

Solid Carbide Straight Flute Drills by ULTRATOOL

Series 570

Two Flute Micro Hole Drill
135° Four Facet Point



Fractional

Diam	LOF	OAL	EDP#	UnCoated Price	Coated Price
3/64	3/8	1-1/2	57003	\$9.20	\$10.80
1/16	3/8	1-1/2	57004	\$8.60	\$10.30
5/64	1/2	2"	57005	\$8.40	\$10.20
3/32	1/2	2"	57006	\$8.60	\$10.30
7/64	5/8	2-1/4	57007	\$9.50	\$11.90
1/8	5/8	2-1/4	57008	\$10.50	\$13.00
9/64	5/8	2-1/2	57009	\$11.30	\$14.40
5/32	3/4	2-1/2	57010	\$11.90	\$15.00
11/64	3/4	2-1/2	57011	\$13.90	\$16.90
3/16	3/4	2-1/2	57012	\$14.70	\$17.70
13/64	1"	2-1/2	57013	\$17.10	\$21.20
7/32	1"	2-1/2	57014	\$17.60	\$21.70
15/64	1"	2-1/2	57015	\$18.80	\$22.80
1/4	1"	2-1/2	57016	\$21.10	\$25.10
17/64	1"	2-1/2	57017	\$27.10	\$32.10
9/32	1"	2-1/2	57018	\$28.30	\$33.20
19/64	1-1/4	2-1/2	57019	\$29.90	\$34.90
5/16	1-1/4	2-1/2	57020	\$31.10	\$36.00
21/64	1-1/4	3"	57021	\$33.40	\$38.70
11/32	1-1/4	3"	57022	\$36.90	\$42.20
23/64	1-1/4	3"	57023	\$40.40	\$45.70
3/8	1-1/4	3"	57024	\$42.00	\$47.30
25/64	1-1/4	3"	57025	\$47.30	\$54.20
13/32	1-1/4	3"	57026	\$52.50	\$59.40
27/64	1-1/4	3"	57027	\$57.30	\$64.20
7/16	1-1/4	3"	57028	\$57.30	\$64.20
29/64	1-1/4	3"	57029	\$61.30	\$68.30
15/32	1-1/4	3"	57030	\$62.00	\$69.10
31/64	1-1/4	3"	57031	\$62.60	\$69.60
1/2	1-1/4	3"	57032	\$63.60	\$70.60
9/16	1-1/2	3-1/2	57034	\$84.00	\$94.10
5/8	1-1/2	3-1/2	57036	\$93.40	\$104.30
3/4	1-1/2	4"	57040	\$106.20	\$119.70

