

# THINK COMPOSITE DRILLING



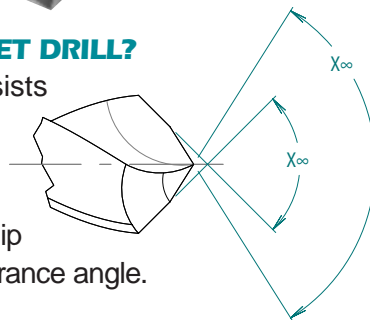
## SOLID CARBIDE 8 FACET DRILLS

Onsrud's drills for composite materials incorporate an 8-facet point design that reduces cutting forces and eliminates delamination when exiting the material. The solid carbide drills are wear-resistant and can be coated for improved tool life. The drills can be used on carbon fiber and other composite materials where clean, delamination-free holes are desired.

Custom sizes can be made upon request.

### WHAT IS A 8 FACET DRILL?

An 8 facet drill consists of 4 cutting edges with 2 facets per cutting edge. These facets consist of the lip relief and the lip clearance angle.



# THINK ONSRUD

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### FRACTIONAL DRILLS

PART #	CED	CEL	SHK DIA	OAL
67-807	1/8 (0.125)	1 1/4	0.125	2 1/4
67-808	9/64 (0.140)	1 3/8	0.140	2 1/2
67-809	5/32 (0.156)	1 3/8	0.156	2 1/2
67-810	11/64 (0.172)	1 5/8	0.172	2 3/4
67-811	3/16 (0.188)	1 5/8	0.188	2 3/4
67-812	13/64 (0.203)	1 3/4	0.203	3
67-813	7/32 (0.219)	1 3/4	0.219	3
67-814	15/64 (0.234)	2	0.234	3 1/4
67-815	1/4 (0.250)	2	0.250	3 1/4
67-816	17/64 (0.266)	2 1/8	0.266	3 1/2
67-817	9/32 (0.281)	2 1/8	0.281	3 1/2
67-818	19/64 (0.297)	2 3/8	0.297	3 3/4
67-819	5/16 (0.313)	2 3/8	0.313	3 3/4
67-820	21/64 (0.328)	2 1/2	0.328	4
67-821	11/32 (0.344)	2 1/2	0.344	4
67-822	23/64 (0.359)	2 1/2	0.359	4
67-823	3/8 (0.375)	2 3/4	0.375	4 1/4
67-824	25/64 (0.391)	2 7/8	0.391	4 1/2
67-825	13/32 (0.406)	2 7/8	0.406	4 1/2
67-826	27/64 (0.422)	2 7/8	0.422	4 1/2
67-827	7/16 (0.438)	2 7/8	0.438	4 1/2
67-828	29/64 (0.453)	3	0.453	4 3/4
67-829	15/32 (0.469)	3	0.469	4 3/4
67-830	31/64 (0.484)	3	0.484	4 3/4
67-831	1/2 (0.500)	3	0.500	4 3/4

### LETTER DRILLS

PART #	CED	CEL	SHK DIA	OAL
67-850	A (0.234)	2	0.234	3 1/4
67-851	B (0.238)	2	0.238	3 1/4
67-852	C (0.242)	2	0.242	3 1/4
67-853	D (0.246)	2	0.246	3 1/4
67-854	E (0.250)	2	0.250	3 1/4
67-855	F (0.257)	2	0.257	3 1/4
67-856	G (0.261)	2 1/8	0.261	3 1/2
67-857	H (0.266)	2 1/8	0.266	3 1/2
67-858	I (0.272)	2 1/8	0.272	3 1/2
67-859	J (0.277)	2 1/8	0.277	3 1/2
67-860	K (0.281)	2 1/8	0.281	3 1/2
67-861	L (0.291)	2 1/8	0.291	3 1/2
67-862	M (0.295)	2 3/8	0.295	3 3/4
67-863	N (0.302)	2 3/8	0.302	3 3/4
67-864	O (0.316)	2 3/8	0.316	3 3/4
67-865	P (0.323)	2 3/8	0.323	3 3/4
67-866	Q (0.332)	2 1/2	0.332	4
67-867	R (0.339)	2 1/2	0.339	4
67-868	S (0.348)	2 1/2	0.348	4
67-869	T (0.358)	2 1/2	0.358	4
67-870	U (0.368)	2 3/4	0.368	4 1/4
67-871	V (0.377)	2 3/4	0.377	4 1/4
67-872	W (0.386)	2 7/8	0.386	4 1/2
67-873	X (0.397)	2 7/8	0.397	4 1/2
67-874	Y (0.404)	2 7/8	0.404	4 1/2
67-875	Z (0.413)	2 7/8	0.413	4 1/2

