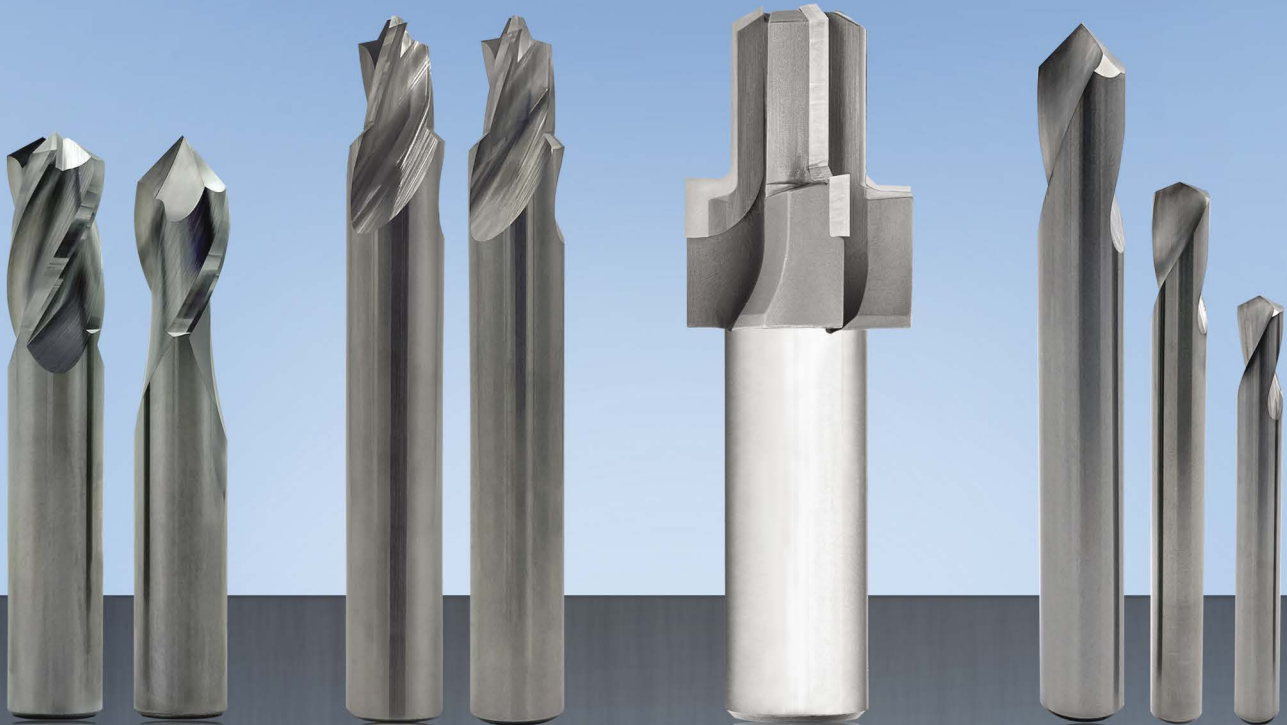




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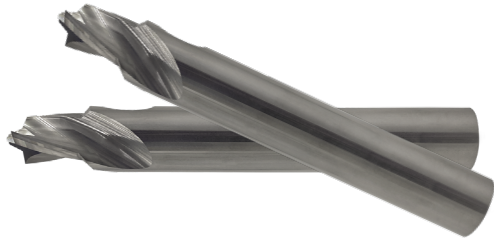
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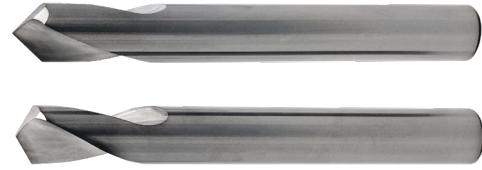
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DRILL MILLS, AUTOCLAVE PORT TOOLS,
ISO 1179 & SPOTTING DRILLS
BY SCIENTIFIC CUTTING TOOLS



Autoclave Port Tools (Medium-Pressure)

Autoclave port tools are the newest addition and conform to the Parker medium-pressure Autoclave standard. Solid carbide tools with helical flutes are stocked for the 1/4, 3/8" and 9/16" tube sizes. Carbide-tipped tools are stocked for the 3/4" and 1.00" tube sizes. All of our Autoclave tools are exclusively offered with AlTiN+ coating for the demanding materials associated with these ports.



