Link Industries

CUTTING TOOL CATALOG

(800) 626-9460 | www.linkcuttingtools.com

Link Industries

Proud To Say American Made And Family Owned For Over 80 Years

Focusing on Centerdrills, Countersinks, Counterbores and Custom Made-to-order Tools, LINK is dedicated to producing the finest precision High-Speed Steel and Carbide cutting tools available. As part of an Engineering focused company, LINK has the technical capability to provide each customer with the best tooling solution for their application.

A brief outline of Link Industries' history:

1935 – Herbert Link established the Link Engineering Company in Detroit, Michigan.

1948 – Link Industries developed a unique design and process to manufacture HSS Centerdrills.

1952 – Company relocated its cutting tool manufacturing operations to Indian River, MI.

1968 – 1st building expansion for more manufacturing and office space.

1985 – 2nd building expansion; including dedicated Quality and Inventory areas.

2001 – ISO 9001:2008 Certification achieved.

2014 – Laser marking introduced; LEAN Manufacturing begins implementation.

2015 – 1st 5-Axis CNC machine purchased; new tool packaging/labels launched.

2016 – 2nd 5-Axis CNC machine purchased; new Cutting Tool Catalog released.

2017 – Patent Pending Cross-LINK Drills introduced; new Optical Cutting Tool inspection system purchased.

For additional information: www.linkcuttingtools.com

ISO 9001 CERTIFIED

Table of Contents

Centerdrills . . . 3
- Centerdrill ST Type . . . 4
- Centerdrill R Type Radial . . . 5
- Centerdrill S Type Bell . . . 6
- Centerdrill B Type Bell . . . 7
- Centerdrill ST Type 60° (Metric) . . . 8
- Centerdrill 90° And 100° Type . . . 8
- Hey Centerdrills ST Type . . . 9
- Hey Centerdrills R Type . . . 9
- Hey Centerdrills B Type . . . 10
- Single-End Thru-Tool Cooling (TTC) Drill . . . 10
- Carbide Centerdrills 60°/82°/90° . . . 11
- Carbide Centerdrill B Type . . . 11

Spotting Drills . . . 12
- Spot and Centering Drill . . . 12
- Cobalt Spot and Centering Drill Extended Length – 82°/ 90°/ 120° . . . 12
- Carbide NC Spot Drills – 90°/120°/142° . . . 12

Counterbores & Countersinks . . . 13
- English Drill and Counterbores . . . 14
- 3XD English Drill and Counterbores . . . 14
- Metric Drill and Counterbores . . . 15
- Extended Length Three Flute Counterbore (English) 15
- Extended Length Three Flute Counterbore (Metric) . 15
- Countersink Straight Shanks (English) . . . 16
- Countersink Straight Shanks (Metric) . . . 16
- Cross-LINK 82° Countersinks . . . 17
- Single Flute Chamfer . . . 17
- Three Flute Center Reamer . . . 17
- Six Flute Countersink . . . 18
- No Flute Countersink and Deburrs . . . 18
- Carbide Four Flute Performance Chamfers – 60°/82°/90° . . . 18

Unidapt System . . . 19
- Unidapt System Centerdrill ST Type 60° Insert . . . 21
- Unidapt System Centerdrill R Type Insert . . . 21
- Unidapt System Centerdrill S Type 60°/82° Bell Insert . . . 21
- Unidapt System Centerdrill B Type 60°/120° Bell Insert . . . 22
- Unidapt System Centerdrill 90° and 100° Insert . . . 22
- Unidapt System Counterbore (English) . . . 23
- Unidapt System Counterbore (Metric) . . . 23
- Unidapt System Countersink (English) . . . 23
- Unidapt System Countersink (Metric) . . . 24
- Unidapt System Spotting Drill . . . 24
- Unidapt System Morse Taper Adapter . . . 25
- Unidapt Tool Holder Adapter . . . 26
- Unidapt Tool Holder Extension Adapter . . . 27

Tool Sets . . . 28
- Unidapt Adapter Set . . . 29
- Counterbore Set (English or Metric) . . . 29
- Countersink Set (English or Metric) . . . 29
- Single Flute Chamfer Set . . . 30
- Three Flute Center Reamer Set . . . 30
- Centerdrill Starter Set . . . 30
- Tap Wrench . . . 30
- No Flute Countersink and Deburrs Set . . . 31
- Six Flute Countersink Set . . . 31
- Spot and Centering Drill Set . . . 31
- Three Flute Spot Weld Drills . . . 31

Technical Services . . . 32

Engineered Solution Examples . . . 32
- Special Tool Forms . . . 32
- Combination Drill and Spot Face Tools . . . 32
- Step Drills . . . 33
- Center Drills with Thru-Tool Cooling . . . 33
- Double End Carbide Special . . . 33
- Application Driven Solutions . . . 33
- Blanket Order Options . . . 33

Tool Coatings . . . 34
- TIN (Titanium Nitride) . . . 34
- TIALN (Titanium Aluminum Nitride) . . . 34
- ALCRN (Aluminum Chromium Nitride) . . . 34
- ALU (Aluminum) . . . 34
- TA-C (Hard Carbon) . . . 34

Technical Information . . . 35
- Speeds and Feeds are suggested starting points . . . 35

Distributor Friendly Packaging . . . 36

Get In Touch With Our Team . . . 36

LINK

DS 30

Accu-Tool

INDIAN RIDER

Ebbco inc

Centerdrills

Centerdrills are used for centering parts to be turned between centers. Link Industries offers a variety of different types of centerdrills, material options and coatings to handle all of your applications.

CENTERDRILL ST TYPE 4

CENTERDRILL R TYPE RADIAL 5

CENTERDRILL S TYPE BELL 6

CENTERDRILL B TYPE BELL 7

CENTERDRILL METRIC ST TYPE 8

CENTERDRILL 90° AND 100° TYPE 8

HEY CENTERDRILLS ST/B/R 9

SINGLE-END THRU-TOOL COOLING (TTC) DRILL 10

CARBIDE CENTERDRILLS 60°/82°/90° 11

CARBIDE CENTERDRILL B TYPE 11

Many tools are available with additional coatings. Please call for a quote! 1-800-626-9460

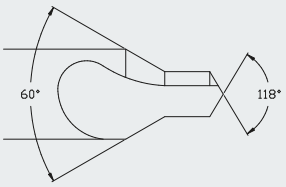
Link Industries reserves the right to make changes, alterations, and substitutions to the products, services, or other information presented without prior notice. For the latest information contact Link Industries.

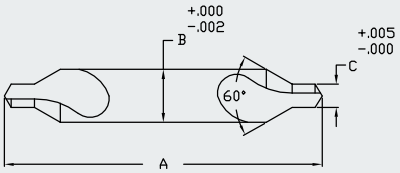
Equipment pictured may be shown with safety equipment removed or disabled for purposes of illustration. Equipment must never be operated with safety equipment removed or disabled.

CENTERDRILLS

Centerdrill ST Type

The ST Type Centerdrill is our standard drill featuring a 60° angle design. This drill is ideal for centering parts to be turned between centers.





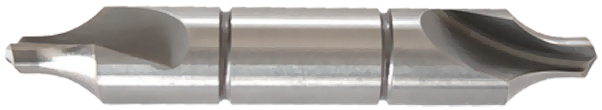
Drill Type	Part No.								OAL (A)	Body DIA (B)	Drill DIA (C)
	HSS	HSS-TiN	HSS-TiAlN	HSS-LH	COBALT	COBALT-TiN	COBALT-TiAlN	T15			
00ST	20-L2-090	-	-	-	-	-	-	-	1-1/4	1/8	.025
0ST	20-L2-091	-	-	11-L2-091	20-CO-091	-	-	-			1/32
1ST	20-L2-092	-	-	11-L2-092	20-CO-092	-	-	-			3/64
1ST3	20-L2-113	-	-	11-L2-113	20-CO-113	-	-	-	3		
1ST4	20-L2-114	-	-	11-L2-114	20-CO-114	-	-	-	4		
1ST5	20-L2-115	-	-	11-L2-115	20-CO-115	-	-	-	5•		
1ST6	20-L2-116	-	-	-	20-CO-116	-	-	-	6•		
2ST	20-L2-093	20-TN-093	20-TL-093	11-L2-093	20-CO-093	CO-TN-093	CO-TL-093	-	1-7/8	3/16	5/64
2ST4	20-L2-117	-	-	11-L2-117	20-CO-117	-	-	-	4		
2ST5	20-L2-118	-	-	11-L2-118	20-CO-118	-	-	-	5•		
2ST6	20-L2-119	-	-	-	20-CO-119	-	-	-	6•		
3ST	20-L2-094	20-TN-094	20-TL-094	11-L2-094	20-CO-094	CO-TN-094	CO-TL-094	20-T5-094	2	1/4	7/64
3ST4	20-L2-120	-	-	11-L2-120	20-CO-120	-	-	-	4		
3ST5	20-L2-121	-	-	11-L2-121	20-CO-121	-	-	-	5•		
3ST6	20-L2-122	-	-	11-L2-122	20-CO-122	-	-	-	6•		
4ST	20-L2-095	20-TN-095	20-TL-095	11-L2-095	20-CO-095	CO-TN-095	CO-TL-095	20-T5-095	2-1/8	5/16	1/8
4ST4	20-L2-123	-	-	11-L2-123	20-CO-123	-	-	20-T5-123	4		
4ST5	20-L2-124	-	-	11-L2-124	20-CO-124	-	-	-	5•		
4ST6	20-L2-125	-	-	11-L2-125	20-CO-125	-	-	-	6•		
45ST	20-L2-049	-	-	-	-	-	-	-	2-1/2	3/8	9/64
45ST4	20-L2-126	-	-	11-L2-126	-	-	-	-	4		
45ST5	20-L2-127	-	-	11-L2-127	-	-	-	-	5•		
45ST6	20-L2-128	-	-	11-L2-128	-	-	-	-	6•		
5ST	20-L2-096	20-TN-096	20-TL-096	11-L2-096	20-CO-096	CO-TN-096	CO-TL-096	20-T5-096	2-3/4	7/16	3/16
5ST5	20-L2-129	-	-	11-L2-129	-	-	-	-	5•		
5ST6	20-L2-130	-	-	11-L2-130	20-CO-130	-	-	-	6•		
6ST	20-L2-097	20-TN-097	20-TL-097	11-L2-097	20-CO-097	CO-TN-097	CO-TL-097	20-T5-097	3	1/2	7/32
6ST5	20-L2-131	-	-	11-L2-131	-	-	-	-	5•		
6ST6	20-L2-132	-	-	11-L2-132	20-CO-132	-	-	-	6•		
7ST	20-L2-098	20-TN-098	20-TL-098	11-L2-098	20-CO-098	CO-TN-098	CO-TL-098	20-T5-098	3-1/4	5/8	1/4
7ST6	20-L2-133	-	-	11-L2-133	-	-	-	-	6•		
8ST	20-L2-099	20-TN-099	20-TL-099	11-L2-099	20-CO-099	CO-TN-099	CO-TL-099	20-T5-099	3-1/2	3/4	5/16
8ST6	20-L2-134	-	-	11-L2-134	-	-	-	-	6•		
9ST	20-L2-136	-	-	-	-	-	-	-	3-5/8	7/8	11/32
10ST	20-L2-135	-	-	-	-	-	-	-	3-3/4	1	3/8

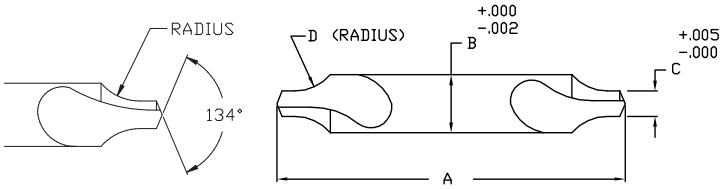
•• Extended Length

CENTERDRILLS

Centerdrill R Type Radial

The R type Centerdrill is a combined drill and countersink, used where the most precise centering accuracy is required. The tip form features a curved contour to enable a single band of contact. This radial tip distributes forces evenly during drilling.





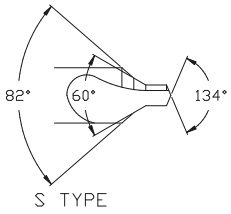
Drill Type	Part No. HSS	HSS-TiN	HSS-TiAlN	HSS-LH	COBALT	COBALT-TiN	COBALT-TiAlN	OAL (A)	Body DIA (B)	Drill DIA (C)	Radius (D)
00R	10-L2-000	-	-	-	-	-	-	1-1/4	1/8	.025	.1175
0R	10-L2-001	-	-	11-L2-001	10-CO-001	-	-			1/32	.1358
1R	10-L2-002	-	-	11-L2-002	10-CO-002	-	-			3/64	.136
1R3	10-L2-023	-	-	11-L2-023	-	-	-	3			
1R4	10-L2-024	-	-	11-L2-024	-	-	-	4			
1R5	10-L2-025	-	-	11-L2-025	-	-	-	5•			
1R6	10-L2-026	-	-	-	-	-	-	6•			
2R	10-L2-003	10-TN-003	10-TL-003	11-L2-003	10-CO-003	CO-TN-003	CO-TL-003	1-7/8	3/16	5/64	.221
2R4	10-L2-027	-	-	11-L2-027	-	-	-	4			
2R5	10-L2-028	-	-	11-L2-028	-	-	-	5•			
2R6	10-L2-029	-	-	-	-	-	-	6•			
3R	10-L2-004	10-TN-004	10-TL-004	11-L2-004	10-CO-004	CO-TN-004	CO-TL-004	2	1/4	7/64	.207
3R4	10-L2-030	-	-	11-L2-030	-	-	-	4			
3R5	10-L2-031	-	-	11-L2-031	-	-	-	5•			
3R6	10-L2-032	-	-	11-L2-032	-	-	-	6•			
4R	10-L2-005	10-TN-005	10-TL-005	11-L2-005	10-CO-005	CO-TN-005	CO-TL-005	2-1/8	5/16	1/8	.248
4R4	10-L2-033	-	-	11-L2-033	-	-	-	4			
4R5	10-L2-034	-	-	11-L2-034	-	-	-	5•			
4R6	10-L2-035	-	-	11-L2-035	-	-	-	6•			
45R	10-L2-049	-	-	-	-	-	-	2-1/2	3/8	9/64	.279
45R4	10-L2-036	-	-	11-L2-036	-	-	-	4			
45R5	10-L2-037	-	-	11-L2-037	-	-	-	5•			
45R6	10-L2-038	-	-	11-L2-038	-	-	-	6•			
5R	10-L2-006	10-TN-006	10-TL-006	11-L2-006	10-CO-006	CO-TN-006	CO-TL-006	2-3/4	7/16	3/16	.323
5R5	10-L2-039	-	-	11-L2-039	-	-	-	5•			
5R6	10-L2-040	-	-	11-L2-040	-	-	-	6•			
6R	10-L2-007	10-TN-007	10-TL-007	11-L2-007	10-CO-007	CO-TN-007	CO-TL-007	3	1/2	7/32	.407
6R5	10-L2-041	-	-	11-L2-041	-	-	-	5•			
6R6	10-L2-042	-	-	11-L2-042	-	-	-	6•			
7R	10-L2-008	10-TN-008	10-TL-008	11-L2-008	10-CO-008	CO-TN-008	CO-TL-008	3-1/4	5/8	1/4	.593
7R6	10-L2-043	-	-	11-L2-043	-	-	-	6•			
8R	10-L2-009	10-TN-009	10-TL-009	11-L2-009	10-CO-009	CO-TN-009	CO-TL-009	3-1/2	3/4	5/16	.663
8R6	10-L2-044	-	-	11-L2-044	-	-	-	6•			

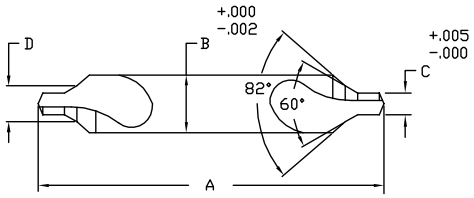
• • Extended Length

CENTERDRILLS

Centerdrill S Type Bell

The S Type Centerdrill is a dual-purpose drill used for the heaviest duty burnishing and chamfering applications where a more rigid setup is required. This drill has a 60° angle design, followed by an 82° angle flare making it a dual-purpose tool.





