available with any of our SmoothCoat standard coatings at one low price.

Shank Diameter = 1/2" (12.7mm)
Neck length = 1/4" (6.3mm)



Diam	Face Width	Face Width	ASA#	Flutes	Neck Diam	OAL	EDP#	Price	Coated
3/8	.0312	1/32	-	8	13/64	2-1/32	61030	\$71.30	\$82.80
3/8	.0469	3/64	-	8	13/64	2-3/64	61031	\$71.30	\$82.80
3/8	.0625	1/16	203	8	13/64	2-1/16	61029	\$71.30	\$82.80
3/8	.0938	3/32	303	8	13/64	2-3/32	61001	\$71.30	\$82.80
3/8	.1250	1/8	403	8	13/64	2-1/8	61002	\$71.30	\$82.80
1/2	.0312	1/32	-	10	1/4	2-1/32	61032	\$80.20	\$91.70
1/2	.0469	3/64	-	10	1/4	2-3/64	61033	\$80.20	\$91.70
1/2	.0625	1/16	204	10	1/4	2-1/16	61034	\$80.20	\$91.70
1/2	.0781	5/64	-	10	1/4	2-5/64	61035	\$80.20	\$91.70
1/2	.0938	3/32	304	10	1/4	2-3/32	61003	\$80.20	\$91.70
1/2	.1094	7/64	-	10	1/4	2-7/64	61036	\$80.20	\$91.70
1/2	.1250	1/8	404	10	1/4	2-1/8	61004	\$80.20	\$91.70
5/8	.0312	1/32	-	10	9/32	2-1/32	61037	\$92.70	\$108.00
5/8	.0469	3/64	-	10	9/32	2-3/64	61038	\$92.70	\$108.00
5/8	.0625	1/16	-	10	9/32	2-1/16	61039	\$92.70	\$108.00
5/8	.0781	5/64	-	10	9/32	2-5/64	61040	\$92.70	\$108.00
5/8	.0938	3/32	305	10	9/32	2-3/32	61005	\$92.70	\$108.00
5/8	.1094	7/64	-	10	9/32	2-7/64	61041	\$92.70	\$108.00
5/8	.1250	1/8	405	10	9/32	2-1/8	61006	\$92.70	\$108.00
5/8	.1406	9/64	-	10	9/32	2-9/64	61042	\$92.70	\$108.00
5/8	.1562	5/32	505	10	9/32	2-5/32	61007	\$92.70	\$108.00
5/8	.1875	3/16	605	10	9/32	2-3/16	61008	\$92.70	\$108.00
3/4	.0312	1/32	-	10	9/32	2-1/32	61043	\$118.90	\$137.00
3/4	.0469	3/64	-	10	9/32	2-3/64	61044	\$118.90	\$137.00
3/4	.0625	1/16	-	10	9/32	2-1/16	61045	\$118.90	\$137.00
3/4	.0781	5/64	-	10	9/32	2-5/64	61046	\$118.90	\$137.00
3/4	.0938	3/32	-	10	9/32	2-3/32	61047	\$118.90	\$137.00
3/4	.1094	7/64	-	10	9/32	2-7/64	61048	\$118.90	\$137.00
3/4	.1250	1/8	406	10	9/32	2-1/8	61009	\$118.90	\$137.00
3/4	.1406	9/64	-	10	9/32	2-9/64	61049	\$118.90	\$137.00
3/4	.1562	5/32	506	10	9/32	2-5/32	61010	\$118.90	\$137.00
3/4	.1875	3/16	606	10	9/32	2-3/16	61011	\$118.90	\$137.00
3/4	.2031	13/64	-	10	9/32	2-13/64	61050	\$118.90	\$137.00
3/4	.2188	7/32	-	10	9/32	2-7/32	61051	\$118.90	\$137.00
3/4	.2344	15/64	-	10	9/32	2-15/64	61052	\$118.90	\$137.00
3/4	.2500	1/4	806	10	9/32	2-1/4	61012	\$118.90	\$137.00
7/8	.0625	1/16	-	12	9/32	2-1/16	61053	\$144.90	\$165.00
7/8	.1250	1/8	-	12	9/32	2-1/8	61054	\$144.90	\$165.00
7/8	.1562	5/32	507	12	9/32	2-5/32	61013	\$144.90	\$165.00
7/8	.1875	3/16	607	12	9/32	2-3/16	61014	\$144.90	\$165.00
7/8	.2188	7/32	707	12	9/32	2-7/32	61015	\$144.90	\$165.00
7/8	.2500	1/4	807	12	9/32	2-1/4	61016	\$144.90	\$165.00
1"	.0312	1/32	-	12	9/32	2-1/32	61055	\$163.90	\$187.00
1"	.0469	3/64	-	12	9/32	2-3/64	61056	\$163.90	\$187.00
1"	.0625	1/16	-	12	9/32	2-1/16	61057	\$163.90	\$187.00
1"	.0781	5/64	-	12	9/32	2-5/64	61058	\$163.90	\$187.00
1"	.0938	3/32	-	12	9/32	2-3/32	61059	\$163.90	\$187.00
1"	.1250	1/8	-	12	9/32	2-1/8	61060	\$163.90	\$187.00
1"	.1562	5/32	-	12	9/32	2-5/32	61061	\$163.90	\$187.00
1"	.1875	3/16	608	12	9/32	2-3/16	61017	\$163.90	\$187.00
1"	.2188	7/32	708	12	9/32	2-7/32	61018	\$163.90	\$187.00
1"	.2500	1/4	808	12	9/32	2-1/4	61019	\$163.90	\$187.00

Diam	Face Width	Face Width	ASA#	Flutes	Neck Diam	OAL	EDP#	Price	Coated
1-1/8	.1250	1/8	-	14	9/32	2-1/8	61062	\$205.90	\$240.00
1-1/8	.1875	3/16	609	14	9/32	2-3/16	61020	\$205.90	\$240.00
1-1/8	.2188	7/32	709	14	9/32	2-7/32	61021	\$205.90	\$240.00
1-1/8	.2500	1/4	809	14	9/32	2-1/4	61022	\$205.90	\$240.00
1-1/4	.0312	1/32	-	14	9/32	2-1/32	61063	\$212.40	\$248.50
1-1/4	.0625	1/16	-	14	9/32	2-1/16	61064	\$212.40	\$248.50
1-1/4	.0938	3/32	-	14	9/32	2-3/32	61065	\$212.40	\$248.50
1-1/4	.1250	1/8	-	14	9/32	2-1/8	61066	\$212.40	\$248.50
1-1/4	.1562	5/32	-	14	9/32	2-5/32	61067	\$212.40	\$248.50
1-1/4	.1875	3/16	610	14	9/32	2-3/16	61023	\$212.40	\$248.50
1-1/4	.2188	7/32	710	14	9/32	2-7/32	61024	\$212.40	\$248.50
1-1/4	.2500	1/4	810	14	9/32	2-1/4	61025	\$212.40	\$248.50
1-1/2	.0312	1/32	-	16	5/16	2-1/32	61068	\$270.80	\$315.00
1-1/2	.0625	1/16	-	16	5/16	2-1/16	61069	\$270.80	\$315.00
1-1/2	.0938	3/32	-	16	5/16	2-3/32	61070	\$270.80	\$315.00
1-1/2	.1250	1/8	-	16	5/16	2-1/8	61071	\$270.80	\$315.00
1-1/2	.1875	3/16	-	16	5/16	2-3/16	61072	\$270.80	\$315.00
1-1/2	.2500	1/4	812	16	5/16	2-1/4	61026	\$270.80	\$315.00
1-1/2	.3125	5/16	1012	16	5/16	2-5/16	61027	\$270.80	\$315.00
1-1/2	.3750	3/8	1212	16	5/16	2-3/8	61028	\$270.80	\$315.00

Metric Widths

Diam	Face Width	Face Width	Flutes	Neck Diam	OAL	EDP#	Price	Coated
9.5mm	1.0mm	.0394	8	5.2	52	61100	\$71.30	\$82.80
9.5mm	2.0mm	.0787	8	5.2	53	61104	\$71.30	\$82.80
9.5mm	3.0mm	.1181	8	5.2	54	61108	\$71.30	\$82.80
12.7mm	2.0mm	.0787	10	6.3	53	61112	\$80.20	\$91.70
12.7mm	3.0mm	.1181	10	6.3	54	61116	\$80.20	\$91.70
15.9mm	2.0mm	.0787	10	7.1	53	61120	\$92.70	\$108.00
15.9mm	3.0mm	.1181	10	7.1	54	61124	\$92.70	\$108.00
15.9mm	4.0mm	.1575	10	7.1	55	61128	\$92.70	\$108.00
19.1mm	3.0mm	.1181	10	7.1	54	61132	\$118.90	\$137.00
19.1mm	4.0mm	.1575	10	7.1	55	61136	\$118.90	\$137.00
19.1mm	5.0mm	.1969	10	7.1	56	61140	\$118.90	\$137.00
19.1mm	6.0mm	.2362	10	7.1	57	61144	\$118.90	\$137.00
22.2mm	3.0mm	.1181	12	7.1	54	61148	\$144.90	\$165.00
22.2mm	4.0mm	.1575	12	7.1	55	61152	\$144.90	\$165.00
22.2mm	5.0mm	.1969	12	7.1	56	61156	\$144.90	\$165.00
22.2mm	6.0mm	.2362	12	7.1	57	61160	\$144.90	\$165.00
25.4mm	4.0mm	.1575	12	7.1	55	61164	\$163.90	\$187.00
25.4mm	5.0mm	.1969	12	7.1	56	61168	\$163.90	\$187.00
25.4mm	6.0mm	.2362	12	7.1	57	61172	\$163.90	\$187.00
28.6mm	4.0mm	.1575	14	7.1	55	61176	\$205.90	\$240.00
28.6mm	5.0mm	.1969	14	7.1	56	61180	\$205.90	\$240.00
28.6mm	6.0mm	.2362	14	7.1	57	61184	\$205.90	\$240.00
31.8mm	4.0mm	.1575	14	7.1	55	61188	\$212.40	\$248.50
31.8mm	5.0mm	.1969	14	7.1	56	61192	\$212.40	\$248.50
31.8mm	6.0mm	.2362	14	7.1	57	61196	\$212.40	\$248.50
38.1mm	6.0mm	.2362	16	7.9	57	61200	\$270.80	\$315.00
38.1mm	7.0mm	.2756	16	7.9	58	61204	\$270.80	\$315.00
38.1mm	8.0mm	.3150	16	7.9	59	61208	\$270.80	\$315.00

Keyseat Specifications:
Head Diam (3/8" to 3/4") +.010/-0.015
Head Diam (7/8" to 1-1/2") +.012/-0.017
Face Width +.0000/-0.0005 Neck Length 1/4"

Keyseat Specifications (Metric):
Head Diam (9.5mm to 19.1mm) +0.25/-0.38mm
Head Diam (22.2 to 38.1mm) +0.30/-0.43mm
Face Width +0.000/-0.013mm Neck Length 6.3mm

Solid Carbide Saws by ULTRATOOL®

Ordering our Series 620 Solid Carbide Saws has never been easier. Size ranges and quantity breaks have been consolidated; simply note the semi-blank EDP# for the diameter of your need and specify the decimal thickness. Pricing inclusive of our in-house SmoothCoat® PVD hardcoating is also listed. All Ultra-Tool® saws are manufactured in our factories featuring 100% CNC generated fluting and relief angles. Available in 24-Hours via Ultra's Express Service. Special radii, chamfers, hubs, and angles also available via Express Service. Special sizes, thicknesses, ID's, keyways, etc. are available upon quotation request.

Series 620 Solid Carbide Saws

ULTRA-Carb®



Diam	Thickness Range	ID	# Teeth	Blank EDP#	Price	Coated Price
3/4"	.008 - .125	1/4"	18	63001	\$51.50	\$58.00
1"	.010 - .125	3/8"	20	62019	\$67.50	\$74.00
1-1/4"	.010 - .125	1/2"	24	63005	\$73.00	\$79.50
1-1/2"	.010 - .125	1/2"	36	62029	\$80.50	\$87.00
1-3/4"	.010 - .125	1/2"	38	63010	\$100.50	\$107.00
2"	.010 - .125	1/2"	40	62039	\$120.00	\$128.00
2"	.010 - .125	1"	40	63015	\$120.00	\$128.00
2-1/4"	.010 - .125	5/8"	44	63020	\$132.00	\$144.00
2-1/2"	.010 - .125	1"	48	62049	\$145.50	\$157.50
2-3/4"	.010 - .125	1"	60	63025	\$198.50	\$212.50
3"	.010 - .125	1"	72	62059	\$232.00	\$250.00
3"	.126 - .250	1"	72	62064	\$328.00	\$353.00
4"	.020 - .125	1"	80	62069	\$295.00	\$320.00
4"	.126 - .250	1"	80	62074	\$460.00	\$490.00

Saw Specifications:
Diameter $\pm .015$ Thickness $\pm .00025$
Hole (ID) $+.0005/-0.0000$

Metric Sizes

Diam	Thickness Range	ID	# Teeth	Blank EDP#	Price	Coated Price
20.0mm	0.20 - 3.15	5.0	20	63050	\$57.50	\$64.00
25.0mm	0.25 - 3.15	8.0	24	63055	\$68.50	\$75.00
32.0mm	0.25 - 3.15	8.0	30	63060	\$77.50	\$84.00
40.0mm	0.25 - 3.15	10.0	36	63065	\$100.50	\$107.00
50.0mm	0.25 - 3.15	13.0	40	63070	\$120.00	\$128.00
63.0mm	0.25 - 3.15	16.0	48	63075	\$145.50	\$157.50
80.0mm	0.35 - 3.15	22.0	60	63080	\$237.50	\$255.50
100.0mm	0.50 - 3.15	22.0	72	63085	\$295.00	\$320.00

Saw Specifications (Metric):
Diameter $\pm 0.38\text{mm}$ Thickness $\pm 0.006\text{mm}$
Hole (ID) $+0.013/-0.000\text{mm}$

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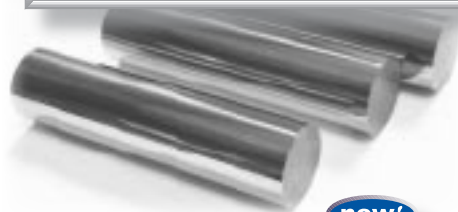


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 Series 650
 Solid Carbide Blanks

Diam	Dec.	OAL	EDP#	Price
#69	.0292	1-1/4	65301	\$5.00
#68	.0310	1-1/4	65302	\$5.00
1/32	.0312	1-1/4	65303	\$5.00
#67	.0320	1-1/4	65304	\$5.00
#66	.0330	1-1/4	65305	\$4.80
#65	.0350	1-1/2	65306	\$4.80
#64	.0360	1-1/2	65307	\$4.80
#63	.0370	1-1/2	65308	\$4.80
#62	.0380	1-1/2	65309	\$4.80
#61	.0390	1-1/2	65310	\$4.60
#60	.0400	1-1/2	65312	\$4.60
#59	.0410	1-1/2	65313	\$4.60
#58	.0420	1-1/2	65314	\$4.60
#57	.0430	1-1/2	65315	\$4.60
#56	.0465	1-1/2	65316	\$4.60
3/64	.0469	1-1/2	65317	\$4.60
#55	.0520	1-1/2	65318	\$4.60
#54	.0550	1-1/2	65319	\$4.60
#53	.0595	1-1/2	65321	\$4.60
1/16	.0625	1-1/2	65001	\$4.20
#52	.0635	1-1/2	65322	\$4.40
#51	.0670	1-1/2	65323	\$4.40
#50	.0700	1-3/4	65325	\$4.40
#50	.0700	2"	65324	\$4.80
#49	.0730	1-3/4	65327	\$4.40
#49	.0730	2"	65326	\$4.80
#48	.0760	1-3/4	65329	\$4.40
#48	.0760	2"	65328	\$4.80
5/64	.0781	1-3/4	65331	\$4.40
5/64	.0781	2"	65330	\$4.80
#47	.0785	1-3/4	65333	\$4.40
#47	.0785	2"	65332	\$4.80
#46	.0810	1-3/4	65337	\$4.40
#46	.0810	2"	65336	\$4.80
#45	.0820	1-3/4	65339	\$4.40
#45	.0820	2"	65338	\$4.80
#44	.0860	2"	65340	\$4.80
#43	.0890	2"	65341	\$4.80
#42	.0935	2"	65342	\$4.80
3/32	.0938	2"	65002	\$4.80
#41	.0960	2"	65343	\$4.80
#40	.0980	2"	65344	\$4.80
#39	.0995	2-1/4	65346	\$5.50
#38	.1015	2-1/4	65347	\$5.50
#37	.1040	2-1/4	65348	\$5.50
#36	.1065	2-1/4	65349	\$5.50
7/64	.1094	2-1/4	65036	\$5.50
#35	.1100	2-1/4	65350	\$5.50
#34	.1110	2-1/4	65351	\$5.50
#33	.1130	2-1/4	65352	\$5.50
#32	.1160	2-1/4	65353	\$5.50
#31	.1200	2-1/4	65355	\$5.50
1/8	.1250	1-1/2	65003	\$3.20