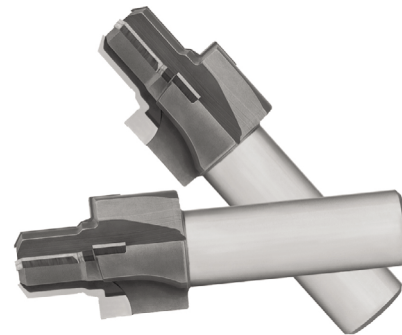
Spotting Drills

Spotting drills are a valuable first step in the hole-making process. The precise point angle is held to a one-degree tolerance for true centering. Covering a wide range of sizes, tools are stocked with 82°, 90°, 100°, 120° and 142° point angles in both AlTiN and uncoated finishes. For optimal performance, it is best to choose a spotting drill angle that is equal to or greater than the angle of the following drill. All spotting drills are designed with a 4-facet point and constant web for easy resharpening. AlTiN coating is highly recommended for extended tool life.



Drill Mills

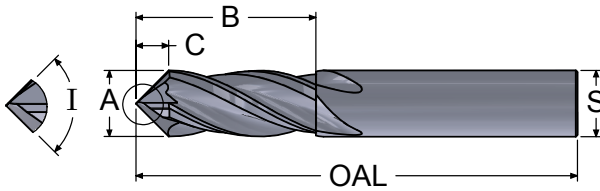
The versatile, multi-operational specialty drill mill is designed for milling, chamfering, and light spotting applications. Despite the word 'drill' in the name, it is not recommended for drilling. The name is conceived from the common industry standard for the tool. Cutting diameter sizes range from 1/8" to 1/2". Included angle options are 90° or 120°. The two-flute design is optimal when chip evacuation and increased chip per tooth are the priority. For harder materials, the fortified strength of the four-flute design performs best and allows for increased feed rates in hard materials. The utility and diversity of the drill mill functions provide flexibility and enhanced productivity in one outstanding tool.



ISO 1179 Port Tool

The ISO 1179 port tool cuts the BSPP minor thread diameter, 90° included angle, and the spot face per the requirements of ISO 1179. Sizes range from G1/8" to G1-1/2". The carbide tipped port tool features brazed carbide inserts of highest quality sub-micron carbide for optimal material properties. Smaller thread size port tools are three flute and larger thread size port tools are four flutes. 1179 port tools have a polished flute face for best performance. Items are stocked uncoated or AlTiN coated. The AlTiN coating is highly recommended if cutting steel as the coating prevents the chip from sticking to the carbide. Additionally, AlTiN coating improves tool life and allows the tool to achieve a high quality finish.

DRILL MILLS - SOLID CARBIDE



- For milling, chamfering and light spotting applications
- ALTiN+ coating for higher cutting speed
- Precision ground for maximum concentricity

