



Trepanning Tools

- Cutter size in mm determines the type of toolholder to be used.

Hole Type A

Cobalt Cutters

Type A	Cutter Size	Cutting Depth	Part Number	Price Each
10	5mm	3/8"	80-101-9	\$21.30
15	5mm	1/2"	80-102-7	22.60
15	6mm	1/2"	80-104-3	27.00
25	6mm	3/4"	80-105-0	28.20
35	6mm	1"	80-106-8	31.10
40	8mm	1"	80-108-4	38.50
50	8mm	1 3/4"	80-109-2	43.10

For Sheet Metal .020" - .080" Thickness

10V	5mm		80-113-4	\$21.80
-----	-----	--	-----------------	---------

For Plexiglass & Synthetic Materials

10P	5mm	3/8"	80-116-7	\$21.80
-----	-----	------	-----------------	---------

Carbide Cutters

10H	5mm	3/8"	80-117-5	\$35.20
10T*	5mm	3/8"	80-118-3*	43.25

For Plexiglass, Synthetic Materials & Brass

10PH	5mm	3/8"	80-119-1	\$33.40
10PT*	5mm	3/8"	80-120-9*	42.00

*Titanium coated.

Disc Type I

Cobalt Cutters

Type I	Cutter Size	Cutting Depth	Part Number	Price Each
10	5mm	3/8"	80-121-7	\$20.30
15	6mm	1/2"	80-123-3	25.40
25	6mm	3/4"	80-124-1	26.40
35	6mm	1"	80-125-8	28.70
40	8mm	1"	80-127-4	38.00
50	8mm	1 3/4"	80-128-2	42.10

Carbide Cutters

10H	5mm	3/8"	80-129-0	\$32.80
10T*	5mm	3/8"	80-130-8*	41.30

For Plexiglass, Synthetic Materials & Brass

10PH	5mm	3/8"	80-131-6	\$32.30
10PT*	5mm	3/8"	80-132-4*	40.25

*Titanium coated.



Trepanning Tools

Economy Version

- The proven "Drag-Cut" trepanning method for efficient use in BRIDGEPORT mills, drill presses, etc. is now available in a cost saving square shank toolholder and cutter design.
- Amazing cutting performance in all types of materials.
- The cutter is drawn behind center at a specific angle and performs without any vibration and without hooking.
- The geometry of the patented cutter produces a chip which is smaller than the width of the groove to be cut.
- Clean bores up to 5/8" dia. are cut with hole type A cutters and clean discs are produced with type I cutters.
- Cobalt cutters for general trepanning applications, TiN coated cutters for hard to machine, exotic materials.
- Fast and easy set-ups for prototype work or production runs.
- Shank features 3 flats for positive holding and driving in 1/2" capacity drill chucks.
- Furnished complete with 1 hole type Cobalt cutter A **80-150-6**, center drill, rule for easy diameter setting and allen wrench.

Shank	Capacity	Cutter Size	Cutting Depth	Part Number	Price Each
1/2"	3/4" - 3"	5mm	3/8"	80-140-7	\$150.00

Optional:

Toolholder for 5/2" dia. capacity	80-145-6	\$56.20
-----------------------------------	-----------------	---------

Cutters

Type	Cutter Size	Cutting Depth	Part Number	Price Each
Hole A, Cobalt	5mm	3/8"	80-150-6	\$18.00
Hole A, TiN coated	5mm	3/8"	80-152-2	26.40
Disc I, Cobalt	5mm	3/8"	80-154-8	18.00
Disc I, TiN coated	5mm	3/8"	80-156-3	25.90

Accessories

Description	Part No.	Price
Center Drill	80-033-4	\$13.90
Center Guide	80-035-9	14.90
Ejector Spring	80-036-7	9.75

Feeds & Speeds for Val-Cut Trepanning Tools

Cutting Diameter	Mild Steel	Alloy Tool Steel	Stainless Steel	Hi-Nickel Alloys	Aluminum	Plastic
	95 fpm	70 fpm	60 fpm	20 fpm	120 fpm	120 fpm
	RPM	RPM	RPM	RPM	RPM	RPM
2"	180	133	115	40	230	230
3"	120	90	76	25	150	150
4"	90	67	57	19	115	115
5"	72	53	46	16	92	92
6"	60	45	38	13	78	78
7"	52	38	33	11	65	65
8"	45	33	29	10	58	58
9"	40	30	25	9	51	51
10"	36	26	23	8	46	46
12"	30	22	19	6.5	38	38
15"	25	18	16	5.5	30	30
20"	18	14	12	5	23	23

Feed Rate Depends on the Cutter size

Cutter Size	ipr
5mm	0.0012
6mm	0.0016
8mm	0.002