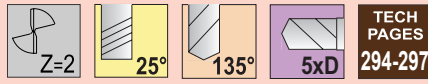


TOLERANCES

<i>d</i>	+.0000" - .0005" (+.0000 - .0127mm)	
<i>l1</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)
<i>l2</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)

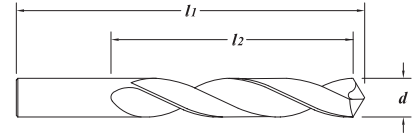
Series 1205

.0625" - .1575"
(1.588mm - 4.000mm)



General purpose for all material groups

- Solid submicron grain carbide drill
- No spotting required in most applications
- 4-facet self-centering point
- Adaptability when converting from high-speed steel
- Live tooling recommended on lathe processes
- Hardlube Coating - page 74



DRILLS

EDP#	<i>d</i> [†] Diameter		<i>l1</i> Overall Length	<i>l2</i> Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric							
89165	.0625	1/16"	1.588	1-3/4"	3/4"	6.79	6.49	6.20	5.90
89170	.0635	#52	1.613	1-3/4"	3/4"	6.89	6.59	6.29	5.99
89175	.0670	#51	1.702	1-3/4"	3/4"	6.99	6.69	6.38	6.08
89180	.0700	#50	1.778	1-3/4"	7/8"	7.16	6.85	6.54	6.23
89185	.0730	#49	1.854	1-3/4"	7/8"	7.35	7.03	6.71	6.39
89190	.0760	#48	1.930	1-3/4"	7/8"	7.59	7.26	6.93	6.60
89195	.0781	5/64"	1.984	1-3/4"	7/8"	7.88	7.54	7.19	6.85
89200	.0785	#47	1.994	1-3/4"	7/8"	8.14	7.79	7.43	7.08
89205	.0787		2.000	44	22	8.27	7.91	7.55	7.19
89210	.0810	#46	2.057	1-3/4"	7/8"	8.40	8.03	7.67	7.30
89215	.0820	#45	2.083	1-3/4"	7/8"	8.65	8.27	7.90	7.52
89220	.0860	#44	2.184	2"	1"	8.94	8.55	8.16	7.77
89225	.0890	#43	2.261	2"	1"	9.19	8.79	8.39	7.99
89230	.0935	#42	2.375	2"	1"	9.32	8.91	8.51	8.10
89235	.0938	3/32"	2.383	2"	1"	9.53	9.12	8.70	8.29
89240	.0960	#41	2.438	2"	1"	9.61	9.20	8.78	8.36
89245	.0980	#40	2.489	2"	1"	9.76	9.34	8.91	8.49
89250	.0984		2.500	57	32	9.81	9.38	8.96	8.53
89255	.0995	#39	2.527	2-1/4"	1-1/4"	9.86	9.43	9.00	8.57
89260	.1015	#38	2.578	2-1/4"	1-1/4"	9.98	9.55	9.11	8.68
89265	.1040	#37	2.642	2-1/4"	1-1/4"	10.11	9.67	9.23	8.79
89270	.1065	#36	2.705	2-1/4"	1-1/4"	10.24	9.79	9.35	8.90
89275	.1094	7/64"	2.779	2-1/4"	1-1/4"	10.41	9.96	9.50	9.05
89280	.1100	#35	2.794	2-1/4"	1-1/4"	10.52	10.07	9.61	9.15
89285	.1110	#34	2.819	2-1/4"	1-1/4"	10.65	10.19	9.72	9.26
89290	.1130	#33	2.870	2-1/4"	1-1/4"	10.84	10.37	9.90	9.43
89295	.1160	#32	2.946	2-1/4"	1-1/4"	10.96	10.48	10.01	9.53
89300	.1181		3.000	57	32	11.07	10.59	10.11	9.63
89305	.1200	#31	3.048	2-1/4"	1-1/4"	11.14	10.66	10.17	9.69
89310	.1250	1/8"	3.175	2-1/4"	1-1/4"	11.28	10.79	10.30	9.81
89315	.1285	#30	3.264	2-1/4"	1-1/4"	11.57	11.07	10.56	10.06
89320	.1360	#29	3.454	2-1/2"	1-3/8"	11.93	11.41	10.89	10.37
89325	.1378		3.500	63	35	12.32	11.78	11.25	10.71
89330	.1405	#28	3.569	2-1/2"	1-3/8"	12.44	11.90	11.36	10.82
89335	.1406	9/64"	3.571	2-1/2"	1-3/8"	12.58	12.03	11.49	10.94
89340	.1440	#27	3.658	2-1/2"	1-3/8"	13.08	12.51	11.94	11.37
89345	.1470	#26	3.734	2-1/2"	1-3/8"	13.21	12.64	12.06	11.49
89350	.1495	#25	3.797	2-1/2"	1-3/8"	13.39	12.80	12.22	11.64
89355	.1520	#24	3.861	2-1/2"	1-3/8"	13.41	12.83	12.24	11.66
89360	.1540	#23	3.912	2-1/2"	1-3/8"	13.50	12.91	12.33	11.74
89365	.1562	5/32"	3.967	2-1/2"	1-3/8"	13.59	13.00	12.41	11.82
89370	.1570	#22	3.988	2-1/2"	1-3/8"	14.44	13.82	13.19	12.56
89375	.1575		4.000	63	35	14.63	13.99	13.36	12.72

