



CLEVELAND

**The name you've trusted since 1876
for quality cutting tools.**

Cleveland has been supplying cutting tools for over 130 years. During its long history, Cleveland has earned a reputation for the highest quality tools, superior customer service, and expert technical advice. You can be assured that the Cleveland tradition continues today.

Whether you need one tool or fifty...whether you are drilling, threading, or milling...from high-performance to the best in general-purpose tools...if your need is immediate or you're planning for the future, contact your Cleveland distributor for the solution.



CLEVELAND

2501 Davis Creek Road, Seneca, SC 29678

Customer Service: telephone 800.348.2885 • fax 800.892.4290

Email: greenfield.information@gfii.com

International Sales: telephone 706.863.7708 fax 706.860.8559

Technical Support: telephone 800.892.4281 fax 706.892.4290

Cleveland is a brand of Greenfield Industries, Inc.



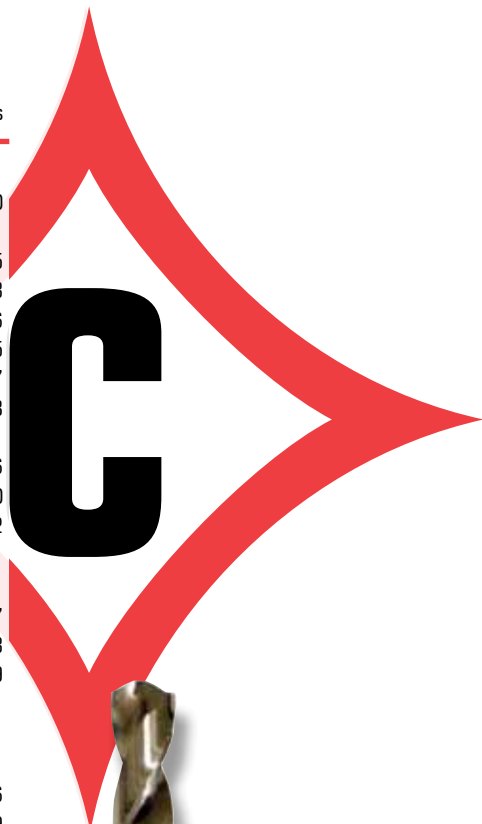
Index by Style Number (Index by Order Number starts on page 284)

