

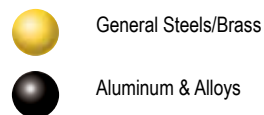
# 5xD

# Series 207

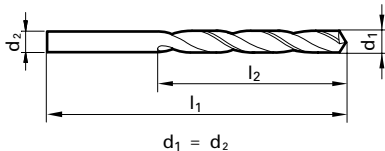
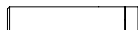
## Application Materials:



**High Helix**  
**HSS, High Helix (Type W), jobber length, 130° point, Form A web thinned**  
**>14.0mm dia., standard straight shank, RH helix**



Cut / Shank Dia. = h8 tolerance range



Speeds & Feeds  
 information pg 425

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter mm				
0.0079		92	0.200	19.00	2.50	9002070002000
0.0118			0.300	19.00	3.00	9002070003000
0.0138			0.350	19.00	4.00	9002070003500
0.0157	1/64		0.400	20.00	5.00	9002070004000
0.0177			0.450	20.00	5.00	9002070004500
0.0181		77	0.460	20.00	5.00	9002070004600
0.0197			0.500	22.00	6.00	9002070005000
0.0201		76	0.510	22.00	6.00	9002070005100
0.0217			0.550	24.00	7.00	9002070005500
0.0224		74	0.570	24.00	7.00	9002070005700
0.0236			0.600	24.00	7.00	9002070006000
0.0240		73	0.610	26.00	8.00	9002070006100
0.0244			0.620	26.00	8.00	9002070006200
0.0252		72	0.640	26.00	8.00	9002070006400
0.0256			0.650	26.00	8.00	9002070006500
0.0260		71	0.660	26.00	8.00	9002070006600
0.0276			0.700	28.00	9.00	9002070007000
0.0295			0.750	28.00	9.00	9002070007500
0.0307			0.780	30.00	10.00	9002070007800
0.0311	1/32	68	0.790	30.00	10.00	9002070007900
0.0315			0.800	30.00	10.00	9002070008000
0.0319		67	0.810	30.00	10.00	9002070008100
0.0331		66	0.840	30.00	10.00	9002070008400
0.0335			0.850	30.00	10.00	9002070008500
0.0339			0.860	32.00	11.00	9002070008600
0.0343			0.870	32.00	11.00	9002070008700
0.0354			0.900	32.00	11.00	9002070009000
0.0374			0.950	32.00	11.00	9002070009500
0.0382		62	0.970	34.00	12.00	9002070009700
0.0386			0.980	34.00	12.00	9002070009800
0.0390		61	0.990	34.00	12.00	9002070009900
0.0394			1.000	34.00	12.00	9002070010000
0.0398			1.010	34.00	12.00	9002070010100
0.0402		60	1.020	34.00	12.00	9002070010200
0.0413			1.050	34.00	12.00	9002070010500
0.0421		58	1.070	36.00	14.00	9002070010700
0.0425			1.080	36.00	14.00	9002070010800
0.0433			1.100	36.00	14.00	9002070011000
0.0441			1.120	36.00	14.00	9002070011200
0.0453			1.150	36.00	14.00	9002070011500
0.0465		56	1.180	36.00	14.00	9002070011800
0.0469	3/64		1.190	38.00	16.00	9002070011900
0.0472			1.200	38.00	16.00	9002070012000
0.0480			1.220	38.00	16.00	9002070012200
0.0492			1.250	38.00	16.00	9002070012500
0.0500			1.270	38.00	16.00	9002070012700
0.0512			1.300	38.00	16.00	9002070013000
0.0516			1.310	38.00	16.00	9002070013100
0.0524			1.330	40.00	18.00	9002070013300
0.0531			1.350	40.00	18.00	9002070013500
0.0543			1.380	40.00	18.00	9002070013800
0.0551		54	1.400	40.00	18.00	9002070014000
0.0559			1.420	40.00	18.00	9002070014200
0.0563			1.430	40.00	18.00	9002070014300

