

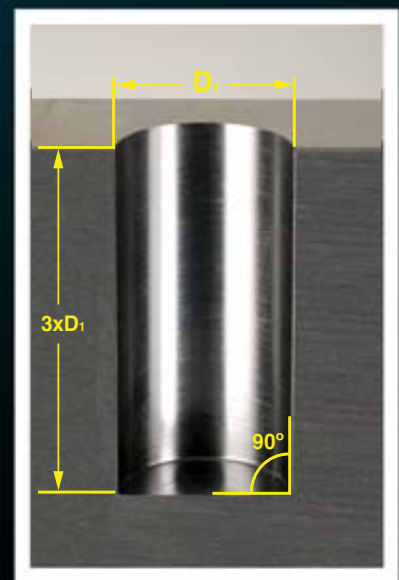
## QUADODRILL<sup>+</sup>

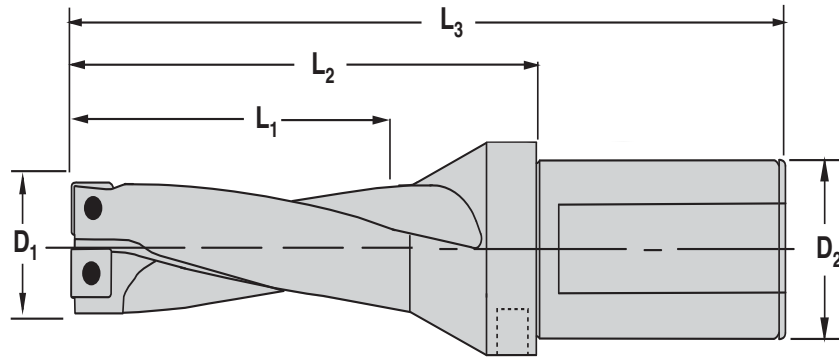


### **QF Series** **Flat Bottom Square Insert** **Indexable Drill - 3:1**

#### **FEATURES AND BENEFITS**

- Twisted Flute design - Deeper flutes, larger coolant holes without sacrificing body strength
- Multiple specialty inserts and grades available
- Flat Bottom holes, Pockets, Counterbores

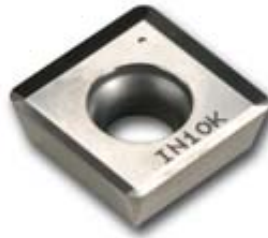
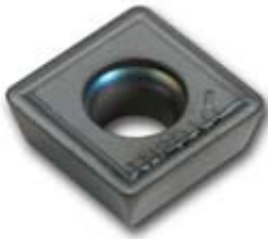




**SQUARE INSERT FLAT BOTTOM INDEXABLE DRILLS-3:1** SERIES QF

D <sub>1</sub> Nominal Diameter	New Drill Number	L <sub>1</sub> Drilling Length	L <sub>2</sub> Ext. frm Holder	L <sub>3</sub> Overall Length	D <sub>2</sub> Shank Style/Size	Num. of Inserts
.625	QF0159048N5R01	1.88	2.99	5.20	1.000 Universal	2
.688	QF0175053N5R01	2.06	3.27	5.47	1.000 Universal	2
.719	QF0183055N5R01	2.16	3.27	5.47	1.000 Universal	2
.750	*QF0191057N5R01	2.25	3.39	5.59	1.000 Universal	2
.781	QF0198059N5R01	2.34	3.58	5.79	1.000 Universal	2
.813	QF0206062N5R01	2.44	3.70	5.91	1.000 Universal	2
.843	QF0214064N5R01	2.53	3.82	6.02	1.000 Universal	2
.875	QF0222067N5R01	2.63	3.82	6.02	1.000 Universal	2
.906	QF0230069N6R01	2.72	4.09	6.46	1.250 Universal	2
.938	QF0238071N6R01	2.81	4.25	6.61	1.250 Universal	2
.969	QF0246074N6R01	2.91	4.41	6.77	1.250 Universal	2
1.000	*QF0254076N6R01	3.00	4.53	6.89	1.250 Universal	2
1.031	QF0262079N6R01	3.09	4.53	6.89	1.250 Universal	2
1.063	QF0270081N6R01	3.19	4.65	7.01	1.250 Universal	2
1.094	QF0278083N6R01	3.28	4.80	7.17	1.250 Universal	2
1.125	QF0286086N6R01	3.38	4.92	7.28	1.250 Universal	2
1.156	QF0294088N6R01	3.47	5.16	7.52	1.250 Universal	2
1.187	QF0302090N6R01	3.56	5.16	7.52	1.250 Universal	2
1.219	QF0310093N6R01	3.66	5.31	7.67	1.250 Universal	2
1.250	*QF0318095N6R01	3.75	5.43	7.79	1.250 Universal	2
1.281	QF0325098N6R01	3.84	5.59	7.95	1.250 Universal	2
1.312	QF0333100N6R01	3.94	5.59	7.95	1.250 Universal	2
1.343	QF0341102N6R01	4.03	5.71	8.07	1.250 Universal	2
1.375	QF0349105N6R01	4.13	5.87	8.23	1.250 Universal	2
1.437	QF0365110N6R01	4.31	6.18	8.54	1.250 Universal	2
1.468	QF0373112N6R01	4.40	6.18	8.54	1.250 Universal	2
1.500	*QF0381114N6R01	4.50	6.34	8.70	1.250 Universal	2
1.531	QF0389117N6R01	4.59	6.46	8.82	1.250 Universal	2
1.562	QF0397119N6R01	4.69	6.61	9.37	1.250 Universal	2
1.625	QF0413124N6R01	4.88	6.77	9.53	1.250 Universal	2
1.687	QF0428128N6R01	5.06	7.05	9.80	1.250 Universal	2
1.719	QF0437131N6R01	5.16	7.17	9.92	1.250 Universal	2
1.75	QF0445134N6R01	5.25	7.36	10.12	1.250 Universal	2
1.875	QF0476143N7R01	5.63	7.80	10.55	1.500 Universal	2
1.937	QF0492148N7R01	5.81	7.91	10.67	1.500 Universal	2
2.000	*QF0508152N7R01	6.00	8.23	10.98	1.500 Universal	4

