



Advanced Performance High Feed 3-Flute Carbide Drills

Vol 1

# ADO-TRS

ADO-TRS 3D & 5D



# The A Brand Story

The A Brand represent a new evolution in cutting tool technology. With a commitment to only the best, the A Brand emanates innovations essential for shaping the future of global manufacturing.

The A Brand is a premium tooling brand that represents OSG's quality assurance guarantee to each and every customer. The A Brand products have been developed with attention to the finest details, while incorporating a versatility to enable a wide range of processing in various materials. With the capability to perform difficult processing tasks, and high efficiency the A Brand products lend to shortened production time and cost savings.

The A Brand products have been developed with OSG's latest tooling innovations in threading, drilling, and milling to bring an unparalleled experience to our manufacturers with the highest level of quality, reliability, and satisfaction that can only be delivered by the A Brand, the tooling master class.



# The Tooling Master Class

Innovations for shaping the future of global manufacturing



# The A Brand *The Tooling Master Class*

## LINE-UP

The A Brand is not only a premium tooling brand, it also represents the quality assurance OSG guarantees to each and every customer.

To better accommodate evolving manufacturing needs, the A Brand offering has been expanded. Whether you are looking for better tools or need assistance in choosing the right tool, give one of the A Brand products a try. You will experience a level of quality, reliability and satisfaction that can only be delivered by the A Brand tooling master class.

## A-DRILL



**A Brand ADO-TRS 3D & 5D**



**A Brand ADF • ADFO • ADFL**



**A Brand ADO 3-50D**



**A Brand AD 2D & 4D**



**A Brand ADO-SUS 3-8D**



**A Brand AD-LDS**



**A Brand ADO-MICRO 2-30D**

## A-TAP



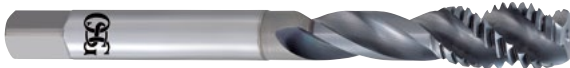
**A Brand AT-1**



**A Brand A-CSF**



**A Brand A-CHT**



**A Brand A-SFT • A-OIL-SFT • A-LT-SFT**



**A Brand A-POT • A-OIL-POT • A-LT-POT**



**A Brand A-PIPE**

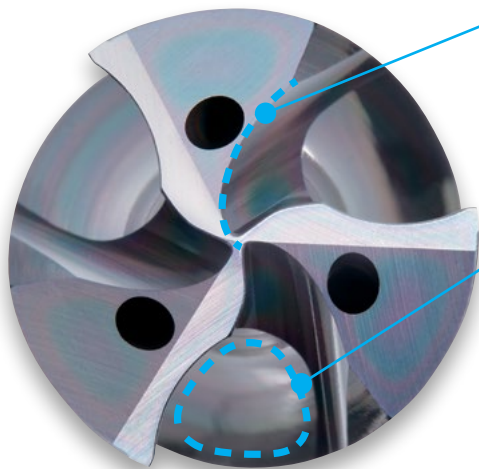
## A-END MILL



**A Brand AE-BD-H • AE-BM-H • AE-LNBD-H**



**A Brand AE-VMS • AE-CR-VMS • AE-LN-CR-VMS  
AE-VMSS • AE-LN-VMSS • AE-VML • AE-NIK-VML**



## R Gash Geometry

Enables low cutting resistance compared to 2-flute drills, and breaks chips into small manageable pieces.

## Wide Flutes

Large chip pockets enable smooth chip evacuation.

## EgiAs Coating

for exceptional wear resistance and toughness.

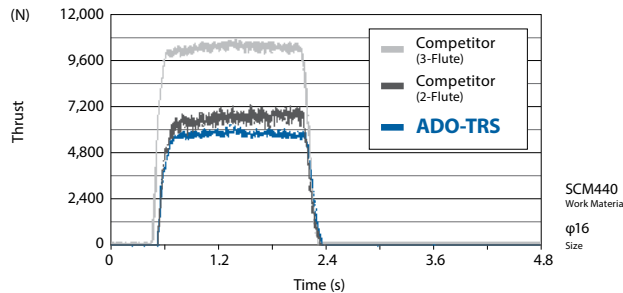


## The New Standard of 3-Flute Drills

### 3 Advantages of a 3-Flute Design

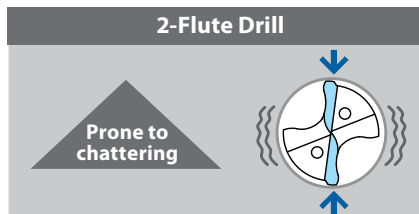
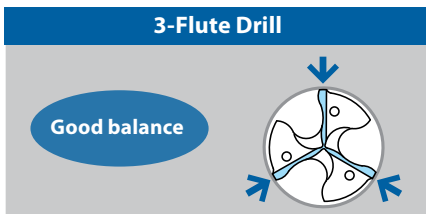
#### Lower Thrust Force:

ADO-TRS reduces thrust force by over 30% against the competitor's 3-flute drill, while also producing lower thrust force than even the competitor's 2-flute drill.



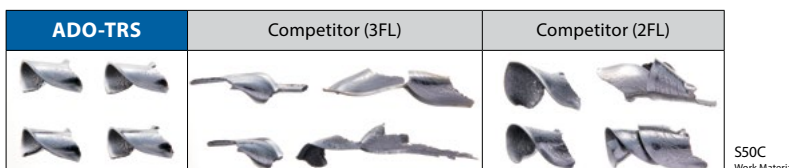
#### High Precision & Hole Quality:

The 120° equal spacing margins of the 3-flute design allows for more stable, vibration-free hole processing, thereby increasing hole quality and tolerance.



#### Outstanding Chip Management:

ADO-TRS produces small, consistent chips that can be easily evacuated, while the competitor's 3-flute & 2-flute drills' chips are elongated, which is the most common cause of chip evacuation difficulty.

