

# 5xD

# Series 208

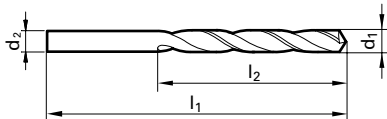
### Application Materials:

- General Steels/Brass
- Universal Steels
- Cast Iron

## General Purpose, LH helix

HSS, general purpose (Type N), jobber length, 118° point, Form A web thinned >14.0mm dia., standard straight shank, LH cut

Cut / Shank Dia. = h8 tolerance range



$$d_1 = d_2$$

Steam Oxide >6.00 mm dia.

External Coolant

Straight Shank

Speeds & Feeds information pg 425

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch					
0.0094		88	0.240	19.00	2.50	9002080002400
0.0114		84	0.290	19.00	3.00	9002080002900
0.0118			0.300	19.00	3.00	9002080003000
0.0134		80	0.340	19.00	4.00	9002080003400
0.0138			0.350	19.00	4.00	9002080003500
0.0142			0.360	19.00	4.00	9002080003600
0.0146		79	0.370	19.00	4.00	9002080003700
0.0157	1/64		0.400	20.00	5.00	9002080004000
0.0161		78	0.410	20.00	5.00	9002080004100
0.0165			0.420	20.00	5.00	9002080004200
0.0169			0.430	20.00	5.00	9002080004300
0.0173			0.440	20.00	5.00	9002080004400
0.0177			0.450	20.00	5.00	9002080004500
0.0181		77	0.460	20.00	5.00	9002080004600
0.0185			0.470	20.00	5.00	9002080004700
0.0189			0.480	20.00	5.00	9002080004800
0.0197			0.500	22.00	6.00	9002080005000
0.0201		76	0.510	22.00	6.00	9002080005100
0.0205			0.520	22.00	6.00	9002080005200
0.0209		75	0.530	22.00	6.00	9002080005300
0.0213			0.540	24.00	7.00	9002080005400
0.0217			0.550	24.00	7.00	9002080005500
0.0220			0.560	24.00	7.00	9002080005600
0.0224		74	0.570	24.00	7.00	9002080005700
0.0228			0.580	24.00	7.00	9002080005800
0.0236			0.600	24.00	7.00	9002080006000
0.0240		73	0.610	26.00	8.00	9002080006100
0.0244			0.620	26.00	8.00	9002080006200
0.0248			0.630	26.00	8.00	9002080006300
0.0252		72	0.640	26.00	8.00	9002080006400
0.0256			0.650	26.00	8.00	9002080006500
0.0260		71	0.660	26.00	8.00	9002080006600
0.0264			0.670	26.00	8.00	9002080006700
0.0268			0.680	28.00	9.00	9002080006800
0.0276			0.700	28.00	9.00	9002080007000
0.0280		70	0.710	28.00	9.00	9002080007100
0.0283			0.720	28.00	9.00	9002080007200
0.0287			0.730	28.00	9.00	9002080007300
0.0295			0.750	28.00	9.00	9002080007500
0.0303			0.770	30.00	10.00	9002080007700
0.0307			0.780	30.00	10.00	9002080007800
0.0311	1/32	68	0.790	30.00	10.00	9002080007900
0.0315			0.800	30.00	10.00	9002080008000
0.0319		67	0.810	30.00	10.00	9002080008100
0.0323			0.820	30.00	10.00	9002080008200
0.0327			0.830	30.00	10.00	9002080008300
0.0331		66	0.840	30.00	10.00	9002080008400
0.0335			0.850	30.00	10.00	9002080008500
0.0339			0.860	32.00	11.00	9002080008600
0.0343			0.870	32.00	11.00	9002080008700
0.0346			0.880	32.00	11.00	9002080008800
0.0350		65	0.890	32.00	11.00	9002080008900
0.0354			0.900	32.00	11.00	9002080009000
0.0358		64	0.910	32.00	11.00	9002080009100