SFR Drill Specifications:
Diameter +.0000/-0.0003
Point Angle ±1°

Series 570 • Wire Gage

Diam	LOF	OAL	EDP#	UnCoated Price	Coated Price
1	1"	2-1/2	57101	\$18.80	\$22.80
2	1"	2-1/2	57102	\$18.80	\$22.80
3	1"	2-1/2	57103	\$17.40	\$21.50
4	1"	2-1/2	57104	\$17.40	\$21.50
5	1"	2-1/2	57105	\$17.40	\$21.50
6	1"	2-1/2	57106	\$17.40	\$21.50
7	1"	2-1/2	57107	\$16.40	\$20.40
8	1"	2-1/2	57108	\$16.40	\$20.40
9	1"	2-1/2	57109	\$16.00	\$20.10
10	3/4	2-1/2	57110	\$16.00	\$20.10
11	3/4	2-1/2	57111	\$15.90	\$20.00
12	3/4	2-1/2	57112	\$15.90	\$20.00
13	3/4	2-1/2	57113	\$14.70	\$17.70
14	3/4	2-1/2	57114	\$14.70	\$17.70
15	3/4	2-1/2	57115	\$14.20	\$17.20
16	3/4	2-1/2	57116	\$14.20	\$17.20
17	3/4	2-1/2	57117	\$14.20	\$17.20
18	3/4	2-1/2	57118	\$13.90	\$16.90
19	3/4	2-1/2	57119	\$13.90	\$16.90
20	3/4	2-1/2	57120	\$13.60	\$16.70
21	3/4	2-1/2	57121	\$13.60	\$16.70
22	3/4	2-1/2	57122	\$13.00	\$16.00
23	5/8	2-1/2	57123	\$11.90	\$15.00
24	5/8	2-1/2	57124	\$11.90	\$15.00
25	5/8	2-1/2	57125	\$11.90	\$15.00
26	5/8	2-1/2	57126	\$11.90	\$15.00
27	5/8	2-1/2	57127	\$11.40	\$14.50
28	5/8	2-1/2	57128	\$11.30	\$14.40
29	5/8	2-1/2	57129	\$10.70	\$13.70
30	5/8	2-1/4	57130	\$10.70	\$13.70
31	5/8	2-1/4	57131	\$10.20	\$12.70
32	5/8	2-1/4	57132	\$9.60	\$12.10
33	5/8	2-1/4	57133	\$9.60	\$12.10
34	5/8	2-1/4	57134	\$9.60	\$12.10
35	5/8	2-1/4	57135	\$9.60	\$12.10
36	5/8	2-1/4	57136	\$9.50	\$11.90
37	5/8	2-1/4	57137	\$9.50	\$11.90
38	5/8	2-1/4	57138	\$9.50	\$11.90
39	5/8	2-1/4	57139	\$9.50	\$11.90
40	1/2	2"	57140	\$9.50	\$11.20
41	1/2	2"	57141	\$9.50	\$11.20
42	1/2	2"	57142	\$8.60	\$10.30
43	1/2	2"	57143	\$8.60	\$10.30
44	1/2	2"	57144	\$8.60	\$10.30
45	1/2	2"	57145	\$8.60	\$10.30
46	1/2	2"	57146	\$8.60	\$10.30
47	1/2	2"	57147	\$8.60	\$10.30
48	1/2	2"	57148	\$8.50	\$10.20
49	3/8	2"	57149	\$8.50	\$10.20
50	3/8	2"	57150	\$8.50	\$10.20
51	3/8	1-1/2	57151	\$9.40	\$11.00
52	3/8	1-1/2	57152	\$9.40	\$11.00
53	3/8	1-1/2	57153	\$9.20	\$10.80
54	3/8	1-1/2	57154	\$9.20	\$10.80
55	3/8	1-1/2	57155	\$9.20	\$10.80
56	3/8	1-1/2	57156	\$9.20	\$10.80
57	3/8	1-1/2	57157	\$9.20	\$10.80
58	3/8	1-1/2	57158	\$9.20	\$10.80
59	3/8	1-1/2	57159	\$9.20	\$10.80
60	3/8	1-1/2	57160	\$9.20	\$10.80

Series 570 • Letter Sizes

Diam	LOF	OAL	EDP#	UnCoated Price	Coated Price
A	1"	2-1/2	57161	\$24.70	\$28.70
B	1"	2-1/2	57162	\$25.80	\$29.90
C	1"	2-1/2	57163	\$26.60	\$30.70
D	1"	2-1/2	57164	\$27.00	\$31.10
E	1"	2-1/2	57165	\$28.80	\$32.90
F	1"	2-1/2	57166	\$30.40	\$35.40
G	1"	2-1/2	57167	\$31.80	\$36.70
H	1"	2-1/2	57168	\$32.20	\$37.10
I	1"	2-1/2	57169	\$32.50	\$37.50
J	1"	2-1/2	57170	\$33.00	\$38.00
K	1"	2-1/2	57171	\$33.30	\$38.30
L	1"	2-1/2	57172	\$34.30	\$39.20
M	1"	2-1/2	57173	\$34.60	\$39.60
N	1-1/4	2-1/2	57174	\$35.60	\$40.60
O	1-1/4	2-1/2	57175	\$39.10	\$44.40
P	1-1/4	2-1/2	57176	\$39.50	\$44.80
Q	1-1/4	3"	57177	\$42.10	\$47.30
R	1-1/4	3"	57178	\$42.90	\$48.20
S	1-1/4	3"	57179	\$45.20	\$50.40
T	1-1/4	3"	57180	\$47.30	\$52.60
U	1-1/4	3"	57181	\$49.80	\$55.10
V	1-1/4	3"	57182	\$54.60	\$61.50
W	1-1/4	3"	57183	\$56.80	\$63.70
X	1-1/4	3"	57184	\$61.50	\$68.40
Y	1-1/4	3"	57185	\$61.90	\$68.80
Z	1-1/4	3"	57186	\$64.90	\$71.80