"I" INCLUDED ANGLE	"A" TOOL DIA.	"B" LENGTH OF CUT	"C" TIP LENGTH	"S" SHANK DIA.	OAL	FLUTES	ORDER #		EDP #	
							UNCOATED	ALTiN+	UNCOATED	ALTiN+
90°	0.125	0.500	0.061	0.125	1.50	2	DRM12502-090	DRM12502-090A	502000	502002
90°	0.125	0.500	0.061	0.125	1.50	4	DRM12504-090	DRM12504-090A	502008	502010
90°	0.1875	0.625	0.092	0.1875	2.00	2	DRM18702-090	DRM18702-090A	502016	502018
90°	0.1875	0.625	0.092	0.1875	2.00	4	DRM18704-090	DRM18704-090A	502024	502026
90°	0.250	0.750	0.123	0.250	2.50	2	DRM25002-090	DRM25002-090A	502032	502034
90°	0.250	0.750	0.123	0.250	2.50	4	DRM25004-090	DRM25004-090A	502040	502042
90°	0.3125	0.812	0.155	0.3125	2.50	2	DRM31202-090	DRM31202-090A	502048	502050
90°	0.3125	0.812	0.155	0.3125	2.50	4	DRM31204-090	DRM31204-090A	502056	502058
90°	0.375	1.000	0.186	0.375	2.50	2	DRM37502-090	DRM37502-090A	502064	502066
90°	0.375	1.000	0.186	0.375	2.50	4	DRM37504-090	DRM37504-090A	502072	502074
90°	0.500	1.000	0.248	0.500	3.00	2	DRM50002-090	DRM50002-090A	502080	502082
90°	0.500	0.100	0.248	0.500	3.00	4	DRM50004-090	DRM50004-090A	502088	502090
120°	0.125	0.500	0.035	0.125	1.50	2	DRM12502-120	DRM12502-120A	502004	502006
120°	0.125	0.500	0.035	0.125	1.50	4	DRM12504-120	DRM12504-120A	502012	502014
120°	0.1875	0.625	0.053	0.1875	2.00	2	DRM18702-120	DRM18702-120A	502020	502022
120°	0.1875	0.625	0.053	0.1875	2.00	4	DRM18704-120	DRM18704-120A	502028	502030
120°	0.250	0.750	0.071	0.250	2.50	2	DRM25002-120	DRM25002-120A	502036	502038
120°	0.250	0.750	0.071	0.250	2.50	4	DRM25004-120	DRM25004-120A	502044	502046
120°	0.3125	0.812	0.089	0.3125	2.50	2	DRM31202-120	DRM31202-120A	502052	502054
120°	0.3125	0.812	0.089	0.3125	2.50	4	DRM31204-120	DRM31204-120A	502060	502062
120°	0.375	1.000	0.107	0.375	2.50	2	DRM37502-120	DRM37502-120A	502068	502070
120°	0.375	1.000	0.107	0.375	2.50	4	DRM37504-120	DRM37504-120A	502076	502078
120°	0.500	1.000	0.143	0.500	3.00	2	DRM50002-120	DRM50002-120A	502084	502086
120°	0.500	0.100	0.143	0.500	3.00	4	DRM50004-120	DRM50004-120A	502092	502094

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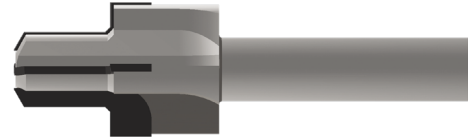
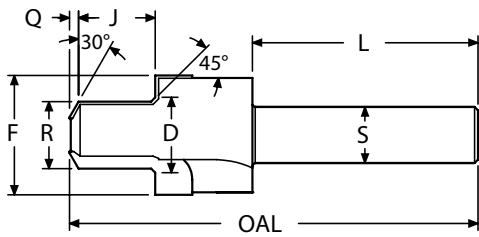
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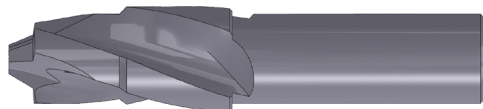
ISO 1179 PORT TOOL - CARBIDE TIPPED



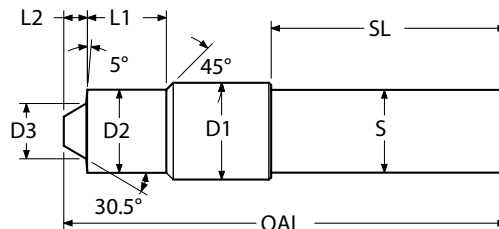
- Meets the requirements of the ISO1179
- Polished flute face for optimum performance
- Precision ground for maximum concentricity
- AlTiN+ coating for improved surface finish

D	F	J	R	Q	L	S	OAL	FLUTES	THREAD	ORDER #		EDP #	
										UNCOATED	AlTiN+	UNCOATED	AlTiN+
0.398	0.681	0.445	0.345	0.045	2.00	0.500	3.50	3	G1/8	1179-G125	1179-G125A	402874	402875
0.524	0.819	0.683	0.459	0.065	2.00	0.500	3.62	3	G1/4	1179-G250	1179-G250A	402876	402877
0.662	0.969	0.683	0.597	0.080	2.00	0.500	3.62	4	G3/8	1179-G375	1179-G375A	402878	402879
0.831	1.169	0.801	0.741	0.090	2.00	0.750	3.62	4	G1/2	1179-G500	1179-G500A	402880	402881
1.048	1.457	0.880	0.958	0.120	2.50	0.750	4.37	4	G3/4	1179-G750	1179-G750A	402882	402883
1.319	1.819	0.998	1.201	0.120	2.50	1.000	4.62	4	G1	1179-G1000	1179-G1000A	402884	402885
1.662	2.130	1.078	1.541	0.125	2.50	1.000	4.62	4	G1-1/4	1179-G1250	1179-G1250A	402886	402887
1.894	2.386	1.200	1.774	0.125	2.50	1.000	4.88	4	G1-1/2	1179-G1500	1179-G1500A	402888	402889