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch					
0.0362			0.920	32.00	11.00	9002080009200
0.0366			0.930	32.00	11.00	9002080009300
0.0374			0.950	32.00	11.00	9002080009500
0.0378			0.960	34.00	12.00	9002080009600
0.0382		62	0.970	34.00	12.00	9002080009700
0.0386			0.980	34.00	12.00	9002080009800
0.0390		61	0.990	34.00	12.00	9002080009900
0.0394			1.000	34.00	12.00	9002080010000
0.0402		60	1.020	34.00	12.00	9002080010200
0.0409		59	1.040	34.00	12.00	9002080010400
0.0413			1.050	34.00	12.00	9002080010500
0.0421		58	1.070	36.00	14.00	9002080010700
0.0425			1.080	36.00	14.00	9002080010800
0.0429		57	1.090	36.00	14.00	9002080010900
0.0433			1.100	36.00	14.00	9002080011000
0.0441			1.120	36.00	14.00	9002080011200
0.0445			1.130	36.00	14.00	9002080011300
0.0453			1.150	36.00	14.00	9002080011500
0.0461			1.170	36.00	14.00	9002080011700
0.0465		56	1.180	36.00	14.00	9002080011800
0.0469	3/64		1.190	38.00	16.00	9002080011900
0.0472			1.200	38.00	16.00	9002080012000
0.0476			1.210	38.00	16.00	9002080012100
0.0480			1.220	38.00	16.00	9002080012200
0.0488			1.240	38.00	16.00	9002080012400
0.0492			1.250	38.00	16.00	9002080012500
0.0500			1.270	38.00	16.00	9002080012700
0.0512			1.300	38.00	16.00	9002080013000
0.0520		55	1.320	38.00	16.00	9002080013200
0.0531			1.350	40.00	18.00	9002080013500
0.0543			1.380	40.00	18.00	9002080013800
0.0547			1.390	40.00	18.00	9002080013900
0.0551		54	1.400	40.00	18.00	9002080014000
0.0559			1.420	40.00	18.00	9002080014200
0.0571			1.450	40.00	18.00	9002080014500
0.0579			1.470	40.00	18.00	9002080014700
0.0591			1.500	40.00	18.00	9002080015000
0.0594		53	1.510	43.00	20.00	9002080015100
0.0602			1.530	43.00	20.00	9002080015300
0.0610			1.550	43.00	20.00	9002080015500
0.0614			1.560	43.00	20.00	9002080015600
0.0626	1/16		1.590	43.00	20.00	9002080015900
0.0630			1.600	43.00	20.00	9002080016000
0.0634		52	1.610	43.00	20.00	9002080016100
0.0638			1.620	43.00	20.00	9002080016200
0.0642			1.630	43.00	20.00	9002080016300
0.0650			1.650	43.00	20.00	9002080016500
0.0654			1.660	43.00	20.00	9002080016600
0.0661			1.680	43.00	20.00	9002080016800
0.0669		51	1.700	43.00	20.00	9002080017000
0.0677			1.720	46.00	22.00	9002080017200
0.0681			1.730	46.00	22.00	9002080017300
0.0689			1.750	46.00	22.00	9002080017500
0.0693			1.760	46.00	22.00	9002080017600