Series 570 • Metric Sizes

SFR Drill Specifications (mm):
Diameter +0.000/-0.008mm
Point Angle ±1°

Diam	LOF	OAL	EDP#	UnCoated Price	Coated Price
1.0mm	9.5	38	57061	\$9.20	\$10.80
1.5mm	9.5	38	57062	\$8.20	\$9.80
2.0mm	12	50	57063	\$8.60	\$10.30
2.5mm	12	50	57064	\$9.50	\$11.20
3.0mm	16	57	57065	\$10.20	\$12.70
3.5mm	16	63	57066	\$11.30	\$14.40
4.0mm	19	63	57067	\$13.00	\$16.00
4.5mm	19	63	57068	\$14.20	\$17.20
5.0mm	25	63	57069	\$16.40	\$20.40
5.5mm	25	63	57070	\$17.60	\$21.70
6.0mm	25	63	57071	\$21.10	\$25.10
6.5mm	25	63	57072	\$27.10	\$32.10
7.0mm	25	63	57073	\$28.30	\$33.20
7.5mm	25	63	57074	\$29.90	\$34.90
8.0mm	32	63	57075	\$31.10	\$36.40
8.5mm	32	75	57076	\$36.90	\$42.20
9.0mm	32	75	57077	\$39.10	\$44.40
9.5mm	32	75	57078	\$42.00	\$47.30
10.0mm	32	75	57079	\$51.80	\$58.70
10.5mm	32	75	57080	\$57.10	\$64.00
11.0mm	32	75	57081	\$57.30	\$64.20
11.5mm	32	75	57082	\$59.00	\$66.00
12.0mm	32	75	57083	\$62.60	\$69.60
12.5mm	32	75	57084	\$63.60	\$70.60
14.0mm	38	89	57085	\$84.00	\$94.10
16.0mm	38	89	57086	\$93.40	\$104.30
20.0mm	38	100	57088	\$123.60	\$138.50



Ultra-Tool® Drills are manufactured to a diameter tolerance 40% tighter than industry standards, feature unique high-productivity geometry with SmoothGrind® finishes, and are precision ground from an exclusive Ultra-Carb® material with superb wear characteristics.

Application Data for ULTRATOOL® Drills



Drilling speeds and feeds are based upon hole depth of up to 3X diameter. For deeper hole ratios reduce speeds and feeds by 10% to 25%.