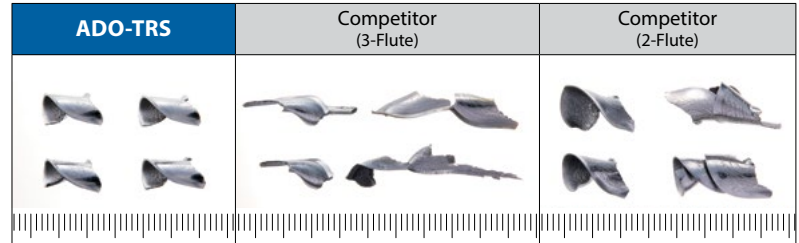
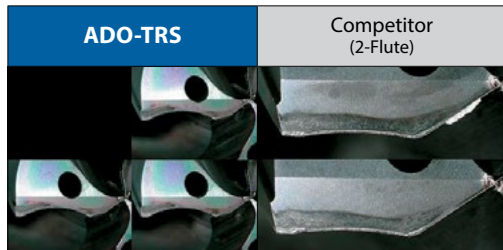
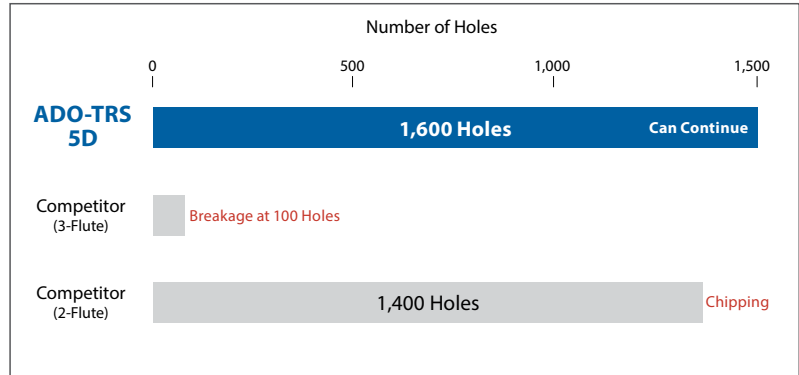


## Tool Life in Carbon Steel

### 1050 Carbon Steel

Outstanding cutting chip breakage and consistent chip form.

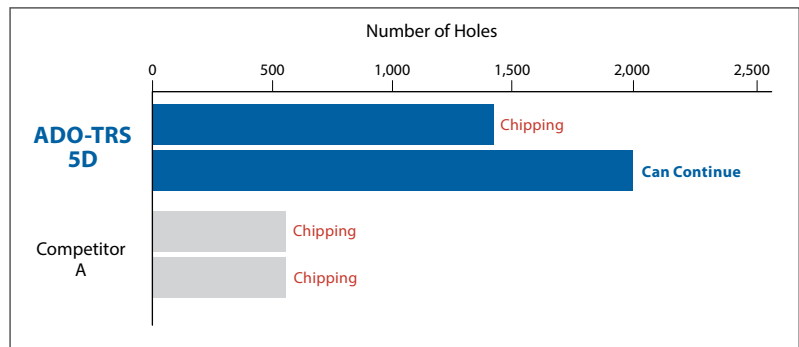
Tool	ADO-TRS 5D	Competitor (3-Flute)	Competitor (2-Flute)
Drill Size	Ø14		
Work Material	1050 Carbon Steel		
Cutting Speed	330 SFM (2,275 RPM)		
Feed Rate	53.7 IPM (0.024 in/rev)	38.0 IPM (0.015 in/rev)	
Depth of Hole	2.756" (Blind)		
Coolant	Water-Soluble		
Machine	Horizontal Machining Center		



## Tool Life in Cast Iron

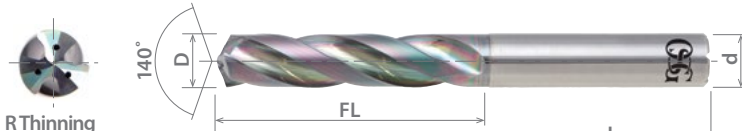
### Gray Cast Iron

Tool	ADO-TRS 5D	Competitor A
Drill Size	Ø8.5mm	
Work Material	Gray Cast Iron	
Cutting Speed	230 SFM (2,625 RPM)	
Feed Rate	44.6 IPM (0.017 IPR)	
Depth of Hole	43 mm	
Coolant	Water Soluble	
Machine	Vertical Machining Center	



