

# 5xD


  
 Steam Oxide
   
 >6.00 mm dia.


  
 External Coolant


  
 Straight Shank

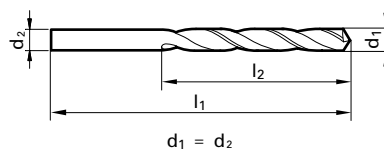
Speeds & Feeds
   
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# Series 308



## General Purpose, LH helix

Cobalt, general purpose (Type N), jobber length, 118° point,
   
 Form A web thinned >2.36mm dia., standard straight shank, LH helix

Cut / Shank Dia. = h8 tolerance range



Application Materials:

-  Universal Steels
-  Hardened Materials

Twist Drills

Diameter (d1)		Wire / letter	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch				
0.0189			20.00	5.00	9003080004800
0.0197			22.00	6.00	9003080005000
0.0295			28.00	9.00	9003080007500
0.0307			30.00	10.00	9003080007800
0.0315			30.00	10.00	9003080008000
0.0354			32.00	11.00	9003080009000
0.0358		64	32.00	11.00	9003080009100
0.0366			32.00	11.00	9003080009300
0.0386			34.00	12.00	9003080009800
0.0394			34.00	12.00	9003080010000
0.0402		60	34.00	12.00	9003080010200
0.0425			36.00	14.00	9003080010800
0.0433			36.00	14.00	9003080011000
0.0453			36.00	14.00	9003080011500
0.0465		56	36.00	14.00	9003080011800
0.0469	3/64		38.00	16.00	9003080011900
0.0472			38.00	16.00	9003080012000
0.0492			38.00	16.00	9003080012500
0.0512			38.00	16.00	9003080013000
0.0520		55	38.00	16.00	9003080013200
0.0531			40.00	18.00	9003080013500
0.0551		54	40.00	18.00	9003080014000
0.0563			40.00	18.00	9003080014300
0.0571			40.00	18.00	9003080014500
0.0579			40.00	18.00	9003080014700
0.0587			40.00	18.00	9003080014900
0.0591			40.00	18.00	9003080015000
0.0594		53	43.00	20.00	9003080015100
0.0610			43.00	20.00	9003080015500
0.0626	1/16		43.00	20.00	9003080015900
0.0630			43.00	20.00	9003080016000
0.0661			43.00	20.00	9003080016800
0.0669		51	43.00	20.00	9003080017000
0.0677			46.00	22.00	9003080017200
0.0689			46.00	22.00	9003080017500
0.0701		50	46.00	22.00	9003080017800
0.0709			46.00	22.00	9003080018000
0.0728		49	46.00	22.00	9003080018500
0.0748			46.00	22.00	9003080019000
0.0760		48	49.00	24.00	9003080019300
0.0768			49.00	24.00	9003080019500
0.0780	5/64		49.00	24.00	9003080019800
0.0787			49.00	24.00	9003080020000
0.0811		46	49.00	24.00	9003080020600
0.0819		45	49.00	24.00	9003080020800
0.0827			49.00	24.00	9003080021000
0.0858		44	53.00	27.00	9003080021800
0.0866			53.00	27.00	9003080022000
0.0886			53.00	27.00	9003080022500
0.0890		43	53.00	27.00	9003080022600
0.0906			53.00	27.00	9003080023000
0.0925			53.00	27.00	9003080023500
0.0933		42	57.00	30.00	9003080023700
0.0937	3/32		57.00	30.00	9003080023800

