

# **QUAD•DRILL<sup>+</sup>** in 5xD



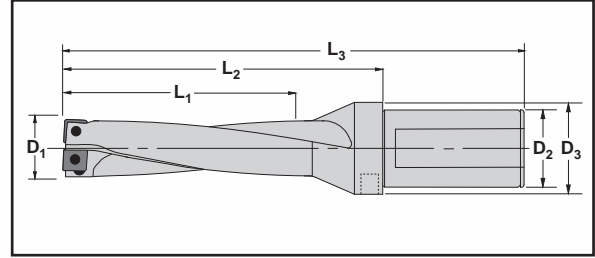
*Ingersoll's Quad•Drill+ is now firmly established as one of the best performing indexable drills in the cutting tool industry. To further enhance its reputation, we are introducing an extended program for drilling applications up to 5 times the drill depth-to-diameter ratio.*

*This new 5xD line retains the stability and performance advantages of the existing 2xD, 3xD and 4xD and will assist the increasing number of customers requesting 5xD special Quad drills - that up until now have only been available as semi-standard or special products.*

*The 5xD Quad•Drill drills are available in the diameter range of .500in.- 1.625in. and are available in 1/32in. diameter increments.*

*With the exception of the drill length - all other specifications of the 5xD line are the same as the existing 2xD, 3xD and 4xD Quad•Drill+.*

5xD **QUAD<sup>+</sup>DRILL<sup>+</sup>**



	D <sub>1</sub> Nom. Dia. inch mm	Drill Number	D <sub>2</sub> Shank Style/Size	D <sub>3</sub>	L <sub>1</sub> Drilling Length	L <sub>2</sub> Ext. frm Holder	L <sub>3</sub> Overall Length	Insert Number	Insert Screw	Insert Driver	Coolant Fitting
.500	12,7	Q0127064N5R01	1.000	1.260	2.50	3.57	5.77	SCLT050204N-PH	SM20-043-00	DS-TP06S	PF-0012
.531	13,5	Q0135067N5R01	1.000	1.260	2.65	3.76	5.96	SCLT050204N-PH	SM20-043-00	DS-TP06S	PF-0012
.563	14,3	Q0143072N5R01	1.000	1.260	2.81	3.79	5.99	SCLT050204N-PH	SM20-043-00	DS-TP06S	PF-0012
.594	15,1	Q0150075N5R01	1.000	1.260	2.97	4.02	6.22	SCLT050204N-PH	SM20-043-00	DS-TP06S	PF-0012
.625	15,9	Q0159080N5R01	1.000	1.260	3.13	4.25	6.46	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.657	16,7	Q0167083N5R01	1.000	1.260	3.29	4.45	6.65	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.688	17,5	Q0175087N5R01	1.000	1.260	3.44	4.69	6.89	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.719	18,3	Q0183091N5R01	1.000	1.260	3.60	4.69	6.89	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.750	19,1	Q0191095N5R01	1.000	1.260	3.75	4.88	7.09	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.781	19,8	Q0198099N5R01	1.000	1.260	3.91	5.16	7.36	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.813	20,7	Q0206103N5R01	1.000	1.260	4.07	5.35	7.56	SHLT060204N-PH	SM22-052-00	DS-T07F	PF-0012
.844	21,4	Q0214107N5R01	1.000	1.260	4.22	5.55	7.76	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0012
.875	22,2	Q0222111N5R01	1.000	1.260	4.38	5.55	7.76	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0012
.906	23,0	Q0230115N6R01	1.250	1.770	4.53	5.91	8.27	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
.938	23,8	Q0238119N6R01	1.250	1.770	4.69	6.14	8.50	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
.969	24,6	Q0246123N6R01	1.250	1.770	4.85	6.38	8.74	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
.984	25,0	Q0250125N6R01	1.250	1.770	4.92	6.38	8.74	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
1.000	25,4	Q0254127N6R01	1.250	1.770	5.00	6.57	8.94	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
1.031	26,2	Q0262131N6R01	1.250	1.770	5.16	6.57	8.94	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
1.063	27,0	Q0270135N6R01	1.250	1.770	5.32	6.77	9.13	SPLT07T308N-PH	SM25-064-00	DS-T08W	PF-0013
1.094	27,8	Q0278139N6R02	1.250	1.770	5.47	7.00	9.36	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.125	28,6	Q0286143N6R02	1.250	1.770	5.62	7.19	9.55	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.156	29,4	Q0294147N6R01	1.250	1.770	5.78	7.49	9.86	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.187	30,1	Q0302151N6R01	1.250	1.770	5.93	7.53	9.89	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.219	31,0	Q0310155N6R01	1.250	1.770	6.09	7.75	10.12	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.250	31,8	Q0318159N6R01	1.250	1.770	6.25	7.94	10.31	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.281	32,5	Q0325163N6R01	1.250	1.770	6.40	8.17	10.53	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.312	33,3	Q0333167N6R01	1.250	1.770	6.56	8.20	10.56	SHLT090408N-PH1	SM35-088-60	DS-T10T	-
1.343	34,1	Q0341171N6R02	1.250	1.770	6.71	8.39	10.75	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.375	34,9	Q0349175N6R02	1.250	1.770	6.87	8.62	10.98	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.406	35,7	Q0357179N6R02	1.250	1.770	7.03	8.85	11.21	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.437	36,5	Q0365182N6R01	1.250	1.770	7.18	9.07	11.44	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.468	37,3	Q0373186N6R01	1.250	1.770	7.34	9.11	11.47	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.500	38,1	Q0381191N6R01	1.250	1.770	7.50	9.33	11.70	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.531	38,9	Q0389194N6R01	1.250	1.770	7.65	9.52	11.89	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.562	39,7	Q0397198N6R01	1.250	1.770	7.81	9.75	12.11	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.594	40,5	Q0405202N6R01	1.250	1.770	7.97	9.98	12.34	SHLT110408N-PH1	SM40-093-20	DS-T15T	-
1.625	41,3	Q0413206N6R01	1.250	1.770	8.12	10.01	12.37	SHLT110408N-PH1	SM40-093-20	DS-T15T	-