# Series 208

## Speeds & Feeds information pg 425

Twist Drills

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch					
0.0709			1.800	46.00	22.00	9002080018000
0.0717			1.820	46.00	22.00	9002080018200
0.0720			1.830	46.00	22.00	9002080018300
0.0724			1.840	46.00	22.00	9002080018400
0.0728		49	1.850	46.00	22.00	9002080018500
0.0748			1.900	46.00	22.00	9002080019000
0.0760		48	1.930	49.00	24.00	9002080019300
0.0764			1.940	49.00	24.00	9002080019400
0.0768			1.950	49.00	24.00	9002080019500
0.0776			1.970	49.00	24.00	9002080019700
0.0780	5/64		1.980	49.00	24.00	9002080019800
0.0787			2.000	49.00	24.00	9002080020000
0.0803			2.040	49.00	24.00	9002080020400
0.0807			2.050	49.00	24.00	9002080020500
0.0811		46	2.060	49.00	24.00	9002080020600
0.0819		45	2.080	49.00	24.00	9002080020800
0.0827			2.100	49.00	24.00	9002080021000
0.0835			2.120	49.00	24.00	9002080021200
0.0846			2.150	53.00	27.00	9002080021500
0.0858		44	2.180	53.00	27.00	9002080021800
0.0866			2.200	53.00	27.00	9002080022000
0.0886			2.250	53.00	27.00	9002080022500
0.0890		43	2.260	53.00	27.00	9002080022600
0.0898			2.280	53.00	27.00	9002080022800
0.0906			2.300	53.00	27.00	9002080023000
0.0913			2.320	53.00	27.00	9002080023200
0.0925			2.350	53.00	27.00	9002080023500
0.0933		42	2.370	57.00	30.00	9002080023700
0.0937	3/32		2.380	57.00	30.00	9002080023800
0.0945			2.400	57.00	30.00	9002080024000
0.0961		41	2.440	57.00	30.00	9002080024400
0.0965			2.450	57.00	30.00	9002080024500
0.0980		40	2.490	57.00	30.00	9002080024900
0.0984			2.500	57.00	30.00	9002080025000
0.0996		39	2.530	57.00	30.00	9002080025300
0.1004			2.550	57.00	30.00	9002080025500
0.1016		38	2.580	57.00	30.00	9002080025800
0.1024			2.600	57.00	30.00	9002080026000
0.1039		37	2.640	57.00	30.00	9002080026400
0.1043			2.650	57.00	30.00	9002080026500
0.1063			2.700	61.00	33.00	9002080027000
0.1075			2.730	61.00	33.00	9002080027300
0.1083			2.750	61.00	33.00	9002080027500
0.1094	7/64		2.780	61.00	33.00	9002080027800
0.1102			2.800	61.00	33.00	9002080028000
0.1110		34	2.820	61.00	33.00	9002080028200
0.1122			2.850	61.00	33.00	9002080028500
0.1130		33	2.870	61.00	33.00	9002080028700
0.1142			2.900	61.00	33.00	9002080029000
0.1161		32	2.950	61.00	33.00	9002080029500
0.1169			2.970	61.00	33.00	9002080029700
0.1181			3.000	61.00	33.00	9002080030000
0.1201		31	3.050	65.00	36.00	9002080030500
0.1209			3.070	65.00	36.00	9002080030700
0.1220			3.100	65.00	36.00	9002080031000
0.1240			3.150	65.00	36.00	9002080031500
0.1248	1/8		3.170	65.00	36.00	9002080031700
0.1260			3.200	65.00	36.00	9002080032000
0.1268			3.220	65.00	36.00	9002080032200
0.1280			3.250	65.00	36.00	9002080032500
0.1283		30	3.260	65.00	36.00	9002080032600
0.1299			3.300	65.00	36.00	9002080033000
0.1319			3.350	65.00	36.00	9002080033500
0.1327			3.370	70.00	39.00	9002080033700
0.1339			3.400	70.00	39.00	9002080034000
0.1358		29	3.450	70.00	39.00	9002080034500
0.1378			3.500	70.00	39.00	9002080035000
0.1398			3.550	70.00	39.00	9002080035500
0.1406	9/64	28	3.570	70.00	39.00	9002080035700
0.1417			3.600	70.00	39.00	9002080036000
0.1437			3.650	70.00	39.00	9002080036500

