



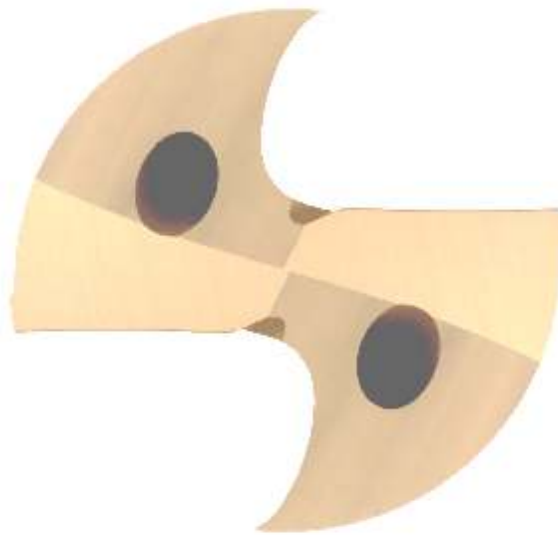
Since 1969

**Solid Carbide, Carbide Tipped & Diamond
DRILLS / REAMERS / END MILLS
& Coolant Fed Cutting Tools**

2015 Product Selection Guide

Begin on page 4 with Material, select potential options from Tool Group (A-R)

Then select from pages 2 or 3 the best tool option for your application from Tool Group.



Durapoint® Koolcarb® Kooltwist® Koolream® GenHam®

ISO 9001:2008
CERTIFIED

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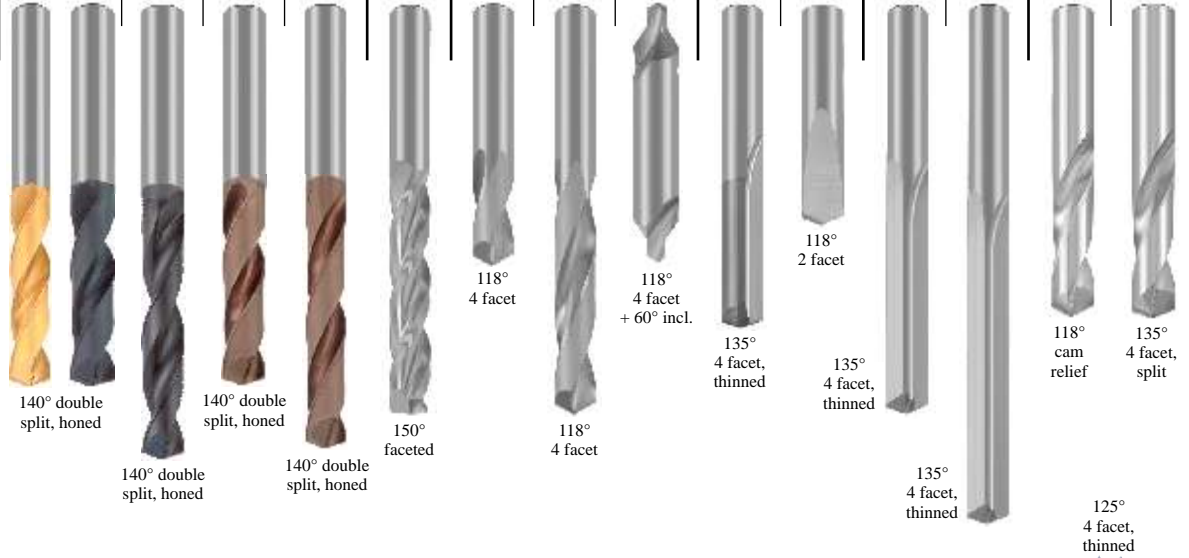
Toll-free USA & Canada: 800-323-2299
Phone: 630-690-5933
Fax: 630-690-6355
info@cjtkoolcarb.com