Diam	Dec.	OAL	EDP#	Price
1/8	.1250	2"	65004	\$4.60
1/8	.1250	2-1/4	65037	\$5.70
1/8	.1250	3"	65005	\$5.90
1/8	.1250	4"	65006	\$8.80
1/8	.1250	6"	65007	\$13.60
1/8	.1250	12"	65038	\$30.50
#30	.1285	2-1/4	65356	\$7.90
#29	.1360	2-1/2	65357	\$7.90
#28	.1405	2-1/2	65359	\$7.90
9/64	.1406	2-1/2	65039	\$7.90
#27	.1440	2-1/2	65360	\$9.15
#26	.1470	2-1/2	65361	\$9.15
#25	.1495	2-1/2	65362	\$9.15
#24	.1520	2-1/2	65363	\$9.15
#23	.1540	2-1/2	65364	\$9.15
5/32	.1562	2-1/2	65040	\$9.15
#22	.1570	2-1/2	65365	\$9.60
#21	.1590	2-1/2	65367	\$9.60
#20	.1610	2-1/2	65368	\$9.60
#19	.1660	2-3/4	65369	\$10.20
#18	.1695	2-3/4	65370	\$10.20
11/64	.1719	2-1/2	65372	\$10.00
11/64	.1719	2-3/4	65041	\$10.20
#17	.1730	2-3/4	65373	\$10.20
#16	.1770	2-3/4	65374	\$10.90
#15	.1800	2-1/2	65450	\$9.90
#15	.1800	2-3/4	65376	\$10.90
#14	.1820	2-1/2	65451	\$9.90
#14	.1820	2-3/4	65377	\$10.90
#13	.1850	2-1/2	65452	\$9.90
#13	.1850	2-3/4	65378	\$10.90
3/16	.1875	2"	65008	\$5.80
3/16	.1875	2-1/2	65042	\$9.90
3/16	.1875	2-3/4	65043	\$10.90
3/16	.1875	3"	65009	\$11.20
3/16	.1875	4"	65010	\$13.60
3/16	.1875	6"	65011	\$20.50
3/16	.1875	12"	65044	\$44.90
#12	.1890	2-1/2	65453	\$11.80
#12	.1890	2-3/4	65379	\$12.00
#11	.1910	2-1/2	65454	\$11.80
#11	.1910	2-3/4	65380	\$12.00
#10	.1935	2-3/4	65381	\$12.00
#9	.1960	3"	65382	\$12.30
#8	.1990	3"	65384	\$12.30
#7	.2010	3"	65385	\$12.30
13/64	.2031	2-1/2	65386	\$12.00
13/64	.2031	3"	65045	\$12.30
#6	.2040	3"	65387	\$14.00
#5	.2055	3"	65388	\$14.00
#4	.2090	3"	65389	\$14.00
#3	.2130	3"	65390	\$14.00
7/32	.2188	2-1/2	65392	\$13.50
7/32	.2188	3"	65046	\$14.00
#2	.2210	3"	65393	\$14.75
#1	.2280	3-1/4	65394	\$15.00
A	.2340	2-1/2	65482	\$14.50
A	.2340	3-1/4	65395	\$15.00
15/64	.2344	2-1/2	65396	\$14.50
15/64	.2344	3-1/4	65047	\$15.00
B	.2380	2-1/2	65483	\$15.00
B	.2380	3-1/4	65399	\$15.75

Diam	Dec.	OAL	EDP#	Price
C	.2420	2-1/2	65484	\$15.00
C	.2420	3-1/4	65400	\$15.75
D	.2460	2-1/2	65485	\$15.00
D	.2460	3-1/4	65401	\$15.75
1/4	.2500	2"	65012	\$7.80
1/4	.2500	2-1/2	65013	\$9.00
1/4	.2500	3"	65014	\$13.60
1/4	.2500	3-1/4	65048	\$15.75
1/4	.2500	4"	65015	\$21.00
1/4	.2500	6"	65016	\$31.00
1/4	.2500	12"	65049	\$67.50
F	.2570	2-1/2	65487	\$16.75
F	.2570	3-1/2	65403	\$18.75
G	.2610	2-1/2	65488	\$16.75
G	.2610	3-1/2	65404	\$18.75
17/64	.2656	2-1/2	65405	\$16.75
17/64	.2656	3-1/2	65050	\$18.75
H	.2660	2-1/2	65489	\$16.75
H	.2660	3-1/2	65406	\$18.75
I	.2720	2-1/2	65490	\$19.00
I	.2720	3-1/2	65407	\$22.00
J	.2770	2-1/2	65491	\$19.00
J	.2770	3-1/2	65409	\$22.00
K	.2810	2-1/2	65492	\$19.00
K	.2810	3-1/2	65410	\$22.00
9/32	.2812	2-1/2	65411	\$19.00
9/32	.2812	3-1/2	65051	\$22.00
L	.2900	2-1/2	65493	\$19.50
L	.2900	3-3/4	65412	\$22.50
M	.2950	2-1/2	65494	\$19.50
M	.2950	3-3/4	65413	\$22.50
19/64	.2969	2-1/2	65415	\$19.50
19/64	.2969	3-3/4	65052	\$22.50
N	.3020	2-1/2	65495	\$22.00
N	.3020	3-3/4	65416	\$25.00
5/16	.3125	2-1/2	65017	\$14.30
5/16	.3125	2-3/4	65417	\$21.50
5/16	.3125	3"	65018	\$23.00
5/16	.3125	3-3/4	65053	\$25.00
5/16	.3125	4"	65019	\$28.00
5/16	.3125	6"	65020	\$44.00
5/16	.3125	12"	65054	\$92.00
O	.3160	2-1/2	65496	\$24.00
O	.3160	3-3/4	65420	\$31.00
P	.3230	2-1/2	65497	\$24.00
P	.3230	4"	65421	\$31.00
21/64	.3281	3"	65508	\$25.00
21/64	.3281	4"	65055	\$31.00
Q	.3320	3"	65498	\$26.00
Q	.3320	4"	65422	\$34.00
R	.3390	3"	65499	\$26.00
R	.3390	4"	65424	\$34.00
11/32	.3438	3"	65425	\$26.00
11/32	.3438	4"	65056	\$34.00
S	.3480	3"	65500	\$27.00
S	.3480	4"	65426	\$35.00
T	.3580	3"	65501	\$27.00
T	.3580	4-1/4	65428	\$36.00
23/64	.3594	4-1/4	65057	\$36.00
U	.3680	3"	65502	\$29.00
U	.3680	4-1/4	65429	\$38.50
3/8	.3750	2-1/2	65021	\$19.00

ULTRA TOOL Precision Ground & Polished Solid Carbide Blanks

Diam	Dec.	OAL	EDP#	Price
3/8	.3750	3"	65022	\$26.00
3/8	.3750	4"	65023	\$35.00
3/8	.3750	4-1/4	65058	\$38.50
3/8	.3750	6"	65024	\$56.00
3/8	.3750	12"	65059	\$125.00
V	.3770	3"	65503	\$30.00
V	.3770	4-1/4	65431	\$43.50
W	.3860	3"	65504	\$30.00
W	.3860	4-1/2	65432	\$43.50
25/64	.3906	3"	65433	\$30.00
25/64	.3906	4-1/2	65060	\$43.50
X	.3970	3"	65505	\$32.00
X	.3970	4-1/2	65436	\$45.75
Y	.4040	3"	65506	\$32.00
Y	.4040	4-1/2	65437	\$45.75
13/32	.4062	3"	65438	\$32.00
13/32	.4062	4-1/2	65061	\$45.75
Z	.4130	3"	65507	\$34.00
Z	.4130	4-1/2	65439	\$49.50
27/64	.4219	4-1/2	65062	\$49.50
7/16	.4375	2-3/4	65025	\$30.00
7/16	.4375	3"	65026	\$33.00
7/16	.4375	4"	65027	\$46.00
7/16	.4375	4-1/2	65063	\$52.50
7/16	.4375	6"	65028	\$70.00
7/16	.4375	12"	65064	\$150.00
29/64	.4531	3"	65443	\$41.00
29/64	.4531	4-3/4	65065	\$62.00
15/32	.4688	4-3/4	65066	\$64.50
31/64	.4844	4-3/4	65445	\$65.00
1/2	.5000	2-1/2	65105	\$30.00
1/2	.5000	3"	65029	\$32.50
1/2	.5000	4"	65030	\$46.00
1/2	.5000	4-3/4	65067	\$65.00
1/2	.5000	6"	65031	\$80.00
1/2	.5000	12"	65068	\$170.00
17/32	.5312	6"	65509	\$125.00
9/16	.5625	3-1/2	65032	\$64.00
9/16	.5625	6"	65110	\$130.00
9/16	.5625	12"	65111	\$290.00
19/32	.5938	6"	65510	\$135.00
5/8	.6250	3-1/2	65033	\$70.00
5/8	.6250	5"	65106	\$121.00
5/8	.6250	6"	65069	\$140.00
5/8	.6250	12"	65070	\$320.00
21/32	.6562	6"	65511	\$170.00
11/16	.6875	6"	65512	\$175.00
3/4	.7500	4"	65034	\$105.00
3/4	.7500	5"	65107	\$160.00
3/4	.7500	6"	65071	\$180.00
3/4	.7500	12"	65072	\$380.00
13/16	.8125	6"	65513	\$280.00
7/8	.8750	4"	65075	\$170.00
7/8	.8750	6"	65449	\$300.00
7/8	.8750	12"	65514	\$650.00
15/16	.9375	6"	65515	\$310.00
1"	1.000	4"	65035	\$185.00
1"	1.000	5"	65108	\$280.00
1"	1.000	6"	65073	\$310.00
1"	1.000	12"	65074	\$675.00

Diam	Dec.	OAL	EDP#	Price
1.0mm	.0394	38	65311	\$4.60
1.5mm	.0591	38	65320	\$4.60
2.0mm	.0787	44	65335	\$4.40
2.0mm	.0787	50	65334	\$4.80
2.5mm	.0984	50	65345	\$4.80
3.0mm	.1181	38	65076	\$3.20
3.0mm	.1181	57	65354	\$5.70
3.0mm	.1181	75	65077	\$5.90
3.0mm	.1181	100	65109	\$8.80
3.0mm	.1181	305	65516	\$30.50
3.5mm	.1378	63	65358	\$7.90
3.5mm	.1378	305	65517	\$40.00
4.0mm	.1575	50	65078	\$6.00
4.0mm	.1575	63	65366	\$9.60
4.0mm	.1575	75	65079	\$11.80
4.0mm	.1575	100	65480	\$15.00
4.0mm	.1575	305	65518	\$43.00
4.5mm	.1772	63	65475	\$9.90
4.5mm	.1772	70	65375	\$10.90
4.5mm	.1772	305	65519	\$49.00
5.0mm	.1969	50	65080	\$6.50
5.0mm	.1969	63	65383	\$12.00
5.0mm	.1969	75	65081	\$12.30
5.0mm	.1969	100	65481	\$18.20
5.0mm	.1969	305	65520	\$55.00
5.5mm	.2165	75	65391	\$14.00
5.5mm	.2165	305	65521	\$60.00
6.0mm	.2362	50	65082	\$7.80
6.0mm	.2362	63	65398	\$9.00
6.0mm	.2362	75	65083	\$13.60
6.0mm	.2362	82	65397	\$15.75
6.0mm	.2362	100	65448	\$21.00
6.0mm	.2362	305	65522	\$67.50
6.5mm	.2559	82	65402	\$18.75
6.5mm	.2559	305	65523	\$76.00
7.0mm	.2756	60	65084	\$14.00
7.0mm	.2756	89	65408	\$22.00
7.0mm	.2756	100	65524	\$27.40
7.0mm	.2756	305	65525	\$82.00
7.5mm	.2953	95	65414	\$22.50
7.5mm	.2953	305	65526	\$89.00
8.0mm	.3150	63	65085	\$14.30
8.0mm	.3150	70	65419	\$21.50
8.0mm	.3150	95	65418	\$25.00
8.0mm	.3150	100	65086	\$28.00
8.0mm	.3150	305	65527	\$92.00
8.5mm	.3346	100	65423	\$35.00
8.5mm	.3346	305	65528	\$108.00
9.0mm	.3543	63	65087	\$21.00
9.0mm	.3543	100	65529	\$35.50
9.0mm	.3543	108	65427	\$36.00
9.0mm	.3543	305	65530	\$120.00
9.5mm	.3740	108	65430	\$38.50
10.0mm	.3937	70	65088	\$30.00
10.0mm	.3937	75	65435	\$33.00
10.0mm	.3937	100	65089	\$43.00
10.0mm	.3937	114	65434	\$45.75
10.0mm	.3937	305	65531	\$142.00
10.5mm	.4134	114	65440	\$49.50
11.0mm	.4331	114	65441	\$52.50
11.0mm	.4331	305	65541	\$165.00
11.5mm	.4528	120	65442	\$62.00

Diam	Dec.	OAL	EDP#	Price
12.0mm	.4724	75	65090	\$32.50
12.0mm	.4724	100	65091	\$46.00
12.0mm	.4724	120	65444	\$65.00
12.0mm	.4724	152	65101	\$80.00
12.0mm	.4724	305	65532	\$170.00
12.5mm	.4921	120	65446	\$67.00
14.0mm	.5512	89	65092	\$64.00
14.0mm	.5512	100	65533	\$88.00
14.0mm	.5512	152	65102	\$130.00
14.0mm	.5512	305	65534	\$290.00
16.0mm	.6299	89	65093	\$70.00
16.0mm	.6299	100	65535	\$98.00
16.0mm	.6299	127	65094	\$121.00
16.0mm	.6299	152	65103	\$140.00
16.0mm	.6299	305	65536	\$320.00
18.0mm	.7087	100	65095	\$130.00
18.0mm	.7087	152	65104	\$178.00
18.0mm	.7087	305	65537	\$375.00
20.0mm	.7874	100	65096	\$142.80
20.0mm	.7874	152	65097	\$210.00
20.0mm	.7874	305	65538	\$415.00
22.0mm	.8661	100	65098	\$205.00
22.0mm	.8661	305	65539	\$640.00
25.0mm	.9843	100	65099	\$185.00
25.0mm	.9843	152	65100	\$310.00
25.0mm	.9843	305	65540	\$675.00

Series 650 Tech Information

Ultra-Tool's Series 650 Polished Ground Carbide Cylinders feature the same world-class tungsten carbide substrate we use in all our finished cutting tools. Ultra-Grain has an excellent combination of high hardness & transverse rupture strength. Additionally, although cemented carbides typically feature poor corrosion resistance, our Series 650 offers industry leading specifications for this characteristic as well. These cylinders, like all Ultra-Tool solid carbide products, are Shrink-Fit Ready (SFR).



Ultra-Grain® 1
Cobalt Percentage: 10%
Grain Size (µm): ≤ 0.7
Hardness: 92.7 HRA, 1680 HV
Fracture Toughness (K_{1c}): 7.9
TRS (GPa): 4.1
Density (gm/cc): 14.30

SFR Ground Cyl Specs (Metric):
Diameter +0.000/-0.007mm
OAL ±1.52mm

SFR Ground Cylinder Specs:
Diameter +.0000/- .0003
OAL ±.060

Diameter tolerance is .0005 on lengths of 6" and longer. Lengths of 12" (305 mm) are uncut and will have greater OAL plus + tolerance.



ULTRATOOL® Close Tolerance Extended Length Carbide Blanks

new! Series 650+Plus



These blanks offer extended lengths with incredible size and TIR specifications due to a specialized grinding operation. We use the 650+Plus Series ourselves for extended reach milling and drilling applications.