# UNIQUE TOOLS • UNIQUE SOLUTIONS

**CLEAN  
HOLES IN  
COMPOSITE  
SHEETS**

## NUMBER DRILLS

PART #	CED	CEL	SHK DIA	OAL
67-876	1 (0.228)	1 <sup>3</sup> / <sub>4</sub>	0.228	3
67-877	2 (0.221)	1 <sup>3</sup> / <sub>4</sub>	0.221	3
67-878	3 (0.213)	1 <sup>3</sup> / <sub>4</sub>	0.213	3
67-879	4 (0.209)	1 <sup>3</sup> / <sub>4</sub>	0.209	3
67-880	5 (0.206)	1 <sup>3</sup> / <sub>4</sub>	0.206	3
67-881	6 (0.204)	1 <sup>3</sup> / <sub>4</sub>	0.204	3
67-882	7 (0.201)	1 <sup>3</sup> / <sub>4</sub>	0.201	3
67-883	8 (0.199)	1 <sup>3</sup> / <sub>4</sub>	0.199	3
67-884	9 (0.196)	1 <sup>3</sup> / <sub>4</sub>	0.196	3
67-885	10 (0.194)	1 <sup>5</sup> / <sub>8</sub>	0.194	2 <sup>3</sup> / <sub>4</sub>
67-886	11 (0.191)	1 <sup>5</sup> / <sub>8</sub>	0.191	2 <sup>3</sup> / <sub>4</sub>
67-887	12 (0.189)	1 <sup>5</sup> / <sub>8</sub>	0.189	2 <sup>3</sup> / <sub>4</sub>
67-888	13 (0.185)	1 <sup>5</sup> / <sub>8</sub>	0.185	2 <sup>3</sup> / <sub>4</sub>
67-889	14 (0.182)	1 <sup>5</sup> / <sub>8</sub>	0.182	2 <sup>3</sup> / <sub>4</sub>
67-890	15 (0.180)	1 <sup>5</sup> / <sub>8</sub>	0.180	2 <sup>3</sup> / <sub>4</sub>
67-891	16 (0.177)	1 <sup>5</sup> / <sub>8</sub>	0.177	2 <sup>3</sup> / <sub>4</sub>
67-892	17 (0.173)	1 <sup>5</sup> / <sub>8</sub>	0.173	2 <sup>3</sup> / <sub>4</sub>
67-893	18 (0.170)	1 <sup>5</sup> / <sub>8</sub>	0.170	2 <sup>3</sup> / <sub>4</sub>
67-894	19 (0.166)	1 <sup>5</sup> / <sub>8</sub>	0.166	2 <sup>3</sup> / <sub>4</sub>
67-895	20 (0.161)	1 <sup>3</sup> / <sub>8</sub>	0.161	2 <sup>1</sup> / <sub>2</sub>
67-896	21 (0.159)	1 <sup>3</sup> / <sub>8</sub>	0.159	2 <sup>1</sup> / <sub>2</sub>
67-897	22 (0.157)	1 <sup>3</sup> / <sub>8</sub>	0.157	2 <sup>1</sup> / <sub>2</sub>
67-898	23 (0.154)	1 <sup>3</sup> / <sub>8</sub>	0.154	2 <sup>1</sup> / <sub>2</sub>
67-899	24 (0.152)	1 <sup>3</sup> / <sub>8</sub>	0.152	2 <sup>1</sup> / <sub>2</sub>
67-900	25 (0.150)	1 <sup>3</sup> / <sub>8</sub>	0.150	2 <sup>1</sup> / <sub>2</sub>
67-901	26 (0.147)	1 <sup>3</sup> / <sub>8</sub>	0.147	2 <sup>1</sup> / <sub>2</sub>
67-902	27 (0.144)	1 <sup>3</sup> / <sub>8</sub>	0.144	2 <sup>1</sup> / <sub>2</sub>
67-903	28 (0.141)	1 <sup>3</sup> / <sub>8</sub>	0.141	2 <sup>1</sup> / <sub>2</sub>
67-904	29 (0.136)	1 <sup>3</sup> / <sub>8</sub>	0.136	2 <sup>1</sup> / <sub>2</sub>
67-905	30 (0.129)	1 <sup>1</sup> / <sub>4</sub>	0.129	2 <sup>1</sup> / <sub>4</sub>
67-906	31 (0.120)	1 <sup>1</sup> / <sub>4</sub>	0.120	2 <sup>1</sup> / <sub>4</sub>