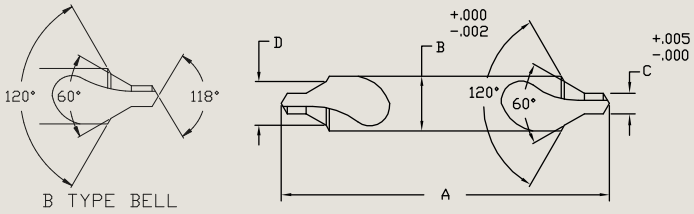
Drill Type	Part No.							OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)
	HSS	HSS-TiN	HSS-TiAlN	HSS-LH	COBALT	COBALT-TiN	COBALT-TiAlN				
00S	15-L2-045	-	-	-	-	-	-	1-1/4	1/8	.025	.0576
10S	15-L2-046	-	-	11-L2-046	15-CO-046	-	-			1/32	.080
11S	15-L2-047	-	-	11-L2-047	15-CO-047	-	-			3/64	.093
11S3	15-L2-068	-	-	11-L2-068	-	-	-	3			
11S4	15-L2-069	-	-	11-L2-069	-	-	-	4			
11S5	15-L2-070	-	-	11-L2-070	-	-	-	5•			
11S6	15-L2-071	-	-	-	-	-	-	6•			
12S	15-L2-048	15-TN-048	15-TL-048	11-L2-048	15-CO-048	CO-TN-048	CO-TL-048	1-7/8	3/16	1/16	.125
12S4	15-L2-072	-	-	11-L2-072	-	-	-	4			
12S5	15-L2-073	-	-	11-L2-073	-	-	-	5•			
12S6	15-L2-074	-	-	-	-	-	-	6•			
13S	15-L2-049	15-TN-049	15-TL-049	11-L2-049	15-CO-049	CO-TN-049	CO-TL-049	2	1/4	3/32	.1875
13S4	15-L2-075	-	-	11-L2-075	-	-	-	4			
13S5	15-L2-076	-	-	11-L2-076	-	-	-	5•			
13S6	15-L2-077	-	-	11-L2-077	-	-	-	6•			
14S	15-L2-050	15-TN-050	15-TL-050	11-L2-050	15-CO-050	CO-TN-050	CO-TL-050	2-1/8	5/16	7/64	
14S4	15-L2-078	-	-	11-L2-078	-	-	-	4			
14S5	15-L2-079	-	-	11-L2-079	-	-	-	5•			
14S6	15-L2-080	-	-	11-L2-080	-	-	-	6•			
145S4	15-L2-081	-	-	11-L2-081	-	-	-	4	3/8	9/64	.250
145S5	15-L2-082	-	-	11-L2-082	-	-	-	5•			
145S6	15-L2-083	-	-	11-L2-083	-	-	-	6•			
15S	15-L2-051	15-TN-051	15-TL-051	11-L2-051	15-CO-051	CO-TN-051	CO-TL-051	2-3/4	7/16	5/32	.312
15S5	15-L2-084	-	-	11-L2-084	-	-	-	5•			
15S6	15-L2-085	-	-	11-L2-085	-	-	-	6•			
16S	15-L2-052	15-TN-052	15-TL-052	11-L2-052	15-CO-052	CO-TN-052	CO-TL-052	3	1/2	3/16	
16S5	15-L2-086	-	-	11-L2-086	-	-	-	5•			
16S6	15-L2-087	-	-	11-L2-087	-	-	-	6•			
17S	15-L2-053	15-TN-053	15-TL-053	11-L2-053	15-CO-053	CO-TN-053	CO-TL-053	3-1/4	5/8	7/32	.437
17S6	15-L2-088	-	-	11-L2-088	-	-	-	6•			
18S	15-L2-054	15-TN-054	15-TL-054	11-L2-054	15-CO-054	CO-TN-054	CO-TL-054	3-1/2	3/4	1/4	.4687
18S6	15-L2-089	-	-	11-L2-089	-	-	-	6•			

• Extended Length

CENTERDRILLS

Centerdrill B Type Bell

The B Type Centerdrill is a dual-purpose drill used for the heaviest of work applications.. This drill has a 60° angle for burnishing , followed by a 120° flare for chamfering. .

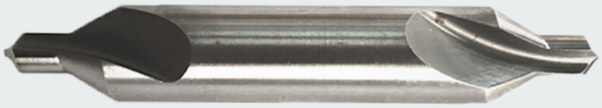


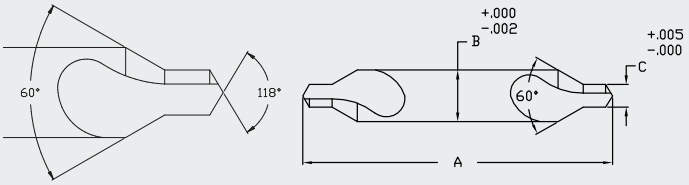
Drill Type	Part No.							OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)
	HSS	HSS-TiN	HSS-TiAlN	HSS-LH	COBALT	COBALT-TiN	COBALT-TiAlN				
00B	25-L2-135	-	-	-	-	-	-	1-1/4	1/8	.025	.064
0B	25-L2-136	-	-	11-L2-136	25-CO-136	-	-			1/32	.090
11B	25-L2-137	-	-	11-L2-137	25-CO-137	-	-				
11B3	25-L2-158	-	-	11-L2-158	-	-	-	3		3/64	.100
11B4	25-L2-159	-	-	11-L2-159	-	-	-	4			
11B5	25-L2-160	-	-	11-L2-160	-	-	-	5•			
11B6	25-L2-161	-	-	-	-	-	-	6•			
12B	25-L2-138	25-TN-138	25-TL-138	11-L2-138	25-CO-138	CO-TN-138	CO-TL-138	1-7/8	3/16	1/16	.150
12B4	25-L2-162	-	-	11-L2-162	-	-	-	4			
12B5	25-L2-163	-	-	11-L2-163	-	-	-	5•			
12B6	25-L2-164	-	-	-	-	-	-	6•			
13B	25-L2-139	25-TN-139	25-TL-139	11-L2-139	25-CO-139	CO-TN-139	CO-TL-139	2	1/4	3/32	.200
13B4	25-L2-165	-	-	11-L2-165	-	-	-	4			
13B5	25-L2-166	-	-	11-L2-166	-	-	-	5•			
13B6	25-L2-167	-	-	11-L2-167	-	-	-	6•			
14B	25-L2-140	25-TN-140	25-TL-140	11-L2-140	25-CO-140	CO-TN-140	CO-TL-140	2-1/8	5/16	7/64	.250
14B4	25-L2-168	-	-	11-L2-168	-	-	-	4			
14B5	25-L2-169	-	-	11-L2-169	-	-	-	5•			
14B6	25-L2-170	-	-	11-L2-170	-	-	-	6•			
145B4	25-L2-171	-	-	11-L2-171	-	-	-	4	3/8	9/64	
145B5	25-L2-172	-	-	11-L2-172	-	-	-	5•			
145B6	25-L2-173	-	-	11-L2-173	-	-	-	6•			
15B	25-L2-141	25-TN-141	25-TL-141	11-L2-141	25-CO-141	CO-TN-141	CO-TL-141	2-3/4	7/16	5/32	.350
15B5	25-L2-174	-	-	11-L2-174	-	-	-	5•			
15B6	25-L2-175	-	-	11-L2-175	-	-	-	6•			
16B	25-L2-142	25-TN-142	25-TL-142	11-L2-142	25-CO-142	CO-TN-142	CO-TL-142	3	1/2	3/16	.400
16B5	25-L2-176	-	-	11-L2-176	-	-	-	5•			
16B6	25-L2-177	-	-	11-L2-177	-	-	-	6•			
17B	25-L2-143	25-TN-143	25-TL-143	11-L2-143	25-CO-143	CO-TN-143	CO-TL-143	3-1/4	5/8	7/32	.500
17B6	25-L2-178	-	-	11-L2-178	-	-	-	6•			
18B	25-L2-144	25-TN-144	25-TL-144	11-L2-144	25-CO-144	CO-TN-144	CO-TL-144	3-1/2	3/4	1/4	.600
18B6	25-L2-179	-	-	11-L2-179	-	-	-	6•			
20B	25-L2-146	-	-	-	-	-	-	3-3/4	1	3/8	.800

• Extended Length

Centerdrill ST Type 60° (Metric)

Same as our ST Type 60° Centerdrill, now available in standard metric sizes in both HSS and Cobalt.

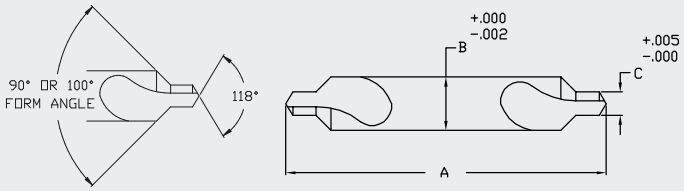




Drill Size	Part No.						OAL (A)	Body DIA (B)	Drill DIA (C)
	HSS	HSS-TiN	HSS-TiAlN	COBALT	COBALT-TiN	COBALT-TiAlN			
1.0 X 3.15	23-L2-004	23-TN-004	23-TL-004	23-CO-004	CO-TN-010	CO-TL-010	31.5	3.15	1.00
1.25 X 3.15	23-L2-005	23-TN-005	23-TL-005	23-CO-005	CO-TN-011	CO-TL-011	31.5	3.15	1.25
1.6 X 4.0	23-L2-006	23-TN-006	23-TL-006	23-CO-006	CO-TN-012	CO-TL-012	35.5	4.00	1.60
2.0 X 5.0	23-L2-007	23-TN-007	23-TL-007	23-CO-007	CO-TN-013	CO-TL-013	40.0	5.00	2.00
2.5 X 6.3	23-L2-008	23-TN-008	23-TL-008	23-CO-008	CO-TN-014	CO-TL-014	45.0	6.30	2.50
3.15 X 8.0	23-L2-009	23-TN-009	23-TL-009	23-CO-009	CO-TN-015	CO-TL-015	50.0	8.00	3.15
4.0 X 10.0	23-L2-010	23-TN-010	23-TL-010	23-CO-010	CO-TN-016	CO-TL-016	56.0	10.00	4.00
5.0 X 12.5	23-L2-011	23-TN-011	23-TL-011	23-CO-011	CO-TN-017	CO-TL-017	63.0	12.50	5.00
6.3 X 16.0	23-L2-012	23-TN-012	23-TL-012	23-CO-012	CO-TN-018	CO-TL-018	71.0	16.00	6.30
8.0 X 20.0	23-L2-013	23-TN-013	23-TL-013	23-CO-013	CO-TN-019	CO-TL-019	80.0	20.00	8.00

Centerdrill 90° And 100° Type

Similar to our standard ST Type Centerdrill, these drills feature either a 90° or 100° angle design.



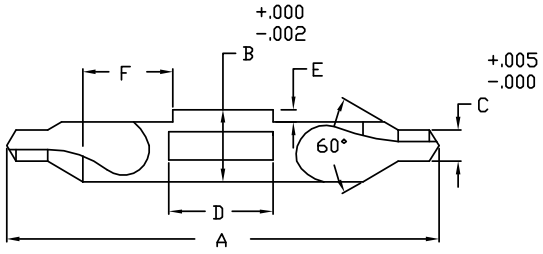
Drill Size	Part Number		OAL (A)	Body DIA (B)	Drill DIA (C)
	HSS - 90°	COBALT - 90°			
0-90	10-90-001	90-CO-001	1-1/4	1/8	1/32
1-90	10-90-002	90-CO-002			3/64
2-90	10-90-003	90-CO-003	1-7/8	3/16	5/64
3-90	10-90-004	90-CO-004	2	1/4	7/64
4-90	10-90-005	90-CO-005	2-1/8	5/16	1/8
5-90	10-90-006	90-CO-006	2-3/4	7/16	3/16
6-90	10-90-007	90-CO-007	3	1/2	7/32
7-90	10-90-008	90-CO-008	3-1/4	5/8	1/4
8-90	10-90-009	90-CO-009	3-1/2	3/4	5/16

Drill Size	Part Number		OAL (A)	Body DIA (B)	Drill DIA (C)
	HSS - 100°	COBALT - 100°			
0-100	10-100-001	100-CO-001	1-1/4	1/8	1/32
1-100	10-100-002	100-CO-002			3/64
2-100	10-100-003	100-CO-003	1-7/8	3/16	5/64
3-100	10-100-004	100-CO-004	2	1/4	7/64
4-100	10-100-005	100-CO-005	2-1/8	5/16	1/8
5-100	10-100-006	100-CO-006	2-3/4	7/16	3/16
6-100	10-100-007	100-CO-007	3	1/2	7/32
7-100	10-100-008	100-CO-008	3-1/4	5/8	1/4
8-100	10-100-009	100-CO-009	3-1/2	3/4	5/16

CENTERDRILLS

Hey Centerdrills ST Type

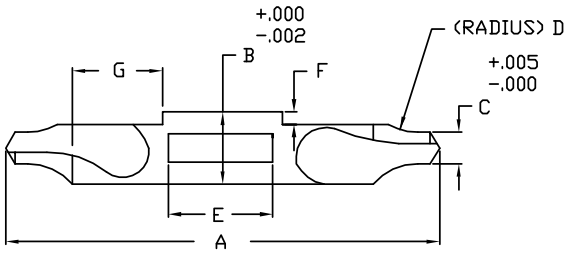
LINK Hey Drills offer the high quality and precision workmanship of our standard line of Centerdrills, with strategically positioned flats for locking set screws and to accommodate adjacent tooling. The position of the center flat is exactly 90° from the Hey Flat location. These drills feature our ST tip form.