Ground & Polished Carbide Round Blanks • Extended Length Maximum .0003 TIR • Size +.0000 / -.0003

Diam	OAL	EDP#	Price
1/4	6"	65616	\$48.00
1/4	8"	65617	\$71.50
1/4	12"	65618	\$94.50
5/16	6"	65619	\$61.50
5/16	8"	65620	\$96.50
5/16	12"	65621	\$128.50
3/8	4"	65622	\$52.00
3/8	6"	65623	\$78.50
3/8	8"	65624	\$129.50
3/8	12"	65625	\$175.00
1/2	4"	65626	\$75.00
1/2	6"	65627	\$112.00

Diam	OAL	EDP#	Price
1/2	8"	65628	\$175.00
1/2	12"	65629	\$238.00
5/8	4"	65630	\$125.00
5/8	6"	65631	\$196.00
5/8	8"	65632	\$265.00
5/8	12"	65633	\$410.00
3/4	6"	65634	\$255.00
3/4	8"	65635	\$350.00
3/4	12"	65636	\$510.00
1"	6"	65637	\$430.00
1"	8"	65638	\$572.00
1"	12"	65639	\$850.00

Diam	OAL	EDP#	Price
1-1/4	6"	65640	\$640.00
1-1/4	8"	65641	\$860.00
1-1/4	12"	65642	\$1280.00

SFR 650+Plus Specifications:
Blank Diam +.0000/-0.0003
TIR Max .0003

ULTRATOOL® Engraving Blanks

Series 652



Ground & Polished Carbide Round Blanks • Split Both Ends

SFR Engraving Blank Specs:
Split +.001/-0.000 over center
Diam +.0000/-0.0003 OAL ±.060

Diam	OAL	Split	EDP#	Price
1/8	1-1/2	1/4	65203	\$5.80
1/8	2"	1/4	65204	\$7.00
1/8	3"	1/4	65205	\$13.80
1/8	4"	1/4	65206	\$18.40
1/8	6"	1/4	65207	\$24.70
3/16	2"	1/4	65208	\$11.70
3/16	3"	1/4	65209	\$15.20
3/16	4"	1/4	65210	\$21.20
3/16	6"	1/4	65211	\$30.40
1/4	2"	3/8	65212	\$17.00
1/4	2-1/2	3/8	65213	\$20.00
1/4	3"	3/8	65214	\$24.30
1/4	4"	3/8	65215	\$32.10
1/4	6"	3/8	65216	\$45.30
5/16	2-1/2	3/8	65217	\$29.50
5/16	3"	3/8	65218	\$32.60
5/16	4"	3/8	65219	\$41.80
5/16	6"	3/8	65220	\$51.60
3/8	2-1/2	1/2	65221	\$37.70
3/8	3"	1/2	65222	\$43.80
3/8	4"	1/2	65223	\$58.40
3/8	6"	1/2	65224	\$65.90
7/16	2-3/4	1/2	65225	\$55.60
7/16	3"	1/2	65226	\$56.70
7/16	4"	1/2	65227	\$71.60
7/16	6"	1/2	65228	\$101.40
1/2	3"	1/2	65229	\$57.30
1/2	4"	1/2	65230	\$75.00
1/2	6"	1/2	65231	\$103.60

Series 652 • Metric



Ground & Polished Carbide Round Blanks • Split Both Ends

SFR Engraving Blank Specs (Metric):
Split +0.025/-0.000mm over center
Diam +0.000/-0.007mm
OAL ±1.52mm

Diam	OAL	Split	EDP#	Price
3.0mm	38	6	65232	\$5.80
3.0mm	76	6	65233	\$13.80
4.0mm	50	6	65234	\$11.70
4.0mm	76	6	65235	\$15.50
5.0mm	50	6	65236	\$16.40
5.0mm	76	6	65237	\$22.80
6.0mm	50	9	65238	\$17.00
6.0mm	76	9	65239	\$24.30
7.0mm	60	9	65240	\$29.20
8.0mm	63	9	65241	\$29.50
8.0mm	101	9	65242	\$41.80
9.0mm	63	12	65243	\$44.10
10.0mm	70	12	65244	\$53.90
10.0mm	101	12	65245	\$76.20
12.0mm	76	12	65246	\$57.30
12.0mm	101	12	65247	\$79.60

ULTRATOOL Carbide Rotary Files (Burs)

Only Ultra-Tool® offers a full range of cut styles for your specific application needs. Featuring our proprietary Dura-Cut and Fast-Mill, all styles are precision ground to the best quality standards. Truly a high-end product. Now available with A1 coating for Style #7 and TA coating for all seven other cuts.

Cut #1	Cut #2	Cut #3	Cut #4	Cut #5	Cut #6	Cut #7	Cut #8
Standard	Fine	Coarse	Dura-Cut	CoarseDura	Fine-Dura	Fast-Mill	Diamond
Standard Cut is a general purpose style designed for cast iron, steel, other ferrous materials. It will achieve very high material removal rates and good workpiece finishes. The second most popular style after Dura-Cut. Available with:	Fine Cut improves finishes on hard-ened steel, stainless steel, and cast iron. Operator control is improved. The excellent finish, however, comes with reduced stock removal rates. Available with:	Coarse Cut is recommended for use on soft material such as copper, brass, aluminum, plastics, and rubber, where chip loading is a problem, and the rapid stock removal rates of Fast-Mill is not practical. Available with:	Dura-Cut allows for rapid stock removal in harder materials. The addition of left hand flutes reduces the pulling action, allowing better operator control. It reduces the size of the chips and can be used at slower than normal speeds. Available with:	Coarse-Dura Cut is for fast stock removal in soft materials, with improved operator control over Coarse Cut. The addition of the left-hand Dura also reduces chip size. Available with:	Fine-Dura Cut is very effective in heat treated and tough alloy steels. The Dura addition reduces the size of the chips and offers excellent operator control and surface finish. Available with:	Fast-Mill is designed specifically for use on non-ferrous & non-metallic materials. Designed for rapid stock removal with minimum chip loading. The best selection for rapid removal of aluminum. Available with:	Diamond Cut is very effective in heat treated and tough alloy steels, producing extremely small, powder-like chips. It offers very good operator control and stock removal at the sacrifice of some finish and tool life characteristics. Available with:
							

Why TA and A1 Coatings? Both of these superb SmoothCoat surface coatings are ideal for dry machining and will enhance tool life, lubricity, and part finish. Our TA is an extremely well-rounded coating for a wide material & hardness range, while A1 is ideal for the materials Cut #7 is utilized on. Other coatings available per application.

BURRS & SETS AVAILABLE IN METRIC CONFIGURATION:

Furnished on 6mm or 3mm shanks. Add 70000 to displayed EDP# (ie: 04001 becomes 74001). Add "M" to Style description (ie: SA-5 becomes MSA-5). Two-piece construction burs retain fractional head diameters & LOC.

OAL Information for Series 40 thru 53: All burs with body diameter of greater than 1/4" have Ultra-Carb heads brazed to a two-inch (51 mm) long hardened steel shank with a 1/4" or 6mm diameter unless otherwise noted. All burs with a body diameter of 1/4" or less are manufactured from solid Ultra-Carb and are 2-inch (51 mm) overall length.

Series 604 • Burr Sets

Set Contains 1 Each

SA-1 SC-12 SE-1 SN-1
SA-14 SF-1 SM-2
SC-1 SG-1 SL-1

Cut	EDP#	Price	Coated
#1	00401	\$141.40	\$191.40
#2	00402	\$172.40	\$222.40
#3	00403	\$149.90	\$199.90
#4	00404	\$157.40	\$207.40
#5	00405	\$164.90	\$214.90
#6	00406	\$179.90	\$229.90
#7	00407	\$209.90	\$289.90
#8	00408	\$179.90	\$229.90

Series 605 • Burr Sets

Set Contains 1 Each

SA-1 SC-1 SF-1
SA-3 SC-3 SF-3
SA-5 SC-5 SF-5

Cut	EDP#	Price	Coated
#1	00501	\$174.70	\$231.70
#2	00502	\$212.90	\$269.90
#3	00503	\$185.20	\$242.20
#4	00504	\$194.40	\$251.40
#5	00505	\$203.70	\$260.70
#6	00506	\$222.20	\$279.20
#7	00507	\$259.20	\$343.20
#8	00508	\$222.20	\$279.20

Series 606 • Burr Sets

Set Contains 1 Each

SA-5 SF-5 SG-3 SD-5
SC-5 SF-3 SE-3
SC-3 SG-5 SL-4

Cut	EDP#	Price	Coated
#1	00601	\$233.00	\$305.00
#2	00602	\$284.00	\$356.00
#3	00603	\$247.00	\$319.00
#4	00604	\$261.90	\$333.90
#5	00605	\$271.70	\$343.70
#6	00606	\$296.40	\$368.40
#7	00607	\$345.80	\$447.80
#8	00608	\$296.40	\$368.40

Series 40

ULTRATOOL

SB Style: Cylindrical with End Cut

ULTRA-Carb®

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Burr Specifications: Shank Diameter 1/4\"/>			#1	#3			#2	#4	#5			#6	#8		#7			
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price
SB-12	1/8	5/8	04001	04033	\$13.80	\$18.80	04017	04049	04065	\$15.30	\$20.30	04081	14014	\$17.50	\$22.50	04097	\$20.40	\$28.40
SB-14	3/16	5/8	04002	04034	\$13.60	\$18.60	04018	04050	04066	\$15.10	\$20.10	04082	14015	\$17.20	\$22.20	04098	\$20.10	\$28.10
SB-1	1/4	5/8	04003	04035	\$12.80	\$17.80	04019	04051	04067	\$14.20	\$19.20	04083	14016	\$16.20	\$21.20	04099	\$18.90	\$26.90
SB-1A	1/4	1\"/>	04004	04036	\$19.50	\$24.50	04020	04052	04068	\$21.60	\$26.60	04084	14017	\$24.70	\$29.70	14001	\$28.80	\$36.80
SB-2	5/16	3/4	04005	04037	\$17.80	\$23.80	04021	04053	04069	\$19.90	\$25.90	04085	14018	\$22.70	\$28.70	14002	\$26.50	\$35.50
SB-2A	5/16	1\"/>	04006	04038	\$21.30	\$27.30	04022	04054	04070	\$23.70	\$29.70	04086	14019	\$27.10	\$33.10	14003	\$31.60	\$40.60
SB-3	3/8	3/4	04007	04039	\$19.20	\$25.20	04023	04055	04071	\$21.30	\$27.30	04087	14020	\$24.40	\$30.40	14004	\$28.40	\$37.40
SB-3A	3/8	1\"/>	04008	04040	\$22.20	\$28.20	04024	04056	04072	\$24.80	\$30.80	04088	14021	\$28.30	\$34.30	14005	\$33.00	\$42.00
SB-3B	3/8	1-1/2\"/>	04009	04041	\$26.50	\$32.50	04025	04057	04073	\$29.60	\$35.60	04089	14022	\$33.80	\$39.80	14006	\$39.40	\$48.40
SB-4	7/16	1\"/>	04010	04042	\$27.90	\$35.90	04026	04058	04074	\$31.10	\$39.10	04090	14023	\$35.50	\$43.50	14007	\$41.40	\$52.40
SB-5	1/2	1\"/>	04011	04043	\$29.10	\$37.10	04027	04059	04075	\$35.00	\$43.00	04091	14024	\$39.90	\$47.90	14008	\$46.60	\$57.60
SB-6	5/8	1\"/>	04012	04044	\$39.90	\$50.90	04028	04060	04076	\$44.50	\$55.50	04092	14025	\$50.80	\$61.80	14009	\$59.30	\$74.30
SB-15	3/4	1/2\"/>	04013	04045	\$56.50	\$71.50	04029	04061	04077	\$62.90	\$77.90	04093	14026	\$71.90	\$86.90	14010	\$83.90	\$103.90
SB-16	3/4	3/4\"/>	04014	04046	\$59.60	\$74.60	04030	04062	04078	\$66.30	\$81.30	04094	14027	\$75.80	\$90.80	14011	\$88.40	\$108.40
SB-7	3/4	1\"/>	04015	04047	\$60.10	\$75.10	04031	04063	04079	\$66.90	\$81.90	04095	14028	\$76.40	\$91.40	14012	\$89.20	\$109.20
SB-9	1\"/>	1\"/>	04016	04048	\$83.30	\$103.30	04032	04064	04080	\$92.70	\$112.70	04096	14029	\$106.00	\$126.00	14013	\$123.60	\$153.60



ULTRATOOL Carbide Rotary Files (Burs)

Series 41

ULTRATOOL

SA Style: Cylindrical Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

			Burr Specifications: Shank Diameter 1/4" Add "M" for 6mm shank																							
			#1	#3			#2	#4	#5			#6	#8			#7										
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SA-12	1/8	5/8	04101	04133	\$12.40	\$17.40	04117	04149	04165	\$13.80	\$18.80	04181	14114	\$15.70	\$20.70	04197	\$18.30	\$26.30								
SA-14	3/16	5/8	04102	04134	\$12.00	\$17.00	04118	04150	04166	\$13.40	\$18.40	04182	14115	\$15.30	\$20.30	04198	\$17.80	\$25.80								
SA-1	1/4	5/8	04103	04135	\$10.60	\$15.60	04119	04151	04167	\$11.90	\$16.90	04183	14116	\$14.60	\$19.60	04199	\$17.00	\$25.00								
SA-1A	1/4	1"	04104	04136	\$16.40	\$21.40	04120	04152	04168	\$18.20	\$23.20	04184	14117	\$20.80	\$25.80	14101	\$24.30	\$32.30								
SA-2	5/16	3/4	04105	04137	\$15.10	\$21.10	04121	04153	04169	\$16.80	\$22.80	04185	14118	\$19.20	\$25.20	14102	\$22.40	\$31.40								
SA-2A	5/16	1"	04106	04138	\$18.10	\$24.10	04122	04154	04170	\$20.10	\$26.10	04186	14119	\$23.00	\$29.00	14103	\$26.80	\$35.80								
SA-3	3/8	3/4	04107	04139	\$16.20	\$22.20	04123	04155	04171	\$18.10	\$24.10	04187	14120	\$20.70	\$26.70	14104	\$24.20	\$33.20								
SA-3A	3/8	1"	04108	04140	\$18.80	\$24.80	04124	04156	04172	\$20.90	\$26.90	04188	14121	\$23.90	\$29.90	14105	\$27.90	\$36.90								
SA-3B	3/8	1-1/2	04109	04141	\$22.40	\$28.40	04125	04157	04173	\$25.00	\$31.00	04189	14122	\$28.50	\$34.50	14106	\$33.30	\$42.30								
SA-4	7/16	1"	04110	04142	\$21.50	\$29.50	04126	04158	04174	\$24.50	\$32.50	04190	14123	\$30.00	\$38.00	14107	\$35.00	\$46.00								
SA-5	1/2	1"	04111	04143	\$22.50	\$30.50	04127	04159	04175	\$25.10	\$33.10	04191	14124	\$31.30	\$39.30	14108	\$36.50	\$47.50								
SA-6	5/8	1"	04112	04144	\$31.80	\$42.80	04128	04160	04176	\$35.90	\$46.90	04192	14125	\$42.90	\$53.90	14109	\$50.10	\$65.10								
SA-15	3/4	1/2	04113	04145	\$47.60	\$62.60	04129	04161	04177	\$52.90	\$67.90	04193	14126	\$60.50	\$75.50	14110	\$70.60	\$90.60								
SA-16	3/4	3/4	04114	04146	\$50.40	\$65.40	04130	04162	04178	\$56.10	\$71.10	04194	14127	\$64.00	\$79.00	14111	\$74.70	\$94.70								
SA-7	3/4	1"	04115	04147	\$43.50	\$58.50	04131	04163	04179	\$49.70	\$64.70	04195	14128	\$64.60	\$79.60	14112	\$75.40	\$95.40								
SA-9	1"	1"	04116	04148	\$56.10	\$76.10	04132	04164	04180	\$64.00	\$84.00	04196	14129	\$90.20	\$110.20	14113	\$105.20	\$135.20								

Series 42

ULTRATOOL

SC Style: Cylindrical Ball Nose Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Burr Specifications: Shank Diameter 1/4" Add "M" for 6mm shank			#1		#3		TA		#2		#4		#5		TA		#6		#8		TA		#7		A1	
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SC-12	1/8	5/8	04201	04233	\$13.60	\$18.60	04217	04249	04265	\$15.10	\$20.10	04281	14214	\$17.30	\$22.30	04297	\$20.20	\$28.20								
SC-14	3/16	5/8	04202	04234	\$13.60	\$18.60	04218	04250	04266	\$15.10	\$20.10	04282	14215	\$17.30	\$22.30	04298	\$20.20	\$28.20								
SC-1	1/4	5/8	04203	04235	\$13.30	\$18.30	04219	04251	04267	\$14.80	\$19.80	04283	14216	\$16.90	\$21.90	04299	\$19.70	\$27.70								
SC-1A	1/4	1"	04204	04236	\$17.90	\$22.90	04220	04252	04268	\$19.90	\$24.90	04284	14217	\$22.80	\$27.80	14201	\$26.50	\$34.50								
SC-2	5/16	3/4	04205	04237	\$16.60	\$22.60	04221	04253	04269	\$18.40	\$24.40	04285	14218	\$21.10	\$27.10	14202	\$24.60	\$33.60								
SC-2A	5/16	1"	04206	04238	\$20.10	\$26.10	04222	04254	04270	\$22.30	\$28.30	04286	14219	\$25.50	\$31.50	14203	\$29.80	\$38.80								
SC-3	3/8	3/4	04207	04239	\$18.20	\$24.20	04223	04255	04271	\$20.20	\$26.20	04287	14220	\$23.10	\$29.10	14204	\$27.00	\$36.00								
SC-3A	3/8	1"	04208	04240	\$20.80	\$26.80	04224	04256	04272	\$23.10	\$29.10	04288	14221	\$26.40	\$32.40	14205	\$30.80	\$39.80								
SC-3B	3/8	1-1/2	04209	04241	\$22.00	\$28.00	04225	04257	04273	\$24.50	\$30.50	04289	14222	\$27.90	\$33.90	14206	\$32.60	\$41.60								
SC-4	7/16	1"	04210	04242	\$26.20	\$34.20	04226	04258	04274	\$29.20	\$37.20	04290	14223	\$33.30	\$41.30	14207	\$38.90	\$49.90								
SC-5	1/2	1"	04211	04243	\$28.50	\$36.50	04227	04259	04275	\$31.70	\$39.70	04291	14224	\$36.20	\$44.20	14208	\$42.30	\$53.30								
SC-6	5/8	1"	04212	04244	\$39.30	\$50.30	04228	04260	04276	\$43.70	\$54.70	04292	14225	\$49.90	\$60.90	14209	\$58.20	\$73.20								
SC-7	3/4	1"	04215	04247	\$55.60	\$70.60	04231	04263	04279	\$61.90	\$76.90	04295	14228	\$70.70	\$85.70	14212	\$82.40	\$102.40								