## List 6600

ADO-TRS-3D, 3 Flute, Coolant-Through



<b>NEW</b>	<b>SPEED FEED</b> P15	<b>CARBIDE</b>	<b>EgiAs</b>		<b>30°</b>	<b>SHANK</b> h6
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Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status								
	Fractional Size	Wire Gage	Letter Size	mm	Inch												
8720300	-	-	-	3.000	0.11811	18	66	3	●								
660012517	1/8	-	-	3.175	0.12500	20	74	1/8	●								
8720330	-	-	-	3.300	0.12992	21		4	●								
660013217	-	-	-	3.360	0.13228				●								
660013517	-	-	-	3.440	0.13543	22			●								
8720350	-	-	-	3.500	0.13780				●								
660013817	-	-	-	3.520	0.13858	23			●								
660014017	-	-	-	3.570	0.14055				●								
8720366	-	-	-	3.660	0.14409	24			●								
660014817	-	-	-	3.770	0.14843				●								
8720386	-	-	-	3.860	0.15197	25			5/32	●							
660015617	5/32	-	-	3.969	0.15625		4		●								
8720400	-	-	-	4.000	0.15748	26	6	●									
660015917	-	-	-	4.050	0.15945			27	3/16	●							
660016117	-	20	-	4.089	0.16100					28	6	●					
8720410	-	-	-	4.100	0.16142			29				6	●				
660016317	-	-	-	4.160	0.16378					30			1/4	●			
8720420	-	-	-	4.200	0.16535			31						6	●		
660016817	-	-	-	4.270	0.16811					32					1/4	●	
8720430	-	-	-	4.300	0.16929			33								8	●
660017217	11/64	-	-	4.366	0.17188					32							1/4
8720440	-	-	-	4.400	0.17323			33									
660017517	-	-	-	4.460	0.17559	32	1/4			●							
8720450	-	-	-	4.500	0.17717			33	8	●							
8720460	-	-	-	4.600	0.18110	32				8	●						
660018317	-	-	-	4.660	0.18346			33			8	●					
8720470	-	-	-	4.700	0.18504	32						8	●				
660018717	3/16	-	-	4.763	0.18750			33					8	●			
8720480	-	-	-	4.800	0.18898	32								8	●		
8720490	-	-	-	4.900	0.19291			31							8	●	
8720500	-	-	-	5.000	0.19685	30										8	●
8720510	-	-	-	5.100	0.20079			29									8
660020317	13/64	-	-	5.159	0.20313	28	8										
8720520	-	-	-	5.200	0.20472			27	8								
8720530	-	-	-	5.300	0.20866	26				8							
8720540	-	-	-	5.400	0.21260			25			8						
660021317	-	3	-	5.410	0.21300	24						8					
8720550	-	-	-	5.500	0.21654			23					8				
660021817	7/32	-	-	5.556	0.21875	22								8			
8720560	-	-	-	5.600	0.22047			21							8		
8720570	-	-	-	5.700	0.22441	20										8	
8720580	-	-	-	5.800	0.22835			19									8
8720590	-	-	-	5.900	0.23228	18	8										
660023417	15/64	-	-	5.953	0.23438			17	8								
8720600	-	-	-	6.000	0.23622	16				8							
8720610	-	-	-	6.100	0.24016			15			8						
8720620	-	-	-	6.200	0.24409	14						8					
8720630	-	-	-	6.300	0.24803			13					8				
660025017	1/4	-	E	6.350	0.25000	12								8			
8720640	-	-	-	6.400	0.25197			11							8		
8720650	-	-	-	6.500	0.25591	10										8	
660025717	-	-	F	6.528	0.25700			9									8

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.

continued on next page

List No.	Work Material																
	P					M			K	N		S		H			
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels			
	Low 1010 1018	Med. 1035 1045	High 1065	4140 4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
6600	○	○	○	○	○		○	○	○		○		○	○	○	○	○

○ good ○ best

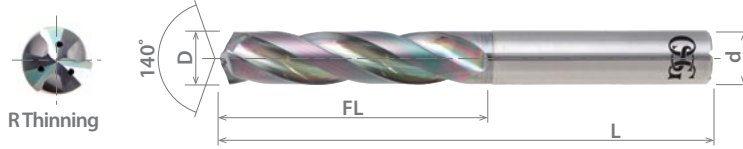


# A Brand ADO-TRS

Advanced Performance High Feed 3-Flute Carbide Drills

## List 6600 (Continued)

ADO-TRS-3D, 3 Flute, Coolant-Through



<b>NEW</b>	<b>SPEED FEED</b> P15	<b>CARBIDE</b>	<b>EgiAs</b>		<b>30°</b>	<b>SHANK</b> h6
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Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8720660	-	-	-	6.600	0.25984	33	88	8	●
8720670	-	-	-	6.700	0.26378	34		5/16	●
660026517	17/64	-	-	6.747	0.26563		35	8	●
8720680	-	-	-	6.800	0.26772	36		5/16	●
8720690	-	-	-	6.900	0.27165		37		8
8720700	-	-	-	7.000	0.27559	38		5/16	
8720710	-	-	-	7.100	0.27953		39		8
660028117	9/32	-	-	7.144	0.28125	40		5/16	
8720720	-	-	-	7.200	0.28346		41		8
8720730	-	-	-	7.300	0.28740	42		5/16	
8720738	-	-	-	7.380	0.29055		43		8
8720740	-	-	-	7.400	0.29134	44		5/16	
8720750	-	-	-	7.500	0.29528		45		8
660029617	19/64	-	-	7.541	0.29688	46		5/16	
8720760	-	-	-	7.600	0.29921		47		8
8720770	-	-	-	7.700	0.30315	48		5/16	
8720780	-	-	-	7.800	0.30709		49		8
8720790	-	-	-	7.900	0.31102	50		5/16	
660031217	5/16	-	-	7.938	0.31250		51		8
8720800	-	-	-	8.000	0.31496	52		10	
8720810	-	-	-	8.100	0.31890		53		3/8
8720820	-	-	-	8.200	0.32283	54		10	
8720830	-	-	-	8.300	0.32677		55		3/8
660032817	21/64	-	-	8.334	0.32813	56		10	
8720840	-	-	-	8.400	0.33071		57		10
660033217	-	-	Q	8.433	0.33200	58		3/8	
8720850	-	-	-	8.500	0.33465		59		10
8720860	-	-	-	8.600	0.33858	60		3/8	
8720870	-	-	-	8.700	0.34252		61		10
660034317	11/32	-	-	8.731	0.34375	62		3/8	
8720880	-	-	-	8.800	0.34646		63		10
8720890	-	-	-	8.900	0.35039	64		3/8	
8720900	-	-	-	9.000	0.35433		65		10
8720910	-	-	-	9.100	0.35827	66		3/8	
660035917	23/64	-	-	9.128	0.35938		67		10
8720920	-	-	-	9.200	0.36220	68		3/8	
8720925	-	-	-	9.250	0.36417		69		10
8720930	-	-	-	9.300	0.36614	70		3/8	
8720938	-	-	-	9.380	0.36929		71		10
8720940	-	-	-	9.400	0.37008	72		3/8	
8720950	-	-	-	9.500	0.37402		73		10
660037517	3/8	-	-	9.525	0.37500	74		3/8	
8720960	-	-	-	9.600	0.37795		75		10
8720970	-	-	-	9.700	0.38189	76		3/8	
8720980	-	-	-	9.800	0.38583		77		10
8720990	-	-	-	9.900	0.38976	78		3/8	
660039017	25/64	-	-	9.922	0.39063		79		10
8721000	-	-	-	10.000	0.39370	80		3/8	
8721010	-	-	-	10.100	0.39764		81		10
8721020	-	-	-	10.200	0.40157	82		3/8	
8721030	-	-	-	10.300	0.40551		83		10
660040617	13/32	-	-	10.319	0.40625	84		3/8	
8721040	-	-	-	10.400	0.40945		85		10
8721050	-	-	-	10.500	0.41339	86		3/8	
8721060	-	-	-	10.600	0.41732		87		10
8721070	-	-	-	10.700	0.42126	88		3/8	
660042217	27/64	-	-	10.716	0.42188		89		10
8721080	-	-	-	10.800	0.42520	90		3/8	
8721090	-	-	-	10.900	0.42913		91		10
8721100	-	-	-	11.000	0.43307	92		3/8	
8721110	-	-	-	11.100	0.43701		96		120

