

# Specialty Cutters



## Tapping Cutter Sizes Selection Chart

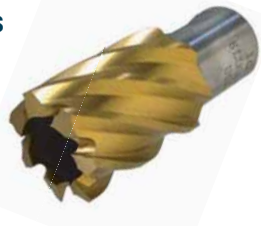
The following chart is to assist in determining available Sluggger Cutters to suit UN taps. All sizes are "suggested sizes" only and may be varied to suit individual requirements.

Tap Size	TPI	Cutter Size	Tap Size	TPI	Cutter Size
1/2" UNC	13	27/64"	1" UNC	8	7/8"
1/2" UNF	20	29/64"	1" UNF	12	59/64"
9/16" UNC	12	31/64"	1-1/8" UNC	7	25mm
9/16" UNF	18	13mm	1-1/8" UNF	12	1"
5/8" UNC	11	17/32"	1-1/4" UNC	7	1-7/64"
5/8" UNF	18	19/32"	1-1/4" UNF	12	1-11/64
11/16" UNS	11	5/8"	1-1/2" UNC	6	1-11/32
3/4" UNC	10	21/32"	1-1/2" UNF	12	1-27/64"
3/4" UNF	16	11/16"	1-3/4" UNC	5	39mm
7/8" UNC	9	49/64"	2" UNC	4.5	1-25/32"
7/8" UNF	14	51/64"			

## Cobalt Titanium Nitride Cutters

**Cobalt M42** suitable for Hardened Steel up to 350BNH (38HRC) ie: Hard Steels or Steel with 'Hard Spots'

TINI Coating (gold colour) has a hardness of 85HRC and coating thickness of 1-3 microns thus providing a harder surface, and reduced friction, giving longer life.



### 25mm DEPTH METRIC

Part Number	Diameter
SC1/2X1CTN	1/2"
SC9/16X1CTN	9/16"
SC5/8X1CTN	5/8"
SC3/4X1CTN	3/4"
SC7/8X1CTN	7/8"
SC1X1CTN	1"

## Chassis Cutters

AS PER COBALT TITANIUM NITRIDE CUTTERS WITH STACK GRINDING

**Stack Grinding** allows the cutter to go through 2 or more layers of material in one pass.

These cutters are ideally suited for drilling truck chassis.

**NOTE:** Stack Grinding can be provided on standard Sluggger Cutters in Metric or Imperial sizes up to 30mm or 1-1/8"

### 25mm DEPTH METRIC

Part Number	Diameter
SC1/2X1COSG	1/2"
SC9/16X1COSG	9/16"
SC5/8X1COSG	5/8"
SC3/4X1COSG	3/4"
SC7/8X1COSG	7/8"
SC1X1COSG	1"

## Sluggger Helpful Tip

Maintain a working knowledge of the material being machined. Different materials require different feed rates, speeds and cutter types.

When drilling hard materials, use of Tap Magic Cutting Fluids will greatly improve Sluggger Cutter performance. In horizontal positions ( such as drilling truck chassis ) Tap Magic "Extra Thick" is ideal as it adheres to the cutter

## Titanium Carbon Nitride Cutters

**TICN coating** (blue/grey in colour) is harder and tougher than other coating materials.

Consequently it has high resistance to edge chipping and abrasive wear.

TICN coating has a hardness of 90HRC

and a coating thickness of 3 - 5 microns.

Suitable for Abrasive & Difficult Materials.

ie: Stainless Steel, Cast Iron, SI-Aluminium Alloys.



### 25mm DEPTH 50mm DEPTH METRIC

Part Number	Part Number	Diameter
SC1225TICN	SC1250TICN	12mm
SC1425TICN	SC1450TICN	14mm
SC1625TICN	SC1650TICN	16mm
SC1825TICN	SC1850TICN	18mm
SC2025TICN	SC2050TICN	20mm
SC2225TICN	SC2250TICN	22mm
SC2425TICN	SC2450TICN	24mm
SC2625TICN	SC2650TICN	26mm
SC2825TICN	SC2850TICN	28mm
SC3025TICN	SC3050TICN	30mm
SC3225TICN	SC3250TICN	32mm



## Rail Cutters

Tungsten Carbide Tipped Specifically Designed for Drilling Railway Line & Suitable for drilling other hard materials such as wear plate & Bisalloy



### 25mm DEPTH METRIC

Part Number	Diameter
MAXRAIL2225	22mm
MAXRAIL2625	26mm
MAXRAIL2825	28mm
MAXRAIL3025	30mm
MAXRAIL3225	32mm

## Straight Flute T.C.T Cutters

Tungsten Carbide Tipped Cutters Suitable for drilling difficult & harder materials such as stainless steel, wear plate & Bisalloy



### 25mm DEPTH METRIC

Part Number	Diameter
HMRAIL18	18mm
HMRAIL20	20mm
HMRAIL22	22mm
HMRAIL24	24mm
HMRAIL25	25mm
HMRAIL26	26mm
HMRAIL30	30mm
HMRAIL32	32mm
HMRAIL35	35mm