Series 43

ULTRATOOL

SD Style: Ball Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

			#1		#3				#2		#4		#5				#6		#8				#7			
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SD-12	1/8	7/64	04301	04333	\$12.90	\$17.90	04317	04349	04365	\$14.30	\$19.30	04381	14314	\$16.40	\$21.40	04397	\$19.10	\$27.10								
SD-14	3/16	11/64	04302	04334	\$12.80	\$17.80	04318	04350	04366	\$14.20	\$19.20	04382	14315	\$16.20	\$21.20	04398	\$18.90	\$26.90								
SD-1	1/4	7/32	04303	04335	\$12.50	\$17.50	04319	04351	04367	\$13.90	\$18.90	04383	14316	\$15.90	\$20.90	04399	\$18.60	\$26.60								
SD-2	5/16	17/64	04305	04337	\$13.30	\$19.30	04321	04353	04369	\$14.80	\$20.80	04385	14318	\$16.90	\$22.90	14302	\$19.70	\$28.70								
SD-3	3/8	5/16	04307	04339	\$15.70	\$21.70	04323	04355	04371	\$17.50	\$23.50	04386	14319	\$20.00	\$26.00	14303	\$23.30	\$32.30								
SD-4	7/16	3/8	04310	04342	\$19.40	\$27.40	04326	04358	04374	\$21.60	\$29.60	04390	14323	\$24.70	\$32.70	14307	\$28.80	\$39.80								
SD-5	1/2	7/16	04311	04343	\$21.20	\$29.20	04327	04359	04375	\$23.60	\$31.60	04391	14324	\$27.00	\$35.00	14308	\$31.50	\$42.50								
SD-6	5/8	17/32	04312	04344	\$28.60	\$39.60	04328	04360	04376	\$31.80	\$42.80	04392	14325	\$36.40	\$47.40	14309	\$42.40	\$57.40								
SD-7	3/4	21/32	04315	04347	\$39.90	\$54.90	04331	04363	04379	\$44.40	\$59.40	04395	14328	\$50.70	\$65.70	14312	\$59.20	\$79.20								
SD-9	1"	29/32	04316	04348	\$68.30	\$88.30	04332	04364	04380	\$76.00	\$96.00	04396	14329	\$86.80	\$106.80	14313	\$101.30	\$131.30								

ULTRATOOL Carbide Rotary Files (Burs)

Series 44



SE Style: Egg Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	Standard EDP#		Price	Coated Price	Fine EDP#		Price	Coated Price	FineDC EDP#		Price	Coated Price	FastMill EDP#		Price	Coated Price
			EDP#	Coarse EDP#			EDP#	DuraC EDP#			EDP#	Diamond EDP#			EDP#	Price		
SE-11	3/16	5/16	04402	04434	\$15.50	\$20.50	04418	04450	04466	\$17.20	\$22.20	04482	14415	\$19.70	\$24.70	04498	\$23.00	\$31.00
SE-1	1/4	3/8	04403	04435	\$15.30	\$20.30	04419	04451	04467	\$17.00	\$22.00	04483	14416	\$19.40	\$24.40	04499	\$22.60	\$30.60
SE-3	3/8	5/8	04407	04439	\$18.40	\$24.40	04423	04455	04471	\$20.40	\$26.40	04486	14419	\$23.30	\$29.30	14403	\$27.20	\$36.20
SE-5	1/2	7/8	04411	04443	\$27.90	\$35.90	04427	04459	04475	\$31.00	\$39.00	04491	14424	\$35.40	\$43.40	14408	\$41.30	\$52.30
SE-6	5/8	1"	04412	04444	\$39.00	\$50.00	04428	04460	04476	\$43.40	\$54.40	04492	14425	\$49.60	\$60.60	14409	\$57.80	\$72.80
SE-7	3/4	1"	04415	04447	\$52.10	\$67.10	04431	04463	04479	\$57.90	\$72.90	04495	14428	\$66.20	\$81.20	14412	\$77.30	\$97.30

Series 45



SF Style: Round Tree Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	Standard EDP#		Price	Coated Price	Fine EDP#		Price	Coated Price	FineDC EDP#		Price	Coated Price	FastMill EDP#		Price	Coated Price
			EDP#	Coarse EDP#			EDP#	DuraC EDP#			EDP#	Diamond EDP#			EDP#	Price		
SF-1	1/4	5/8	04503	04535	\$14.10	\$19.10	04519	04551	04567	\$15.70	\$20.70	04583	14516	\$18.00	\$23.00	04599	\$20.90	\$28.90
SF-3	3/8	3/4	04507	04539	\$17.90	\$23.90	04523	04555	04571	\$19.90	\$25.90	04586	14519	\$22.80	\$28.80	14503	\$26.50	\$35.50
SF-13	1/2	3/4	04510	04542	\$26.40	\$34.40	04526	04558	04574	\$29.40	\$37.40	04590	14523	\$33.50	\$41.50	14507	\$39.10	\$50.10
SF-5	1/2	1"	04511	04543	\$27.60	\$35.60	04527	04559	04575	\$30.70	\$38.70	04591	14524	\$35.10	\$43.10	14508	\$40.90	\$51.90
SF-6	5/8	1"	04512	04544	\$38.10	\$49.10	04528	04560	04576	\$42.40	\$53.40	04592	14525	\$48.50	\$59.50	14509	\$56.50	\$71.50
SF-7	3/4	1"	04515	04547	\$47.20	\$62.20	04531	04563	04579	\$52.50	\$67.50	04595	14528	\$60.00	\$75.00	14512	\$70.00	\$90.00
SF-14	3/4	1-1/4	04516	04548	\$56.70	\$71.70	04532	04564	04580	\$63.10	\$78.10	04596	14529	\$72.10	\$87.10	14513	\$84.10	\$104.10
SF-15	3/4	1-1/2	04517	04549	\$72.60	\$87.60	04533	04565	04581	\$80.80	\$95.80	04597	14530	\$92.30	\$107.30	14514	\$107.70	\$127.70

Series 46



SG Style: Pointed Tree Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	Standard EDP#		Price	Coated Price	Fine EDP#		Price	Coated Price	FineDC EDP#		Price	Coated Price	FastMill EDP#		Price	Coated Price
			EDP#	Coarse EDP#			EDP#	DuraC EDP#			EDP#	Diamond EDP#			EDP#	Price		
SG-1	1/4	5/8	04603	04635	\$14.10	\$19.10	04619	04651	04667	\$15.70	\$20.70	04683	14616	\$18.00	\$23.00	04699	\$20.90	\$28.90
SG-2	5/16	3/4	04605	04637	\$16.60	\$22.60	04621	04653	04669	\$18.50	\$24.50	04685	14618	\$21.20	\$27.20	14602	\$24.70	\$33.70
SG-3	3/8	5/8	04607	04639	\$17.90	\$23.90	04623	04655	04671	\$19.90	\$25.90	04686	14619	\$22.80	\$28.80	14603	\$26.50	\$35.50
SG-13	1/2	3/4	04610	04642	\$26.40	\$34.40	04626	04658	04674	\$29.40	\$37.40	04690	14623	\$33.50	\$41.50	14607	\$39.10	\$50.10
SG-5	1/2	1"	04611	04643	\$27.60	\$35.60	04627	04659	04675	\$30.70	\$38.70	04691	14624	\$35.10	\$43.10	14608	\$40.90	\$51.90
SG-6	5/8	1"	04612	04644	\$38.30	\$49.30	04628	04660	04676	\$42.60	\$53.60	04692	14625	\$48.70	\$59.70	14609	\$56.80	\$71.80
SG-7	3/4	1"	04615	04647	\$50.40	\$65.40	04631	04663	04679	\$56.10	\$71.10	04695	14628	\$64.00	\$79.00	14612	\$74.70	\$94.70
SG-15	3/4	1-1/2	04617	04649	\$72.60	\$87.60	04633	04665	04681	\$80.80	\$95.80	04697	14630	\$92.30	\$107.30	14614	\$107.70	\$127.70

Series 47



SM Style: Cone Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	Ang	LOC	Standard EDP#		Price	Coated Price	Fine EDP#		Price	Coated Price	FineDC EDP#		Price	Coated Price	FastMill EDP#		Price	Coated Price
				EDP#	Coarse EDP#			EDP#	DuraC EDP#			EDP#	Diamond EDP#			EDP#	Price		
SM-1	1/4	22°	1/2	04703	04735	\$13.60	\$18.60	04719	04751	04767	\$15.10	\$20.10	04783	14716	\$17.30	\$22.30	04799	\$20.20	\$28.20
SM-2	1/4	14°	3/4	04705	04737	\$14.40	\$19.40	04721	04753	04769	\$16.00	\$21.00	04785	14718	\$18.30	\$23.30	14702	\$21.40	\$29.40
SM-3	1/4	10°	1"	04707	04739	\$16.60	\$21.60	04723	04755	04771	\$18.50	\$23.50	04786	14719	\$21.20	\$26.20	14703	\$24.70	\$32.70
SM-3A	1/4	8°	1-1/4	04710	04742	\$18.80	\$23.80	04726	04758	04774	\$20.90	\$25.90	04790	14723	\$23.90	\$28.90	14707	\$27.90	\$35.90
SM-4	3/8	28°	5/8	04711	04743	\$22.80	\$28.80	04727	04759	04775	\$25.40	\$31.40	04791	14724	\$29.00	\$35.00	14708	\$33.80	\$42.80
SM-5	1/2	28°	7/8	04712	04744	\$30.00	\$38.00	04728	04760	04776	\$33.40	\$41.40	04792	14725	\$38.20	\$46.20	14709	\$44.60	\$55.60
SM-6	5/8	31°	1"	04715	04747	\$41.10	\$52.10	04731	04763	04779	\$45.80	\$56.80	04795	14728	\$52.30	\$63.30	14712	\$61.00	\$76.00

Cut
#1Cut
#2Cut
#3Cut
#4Cut
#5Cut
#6Cut
#7Cut
#8

Standard

Fine

Coarse

Dura-Cut

CoarseDura

Fine-Dura

Fast-Mill

Diamond

ULTRA-Carb®



ULTRATOOL Carbide Rotary Files (Burs)

Series 48 SL Style: 14° Included Angle Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

			#1		#3				#2		#4		#5				#6		#8				#7			
Tool Name Diam LOC			Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SL-1	1/4	5/8	04802	04834	\$14.40	\$19.40	04818	04850	04866	\$16.00	\$21.00	04882	14815	\$18.20	\$23.20	04898	\$21.30	\$29.30								
SL-2	5/16	7/8	04803	04835	\$19.10	\$25.10	04819	04851	04867	\$21.20	\$27.20	04883	14816	\$24.20	\$30.20	04899	\$28.20	\$37.20								
SL-3	3/8	1-1/16	04807	04839	\$22.70	\$28.70	04823	04855	04871	\$25.20	\$31.20	04886	14819	\$28.80	\$34.80	14803	\$33.60	\$42.60								
SL-4	1/2	1-1/8	04811	04843	\$28.40	\$36.40	04827	04859	04875	\$31.60	\$39.60	04891	14824	\$36.20	\$44.20	14808	\$42.20	\$53.20								
SL-6	5/8	1-5/16	04812	04844	\$52.10	\$63.10	04828	04860	04876	\$57.90	\$68.90	04892	14825	\$66.20	\$77.20	14809	\$77.30	\$92.30								
SL-7	3/4	1-1/2	04815	04847	\$75.90	\$90.90	04831	04863	04879	\$84.50	\$99.50	04895	14828	\$96.60	\$111.60	14812	\$112.70	\$132.70								

Series 49 SH Style: Flame Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Burr Specifications:
Shank Diameter 1/4\"/>

			#1		#3		TA		#2		#4		#5		TA		#6		#8		TA		#7		A1	
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SH-1	1/4	5/8	04902	04934	\$16.60	\$21.60	04918	04950	04966	\$18.50	\$23.50	04982	14915	\$21.20	\$26.20	04998	\$24.70	\$32.70								
SH-2	5/16	3/4	04903	04935	\$18.80	\$24.80	04919	04951	04967	\$20.90	\$26.90	04983	14916	\$23.90	\$29.90	04999	\$27.90	\$36.90								
SH-5	1/2	1-1/4	04907	04939	\$39.90	\$47.90	04923	04955	04971	\$44.50	\$52.50	04986	14919	\$50.80	\$58.80	14903	\$59.30	\$70.30								
SH-6	5/8	1-7/16	04911	04943	\$55.30	\$66.30	04927	04959	04975	\$61.60	\$72.60	04991	14924	\$70.40	\$81.40	14908	\$82.10	\$97.10								
SH-7	3/4	1-5/8	04912	04944	\$76.20	\$91.20	04928	04960	04976	\$84.80	\$99.80	04992	14925	\$95.70	\$110.70	14909	\$113.10	\$133.10								

Series 50 SK Style: 90° Included Angle Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

			#1		#3				#2		#4		#5				#6		#8				#7			
Tool Name	Diam	LOC	Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SK-1	1/4	1/8	05003	05035	\$13.20	\$18.20	05019	05051	05067	\$14.60	\$19.60	05083	15016	\$16.70	\$21.70	05099	\$19.50	\$27.50								
SK-2	5/16	5/32	05005	05037	\$16.40	\$22.40	05021	05053	05069	\$18.30	\$24.30	05085	15018	\$20.90	\$26.90	15002	\$24.30	\$33.30								
SK-3	3/8	3/16	05007	05039	\$17.00	\$23.00	05023	05055	05071	\$19.00	\$25.00	05086	15019	\$21.70	\$27.70	15003	\$25.30	\$34.30								
SK-5	1/2	1/4	05010	05042	\$21.90	\$29.90	05026	05058	05074	\$24.30	\$32.30	05090	15023	\$27.80	\$35.80	15007	\$32.40	\$43.40								
SK-6	5/8	5/16	05011	05043	\$29.00	\$40.00	05027	05059	05075	\$32.20	\$43.20	05091	15024	\$36.80	\$47.80	15008	\$42.90	\$57.90								
SK-7	3/4	3/8	05012	05044	\$38.20	\$53.20	05028	05060	05076	\$42.50	\$57.50	05092	15025	\$48.50	\$63.50	15009	\$56.60	\$76.60								
SK-8	7/8	7/16	05015	05047	\$50.50	\$70.50	05031	05063	05079	\$56.20	\$76.20	05095	15028	\$64.30	\$84.30	15012	\$75.00	\$105.00								
SK-9	1"	1/2	05017	05049	\$61.00	\$81.00	05033	05065	05081	\$67.90	\$87.90	05097	15030	\$77.60	\$97.60	15014	\$90.50	\$120.50								

Series 51 SJ Style: 60° Included Angle Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

			#1		#3				#2		#4		#5				#6		#8				#7			
Tool Name Diam LOC			Standard EDP#	Coarse EDP#	Price	Coated Price	Fine EDP#	DuraC EDP#	CoarDC EDP#	Price	Coated Price	FineDC EDP#	Diamond EDP#	Price	Coated Price	FastMill EDP#	Price	Coated Price								
SJ-1 1/4 3/16			05103	05135	\$13.20	\$18.20	05119	05151	05167	\$14.60	\$19.60	05183	15116	\$16.70	\$21.70	05199	\$19.50	\$27.50								
SJ-2 5/16 1/4			05105	05137	\$16.40	\$22.40	05121	05153	05169	\$18.30	\$24.30	05185	15118	\$20.90	\$26.90	15102	\$24.30	\$33.30								
SJ-3 3/8 1/4			05107	05139	\$17.00	\$23.00	05123	05155	05171	\$19.00	\$25.00	05186	15119	\$21.70	\$27.70	15103	\$25.30	\$34.30								
SJ-5 1/2 7/16			05110	05142	\$21.90	\$29.90	05126	05158	05174	\$24.30	\$32.30	05190	15123	\$27.80	\$35.80	15107	\$32.40	\$40.40								
SJ-6 5/8 1/2			05111	05143	\$29.00	\$40.00	05127	05159	05175	\$32.20	\$43.20	05191	15124	\$36.80	\$47.80	15108	\$42.90	\$57.90								
SJ-7 3/4 5/8			05112	05144	\$38.20	\$53.20	05128	05160	05176	\$42.50	\$57.50	05192	15125	\$48.50	\$63.50	15109	\$56.60	\$76.60								
SJ-8 7/8 3/4			05115	05147	\$50.50	\$70.50	05131	05163	05179	\$56.20	\$76.20	05195	15128	\$64.30	\$84.30	15112	\$75.00	\$105.00								
SJ-9 1\"/>			05117	05149	\$61.00	\$81.00	05133	05165	05181	\$67.90	\$87.90	05197	15130	\$77.60	\$97.60	15114	\$90.50	\$120.50								

ULTRATOOL® Carbide Rotary Files (Burs)