Standard Product Index

	Solid Carbide										Carbide Tipped				
	High Performance				High Helix 3 flute	Standard Helix			Heavy Duty		Bore Drill/Burnisher		Standard Helix		
Inch { Dia. Max. Stocked { Dia. Min.	0.75" 0.098"	0.75" 0.125"	0.75" 0.125"	0.75" 0.125"	0.5" 0.0980"	0.500" 0.125"	0.5" 0.040"	0.2188" 0.0469"	0.5" 0.0469"	0.5" 0.0625"	0.6875" 0.0938"	0.6875" 0.0938"	1.25" 0.125"	1.25" 0.125"	
Metric { Dia. Max. Stocked { Dia. Min.	19.0 2.5	19.0 3.5	19.0 3.2	19.0 3.5	12.5 2.5	11.0 2.5	12.5 1.5	— —	— —	— —	16.0 2.5	16.0 2.5	14.0 3.5	14.0 3.5	
Max x Dia. Depth	3	4-5	3	4-5	4*	1.5-3.5	4*	—	3	2	4*	6*	4*	4*	
Tool Group	A		A	B	B	C	D	D	D	E	E	F	F	G	G
Style No.	114	114A	118A	113	116	121	111	124	144	155	151	153	154	110	115



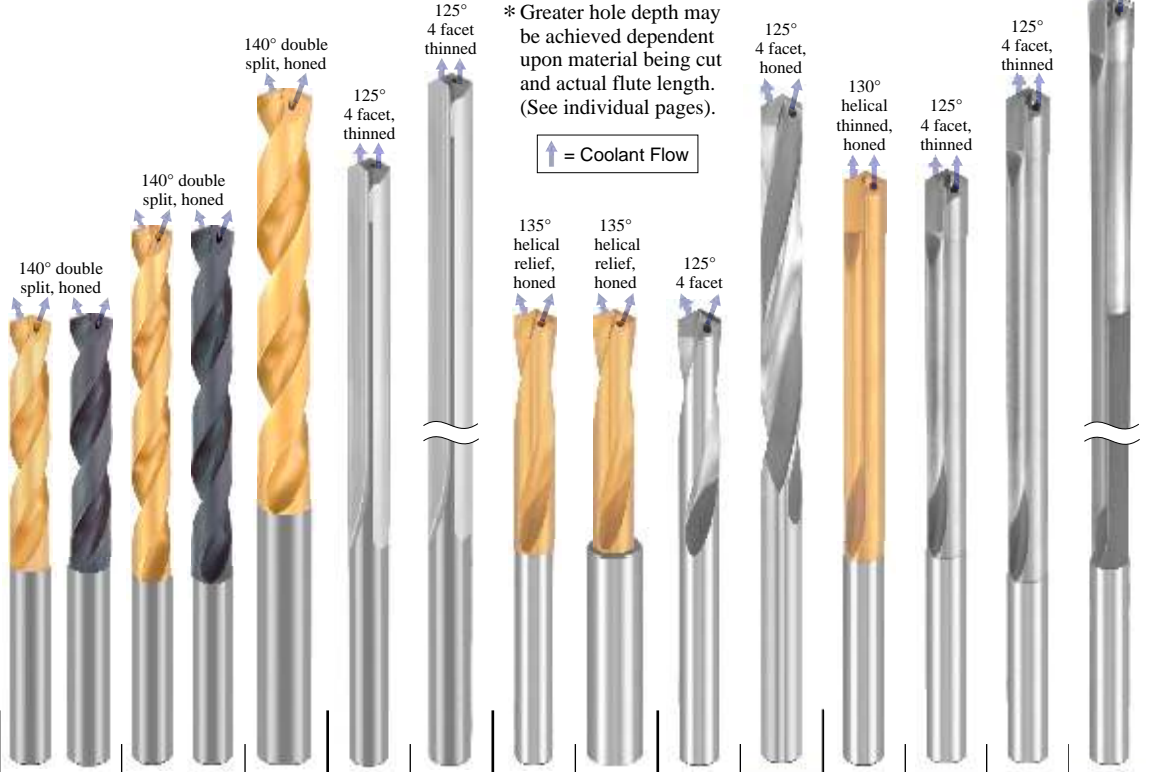
NON-COOLANT FED PRODUCTS



Toll-Free: 800-323-2299
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COOLANT FED PRODUCTS