60° Double End									
	Part No.								
Drill Type	HSS	HSS-TiN	HSS-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Central Flat Length (D)	End Flat Depth (E)	End Flat Length (F)
4ST	21-L2-654	21-TN-654	21-TL-654	2-1/8	5/16	1/8	1/2	.075	9/16
5ST	21-L2-655	21-TN-655	21-TL-655	2-3/4	7/16	3/16	3/4	.086	5/8
6ST	21-L2-656	21-TN-656	21-TL-656	3	1/2	7/32	3/4	.086	5/8
7ST	21-L2-657	21-TN-657	21-TL-657	3-1/4	5/8	1/4	3/4	.105	5/8
8ST	21-L2-658	21-TN-658	21-TL-658	3-1/2	3/4	5/16	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Central Flat Length (D)	End Flat Depth (E)	End Flat Length (F)
4ST	21-CO-654	CO-TN-654	CO-TL-654	2-1/8	5/16	1/8	1/2	.075	9/16
5ST	21-CO-655	CO-TN-655	CO-TL-655	2-3/4	7/16	3/16	3/4	.086	5/8
6ST	21-CO-656	CO-TN-656	CO-TL-656	3	1/2	7/32	3/4	.086	5/8
7ST	21-CO-657	CO-TN-657	CO-TL-657	3-1/4	5/8	1/4	3/4	.105	5/8
8ST	21-CO-658	CO-TN-658	CO-TL-658	3-1/2	3/4	5/16	3/4	.105	5/8

Hey Centerdrills R Type

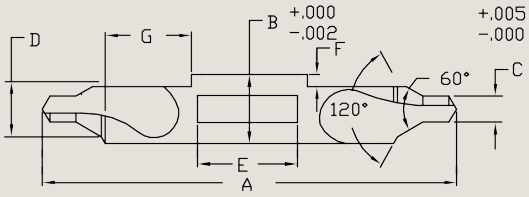
The R Type Hey Drill provides an increased cross-sectional area that is directly related to the depth of the cut and the resulting tool force. The position for the central flat is exactly 90° from the Hey Flat location.



Radius Double End										
	Part No.									
Drill Type	HSS	HSS-TiN	HSS-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Radius (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
5R	27-L2-684	27-TN-684	27-TL-684	2-3/4	7/16	3/16	.323	3/4	.086	5/8
6R	27-L2-685	27-TN-685	27-TL-685	3	1/2	7/32	.407	3/4	.086	5/8
7R	27-L2-686	27-TN-686	27-TL-686	3-1/4	5/8	1/4	.593	3/4	.105	5/8
8R	27-L2-687	27-TN-687	27-TL-687	3-1/2	3/4	5/16	.663	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Radius (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
6R	27-CO-685	CO-TN-685	CO-TL-685	3	1/2	7/32	.407	3/4	.086	5/8
7R	27-CO-686	CO-TN-686	CO-TL-686	3-1/4	5/8	1/4	.593	3/4	.105	5/8
8R	27-CO-687	CO-TN-687	CO-TL-687	3-1/2	3/4	5/16	.663	3/4	.105	5/8

Hey Centerdrills B Type

The B Type Hey Drill is a dual-purpose drill which includes a 60° angle for burnishing and 120° flair for chamfering. It is used in conjunction with facing inserts. The position for the central flat is exactly 90° from the Hey Flat location. These drills feature our B tip form.



60°/120° Double End										
Drill Type	Part No. HSS	HSS-TiN	HSS-TiAlN	OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
13B	26-L2-673	26-TN-673	26-TL-673	2	1/4	3/32	.200	5/16	.055	7/16
14B	26-L2-674	26-TN-674	26-TL-674	2-1/8	5/16	7/64	.250	1/2	.075	9/16
15B	26-L2-675	26-TN-675	26-TL-675	2-3/4	7/16	5/32	.350	3/4	.086	5/8
16B	26-L2-676	26-TN-676	26-TL-676	3	1/2	3/16	.400	3/4	.086	5/8
17B	26-L2-677	26-TN-677	26-TL-677	3-1/4	5/8	7/32	.500	3/4	.105	5/8
18B	26-L2-678	26-TN-678	26-TL-678	3-1/2	3/4	1/4	.600	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAlN	OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
15B	26-CO-675	CO-TN-675	CO-TL-675	2-3/4	7/16	5/32	.350	3/4	.086	5/8
16B	26-CO-676	CO-TN-676	CO-TL-676	3	1/2	3/16	.400	3/4	.086	5/8
17B	26-CO-677	CO-TN-677	CO-TL-677	3-1/4	5/8	7/32	.500	3/4	.105	5/8
18B	26-CO-678	CO-TN-678	CO-TL-678	3-1/2	3/4	1/4	.600	3/4	.105	5/8

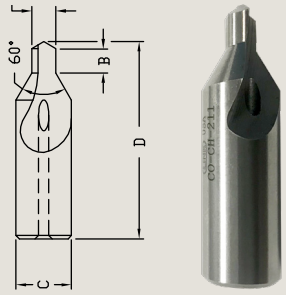
Single-End Thru-Tool Cooling (TTC) Drill

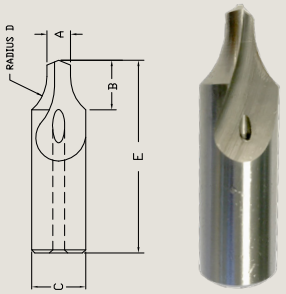
Single-End Cobalt drills now available with Thru-Tool Cooling (TTC). The TTC design offers superior cooling and chip removal characteristics to promote a longer tool life. They are available in ST Type 60°, R Type and B Type 60°/120° forms. Tool coatings available–please call for a quote.

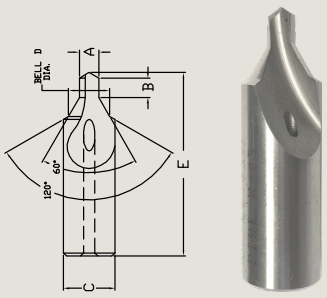
ST Type 60°					
Drill Type	Part No. COBALT	Drill DIA (A)	Drill Length (B)	Body DIA (C)	OAL (D)
4-ST	CO-CH-209	.125	.125	.312	1.250
5-ST	CO-CH-210	.187	.187	.437	1.625
6-ST	CO-CH-211	.218	.218	.500	1.781
7-ST	CO-CH-212	.250	.250	.625	2.125
8-ST	CO-CH-213	.312	.312	.750	2.500

R Type						
Drill Type	Part No. COBALT	Drill DIA (A)	Drill Length (B)	Body DIA (C)	Radius (D)	OAL (E)
4-R	CO-CH-201	.125	.290	.312	.248	1.250
5-R	CO-CH-202	.187	.395	.437	.323	1.625
6-R	CO-CH-203	.218	.460	.500	.407	1.781
7-R	CO-CH-204	.250	.583	.625	.593	2.125
8-R	CO-CH-205	.312	.675	.750	.663	2.500

B Type 60°/120°						
Drill Type	Part No. COBALT	Drill DIA (A)	Drill Length (B)	Body DIA (C)	Bell DIA (D)	OAL (E)
14-B	CO-CH-225	.109	.109	.312	.250	1.250
15-B	CO-CH-226	.156	.156	.437	.350	1.625
16-B	CO-CH-227	.187	.187	.500	.400	1.781
17-B	CO-CH-228	.218	.218	.625	.500	2.125
18-B	CO-CH-229	.250	.250	.750	.600	2.500



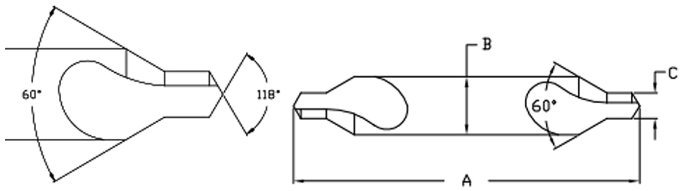




CENTERDRILLS

Carbide Centerdrills 60°/82°/90°

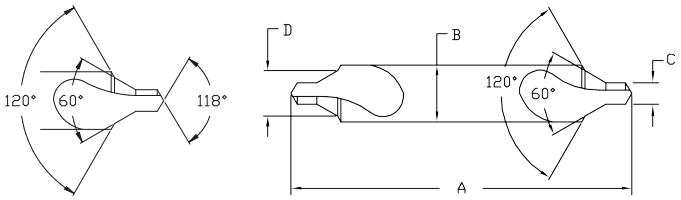
- Ideal for centering parts to be turned between centers
- Manufactured from premium submicron solid carbide
- Coatings available upon request
- Our ST-Type Carbide Centerdrill has a straight flute design, available in 60°/82°/90°



Drill Type	Part No.			Body Diameter	Drill Diameter	Overall Length
	60° Carbide	82° Carbide	90° Carbide			
1	20-CB-092	82-CB-002	90-CB-002	1/8	3/64	1-1/2
2	20-CB-093	82-CB-003	90-CB-003	3/16	5/64	2
3	20-CB-094	82-CB-004	90-CB-004	1/4	7/64	2
4	20-CB-095	82-CB-005	90-CB-005	5/16	1/8	2-1/8
5	20-CB-096	82-CB-006	90-CB-006	7/16	3/16	2-3/4
6	20-CB-097	82-CB-007	90-CB-007	1/2	7/32	3
7	20-CB-098	82-CB-008	90-CB-008	5/8	1/4	3-1/8
8	20-CB-099	82-CB-009	90-CB-009	3/4	5/16	3-3/8

Carbide Centerdrill B Type

- Dual-purpose 60° drill with 120° flare for chamfering
- Manufactured from premium submicron solid carbide
- Coatings available upon request



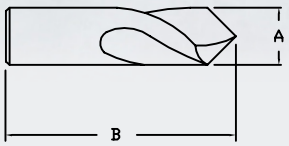
Drill Type	Part No	Body Diameter	Drill Diameter	Overall Length	Bell Diameter
11B	25-CB-137	1/8	3/64	1-1/2	0.100
12B	25-CB-138	3/16	1/16	2	0.150
13B	25-CB-139	1/4	3/32	2	0.200
14B	25-CB-140	5/16	7/64	2-1/8	0.250
15B	25-CB-141	7/16	5/32	2-3/4	0.350
16B	25-CB-142	1/2	3/16	3	0.400
17B	25-CB-143	5/8	7/32	3-1/8	0.500
18B	25-CB-144	3/4	1/4	3-1/2	0.600

Tolerances	
Body Diameter	+.000/-.001
Drill Diameter	+.003/-.000
Drill Length	± .005
Overall Length	± .031
Bell Diameter	± .005
Point Angle	± 1°
Countersink Angles	± 1°
Flute Design	Straight

Spotting Drills

Spot and Centering Drill

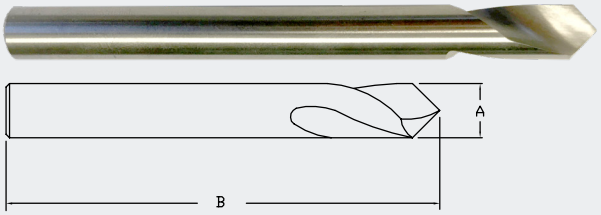
The LINK Spot drill design features a thin web to reduce walking and offer easy cutting. Ideal for chamfering, spot drilling, hole centering accuracy and countersinking. The LINK short drill design is offered in both HSS and Cobalt with an 82°/90°/120° point angle. Short drills are often used for chucking close to the point to ensure extreme accuracy. Additional coatings available upon request.