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

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## List 6600 (Continued)

ADO-TRS-3D, 3 Flute, Coolant-Through

NEW	SPEED FEED P15	CARBIDE	EgiAs		30°	SHANK h6
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EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status					
	Fractional Size	Wire Gage	Letter Size	mm	Inch									
660043717	7/16	-	-	11.113	0.43750	56	120	7/16	●					
8721120	-	-	-	11.200	0.44094	57		12	●					
8721125	-	-	-	11.250	0.44291				●					
8721130	-	-	-	11.300	0.44488	●								
8721138	-	-	-	11.380	0.44803	58			●					
8721140	-	-	-	11.400	0.44882				●					
8721150	-	-	-	11.500	0.45276	59			●					
660045317	29/64	-	-	11.509	0.45313				●					
8721160	-	-	-	11.600	0.45669	60			1/2	●				
8721170	-	-	-	11.700	0.46063				●					
8721180	-	-	-	11.800	0.46457	61			128	12	●			
8721190	-	-	-	11.900	0.46850					●				
660046817	15/32	-	-	11.906	0.46875	62	1/2			●				
8721200	-	-	-	12.000	0.47244		12	●						
8721210	-	-	-	12.100	0.47638	63	14	14		●				
8721220	-	-	-	12.200	0.48031			●						
8721230	-	-	-	12.300	0.48425	64		1/2		▲				
660048417	31/64	-	-	12.303	0.48438					●				
8721240	-	-	-	12.400	0.48819	65				14	▲			
8721250	-	-	-	12.500	0.49213						●			
8721260	-	-	-	12.600	0.49606	66					14	●		
8721270	-	-	-	12.700	0.50000							●		
660050017	1/2	-	-	12.700	0.50000	67			134			1/2	●	
8721280	-	-	-	12.800	0.50394							●		
8721290	-	-	-	12.900	0.50787	68						14	▲	
8721300	-	-	-	13.000	0.51181								●	
8721310	-	-	-	13.100	0.51575	69	16						▲	
8721320	-	-	-	13.200	0.51969								●	
8721325	-	-	-	13.250	0.52165	70		16					●	
8721330	-	-	-	13.300	0.52362								●	
8721338	-	-	-	13.380	0.52677	71				5/8			●	
8721340	-	-	-	13.400	0.52756								●	
660053117	17/32	-	-	13.494	0.53125	72					140		5/8	●
8721350	-	-	-	13.500	0.53150								●	
8721360	-	-	-	13.600	0.53543	73			16				●	
8721370	-	-	-	13.700	0.53937								●	
8721380	-	-	-	13.800	0.54331	74						16	▲	
8721390	-	-	-	13.900	0.54724								●	
8721400	-	-	-	14.000	0.55118	75	16						●	
8721410	-	-	-	14.100	0.55512								●	
8721420	-	-	-	14.200	0.55906	76		5/8					●	
660056217	9/16	-	-	14.288	0.56250								●	
8721430	-	-	-	14.300	0.56299	77				145			5/8	●
8721440	-	-	-	14.400	0.56693								●	
8721450	-	-	-	14.500	0.57087	78					16		▲	
8721460	-	-	-	14.600	0.57480								●	
8721470	-	-	-	14.700	0.57874	79			16				▲	
8721480	-	-	-	14.800	0.58268								●	
8721490	-	-	-	14.900	0.58661	80						16	▲	
8721500	-	-	-	15.000	0.59055								●	
660059317	19/32	-	-	15.081	0.59375	81	16						5/8	●
8721510	-	-	-	15.100	0.59449								●	
8721520	-	-	-	15.200	0.59843	82		16					●	
8721530	-	-	-	15.300	0.60236								●	
8721540	-	-	-	15.400	0.60630	83				16			▲	
8721550	-	-	-	15.500	0.61024								●	
8721560	-	-	-	15.600	0.61417	8					●			

Packed: 1 pc. Available EgiAs Coating Only.

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▶ continued on next page ▶

List No.	Work Material																
	P					M			K	N		S		H			
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels			
	Low	Med.	High											6061	Casting	Inconel	6Al4V (30 HRC)
	1010	1035	1065	4140	4340	300	400	17-4 PH	7075								
6600	○	○	○	○	○		○	○	○			○	○	○			