	Style Number	Page Number	Style Number	Page Number	Style Number	Page Number	Style Number	Page Number
DRILLING	100	111	998	109	2412	87-90	HG-4	250-252
	102	111	1001 (countersink)	108	2440	.91	HG-4B	256
	104	112	1001 (tap)	168-172	2470	.97	HG-4C	253-255
	105	112	1001TN	168-172	2480	100-101	HG-4LL	257
	183	150-151	1002	168-172	2490	100-101	HGA-2	246
	192	274	1002TN	168-172	2510	78-81	HGC-2	235
	305	280	1003 (countersink)	108	2513	.83	HGC-2B	236
	307	280	1003 (tap)	168-172	2540	.84	HGC-4B	239
	318	281	1003TN	168-172	2550	82-83	HGC-4C	237-238
	321	280	1011	173-175	2560	.96	HGN-2	244
HOLE FINISHING	326	281	1011TN	173-175	2565	21-22	HGN-2B	245
	327	282	1012	177	2565TN	21-22	HMD-2	220
	0474	101	1053	176-177	2570	.96	HMD-2B	221
	0475	101	1091	179-180	2575	14-16	HMD-4	222
	0476	101	1092	179-180	2575T	14-16	HMDC-2	218
	610	107	1093	178	2580	.98	HMDC-4	219
	616	138	1093TN	178	2590	.99	HMG-2	223
	618	138	1094	178	2635	106	HMG-4	224
	642	139	1094TN	178	2636	105	HPDM-2	247
	650	140	1727	46-47	2645	106	PM-2	207
THREADING	655	149	1730	136	2646	105	PM-3	208
	657	141	1798	110	2727	.47	PM-4	209-210
	659	141	1980	24-25	2740	.92	PM-4B	211
	779	148	1981S JL	26-28	2745	.85	PM-4DE	206
	850	275	1982S JL	29-30	3507	275	PM-538L	217
	851	276-277	2001	40-41	3517	276-277	PM-538R	217
	852	278	2002	40-41	3722-6	.65	PM-539L	213
	853	278	2001G	34-39	3745	.95	PM-539R	212
	855	275	2002G	34-39	3780	49-51	PMRC	214
	856	276-277	2002G-TC	34-39	3780TC	49-51	PMRC-B	216
MILLING	857	278	2006	45	3780-6	52	PMRF-B	216
	858	278	2011	48	3957-6	55-56	PMRF-C	215
	860	275	2012	42-43	3957-12	55-56	RG5	258
	861	276-277	2020	44-45	4001	130-133	RG5-TA	258
	878	145	2065	17-29	4005	135	RG5-TC	258
	879	144	2065TN	17-29	4030	134-135	RG6	259
	879P	147	2075	7-10	4703	137	RG6-TA	259
	883	146	2075T	7-10	B-101	158-159, 166	RG6-TC	259
	884	146	2075N	7-10	B-202	162-163, 166	RG6B	260
	902	279	2075A	7-10	BRZT-CT	277	RG6B-TC	260
OTHER TOOLS	903	279	2120	66-67	CI-1000	164-165, 167	RG7	261
	927E	102-103	2133	68-71	CI-1000TC	164-165	RG7-TA	261
	0932	101	2165	.20	HD-2	227-228	RG7-TC	261
	940E	93-94	2165TN	.20	HD-2B	228	RG8	262
	950E	86	2175	11-13	HD-3	230	RG8-TA	262
	963B	183	2175T	11-13	HD-4	231-232	RG8-TC	262
	964B	182	2175N	11-13	HD-4C	233-234	RG8B	263
	965B	181	2175A	11-13	HD-4LH	232	RG8B-TC	263
	966B	182	2213	60-64	HDA-2	229	RG9	264
	967B	183	2222	57-59	HDC-2	225	RG9-TC	264
975	181	2228	53-54	HDC-4C	226	T-101	156-157, 166	
975TN	181	2330	75-77	HG-2	240-242	T-202	160-161, 166	
991	107	2331G	72-74	HG-2B	242	T-302	167	
995	104	2410	87-90	HG-2K	243			
996	109	2411	87-90	HG-3	248-249			



Table of Contents

Section	Pages
Drilling Tools	
High-Performance Drills	7-30
General Application Drills	
Jobber Length	34-65
Screw Machine Length	66-78
Taper Length / Extra Length	78-86
Taper Shank	87-95
Core Drills	96-97
Coolant Feed	98-103
Other Drilling Tools	
Spotting and Centering Drills	104-106
Countersinks	107-110
Drill Accessories	111-112
Reamers	
Chucking Reamers	130-137
Taper Shank Reamers	138
Taper Pipe Reamers	139
Taper Pin Reamers	140-141
Counterbores	
Interchangeable Pilot Counterbores	144-146
One-Piece Counterbores	147-149
Continuous Pilot Counterbores	150-151
Threading Tools	
High-Performance Taps	156-167
General Application Taps	
Hand Taps	144-148
Spiral Point Taps	149-153
Spiral Flute Taps	154
Forming Taps	155-156
Pipe Taps	157-159
End Mills	
PM Plus™ High-Performance End Mills	
Finishing End Mills	206-213
Roughing End Mills	214-217
Miniature End Mills	218-224
General Application End Mills	
Double End	225-234
Single End	235-257
Cobalt Roughing End Mills	258-264
Other Round Tools	
Screw Extractors	274
Tool Bits and Cut-Off Blades	275-278
Blanks	279
Milling Cutters and Saws	280-282
Drill Set Cases	282
Index by Order Number	283-319