Series 52



SN Style: Inverted Cone Shape

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	#1		#3		Price	Coated Price	#2		#4		Price	Coated Price	#5		Price	Coated Price	#6		#8		Price	Coated Price	#7		Price	Coated Price
			Standard EDP#	Coarse EDP#	Standard EDP#	Coarse EDP#			Standard EDP#	Coarse EDP#	Standard EDP#	Coarse EDP#			Standard EDP#	Coarse EDP#			Standard EDP#	Diamond EDP#	Standard EDP#	Diamond EDP#			Standard EDP#	Coarse EDP#		
SN-1	1/4	5/16	05202	05234	05203	05235	\$15.30	\$20.30	05218	05250	05266	05267	\$17.00	\$22.00	05282	15215	\$19.40	\$24.40	05298	15216	05299	15217	\$22.60	\$30.60	05298	15216	\$22.60	\$30.60
SN-2	3/8	3/8	05207	05239	05207	05239	\$22.10	\$28.10	05223	05255	05271	05272	\$24.60	\$30.60	05286	15219	\$28.10	\$34.10	05299	15220	05299	15221	\$32.70	\$41.70	05299	15221	\$32.70	\$41.70
SN-3	1/2	1/2	05207	05239	05207	05239	\$31.50	\$39.50	05223	05255	05271	05272	\$35.00	\$43.00	05286	15219	\$40.00	\$48.00	15203		15203		\$46.70	\$57.70	15203		\$46.70	\$57.70
SN-6	5/8	3/4	05211	05243	05211	05243	\$39.70	\$50.70	05227	05259	05275	05276	\$44.20	\$55.20	05291	15224	\$50.50	\$61.50	15208		15208		\$58.90	\$73.90	15208		\$58.90	\$73.90
SN-7	3/4	5/8	05212	05244	05212	05244	\$49.80	\$64.80	05228	05260	05276	05277	\$55.50	\$70.50	05292	15225	\$63.40	\$78.40	15209		15209		\$73.90	\$93.90	15209		\$73.90	\$93.90

Series 53



SN-E Style: Inverted Cone Shape with End Cut

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	#1		#3		Price	Coated Price	#2		#4		Price	Coated Price	#5		Price	Coated Price	#6		#8		Price	Coated Price	#7		Price	Coated Price
			Standard EDP#	Coarse EDP#	Standard EDP#	Coarse EDP#			Standard EDP#	Coarse EDP#	Standard EDP#	Coarse EDP#			Standard EDP#	Coarse EDP#			Standard EDP#	Diamond EDP#	Standard EDP#	Diamond EDP#			Standard EDP#	Coarse EDP#		
SN-1E	1/4	5/16	05302	05334	05303	05335	\$16.80	\$21.80	05318	05350	05366	05367	\$18.70	\$23.70	05382	15315	\$21.40	\$26.40	05398	15316	05399	15317	\$24.90	\$32.90	05398	15316	\$24.90	\$32.90
SN-2E	3/8	3/8	05303	05335	05303	05335	\$23.50	\$29.50	05319	05351	05367	05368	\$26.20	\$32.20	05383	15316	\$29.90	\$35.90	05399	15317	05399	15318	\$34.90	\$43.90	05399	15318	\$34.90	\$43.90
SN-3E	1/2	1/2	05307	05339	05307	05339	\$36.10	\$44.10	05323	05355	05371	05372	\$40.20	\$48.20	05386	15319	\$45.90	\$53.90	15303		15303		\$53.60	\$64.60	15303		\$53.60	\$64.60
SN-6E	5/8	3/4	05311	05343	05311	05343	\$44.50	\$55.50	05327	05359	05375	05376	\$49.50	\$60.50	05391	15324	\$56.50	\$67.50	15308		15308		\$66.00	\$81.00	15308		\$66.00	\$81.00
SN-7E	3/4	5/8	05312	05344	05312	05344	\$57.50	\$72.50	05328	05360	05376	05377	\$64.00	\$79.00	05392	15325	\$73.10	\$88.10	15309		15309		\$85.30	\$105.30	15309		\$85.30	\$105.30

ULTRA-Carb®

Cut #1	Cut #2	Cut #3	Cut #4	Cut #5	Cut #6	Cut #7	Cut #8
Standard	Fine	Coarse	Dura-Cut	CoarseDura	Fine-Dura	Fast-Mill	Diamond

Series 54

SB, SA, SC, SD, SE, SF, SG, SH & SL Styles with 6" Extended Length Shanks



Our most popular burr shapes & cut styles are now offered with 6" long shanks for extended reach.
Also available with 6mm diameter metric shanks (add 70000 to displayed EDP# or "M" to tool name).

Burr Specifications:
Shank Diameter 1/4"
Add "M" for 6mm shank

Tool Name	Diam	LOC	#1		#4		#8	
			Standard EDP#	Price	Coated Price	DuraC EDP#	Price	Coated Price
SB-1L6	1/4	1/2	03024	\$25.90	\$35.90	03050	\$28.80	\$38.80
SB-3L6	3/8	3/4	03025	\$33.00	\$44.00	03051	\$36.70	\$47.70
SB-5L6	1/2	1"	03026	\$43.10	\$55.10	03052	\$47.90	\$59.90
SA-1L6	1/4	1/2	03001	\$22.50	\$32.50	03027	\$25.00	\$35.00
SA-3L6	3/8	3/4	03002	\$28.70	\$39.70	03028	\$31.90	\$42.90
SA-5L6	1/2	1"	03003	\$37.50	\$49.50	03029	\$41.70	\$53.70
SC-1L6	1/4	1/2	03004	\$22.50	\$32.50	03030	\$25.00	\$35.00
SC-3L6	3/8	3/4	03005	\$28.70	\$39.70	03031	\$31.90	\$42.90
SC-5L6	1/2	1"	03006	\$40.80	\$52.80	03032	\$45.40	\$57.40
SD-1L6	1/4	7/32	03007	\$22.50	\$32.50	03033	\$25.00	\$35.00
SD-3L6	3/8	5/16	03008	\$28.70	\$39.70	03034	\$31.90	\$42.90
SD-5L6	1/2	7/16	03009	\$37.50	\$49.50	03035	\$41.70	\$53.70
SE-1L6	1/4	3/8	03010	\$23.40	\$33.40	03036	\$26.00	\$36.00
SE-3L6	3/8	5/8	03011	\$28.70	\$39.70	03037	\$31.90	\$42.90
SE-5L6	1/2	7/8	03012	\$41.40	\$53.40	03038	\$46.10	\$58.10
SF-1L6	1/4	1/2	03013	\$24.30	\$34.30	03039	\$27.00	\$37.00
SF-3L6	3/8	3/4	03014	\$28.70	\$39.70	03040	\$31.90	\$42.90
SF-5L6	1/2	1"	03015	\$38.60	\$50.60	03041	\$42.90	\$54.90
SG-1L6	1/4	1/2	03016	\$22.50	\$32.50	03042	\$25.00	\$35.00
SG-3L6	3/8	3/4	03017	\$28.70	\$39.70	03043	\$31.90	\$42.90
SG-5L6	1/2	1"	03018	\$39.70	\$51.70	03044	\$44.20	\$56.20
SH-2L6	5/16	3/4	03019	\$28.70	\$39.70	03045	\$31.90	\$42.90
SH-5L6	1/2	1-1/4	03020	\$55.10	\$67.10	03046	\$61.30	\$73.30
SL-1L6	1/4	5/8	03021	\$24.30	\$34.30	03047	\$27.00	\$37.00
SL-3L6	3/8	1-1/16	03022	\$43.40	\$54.40	03048	\$48.30	\$59.30
SL-4L6	1/2	1-1/8	03023	\$46.30	\$58.30	03049	\$51.50	\$63.50



SA-51 • 1/2" LOC

Cut	EDP#	Price	Coated
#1	07001	\$12.40	\$15.90
#2	07002	\$15.00	\$18.50
#3	07003	\$13.10	\$16.60
#4	07004	\$13.80	\$17.30
#5	07005	\$14.40	\$17.90
#6	07006	\$15.70	\$19.20
#7	07007	\$18.30	\$25.30
#8	07008	\$15.70	\$19.20

ULTRATOOL 1/4" Diam. Burrs

Series 70

1/4" Diam Head • 1/8" Diam Steel Shank
1-1/2" Shank Length • 2" Max. OAL
For Metric sizing, add 70000 to displayed EDP #.
6.4mm Diam, 3mm Shank, 38mm Shank Length



All Cut Styles available with TA coating except Cut #7 which features A1.



Series 601 • Burr Sets

Set Contains 1 Each:

Cut	EDP#	Price	Coated
#1	00101	\$110.80	\$142.30
#2	00102	\$135.10	\$166.60
#3	00103	\$117.50	\$149.00
#4	00104	\$123.30	\$154.80
#5	00105	\$129.20	\$160.70
#6	00106	\$140.90	\$172.40
#7	00107	\$164.40	\$227.40
#8	00108	\$140.90	\$172.40

SA-51 SB-51
SC-51 SD-51
SE-51 SF-51
SG-51 SM-51
SN-51

Burr Specifications:
Shank Diameter 1/8"
Add "M" for 3mm shank

SB-51 • 3/16" LOC

Cut	EDP#	Price	Coated
#1	07009	\$12.40	\$15.90
#2	07020	\$15.00	\$18.50
#3	07021	\$13.10	\$16.60
#4	07022	\$13.80	\$17.30
#5	07023	\$14.40	\$17.90
#6	07024	\$15.70	\$19.20
#7	07025	\$18.30	\$25.30
#8	07026	\$15.70	\$19.20

SC-51 • 1/2" LOC

Cut	EDP#	Price	Coated
#1	07035	\$12.40	\$15.90
#2	07036	\$15.00	\$18.50
#3	07037	\$13.10	\$16.60
#4	07038	\$13.80	\$17.30
#5	07039	\$14.40	\$17.90
#6	07040	\$15.70	\$19.20
#7	07041	\$18.30	\$25.30
#8	07042	\$15.70	\$19.20

SG-51 • 1/2" LOC

Cut	EDP#	Price	Coated
#1	07051	\$12.40	\$15.90
#2	07052	\$15.00	\$18.50
#3	07053	\$13.10	\$16.60
#4	07054	\$13.80	\$17.30
#5	07055	\$14.40	\$17.90
#6	07056	\$15.70	\$19.20
#7	07057	\$18.30	\$25.30
#8	07058	\$15.70	\$19.20

SE-51 • 3/8" LOC

Cut	EDP#	Price	Coated
#1	07067	\$12.40	\$15.90
#2	07068	\$15.00	\$18.50
#3	07069	\$13.10	\$16.60
#4	07070	\$13.80	\$17.30
#5	07071	\$14.40	\$17.90
#6	07072	\$15.70	\$19.20
#7	07073	\$18.30	\$25.30
#8	07074	\$15.70	\$19.20

SD-51 • 1/4" LOC

Cut	EDP#	Price	Coated
#1	07027	\$12.40	\$15.90
#2	07028	\$15.00	\$18.50
#3	07029	\$13.10	\$16.60
#4	07030	\$13.80	\$17.30
#5	07031	\$14.40	\$17.90
#6	07032	\$15.70	\$19.20
#7	07033	\$18.30	\$25.30
#8	07034	\$15.70	\$19.20

SF-51 • 1/2" LOC

Cut	EDP#	Price	Coated
#1	07043	\$12.40	\$15.90
#2	07044	\$15.00	\$18.50
#3	07045	\$13.10	\$16.60
#4	07046	\$13.80	\$17.30
#5	07047	\$14.40	\$17.90
#6	07048	\$15.70	\$19.20
#7	07049	\$18.30	\$25.30
#8	07050	\$15.70	\$19.20

SM-51 • 1/2" LOC 22°

Cut	EDP#	Price	Coated
#1	07059	\$12.40	\$15.90
#2	07060	\$15.00	\$18.50
#3	07061	\$13.10	\$16.60
#4	07062	\$13.80	\$17.30
#5	07063	\$14.40	\$17.90
#6	07064	\$15.70	\$19.20
#7	07065	\$18.30	\$25.30
#8	07066	\$15.70	\$19.20

SN-51 • 1/4" LOC 10°

Cut	EDP#	Price	Coated
#1	07075	\$12.40	\$15.90
#2	07076	\$15.00	\$18.50
#3	07077	\$13.10	\$16.60
#4	07078	\$13.80	\$17.30
#5	07079	\$14.40	\$17.90
#6	07080	\$15.70	\$19.20
#7	07081	\$18.30	\$25.30
#8	07082	\$15.70	\$19.20

ULTRATOOL 5/32" & 3/16" Diam. Solid Carbide Burrs

Series 71 Solid Carbide Construction • 2" OAL • 1/8" Diameter Shank

For Metric sizing (4mm & 4.75mm Diam, 51mm OAL, 3mm shank), add 70000 to displayed EDP #.



SA-53 • 3/16 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07101	\$17.20	\$20.20
#2	07102	\$21.00	\$24.00
#3	07103	\$18.20	\$21.20
#4	07104	\$19.20	\$22.20
#5	07105	\$20.10	\$23.10
#6	07106	\$21.90	\$24.90
#7	07107	\$25.50	\$31.50
#8	07108	\$21.90	\$24.90

SN-53 • 3/16 X 1/4 10°IncTaper

Cut	EDP#	Price	Coated
#1	07135	\$17.20	\$20.20
#2	07136	\$21.00	\$24.00
#3	07137	\$18.20	\$21.20
#4	07138	\$19.20	\$22.20
#5	07139	\$20.10	\$23.10
#6	07140	\$21.90	\$24.90
#7	07141	\$25.50	\$31.50
#8	07142	\$21.90	\$24.90

SH-53 • 3/16 X 3/8" LOC

Cut	EDP#	Price	Coated
#1	07159	\$17.20	\$20.20
#2	07160	\$21.00	\$24.00
#3	07161	\$18.20	\$21.20
#4	07162	\$19.20	\$22.20
#5	07163	\$20.10	\$23.10
#6	07164	\$21.90	\$24.90
#7	07165	\$25.50	\$31.50
#8	07166	\$21.90	\$24.90

SG-53 • 3/16 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07183	\$17.20	\$20.20
#2	07184	\$21.00	\$24.00
#3	07185	\$18.20	\$21.20
#4	07186	\$19.20	\$22.20
#5	07187	\$20.10	\$23.10
#6	07188	\$21.90	\$24.90
#7	07189	\$25.50	\$31.50
#8	07190	\$21.90	\$24.90

SA-52 • 5/32 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07109	\$17.20	\$20.20
#2	07120	\$21.00	\$24.00
#3	07121	\$18.20	\$21.20
#4	07122	\$19.20	\$22.20
#5	07123	\$20.10	\$23.10
#6	07124	\$21.90	\$24.90
#7	07125	\$25.50	\$31.50
#8	07126	\$21.90	\$24.90

SC-53 • 3/16 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07143	\$17.20	\$20.20
#2	07144	\$21.00	\$24.00
#3	07145	\$18.20	\$21.20
#4	07146	\$19.20	\$22.20
#5	07147	\$20.10	\$23.10
#6	07148	\$21.90	\$24.90
#7	07149	\$25.50	\$31.50
#8	07150	\$21.90	\$24.90

SM-53 • 3/16 X 1/2 16°IncTaper

Cut	EDP#	Price	Coated
#1	07167	\$17.20	\$20.20
#2	07168	\$21.00	\$24.00
#3	07169	\$18.20	\$21.20
#4	07170	\$19.20	\$22.20
#5	07171	\$20.10	\$23.10
#6	07172	\$21.90	\$24.90
#7	07173	\$25.50	\$31.50
#8	07174	\$21.90	\$24.90

SE-53 • 3/16 X 9/32" LOC

Cut	EDP#	Price	Coated
#1	07191	\$17.20	\$20.20
#2	07192	\$21.00	\$24.00
#3	07193	\$18.20	\$21.20
#4	07194	\$19.20	\$22.20
#5	07195	\$20.10	\$23.10
#6	07196	\$21.90	\$24.90
#7	07197	\$25.50	\$31.50
#8	07198	\$21.90	\$24.90

SF-53 • 3/16 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07127	\$17.20	\$20.20
#2	07128	\$21.00	\$24.00
#3	07129	\$18.20	\$21.20
#4	07130	\$19.20	\$22.20
#5	07131	\$20.10	\$23.10
#6	07132	\$21.90	\$24.90
#7	07133	\$25.50	\$31.50
#8	07134	\$21.90	\$24.90

SD-53 • 3/16" Ball

Cut	EDP#	Price	Coated
#1	07151	\$17.20	\$20.20
#2	07152	\$21.00	\$24.00
#3	07153	\$18.20	\$21.20
#4	07154	\$19.20	\$22.20
#5	07155	\$20.10	\$23.10
#6	07156	\$21.90	\$24.90
#7	07157	\$25.50	\$31.50
#8	07158	\$21.90	\$24.90

SC-52 • 5/32 X 1/2" LOC

Cut	EDP#	Price	Coated
#1	07175	\$17.20	\$20.20
#2	07176	\$21.00	\$24.00
#3	07177	\$18.20	\$21.20
#4	07178	\$19.20	\$22.20
#5	07179	\$20.10	\$23.10
#6	07180	\$21.90	\$24.90
#7	07181	\$25.50	\$31.50
#8	07182	\$21.90	\$24.90

SL-53 • 3/16 X 1/2 14°IncTaper

Cut	EDP#	Price	Coated
#1	07300	\$17.20	\$20.20
#2	07301	\$21.00	\$24.00
#3	07302	\$18.20	\$21.20
#4	07303	\$19.20	\$22.20
#5	07304	\$20.10	\$23.10
#6	07305	\$21.90	\$24.90
#7	07306	\$25.50	\$31.50
#8	07307	\$21.90	\$24.90

Series 600 • Burr Sets

SA-43 SA-42 SC-42 SD-42 SE-41
Set Contains 1 Each: SF-42 SF-41 SG-41 SM-43 SH-41 SN-42 SL-41

Cut	EDP#	Price	Coated
#1	00001	\$82.50	\$116.40
#2	00002	\$100.50	\$134.40
#3	00003	\$87.60	\$121.20
#4	00004	\$91.80	\$126.00

Cut	EDP#	Price	Coated
#5	00005	\$96.20	\$130.80
#6	00006	\$104.90	\$139.20
#7	00007	\$122.40	\$180.00
#8	00008	\$104.90	\$139.20

ULTRATOOL 1/16" - 1/8" Diam. Solid Carbide Burrs

Series 59 • Solid Carbide Construction • 1-1/2" OAL • 1/8" Diam. Shank
For Metric sizing (1.5 - 3 mm Diam, 38 mm OAL, 3.0 mm shank) add 70000 to EDP #.