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch					
0.1457			3.700	70.00	39.00	9002080037000
0.1476			3.750	70.00	39.00	9002080037500
0.1496		25	3.800	75.00	43.00	9002080038000
0.1516			3.850	75.00	43.00	9002080038500
0.1535			3.900	75.00	43.00	9002080039000
0.1539		23	3.910	75.00	43.00	9002080039100
0.1555			3.950	75.00	43.00	9002080039500
0.1563	5/32		3.970	75.00	43.00	9002080039700
0.1575			4.000	75.00	43.00	9002080040000
0.1594			4.050	75.00	43.00	9002080040500
0.1614			4.100	75.00	43.00	9002080041000
0.1626			4.130	75.00	43.00	9002080041300
0.1634			4.150	75.00	43.00	9002080041500
0.1654			4.200	75.00	43.00	9002080042000
0.1673			4.250	75.00	43.00	9002080042500
0.1693		18	4.300	80.00	47.00	9002080043000
0.1713			4.350	80.00	47.00	9002080043500
0.1720	11/64		4.370	80.00	47.00	9002080043700
0.1728		17	4.390	80.00	47.00	9002080043900
0.1732			4.400	80.00	47.00	9002080044000
0.1752			4.450	80.00	47.00	9002080044500
0.1772		16	4.500	80.00	47.00	9002080045000
0.1791			4.550	80.00	47.00	9002080045500
0.1799		15	4.570	80.00	47.00	9002080045700
0.1811			4.600	80.00	47.00	9002080046000
0.1831			4.650	80.00	47.00	9002080046500
0.1850		13	4.700	80.00	47.00	9002080047000
0.1870			4.750	80.00	47.00	9002080047500
0.1874	3/16		4.760	86.00	52.00	9002080047600
0.1890		12	4.800	86.00	52.00	9002080048000
0.1909		11	4.850	86.00	52.00	9002080048500
0.1929			4.900	86.00	52.00	9002080049000
0.1937		10	4.920	86.00	52.00	9002080049200
0.1949			4.950	86.00	52.00	9002080049500
0.1961		9	4.980	86.00	52.00	9002080049800
0.1969			5.000	86.00	52.00	9002080050000
0.1992		8	5.060	86.00	52.00	9002080050600
0.2008			5.100	86.00	52.00	9002080051000
0.2012		7	5.110	86.00	52.00	9002080051100
0.2031	13/64		5.160	86.00	52.00	9002080051600
0.2039		6	5.180	86.00	52.00	9002080051800
0.2047			5.200	86.00	52.00	9002080052000
0.2055		5	5.220	86.00	52.00	9002080052200
0.2067			5.250	86.00	52.00	9002080052500
0.2087			5.300	86.00	52.00	9002080053000
0.2126			5.400	93.00	57.00	9002080054000
0.2165			5.500	93.00	57.00	9002080055000
0.2189	7/32		5.560	93.00	57.00	9002080055600
0.2205			5.600	93.00	57.00	9002080056000
0.2209		2	5.610	93.00	57.00	9002080056100
0.2244			5.700	93.00	57.00	9002080057000
0.2264			5.750	93.00	57.00	9002080057500
0.2283			5.800	93.00	57.00	9002080058000
0.2303			5.850	93.00	57.00	9002080058500
0.2323			5.900	93.00	57.00	9002080059000
0.2339		A	5.940	93.00	57.00	9002080059400
0.2343	15/64		5.950	93.00	57.00	9002080059500
0.2362			6.000	93.00	57.00	9002080060000
0.2382			6.050	101.00	63.00	9002080060500
0.2402			6.100	101.00	63.00	9002080061000
0.2441			6.200	101.00	63.00	9002080062000
0.2461		D	6.250	101.00	63.00	9002080062500
0.2480			6.300	101.00	63.00	9002080063000
0.2500	1/4	E	6.350	101.00	63.00	9002080063500
0.2520			6.400	101.00	63.00	9002080064000
0.2559			6.500	101.00	63.00	9002080065000
0.2598			6.600	101.00	63.00	9002080066000
0.2638			6.700	101.00	63.00	9002080067000
0.2657	17/64	H	6.750	109.00	69.00	9002080067500
0.2677			6.800	109.00	69.00	9002080068000
0.2717		I	6.900	109.00	69.00	9002080069000