AUTOCLAVE PORT TOOLS - MEDIUM PRESSURE SOLID CARBIDE AND CARBIDE-TIPPED



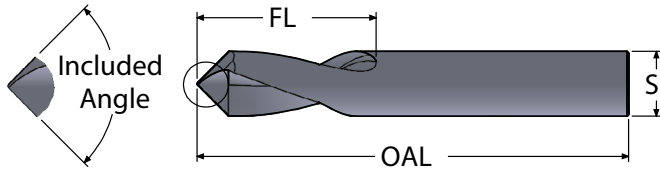
- Designed to produce ports per Parker Autoclave Standard
- Precision ground for maximum concentricity
- Polished flute face for optimum performance
- AlTiN+ coating for improved surface finish



D1	D2	D3	L1	L2	S	SL	OAL	FLUTES	FLUTE TYPE	TUBE	THREAD	CONNECTION TYPE	ORDER #		EDP #	
													AlTiN+	AlTiN+	AlTiN+	AlTiN+
Solid Carbide																
0.500	0.390	0.188	0.471	0.101	0.500	2.13	3.50	3	Helical	1/4	7/16-20	SF250CX	PT-SF0250CX-A		405006	
0.625	0.511	0.310	0.599	0.134	0.500	2.13	3.50	3	Helical	3/8	9/16-18	SF375CX	PT-SF0375CX-A		405008	
0.875	0.752	0.500	0.715	0.213	0.750	2.13	4.00	3	Helical	9/16	13/16-16	SF562CX10 SF562CX20	PT-SF0562CX-A		405010	
Carbide-Tipped																
1.090	0.966	0.625	0.899	0.216	0.750	2.25	4.50	3	Straight	3/4	3/4-14 NPS	SF750CX10 SF750CX20	PT-SF0750CX-A		405012	
1.438	1.297	0.875	1.266	0.418	0.750	2.25	4.75	3	Straight	1	1-3/8-12	SF1000CX10 SF1000CX20	PT-SF1000CX-A		405014	

Helical flute styles are solid carbide. Straight flute styles are carbide-tipped.

SPOTTING DRILLS - SOLID CARBIDE



- Designed with a 4-facet point and constant web
- Point angle is held to $\pm 1^\circ$ tolerance
- 20° helical flute
- ALTiN+ coating extends tool life