○ good ○ best

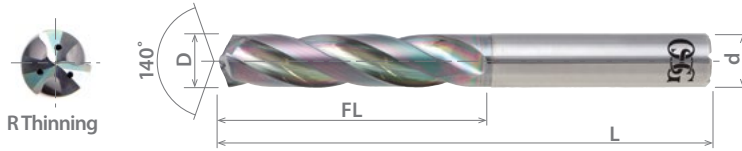


# A Brand ADO-TRS

Advanced Performance High Feed 3-Flute Carbide Drills

## List 6600 (Continued)

ADO-TRS-3D, 3 Flute, Coolant-Through



<b>NEW</b>	<b>SPEED FEED</b> P15	<b>CARBIDE</b>	<b>EgiAs</b>		<b>30°</b>	<b>SHANK</b> h6
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Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8721570	-	-	-	15.700	0.61811	79	145	16	▲
8721580	-	-	-	15.800	0.62205			▲	
660062517	5/8	-	-	15.875	0.62500	80	145	5/8	●
8721590	-	-	-	15.900	0.62598			▲	
8721600	-	-	-	16.000	0.62992	81	150	16	▲
660063317	-	-	-	16.100	0.63386			▲	
8721650	-	-	-	16.500	0.64961	83	18	●	
660065617	21/32	-	-	16.669	0.65625	85	150	3/4	●
660066317	-	-	-	16.840	0.66299			●	
8721700	-	-	-	17.000	0.66929	87	155	18	●
8721725	-	-	-	17.250	0.67913			●	
660068717	11/16	-	-	17.463	0.68750	88	155	3/4	●
8721750	-	-	-	17.500	0.68898			●	
660070317	45/64	-	-	17.859	0.70313	90	160	3/4	●
8721800	-	-	-	18.000	0.70866			●	
660071817	23/32	-	-	18.256	0.71875	92	160	3/4	●
8721850	-	-	-	18.500	0.72835			●	
8721900	-	-	-	19.000	0.74803	95	165	20	●
660075017	3/4	-	-	19.050	0.75000			●	
8721925	-	-	-	19.250	0.75787	97	165	3/4	●
8721950	-	-	-	19.500	0.76772			●	
8722000	-	-	-	20.000	0.78740	100	20	●	

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.



Work Material																		
List No.	P					Die Steels	M			K Cast Iron	N		S		H			
	Carbon Steels			Alloy Steels	Stainless Steels		Aluminum	Nickel Alloy	Titanium		Hardened Steels							
	Low	Med.	High								300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC
6600	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

○ good ○ best



## List 6610

ADO-TRS-5D, 3 Flute, Coolant-Through

**NEW** **SPEED FEED P15** **CARBIDE** **EgiAs** **30°** **SHANK h6**



Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length	Overall Length	Shank Diameter	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8722300	-	-	-	3.000	0.11811	27	78	3	●
661012517	1/8	-	-	3.175	0.12500	29	86	1/8	●
8722330	-	-	-	3.300	0.12992	30		●	
8722350	-	-	-	3.500	0.13780	32		●	
8722366	-	-	-	3.660	0.14409	33		●	
661015617	5/32	-	-	3.969	0.15625	36		5/32	●
8722400	-	-	-	4.000	0.15748	-	4	●	
661016117	-	20	-	4.089	0.16100	-	95	●	
8722410	-	-	-	4.100	0.16142	37		6	●
8722420	-	-	-	4.200	0.16535	38		●	
8722430	-	-	-	4.300	0.16929	39		●	
661017217	11/64	-	-	4.366	0.17188	-		3/16	●
8722440	-	-	-	4.400	0.17323	40		●	
8722450	-	-	-	4.500	0.17717	41		6	●
8722460	-	-	-	4.600	0.18110	42		●	
8722470	-	-	-	4.700	0.18504	43		●	
661018717	3/16	-	-	4.763	0.18750	-		3/16	●
8722480	-	-	-	4.800	0.18898	44	●		
8722490	-	-	-	4.900	0.19291	45	6	●	
8722500	-	-	-	5.000	0.19685	-	●		
8722510	-	-	-	5.100	0.20079	41	●		
661020317	13/64	-	-	5.159	0.20313	-	1/4	●	
8722520	-	-	-	5.200	0.20472	42	●		
8722530	-	-	-	5.300	0.20866	43	●		
8722540	-	-	-	5.400	0.21260	-	6	●	
661021317	-	3	-	5.410	0.21300	44	●		
8722550	-	-	-	5.500	0.21654	-	●		
661021817	7/32	-	-	5.556	0.21875	-	1/4	●	
8722560	-	-	-	5.600	0.22047	45	●		
8722570	-	-	-	5.700	0.22441	46	●		
8722580	-	-	-	5.800	0.22835	47	6	●	
8722590	-	-	-	5.900	0.23228	-	●		
661023417	15/64	-	-	5.953	0.23438	48	1/4	●	
8722600	-	-	-	6.000	0.23622	-	6	●	
8722610	-	-	-	6.100	0.24016	49	●		
8722620	-	-	-	6.200	0.24409	50	8	●	
8722630	-	-	-	6.300	0.24803	51	●		
661025017	1/4	-	E	6.350	0.25000	-	1/4	●	
8722640	-	-	-	6.400	0.25197	52	●		
8722650	-	-	-	6.500	0.25591	-	●		
661025717	-	-	F	6.528	0.25700	-	8	●	
8722660	-	-	-	6.600	0.25984	53	●		
8722670	-	-	-	6.700	0.26378	54	●		
661026517	17/64	-	-	6.747	0.26563	-	5/16	●	
8722680	-	-	-	6.800	0.26772	55	●		
8722690	-	-	-	6.900	0.27165	-	●		
8722700	-	-	-	7.000	0.27559	56	8	●	
8722710	-	-	-	7.100	0.27953	57	●		
661028117	9/32	-	-	7.144	0.28125	-	5/16	●	
8722720	-	-	-	7.200	0.28346	58	●		
8722730	-	-	-	7.300	0.28740	59	8	●	

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.