**MAXIMUM HOLE SIZE WITH RADIAL ADJUSTMENT:**

Diameter (inch)	Radial Shift (inch)	Max. Hole Diameter (inch)
.500	.010	.520
.531	.010	.551
.563	.010	.583
.594	.010	.614
.625	+ .02	.665
.657	+ .02	.697
.688	+ .02	.728
.719	+ .02	.759
.750	+ .02	.790
.781	+ .02	.821
.813	+ .01	.833
.844	+ .02	.884
.875	+ .02	.915
.906	+ .02	.946
.938	+ .02	.978
.969	+ .02	1.009
.984	+ .02	1.024
1.000	+ .01	1.020
1.031	+ .01	1.051
1.063	+ .01	1.083
1.094	.020	1.134
1.125	.020	1.165
1.156	.020	1.196
1.187	.020	1.227
1.219	.010	1.239
1.250	.010	1.270
1.281	.010	1.301
1.312	.010	1.332
1.343	.020	1.383
1.375	.020	1.415
1.406	.020	1.446
1.437	.020	1.477
1.468	.020	1.508
1.500	.020	1.540
1.531	.020	1.571
1.562	.010	1.582
1.594	.010	1.614
1.625	.010	1.645

**HOLE TOLERANCE:**

Drilling Depth	Hole Tolerance (inch)
2xD	+ .008 / - .004
3xD	+ .010 / - .004
4xD	+ .012 / - .004
5xD	+ .016 / - .004

**TECHNICAL DATA:**

Please refer to the latest Holemaking catalog (CAT-002-2 (3/06)) or Super Catalog (CAT-009 (8/06)).

**OPERATING GUIDELINES:**

It is strongly suggested that the recommended catalog feed rates are reduced by 60% upon engaging the part piece and for the first .100" depth of cut.

**AVAILABILITY:**

Ex stock