All Cut Styles available with TA coating except Cut #7 which features A1.



SA-43 • 1/8 X 9/16

Cut	EDP#	Price	Coated
#1	05901	\$6.00	\$8.80
#2	05902	\$7.50	\$10.30
#3	05903	\$6.40	\$9.20
#4	05904	\$6.80	\$9.60
#5	05905	\$7.20	\$10.00
#6	05906	\$7.90	\$10.70
#7	05907	\$8.60	\$14.10
#8	05908	\$7.90	\$10.70

SD-42 • 1/8 Ball

Cut	EDP#	Price	Coated
#1	05949	\$6.90	\$9.70
#2	05950	\$8.40	\$11.20
#3	05951	\$7.30	\$10.10
#4	05952	\$7.70	\$10.50
#5	05953	\$8.10	\$10.90
#6	05954	\$8.80	\$11.60
#7	05955	\$9.50	\$15.00
#8	05956	\$8.80	\$11.60

SF-42 • 1/8 X 1/2

Cut	EDP#	Price	Coated
#1	05997	\$6.90	\$9.70
#2	05998	\$8.40	\$11.20
#3	05999	\$7.30	\$10.10
#4	15901	\$7.70	\$10.50
#5	15902	\$8.10	\$10.90
#6	15903	\$8.80	\$11.60
#7	15904	\$9.50	\$15.00
#8	15905	\$8.80	\$11.60

SM-42 • 1/8 X 7/16 14° IncTaper

Cut	EDP#	Price	Coated
#1	15946	\$6.90	\$9.70
#2	15947	\$8.40	\$11.20
#3	15948	\$7.30	\$10.10
#4	15949	\$7.70	\$10.50
#5	15950	\$8.10	\$10.90
#6	15951	\$8.80	\$11.60
#7	15952	\$9.50	\$15.00
#8	15953	\$8.80	\$11.60

SA-42 • 3/32 X 7/16

Cut	EDP#	Price	Coated
#1	05909	\$6.00	\$8.80
#2	05910	\$7.50	\$10.30
#3	05911	\$6.40	\$9.20
#4	05912	\$6.80	\$9.60
#5	05913	\$7.20	\$10.00
#6	05914	\$7.90	\$10.70
#7	05915	\$8.60	\$14.10
#8	05916	\$7.90	\$10.70

SD-41 • 3/32 Ball

Cut	EDP#	Price	Coated
#1	05957	\$6.90	\$9.70
#2	05958	\$8.40	\$11.20
#3	05959	\$7.30	\$10.10
#4	05960	\$7.70	\$10.50
#5	05961	\$8.10	\$10.90
#6	05962	\$8.80	\$11.60
#7	05963	\$9.50	\$15.00
#8	05964	\$8.80	\$11.60

SF-41 • 1/8 X 1/4

Cut	EDP#	Price	Coated
#1	15906	\$6.90	\$9.70
#2	15907	\$8.40	\$11.20
#3	15908	\$7.30	\$10.10
#4	15909	\$7.70	\$10.50
#5	15910	\$8.10	\$10.90
#6	15911	\$8.80	\$11.60
#7	15912	\$9.50	\$15.00
#8	15913	\$8.80	\$11.60

SM-43 • 1/8 X 5/8 7° IncTaper

Cut	EDP#	Price	Coated
#1	15954	\$6.90	\$9.70
#2	15955	\$8.40	\$11.20
#3	15956	\$7.30	\$10.10
#4	15957	\$7.70	\$10.50
#5	15958	\$8.10	\$10.90
#6	15959	\$8.80	\$11.60
#7	15960	\$9.50	\$15.00
#8	15961	\$8.80	\$11.60

SA-41 • 1/16 X 1/4

Cut	EDP#	Price	Coated
#1	05917	\$6.90	\$9.70
#2	05918	\$8.40	\$11.20
#3	05919	\$7.30	\$10.10
#4	05920	\$7.70	\$10.50
#5	05921	\$8.10	\$10.90
#6	05922	\$8.80	\$11.60
#7	05923	\$9.50	\$15.00
#8	05924	\$8.80	\$11.60

SE-41 • 1/8 X 1/4

Cut	EDP#	Price	Coated
#1	05965	\$6.90	\$9.70
#2	05966	\$8.40	\$11.20
#3	05967	\$7.30	\$10.10
#4	05968	\$7.70	\$10.50
#5	05969	\$8.10	\$10.90
#6	05970	\$8.80	\$11.60
#7	05971	\$9.50	\$15.00
#8	05972	\$8.80	\$11.60

SG-44 • 1/8 X 1/2

Cut	EDP#	Price	Coated
#1	15914	\$6.90	\$9.70
#2	15915	\$8.40	\$11.20
#3	15916	\$7.30	\$10.10
#4	15917	\$7.70	\$10.50
#5	15918	\$8.10	\$10.90
#6	15919	\$8.80	\$11.60
#7	15920	\$9.50	\$15.00
#8	15921	\$8.80	\$11.60

SL-41 • 1/8 X 3/8 8° IncTaper

Cut	EDP#	Price	Coated
#1	15962	\$6.90	\$9.70
#2	15963	\$8.40	\$11.20
#3	15964	\$7.30	\$10.10
#4	15965	\$7.70	\$10.50
#5	15966	\$8.10	\$10.90
#6	15967	\$8.80	\$11.60
#7	15968	\$9.50	\$15.00
#8	15969	\$8.80	\$11.60

SB-41 • 1/8

Cut	EDP#	Price	Coated
#1	05925	\$6.90	\$9.70
#2	05926	\$8.40	\$11.20
#3	05927	\$7.30	\$10.10

SH-41 • 1/8 X 1/4

Cut	EDP#	Price	Coated
#1	05973	\$6.90	\$9.70
#2	05974	\$8.40	\$11.20
#3	05975	\$7.30	\$10.10
#4	05976	\$7.70	\$10.50
#5	05977	\$8.10	\$10.90
#6	05978	\$8.80	\$11.60
#7	05979	\$9.50	\$15.00
#8	05980	\$8.80	\$11.60

SG-43 • 1/8 X 3/8

Cut	EDP#	Price	Coated
#1	15922	\$6.90	\$9.70
#2	15923	\$8.40	\$11.20
#3	15924	\$7.30	\$10.10
#4	15925	\$7.70	\$10.50
#5	15926	\$8.10	\$10.90
#6	15927	\$8.80	\$11.60
#7	15928	\$9.50	\$15.00
#8	15929	\$8.80	\$11.60

SL-42 • 1/8 X 1/2 8° IncTaper

Cut	EDP#	Price	Coated
#1	15970	\$6.90	\$9.70
#2	15971	\$8.40	\$11.20
#3	15972	\$7.30	\$10.10
#4	15973	\$7.70	\$10.50
#5	15974	\$8.10	\$10.90
#6	15975	\$8.80	\$11.60
#7	15976	\$9.50	\$15.00
#8	15977	\$8.80	\$11.60

SC-42 • 1/8 X 9/16

Cut	EDP#	Price	Coated
#1	05933	\$6.90	\$9.70
#2	05934	\$8.40	\$11.20
#3	05935	\$7.30	\$10.10
#4	05936	\$7.70	\$10.50
#5	05937	\$8.10	\$10.90
#6	05938	\$8.80	\$11.60
#7	05939	\$9.50	\$15.00
#8	05940	\$8.80	\$11.60

SN-42 • 1/8 X 3/16

Cut	EDP#	Price	Coated
#1	05981	\$6.90	\$9.70
#2	05982	\$8.40	\$11.20
#3	05983	\$7.30	\$10.10
#4	05984	\$7.70	\$10.50
#5	05985	\$8.10	\$10.90
#6	05986	\$8.80	\$11.60
#7	05987	\$9.50	\$15.00
#8	05988	\$8.80	\$11.60

SG-41 • 1/8 X 1/4

Cut	EDP#	Price	Coated
#1	15930	\$6.90	\$9.70
#2	15931	\$8.40	\$11.20
#3	15932	\$7.30	\$10.10
#4	15933	\$7.70	\$10.50
#5	15934	\$8.10	\$10.90
#6	15935	\$8.80	\$11.60
#7	15936	\$9.50	\$15.00
#8	15937	\$8.80	\$11.60

SK-42 • 1/8 90° IncTaper

Cut	EDP#	Price	Coated
#1	15978	\$6.90	\$9.70
#2	15979	\$8.40	\$11.20
#3	15980	\$7.30	\$10.10
#4	15981	\$7.70	\$10.50
#5	15982	\$8.10	\$10.90
#6	15983	\$8.80	\$11.60
#7	15984	\$9.50	\$15.00
#8	15985	\$8.80	\$11.60

SC-41 • 3/32 X 7/16

Cut	EDP#	Price	Coated
#1	05941	\$6.90	\$9.70
#2	05942	\$8.40	\$11.20
#3	05943	\$7.30	\$10.10
#4	05944	\$7.70	\$10.50
#5	05945	\$8.10	\$10.90
#6	05946	\$8.80	\$11.60
#7	05947	\$9.50	\$15.00
#8	05948	\$8.80	\$11.60

SN-41 • 3/32 X 1/8

Cut	EDP#	Price	Coated
#1	05989	\$6.90	\$9.70
#2	05990	\$8.40	\$11.20
#3	05991	\$7.30	\$10.10
#4	05992	\$7.70	\$10.50
#5	05993	\$8.10	\$10.90
#6	05994	\$8.80	\$11.60
#7	05995	\$9.50	\$15.00
#8	05996	\$8.80	\$11.60

SM-41 • 1/8 X 11/32 12° IncTaper

Cut	EDP#	Price	Coated
#1	15938	\$6.90	\$9.70
#2	15939	\$8.40	\$11.20
#3	15940	\$7.30	\$10.10
#4	15941	\$7.70	\$10.50
#5	15942	\$8.10	\$10.90
#6	15943	\$8.80	\$11.60
#7	15944	\$9.50	\$15.00
#8	15945	\$8.80	\$11.60

SJ-42 • 1/8 60° IncTaper

Cut	EDP#	Price	Coated
#1	15986	\$6.90	\$9.70
#2	15987	\$8.40	\$11.20
#3	15988	\$7.30	\$10.10
#4	15989	\$7.70	\$10.50
#5	15990	\$8.10	\$10.90
#6	15991	\$8.80	\$11.60
#7	15992	\$9.50	\$15.00
#8	15993	\$8.80	\$11.60



ULTRATOOL® Technical Data

SmoothEdge®

The Edge Preparation Process

Our cutting edges are literally too sharp for certain materials. For our carbide inserts and now increasingly for our solid carbide round tools, proper edge preparation can yield huge productivity improvements to "out of the box" tool application. Using a process we call **SmoothEdge®** and performed on machine tools developed in our own R&D lab, we've taken the mystery out of tool "break-in" and provided a consistency that can be counted on time and again. All five types of **SmoothEdge** will yield different benefits dependent upon application. **SmoothEdge** will make your tools sound and run smooth from the first cut and protect your tooling investment from unnecessary potential for chipping during initial tool paths.



Combine **SmoothEdge** with our other value added features to design the ultimate cutting solution.

SmoothGrind®

- Lubricity
- Sharpness
- Polished Cutting Edges
- Hardness & Adhesion
- Masked Shanks
- Coating Uniformity
- Minimized TIR
- Shrink Fit Ready (SFR)
- Tight Tolerances

SmoothCoat®
SmoothConcavity®

Primary SmoothCoat recommendations:



A1 for SE3



TA for SE4



AT for SE5

Our newest technology can achieve incredible productivity increases in specific applications. Many of our new Series include **SmoothEdge** as a standard feature, while on others it can be added as a same day post treatment for a small charge. Ask your Inside Sales representative about **SmoothEdge** today!



SmoothEdge 1

A microblasting treatment using extremely fine aluminum oxide powder to smooth the carbide surface while generating a very light edge preparation. This feature comes standard with any **SmoothCoat®** coating.

Uses: Highly recommended for most milling and drilling applications.



SmoothEdge 2

A lapping treatment to create extreme lubricity & smoothness with minimal edge prep on uncoated tools.

Uses: Highly recommended for milling and drilling of aluminum and other non-ferrous applications using uncoated tools.



SmoothEdge 3

Combines microblasting and lapping for a light hone with extreme lubricity.

Uses: Highly recommended for milling and drilling applications of aluminum and other non-ferrous applications using coated tools.



SmoothEdge 4

Adds a proprietary hone to the blasting and lapping cycles for a medium edge prep with excellent lubricity.

Uses: Highly recommended for milling and drilling applications involving general steels, stainless, and cast iron.



SmoothEdge 5

Doubles the honing and lapping cycle for maximum edge strength; a robust edge preparation combined with excellent lubricity characteristics.

Uses: Highly recommended for milling and drilling applications involving stainless, high-temp alloys, and exotics.

ULTRATOOL® Technical Data

With so many variables present in the machining process, it is essential to optimize every possible factor to achieve world-class efficiency. Your choice of a genuine Ultra-Tool® Solid Carbide product is an excellent first step in the process. Ultra-Tool® Solid Carbide products are high-performance tools that will perform best in a machining environment characterized by rigid fixturing and minimal spindle runout. Attention to proper speed and feed will eliminate vibration, chatter, and overheating as well as extending tool life. Generally speaking, the peripheral speed of solid carbide tools will vary with the hardness of the material being cut. The harder the material, the slower the speed. High speed and insufficient feed will cause work surface glazing and poor tool life. Chipping of cutting edges is an indication of chatter which can be caused by too high a speed, too light a cut, or improper support of the tool or workpiece. Handling is also very important; sharpened cutting edges should never be allowed to come into contact with any hard object (or another tool) in a non-machining environment as they will chip easily. Keep your Ultra-Tool® products in their original protective packaging until ready for use.

The guidelines on the following pages are generalities designed to demonstrate the operating window within which you may experience the best results. The charts and information should prove valuable in longer tool life with greatly reduced operational costs. This information is for uncoated product: SmoothCoat products will have significantly higher speed and feed rates. For more information contact an Ultra-Tool® Factory Engineer, Sales Manager or consult our website at www.ultra-tool.com. Also coming soon, the ultimate shared applications database: speedsandfeeds.com.

Ultra-Tool International, Inc. is constantly striving to improve its processes, specifications, and tolerances. As such, products are subject to change without prior notice.

WARNING: Grinding or other use of this tool may produce hazardous dust and fumes which may endanger health. To avoid adverse health effects, read the material safety data sheet for this product. Utilize adequate ventilation and appropriate protection. Cutting tools may shatter when broken; eye protection in vicinity of use is strongly advised. MSDS available at www.ultra-tool.com.



Commonly Used Formulas:

Surface Feet Minute (SFM)=RPM x Diam. x .262
 Revolutions Per Minute (RPM)=3.82 x (SFM / Diam.)
 Feed Rate (IPM)=IPT x #teeth x RPM
 Drilling (IPM)=IPR x RPM
 Feed Per Tooth (IPT)=IPM / (#teeth x RPM)
 Convert Inches to millimeters: Multiply by 25.4
 Convert millimeters to Inches: Multiply by .03937

Tech Help Call, e-mail us at technical@toolalliance.com, or copy / fax us this page for detailed assistance beyond what printed materials can provide. Please have the following information available to assure we can promptly process a response.

