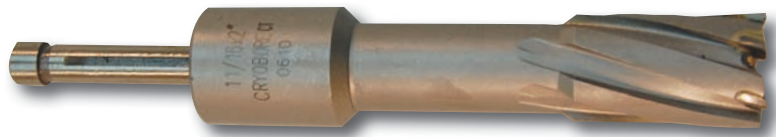


## 2" Depth

Code #	Description
818-8-3100	5/8"
818-8-3200	1 1/16"
818-8-3300	3/4"
818-8-3400	13/16"
818-8-3500	7/8"
818-8-3600	15/16"
818-8-3700	1"
818-8-3750	1-1/16"
818-8-3800	1-1/8"
818-8-3850	1-3/16"
818-8-3900	1-1/4"
818-8-3950	1-5/16"
818-8-4000	1-3/8"
818-8-4050	1-7/16"
818-8-4100	1-1/2"
818-8-4150	1-9/16"
818-8-4200	1-5/8"
818-8-4250	1-11/16"
818-8-4300	1-3/4"
818-8-4350	1-13/16"
818-8-4400	1-7/8"
818-8-4450	1-15/16"
818-8-4500	2"
818-8-4525	2-1/8"
818-8-4550	2-3/16"
818-8-4600	2-1/4"
818-8-4625	2-5/16"
818-8-4650	2-3/8"



## Cryobore™ CT Annular Cutters Carbide-Tooth Hole Cutters

- **Smooth Cutting** – Finished holes are virtually scratch-free with very few or no burrs at the entry or exit
- **Time Saving** – Cut faster than twist drills and last much longer
- **Cut Tougher Metals** – Premium grade tungsten-carbide teeth drill into materials up to 3" thick and as hard as 45Rc
- **Weldon shank**

## 3" Depth

Code #	Description
818-8-4633	3/4"
818-8-4637	1"
818-8-4639	1-1/4"
818-8-4641	1-1/2"
818-8-4643	1-3/4"
818-8-4645	2"



### Assortment

818-9-5000  
4-Piece Bolt Hole Cutter Kit, 2" Deep - 11/16, 13/16, 15/16, and 1-1/16 with pilot pins in 4-slot pouch.

Note: Ejector Pin is included with cutter

DRILLING SPEED CHART						
Steel Type	3/4"	1"	1-1/4"	1-1/2"	1-3/4"	2"
300-Series Stainless	300-430	250-325	200-260	165-215	140-185	125-165
Heat Treated, Steel 20Rc	550-1000	425-750	350-615	290-510	250-440	220-380
Heat Treated, Steel 40Rc	500-870	320-650	305-525	250-435	220-370	195-340

Use cutting fluid. Apply a light but steady feed. Excessive chatter usually indicates inadequate use of cutting fluid and or too high feed rate. Some drill presses are not rigid enough to prevent shifting during machining and could cause tool break.

### Applications

- Use with magdrill, vertical milling machine, or heavy-duty drill press
- Designed to cut steel heat-treated between 20-45 Rc
- Truck Frames, construction and earthmoving equipment frames, yolks, and wearplate mounting holes
- Retrofitting armored vehicles
- Perfect on a drill press or vertical mill for drilling all grades of stainless steel up to 40 Rc
- Use only on heat-treated steel or stainless steel

CUTTER SIZE RECOMMENDATION CHART	
Bolt or Tap Size	Cutter Hole Size
5/8", 3/4"-16 Tap	11/16"
M18	3/4"
3/4", 7/8"-14 Tap	13/16"
M20, 1"-8 Tap, M20-2.5	7/8"
7/8", 1"-12 Tap	15/16"
M22	1"
1", M24	1-1/16"
M26	1-1/8"
M28	1-3/16"
1-1/8"	1-1/4"
1-1/4"	1-3/8"
1-3/8"	1-1/2"
1-1/2"	1-5/8"
1-3/4"	1-7/8"