

FLOWDRILL FOR AMERICAN STANDARD COARSE TAPS (UNC)										
		APPLICATION GUIDES				DRILLING CRITERIA				
ROLL FORM TAP SIZE	HOLE SIZE (MM)	TYPE	MAXIMUM THICKNESS (MM) (INCH)		BLIND HOLE MIN DEPTH (MM)	RPM	HP	THRUST (LBS)	DRILLING TIME (SEC)	FLOWDRILL PART NUMBER
#4-40	2.5	SHORT	1.7	.067	6.4	3100	1.0	140	4	FD025S
		LONG	2.3	.091	8.4				4	FD025L
#5-40	2.9	SHORT	1.7	.067	6.9	2900	1.0	154	4	FD029S
		LONG	2.4	.094	8.9				4	FD029L
#6-32	3.1	SHORT	1.7	.067	7.3	2800	1.0	161	4	FD031S
		LONG	2.4	.094	9.4				4	FD031L
#8-32	3.8	SHORT	1.8	.071	8.2	2600	1.0	186	4	FD038S
		LONG	2.6	.102	10.5				5	FD038L
#10-24	4.3	SHORT	1.9	.075	8.9	2500	1.0	203	4	FD043S
		LONG	2.7	.106	11.4				5	FD043L
#12-24	4.9	SHORT	2.0	.079	9.8	2500	1.0	225	4	FD049S
		LONG	2.8	.110	12.7				5	FD049L
1/4-20	5.7	SHORT	2.1	.083	11.0	2400	1.5	253	4	FD057S
		LONG	3.0	.118	14.5				5	FD057L
5/16-18	7.2	SHORT	2.3	.091	13.4	2200	2.0	306	4	FD072S
		LONG	3.3	.130	17.9				5	FD072L
3/8-16	8.7	SHORT	2.5	.098	15.9	2000	2.0	359	5	FD087S
		LONG	3.6	.142	21.3				6	FD087L
7/16-14	10.2	SHORT	2.7	.106	18.5	1900	2.5	412	5	FD102S
		LONG	3.9	.154	24.8				6	FD102L
1/2-13	11.7	SHORT	2.9	.114	21.2	1700	2.5	465	5	FD117S
		LONG	4.2	.165	28.3				6	FD117L
9/16-12	13.2	SHORT	3.1	.122	23.8	1600	3.0	518	5	FD132S
		LONG	4.5	.177	31.6				7	FD132L
5/8-11	14.7	SHORT	3.3	.130	26.7	1400	3.5	571	5	FD147S
		LONG	4.9	.193	35.1				7	FD147L
3/4-10	17.8	SHORT	3.7	.146	32.4	1300	4.0	681	6	FD178S
		LONG	5.5	.217	42.2				8	FD178L

SIZES BASED ON 2MM THICKNESS, FOR THICKER MATERIAL OR MATERIAL WITH GREATER TENSILE STRENGTH (STAINLESS STEEL) THE FLOWDRILL DIAMETER WILL BE 0.1 MM BIGGER