DRILLING

HOLE FINISHING

THREADING

MILLING

OTHER TOOLS



Drilling Tools

Style Number	Description	Pages
High-Performance Drills		
2075	Q-Cobalt™ Wide Land Parabolic Jobber Length	7-10
2175	Q-Cobalt™ Wide Land Parabolic Screw Machine Length	11-13
2575	Q-Cobalt™ Wide Land Parabolic Taper Length	14-16
2065	Parabolic HSS Jobber Length	17-19
2165	Parabolic HSS Screw Machine Length	20
2565	Parabolic HSS Taper Length	21-22
1980	Q-PM™ Powder Metal Coolant Feed	24-25
1981SJL	Q-PM™ Powder Metal for Steel	26-28
1982SJL	Q-PM™ Powder Metal Drill for Cast Iron	29-30
General Application Drills		
Jobber Length		
2002G, 2001G	CLE-MAX™ General Purpose Jobber Length	34-39
2002, 2001	General Purpose Jobber length	40-41
2012	High-Helix Jobber Length	42-43
2020	Low-Helix Jobber Length	44-45
2006	Left Hand Jobber Length	45
1727	Solid Carbide Jobber Length	46-47
2727	Carbide-Tipped Jobber Length	47
2011	Heavy-Duty Cotter Pin Jobber Length	48
3780, 3780TC	Q-AMD™ Aircraft Maintenance Short Flute Jobber Length	49-51
3780-6	Q-AMD™ Aircraft Maintenance Short Flute 6" Extended Length	52
2228	NAS907 Type A General-Purpose Jobber Length	53-54
3957-6 - 3957-12	NAS907 Type A General-Purpose Extended Length	55-56
2222	NAS907 Type B Heavy-Duty Jobber Length	57-59
2213	NAS907 Type J Cobalt Heavy-Duty Jobber Length	60-64
3722-6	NAS907 Type J Cobalt Heavy-Duty 6" Extended Length	65
Screw Machine Length		
2120	General-Purpose Screw Machine Length	66-67
2133	Cobalt Heavy-Duty Screw Machine	68-71
2331G	NAS907 Type C CLE-MAX General-Purpose Stub Length	72-74
2330	NAS907 Type C Heavy-Duty Screw Machine Length	75-78
Taper Length / Extra Length		
2510	General-Purpose Taper Length	78-81
2550	High-Helix Taper Length	82-83
2513	Cobalt Heavy-Duty Taper Length	83
2540	Heavy-Duty Taper Length with Automotive Tanged Shank	84
2745	Carbide-Tipped Heavy-Duty Taper Length	85
950E	Extra Length	86
Taper Shank		
2410, 2411, 2412	Taper Shank Taper Length	87-90
2440	Cobalt Taper Shank	91
2740	Carbide-Tipped Heavy-Duty Taper Shank	92
940E	Extra Length Taper Shank	93-94
3745	Armour-Piercing Taper Shank	95
Core Drills		
2560, 2570	Three-Flute and Four-Flute Core Drill	96
2470	Taper Shank Core Drill	97
Coolant Feed		
2580	Coolant Feed, Heavy-Duty Low-Helix Straight Shank	98
2590	Coolant Feed, Heavy-Duty Straight Shank	99
2480, 2490	Coolant Feed, Taper Shank	100-101
927E	Coolant Feed, Extra Length Taper Shank	102-103



DRILLING

HOLE FINISHING

THREADING

MILLING

OTHER TOOLS

continued on next page

Table of Contents

DRILLING

HOLE FINISHING

THREADING

MILLING

OTHER TOOLS

Style Number	Description	Pages
Other Drilling Tools		
995	Spotting and Centering Drills	104
2636-2646	Cobalt NC Spotting and Centering Drills – Short and Long	105
2635-2645	HSS NC Spotting Drills – Short and Long	106
610	Countersink/Center Reamer	107
991	Four-Flute Carbide-Tipped Machine Countersink	108
1001, 1003	Single-Flute and Three-Flute Countersink	108
996, 998	Bell-Type and Plain Combined Drill and Countersink	109
1798	Solid Carbide Combined Drill and Countersink	110
100, 102	Drill Sockets	111
104, 105	Drill Reducing Sleeve and Drill Drifts	112
Technical Information		
	Drill tolerances	1
	Feeds & speeds	1-2
	Choosing the correct drill	3
	Surface treatments	4
	Ordering special drills	4
	Nomenclature	113
	Cutting speeds by drill size	114-116
	Standard dimensions	117-123
	Tang and Morse Taper specifications	123