Style No.	294	294A	293	293A	292A	174	175	296	297	295	290	176	171	170	172
Tool Group	M		M		M	N	N	P	P	Q	Q	R	R	R	R
Inch { Dia. Max. Stocked { Dia. Min.	0.7500" 0.125"	0.5938" 0.125"	0.75" 0.6094"	0.75" 0.125"	0.25" 0.125"	1.125" 0.246"	1.125" 0.25"	1.125" 0.25"	0.75" 0.25"	1" 0.1875"	1" 0.1875"	1" 0.1875"	1" 0.1875"	1" 0.25"	
Metric { Dia. Max. Stocked { Dia. Min.	19.279 3.2	15.0 3.2	19.0 15.5	6.0 3.5	6.0 3.5	26.0 6.5	26.0 6.5	26.0 6.5	— —	— —	25.0 5.0	25.0 5.0	— —	— —	
Max x Dia. Depth	4	6	6	10.5*	17.5*	4*	4*	4*	7-12	5.5-8	5.5-8	7-15	12-28		



High Performance Kooltwist®
Solid Carbide

Koolcarb®
High Performance Kooltwist®
Carbide Tipped

Heavy Duty Kooltwist®
Carbide Tipped

Koolcarb®

Carbide Tipped

Solid Carbide

Standard Helix						Heavy Duty	Special Purpose	End Mill	End Mills				Dia. Max. } Inch Dia. Min. } Stocked	
0.6875" 0.098"	0.6875" 0.116"	1" 0.125"		1.250" 0.500"	0.5" 0.116"	1" 0.1719"	0.625" 0.125"	1.375" 0.5"	1.25" 0.25"	1" 0.125"	1" 0.125"	1" 0.125"		1" 0.125"
13.0 3.0	— —	19.0 5.0		— —	— —	14.0 5.0	— —	— —	— —	25.0 3.0	— —	— —	— —	Dia. Max. } Metric Dia. Min. } Stocked
4*	4*	4*		4*	4*	3*	—	—	—	—	—	—	—	Max x Dia. Depth
G	G	G	New	G	G	J	—	—	—	—	—	—	—	Tool Group
120	125	130	126	129	140	150	162	163	320	304	302	314	312	Style No.



118° cam relief



135° 4 facet, split



118° cam relief



135° split (NASP3)



135° split (NASP3)



118° cam relief



118° cam relief, thinned



118° 2 facet



Glass & Tile



4 flute Non-center cutting.



4 flute square end, center cutting



2 flute square end, center cutting



4 flute ball nose, center cutting



2 flute ball nose, center cutting

Solid carbide end mill coating options available.



Additional End Mill styles and sizes available in the CJT End Mill Catalog.

* Greater hole depth may be achieved dependent upon material being cut and actual flute length. (See individual pages).

↑ = Coolant Flow

All reamers have 90° included chamfer point.



PCD Tipped, Diamond Tooling. Refer to CJT's Genham Catalog.

Special Tool Configurations.



Aerospace Extension and Threaded Shank Tools.



In Factory Re-sharp & Re-coat Services.

