



THE GEORGE WHALLEY COMPANY

Everything Coolant-Fed

COATED THROW-AWAY SPADE DRILL INSERTS AND HOLDERS



▶ ULTRA HIGH PERFORMANCE COATINGS

▶ IMPROVED PRODUCTIVITY

▶ BROADER RANGE OF APPLICATIONS

▶ COOLANT THRU HOLDERS

Discover our new line of Coated Throw-Away Spade Drill Inserts and Holders. Our inserts are manufactured with ultra high performance coatings which allow for higher speeds & feeds, longer tool life, reduced machining time and improved productivity. Our combination of materials and multi-layered coatings provide for a broader range of applications subsequently reducing your inventory. All of our inserts and holders are competitively priced. We have a large inventory of products in stock now and available for immediate delivery.

SERIES & SIZES

SPADE DRILL INSERT AVAILABILITY

SERIES	DIAMETER SIZES			HIGH SPEED STEEL			SUPER COBALT		PREMIUM COBALT		CARBIDE	
	INCH	METRIC	DECIMAL	M04			T15		M48		K20	
				TiN	TiAlN	TiCN	ULTRA-TiN	LIFE-COAT	ULTRA-TiN	LIFE-COAT	ULTRA-TiN	LIFE-COAT
Y	3/8"-27/64"	9.5MM - 11MM	0.374 - 0.433				•	•	•	•	•	•
						•	•					
Z	7/16-1/2"	11.5MM - 12.5MM	0.437 - 0.500				•	•	•	•	•	•
						•	•					
0	33/64"-11/16"	13MM - 17.5MM	0.511 - 0.689				•	•	•	•	•	•
						•	•					
1	45/64"-15/16"	18MM - 24MM	0.703 - 0.944	•	•	•	•	•	•	•	•	•
						•	•					
2	31/32"-1-3/8"	26MM - 35MM	0.968 - 1.378	•	•	•	•	•			•	•
						•	•					
3	1-13/32"-1-7/8"	36MM - 47MM	1.406 - 1.875	•	•	•	•	•				
						•	•					
4	1-29/32"-2-9/16"	48MM - 65MM	1.889 - 2.562	•	•	•	•	•				
						•	•					
5	2-1/2"-3"	64MM - 76MM	2.500 - 3.000	•	•	•						
6	3-1/32"-3-1/2"	78MM - 88MM	3.031 - 3.500	•	•	•						
7	3-17/32"-4"	90MM - 100MM	3.531 - 4.000	•	•	•						
8	4-1/64"-4-1/2"	106MM - 114MM	4.015 - 4.500	•	•	•						

SPADE DRILL HOLDER AVAILABILITY

INSERT SERIES	A SIZE RANGE	B OVERALL LENGTH	C MAX DEPTH	D FLUTE LENGTH	E SHANK DIA.	F SHANK LENGTH	G PIPE TAP
SHORT LENGTH - STRAIGHT SHANK HOLDERS - STRAIGHT FLUTE							
Y TO 3	0.375" - 1.875"	4-13/32" - 10"	1-1/4" - 4-3/4"	2-1/32" - 6"	3/4" - 1-1/2"	2-3/8" - 4"	1/8" - 1/4"
STANDARD LENGTH - STRAIGHT SHANK HOLDERS - STRAIGHT FLUTE							
Y TO 0.5	0.375" - 0.687"	5-17/32" - 5-11/16"	2-3/8" - 2-1/2"	3-5/32" - 3-5/16"	3/4"	2-3/8"	1/8"
INTERMEDIATE LENGTH - STRAIGHT SHANK HOLDERS - STRAIGHT FLUTE							
1 TO 3	0.703" - 1.875"	8-7/8" - 11-3/4"	4-5/8" - 6-1/2"	5-7/8" - 7-3/4"	1" - 1-1/2"	3" - 4"	1/8"-1/4"

COATING CODES & APPLICATIONS

TiN	ST	Titanium Nitride	Color - Yellow / Gold	Effective Abrasion Wear and Good Lubricity.
TiAlN	SA	Titanium Aluminum Nitride	Color - Violet Gray	High Temperature and Outstanding Wear Resistance.
TiCN	SC	Titanium Carbo Nitride	Color - Blue Gray	Outstanding Wear Resistance.
Ultra-TiN	SU	Ultra-TiN	Color - Deep Gold	High Lubricity, High Temperature and Outstanding Wear Resistance.
Life-Coat	SL	Life-Coat	Color - Violet Gray	Phenomenal Lubricity, High Temperature and Outstanding Wear Resistance.



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Coolant-Fed Tooling & Systems® Division

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