continued →

Series 1205 (continued)

.1590" - .3346"
(4.039mm - 8.500mm)

DRILLS

EDP#	d^{\dagger} Diameter		l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric							
89380	.1590	#21	4.039	2-1/2"	1-3/8"	14.80	14.16	13.51	12.87
89385	.1610	#20	4.089	2-1/2"	1-3/8"	14.90	14.26	13.61	12.96
89390	.1660	#19	4.216	2-3/4"	1-5/8"	15.51	14.84	14.16	13.49
89395	.1695	#18	4.305	2-3/4"	1-5/8"	15.71	15.03	14.34	13.66
89400	.1719	11/64"	4.366	2-3/4"	1-5/8"	16.03	15.33	14.64	13.94
89405	.1730	#17	4.394	2-3/4"	1-5/8"	16.25	15.54	14.84	14.13
89410	.1770	#16	4.496	2-3/4"	1-5/8"	16.43	15.72	15.00	14.29
89415	.1772		4.500	70	41	16.51	15.80	15.08	14.36
89420	.1800	#15	4.572	2-3/4"	1-5/8"	16.58	15.86	15.14	14.42
89425	.1820	#14	4.623	2-3/4"	1-5/8"	16.96	16.23	15.49	14.75
89430	.1850	#13	4.700	2-3/4"	1-5/8"	17.10	16.36	15.61	14.87
89435	.1875	3/16"	4.763	2-3/4"	1-5/8"	17.17	16.42	15.68	14.93
89440	.1890	#12	4.801	2-3/4"	1-5/8"	17.73	16.96	16.19	15.42
89445	.1910	#11	4.851	2-3/4"	1-5/8"	17.93	17.15	16.37	15.59
89450	.1935	#10	4.915	2-3/4"	1-5/8"	18.78	17.96	17.15	16.33
89455	.1960	#9	4.978	3"	1-3/4"	19.25	18.41	17.58	16.74
89460	.1969		5.000	76	44	19.37	18.52	17.68	16.84
89465	.1990	#8	5.055	3"	1-3/4"	19.49	18.65	17.80	16.95
89470	.2010	#7	5.105	3"	1-3/4"	20.07	19.20	18.32	17.45
89475	.2031	13/64"	5.159	3"	1-3/4"	20.22	19.34	18.46	17.58
89480	.2040	#6	5.182	3"	1-3/4"	20.63	19.73	18.84	17.94
89485	.2055	#5	5.220	3"	1-3/4"	21.06	20.14	19.23	18.31
89490	.2090	#4	5.309	3"	1-3/4"	21.42	20.49	19.56	18.63
89495	.2130	#3	5.410	3"	1-3/4"	21.79	20.85	19.90	18.95
89500	.2165		5.500	76	44	21.97	21.01	20.06	19.10
89505	.2188	7/32"	5.558	3"	1-3/4"	22.13	21.16	20.20	19.24
89510	.2210	#2	5.613	3"	1-3/4"	22.67	21.68	20.70	19.71