		82° Angle				90° Angle				120° Angle			
		Part No.				Part No.				Part No.			
Drill DIA (A)	OAL (B)	HSS	HSS - TiN	COBALT	COBALT TiN	HSS	HSS - TiN	COBALT	COBALT TiN	HSS	HSS - TiN	COBALT	COBALT TiN
1/4	2	97-L2-395	97-TN-395	97-CO-394	CO-TN-394	97-L2-380	97-TN-380	97-CO-379	CO-TN-379	97-L2-401	97-TN-401	97-CO-417	CO-TN-417
3/8	2	97-L2-396	97-TN-396	97-CO-396	CO-TN-396	97-L2-381	97-TN-381	97-CO-381	CO-TN-381	97-L2-386	97-TN-386	97-CO-386	CO-TN-386
1/2	2	97-L2-398	97-TN-398	97-CO-398	CO-TN-398	97-L2-383	97-TN-383	97-CO-383	CO-TN-383	97-L2-388	97-TN-388	97-CO-388	CO-TN-388
5/8	2-1/4	97-L2-399	97-TN-399	97-CO-399	CO-TN-399	97-L2-384	97-TN-384	97-CO-384	CO-TN-384	97-L2-389	97-TN-389	97-CO-389	CO-TN-389
3/4	2-1/4	97-L2-400	97-TN-400	97-CO-400	CO-TN-400	97-L2-385	97-TN-385	97-CO-385	CO-TN-385	97-L2-390	97-TN-390	97-CO-390	CO-TN-390

Cobalt Spot and Centering Drill Extended Length – 82°/ 90°/ 120°

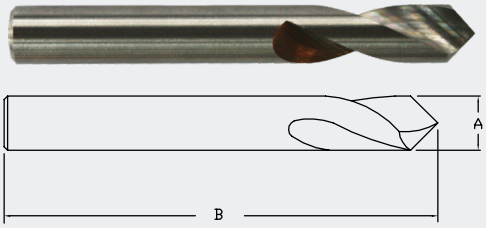
- Extended length applications
- Point Angles 82°/90°/120°
- Coatings available upon request



		Part No.		
Drill DIA (A)	OAL (B)	82° Angle	90° Angle	120° Angle
1/4	4	97-CO-395	97-CO-380	97-CO-418
3/8	4	97-CO-401	97-CO-405	97-CO-419
1/2	4	97-CO-402	97-CO-406	97-CO-420
5/8	6	97-CO-403	97-CO-407	97-CO-421
3/4	6	97-CO-404	97-CO-408	97-CO-422

Carbide NC Spot Drills – 90°/120°/142°

- Ideal for chamfering or spot drilling
- Manufactured from premium submicron solid carbide
- Point Angles: 90°/120°/142°
- Coatings available upon request



		Part No.		
Drill Diameter	Overall Length	90° Carbide	120° Carbide	142° Carbide
1/8	2	97-CB-380	97-CB-386	97-CB-392
3/16	3	97-CB-381	97-CB-387	97-CB-393
1/4	3	97-CB-382	97-CB-388	97-CB-394
5/16	2-1/2	97-CB-383	97-CB-389	97-CB-395
3/8	3	97-CB-384	97-CB-390	97-CB-396
1/2	4	97-CB-385	97-CB-391	97-CB-397

Counterbores & Countersinks

ENGLISH DRILL AND COUNTERBORES. 14

3XD ENGLISH DRILL AND COUNTERBORES 14

METRIC DRILL AND COUNTERBORES 15

EXTENDED LENGTH THREE FLUTE COUNTERBORE (ENGLISH) 15

EXTENDED LENGTH THREE FLUTE COUNTERBORE (METRIC) 15

COUNTERSINK STRAIGHT SHANKS (ENGLISH) 16

COUNTERSINK STRAIGHT SHANKS (METRIC). 16

CROSS-LINK 82° COUNTERSINKS. 17

SINGLE FLUTE CHAMFER 17

THREE FLUTE CENTER REAMER 17

SIX FLUTE COUNTERSINK. 18

NO FLUTE COUNTERSINK AND DEBURRS. 18

CARBIDE FOUR FLUTE PERFORMANCE CHAMFERS – 60°/82°/90° 18

Many tools are available with additional coatings. Please call for a quote! 1-800-626-9460

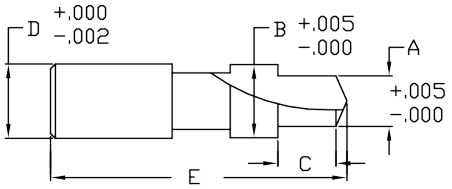
Link Industries reserves the right to make changes, alterations, and substitutions to the products, services, or other information presented without prior notice. For the latest information contact Link Industries.

Equipment pictured may be shown with safety equipment removed or disabled for purposes of illustration. Equipment must never be operated with safety equipment removed or disabled.

COUNTERBORES

English Drill and Counterbores

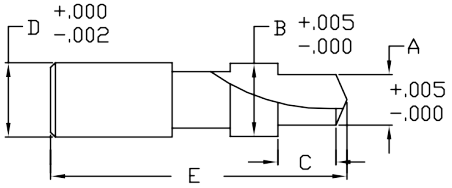
The LINK Counterbore is designed to drill and counterbore in one operation to allow for sufficient clearance for a socket head cap screw. All drills come with a 134° self-centering point and a straight shank for standard chucking or use with a collet. Made from HSS.



Part No.	English Screw	Drill DIA (A)	Counterbore DIA (B)	Drill Length (C)	Shank DIA (D)	OAL (E)
50-L2-178	#3	.110	.175	.220	3/16	1-1/16
50-L2-179	#4	.125	.197	.220	1/4	1-3/16
50-L2-180	#5	.138	.220	1/4	1/4	1-7/32
50-L2-181	#6	.150	.242	1/4	1/4	1-7/32
50-L2-182	#8	.178	.290	9/32	5/16	1-15/32
50-L2-183	#10	.200	.332	5/16	5/16	1-1/2
50-L2-184	1/4	.280	.406	3/8	7/16	1-3/4
50-L2-185	5/16	.340	.490	3/8	1/2	1-15/16
50-L2-186	3/8	.406	.593	15/32	5/8	2-11/32
50-L2-187	7/16	.468	.687	1/2	5/8	2-1/2
50-L2-188	1/2	.532	.781	9/16	5/8	2-11/16

3XD English Drill and Counterbores

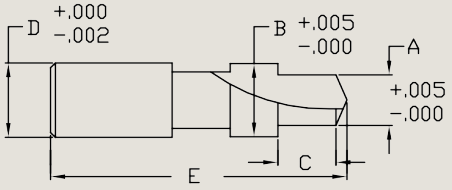
- Drill and Counterbore in one operation for socket head cap screws; drill lengths are longer for thicker materials.
- 134° self-centering point.
- Made from HSS.



Part No	English Screw	Drill DIA (A)	Counterbore DIA (B)	3XD Drill Length (C)	Shank DIA (D)	OAL (E)
50-L2-380	#5	.138	.220	.414	1/4	2
50-L2-381	#6	.150	.242	.450	1/4	2
50-L2-382	#8	.178	.290	.534	3/8	2-1/4
50-L2-383	#10	.200	.332	.600	3/8	2-1/4
50-L2-384	1/4	.280	.406	.840	3/8	2-3/4
50-L2-385	5/16	.340	.490	1.020	1/2	3
50-L2-386	3/8	.406	.593	1.218	1/2	3-1/2
50-L2-387	7/16	.468	.688	1.404	1/2	4
50-L2-388	1/2	.532	.781	1.596	1/2	4-1/2

Metric Drill and Counterbores

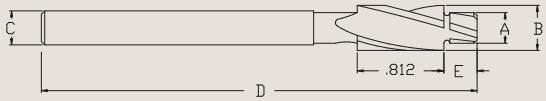
Same as the English design, the LINK Metric Counterbore is designed to drill and counterbore in one operation and to allow sufficient clearance for a metric socket head cap screw. They have a straight shank for standard chucking or use with a collet holder. Made from HSS.



Part No.	Metric Screw	Drill DIA (A)	Counterbore DIA (B)	Drill Length (C)	Shank DIA (D)	OAL (E)
75-L2-520	3 mm	3.57	5.95	6.35	6.35	31.75
75-L2-521	4 mm	4.36	7.54	7.54	6.35	34.92
75-L2-522	5 mm	5.55	9.13	7.94	7.94	38.10
75-L2-523	6 mm	6.30	10.71	9.52	7.94	39.69
75-L2-524	8 mm	8.73	13.49	11.11	11.11	46.04
75-L2-525	10 mm	10.32	16.66	14.29	12.70	52.39
75-L2-526	12 mm	12.70	18.75	15.87	15.87	61.91
75-L2-527	14 mm	14.68	21.82	16.67	15.87	66.67
75-L2-528	16 mm	16.67	24.60	17.46	15.87	69.85

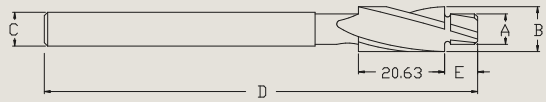
Extended Length Three Flute Counterbore (English)

LINK's 3-Flute Counterbores have a guided pilot design with an extended straight shank. CNC precision ground and made from COBALT HSS, the English 3-Flute Counterbore is designed to provide sufficient clearance for a socket head cap screw.



Part No.	English Screw	Pilot DIA (A)	Counterbore DIA (B)	Shank DIA (C)	OAL (D)	Pilot Length (E)
50-CO-180	#5	.156	.237	1/4	4	.187
50-CO-181	#6	.169	.260	1/4	4	.218
50-CO-182	#8	.195	.304	1/4	4	.250
50-CO-183	#10	.221	.346	5/16	4	.281
50-CO-184	1/4	.281	.414	5/16	4	.312
50-CO-185	5/16	.343	.507	3/8	5	.375
50-CO-186	3/8	.406	.604	3/8	5	.500
50-CO-187	7/16	.468	.695	1/2	6	.500
50-CO-188	1/2	.531	.789	1/2	6	.500
50-CO-189	5/8	.655	.978	5/8	6	.500

Extended Length Three Flute Counterbore (Metric)

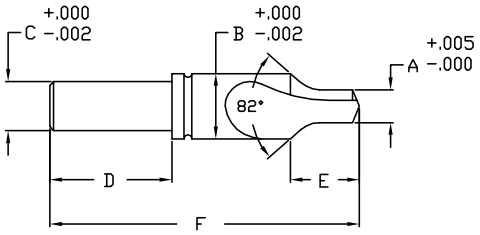


Part No.	Metric Screw	Pilot DIA (A)	Counterbore DIA (B)	Shank DIA (C)	OAL (D)	Pilot Length (E)
75-CO-519	2.5 mm	3.0	5.4	6.35	100	5.53
75-CO-520	3 mm	3.8	6.3	6.35	100	5.53
75-CO-521	4 mm	4.8	7.8	6.35	100	6.35
75-CO-522	5 mm	5.8	9.3	6.35	100	7.13
75-CO-523	6 mm	6.8	10.8	7.94	100	7.92
75-CO-524	8 mm	8.8	13.8	7.94	100	9.52
75-CO-525	10 mm	10.8	16.8	9.53	125	12.70
75-CO-526	12 mm	12.8	18.8	9.53	125	12.70
75-CO-527	14 mm	14.8	21.8	12.70	150	14.27
75-CO-528	16 mm	16.8	24.8	12.70	150	14.27

COUNTERSINKS

Countersink Straight Shanks (English)

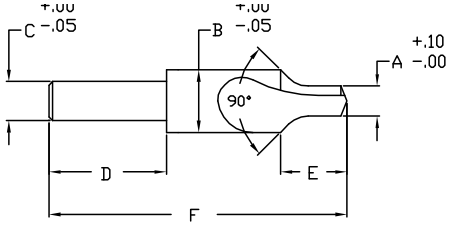
The LINK English countersink features an 82° angle to allow sufficient clearance for drilling and chamfering for flat head and oval head screws. They have a straight shank for standard chucking or a collet holder.



82° Angle									
Part No.									
HSS	HSS - TiN	COBALT	English Screw	Drill DIA (A)	Body DIA (B)	Shank DIA (C)	Shank Length (D)	Drill Length (E)	OAL (F)
55-L2-189	55-TN-189	-	#5	.127	5/16	1/4	5/8	11/32	1-3/4
55-L2-190	55-TN-190	55-CO-190	#6	.140	5/16	1/4	5/8	11/32	1-3/4
55-L2-191	55-TN-191	55-CO-191	#8	.166	7/16	1/4	5/8	15/32	2
55-L2-192	55-TN-192	55-CO-192	#10	.192	7/16	1/4	5/8	15/32	2
55-L2-193	55-TN-193	55-CO-193	#12	.220	7/16	1/4	5/8	1/2	2
55-L2-194	55-TN-194	55-CO-194	1/4	.252	1/2	3/8	15/16	17/32	2-3/8
55-L2-195	55-TN-195	55-CO-195	5/16	.315	5/8	3/8	15/16	21/32	2-5/8
55-L2-196	55-TN-196	55-CO-196	3/8	.378	3/4	1/2	1-1/8	25/32	3
55-L2-197	55-TN-197	-	1/2	.503	1	1/2	1-1/8	1-1/64	3
55-L2-198	55-TN-198	-	5/8	.625	1-1/8	1/2	1-1/4	1-5/32	3-1/2

Countersink Straight Shanks (Metric)

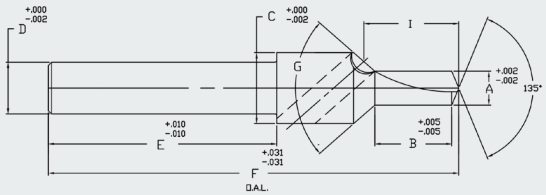
The LINK Metric countersink features a 90° angle to allow sufficient clearance for drilling and chamfering for flat head and oval head screws. They have a straight shank for standard chucking or a collet holder.



90° Angle								
Part No.								
HSS	HSS - TiN	Metric Screw	Drill DIA (A)	Body DIA (B)	Shank DIA (C)	Shank Length (D)	Drill Length (E)	OAL (F)
70-L3-379	70-TN-379	3 mm	3.10	6.35	6.35	–	8.73	44.44
70-L3-380	70-TN-380	4 mm	4.10	8.20	6.35	15.87	11.90	44.44
70-L3-381	70-TN-381	5 mm	5.10	11.20	7.93	15.87	12.70	50.79
70-L3-382	70-TN-382	6 mm	6.10	12.70	7.93	15.87	13.49	50.79
70-L3-383	70-TN-383	8 mm	8.10	17.45	11.11	23.79	18.25	66.66
70-L3-384	70-TN-384	10 mm	10.10	20.63	12.70	28.57	21.43	76.19
70-L3-385	70-TN-385	12 mm	12.10	25.40	15.87	28.57	23.81	76.19

Cross-LINK 82° Countersinks

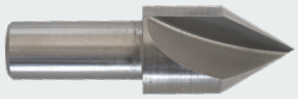
- 3 in 1 Tool: Spot, Drill & Countersink for English flat head screws
- Extreme-performance in aluminum applications
- Patent Pending design

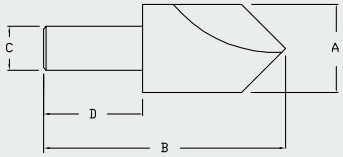


82° Angle									Speeds & Feeds	
Part No		English Screw	Drill Diameter	Drill Length	Body Diameter	Shank Diameter	Shank Length	Overall Length	SFM	FEED - IPR
Cobalt	Alu Coating									
55-CO-289	CO-AL-289	#5	.141	7/16	7/16	7/16	FULL	4	300-700	0.002
55-CO-290	CO-AL-290	#6	.154	7/16	7/16	7/16	FULL	4	300-700	0.002
55-CO-291	CO-AL-291	#8	.180	7/16	7/16	7/16	FULL	4	300-700	0.003
55-CO-292	CO-AL-292	#10	.206	7/16	7/16	7/16	FULL	4	300-700	0.003
55-CO-293	CO-AL-293	#12	.234	7/16	1/2	1/2	FULL	4	300-700	0.004
55-CO-294	CO-AL-294	1/4	.266	5/8	1/2	1/2	FULL	4	300-700	0.004
55-CO-295	CO-AL-295	5/16	.328	3/4	11/16	1/2	2.225	4	300-700	0.006
55-CO-296	CO-AL-296	3/8	.391	3/4	13/16	1/2	2.225	4	300-700	0.008
55-CO-297	CO-AL-297	1/2	.516	1	1	1/2	2.375	4-1/2	300-700	0.010

Single Flute Chamfer

LINK Single Flute Chamfer tools are ideal for a wide range of general purpose chamfering, deburring or countersinking. The single flute design provides a smooth surface finish on a wide variety of materials.

