







# HIGH SPEED STEEL AIRCRAFT EXTENSION DRILLS

ICS USA/WIS

**HEAVY DUTY**

**SPLIT POINT**

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA	NAS* SPECS
AC-06B AC-12B AC-18B	 OXIDE FINISH	For portable or machine drilling in hard steels, stainless steels and other hard materials. Manufactured to NAS 907-B specs.	M2, M7	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	<b>B</b>
AC-12A	 OXIDE FINISH	For portable or machine drilling in mild steels, aluminum, and magnesium alloys. Manufactured to NAS 907-A specs.	M2, M7	118° Split Pt. (P-5) Std. Spiral Hvy. Duty Web	<b>A</b>
AC-12L (Left Hand)	 GOLD FINISH	For portable or machine drilling where left hand rotation is required. Often used to drill out broken studs and screws.	M2, M7	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	<b>B</b>
AC-12S (Stub)	 BRIGHT POLISHED FINISH	For portable drilling where increased rigidity is required. Designed for drilling in hard steels. Screw machine flute length.	M2, M7	135° Split Pt. (P-3) Spec. Fast Spiral Hvy. Duty Web	<b>C</b>
AC-06C AC-12C	 GOLD COBALT FINISH	For portable or machine drilling in stainless steel, titanium, and other work hardening metals. Manufactured to NAS 907-J specs.	M42	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	<b>J</b>
AC-06CT AC-12CT	 CARBIDE TIPPED	For portable or machine drilling of cast iron, non-ferrous metals, and non-metals. Does not need rigid set-up like solid carbide.	M1 (body)	135° Split Pt. (P-3) Std. Spiral Hvy. Duty Web	<b>B</b>

\*(NAS) National Aerospace Standard

## Fractional Sizes (Straight Shank) 3/64" to 3/4" Dia.

SIZE	DEC. EQUIV.	HIGH SPEED STEEL						COBALT		CARBIDE TIPPED	
		6" LENGTH	12" LENGTH	18" LENGTH	12" LENGTH	12" LENGTH	12" LENGTH	6" LENGTH	12" LENGTH	6" LENGTH	12" LENGTH
		Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Left Hand Jobber Flute Length	Screw Machine Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length	Jobber Flute Length
		135° Split Point	135° Split Point	135° Split Point	118° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point	135° Split Point
		AC-06B	AC-12B	AC-18B	AC-12A	AC-12L	AC-12S	AC-06C	AC-12C	AC-06CT	AC-12CT
3/64	.0469	7.38	14.84	-	-	-	-	-	-	-	-
1/16	.0625	3.70	5.88	9.78	6.20	7.82	6.48	5.52	7.74	-	-
5/64	.0781	3.60	5.96	9.86	6.30	7.82	6.56	5.48	7.84	-	-
3/32	.0938	3.50	5.38	9.26	5.66	7.38	5.82	4.68	8.00	-	-
7/64	.1094	3.36	5.42	9.30	5.72	7.38	5.82	4.68	8.24	-	-
1/8	.1250	3.22	5.06	8.96	5.36	7.74	5.30	4.68	6.80	-	17.90
9/64	.1406	3.60	5.54	9.42	5.84	-	5.82	5.84	7.40	-	19.32
5/32	.1562	3.88	6.20	10.08	6.54	8.06	6.48	5.54	8.50	-	19.00
11/64	.1719	4.18	6.66	10.54	7.02	8.74	6.96	6.08	9.06	-	20.26
3/16	.1875	4.58	7.18	11.08	7.56	9.42	7.48	6.08	10.08	-	21.98
13/64	.2031	4.88	7.42	11.30	7.82	9.92	7.74	7.52	10.68	-	21.98
7/32	.2188	5.06	8.00	11.90	8.42	10.96	8.38	7.52	12.78	-	23.88
15/64	.2344	5.40	8.56	12.44	9.00	11.54	8.76	8.16	12.78	-	25.36
1/4	.2500	5.62	9.14	13.02	9.64	12.04	9.16	12.48	13.28	-	23.88
17/64	.2656	6.54	10.68	14.56	11.24	13.76	10.68	13.76	16.02	CALL FOR PRICE	25.46
9/32	.2812	7.60	11.36	15.26	12.00	14.76	11.18	17.32	-	-	25.46
19/64	.2969	8.56	12.12	16.00	12.78	15.94	11.92	17.88	-	-	-
5/16	.3125	9.42	13.26	17.14	13.94	17.12	13.08	18.14	19.16	-	27.56
21/64	.3281	11.00	14.24	18.12	15.00	18.14	14.06	18.80	20.82	-	29.46
11/32	.3438	11.14	14.96	18.82	15.76	20.08	14.78	20.48	22.24	-	-
23/64	.3594	11.68	15.88	19.76	16.74	22.00	15.44	22.20	23.86	-	-
3/8	.3750	12.42	16.66	20.54	17.56	23.24	16.30	23.72	25.04	-	31.24
25/64	.3906	12.86	17.64	21.52	18.58	24.88	17.14	-	26.70	-	32.30
13/32	.4062	13.26	18.78	22.66	19.76	25.96	18.12	-	28.72	-	-
27/64	.4219	13.94	19.66	23.52	20.68	27.56	18.96	-	30.48	-	34.92
7/16	.4375	15.72	21.18	25.06	22.30	29.24	20.42	-	32.86	-	34.92
7/16TS	.4375	-	23.52	-	-	-	-	-	-	-	-
29/64	.4531	15.72	22.20	26.06	23.38	32.26	21.26	-	34.78	-	-
15/32	.4688	15.72	23.30	27.18	24.54	33.68	22.18	-	36.80	-	-
31/64	.4844	15.72	24.30	28.18	25.60	34.76	22.94	-	38.90	-	-
1/2	.5000	12.00	24.96	28.82	26.26	34.76	23.60	36.46	40.52	-	43.98
1/2TS	.5000	-	27.30	-	-	-	-	-	-	-	-
*9/16	.5629	-	41.02	-	-	-	-	-	87.28	-	-
*5/8	.6250	-	44.00	-	-	-	-	-	94.80	-	-
*3/4	.7500	-	55.64	-	-	-	-	-	110.46	-	-

Minimum order 12 each (3/64" - 17/64"); 6 each (9/32" - 1/2"). Add 15% for orders accepted in less than standard packaging.  
(\* 1/2" Shank). 7/16TS and 1/2TS have 3/8" Shank.