INCLUDED ANGLE	"S" SHANK DIA.	OAL	"FL" FLUTE LENGTH	FLUTES	ORDER #		EDP #	
					UNCOATED	ALTiN+	UNCOATED	ALTiN+
82°	0.1250	2.00	0.40	2	SPD125-082	SPD125-082A	501000	501080
82°	0.1875	2.00	0.50	2	SPD187-082	SPD187-082A	501010	501090
82°	0.2500	2.50	0.70	2	SPD250-082	SPD250-082A	501020	501100
82°	0.3125	2.50	0.90	2	SPD312-082	SPD312-082A	501030	501110
82°	0.3750	3.00	1.00	2	SPD375-082	SPD375-082A	501040	501120
82°	0.5000	3.00	1.10	2	SPD500-082	SPD500-082A	501050	501130
82°	0.6250	3.50	1.20	2	SPD625-082	SPD625-082A	501060	501140
82°	0.7500	4.00	1.30	2	SPD750-082	SPD750-082A	501070	501150
90°	0.1250	2.00	0.40	2	SPD125-090	SPD125-090A	501002	501082
90°	0.1875	2.00	0.50	2	SPD187-090	SPD187-090A	501012	501092
90°	0.2500	2.50	0.70	2	SPD250-090	SPD250-090A	501022	501102
90°	0.3125	2.50	0.90	2	SPD312-090	SPD312-090A	501032	501112
90°	0.3750	3.00	1.00	2	SPD375-090	SPD375-090A	501042	501122
90°	0.5000	3.00	1.10	2	SPD500-090	SPD500-090A	501052	501132
90°	0.6250	3.50	1.20	2	SPD625-090	SPD625-090A	501062	501142
90°	0.7500	4.00	1.30	2	SPD750-090	SPD750-090A	501072	501152
100°	0.1250	2.00	0.40	2	SPD125-100	SPD125-100A	501004	501084
100°	0.1875	2.00	0.50	2	SPD187-100	SPD187-100A	501014	501094
100°	0.2500	2.50	0.70	2	SPD250-100	SPD250-100A	501024	501104
100°	0.3125	2.50	0.90	2	SPD312-100	SPD312-100A	501034	501114
100°	0.3750	3.00	1.00	2	SPD375-100	SPD375-100A	501044	501124
100°	0.5000	3.00	1.10	2	SPD500-100	SPD500-100A	501054	501134
100°	0.6250	3.50	1.20	2	SPD625-100	SPD625-100A	501064	501144
100°	0.7500	4.00	1.30	2	SPD750-100	SPD750-100A	501074	501154
120°	0.1250	2.00	0.40	2	SPD125-120	SPD125-120A	501006	501086
120°	0.1875	2.00	0.50	2	SPD187-120	SPD187-120A	501016	501096
120°	0.2500	2.50	0.70	2	SPD250-120	SPD250-120A	501026	501106
120°	0.3125	2.50	0.90	2	SPD312-120	SPD312-120A	501036	501116
120°	0.3750	3.00	1.00	2	SPD375-120	SPD375-120A	501046	501126
120°	0.5000	3.00	1.10	2	SPD500-120	SPD500-120A	501056	501136
120°	0.6250	3.50	1.20	2	SPD625-120	SPD625-120A	501066	501146
120°	0.7500	4.00	1.30	2	SPD750-120	SPD750-120A	501076	501156
142°	0.1250	2.00	0.40	2	SPD125-142	SPD125-142A	501008	501088
142°	0.1875	2.00	0.50	2	SPD187-142	SPD187-142A	501018	501098
142°	0.2500	2.50	0.70	2	SPD250-142	SPD250-142A	501028	501108
142°	0.3125	2.50	0.90	2	SPD312-142	SPD312-142A	501038	501118
142°	0.3750	3.00	1.00	2	SPD375-142	SPD375-142A	501048	501128
142°	0.5000	3.00	1.10	2	SPD500-142	SPD500-142A	501058	501138
142°	0.6250	3.50	1.20	2	SPD625-142	SPD625-142A	501068	501148
142°	0.7500	4.00	1.30	2	SPD750-142	SPD750-142A	501078	501158

For optimal performance choose a spotting drill angle that is equal or greater than the angle of the following drill

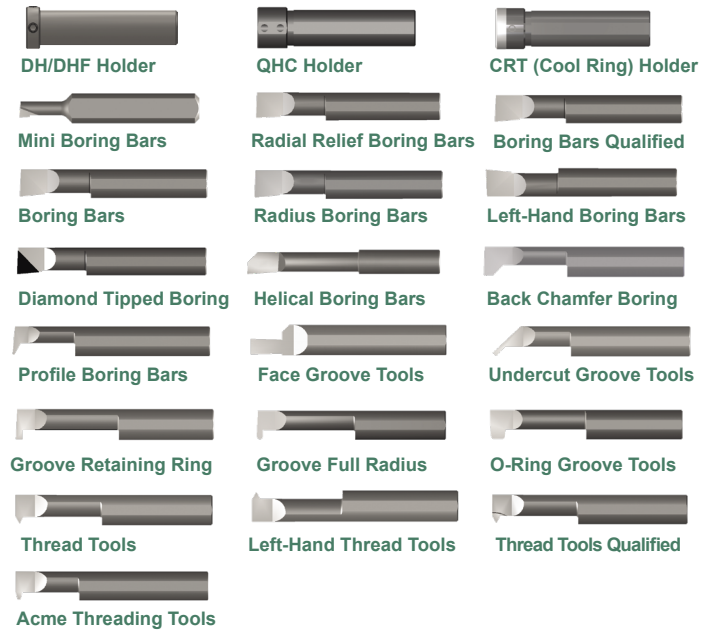
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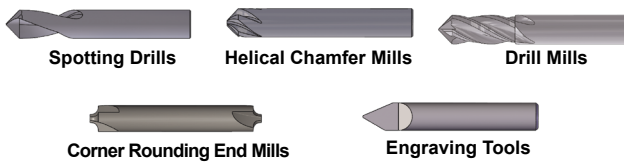
THREAD MILLS



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