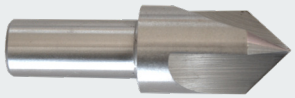


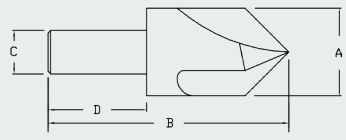


Part No.			Body DIA (A)	OAL (B)	Shank DIA (C)	Shank Length (D)
60° Single Flute - HSS	82° Single Flute - HSS	90° Single Flute - HSS				
90-L2-407	90-L2-550	90-L2-405	1/4	1-1/2	1/4	-
90-L2-409	90-L2-551	90-L2-413	3/8	1-9/16	3/8	-
90-L2-410	90-L2-552	90-L2-414	1/2	2	3/8	1
90-L2-408	90-L2-555	90-L2-404	5/8	2-3/8	3/8	1-1/8
90-L2-411	90-L2-553	90-L2-415	3/4	2-3/8	1/2	1-1/8
90-L2-412	90-L2-554	90-L2-416	1	2-3/4	1/2	1-1/8
90-L2-406	90-L2-556	90-L2-417	1-1/4	2-3/4	1/2	1-1/8
90-L2-424	90-L2-425	90-L2-426	1-1/2	3-1/2	3/4	1-3/4
90-L2-427	90-L2-557	90-L2-403	2	3-3/4	3/4	1-3/4

Three Flute Center Reamer

LINK Three Flute Center Reamers are versatile tools for countersinking holes for centers or enlarge existing holes. Tool coatings available.

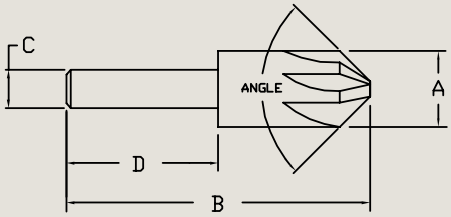




Part No.				Body DIA (A)	OAL (B)	Shank DIA (C)	Shank Length (D)
60° Three Flute - HSS	82° Three Flute - HSS	90° Three Flute - HSS	100° Three Flute - HSS				
91-L2-551	91-L2-556	91-L2-561	91-L2-566	3/8	1-9/16	3/8	-
91-L2-552	91-L2-557	91-L2-562	91-L2-567	1/2	2	3/8	1
91-L2-553	91-L2-558	91-L2-563	91-L2-568	3/4	2-3/8	1/2	1-1/8
91-L2-554	91-L2-559	91-L2-564	91-L2-569	1	2-3/4	1/2	1-1/8
91-L2-555	91-L2-560	91-L2-565	91-L2-570	1-1/2	3-1/2	3/4	1-1/4

Six Flute Countersink

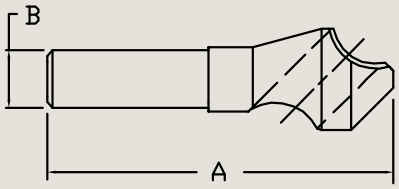
LINK Six Flute Countersinks are used to countersink or enlarge existing holes. Made from Cobalt HSS.



Part No.			Body DIA (A)	OAL (B)	Shank DIA (C)	Shank Length (D)
60° Six Flute - COBALT	82° Six Flute -COBALT	90° Six Flute - COBALT				
91-CO-570	91-CO-560	91-CO-565	3/8	1-3/4	3/8	-
91-CO-571	91-CO-561	91-CO-566	1/2	2	3/8	1
91-CO-572	91-CO-562	91-CO-567	3/4	2-1/2	1/2	1-1/8
91-CO-573	91-CO-563	91-CO-568	1	2-3/4	1/2	1-1/8
91-CO-574	91-CO-564	91-CO-569	1-1/4	3	1/2	1-1/4
91-CO-577	91-CO-575	91-CO-576	1-1/2	3-1/4	3/4	1-1/4

No Flute Countersink and Deburrs

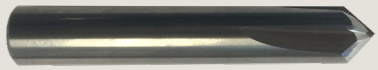
LINK No-Flute Countersink and Deburring tools excel in countersinking or deburring holes in aluminum, plastics and other nonmetallic materials. Made from COBALT, these all-purpose tools provide a chatter-free smooth finish with minimal power requirements.

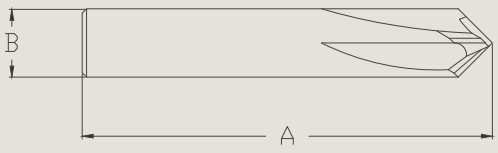


Part No.		Size	Diameter of Cut		Overall Length (A)	Shank Diameter (B)
82° No Flute - COBALT	90° No Flute - COBALT		Minimum	Maximum		
94-CO-195	94-CO-565	3/8	1/8	3/8	1-3/4	5/16
94-CO-196	94-CO-566	1/2	3/16	1/2	1-7/8	5/16
94-CO-197	94-CO-567	3/4	9/32	3/4	2-11/16	3/8
94-CO-198	94-CO-568	1	1/2	1	2-7/8	1/2

Carbide Four Flute Performance Chamfers – 60°/82°/90°

- Designed for deburring, chamfering and profiling features
- Manufactured from premium submicron solid carbide
- Point Angles: 60°/82°/90°
- Coatings available upon request

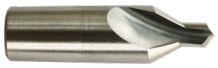




Drill Type	Part No.			Body Diameter	Overall Length	Shank Diameter
	60° 4-Flute Performance Chamfer - Carbide	82° 4-Flute Performance Chamfer - Carbide	90° 4-Flute Performance Chamfer - Carbide			
1	90-CB-409	90-CB-565	91-CB-571	1/8	2	1/8
2	90-CB-410	90-CB-566	91-CB-572	3/16	2	3/16
3	90-CB-411	90-CB-567	91-CB-573	1/4	2-1/2	1/4
4	90-CB-412	90-CB-568	91-CB-574	5/16	2-1/2	5/16
5	90-CB-413	90-CB-569	91-CB-575	3/8	2-1/2	3/8
6	90-CB-414	90-CB-570	91-CB-576	1/2	3	1/2

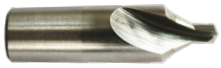
Unidapt System

Link Industries offers centerdrills, counterbores, countersinks, and spotting tools that are used with the Unidapt Adapter or Morse Taper Sleeves. Our drills can be customized to your specific manufacturing application.

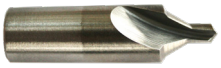


UNIDAPT SYSTEM CENTERDRILL ST TYPE 60° INSERT 21

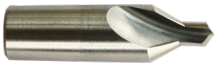
UNIDAPT SYSTEM CENTERDRILL R TYPE INSERT 21



UNIDAPT SYSTEM CENTERDRILL S TYPE 60°/82° BELL INSERT 21



UNIDAPT SYSTEM CENTERDRILL B TYPE 60°/120° BELL INSERT 22

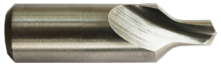


UNIDAPT SYSTEM CENTERDRILL 90° AND 100° INSERT..... 22

UNIDAPT SYSTEM COUNTERBORE (ENGLISH)..... 23

UNIDAPT SYSTEM COUNTERBORE (METRIC) 23

UNIDAPT SYSTEM COUNTERSINK (ENGLISH) 23



UNIDAPT SYSTEM COUNTERSINK (METRIC) 24

UNIDAPT SYSTEM SPOTTING DRILL..... 24

UNIDAPT SYSTEM MORSE TAPER ADAPTER25 25

UNIDAPT TOOL HOLDER ADAPTER 26

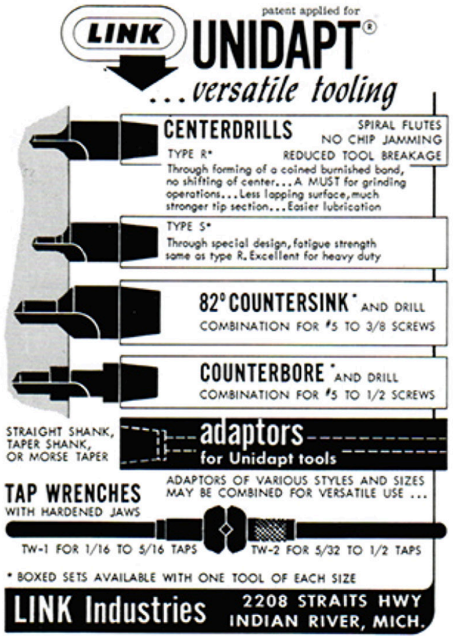
UNIDAPT TOOL HOLDER EXTENSION ADAPTER 27

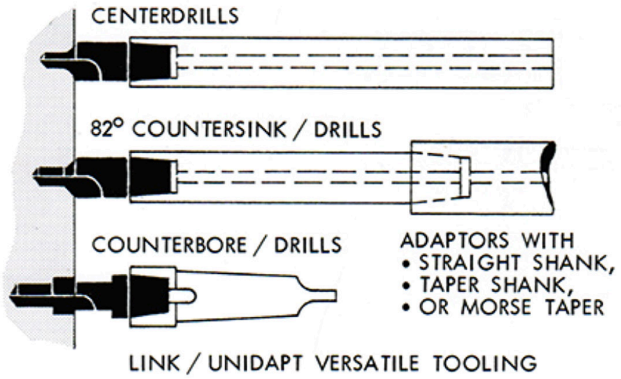
Many tools are available with additional coatings. Please call for a quote! 1-800-626-9460

Link Industries reserves the right to make changes, alterations, and substitutions to the products, services, or other information presented without prior notice. For the latest information contact Link Industries.

Equipment pictured may be shown with safety equipment removed or disabled for purposes of illustration. Equipment must never be operated with safety equipment removed or disabled.

UNIDAPT SYSTEM





The LINK system of cutting tool adapters is a unique and patented technique designed to enable the use of short drill inserts in place of special extended length custom tools.

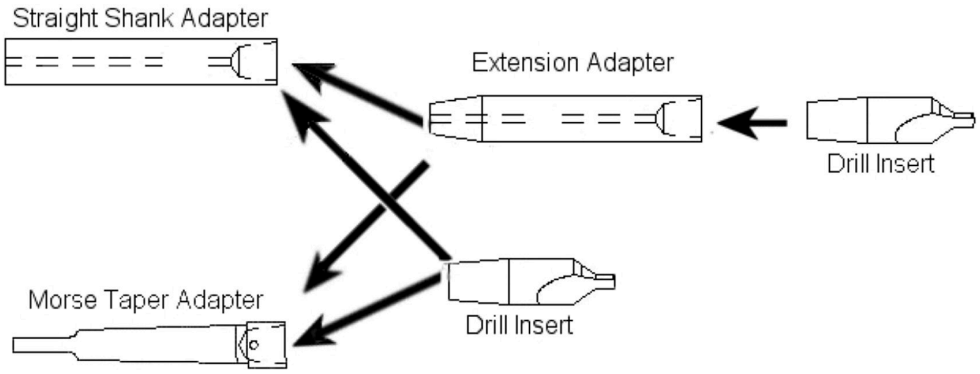
The Unidapt System is based upon the concept of a locking taper which secures the insert within the tool holder without slippage or backlash. Tool Holders are offered with a straight shank or a Morse Taper. Extension adapters are available to further extend the tool length for extremely hard to reach situations.

Tool adapters are tool hardened and black oxide coated to assure durability for years of dependable use. A wide array of sizes and lengths are available to meet most tooling applications.

Drill inserts are available in a wide assortment of standard sizes and tip forms, available in both HSS and Cobalt. LINK can also provide special tool forms to meet your specific application.

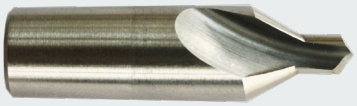
The LINK Unidapt System is an economical solution to replace only the small drill insert instead of an entire extended length tool

The diagram below and the tools specified in the following pages provide a description of the available tools. Special and custom tools are available.



Unidapt System Centerdrills

These centerdrill inserts are used in conjunction with the Unidapt Adapter or Morse Taper Sleeves.

