

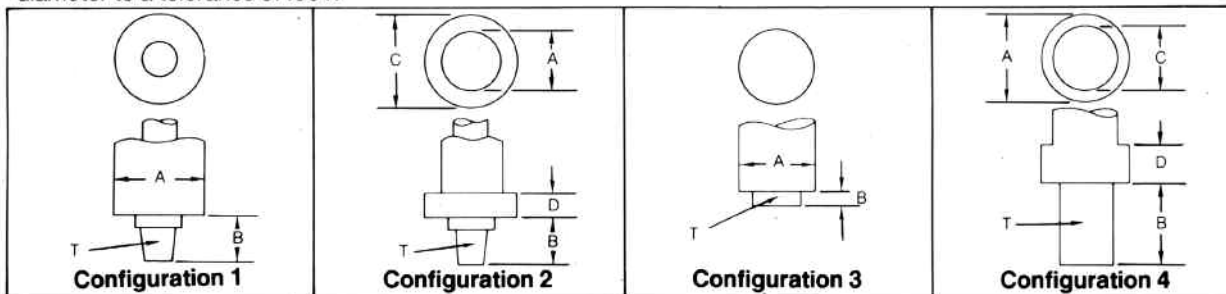
Designers & Manufacturers of Drilling & Tapping Solutions

| SIZE TAP | THREAD PITCH | | DRILL SIZE | | MATERIAL | | | | | |
|------------------|--------------|------|------------|-----------|--------------|-------|-------------------|-------|--------------------------|-------|
| | | | | | ALUMINUM | | SOFT STEEL | | STAINLESS STEEL | |
| | N.C. | N.F. | CUT THD. | ROLL THD. | RPM | H.P. | RPM | H.P. | RPM | H.P. |
| #0 | | 80 | 3/64" | #54 | 2000 | 1/16 | 2000 | 1/16 | 1270 | 1/8 |
| #2 | 56 | | #50 | 5/64" | 2000 | 1/16 | 2000 | 1/16 | 750 | 1/8 |
| #4 | 40 | | #43 | #39 | 2000 | 1/16 | 2000 | 1/8 | 580 | 1/4 |
| #6 | 32 | | #34 | 1/8" | 2000 | 1/16 | 1870 | 1/8 | 470 | 1/4 |
| #8 | 32 | | #29 | #25 | 2000 | 1/16 | 1560 | 1/8 | 390 | 1/4 |
| #10 | 24 | | #23 | 11/64" | 1700 | 1/8 | 1360 | 1/4 | 340 | 1/3 |
| | | 32 | #20 | #16 | 1800 | 1/8 | 1600 | 1/4 | 400 | 1/2 |
| 1/4" | 20 | | #6 | #1 | 1600 | 1/4 | 800 | 1/3 | 200 | 1/2 |
| | | 28 | #3 | A | 1800 | 1/4 | 1200 | 1/4 | 300 | 1/3 |
| 5/16" | 18 | | G | 7.3mm | 1260 | 1/4 | 640 | 1/3 | 160 | 3/4 |
| | | 24 | I | M | 1500 | 1/4 | 960 | 1/3 | 240 | 1/2 |
| 3/8" | 16 | | O | S | 1050 | 1/4 | 530 | 1/2 | 130 | 1 |
| | | 24 | R | T | 1300 | 1/4 | 800 | 1/2 | 200 | 3/4 |
| 7/16" | 14 | | 3/8" | 13/32" | 1200 | 1/3 | 450 | 3/4 | 110 | 1 |
| 1/2" | 13 | | 27/64" | 15/32" | 800 | 1/3 | 400 | 3/4 | 100 | 1 |
| | | 20 | 29/64" | 31/64" | 1200 | 1/3 | 600 | 3/4 | 150 | 3/4 |
| 5/8" | 11 | | 17/32" | 15.0mm | 640 | 1/2 | 320 | 1 | 80 | 1 1/2 |
| | | 18 | 37/64" | 19/32" | 975 | 1/2 | 490 | 3/4 | 120 | 1 |
| 3/4" | 10 | | 21/32" | 45/64" | 540 | 1/2 | 266 | 1 | 66 | 2 |
| | | 16 | 11/16" | 23/32" | 815 | 1/2 | 405 | 1 | 100 | 1 1/2 |
| 7/8" | 9 | | 49/64" | — | 460 | 3/4 | 230 | 1 1/2 | 56 | 2 |
| 1" | 8 | | 7/8" | — | 400 | 3/4 | 200 | 1 1/2 | 50 | 3 |
| 1/8" NPT | 27 | | R | — | 1200 | 1/4 | 900 | 1/2 | 300 | 1/2 |
| 1/4" NPT | 18 | | 7/16" | — | 1000 | 1/2 | 600 | 3/4 | 250 | 1 |
| 3/8" NPT | 18 | | 37/64" | — | 700 | 3/4 | 350 | 1 | 150 | 1 1/2 |
| 1/2" NPT | 14 | | 23/32" | — | 500 | 1 | 250 | 1 1/2 | 90 | 2 |
| 3/4" NPT | 14 | | 59/64" | — | 350 | 1 1/2 | 175 | 2 | 50 | 3 |
| COOLANT → | | | | | Soluble Oil. | | Sulphur Base Oil. | | Chlor. Sulphur Base Oil. | |

NOTE: Water soluble coolant not recommended.

Drill Press Adaptations

PROCUNIER Cover Clamps can be supplied to adapt to virtually any drill press. When ordering cover clamp style heads, the dimensions indicated, including the Taper "T", must be supplied. Dimension "A" always refers to the Quill diameter to a tolerance of .001.



ROCKFORD DRILL HEAD