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter mm				
0.0571			1.450	40.00	18.00	9002070014500
0.0579			1.470	40.00	18.00	9002070014700
0.0591			1.500	40.00	18.00	9002070015000
0.0594		53	1.510	43.00	20.00	9002070015100
0.0610			1.550	43.00	20.00	9002070015500
0.0622			1.580	43.00	20.00	9002070015800
0.0626		1/16	1.590	43.00	20.00	9002070015900
0.0630			1.600	43.00	20.00	9002070016000
0.0634		52	1.610	43.00	20.00	9002070016100
0.0650			1.650	43.00	20.00	9002070016500
0.0669		51	1.700	43.00	20.00	9002070017000
0.0689			1.750	46.00	22.00	9002070017500
0.0693			1.760	46.00	22.00	9002070017600
0.0697			1.770	46.00	22.00	9002070017700
0.0701		50	1.780	46.00	22.00	9002070017800
0.0709			1.800	46.00	22.00	9002070018000
0.0728		49	1.850	46.00	22.00	9002070018500
0.0748			1.900	46.00	22.00	9002070019000
0.0760		48	1.930	49.00	24.00	9002070019300
0.0768			1.950	49.00	24.00	9002070019500
0.0780		5/64	1.980	49.00	24.00	9002070019800
0.0787			2.000	49.00	24.00	9002070020000
0.0795			2.020	49.00	24.00	9002070020200
0.0807			2.050	49.00	24.00	9002070020500
0.0811		46	2.060	49.00	24.00	9002070020600
0.0819		45	2.080	49.00	24.00	9002070020800
0.0827			2.100	49.00	24.00	9002070021000
0.0846			2.150	53.00	27.00	9002070021500
0.0866			2.200	53.00	27.00	9002070022000
0.0874			2.220	53.00	27.00	9002070022200
0.0886			2.250	53.00	27.00	9002070022500
0.0906			2.300	53.00	27.00	9002070023000
0.0913			2.320	53.00	27.00	9002070023200
0.0925			2.350	53.00	27.00	9002070023500
0.0937		3/32	2.380	57.00	30.00	9002070023800
0.0945			2.400	57.00	30.00	9002070024000
0.0965			2.450	57.00	30.00	9002070024500
0.0980		40	2.490	57.00	30.00	9002070024900
0.0984			2.500	57.00	30.00	9002070025000
0.0996		39	2.530	57.00	30.00	9002070025300
0.1004			2.550	57.00	30.00	9002070025500
0.1016		38	2.580	57.00	30.00	9002070025800
0.1024			2.600	57.00	30.00	9002070026000
0.1043			2.650	57.00	30.00	9002070026500
0.1063			2.700	61.00	33.00	9002070027000
0.1071			2.720	61.00	33.00	9002070027200
0.1075			2.730	61.00	33.00	9002070027300
0.1083			2.750	61.00	33.00	9002070027500
0.1094		7/64	2.780	61.00	33.00	9002070027800
0.1102			2.800	61.00	33.00	9002070028000
0.1110		34	2.820	61.00	33.00	9002070028200
0.1122			2.850	61.00	33.00	9002070028500
0.1142			2.900	61.00	33.00	9002070029000
0.1161		32	2.950	61.00	33.00	9002070029500

\*Items listed in red are non-stocked items, and may take 2 - 6 weeks to receive

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Twist Drills

Dec. inch	Diameter (d1)			I1 mm	I2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.1181			3.000	61.00	33.00	9002070030000
0.1193			3.030	65.00	36.00	9002070030300
0.1201		31	3.050	65.00	36.00	9002070030500
0.1205			3.060	65.00	36.00	9002070030600
0.1220			3.100	65.00	36.00	9002070031000
0.1240			3.150	65.00	36.00	9002070031500
0.1248		1/8	3.170	65.00	36.00	9002070031700
0.1260			3.200	65.00	36.00	9002070032000
0.1280			3.250	65.00	36.00	9002070032500
0.1283		30	3.260	65.00	36.00	9002070032600
0.1299			3.300	65.00	36.00	9002070033000
0.1319			3.350	65.00	36.00	9002070033500
0.1339			3.400	70.00	39.00	9002070034000
0.1358		29	3.450	70.00	39.00	9002070034500
0.1378			3.500	70.00	39.00	9002070035000
0.1390			3.530	70.00	39.00	9002070035300
0.1398			3.550	70.00	39.00	9002070035500
0.1406		9/64	3.570	70.00	39.00	9002070035700
0.1417			3.600	70.00	39.00	9002070036000
0.1437			3.650	70.00	39.00	9002070036500
0.1457			3.700	70.00	39.00	9002070037000
0.1469		26	3.730	70.00	39.00	9002070037300
0.1476			3.750	70.00	39.00	9002070037500
0.1496		25	3.800	75.00	43.00	9002070038000
0.1516			3.850	75.00	43.00	9002070038500
0.1535			3.900	75.00	43.00	9002070039000
0.1555			3.950	75.00	43.00	9002070039500
0.1563		5/32	3.970	75.00	43.00	9002070039700
0.1575			4.000	75.00	43.00	9002070040000
0.1591		21	4.040	75.00	43.00	9002070040400
0.1594			4.050	75.00	43.00	9002070040500
0.1614			4.100	75.00	43.00	9002070041000
0.1634			4.150	75.00	43.00	9002070041500
0.1654			4.200	75.00	43.00	9002070042000
0.1661		19	4.220	75.00	43.00	9002070042200
0.1673			4.250	75.00	43.00	9002070042500
0.1693		18	4.300	80.00	47.00	9002070043000
0.1713			4.350	80.00	47.00	9002070043500
0.1732			4.400	80.00	47.00	9002070044000
0.1772		16	4.500	80.00	47.00	9002070045000
0.1811			4.600	80.00	47.00	9002070046000
0.1831			4.650	80.00	47.00	9002070046500
0.1850		13	4.700	80.00	47.00	9002070047000
0.1870			4.750	80.00	47.00	9002070047500
0.1874		3/16	4.760	86.00	52.00	9002070047600
0.1890		12	4.800	86.00	52.00	9002070048000
0.1909		11	4.850	86.00	52.00	9002070048500
0.1929			4.900	86.00	52.00	9002070049000
0.1949			4.950	86.00	52.00	9002070049500
0.1969			5.000	86.00	52.00	9002070050000
0.1988			5.050	86.00	52.00	9002070050500
0.2008			5.100	86.00	52.00	9002070051000
0.2031		13/64	5.160	86.00	52.00	9002070051600
0.2047			5.200	86.00	52.00	9002070052000
0.2067			5.250	86.00	52.00	9002070052500
0.2087			5.300	86.00	52.00	9002070053000
0.2126			5.400	93.00	57.00	9002070054000
0.2146			5.450	93.00	57.00	9002070054500
0.2165			5.500	93.00	57.00	9002070055000
0.2189		7/32	5.560	93.00	57.00	9002070055600
0.2205			5.600	93.00	57.00	9002070056000
0.2244			5.700	93.00	57.00	9002070057000
0.2264			5.750	93.00	57.00	9002070057500
0.2283			5.800	93.00	57.00	9002070058000
0.2303			5.850	93.00	57.00	9002070058500
0.2323			5.900	93.00	57.00	9002070059000
0.2343		15/64	5.950	93.00	57.00	9002070059500
0.2362			6.000	93.00	57.00	9002070060000
0.2402			6.100	101.00	63.00	9002070061000
0.2421		C	6.150	101.00	63.00	9002070061500