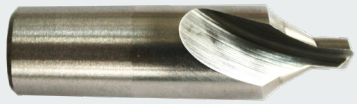


Unidapt System Centerdrill ST Type 60° Insert

Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length
		HSS	COBALT			
UA1	U0ST	40-L2-205	40-CO-205	1/8	1/32	3/4
UA1	U1ST	40-L2-206	40-CO-206	1/8	3/64	3/4
UA2	U2ST	40-L2-207	40-CO-207	3/16	5/64	1
UA3	U3ST	40-L2-208	40-CO-208	1/4	7/64	1-1/16
UA4	U4ST	40-L2-209	40-CO-209	5/16	1/8	1-3/16
UA5	U5ST	40-L2-210	40-CO-210	7/16	3/16	1-9/16
UA6	U6ST	40-L2-211	40-CO-211	1/2	7/32	1-11/16
UA7	U7ST	40-L2-212	40-CO-212	5/8	1/4	1-15/16

Unidapt System Centerdrill R Type Insert

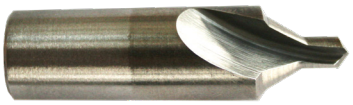
Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length	Radius
		HSS	COBALT				
UA1	U0R	30-L2-197	30-CO-197	1/8	1/32	3/4	0.1358
UA1	U1R	30-L2-198	30-CO-198	1/8	3/64	3/4	0.136
UA2	U2R	30-L2-199	30-CO-199	3/16	5/64	1	0.221
UA3	U3R	30-L2-200	30-CO-200	1/4	7/64	1-1/16	0.207
UA4	U4R	30-L2-201	30-CO-201	5/16	1/8	1-3/16	0.248
UA5	U5R	30-L2-202	30-CO-202	7/16	3/16	1-9/16	0.323
UA6	U6R	30-L2-203	30-CO-203	1/2	7/32	1-11/16	0.407
UA7	U7R	30-L2-204	30-CO-204	5/8	1/4	1-15/16	0.593



Unidapt System Centerdrill S Type 60°/82° Bell Insert

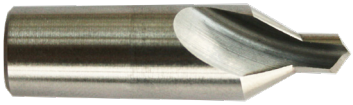
Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length	Bell Diameter
		HSS	COBALT				
UA1	U10S	35-L2-213	35-CO-213	1/8	.031	3/4	0.080
UA1	U11S	35-L2-214	35-CO-214	1/8	.046	3/4	0.093
UA2	U12S	35-L2-215	35-CO-215	3/16	.062	1	0.125
UA3	U13S	35-L2-216	35-CO-216	1/4	.093	1-1/16	0.187
UA4	U14S	35-L2-217	35-CO-217	5/16	.109	1-3/16	0.250
UA5	U15S	35-L2-218	35-CO-218	7/16	.156	1-9/16	0.312
UA6	U16S	35-L2-219	35-CO-219	1/2	.188	1-11/16	0.312
UA7	U17S	35-L2-220	35-CO-220	5/8	.218	1-15/16	0.437

UNIDAPT SYSTEM



Unidapt System Centerdrill B Type 60°/120° Bell Insert

Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length	Bell Diameter
		HSS	COBALT				
UA1	U10B	45-L2-221	45-CO-221	1/8	1/32	3/4	0.090
UA1	U11B	45-L2-222	45-CO-222	1/8	3/64	3/4	0.100
UA2	U12B	45-L2-223	45-CO-223	3/16	1/16	1	0.150
UA3	U13B	45-L2-224	45-CO-224	1/4	3/32	1-1/16	0.200
UA4	U14B	45-L2-225	45-CO-225	5/16	7/64	1-3/16	0.250
UA5	U15B	45-L2-226	45-CO-226	7/16	5/32	1-9/16	0.350
UA6	U16B	45-L2-227	45-CO-227	1/2	3/16	1-11/16	0.400
UA7	U17B	45-L2-228	45-CO-228	5/8	7/32	1-15/16	0.500



Unidapt System Centerdrill 90° and 100° Insert

90° Insert						
Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length
		HSS	COBALT			
UA1	U0-90	30-90-197	29-CO-197	1/8	1/32	3/4
UA1	U1-90	30-90-198	29-CO-198	3/64	1/8	3/64
UA2	U2-90	30-90-199	29-CO-199	3/16	5/64	1
UA3	U3-90	30-90-200	29-CO-200	1/4	7/64	1-1/16
UA4	U4-90	30-90-201	29-CO-201	5/16	1/8	1-3/16
UA5	U5-90	30-90-202	29-CO-202	7/16	3/16	1-9/16
UA6	U6-90	30-90-203	29-CO-203	1/2	7/32	1-11/16
UA7	U7-90	30-90-204	29-CO-204	5/8	1/4	1-15/16

100° Insert						
Fits Holder Size	Drill Type	Part No.		Outside Diameter	Drill Diameter	Overall Length
		HSS	COBALT			
UA1	U0-100	30-100-197	28-CO-197	1/8	1/32	3/4
UA1	U1-100	30-100-198	28-CO-198	3/64	1/8	3/64
UA2	U2-100	30-100-199	28-CO-199	3/16	5/64	1
UA3	U3-100	30-100-200	28-CO-200	1/4	7/64	1-1/16
UA4	U4-100	30-100-201	28-CO-201	5/16	1/8	1-3/16
UA5	U5-100	30-100-202	28-CO-202	7/16	3/16	1-9/16
UA6	U6-100	30-100-203	28-CO-203	1/2	7/32	1-11/16
UA7	U7-100	30-100-204	28-CO-204	5/8	1/4	1-15/16

Unidapt System Counterbore (English)

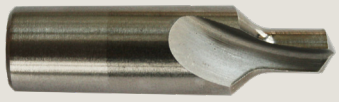
The LINK counterbore is designed to drill and counterbore in a single operation and to allow for sufficient clearance for a standard socket head cap screw.

Fits Holder Size	Part No.	English Screw	Drill Diameter	Counterbore DIA	Drill Length	Overall Length
UA3	60-L2-293	#5	.138	.220	1/4	1-7/32
UA3	60-L2-294	#6	.150	.242	1/4	1-7/32
UA4	60-L2-295	#8	.178	.290	9/32	1-15/32
UA4	60-L2-296	#10	.200	.332	5/16	1-1/2
UA5	60-L2-297	1/4	.280	.406	3/8	1-3/4
UA6	60-L2-298	5/16	.340	.490	3/8	1-15/16
UA7	60-L2-299	3/8	.406	.593	15/32	2-11/32
UA7	60-L2-300	7/16	.468	.687	1/2	2-1/2
UA7	60-L2-301	1/2	.532	.781	9/16	2-11/16

Unidapt System Counterbore (Metric)

The LINK counterbore is designed to drill and counterbore in a single operation and to allow for sufficient clearance for a standard socket head cap screw.

Fits Holder Size	Part No.	Metric Screw	Drill Diameter	Counterbore DIA	Drill Length	Overall Length
UA3	72-L2-510	3 mm	3.57	5.95	6.35	31.75
UA3	72-L2-511	4 mm	4.36	7.54	7.54	34.92
UA4	72-L2-512	5 mm	5.55	9.13	7.94	38.10
UA4	72-L2-513	6 mm	6.30	10.71	9.52	39.69
UA5	72-L2-514	8 mm	8.73	13.49	11.11	46.04
UA6	72-L2-515	10 mm	10.32	16.66	14.29	52.39
UA7	72-L2-516	12 mm	12.70	18.65	15.87	61.91
UA7	72-L2-517	14 mm	14.68	21.82	16.67	66.67
UA7	72-L2-518	16 mm	16.67	24.60	17.46	69.85



Unidapt System Countersink (English)

This 82° angle countersink is designed to allow sufficient clearance for drill and chamfering for flat head and oval head screws in a single operation.

Fits Holder Size	Part No.	English Screw	Drill Diameter	Body Diameter	Drill Length	Overall Length
UA4	65-L2-285	#5	.127	5/16	11/32	1-1/4
UA4	65-L2-286	#6	.140	5/16	11/32	1-1/4
UA5	65-L2-287	#8	.166	7/16	15/32	1-5/8
UA5	65-L2-288	#10	.192	7/16	15/32	1-5/8
UA5	65-L2-289	#12	.220	7/16	1/2	1-21/32
UA6	65-L2-290	1/4	.252	1/2	17/32	1-25/32
UA7	65-L2-291	5/16	.315	5/8	21/32	2-1/8
UA7	65-L2-292	3/8	.378	3/4	25/32	2-1/2

Unidapt System Countersink (Metric)

This 90° angle countersink is designed to allow sufficient clearance for drill and chamfering for flat head and oval head screws in a single operation.

Fits Holder Size	Part No.	Metric Screw	Drill Diameter	Body Diameter	Drill Length	Overall Length
UA4	71-L2-500	3 mm	3.10	7.94	8.73	31.75
UA5	71-L2-501	4 mm	4.10	11.11	11.90	41.27
UA5	71-L2-502	5 mm	5.10	11.11	12.70	41.27
UA6	71-L2-503	6 mm	6.10	12.70	13.49	45.24
UA7	71-L2-504	8 mm	8.10	15.88	18.25	53.97
UA7	71-L2-505	10 mm	10.10	19.05	21.43	63.50
UA7	71-L2-506	12 mm	12.10	22.22	23.81	76.20

Unidapt System Spotting Drill

82°				
	Part No.			
Fits Holder Size	HSS	COBALT	Drill Diameter	Overall Length
UA3	63-L2-400	63-CO-430	1/4	2
UA4	63-L2-401	63-CO-401	3/8	2
UA5	63-L2-402	63-CO-402	7/16	2
UA6	63-L2-403	63-CO-403	1/2	2
UA7	63-L2-404	63-CO-404	5/8	2-1/4
UA7	63-L2-405	63-CO-405	3/4	2-1/4

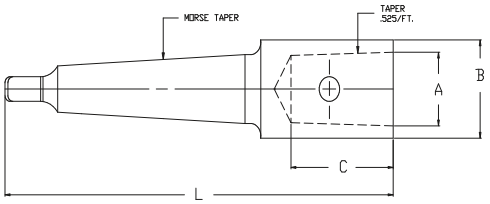
90°				
	Part No.			
Fits Holder Size	HSS	COBALT	Drill Diameter	Overall Length
UA3	63-L2-431	63-CO-432	1/4	2
UA4	63-L2-420	63-CO-420	3/8	2
UA5	63-L2-421	63-CO-421	7/16	2
UA6	63-L2-422	63-CO-422	1/2	2
UA7	63-L2-423	63-CO-423	5/8	2-1/4
UA7	63-L2-424	63-CO-424	3/4	2-1/4

120°				
	Part No.			
Fits Holder Size	HSS	COBALT	Drill Diameter	Overall Length
UA3	63-L2-433	63-CO-434	1/4	2
UA4	63-L2-425	63-CO-425	3/8	2
UA5	63-L2-426	63-CO-426	7/16	2
UA6	63-L2-427	63-CO-427	1/2	2
UA7	63-L2-428	63-CO-428	5/8	2-1/4
UA7	63-L2-429	63-CO-429	3/4	2-1/4

UNIDAPT SYSTEM

Unidapt System Morse Taper Adapter

The Unidapt Morse Taper Adapter is used in conjunction with Unidapt tapered shank tools and Unidapt Extension Adapters.



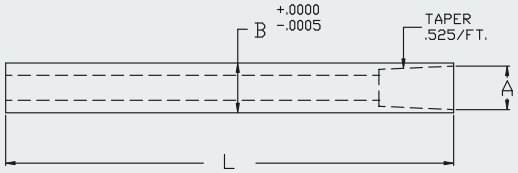
Size	Part No.	Overall Length	Inside Taper Diameter	Outside Taper Diameter
UM12 X MT1	87-L6-358	3.81	.250	.500
UM13-1 X MT1	87-L6-359	3.81	.313	.625
UM15-1 X MT1	87-L6-360	3.81	.437	.625
UM13-2 X MT2	87-L6-361	3.81	.375	.625
UM15-2 X MT2	87-L6-362	4.37	.437	.625
UM25-2 X MT2	87-L6-363	4.75	.500	.750
UM26 X MT2	87-L6-364	4.75	.625	1.000
UM27 X MT2	87-L6-365	4.75	.750	1.000

LINK Cutting Tools.

Engineered solutions made in the USA.

Unidapt Tool Holder Adapter

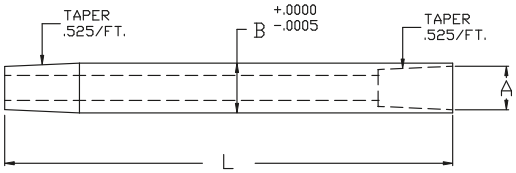
This tool holder adapter is used in conjunction with Unidapt Tapered Shank tools or the tool holder extension.



Unidapt Tool Holder Adapter				
Size	Part No.	OAL (L)	Inside Taper DIA (A)	Outside DIA (B)
UA1 X 3.5	80-L5-236	3.5	.125	.250
UA1 X 4.5	80-L5-237	4.5		
UA1 X 5.5	80-L5-238	5.5		
UA1 X 6.5	80-L5-239	6.5		
UA1 X 7.5	80-L5-240	7.5		
UA1 X 8.5	80-L5-241	8.5		
UA1 X 10	80-L5-242	10		
UA1 X 12	80-L5-288	12		
UA2 X 3.5	80-L5-243	3.5	.187	.250
UA2 X 4.5	80-L5-244	4.5		
UA2 X 5.5	80-L5-245	5.5		
UA2 X 6.5	80-L5-246	6.5		
UA2 X 7.5	80-L5-247	7.5		
UA2 X 8.5	80-L5-248	8.5		
UA2 X 10	80-L5-249	10		
UA2 X 12	80-L5-301	12		
UA3 X 3.5	80-L5-250	3.5	.250	.375
UA3 X 4.5	80-L5-251	4.5		
UA3 X 5.5	80-L5-252	5.5		
UA3 X 6.5	80-L5-253	6.5		
UA3 X 7.5	80-L5-254	7.5		
UA3 X 8.5	80-L5-255	8.5		
UA3 X 10	80-L5-256	10		
UA3 X 12	80-L5-293	12		
UA3 X 16	80-L5-296	16		
UA4 X 3.5	80-L5-257	3.5	.312	.375
UA4 X 4.5	80-L5-258	4.5		
UA4 X 5.5	80-L5-259	5.5		
UA4 X 6.5	80-L5-260	6.5		
UA4 X 7.5	80-L5-261	7.5		
UA4 X 8.5	80-L5-262	8.5		
UA4 X 10	80-L5-263	10		
UA4 X 12	80-L5-294	12		
UA4 X 16	80-L5-291	16		
UA5 X 3.5	80-L5-264	3.5	.437	.500
UA5 X 4.5	80-L5-265	4.5		
UA5 X 5.5	80-L5-266	5.5		
UA5 X 6.5	80-L5-267	6.5		
UA5 X 7.5	80-L5-268	7.5		
UA5 X 8.5	80-L5-269	8.5		
UA5 X 10	80-L5-270	10		
UA5 X 12	80-L5-286	12		
UA5 X 16	80-L5-302	16		
UA6 X 3.5	80-L5-271	3.5	.500	.625
UA6 X 4.5	80-L5-272	4.5		
UA6 X 5.5	80-L5-273	5.5		
UA6 X 6.5	80-L5-274	6.5		
UA6 X 7.5	80-L5-275	7.5		
UA6 X 8.5	80-L5-276	8.5		
UA6 X 10	80-L5-277	10		
UA6 X 12	80-L5-285	12		
UA7 X 3.5	80-L5-278	3.5	.625	.750
UA7 X 4.5	80-L5-279	4.5		
UA7 X 5.5	80-L5-280	5.5		
UA7 X 6.5	80-L5-281	6.5		
UA7 X 7.5	80-L5-282	7.5		
UA7 X 8.5	80-L5-283	8.5		
UA7 X 10	80-L5-284	10		
UA7 X 12	80-L5-287	12		

Unidapt Tool Holder Extension Adapter

This tapered shank tool holder provides an extension for the Unidapt Adapter and the Unidapt Morse Taper Sleeve.