## METRIC DRILLS

PART #	CED	CEL	SHK DIA	OAL
67-961	3.00 (0.118)	1 <sup>1</sup> / <sub>4</sub>	3.00	2 <sup>1</sup> / <sub>4</sub>
67-962	3.50 (0.138)	1 <sup>3</sup> / <sub>8</sub>	3.50	2 <sup>1</sup> / <sub>2</sub>
67-963	4.00 (0.157)	1 <sup>3</sup> / <sub>8</sub>	4.00	2 <sup>1</sup> / <sub>2</sub>
67-964	4.50 (0.177)	1 <sup>5</sup> / <sub>8</sub>	4.50	2 <sup>3</sup> / <sub>4</sub>
67-965	5.00 (0.197)	1 <sup>3</sup> / <sub>4</sub>	5.00	3
67-966	5.50 (0.217)	1 <sup>3</sup> / <sub>4</sub>	5.50	3
67-967	6.00 (0.236)	2	6.00	3 <sup>1</sup> / <sub>4</sub>
67-968	6.50 (0.256)	2	6.50	3 <sup>1</sup> / <sub>4</sub>
67-969	7.00 (0.276)	2 <sup>1</sup> / <sub>8</sub>	7.00	3 <sup>1</sup> / <sub>2</sub>
67-970	7.50 (0.295)	2 <sup>3</sup> / <sub>8</sub>	7.50	3 <sup>3</sup> / <sub>4</sub>
67-971	8.00 (0.315)	2 <sup>3</sup> / <sub>8</sub>	8.00	3 <sup>3</sup> / <sub>4</sub>
67-972	8.50 (0.335)	2 <sup>1</sup> / <sub>2</sub>	8.50	4
67-973	9.00 (0.354)	2 <sup>1</sup> / <sub>2</sub>	9.00	4
67-974	9.50 (0.374)	2 <sup>3</sup> / <sub>4</sub>	9.50	4 <sup>1</sup> / <sub>4</sub>
67-975	10.00 (0.394)	2 <sup>7</sup> / <sub>8</sub>	10.00	4 <sup>1</sup> / <sub>2</sub>
67-976	10.50 (0.413)	2 <sup>7</sup> / <sub>8</sub>	10.50	4 <sup>1</sup> / <sub>2</sub>
67-977	11.00 (0.433)	2 <sup>7</sup> / <sub>8</sub>	11.00	4 <sup>1</sup> / <sub>2</sub>
67-978	11.50 (0.453)	3	11.50	4 <sup>3</sup> / <sub>4</sub>
67-979	12.00 (0.472)	3	12.00	4 <sup>3</sup> / <sub>4</sub>

**ELIMINATE  
DELAMINATION  
PROBLEMS**

**CUSTOM SIZES  
AND LENGTHS  
UPON REQUEST**