Checklist:

- Tool Description
- Application Description
- Work Piece Material
- Hardness (HRC)
- Current Speed (RPM or SFPM)
- Current Feed (CPT or IPM or FPR)
- Axial DOC
- Radial DOC
- Hole Depth (drilling)
- Machine Tool



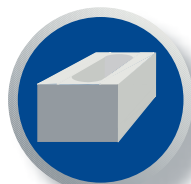
Face Milling



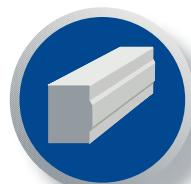
End Milling



Slot Milling



Pocket Milling



Peripheral Milling



Application Tips for ULTRATOOL Solid Carbide Products

Trouble Shooting for Ultra-Tool® Carbide End Mills

Problem	Cause	Solution
Chipping	- Feed rate too high - Up milling (conventional) - Cutting edge too sharp - Chattering - Loose tool - Workpiece rigidity - Tool rigidity - Low cutting speed - Loose toolholder	- Reduce feed rate - Change to down milling (climb) - Hone cutting edge or allow break-in - Reduce RPM - Remove, clean, and retighten - Tighten workpiece holding method - Shorten LOC, place shank further up holder - Increase RPM - Remove from spindle, clean and replace
Wear	- High cutting speed - Low feed rate - Up milling (conventional) - Hard material - Poor chip evacuation - Improper cutter helix - Poor coolant	- Reduce RPM - Increase feed rate - Change to down milling (climb) - Use coated tool - Reposition coolant lines, use air blasting - Change to recommended helix angle - Replace coolant or correct mixture
Breakage	- Feed rate too high - Depth of cut too large - Poor tool rigidity - Tool wear - Poor chip evacuation	- Reduce feed rate - Reduce depth of cut - Shorten LOC, place shank further up holder - Replace/regrind sooner - Reposition coolant lines, use air blasting
Chattering	- Speed and feed too high - Poor toolholder rigidity - Poor spindle rigidity - Workpiece rigidity - Relief angle too high - Depth of cut too large - Poor tool rigidity	- Reduce feed rate - Replace with shorter/more rigid holder - Use larger spindle or different machine tool - Tighten workpiece holding method - Regrind with smaller relief angle - Reduce depth of cut - Shorten LOC, place shank further up holder
Short Life	- Cutter/workpiece friction - Hard material - Poor material condition - Improper cutter angle - Poor coolant	- Use coated tool - Use coated tool - Use coated tool, clean material surface - Regrind with proper primary relief angle - Replace coolant or correct mixture
Chip Packing	- Feed rate too high - Low cutting speed - Insufficient chip room - Insufficient coolant	- Reduce feed rate or increase speed - Increase RPM or reduce feed rate - Use tool with less flutes, increase helix - Increase volume of coolant
Poor Surface Finish	- Feed rate too high - Low cutting speed - Tool wear - Edge build up - Depth of cut too large - Chip welding	- Reduce feed rate - Increase RPM - Replace or regrind tool - Increase RPM, switch to higher helix tool - Reduce depth of cut - Increase volume of coolant
Burring or Workpiece Chipping	- Tool wear - Improper helix angle - Feed rate too high - Depth of cut too large	- Replace or regrind tool - Change to recommended helix angle - Reduce feed rate - Reduce depth of cut
Workpiece Inaccuracy	- Loose/worn toolholder - Poor toolholder rigidity - Poor spindle rigidity - Insufficient number of flutes - Tool deflection	- Repair or replace - Replace with shorter/more rigid toolholder - Use larger spindle or different machine tool - Use tool with higher flute quantity - Shorten LOC, place shank further up holder

Trouble Shooting for Ultra-Tool® Carbide Drills

Problem	Cause	Solution (see key below)
Heavy Wear at Outer Edge	- Insufficient coolant - Incorrect speed & feed	5, 6 1, 2, 8
Chipping at Outer Cutting Edge	- Loose tool, tool movement - Workpiece movement - Poor coolant conditions - Incorrect speed & feed	8, 10, 11, 12, 14, 16, 17, 21 8, 12, 13, 21 5, 6 1, 2, 3, 4
Drill Point Chipping	- Loose tool, tool movement - Incorrect speed & feed - Drill centering	10, 11, 12, 14 1, 2, 3, 4 8, 10, 11, 12, 21
Margin Wear	- Drill margin rubbing wall - Poor chip evacuation - Poor coolant conditions - Workpiece movement	20 (check drill for backtaper) 5, 6, 8, 20 5, 6 8, 13, 21
Tool Breakage	- Loose tool, tool movement - Workpiece movement - Wrong drill type - Poor coolant conditions - Incorrect speed & feed	8, 10, 11, 12, 14, 16, 17, 21 8, 12, 13, 21 9, 15, 16, 18, 19, 20 5, 6 1, 2, 3, 4
Poor Tool Life	- Incorrect speed & feed - Poor coolant conditions - Wrong drill point	1, 2, 3, 4 5, 6 8, 21
Drill Walk	- Incorrect speed & feed - Tool wear - Wrong drill point - Material condition	1, 2 7, 8, 21 8, 10, 11, 21 11, 12, 15, 16, 17
Chip Welding	- Poor coolant conditions - Wrong drill type	5, 6 19, 20
Hole Size Inaccuracy	- Incorrect speed & feed - Poor coolant conditions - Loose tool - Wrong drill type	1, 2, 3, 4 5, 6 14 9, 18
Non-Cylindrical Hole	- Loose tool, tool movement - Workpiece movement - Incorrect speed & feed - Wrong drill type	8, 10, 11, 12, 14, 16, 17 13 1, 2 18, 21
Heavy Burr	- Incorrect speed & feed - Incorrect drill point	1, 2 8, 21
Blue Chips	- Poor coolant conditions - Tool wear	5, 6 7, 8
Long Chips	- Poor point grind - Incorrect speed & feed	8 1, 2
Solutions Key for Drills	1) Reduce RPM 8) Repoint drill 15) Use straight flute 2) Increase feed 9) Correct drill type/size 16) Use stub length 3) Increase RPM 10) Use self-centering drill 17) Place further up holder 4) Reduce feed 11) Spot/center drill 18) Use three-flute 5) Increase coolant 12) Clean surface 19) Use slower helix 6) Increase mixture 13) Improve rigidity/clamp 20) Use parabolic design 7) Add negative hone 14) Tighten holder 21) Change point style	

Trouble Shooting for Ultra-Tool® Carbide Reamers

Problem	Cause	Solution
Chatter	- High cutting speed - Feed rate too low - Workpiece movement - Toolholder rigidity - Tool rigidity	- Lower RPM or increase feed rate - Increase feed rate - Tighten workpiece rigidity - Tighten toolholder or reduce float - Use shorter tool, place further up holder
Tool Wear / Chipping	- Incorrect feed rate - Incorrect speed - Poor hole condition - Abrasive material - Poor chip evacuation - Poor coolant - Insufficient coolant - Workpiece alignment - Excessive stock removal	- Increase feed rate (typically) - Reduce speed (typically) - Work-hardened hole; change drilling type - Use proper coolant, coated reamer - Use/increase coolant, use helical reamer - Replace coolant or correct mixture - Increase coolant volume - Use bushing, floating holder, lead chamfer - Use larger diameter starter drill
Tool Breakage	- Incorrect feed rate - Incorrect speed - Tool wear - Bottoming of hole - Coolant conditions - Insufficient stock removal - Poor set up - Excessive stock removal	- Increase feed rate (typically) - Reduce speed (typically) - Sharpen or replace reamer - Adjust stop depth, check preset - Increase, replace, or correct coolant - Use smaller diameter starter drill - Use bushing, floating toolholder - Use larger diameter starter drill
Poor Finish	- Feed rate too low - Insufficient stock removal - Poor hole condition - Poor coolant - Insufficient coolant	- Increase feed rate - Use smaller diameter starter drill - Work-hardened hole; change drilling type - Replace/correct coolant mixture - Increase coolant volume
Hole Tolerance	- Workpiece alignment - Incorrect tool size - Material shrinkage - Tool wear - Toolholder runoff	- Use bushing, floating toolholder - Check diameter of tool - Adjust diameter for shrinkage; more coolant - Sharpen or replace tool - Adjust or replace toolholder

Application Data for Standard ULTRATOOL® End Mills

The milling data presented below is for all "standard" Series of Ultra end mills (data is presented separately on each respective product page for our application-specific high performance designs). Note: When using SmoothCoat & SmoothEdge surface treatments, Surface Feet or Meters Per Minute can be increased from the stated levels by at least 25%.



Peripheral Milling data based on axial depth ≤ 100% of tool diameter & radial depth of ≤ 25% of tool diameter.



Slot Milling data based on axial depth of cut = 50% of tool diameter.

End Mill Specifications:

Diameter: +.000 / -.002
Shank Diameter: +.0000 / -.0003
LOC: +.060 / -.000
OAL: ± .060
Helix: ± 2°

Milling;
Fractional

Material	SFPM	SFPM	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"
Steel	Peripheral	Slotting					Feed Per Tooth (FPT)					
1018 / 1020	150 to 350	150 to 300	.0005	.0010	.0015	.0018	.0020	.0025	.0030	.0035	.0040	.0045
4140 / 4340 / P20	150 to 300	125 to 225	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0030	.0040
Stainless Steel												
303 / 304 / 316	150 to 300	125 to 250	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0030	.0040	.0040
410 / 420 / 440C	150 to 300	125 to 250	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0035	.0038
15-5/17-4 ≤ 32HRc	125 to 250	100 to 225	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0030	.0038
15-5/17-4 ≥ 32HRc	100 to 150	100 to 150	.0003	.0005	.0010	.0012	.0015	.0015	.0015	.0020	.0030	.0038
13-8 / 316L	125 to 300	125 to 250	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0030	.0040	.0040
Tool Steel												
A2/D2/H13 ≤ 32HRc	125 to 250	100 to 200	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0030	.0035
A2/D2/H13 ≥ 32HRc	100 to 150	100 to 125	.0003	.0005	.0010	.0012	.0015	.0015	.0015	.0020	.0030	.0035
Titanium												
6Al-4V	120 to 250	100 to 175	.0005	.0007	.0010	.0012	.0012	.0018	.0020	.0020	.0030	.0040
High Temp Alloys												
Inconel 625	50 to 150	50 to 125	.0005	.0007	.0010	.0012	.0012	.0018	.0020	.0020	.0025	.0030
Inconel 718	50 to 150	50 to 125	.0003	.0005	.0010	.0012	.0012	.0015	.0015	.0020	.0025	.0025
Cast Iron												
Gray Iron ≤ 32HRc	150 to 350	125 to 300	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0030	.0040	.0045
Ductile Iron	150 to 300	125 to 250	.0005	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0035	.0045
Non-Ferrous												
6061 T6 Aluminum	up to 2000	up to 1500	.0010	.0020	.0020	.0025	.0030	.0035	.0040	.0050	.0060	.0070
Copper, Brass, Bronze	up to 1200	up to 1000	.0010	.0010	.0020	.0022	.0025	.0028	.0030	.0040	.0040	.0050
Plastic	up to 2000	up to 1500	.0010	.0020	.0030	.0035	.0040	.0050	.0060	.0080	.0100	.0120

Metric End Mill Specifications:

Diameter (mm): +.000 / -.051 mm
Shank Diameter (mm): +.000 / -.007 mm
LOC: +1.52 / -.00 mm
OAL: ± 1.52 mm

Metric

Material	SMPM	SMPM	2 mm	3 mm	4 mm	6 mm	8 mm	10 mm	12 mm	16 mm	20 mm	25 mm
Steel	Peripheral	Slotting					Feed Per Tooth (FPT)					
1018 / 1020	45 to 110	45 to 90	0.010	0.012	0.025	0.038	0.045	0.050	0.080	0.090	0.100	0.120
4140 / 4340 / P20	45 to 90	40 to 70	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.080	0.100
Stainless Steel												
303 / 304 / 316	45 to 90	40 to 75	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.080	0.100	0.100
410 / 420 / 440C	45 to 90	40 to 75	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.080	0.100
15-5/17-4 ≤ 32HRc	38 to 75	30 to 70	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.080	0.100
15-5/17-4 ≥ 32HRc	30 to 45	30 to 45	0.005	0.007	0.012	0.025	0.030	0.038	0.038	0.050	0.080	0.100
13-8 / 316L	38 to 90	40 to 75	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.080	0.100	0.100
Tool Steel												
A2/D2/H13 ≤ 32HRc	38 to 75	30 to 60	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.080	0.090
A2/D2/H13 ≥ 32HRc	30 to 45	30 to 40	0.005	0.007	0.012	0.025	0.030	0.038	0.038	0.050	0.080	0.090
Titanium												
6Al-4V	35 to 75	30 to 53	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.080	0.100
High Temp Alloys												
Inconel 625	15 to 45	15 to 38	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.050	0.065	0.070
Inconel 718	15 to 45	15 to 38	0.005	0.007	0.012	0.025	0.030	0.038	0.038	0.050	0.065	0.065
Cast Iron												
Gray Iron ≤ 32HRc	45 to 110	40 to 90	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.080	0.100	0.120
Ductile Iron	45 to 90	40 to 75	0.010	0.012	0.018	0.025	0.030	0.038	0.050	0.065	0.090	0.120
Non-Ferrous												
6061 T6 Aluminum	up to 600	up to 450	0.020	0.025	0.050	0.050	0.064	0.080	0.100	0.130	0.150	0.180
Copper, Brass, Bronze	up to 365	up to 300	0.020	0.025	0.025	0.050	0.056	0.065	0.080	0.100	0.100	0.130
Plastic	up to 600	up to 450	0.020	0.025	0.050	0.080	0.089	0.100	0.150	0.200	0.250	0.300



Application Data for ULTRATOOL® Drills



Drilling speeds and feeds are based upon hole depth of up to 3X diameter. For deeper hole ratios reduce speeds and feeds by 10% to 25%.



Drilling;
Fractional

Material	SFPM	SFPM	1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"
Steel	Uncoated	SmoothCoat	Feed Rate: Inches Per Rev (IPR)									
1018 / 1020	100 to 250	100 to 300	.0010	.0030	.0050	.0070	.0090	.0100	.0110	.0120	.0140	.0160
4140 / 4340 / P20	60 to 230	60 to 260	.0010	.0030	.0050	.0070	.0090	.0100	.0110	.0120	.0140	.0160
Stainless Steel												
303 / 304 / 316	60 to 150	60 to 200	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
410 / 420 / 440C	40 to 100	40 to 150	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
15-5/17-4 ≤ 32HRc	75 to 175	75 to 200	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
15-5/17-4 ≥ 32HRc	50 to 125	50 to 150	.0005	.0010	.0015	.0025	.0030	.0035	.0038	.0040	.0050	.0060
13-8 / 316L	60 to 150	60 to 200	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
Tool Steel												
A2/D2/H13 ≤ 32HRc	60 to 150	60 to 200	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
A2/D2/H13 ≥ 32HRc	40 to 100	40 to 150	.0005	.0010	.0015	.0025	.0028	.0030	.0035	.0040	.0050	.0060
Titanium												
6Al-4V	40 to 150	40 to 175	.0005	.0010	.0020	.0025	.0028	.0030	.0035	.0040	.0050	.0060
High Temp Alloys												
Inconel 625	30 to 70	30 to 80	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
Inconel 718	30 to 45	30 to 50	.0005	.0010	.0020	.0025	.0028	.0030	.0035	.0040	.0050	.0060
Cast Iron												
Gray Iron ≤ 32HRc	150 to 300	150 to 350	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Ductile Iron	150 to 300	150 to 350	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Non-Ferrous												
6061 T6 Aluminum	250 to 750	250 to 1000	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Copper, Brass, Bronze	150 to 400	150 to 500	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Plastic	250 to 1000	250 to 1000	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160

Drill Specifications:

Diameter: +.0000 / -.0003

LOC: +.060 / -.090

OAL: +.060 / -.090

Point Angle: ±1°

Helix Angle: ±1°

Note: Series 560 Combined Drill/C'sink:

Body Diameter: +.0000 / -.0003

Drill Diameter: +.003 / -.000

Ultra-Tool® drills feature diameter tolerances 40% tighter than industry standards. Plus, all shanks are SFR (shrink-fit ready).

Try our drills with standard SmoothCoat for a superb leap in lubricity, productivity, and tool life.



Complete range of Brad Point drills with D1 coating!

Application Data for ULTRATOOL® Burrs

De-Burring

Burr Diam	Diam Metric	# Flutes Std Cut	RPM*	Max. RPM
1/16	1.6 mm	8	60,000 - 90,000	100,000
1/8	3.2 mm	12	40,000 - 70,000	90,000
3/16	4.8 mm	14	35,000 - 60,000	80,000
1/4	6.3 mm	18	30,000 - 50,000	70,000
5/16	8.0 mm	20	20,000 - 40,000	68,000
3/8	9.5 mm	22	20,000 - 40,000	66,000
7/16	11.0 mm	22	15,000 - 40,000	58,000
1/2	12.7 mm	24	15,000 - 40,000	50,000
5/8	16.0 mm	30	12,000 - 25,000	40,000
3/4	19.0 mm	34	10,000 - 20,000	33,000
1"	25.4 mm	44	7,500 - 20,000	25,000

Burr Specifications:

Standard cylindrical helix angle: 30° ± 2°

Cutting Diameter: ± .010

Flute Count: ± 1

Shank Diameter: +0 / -.0005, TIR max .002

Brazed Burr TIR: max .005

Taper Angles: ± 1°

*Speeds are for Standard Cut. Reduce by approximately 25% with addition of Dura-Cut.