Dec. inch	Diameter (d1)			I1 mm	I2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.2441			6.200	101.00	63.00	9002070062000
0.2461		D	6.250	101.00	63.00	9002070062500
0.2480			6.300	101.00	63.00	9002070063000
0.2500		1/4	6.350	101.00	63.00	9002070063500
0.2520			6.400	101.00	63.00	9002070064000
0.2559			6.500	101.00	63.00	9002070065000
0.2571		F	6.530	101.00	63.00	9002070065300
0.2598			6.600	101.00	63.00	9002070066000
0.2618			6.650	101.00	63.00	9002070066500
0.2638			6.700	101.00	63.00	9002070067000
0.2657		17/64	6.750	109.00	69.00	9002070067500
0.2677			6.800	109.00	69.00	9002070068000
0.2697			6.850	109.00	69.00	9002070068500
0.2717		I	6.900	109.00	69.00	9002070069000
0.2736			6.950	109.00	69.00	9002070069500
0.2756			7.000	109.00	69.00	9002070070000
0.2776			7.050	109.00	69.00	9002070070500
0.2795			7.100	109.00	69.00	9002070071000
0.2811		9/32	7.140	109.00	69.00	9002070071400
0.2835			7.200	109.00	69.00	9002070072000
0.2854			7.250	109.00	69.00	9002070072500
0.2874			7.300	109.00	69.00	9002070073000
0.2913			7.400	109.00	69.00	9002070074000
0.2953			7.500	109.00	69.00	9002070075000
0.2969		19/64	7.540	117.00	75.00	9002070075400
0.2992			7.600	117.00	75.00	9002070076000
0.3031			7.700	117.00	75.00	9002070077000
0.3051			7.750	117.00	75.00	9002070077500
0.3071			7.800	117.00	75.00	9002070078000
0.3110			7.900	117.00	75.00	9002070079000
0.3126		5/16	7.940	117.00	75.00	9002070079400
0.3150			8.000	117.00	75.00	9002070080000
0.3161		O	8.030	117.00	75.00	9002070080300
0.3189			8.100	117.00	75.00	9002070081000
0.3209			8.150	117.00	75.00	9002070081500
0.3228		P	8.200	117.00	75.00	9002070082000
0.3248			8.250	117.00	75.00	9002070082500
0.3268			8.300	117.00	75.00	9002070083000
0.3307			8.400	117.00	75.00	9002070084000
0.3346			8.500	117.00	75.00	9002070085000
0.3386			8.600	125.00	81.00	9002070086000
0.3425			8.700	125.00	81.00	9002070087000
0.3437		11/32	8.730	125.00	81.00	9002070087300
0.3445			8.750	125.00	81.00	9002070087500
0.3465			8.800	125.00	81.00	9002070088000
0.3480		S	8.840	125.00	81.00	9002070088400
0.3504			8.900	125.00	81.00	9002070089000
0.3543			9.000	125.00	81.00	9002070090000
0.3579		T	9.090	125.00	81.00	9002070090900
0.3583			9.100	125.00	81.00	9002070091000
0.3594		23/64	9.130	125.00	81.00	9002070091300
0.3622			9.200	125.00	81.00	9002070092000
0.3661			9.300	125.00	81.00	9002070093000
0.3677		U	9.340	125.00	81.00	9002070093400
0.3701			9.400	125.00	81.00	9002070094000
0.3740			9.500	125.00	81.00	9002070095000
0.3748		3/8	9.520	133.00	87.00	9002070095200
0.3780			9.600	133.00	87.00	9002070096000
0.3819			9.700	133.00	87.00	9002070097000
0.3858		W	9.800	133.00	87.00	9002070098000
0.3898			9.900	133.00	87.00	9002070099000
0.3906		25/64	9.920	133.00	87.00	9002070099200
0.3937			10.000	133.00	87.00	9002070100000
0.3969		X	10.080	133.00	87.00	9002070100800
0.3976			10.100	133.00	87.00	9002070101000
0.4016			10.200	133.00	87.00	9002070102000
0.4035			10.250	133.00	87.00	9002070102500
0.4039		Y	10.260	133.00	87.00	9002070102600
0.4055			10.300	133.00	87.00	9002070103000
0.4063		13/32	10.320	133.00	87.00	9002070103200