89515	.2280	#1	5.791	3"	1-3/4"	22.80	21.81	20.82	19.83
89520	.2340	A	5.944	3-1/4"	2"	23.07	22.07	21.06	20.06
89525	.2344	15/64"	5.954	3-1/4"	2"	23.13	22.12	21.12	20.11
89530	.2362		6.000	82	50	23.22	22.21	21.20	20.19
89535	.2380	B	6.045	3-1/4"	2"	23.30	22.29	21.27	20.26
89540	.2420	C	6.147	3-1/4"	2"	23.47	22.45	21.43	20.41
89545	.2460	D	6.248	3-1/4"	2"	23.64	22.62	21.59	20.56
89550	.2500	1/4" / E	6.350	3-1/4"	2"	23.81	22.77	21.74	20.70
89555	.2559		6.500	82	50	24.39	23.33	22.27	21.21
89560	.2570	F	6.528	3-1/4"	2"	24.89	23.80	22.72	21.64
89565	.2610	G	6.629	3-1/2"	2-1/8"	25.40	24.30	23.19	22.09
89570	.2656	17/64"	6.746	3-1/2"	2-1/8"	25.91	24.78	23.66	22.53
89575	.2660	H	6.756	3-1/2"	2-1/8"	26.66	25.50	24.34	23.18
89580	.2720	I	6.909	3-1/2"	2-1/8"	26.96	25.78	24.61	23.44
89585	.2756		7.000	88	54	27.17	25.99	24.81	23.63
89590	.2770	J	7.036	3-1/2"	2-1/8"	27.42	26.22	25.03	23.84
89595	.2810	K	7.137	3-1/2"	2-1/8"	27.66	26.46	25.25	24.05
89600	.2812	9/32"	7.142	3-1/2"	2-1/8"	27.83	26.62	25.41	24.20
89605	.2900	L	7.366	3-1/2"	2-1/8"	28.83	27.58	26.32	25.07
89610	.2950	M	7.493	3-3/4"	2-3/8"	30.85	29.51	28.17	26.83
89615	.2953		7.500	95	60	30.85	29.51	28.17	26.83
89620	.2969	19/64"	7.541	3-3/4"	2-3/8"	30.85	29.51	28.17	26.83
89625	.3020	N	7.671	3-3/4"	2-3/8"	32.69	31.27	29.85	28.43
89630	.3125	5/16"	7.938	3-3/4"	2-3/8"	32.81	31.38	29.96	28.53
89635	.3150		8.000	95	60	35.20	33.67	32.14	30.61
89640	.3160	O	8.026	3-3/4"	2-3/8"	35.20	33.67	32.14	30.61
89645	.3230	P	8.204	3-3/4"	2-3/8"	35.20	33.67	32.14	30.61
89650	.3281	21/64"	8.334	4"	2-1/2"	35.73	34.18	32.62	31.07
89655	.3320	Q	8.433	4"	2-1/2"	36.56	34.97	33.38	31.79
89660	.3346		8.500	101	63	36.88	35.28	33.67	32.07