Fine-Cut increases flute count approximately 50%. Decrease speed accordingly. Coarse-Cut decreases flute count approximately 25%. Increase speed accordingly. Lower listed speeds when cutting harder ferrous materials.

Ultra-Tool® Burrs feature higher hardness and a greater flute count than most competing brands for increased tool life.

Burr heads and solid carbide burrs are manufactured from Ultra-Carb®. Shanks are high speed steel hardened to a rating of 45-48 Rockwell C. Two-piece construction products are induction brazed (using controlled frequency amplification) and slow cooled in our own factory for maximum strength.



Now available with standard TA and A1 SmoothCoat!

Application Data for ULTRATOOL® Reamers



Spiral flutes produce the best hole finish. Right-hand spiral should be used for blind holes, while left-hand spiral is excellent for thru-hole applications. Straight flute is appropriate for all general reaming requirements.



Reaming;
Fractional

Material	SFPM	SFPM	1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"
Steel	Uncoated	SmoothCoat	Feed Rate: Inches Per Rev (IPR)									
1018 / 1020	50 to 125	50 to 150	.0040	.0050	.0050	.0060	.0070	.0080	.0090	.0100	.0100	.0100
4140 / 4340 / P20	40 to 120	40 to 140	.0040	.0040	.0040	.0040	.0050	.0050	.0050	.0060	.0060	.0060
Stainless Steel												
303 / 304 / 316	30 to 120	30 to 140	.0040	.0050	.0050	.0060	.0070	.0080	.0090	.0100	.0100	.0100
410 / 420 / 440C	20 to 80	20 to 100	.0040	.0050	.0050	.0060	.0070	.0080	.0090	.0100	.0100	.0120
15-5/17-4 ≤ 32HRc	40 to 140	40 to 160	.0040	.0040	.0040	.0040	.0050	.0050	.0050	.0060	.0070	.0080
15-5/17-4 ≥ 32HRc	25 to 100	25 to 120	.0020	.0020	.0030	.0030	.0040	.0040	.0050	.0050	.0060	.0060
13-8 / 316L	30 to 120	30 to 140	.0040	.0050	.0050	.0060	.0070	.0080	.0090	.0100	.0100	.0100
Tool Steel												
A2/D2/H13 ≤ 32HRc	30 to 120	30 to 120	.0040	.0040	.0040	.0040	.0050	.0050	.0050	.0060	.0070	.0080
A2/D2/H13 ≥ 32HRc	20 to 80	20 to 100	.0020	.0020	.0030	.0030	.0040	.0040	.0050	.0050	.0060	.0060
Titanium												
6Al-4V	20 to 100	20 to 120	.0020	.0020	.0030	.0030	.0040	.0040	.0060	.0060	.0080	.0100
High Temp Alloys												
Inconel 625	20 to 60	20 to 80	.0020	.0020	.0030	.0030	.0040	.0040	.0050	.0050	.0060	.0060
Inconel 718	20 to 50	20 to 70	.0020	.0020	.0030	.0030	.0040	.0040	.0050	.0050	.0060	.0060
Cast Iron												
Gray Iron ≤ 32HRc	80 to 200	80 to 250	.0060	.0060	.0060	.0060	.0070	.0080	.0100	.0120	.0140	.0150
Ductile Iron	80 to 200	80 to 250	.0060	.0060	.0060	.0060	.0070	.0080	.0100	.0100	.0100	.0120
Non-Ferrous												
6061 T6 Aluminum	100 to 300	100 to 375	.0050	.0050	.0060	.0060	.0070	.0080	.0100	.0120	.0140	.0150
Copper, Brass, Bronze	75 to 200	75 to 250	.0050	.0050	.0060	.0060	.0070	.0080	.0100	.0120	.0140	.0150
Plastic	100 to 350	100 to 350	.0050	.0050	.0060	.0060	.0070	.0080	.0100	.0120	.0140	.0150

Total Stock Removal:

Minimum and Maximum amounts of stock removal should be adhered to for proper reaming action. This is the amount the reamer should be oversized relative to the drilled hole.

Up to 1/16	.003 - .005
1/16 to 1/8	.004 - .008
1/8 to 1/4	.006 - .012
1/4 to 3/8	.008 - .014
3/8 to 1/2	.010 - .015
1/2 to 1"	.012 - .020

All Ultra-Tool® reamer products are manufactured from Ultra-Carb®. Carbide reamers constructed with steel shank are induction-brazed (using controlled-frequency amplification) and slow-cooled in our own factory for maximum strength. All products are manufactured with centers (male, female, or both) for high concentricity characteristics and resharping capabilities. Also, shanks are ground to the next smallest common fractional diameter for effective tool-holding and practicality. Note: Series 411 has oversized shank with clearance neck and does not feature centers.

Reamer Specifications:

Cutting Diameter: +.0002 / -0
Shank Diameter: ±.0005
LOC: ±.030
OAL: ±.060
Helix (RH & LH): 12°
Lead Angle: 45°

new! Now available with TA coating!

Application Data for ULTRATOOL® Slitting Saws

All Ultra-Tool® Saw products are manufactured from Ultra-Carb®. Use a higher RPM and lower feed ratios than in most cutting tool applications. Use light viscosity coolants at most; dry running is acceptable and/or preferred. Concentricity is the single most determining factor in an efficient slotting operation.

new! Now available with standard SmoothCoat!

Saw Specifications:

Diameter: ±.015
Hole (ID): +.0005 / -.0000
Thickness: ±.00025

Material Group	Speed SFPM	Slitting
Aluminum/Related Alloys	700-1000	
Brass/Bronze	450-750	
Cast Iron (soft)	250-450	
Cast Iron (medium)	150-350	
Cast Iron (hard)	100-200	
Magnesium	800-1200	
Monel/Nickel Alloys	150-225	
Steel-Heat Treated (35-40Rc)	150-250	
Steel-Heat Treated (40-45Rc)	100-200	
Steel-Heat Treated (45+Rc)	75-135	
Steel-Low Carbon	250-425	
Stainless-Soft	200-300	
Stainless-Hard	100-200	
Titanium Alloys	150-275	

Feed Rate: Chip Load from .0001 per tooth (hardest materials) to .0015 (easiest machinability).



ULTRA-TOOL® Terms & Conditions

Ordering Information: All Ultra-Tool® products have a Series-Size designator and EDP number. One or both may be used when entering orders via e-mail or fax (preferred methods), phone, or postal mail communications. If the product is coated, be sure to include the coating suffix.

Availability: Ultra-Tool® products are available only through select Industrial Distributors worldwide. Locally, your Industrial Distributor can provide communication, technical assistance, and inventory support. Standard products are subject to prior sale.

Pricing: All prices shown are effective June 16, 2008, supersede and cancel all previous listed prices, and are subject to change without notice. The amount of any present or future sales tax, value-added tax, or similar tax applicable to the products listed herein shall be added to the purchase price and paid by the customer. All sales made at list price less standard applicable distributor discount. Contract pricing must be obtained in writing via current quotation, with stated pricing, effective date, and expiration date, to be valid.

Shipping: Preferred carriers are UPS ground services, Federal Express Express Saver (Guaranteed 3-Day), and Federal Express premium services. Prices quoted herein are F.O.B. our Factory in Huntington Beach, California, U.S.A.

Terms: Domestic and Export Net 30 Days.

Minimum Charge: \$50.00 Net.

Returned Items: Current catalog items are returnable subject to a 25% handling charge and approval by the Ultra-Tool® Inspection Department. Credit cannot be issued for any product that has in any way been modified, machined, altered, coated, marked, or displaying other characteristics that render it in a "used" condition. A Returned Goods Authorization (RGA) number must be obtained from the Ultra-Tool® Sales Department prior to return. Returned product must be sent to the Factory for credit; consignment locations are not capable of issuing either RGA's or credit memos. Special tools are not returnable.

Specials Policy: We reserve the right to over-ship or under-ship and invoice special tools up to a 10% variance per item. Quantities under 10 are subject to a one-piece variance. Any variations to this policy must be stated in advance as it will effect pricing upon quotation. Special orders cannot be cancelled without prior approval and proper consideration.

Product Warranty: Ultra-Tool® warrants that products sold by it shall be free from defects in materials and workmanship. Ultra-Tool will replace, repair, or grant credit for any product which does not comply with this warranty. This warranty does not apply to any products which have been in any way modified, machined, misused, subjected to accident, or used beyond normal life. Warranty claims should be made through the distributor from whom the product was purchased. There are no other warranties, expressed or implied, made by us except as expressed above, and we neither assume nor authorize any other firm or person to assume for it any other obligation or liability in connection with our products.

Cooperative Advertising: Ultra-Tool® does not participate in any cooperative advertising programs with either industrial distributors or manufacturer's representatives. This policy allows us to avoid any possible favoritism or conflicts of interest, and keeps costs and sales prices as low as possible.

Ultra-Express Reamer Program: Orders must be received by 6 pm EST to be eligible for the Ultra-Express Reamer Program guaranteeing shipment on the following business day (up to 6 pieces per size). Ultra-Tool will pay for Federal Express Standard Overnight weekday delivery for any items that miss the shipment deadline.

ULTRA-TOOL® is friendly to the environment. All paper products are separated for reuse and shredded for packaging materials. Shipping boxes are reused when possible. Conservation programs are in place for reduced energy use (additionally, our coastal location eliminates the need for artificial heating or cooling on most days). All displaced materials during the manufacturing process are collected, separated, and returned to a materials recycler. Coolants are recycled when appropriate. Mop water is evaporated and resultant sediment is properly disposed. Skylights provide natural lighting and reduce electricity usage.

Visit our factories on your next trip to the greater Los Angeles / San Diego, CA area (solid carbide) or Fort Myers / Naples, FL (indexable). View our automated facilities, meet our Associates, and tell us how we can better grow our relationship together. Huntington Beach is officially "Surf City" with miles of open beach on the Pacific Ocean, and we're minutes away from attractions such as Disneyland, Knott's, Universal Studios, Reagan and Nixon Presidential Libraries, Getty Museum, Dodger Stadium, Staples Center, Angel Stadium, Honda Center, The Tool Alliance Club, and the list goes on. The closest airport is Orange County (SNA), followed by Long Beach (LGB), Los Angeles (LAX), and then Ontario (ONT). Fort Myers (airport code RSW) is on the beautiful Gulf of Mexico coast, a recreational haven, home to Major League Baseball spring training, and within a 3-hour drive to Orlando, Tampa Bay, Sarasota, Miami, Fort Lauderdale, the Everglades, and more.



Fort Myers, Florida



Huntington Beach, California



Huntington Beach, California

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ULTRATOOL Decimal Equivalent Chart

80 .0135	1/8 .1250	19/64 .2969	47/64 .7344
79 .0145	30 .1285	N .3020	.7480 19.0mm
1/64 .0156	29 .1360	5/16 .3125	3/4 .7500
78 .0160	.1378 3.5mm	.3150 8.0mm	49/64 .7656
77 .0180	28 .1405	O .3160	.7677 19.5mm
.0197 0.5mm	9/64 .1406	P .3230	25/32 .7812
76 .0200	27 .1440	21/64 .3281	.7874 20.0mm
75 .0210	26 .1470	Q .3320	51/64 .7969
74 .0225	25 .1495	.3346 8.5mm	.8071 20.5mm
73 .0240	24 .1520	R .3390	13/16 .8125
72 .0250	23 .1540	11/32 .3438	.8268 21.0mm
71 .0260	5/32 .1562	S .3480	53/64 .8281
70 .0280	22 .1570	.3543 9.0mm	27/32 .8438
69 .0292	.1575 4.0mm	T .3580	.8465 21.5mm
68 .0310	21 .1590	23/64 .3594	55/64 .8594
1/32 .0312	20 .1610	U .3680	.8661 22.0mm
67 .0320	19 .1660	.3740 9.5mm	7/8 .8750
66 .0330	18 .1695	3/8 .3750	.8858 22.5mm
65 .0350	11/64 .1719	V .3770	57/64 .8906
64 .0360	17 .1730	W .3860	.9055 23.0mm
63 .0370	16 .1770	25/64 .3906	29/32 .9062
62 .0380	.1772 4.5mm	.3937 10.0mm	59/64 .9219
61 .0390	15 .1800	X .3970	.9252 23.5mm
.0394 1.0mm	14 .1820	Y .4040	15/16 .9375
60 .0400	13 .1850	13/32 .4062	.9449 24.0mm
59 .0410	3/16 .1875	Z .4130	61/64 .9531
58 .0420	12 .1890	.4134 10.5mm	.9646 24.5mm
57 .0430	11 .1910	27/64 .4219	31/32 .9688
56 .0465	10 .1935	.4331 11.0mm	.9843 25.0mm
3/64 .0469	9 .1960	7/16 .4375	63/64 .9844
55 .0520	.1969 5.0mm	.4528 11.5mm	1" 1.000 25.4mm
54 .0550	8 .1990	29/64 .4531	
.0591 1.5mm	7 .2010	15/32 .4688	
53 .0595	13/64 .2031	.4724 12.0mm	
1/16 .0625	6 .2040	31/64 .4844	
52 .0635	5 .2055	.4921 12.5mm	
51 .0670	4 .2090	1/2 .5000	
50 .0700	3 .2130	.5118 13.0mm	
49 .0730	.2165 5.5mm	33/64 .5156	
48 .0760	7/32 .2188	17/32 .5312	
5/64 .0781	2 .2210	.5315 13.5mm	
47 .0785	1 .2280	35/64 .5469	
.0787 2.0mm	A .2340	.5512 14.0mm	
46 .0810	15/64 .2344	9/16 .5625	
45 .0820	.2362 6.0mm	.5709 14.5mm	
44 .0860	B .2380	37/64 .5781	
43 .0890	C .2420	.5906 15.0mm	
42 .0935	D .2460	19/32 .5938	
3/32 .0938	E .2500	39/64 .6094	
41 .0960	1/4 .2500	.6102 15.5mm	
40 .0980	.2559 6.5mm	5/8 .6250	
.0984 2.5mm	F .2570	.6299 16.0mm	
39 .0995	G .2610	41/64 .6406	
38 .1015	17/64 .2656	.6496 16.5mm	
37 .1040	H .2660	21/32 .6562	
36 .1065	I .2720	.6693 17.0mm	
7/64 .1094	.2756 7.0mm	43/64 .6719	
35 .1100	J .2770	11/16 .6875	
34 .1110	K .2810	.6890 17.5mm	
33 .1130	9/32 .2812	45/64 .7031	
32 .1160	L .2900	.7087 18.0mm	
.1181 3.0mm	M .2950	23/32 .7188	
31 .1200	.2953 7.5mm	.7283 18.5mm	

Conversion Formulas

inches to millimeters:
multiply by 25.4

millimeters to inches:
multiply by .03937



Ultra-Tool® sales features:

- The Company has a well-known brand, superb quality reputation, and a 40-year operating history.
- Ultra-Tool is dedicated solely to the solid carbide rotary tooling industry.
- We are privately-owned, operate with long-term focus and goals, and manufacture 100% of our products within our ISO 9001:2000 Registered factories.
- Our substrate, geometry, and coating are specially selected for each application and Series.
- Our cutting tools have extremely accurate diameter, radius, and concentricity characteristics.
- All solid carbide Ultra-Tool products are "SFR" (Shrink-Fit Ready).
- Our grinding method and coating process yields an extremely sharp & long-lasting cutting edge.
- We offer a full line of standard tools including hard-to-find items.
- We offer proprietary coatings such as TiB2 (A1) and HSN² (AT), all performed in-house for quick delivery.
- We can stock firm blanket orders.
- We offer quick turnaround on special blueprint items.
- We have a great mix of Automation and Craftsmanship.
- Both fractional and metric size ranges are offered.
- We have sales offices in both coastal time zones (Florida and California).
- We strongly support traditional Industrial Distribution.
- We have large standard inventories and excellent service levels.



**ISO 9001:2000
REGISTERED**



Our web site is constantly updated with new products, services and features.

About the technology of Ultra-Tool® & Tool Alliance®:

We obsess over details that create the finest cutting tools available. Our reward is customer satisfaction via increased factory productivity. We cannot be the best without thinking differently, so over a 40 year operating history we've developed proprietary technologies that yield significant characteristics of cutting tools unlike any you'll find elsewhere:

- SmoothGrind® = Polished cutting edges for extreme sharpness and lubricity.
- SmoothConcricity® = Precision grinding, tool holding, and tolerances for minimized TIR.
- SmoothCoat® = Sputter-based SuperNitride PVD coating for superior surface hardness & uniformity.
- SmoothEdge® = Surface and edge preparation for lubricity and minimized break-in.

ULTRATOOL®



Tool Alliance®



Precision grinding by Ultra-Tool.

Sharpness & Lubricity.
No wonder it works better.

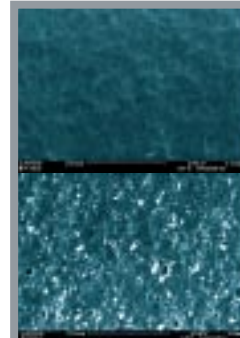
SmoothGrind®

Tight tolerances.
Minimized run-out.



SmoothConcricity®

Our coating @ 2,000X (top).
Everybody else's (bottom).



SmoothCoat®

ULTRATOOL®

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