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Dec. inch	Diameter (d1)		I1 mm	I2 mm	EDP #	
	Fract. inch	Wire / letter				
0.4094			10.400	133.00	87.00	9002070104000
0.4134			10.500	133.00	87.00	9002070105000
0.4173			10.600	133.00	87.00	9002070106000
0.4213			10.700	142.00	94.00	9002070107000
0.4232			10.750	142.00	94.00	9002070107500
0.4252			10.800	142.00	94.00	9002070108000
0.4291			10.900	142.00	94.00	9002070109000
0.4331			11.000	142.00	94.00	9002070110000
0.4370			11.100	142.00	94.00	9002070111000
0.4374	7/16		11.110	142.00	94.00	9002070111100
0.4409			11.200	142.00	94.00	9002070112000
0.4429			11.250	142.00	94.00	9002070112500
0.4449			11.300	142.00	94.00	9002070113000
0.4488			11.400	142.00	94.00	9002070114000
0.4528			11.500	142.00	94.00	9002070115000
0.4531	29/64		11.510	142.00	94.00	9002070115100
0.4567			11.600	142.00	94.00	9002070116000
0.4606			11.700	142.00	94.00	9002070117000
0.4626			11.750	142.00	94.00	9002070117500
0.4646			11.800	142.00	94.00	9002070118000
0.4685			11.900	151.00	101.00	9002070119000
0.4724			12.000	151.00	101.00	9002070120000
0.4764			12.100	151.00	101.00	9002070121000
0.4843	31/64		12.300	151.00	101.00	9002070123000
0.4921			12.500	151.00	101.00	9002070125000
0.4961			12.600	151.00	101.00	9002070126000
0.5000	1/2		12.700	151.00	101.00	9002070127000

Dec. inch	Diameter (d1)		I1 mm	I2 mm	EDP #	
	Fract. inch	Wire / letter				
0.5039			12.800	151.00	101.00	9002070128000
0.5079			12.900	151.00	101.00	9002070129000
0.5118			13.000	151.00	101.00	9002070130000
0.5157	33/64		13.100	151.00	101.00	9002070131000
0.5197			13.200	151.00	101.00	9002070132000
0.5315			13.500	160.00	108.00	9002070135000
0.5433			13.800	160.00	108.00	9002070138000
0.5512			14.000	160.00	108.00	9002070140000
0.5709			14.500	169.00	114.00	9002070145000
0.5787			14.700	169.00	114.00	9002070147000
0.5827			14.800	169.00	114.00	9002070148000
0.5906			15.000	169.00	114.00	9002070150000
0.5984			15.200	178.00	120.00	9002070152000
0.6102			15.500	178.00	120.00	9002070155000
0.6299			16.000	178.00	120.00	9002070160000
0.6496			16.500	184.00	125.00	9002070165000
0.6693			17.000	184.00	125.00	9002070170000
0.7087			18.000	191.00	130.00	9002070180000
0.7185			18.250	198.00	135.00	9002070182500
0.7480			19.000	198.00	135.00	9002070190000
0.7874			20.000	205.00	140.00	9002070200000

Alternative Drill Series:
#549 HSS, GT100, 5xD, 130 pt, bright/nitrided lands > 2.36

\*Items listed in red are non-stocked items, and may take 2 - 6 weeks to receive