List No.	Work Material																
	P					M			K	N		S		H			
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels			
6610	1010	1035	High	4140	300	400	17-4 PH	Cast Iron	6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
	1018	1045	1065	4340					7075								
6610	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

○ good ○ best

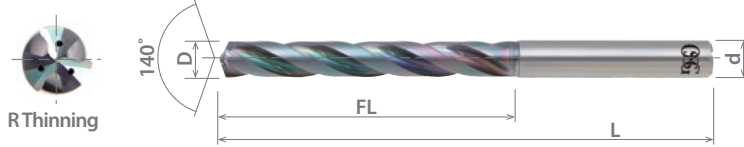


# A Brand ADO-TRS

Advanced Performance High Feed 3-Flute Carbide Drills

## List 6610

ADO-TRS-5D, 3 Flute, Coolant-Through



<b>NEW</b>	<b>SPEED FEED</b> P15	<b>CARBIDE</b>	<b>EgiAs</b>		<b>30°</b>	<b>SHANK</b> h6
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Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8722738	-	-	-	7.380	0.29055	60	118	8	●
8722740	-	-	-	7.400	0.29134				
8722750	-	-	-	7.500	0.29528				
661029617	19/64	-	-	7.541	0.29688				
8722760	-	-	-	7.600	0.29921				
8722770	-	-	-	7.700	0.30315				
8722780	-	-	-	7.800	0.30709				
8722790	-	-	-	7.900	0.31102				
661031217	5/16	-	-	7.938	0.31250				
8722800	-	-	-	8.000	0.31496				
8722810	-	-	-	8.100	0.31890				
8722820	-	-	-	8.200	0.32283				
8722830	-	-	-	8.300	0.32677				
661032817	21/64	-	-	8.334	0.32813				
8722840	-	-	-	8.400	0.33071				
661033217	-	-	Q	8.433	0.33200				
8722850	-	-	-	8.500	0.33465				
8722860	-	-	-	8.600	0.33858				
8722870	-	-	-	8.700	0.34252				
661034317	11/32	-	-	8.731	0.34375				
8722880	-	-	-	8.800	0.34646				
8722890	-	-	-	8.900	0.35039				
8722900	-	-	-	9.000	0.35433				
8722910	-	-	-	9.100	0.35827				
661035917	23/64	-	-	9.128	0.35938				
8722920	-	-	-	9.200	0.36220				
8722925	-	-	-	9.250	0.36417				
8722930	-	-	-	9.300	0.36614				
8722938	-	-	-	9.380	0.36929				
8722940	-	-	-	9.400	0.37008				
8722950	-	-	-	9.500	0.37402				
661037517	3/8	-	-	9.525	0.37500				
8722960	-	-	-	9.600	0.37795				
8722970	-	-	-	9.700	0.38189				
8722980	-	-	-	9.800	0.38583				
8722990	-	-	-	9.900	0.38976				
661039017	25/64	-	-	9.922	0.39063				
8723000	-	-	-	10.000	0.39370				
8723010	-	-	-	10.100	0.39764				
8723020	-	-	-	10.200	0.40157				
8723030	-	-	-	10.300	0.40551				
661040617	13/32	-	-	10.319	0.40625				
8723040	-	-	-	10.400	0.40945				
8723050	-	-	-	10.500	0.41339				
8723060	-	-	-	10.600	0.41732				
8723070	-	-	-	10.700	0.42126				
661042217	27/64	-	-	10.716	0.42188				
8723080	-	-	-	10.800	0.42520				
8723090	-	-	-	10.900	0.42913				
8723100	-	-	-	11.000	0.43307				
8723110	-	-	-	11.100	0.43701				
661043717	7/16	-	-	11.113	0.43750				
8723120	-	-	-	11.200	0.44094				
8723125	-	-	-	11.250	0.44291				
8723130	-	-	-	11.300	0.44488				
8723138	-	-	-	11.380	0.44803				
8723140	-	-	-	11.400	0.44882				
8723150	-	-	-	11.500	0.45276				
661045317	29/64	-	-	11.509	0.45313				
8723160	-	-	-	11.600	0.45669				
8723170	-	-	-	11.700	0.46063				

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.



## List 6610 (Continued)

ADO-TRS-5D, 3 Flute, Coolant-Through



EDP Number	Diameter					Flute Length	Overall Length	Shank Diameter	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8723180	-	-	-	11.800	0.46457	95	156	12	●
8723190	-	-	-	11.900	0.46850	96		1/2	●
661046817	15/32	-	-	11.906	0.46875			12	●
8723200	-	-	-	12.000	0.47244	97	167	14	▲
8723210	-	-	-	12.100	0.47638	98		14	●
8723220	-	-	-	12.200	0.48031	99		1/2	▲
8723230	-	-	-	12.300	0.48425	100	176	14	●
661048417	31/64	-	-	12.303	0.48438	101		14	▲
8723240	-	-	-	12.400	0.48819	102		1/2	●
8723250	-	-	-	12.500	0.49213	103	185	16	●
8723260	-	-	-	12.600	0.49606	104		16	▲
8723270	-	-	-	12.700	0.50000	105		16	●
661050017	1/2	-	-	12.700	0.50000	106	193	16	▲
8723280	-	-	-	12.800	0.50394	107		16	●
8723290	-	-	-	12.900	0.50787	108		5/8	●
8723300	-	-	-	13.000	0.51181	109	201	18	●
8723310	-	-	-	13.100	0.51575	110		18	●
8723320	-	-	-	13.200	0.51969	111		3/4	●
8723325	-	-	-	13.250	0.52165	112	18	18	●
8723330	-	-	-	13.300	0.52362	113		18	●
8723338	-	-	-	13.380	0.52677	114		18	●
8723340	-	-	-	13.400	0.52756	115	193	16	▲
661053117	17/32	-	-	13.494	0.53125	116		16	●
8723350	-	-	-	13.500	0.53150	117		5/8	●
8723360	-	-	-	13.600	0.53543	118	201	18	●
8723370	-	-	-	13.700	0.53937	119		18	●
8723380	-	-	-	13.800	0.54331	120		18	●
8723390	-	-	-	13.900	0.54724	121	193	16	▲
8723400	-	-	-	14.000	0.55118	122		16	●
8723410	-	-	-	14.100	0.55512	123		16	●
8723420	-	-	-	14.200	0.55906	124	185	16	▲
661056217	9/16	-	-	14.288	0.56250	125		16	●
8723430	-	-	-	14.300	0.56299	126		5/8	●
8723440	-	-	-	14.400	0.56693	127	201	18	●
8723450	-	-	-	14.500	0.57087	128		18	●
8723460	-	-	-	14.600	0.57480	129		18	●
8723470	-	-	-	14.700	0.57874	130	193	16	▲
8723480	-	-	-	14.800	0.58268	131		16	●
8723490	-	-	-	14.900	0.58661	132		16	●
8723500	-	-	-	15.000	0.59055	133	185	16	▲
661059317	19/32	-	-	15.081	0.59375	134		16	●
8723510	-	-	-	15.100	0.59449	135		5/8	●
8723520	-	-	-	15.200	0.59843	136	201	18	●
8723530	-	-	-	15.300	0.60236	137		18	●
8723540	-	-	-	15.400	0.60630	138		18	●
8723550	-	-	-	15.500	0.61024	139	193	16	▲
8723560	-	-	-	15.600	0.61417	140		16	●
8723570	-	-	-	15.700	0.61811	141		16	●
8723580	-	-	-	15.800	0.62205	142	185	16	▲
661062517	5/8	-	-	15.875	0.62500	143		16	●
8723590	-	-	-	15.900	0.62598	144		5/8	●
8723600	-	-	-	16.000	0.62992	145	201	18	●
661063317	-	-	-	16.100	0.63386	146		18	●
8723650	-	-	-	16.500	0.64961	147		18	●
661065617	21/32	-	-	16.669	0.65625	148	193	16	▲
661066317	-	-	-	16.840	0.66299	149		16	●
8723700	-	-	-	17.000	0.66929	150		18	●