452	452A	453	453A	450	470	480	490	Style No.
—	—	—	—	—	—	—	—	Tool Group
1.125" 0.2344"	1.125" 0.2344"	0.75" 0.25"	0.75" 0.25"	1.5" 0.1855"	0.75" 0.25"	0.75" 0.25"	1.375" 0.375"	Dia. Max. } Inch Dia. Min. } Stocked
—	—	—	—	9.5 4.75	—	—	—	Dia. Max. } Metric Dia. Min. } Stocked
—	—	—	—	—	—	—	—	Max x Dia. Depth

Koolream®

Reamers

Carbide Tipped

Carbide Tipped



Tool Group / Material Selection Guide

		DURAPOINT®							KOOLTWIST®, KOOLCARB®					
		Tool Group							Tool Group					
		SOLID CARBIDE NON-COOLANT FED				CARBIDE TIP NON-COOLANT FED			SOLID CARBIDE COOLANT FED		CARBIDE TIP COOLANT FED			
Material Workpiece	Chip Class	High Penetration Spiral Flute	High Penetration Spiral Flute	Standard Helix	3 Flute High Helix	Str. Flute Heavy Duty	Bore Drill Straight Flute	Standard Helix	Str. Flute Heavy Duty	High Penetration Spiral Flute	Straight Flute	High Penetration Spiral Flute	Spiral Flute Heavy Duty	Straight Flute
		TiN / TiAlN	TiAlCN							TiN / TiAlN		TiN		
Tool Group		A	B	D	C	E	F	G	J	M	N	P	Q	R
Aluminum Alloys [$<5\%$ Si]	(250-450	○	150-350	200-400	○	○	○	○	500-650	200-400	250-425	200-400	200-400
Aluminum [$>5\%$ Si])]	350-600	○	200-400	300-500	○	200-400	150-350	○	500-650	350-550	300-500	200-400	300-500
Copper - Zinc (Brass))]	200-400	○	150-300	175-350	150-300	150-300	150-300	150-300	400-550	225-300	250-450	225-425	200-400
Copper Alloys (Bronze))]	200-400	○	150-250	200-300	150-250	150-300	150-300	150-200	500-650	175-250	200-400	200-300	200-300
Cast (Grey) Iron)]	150-350	○	150-300	175-325	○	200-350	150-225	○	300-400	200-300	225-325	200-260	225-300
Ductile (Nodular) Iron Powder Metal)]	150-300	150-300	150-250	150-250	○	150-250	125-275	○	275-350	150-250	225-275	200-260	190-250
Carbon Steels [$<35\text{C}$]	(150-250	200-350	○	○	○	○	○	○	290-390	○	180-250	○	○
Medium Carbon Steels [>35 to 50C])]	150-250	130-220	○	○	○	○	○	○	150-250	110-150	150-200	100-150	100-150
High Carbon & Tool Steels [$>50\text{C}$])]	80-140	65-120	○	○	60-125	○	○	60-125	120-225	80-135	135-185	70-100	100-150
Hardened Steel (48 to 65Rc))]	40-80	○	○	○	25-60	○	○	25-60	50-100	○	45-90	60-90	○
Free Machining Stainless Steel)]	100-200	○	80-180	80-180	80-180	○	80-160	○	130-200	120-180	120-170	100-160	70-125
Stainless Steel)]	90-150	90-150	60-140	60-140	60-140	○	○	○	100-150	80-120	80-120	60-100	○
High Nickel Stainless Steel	(30-70	30-70	○	○	○	○	○	○	90-150	○	40-60	○	○
Titanium)]	60-120	55-110	50-90	50-90	50-100	○	40-80	○	90-150	60-100	50-110	50-100	60-120
Moderate Temperature Alloys)]	50-100	○	○	○	50-100	○	○	○	70-130	○	60-90	60-90	○
High Temperature Alloys)]	25-80	○	○	○	25-80	○	○	25-80	40-80	○	40-80	40-80	○
Hard Plastics, Resin, Fiberglass, Graphite and Carbon)]	○	○	100-200	125-225	○	○	100-200	○	○	150-225	○	○	125-200

SFM - Surface Feet per Minute

 1st Choice
 2nd Choice
○ Do Not Use

 1st Choice
 2nd Choice
○ Do Not Use