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

# Series 208

## Speeds & Feeds information pg 425

Diameter (d1)							
Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm	EDP #	
0.2756			7.000	109.00	69.00	9002080070000	
0.2768		J	7.030	109.00	69.00	9002080070300	
0.2795			7.100	109.00	69.00	9002080071000	
0.2811	9/32	K	7.140	109.00	69.00	9002080071400	
0.2835			7.200	109.00	69.00	9002080072000	
0.2874			7.300	109.00	69.00	9002080073000	
0.2913			7.400	109.00	69.00	9002080074000	
0.2953			7.500	109.00	69.00	9002080075000	
0.2969	19/64		7.540	117.00	75.00	9002080075400	
0.2992			7.600	117.00	75.00	9002080076000	
0.3031			7.700	117.00	75.00	9002080077000	
0.3051			7.750	117.00	75.00	9002080077500	
0.3071			7.800	117.00	75.00	9002080078000	
0.3091			7.850	117.00	75.00	9002080078500	
0.3110			7.900	117.00	75.00	9002080079000	
0.3126	5/16		7.940	117.00	75.00	9002080079400	
0.3150			8.000	117.00	75.00	9002080080000	
0.3189			8.100	117.00	75.00	9002080081000	
0.3228		P	8.200	117.00	75.00	9002080082000	
0.3268			8.300	117.00	75.00	9002080083000	
0.3280	21/64		8.330	117.00	75.00	9002080083300	
0.3307			8.400	117.00	75.00	9002080084000	
0.3319		Q	8.430	117.00	75.00	9002080084300	
0.3346			8.500	117.00	75.00	9002080085000	
0.3386			8.600	125.00	81.00	9002080086000	
0.3425			8.700	125.00	81.00	9002080087000	
0.3465			8.800	125.00	81.00	9002080088000	
0.3504			8.900	125.00	81.00	9002080089000	
0.3543			9.000	125.00	81.00	9002080090000	
0.3583			9.100	125.00	81.00	9002080091000	
0.3622			9.200	125.00	81.00	9002080092000	
0.3661			9.300	125.00	81.00	9002080093000	
0.3701			9.400	125.00	81.00	9002080094000	
0.3740			9.500	125.00	81.00	9002080095000	
0.3748	3/8		9.520	133.00	87.00	9002080095200	
0.3780			9.600	133.00	87.00	9002080096000	
0.3819			9.700	133.00	87.00	9002080097000	
0.3839			9.750	133.00	87.00	9002080097500	
0.3858		W	9.800	133.00	87.00	9002080098000	
0.3898			9.900	133.00	87.00	9002080099000	
0.3906	25/64		9.920	133.00	87.00	9002080099200	
0.3937			10.000	133.00	87.00	9002080100000	
0.3976			10.100	133.00	87.00	9002080101000	

Diameter (d1)							
Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm	EDP #	
0.4016			10.200	133.00	87.00	9002080102000	
0.4035			10.250	133.00	87.00	9002080102500	
0.4055			10.300	133.00	87.00	9002080103000	
0.4063	13/32		10.320	133.00	87.00	9002080103200	
0.4094			10.400	133.00	87.00	9002080104000	
0.4134			10.500	133.00	87.00	9002080105000	
0.4173			10.600	133.00	87.00	9002080106000	
0.4213			10.700	142.00	94.00	9002080107000	
0.4220	27/64		10.720	142.00	94.00	9002080107200	
0.4232			10.750	142.00	94.00	9002080107500	
0.4331			11.000	142.00	94.00	9002080110000	
0.4374	7/16		11.110	142.00	94.00	9002080111100	
0.4409			11.200	142.00	94.00	9002080112000	
0.4449			11.300	142.00	94.00	9002080113000	
0.4528			11.500	142.00	94.00	9002080115000	
0.4531	29/64		11.510	142.00	94.00	9002080115100	
0.4646			11.800	142.00	94.00	9002080118000	
0.4685			11.900	151.00	101.00	9002080119000	
0.4689	15/32		11.910	151.00	101.00	9002080119100	
0.4724			12.000	151.00	101.00	9002080120000	
0.4764			12.100	151.00	101.00	9002080121000	
0.4803			12.200	151.00	101.00	9002080122000	
0.4823			12.250	151.00	101.00	9002080122500	
0.4843	31/64		12.300	151.00	101.00	9002080123000	
0.4882			12.400	151.00	101.00	9002080124000	
0.4921			12.500	151.00	101.00	9002080125000	
0.4961			12.600	151.00	101.00	9002080126000	
0.5000	1/2		12.700	151.00	101.00	9002080127000	
0.5118			13.000	151.00	101.00	9002080130000	
0.5217			13.250	160.00	108.00	9002080132500	
0.5276			13.400	160.00	108.00	9002080134000	
0.5669			14.400	169.00	114.00	9002080144000	
0.5787			14.700	169.00	114.00	9002080147000	
0.5827			14.800	169.00	114.00	9002080148000	
0.6004			15.250	178.00	120.00	9002080152500	
0.6102			15.500	178.00	120.00	9002080155000	
0.6248	5/8		15.870	178.00	120.00	9002080158700	
0.6299			16.000	178.00	120.00	9002080160000	

### Alternative Drill Series:

#308 Cobalt, GP Low LH Helix, 5xD, 118 pt, Oxide  
 #664 HSS, GP Low LH Helix, 5xD, 118 pt, TiN