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.



List No.	Work Material																
	P					M			K	N		S		H			
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels			
	Low	Med.	High				300	400		17-4 PH				6061	Casting	Inconel	6Al4V (30 HRC)
6610	○	○	○	○		○	○	○		○		○	○	○	○	○	

○ good ○ best

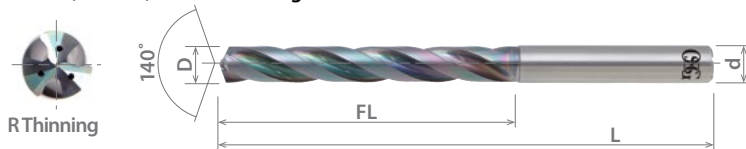


# A Brand ADO-TRS

Advanced Performance High Feed 3-Flute Carbide Drills

## List 6610 (Continued)

ADO-TRS-5D, 3 Flute, Coolant-Through



<b>NEW</b>	<b>SPEED FEED</b> P15	<b>CARBIDE</b>	<b>EgiAs</b>		<b>30°</b>	<b>SHANK</b> h6
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Cutting Diameter Tolerance (h8)		
Size	mm	inch
4 ≤ D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 18	+0 / -0.027	+0 / -0.0011
18 < D ≤ 20	+0 / -0.033	+0 / -0.0013

EDP Number	Diameter					Flute Length FL	Overall Length L	Shank Diameter d	Status
	Fractional Size	Wire Gage	Letter Size	mm	Inch				
8723725	-	-	-	17.250	0.67913	138	209	18	●
661068717	11/16	-	-	17.463	0.68750	140		3/4	●
8723750	-	-	-	17.500	0.68898	143		18	●
661070317	45/64	-	-	17.859	0.70313	144	217	3/4	●
8723800	-	-	-	18.000	0.70866	147		18	●
661071817	23/32	-	-	18.256	0.71875	148		3/4	●
8723850	-	-	-	18.500	0.72835	152	225	20	●
8723900	-	-	-	19.000	0.74803	154		3/4	●
661075017	3/4	-	-	19.050	0.75000	156		20	●
8723925	-	-	-	19.250	0.75787	160		●	
8723950	-	-	-	19.500	0.76772			●	
8724000	-	-	-	20.000	0.78740			●	

Packed: 1 pc. Available EgiAs Coating Only.

● Stocked ○ Available Upon Request ▲ Japan Stocked

Stock and availability vary - Please go to [osgtool.com](http://osgtool.com) or contact customer service to confirm availability.



Work Material																		
List No.	P					Die Steels	M			K Cast Iron	N		S		H			
	Carbon Steels			Alloy Steels	Stainless Steels		Aluminum	Nickel Alloy	Titanium		Hardened Steels							
	Low	Med.	High								300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC
6610	○	○	○	○	○		○	○	○		○	○	○	○	○	○	○	○