EDP#	d^{\dagger} Diameter		l_1 Overall Length	l_2 Flute Length	1-11	12-24	25-49	50-100	
	Decimal	Metric							
89665	.3390	R	8.611	4"	2-1/2"	38.07	36.41	34.76	33.10
89670	.3438	11/32"	8.733	4"	2-1/2"	39.61	37.88	36.16	34.44
89675	.3480	S	8.839	4"	2-1/2"	39.74	38.02	36.29	34.56
89680	.3543		9.000	101	63	39.97	38.24	36.50	34.76
89685	.3580	T	9.093	4-1/4"	2-3/4"	40.34	38.59	36.83	35.08
89690	.3594	23/64"	9.129	4-1/4"	2-3/4"	40.62	38.85	37.09	35.32
89695	.3680	U	9.347	4-1/4"	2-3/4"	46.10	44.10	42.09	40.09
89700	.3740		9.500	107	70	46.53	44.51	42.48	40.46
89705	.3750	3/8"	9.525	4-1/4"	2-3/4"	46.90	44.86	42.82	40.78
89710	.3770	V	9.576	4-1/4"	2-3/4"	47.78	45.71	43.63	41.55
89715	.3860	W	9.804	4-1/2"	2-7/8"	48.81	46.68	44.56	42.44
89720	.3906	25/64"	9.921	4-1/2"	2-7/8"	49.53	47.38	45.22	43.07
89725	.3937		10.000	114	73	51.31	49.08	46.85	44.62
89730	.3970	X	10.084	4-1/2"	2-7/8"	52.82	50.52	48.23	45.93
89735	.4040	Y	10.262	4-1/2"	2-7/8"	53.25	50.93	48.62	46.30
89740	.4062	13/32"	10.317	4-1/2"	2-7/8"	55.17	52.77	50.37	47.97
89745	.4130	Z	10.490	4-1/2"	2-7/8"	55.75	53.33	50.90	48.48
89750	.4134		10.500	114	73	55.75	53.33	50.90	48.48
89755	.4219	27/64"	10.716	4-1/2"	2-7/8"	56.37	53.92	51.47	49.02
89760	.4331		11.000	114	73	61.21	58.55	55.89	53.23
89765	.4375	7/16"	11.113	4-1/2"	2-7/8"	61.21	58.55	55.89	53.23
89770	.4528		11.500	120	76	66.40	63.51	60.63	57.74
89775	.4531	29/64"	11.509	4-3/4"	3"	66.40	63.51	60.63	57.74
89780	.4688	15/32"	11.908	4-3/4"	3"	70.24	67.19	64.13	61.08
89785	.4724		12.000	120	76	70.47	67.41	64.34	61.28
89790	.4844	31/64"	12.304	4-3/4"	3"	70.47	67.41	64.34	61.28
89795	.4921		12.500	120	76	72.35	69.20	66.06	62.91
89800	.5000	1/2"	12.700	4-3/4"	3"	72.35	69.20	66.06	62.91
89805	.5118		13.000	127	83	90.90	86.94	82.99	79.04
89810	.5156	33/64"	13.096	5"	3-1/4"	93.33	89.28	85.22	81.16
89815	.5312	17/32"	13.492	5"	3-1/4"	95.77	91.61	87.44	83.28
89820	.5315		13.500	127	83	98.21	93.94	89.67	85.40
89825	.5469	35/64"	13.891	5"	3-1/4"	100.65	96.27	91.90	87.52
89830	.5512		14.000	127	83	103.10	98.62	94.13	89.65
89835	.5625	9/16"	14.287	5"	3-1/4"	112.42	107.54	102.65	97.76
89840	.5709		14.500	127	83	114.77	109.78	104.79	99.80
89845	.5781	37/64"	14.683	5-1/4"	3-1/2"	117.12	112.02	106.93	101.84
89850	.5906		15.000	133	89	119.50	114.30	109.11	103.91
89855	.5938	19/32"	15.082	5-1/4"	3-1/2"	120.19	114.96	109.74	104.51
89860	.6094	39/64"	15.478	5-1/4"	3-1/2"	120.85	115.60	110.34	105.09
89865	.6102		15.500	133	89	121.54	116.26	110.97	105.69
89870	.6250	5/8"	15.875	5-1/4"	3-1/2"	122.21	116.90	111.58	106.27
89875	.6299		16.000	133	89	125.48	120.02	114.57	109.11