\*In stock; Remaining sizes contact Ingersoll for availability.



## INSERTS

Drill Diameter	Insert Number (■)	Cast Iron Inserts IN2010 Grade only (◆)	Aluminum Inserts IN10K Grade only (▲)	Corner	Grades						
					IN	1030	2005	2010	6520	10K	
.625	SCLT050204N-PH	SCLT050204N	SHGT050204-HP	.016R	■	■	◆	■	▲		
.688-.813	SHLT060204N-PH	SHLT060204N	SHGT060204-HP	.016R	■	■	◆	■	▲		
.843-1.063	SPLT07T308N-PH	SPLT07T308N	SDGT07T308-HP	.030R	■	■	◆	■	▲		
1.094-1.312	SHLT090408N-PH1	SHLT090408N	SHGT090408-HP	.030R	■	■	◆	■	▲		
1.343-1.625	SHLT110408N-PH1	SHLT110408N	SHGT110408-HP	.030R	■	■	◆	■	▲		
1.687 - 1.937	SPLT140512N-PH	SPLT140512N	SDGT140512-HP	.047R	■	■	◆	■	▲		
2.000	SPLT07T308N-PH	SPLT07T308N	SDGT07T308-HP	.030R	■	■	◆	■	▲		

## HARDWARE

Insert Screw			Driver	
Drill Diameter	Part No.	Torque	Part No.	Coolant Fitting
.625	SM20-043-00	5-9 in. lbs.	DS-TP06S (Tx-06)	PF-0012
.688-.813	SM22-052-00	7-11 in. lbs.	DS-T07F (Tx-07)	PF-0012
.843-1.063	SM25-064-00	10-15 in. lbs.	DS-T08W (Tx-08)	PF-0013
1.094-1.312	SM35-088-60	25-30 in. lbs.	DS-T10T (Tx-10)	-
1.343-1.625	SM40-093-20	30-35 in. lbs.	DS-T15T (Tx-15)	-
1.687 - 1.937	SM50-122-50	40-45 in. lbs.	DS-T20T (Tx-20)	-
2.000	SM25-064-00	10-15 in. lbs.	DS-T08W (Tx-08)	-

## Applications:

- Deep Counterbores for standard socket head cap screws
- Flat bottom holes
- Counterbores
- Die spring pocket holes
- Nitro Gas Die cylinder mounting pockets

## Advantages:

### **Incorporates the latest *Twisted Flute Manufacturing Technology***

- Deeper Flutes
- Larger Coolant Holes
- Increases body strength, stability

### **Translates to:**

- Better Chip evacuation
- Increased coolant volume—flushing chips from deeper holes
- Better hole size tolerance and finish capability

### **Uses standard “Quad Drill *Plus*” Inserts**

- Square inserts—four indexes
- Robust insert design capable of aggressive drilling
- Same insert in all pockets
- Multiple insert and Grade selections for “special” applications

## Sales and Marketing:

Any application requiring a flat bottom.

**Plus values** on this new drill include 3 x D drilling depth and a wider size range offering, replacing the old style Ingersoll “N” drills with a superior performing product.

## Operating Guidelines:

Use mid-range drilling parameters from standard catalog Quad Drill Operating Guidelines.

## Availability:

Standard sizes .750”, 1.00”, 1.250”, 1.500”, 2.00” are in stock available for immediate shipment. The balance of the product line will be available starting in late December. Please check with Rockford for availability.