○ good ○ best



## List 6600 - A Brand ADO-TRS: 3D

## List 6610 - A Brand ADO-TRS: 5D

### General Drilling Operations

Work Material		Carbon Steels, Mild Steels 1010, 1050, 12L14		Alloy Steels 4140, 4130		Stainless Steels 400SS, 17-4PH		Cast Iron		Ductile Cast Iron	
Drilling Speed		260-395 SFM		260-395 SFM		130-200 SFM		260-395 SFM		195-330 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch										
3	-	10,700	0.004 - 0.006	10,700	0.004 - 0.006	5,200	0.004 - 0.006	10,700	0.004 - 0.007	8,400	0.004 - 0.006
-	1/8	10,100	0.004 - 0.006	10,100	0.004 - 0.006	4,900	0.004 - 0.006	10,100	0.004 - 0.007	7,900	0.004 - 0.006
4	-	7,900	0.005 - 0.009	7,900	0.005 - 0.009	4,000	0.005 - 0.007	7,900	0.005 - 0.009	6,350	0.005 - 0.009
-	3/16	6,700	0.007 - 0.010	6,700	0.007 - 0.010	3,300	0.007 - 0.009	6,700	0.007 - 0.011	5,300	0.007 - 0.010
6	-	5,300	0.007 - 0.013	5,300	0.007 - 0.013	2,650	0.007 - 0.009	5,300	0.008 - 0.014	4,250	0.007 - 0.013
-	1/4	5,000	0.007 - 0.014	5,000	0.007 - 0.014	2,500	0.007 - 0.010	5,000	0.009 - 0.015	4,000	0.007 - 0.014
8	-	3,950	0.009 - 0.017	3,950	0.009 - 0.017	2,000	0.009 - 0.013	3,950	0.011 - 0.019	3,200	0.009 - 0.017
-	3/8	3,300	0.012 - 0.021	3,300	0.012 - 0.021	1,700	0.011 - 0.015	3,300	0.013 - 0.023	2,650	0.012 - 0.021
10	-	3,150	0.012 - 0.022	3,150	0.012 - 0.022	1,600	0.012 - 0.016	3,150	0.014 - 0.024	2,550	0.012 - 0.022
-	7/16	2,850	0.013 - 0.023	2,850	0.013 - 0.023	1,450	0.013 - 0.017	2,850	0.015 - 0.026	2,300	0.013 - 0.023
12	-	2,650	0.014 - 0.024	2,650	0.014 - 0.024	1,350	0.014 - 0.019	2,650	0.017 - 0.028	2,100	0.014 - 0.024
-	1/2	2,500	0.015 - 0.025	2,500	0.015 - 0.025	1,250	0.015 - 0.020	2,500	0.018 - 0.028	2,000	0.015 - 0.025
14	-	2,250	0.017 - 0.028	2,250	0.017 - 0.028	1,150	0.017 - 0.022	2,250	0.019 - 0.030	1,800	0.017 - 0.028
-	5/8	2,000	0.019 - 0.031	2,000	0.019 - 0.031	1,000	0.019 - 0.025	2,000	0.022 - 0.034	1,600	0.019 - 0.031
16	-	2,000	0.019 - 0.031	2,000	0.019 - 0.031	1,000	0.019 - 0.025	2,000	0.022 - 0.034	1,600	0.019 - 0.031
18	-	1,750	0.021 - 0.032	1,750	0.021 - 0.032	900	0.021 - 0.028	1,750	0.025 - 0.035	1,400	0.021 - 0.032
-	3/4	1,650	0.023 - 0.034	1,650	0.023 - 0.034	850	0.023 - 0.030	1,650	0.026 - 0.037	1,300	0.023 - 0.034
20	-	1,600	0.024 - 0.035	1,600	0.024 - 0.035	800	0.024 - 0.031	1,600	0.028 - 0.039	1,250	0.024 - 0.035

### General Drilling Operations

Work Material		Cast Aluminum		Special Alloy Steels, Hardened Steels					
Hardness				26-30 HRC		30-34 HRC		34-43 HRC	
Drilling Speed		260-660 SFM		195-295 SFM		160-230 SFM		130-160 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch								
3	-	14,900	0.004 - 0.009	7,900	0.004 - 0.006	6,500	0.004 - 0.006	4,700	0.004 - 0.005
-	1/8	14,100	0.005 - 0.009	7,500	0.004 - 0.006	6,100	0.004 - 0.006	4,400	0.004 - 0.005
4	-	11,150	0.006 - 0.012	5,590	0.005 - 0.008	4,750	0.005 - 0.008	3,500	0.005 - 0.007
-	3/16	9,400	0.007 - 0.014	5,000	0.006 - 0.009	4,100	0.006 - 0.009	3,000	0.006 - 0.008
6	-	7,450	0.009 - 0.019	3,950	0.007 - 0.012	3,150	0.007 - 0.012	2,350	0.007 - 0.009
-	1/4	7,000	0.010 - 0.020	3,750	0.007 - 0.012	3,000	0.007 - 0.012	2,200	0.007 - 0.010
8	-	5,600	0.013 - 0.025	2,950	0.009 - 0.016	2,350	0.009 - 0.016	1,750	0.009 - 0.013
-	3/8	4,700	0.015 - 0.030	2,500	0.011 - 0.019	2,000	0.011 - 0.019	1,450	0.011 - 0.015
10	-	4,450	0.016 - 0.031	2,400	0.012 - 0.020	1,900	0.012 - 0.020	1,400	0.012 - 0.016
-	7/16	4,000	0.017 - 0.035	2,150	0.013 - 0.022	1,700	0.013 - 0.022	1,250	0.013 - 0.017
12	-	3,700	0.019 - 0.038	2,000	0.014 - 0.024	1,550	0.014 - 0.024	1,150	0.014 - 0.019
-	1/2	3,500	0.020 - 0.040	1,850	0.015 - 0.024	1,500	0.015 - 0.024	1,100	0.015 - 0.020
14	-	3,200	0.022 - 0.044	1,700	0.017 - 0.025	1,350	0.017 - 0.025	1,000	0.017 - 0.022
-	5/8	2,800	0.025 - 0.050	1,500	0.019 - 0.025	1,200	0.019 - 0.025	900	0.019 - 0.025
16	-	2,800	0.025 - 0.050	1,500	0.019 - 0.025	1,200	0.019 - 0.025	900	0.019 - 0.025
18	-	2,500	0.028 - 0.057	1,300	0.021 - 0.028	1,050	0.021 - 0.028	800	0.021 - 0.028
-	3/4	2,350	0.030 - 0.060	1,250	0.023 - 0.030	1,000	0.023 - 0.030	750	0.023 - 0.030
20	-	2,250	0.031 - 0.063	1,200	0.024 - 0.031	950	0.024 - 0.031	700	0.024 - 0.031





*shaping your dreams*

 **Safe use of cutting tools**

- Use safety cover, safety glasses and safety shoes during operation.
- Do not touch cutting edges with bare hands.
- Do not touch cutting chips with bare hands. Chips will be hot after cutting.
- Stop cutting when the tool becomes dull.
- Stop cutting operation immediately if you hear any abnormal cutting sounds.
- Do not modify tools.
- Please use appropriate tools for the operation. Check dimensions to ensure proper selection.

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