Unidapt Tool Holder Extension Adapter				
Size	Part No.	OAL (L)	Inside Taper DIA (A)	Outside DIA (B)
UT1 X 3.5	85-L5-309	3.5	.125	.250
UT1 X 4.5	85-L5-310	4.5		
UT1 X 5.5	85-L5-311	5.5		
UT1 X 6.5	85-L5-312	6.5		
UT1 X 7.5	85-L5-313	7.5		
UT1 X 8.5	85-L5-314	8.5		
UT1 X 10	85-L5-315	10		
UT2 X 3.5	85-L5-316	3.5	.187	.250
UT2 X 4.5	85-L5-317	4.5		
UT2 X 5.5	85-L5-318	5.5		
UT2 X 6.5	85-L5-319	6.5		
UT2 X 7.5	85-L5-320	7.5		
UT2 X 8.5	85-L5-321	8.5		
UT2 X 10	85-L5-322	10		
UT3 X 3.5	85-L5-323	3.5	.250	.375
UT3 X 4.5	85-L5-324	4.5		
UT3 X 5.5	85-L5-325	5.5		
UT3 X 6.5	85-L5-326	6.5		
UT3 X 7.5	85-L5-327	7.5		
UT3 X 8.5	85-L5-328	8.5		
UT3 X 10	85-L5-329	10		
UT4 X 3.5	85-L5-330	3.5	.312	.375
UT4 X 4.5	85-L5-331	4.5		
UT4 X 5.5	85-L5-332	5.5		
UT4 X 6.5	85-L5-333	6.5		
UT4 X 7.5	85-L5-334	7.5		
UT4 X 8.5	85-L5-335	8.5		
UT4 X 10	85-L5-336	10		
UT5 X 3.5	85-L5-337	3.5	.437	.500
UT5 X 4.5	85-L5-338	4.5		
UT5 X 5.5	85-L5-339	5.5		
UT5 X 6.5	85-L5-340	6.5		
UT5 X 7.5	85-L5-341	7.5		
UT5 X 8.5	85-L5-342	8.5		
UT5 X 10	85-L5-343	10		
UT6 X 3.5	85-L5-344	3.5	.500	.625
UT6 X 4.5	85-L5-345	4.5		
UT6 X 5.5	85-L5-346	5.5		
UT6 X 6.5	85-L5-347	6.5		
UT6 X 7.5	85-L5-348	7.5		
UT6 X 8.5	85-L5-349	8.5		
UT6 X 10	85-L5-350	10		
UT7 X 3.5	85-L5-351	3.5	.625	.750
UT7 X 4.5	85-L5-352	4.5		
UT7 X 5.5	85-L5-353	5.5		
UT7 X 6.5	85-L5-354	6.5		
UT7 X 7.5	85-L5-355	7.5		
UT7 X 8.5	85-L5-356	8.5		
UT7 X 10	85-L5-357	10		

Tool Sets

Link Industries offers a wide assortment of comprehensive tool sets that are both convenient and versatile. We offer tool sets for counterbores, countersinks, flute chamfers, flute center reamers, tap wrenches, and Unidapt adapters.

UNIDAPT ADAPTER SET 29

COUNTERBORE SET (ENGLISH OR METRIC) 29

COUNTERSINK SET (ENGLISH OR METRIC) 29

SINGLE FLUTE CHAMFER SET 30

THREE FLUTE CENTER REAMER SET 30

CENTERDRILL STARTER SET 30

TAP WRENCH SET 30

NO FLUTE COUNTERSINK AND DEBURRS SET 31

SIX FLUTE COUNTERSINK SET 31

SPOT AND CENTERING DRILL SET 31

THREE FLUTE SPOT WELD DRILLS 31

Many tools are available with additional coatings. Please call for a quote! 1-800-626-9460

Link Industries reserves the right to make changes, alterations, and substitutions to the products, services, or other information presented without prior notice. For the latest information contact Link Industries.

Equipment pictured may be shown with safety equipment removed or disabled for purposes of illustration. Equipment must never be operated with safety equipment removed or disabled.

Unidapt Adapter Set

LINK Unidapt is a highly versatile system allowing you to use different styles of shanks to fit any chucking style, to combine them for extended lengths and to insert tip forms for varying any drilling operation.

Choose the tip style you want for your set.

Part No.	Description
05-L5-366	Adapter Holder Set
05-L2-370	7-Piece Stub Drill Set – R Type #1 thru #7
05-L2-371	7-Piece Stub Drill Set – S Type #11 thru #17
05-L2-372	7-Piece Stub Drill Set – ST Type #1 thru #7
05-L2-373	7-Piece Stub Drill Set – B Type #11 thru #17
05-L5-367	7-Piece Holder & Stub Drills – R Type Set #1 thru #7
05-L5-365	7-Piece Holder & Stub Drills – S Type Set #11 thru #17
05-L5-369	7-Piece Holder & Stub Drills – ST Type Set #1 thru #7
05-L5-364	7-Piece Holder & Stub Drills – B Type Set #11 thru #17

Counterbore Set (English or Metric)

The LINK Counterbore is designed to drill and counterbore in one operation and to allow for sufficient clearance for a socket head cap screw. Tool Sets are offered in both straight shank and Unidapt tapered shanks.

Part No.	Description
05-L2-376	9-Piece HSS English Set – #5 thru 1/2
05-L2-375	9-Piece HSS English Unidapt Set – #5 thru 1/2
05-L2-382	9-Piece HSS Metric Set – #3 mm thru #16 mm
05-L2-383	9-Piece HSS Metric Unidapt Set – #3 mm thru #16 mm

Countersink Set (English or Metric)

The LINK Countersink is designed for drilling and chamfering for flat head and oval head screws; 82° for English and 90° for Metric. Tools Sets are offered in both straight shank and Unidapt tapered shanks.

Part No.	Description
05-L2-369	8-Piece English Set
05-L2-374	8-Piece HSS English Unidapt Set – #5 thru 3/8
05-L2-386	7-Piece HSS Metric Set – 3 mm thru 12 mm
05-L2-387	7-Piece HSS Metric Unidapt Set – 3 mm thru 12 mm

TOOL SETS

Single Flute Chamfer Set

Link single-flute chamfer tools are ideal for a wide range of general purpose chamfering, deburring, or countersinking. The single flute design provides a smooth surface finish on a wide variety of materials.

Part No.	Description
05-L2-377	60° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-L2-550	82° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-L2-378	90° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)

Three Flute Center Reamer Set

Link three-flute center reamers are versatile tools for countersinking holes for centers or for enlarging existing holes.

Part No.	Description
05-L2-555	60° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-L2-560	82° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-L2-565	90° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)

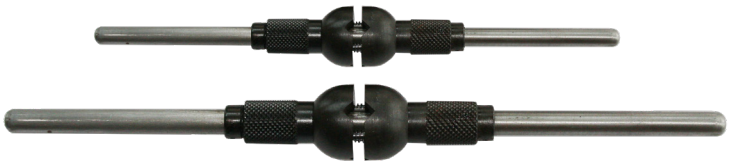
Centerdrill Starter Set

LINK Centerdrills now offered in a convenient 5-piece tool set. Offered in your choice of ST, R, S or B Type drill tip forms.

Part No.	Description
05-L2-392	R Type #2 – #6 HSS
05-L2-393	S Type #12 – #16 HSS
05-L2-394	ST Type #2 – #6 HSS
05-L2-395	B Type #12 – #16 HSS
05-TN-394	ST Type #2 – #6 HSS with TiN coating
05-CO-394	ST Type #2 – #6 Cobalt
05-CB-394	ST Type #2 – #6 Carbide

Tap Wrench

LINK Tap Wrenches are uniquely designed to assure an even distribution of forces throughout the tapping process. Each wrench features four clamping positions to provide a firm hold on the tap.



Part No.	Diameter
95-L8-418	1/16 to 1/4 Diameter (Small Wrench)
95-L8-417	1/8 to 1/2 Diameter (Large Wrench)

No Flute Countersink and Deburrs Set

LINK No-Flute Countersink and Deburring tools excel in countersinking or deburring holes in aluminum, plastics and other nonmetallic materials. Made from COBALT, these all-purpose tools provide a chatter-free smooth finish with minimal power requirements.

Part No.	Description
94-CO-569	82° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
94-CO-570	90° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)

Six Flute Countersink Set

LINK Six Flute Countersinks complement our single and three flute designs. Made from COBALT, these tools are used to countersink or enlarge existing holes at a faster rate.

Part No.	Description
05-CO-566	60° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-CO-567	82° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)
05-CO-568	90° 4-Piece Set (sizes 3/8, 1/2, ¾, 1)

Spot and Centering Drill Set

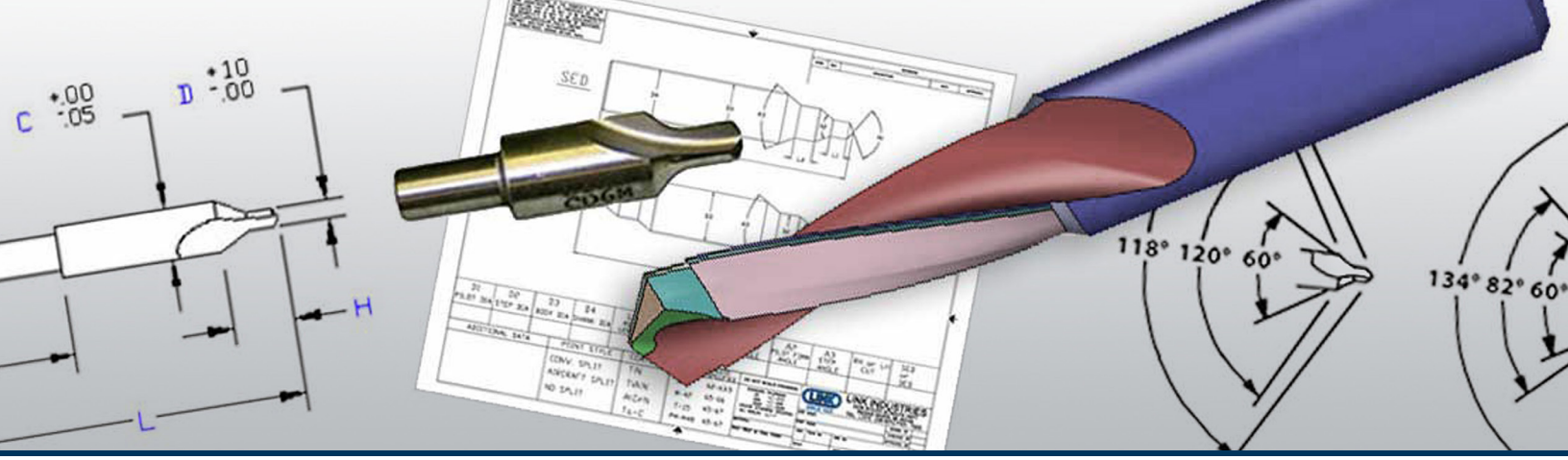
The LINK drill design is offered in both HSS and COBALT with an 82°/90°/120° point angle. Offered in short and extended lengths.

Part No.	Description
05-L2-381	82° HSS 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-L2-379	90° HSS 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-L2-380	120° HSS 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-L2-406	82° HSS Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-L2-384	90° HSS Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-L2-385	120° HSS Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-CO-386	82° Cobalt 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-CO-387	90° Cobalt 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-CO-388	120° Cobalt 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-CO-389	82° Cobalt Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-CO-390	90° Cobalt Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-CO-391	120° Cobalt Unidapt 6-Piece Set (sizes 1/4, 3/8, 7/16, 1/2, 5/8, 3/4)
05-CO-392	82° Cobalt Extended Length 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-CO-393	90° Cobalt Extended Length 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)
05-CO-395	120° Cobalt Extended Length 5-Piece Set (sizes 1/4, 3/8, 1/2, 5/8, 3/4)

Three Flute Spot Weld Drills

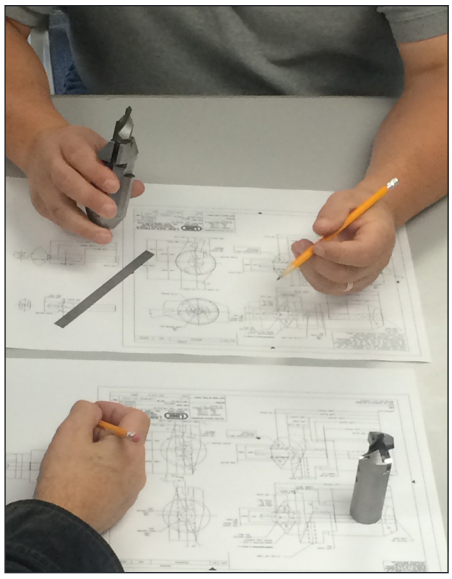
Used to drill thru automotive spot welds. Three flute designed to center itself while drilling. Offered in either T-15 HSS or Carbide, LINK Spot Weld drills are designed to drill thru most auto body metals including Boron.

Size	Part No.	Discription
8MM	99-SP-1033	for T-15 HSS with TiAlN coating
8MM	99-SP-1034	for CARBIDE with TiAlN coating



Technical Services

Link Industries provides turn-key technical services that help to keep your costs down, and make your life simpler. Our services include custom solutions, tool regrinding, tool coatings, technical information, distributor friendly packaging, and design/build guides.



ENGINEERED SOLUTION EXAMPLES 32

BLANKET ORDERING 33

TOOL COATINGS 34

TECHNICAL INFORMATION 35

DISTRIBUTOR FRIENDLY PACKAGING 36

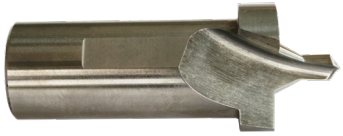
GET IN TOUCH WITH OUR TEAM 36

Engineered Solution Examples

Link Industries is prepared to provide pricing and delivery for a wide range of Special and Custom Tools. In order to define your requirements, please forward a tool print or provide tool specifications, hole patterns, sizes, flats, lubrication requirements, coolant holes, part material or any other features which may be required. You may also provide an illustration of the hole which needs to be cut and let our experienced design staff customize a tool for your needs.

Special Tool Forms

The Combination Drills and Countersinks with Special Tool Forms create desired hole patterns in a single tool. Flats and part changes enable close placement of adjacent tooling and unique drivers and locks.



