



# FORCE M SOLID CARBIDE DRILL

The **FORCE M** is a new addition to the Force range designed specifically for stainless steel drilling applications.

**These drills are problem solvers**, providing high productivity and consistent performance and repeatability in ISO-M applications across diverse machines and conditions. This makes them the ideal choice for general engineering, sub-contract and high production environments.

- CTW (continuously thinned web) technology provides a very strong web design while reducing thrust forces during drilling.
- Consistent edge preparation provides predictable wear and operator confidence.
- Ideally suited for high performance drilling of large numbers of holes in ISO M materials.
- Advanced 140° split point geometry enhances self-centering capabilities and hole quality. This modified 4-facet design also improves chip formation, strength and wear-resistance.
- A strong corner design increases stability during drilling and reduces the forces encountered during breakthrough at exit surfaces and when cross-hole drilling.

**NEW**



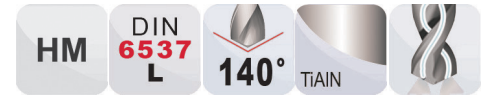
# FORCE M SOLID CARBIDE DRILL

Multi-Application, Standard length, Reinforced Shank

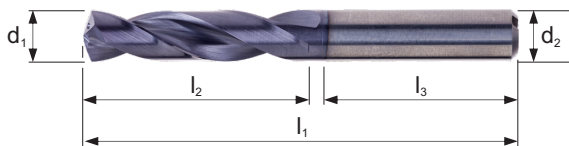
R463 - 5xD

R467 - 3xD

2.1 2.2 2.3 2.4 4.1 4.2 4.3 5.1 5.2 5.3



Self-centering 4-facet split point and CTW flute construction for enhanced penetration rate specifically designed for Stainless Steel (ISO-M) materials. TiAlN coating increases wear resistance and improves tool life. Coolant through combined with an advanced point geometry prevents premature wear of the cutting edges.



Metric sizes also available.

Scan the QR code to see the complete listing of Force M sizes on our website.



d <sub>1</sub> Ø "/Nr./letter	d <sub>1</sub> Ø <sub>m7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Ø <sub>h6</sub> mm	R467 3xD
1/8	3.18	0.1250	20	62	36	6	7625102
29	3.45	0.1360	20	62	36	6	7625106
9/64	3.57	0.1406	20	62	36	6	7625108
5/32	3.97	0.1563	24	66	36	6	7625113
11/64	4.37	0.1719	24	66	36	6	7625119
3/16	4.76	0.1875	28	66	36	6	7625124
7	5.11	0.2010	28	66	36	6	7625130
13/64	5.16	0.2031	28	66	36	6	7625131
5	5.22	0.2055	28	66	36	6	7625133
7/32	5.56	0.2188	28	66	36	6	7625137
15/64	5.95	0.2344	28	66	36	6	7625142
1/4	6.35	0.2500	34	79	36	8	7625148
17/64	6.75	0.2656	34	79	36	8	7625153
9/32	7.14	0.2813	41	79	36	8	7625158
19/64	7.54	0.2969	41	79	36	8	7625163
5/16	7.94	0.3125	41	79	36	8	7625168
21/64	8.33	0.3281	47	89	40	10	7625174
11/32	8.73	0.3438	47	89	40	10	7625179
23/64	9.13	0.3594	47	89	40	10	7625184
3/8	9.53	0.3750	47	89	40	10	7625189
25/64	9.92	0.3906	47	89	40	10	7625194
13/32	10.32	0.4063	55	102	45	12	7625200
27/64	10.72	0.4219	55	102	45	12	7625204
7/16	11.11	0.4375	55	102	45	12	7625208
29/64	11.51	0.4531	55	102	45	12	7625213
15/32	11.91	0.4688	55	102	45	12	7625216
31/64	12.30	0.4844	60	107	45	14	7625221
1/2	12.70	0.5000	60	107	45	14	7625224
33/64	13.10	0.5156	60	107	45	14	7625227
17/32	13.49	0.5313	60	107	45	14	7625229
35/64	13.89	0.5469	60	107	45	14	7625232
9/16	14.29	0.5625	65	115	48	16	7625235
37/64	14.68	0.5781	65	115	48	16	7625237
19/32	15.08	0.5938	65	115	48	16	7625240
39/64	15.48	0.6094	65	115	48	16	7625243
5/8	15.88	0.6250	65	115	48	16	7625246

d <sub>1</sub> Ø "/Nr./letter	d <sub>1</sub> Ø <sub>m7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Ø <sub>h6</sub> mm	R463 5xD
1/8	3.18	0.1250	28	66	36	6	7624915
29	3.45	0.1360	28	66	36	6	7624919
9/64	3.57	0.1406	28	66	36	6	7624961
5/32	3.97	0.1563	36	74	36	6	7624966
11/64	4.37	0.1719	36	74	36	6	7624972
3/16	4.76	0.1875	44	82	36	6	7624977
7	5.11	0.2010	44	82	36	6	7624983
13/64	5.16	0.2031	44	82	36	6	7624984
5	5.22	0.2055	44	82	36	6	7624986
7/32	5.56	0.2188	44	82	36	6	7624990
15/64	5.95	0.2344	44	82	36	6	7624995
1/4	6.35	0.2500	53	91	36	8	7625001
17/64	6.75	0.2656	53	91	36	8	7625006
9/32	7.14	0.2813	53	91	36	8	7625011
19/64	7.54	0.2969	53	91	36	8	7625016
5/16	7.94	0.3125	53	91	36	8	7625021
21/64	8.33	0.3281	61	103	40	10	7625027
11/32	8.73	0.3438	61	103	40	10	7625032
23/64	9.13	0.3594	61	103	40	10	7625037
3/8	9.53	0.3750	61	103	40	10	7625042
25/64	9.92	0.3906	61	103	40	10	7625047
13/32	10.32	0.4063	70	118	45	12	7625053
27/64	10.72	0.4219	70	118	45	12	7625057
7/16	11.11	0.4375	70	118	45	12	7625061
29/64	11.51	0.4531	70	118	45	12	7625066
15/32	11.91	0.4688	70	118	45	12	7625069
31/64	12.30	0.4844	76	124	45	14	7625073
1/2	12.70	0.5000	76	124	45	14	7625076
33/64	13.10	0.5156	76	124	45	14	7625079
17/32	13.49	0.5313	76	124	45	14	7625081
35/64	13.89	0.5469	76	124	45	14	7625084
9/16	14.29	0.5625	82	133	48	16	7625087
37/64	14.68	0.5781	82	133	48	16	7625089
19/32	15.08	0.5938	82	133	48	16	7625092
39/64	15.48	0.6094	82	133	48	16	7625095
5/8	15.88	0.6250	82	133	48	16	7625098