Drilling;
Fractional

Material	SFPM	SFPM	1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"
Steel	UnCoated	SmoothCoat				Feed Rate: Inches Per Rev (IPR)						
1018 / 1020	100 to 250	100 to 300	.0010	.0030	.0050	.0070	.0090	.0100	.0110	.0120	.0140	.0160
4140 / 4340 / P20	60 to 230	60 to 260	.0010	.0030	.0050	.0070	.0090	.0100	.0110	.0120	.0140	.0160
Stainless Steel												
303 / 304 / 316	60 to 150	60 to 200	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
410 / 420 / 440C	40 to 100	40 to 150	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
15-5/17-4 ≤ 32HRc	75 to 175	75 to 200	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
15-5/17-4 ≥ 32HRc	50 to 125	50 to 150	.0005	.0010	.0015	.0025	.0030	.0035	.0038	.0040	.0050	.0060
13-8 / 316L	60 to 150	60 to 200	.0010	.0030	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0140
Tool Steel												
A2/D2/H13 ≤ 32HRc	60 to 150	60 to 200	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
A2/D2/H13 ≥ 32HRc	40 to 100	40 to 150	.0005	.0010	.0015	.0025	.0028	.0030	.0035	.0040	.0050	.0060
Titanium												
6Al-4V	40 to 150	40 to 175	.0005	.0010	.0020	.0025	.0028	.0030	.0035	.0040	.0050	.0060
High Temp Alloys												
Inconel 625	30 to 70	30 to 80	.0010	.0015	.0025	.0040	.0050	.0060	.0070	.0080	.0090	.0100
Inconel 718	30 to 45	30 to 50	.0005	.0010	.0020	.0025	.0028	.0030	.0035	.0040	.0050	.0060
Cast Iron												
Gray Iron ≤ 32HRc	150 to 300	150 to 350	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Ductile Iron	150 to 300	150 to 350	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Non-Ferrous												
6061 T6 Aluminum	250 to 750	250 to 1000	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Copper, Brass, Bronze	150 to 400	150 to 500	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160
Plastic	250 to 1000	250 to 1000	.0010	.0030	.0050	.0070	.0085	.0100	.0110	.0120	.0140	.0160

Drill Specifications:

Diameter: +.0000 / -.0003

LOC: +.060 / -.090

OAL: +.060 / -.090

Point Angle: ±1°

Helix Angle: ±1°

Note: Series 560 Combined Drill/C'sink:

Body Diameter: +.0000 / -.0003

Drill Diameter: +.003 / -.000

Ultra-Tool® drills feature diameter tolerances 40% tighter than industry standards. Plus, all shanks are SFR (shrink-fit ready).

Try our drills with standard SmoothCoat for a superb leap in lubricity, productivity, and tool life.



Complete range of Brad Point drills with D1 coating!

Application Data for ULTRATOOL® Burrs

Burr Diam	Diam Metric	# Flutes Std Cut	RPM*	Max. RPM
1/16	1.6 mm	6	60,000 - 90,000	100,000
1/8	3.2 mm	12	40,000 - 70,000	80,000
3/16	4.8 mm	15	35,000 - 60,000	70,000
1/4	6.3 mm	16	30,000 - 50,000	60,000
5/16	8.0 mm	18	20,000 - 40,000	52,000
3/8	9.5 mm	20	20,000 - 40,000	52,000
7/16	11.0 mm	22	15,000 - 40,000	50,000
1/2	12.7 mm	24	15,000 - 40,000	45,000
5/8	16.0 mm	28	12,000 - 25,000	30,000
3/4	19.0 mm	30	10,000 - 20,000	24,000
1"	25.4 mm	36	7,500 - 20,000	22,000

*Speeds are for Standard Cut. Reduce by approximately 25% with addition of Dura-Cut. Fine Cut increases flute count approximately 50%. Decrease speed accordingly. Coarse Cut decreases flute count approximately 20%. Increase speed accordingly. Lower listed speeds when cutting harder ferrous materials.

Ultra-Tool® Burrs feature higher hardness and a greater flute count than most competing brands for increased tool life.

Burr heads and solid carbide burrs are manufactured from Ultra-Carb®. Shanks are high speed steel hardened to a rating of 45-48 Rockwell C.



#1 Standard, #2 Fine, #3 Coarse, #4 DuraCut, #5 CoarseDura, #6 FineDura, #7 Fast Mill, #8 Diamond. In the event of extended lead times the next closest cut style within the same pricing category may be substituted to enhance service levels.

Burr Specifications:

Standard cylindrical helix angle: 30° ± 2°

Cutting Diameter: ± .010

Flute Count: ± 1

Shank Diameter: +0 / -.0005, TIR max .002

Brazed Burr TIR: max .005

Taper Angles: ± 1°