Combination Drill and Spot Face Tools

The Combination Drill and Spot Face Tools allow special hole patterns to be combined with spot facing in a single tooling operation to conserve tooling costs and machining time.

Step Drills

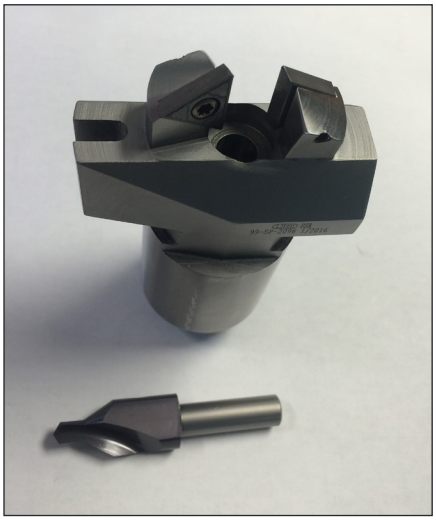
The Step Drills provide a wide array of tool forms to suit any hole pattern for single operation machining operators.

Center Drills with Thru-Tool Cooling

LINK has developed Center Drills with Thru-Tool Cooling (TTC) available for superior tool cooling, exceptional chip removal characteristics and longer tool life. This feature may be added to any custom tool, single or double ended. LINK has developed special techniques for manufacturing these tools. Several standard models are available.

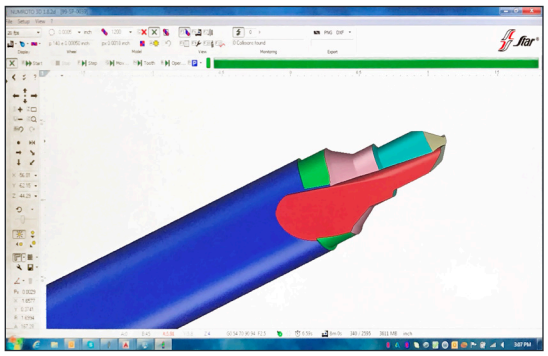
Double End Carbide Special

LINK offers Carbide non-standard tools for your specific job, give us a call.



Application Driven Solutions

LINK offers complete turn-key product solutions based on your method of work holding. We can design and build a tool for your specific application.



Blanket Order Options

LINK offers blanket order options, let us work with you to monitor your production usage. We can ship to your schedule, eliminating the hassle to remember to reorder on-time.

TECHNICAL SERVICES

Tool Coatings

LINK offers several tool coatings for our complete range of standard and custom tools to improve cutting efficiency and extend tool life. These coatings are an engineered part of each tool, and provisions are taken to assure quality and workmanship is retained. LINK can recommend the coating best suited for your specific machining application. Reasons why you may want to consider a tool coating, include:

- Increase speed and feed
- Extend tool life
- Reduce friction, spindle torque and vibration to provide a better finish
- Reduce or eliminate coolant
- Repeatable, stable tool performance

TIN (Titanium Nitride)

- Suitable for use as a general purpose coating in a wide range of materials
- Intended for moderate improvements in tool life and machining

TIALN (Titanium Aluminum Nitride)

- Aggressive machining, ideal for roughing and interrupted cuts.

ALCRN (Aluminum Chromium Nitride)

- Excellent wear resistance and thermal shock stability; outstanding in high heat applications
- Run dry or wet in extreme cutting conditions

ALU (Aluminum)

- Outstanding on aluminum with anti-galling and low friction properties, including high and low silica content.

TA-C (Hard Carbon)

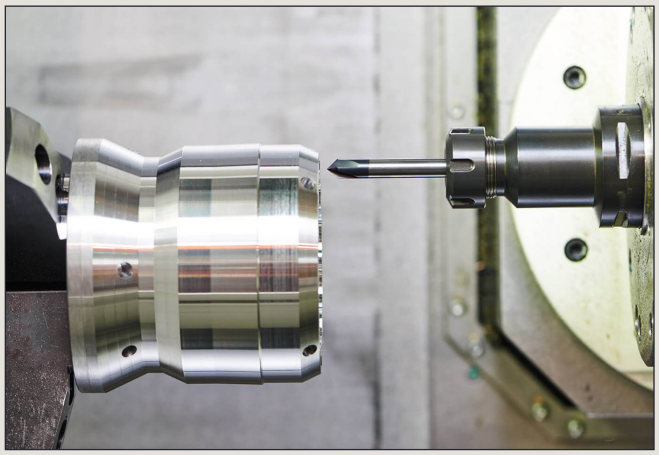
- Excellent wear resistance and adhesion properties; outstanding cut quality for aluminum and nonferrous metals such as copper and bronze.

Technical Information

Material Group		Hardness SFM	HSS SFM	COBALT SFM	T-15 SFM	CARBIDE SFM	Drill Diameter Feed Rate - IPR					
							Up to 1/8"	Up to 1/4"	Up to 3/8"	Up to 1/2"	Up to 5/8"	Up to 3/4"
Aluminum & Al-alloys		≤ 120 HB	230	260	290	350	0.003	0.004	0.005	0.007	0.009	0.010
Al Cast Alloys	≤ 10% Si	≤ 180 HB	165	195	215	250	0.003	0.004	0.005	0.007	0.009	0.010
	≤ 24% Si	≤ 180 HB	165	195	215	300	0.002	0.003	0.004	0.006	0.008	0.009
Brass	Short Chipping	≤ 180 HB	195	230	250	300	0.003	0.005	0.008	0.010	0.012	0.014
	Long Chipping	≤ 180 HB	130	150	150	200	0.003	0.005	0.008	0.010	0.012	0.014
Bronze	Short Chipping	≤ 180 HB	100	115	130	150	0.003	0.005	0.008	0.010	0.012	0.014
		≤ 25 HRC	80	110	125	145	0.003	0.005	0.008	0.010	0.012	0.014
Bronze	Long Chipping	≤ 25 HRC	50	65	75	90	0.003	0.004	0.006	0.008	0.008	0.010
		≤ 32 HRC	40	50	55	65	0.003	0.004	0.006	0.008	0.008	0.010
Cast Iron		≤ 38 HRC	100	110	120	150	0.003	0.005	0.007	0.008	0.010	0.012
Copper		≤ 80 HB	195	215	235	275	0.003	0.004	0.005	0.007	0.009	0.010
Magnesium		≤ 120 HB	230	230	250	300	0.003	0.005	0.006	0.008	0.010	0.012
Thermoplastic		≤ 120 HB	100	120	130	150	0.003	0.005	0.008	0.008	0.010	0.012
Common Structural Steels		≤ 20 HRC	100	115	125	145	0.003	0.004	0.006	0.008	0.010	0.012
		≤ 32 HRC	80	100	110	130	0.002	0.003	0.005	0.007	0.009	0.011
Free-cutting Steels		≤ 25 HRC	105	130	140	165	0.003	0.004	0.006	0.008	0.010	0.012
		≤ 32 HRC	100	130	140	165	0.002	0.003	0.005	0.007	0.009	0.011
Unalloyed Heat-Treatable Steels		≤ 20 HRC	80	115	125	145	0.003	0.004	0.006	0.008	0.010	0.012
		≤ 25 HRC	80	115	125	145	0.002	0.004	0.006	0.008	0.010	0.012
		≤ 32 HRC	65	100	110	130	0.002	0.003	0.005	0.006	0.008	0.010
Alloyed Heat-Treatable Steels		≤ 32 HRC	50	70	75	90	0.003	0.004	0.005	0.007	0.008	0.010
		≤ 42 HRC	40	55	60	70	0.002	0.003	0.004	0.005	0.006	0.008
Unalloyed Case Hardened Steels		≤ 25 HRC	100	110	120	140	0.003	0.004	0.006	0.008	0.010	0.012
Alloyed Case Hardened Steels		≤ 32 HRC	50	65	70	80	0.003	0.004	0.006	0.006	0.008	0.010
		≤ 42 HRC	25	50	55	65	0.002	0.003	0.005	0.005	0.006	0.008
Tool Steels		≤ 25 HRC	50	60	65	75	0.003	0.004	0.006	0.006	0.008	0.010
Stainless Steels	Sulphured	≤ 25 HRC	35	40	45	55	0.002	0.003	0.005	0.005	0.006	0.008
	Austenitic	≤ 35 HRC	25	35	40	50	0.002	0.003	0.005	0.005	0.006	0.008
	Martensitic	≤ 45 HRC	25	35	40	50	0.002	0.003	0.005	0.005	0.006	0.008

Speeds and Feeds are suggested starting points.

- SFM: Surface Feet per Minute
- RPM: Revolutions per Minute
- IPT: Inches per Tooth
- IPR: Inches per Revolution
- IPM: Inches per Minute
- RPM = 3.82 x (SFM ÷ Diameter)
- IPM = IPT x # of Flutes x RPM
- IPR = IPM ÷ RPM
- SFM = RPM x Diameter ÷ 3.82
- Tools with TiN Coat: Increase SFM above 5-10%
- Tools with TiAlN Coat: Increase SFM above 15-20%



WARNING: Any cutting tool may break or shatter under improper or severe use. Use appropriate safety equipment at all times in the vicinity of their use.

Distributor Friendly Packaging

Link Industries cutting tools are packaged in clear telescoping tubes or an easy to open snap pack. Each tool is packaged individually and identified with a barcode label. Our packaging makes it convenient for vending machines and will prevent the need for repacking.

Get In Touch With Our Team

The Link Industries team is dedicated to providing our customers with the most dependable cutting tools. Our team of experts are equipped to handle all of your specific tooling needs, whether you are in need of our standardized products or customized tools for your specific application, we have you covered.

Link Industries

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Indian River, MI 49749

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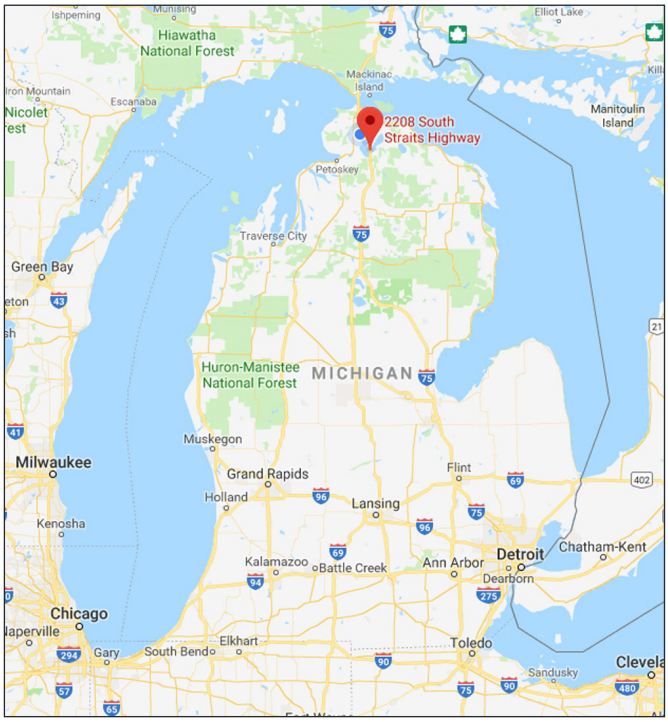
Phone: (231) 238-9012

Fax: (231) 238-7202

Email us at: sales@linkcuttingtools.com

www.linkcuttingtools.com



Link Industries excels in specialty tooling.

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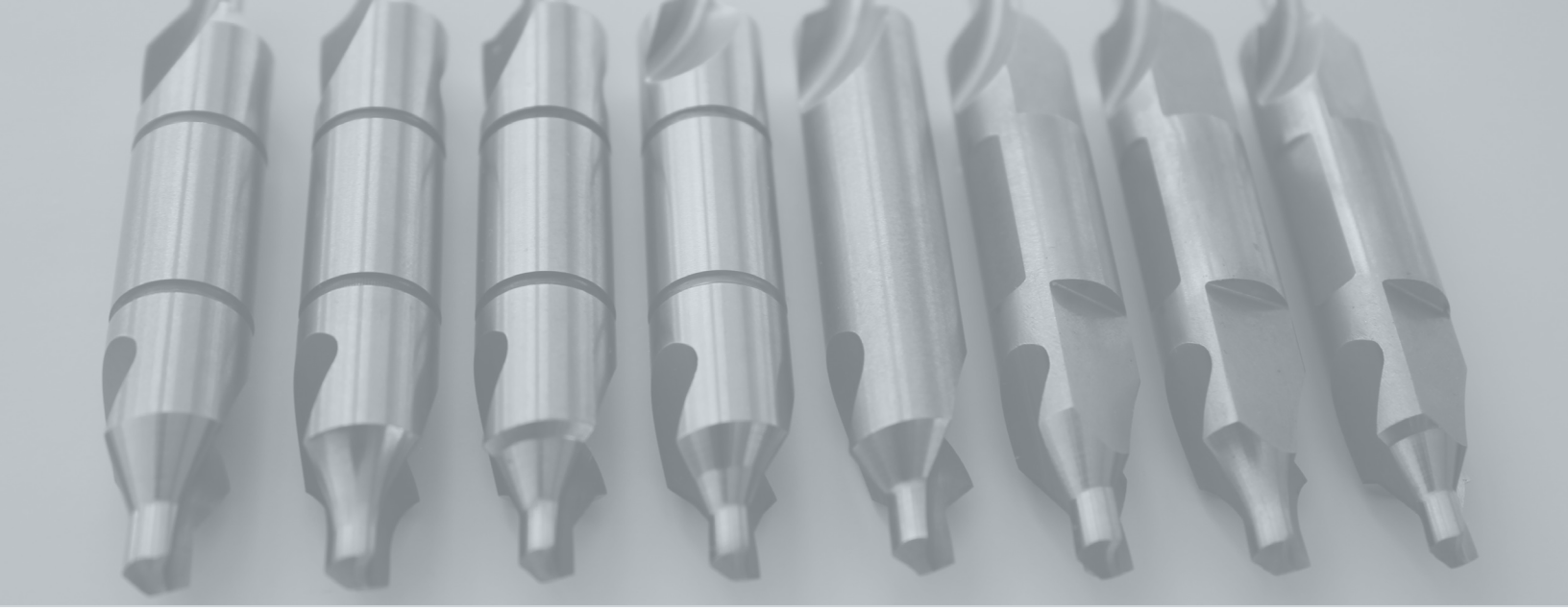
for additional information:

www.linkcuttingtools.com



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