Diameter (d1)		Wire / letter	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch				
0.0945			57.00	30.00	9003080024000
0.0980		40	57.00	30.00	9003080024900
0.0984			57.00	30.00	9003080025000
0.0996		39	57.00	30.00	9003080025300
0.1024			57.00	30.00	9003080026000
0.1039		37	57.00	30.00	9003080026400
0.1063			61.00	33.00	9003080027000
0.1083			61.00	33.00	9003080027500
0.1094	7/64		61.00	33.00	9003080027800
0.1098		35	61.00	33.00	9003080027900
0.1102			61.00	33.00	9003080028000
0.1110		34	61.00	33.00	9003080028200
0.1142			61.00	33.00	9003080029000
0.1161		32	61.00	33.00	9003080029500
0.1181			61.00	33.00	9003080030000
0.1201		31	65.00	36.00	9003080030500
0.1220			65.00	36.00	9003080031000
0.1248	1/8		65.00	36.00	9003080031700
0.1260			65.00	36.00	9003080032000
0.1299			65.00	36.00	9003080033000
0.1339			70.00	39.00	9003080034000
0.1358		29	70.00	39.00	9003080034500
0.1378			70.00	39.00	9003080035000
0.1417			70.00	39.00	9003080036000
0.1437			70.00	39.00	9003080036500
0.1441		27	70.00	39.00	9003080036600
0.1457			70.00	39.00	9003080037000
0.1469		26	70.00	39.00	9003080037300
0.1496		25	75.00	43.00	9003080038000
0.1520		24	75.00	43.00	9003080038600
0.1535			75.00	43.00	9003080039000
0.1539		23	75.00	43.00	9003080039100
0.1563	5/32		75.00	43.00	9003080039700
0.1571		22	75.00	43.00	9003080039900
0.1575			75.00	43.00	9003080040000
0.1591		21	75.00	43.00	9003080040400
0.1594			75.00	43.00	9003080040500
0.1610		20	75.00	43.00	9003080040900
0.1614			75.00	43.00	9003080041000
0.1634			75.00	43.00	9003080041500
0.1654			75.00	43.00	9003080042000
0.1661		19	75.00	43.00	9003080042200
0.1693		18	80.00	47.00	9003080043000
0.1720	11/64		80.00	47.00	9003080043700
0.1728		17	80.00	47.00	9003080043900
0.1732			80.00	47.00	9003080044000
0.1772		16	80.00	47.00	9003080045000
0.1811			80.00	47.00	9003080046000
0.1819		14	80.00	47.00	9003080046200
0.1850		13	80.00	47.00	9003080047000
0.1874	3/16		86.00	52.00	9003080047600
0.1890		12	86.00	52.00	9003080048000
0.1929			86.00	52.00	9003080049000
0.1961		9	86.00	52.00	9003080049800

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

# Series 308

## Speeds & Feeds information pg 432

Diameter (d1)		Wire / letter	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch				
0.1969			86.00	52.00	9003080050000
0.1992		8	5.060	86.00	9003080050600
0.2008			5.100	86.00	9003080051000
0.2012		7	5.110	86.00	9003080051100
0.2031	13/64		5.160	86.00	9003080051600
0.2039		6	5.180	86.00	9003080051800
0.2047			5.200	86.00	9003080052000
0.2055		5	5.220	86.00	9003080052200
0.2087			5.300	86.00	9003080053000
0.2091		4	5.310	93.00	9003080053100
0.2126			5.400	93.00	9003080054000
0.2130		3	5.410	93.00	9003080054100
0.2165			5.500	93.00	9003080055000
0.2189	7/32		5.560	93.00	9003080055600
0.2205			5.600	93.00	9003080056000
0.2209		2	5.610	93.00	9003080056100
0.2244			5.700	93.00	9003080057000
0.2283			5.800	93.00	9003080058000
0.2339		A	5.940	93.00	9003080059400
0.2343	15/64		5.950	93.00	9003080059500
0.2362			6.000	93.00	9003080060000
0.2402			6.100	101.00	9003080061000
0.2421		C	6.150	101.00	9003080061500
0.2441			6.200	101.00	9003080062000
0.2461		D	6.250	101.00	9003080062500
0.2480			6.300	101.00	9003080063000
0.2500	1/4	E	6.350	101.00	9003080063500
0.2559			6.500	101.00	9003080065000
0.2598			6.600	101.00	9003080066000
0.2638			6.700	101.00	9003080067000
0.2657	17/64	H	6.750	109.00	9003080067500
0.2677			6.800	109.00	9003080068000
0.2756			7.000	109.00	9003080070000
0.2902		L	7.370	109.00	9003080073700
0.2913			7.400	109.00	9003080074000
0.2953			7.500	109.00	9003080075000
0.2969	19/64		7.540	117.00	9003080075400
0.2992			7.600	117.00	9003080076000
0.3031			7.700	117.00	9003080077000
0.3110			7.900	117.00	9003080079000
0.3150			8.000	117.00	9003080080000
0.3161		O	8.030	117.00	9003080080300
0.3189			8.100	117.00	9003080081000
0.3228		P	8.200	117.00	9003080082000

Diameter (d1)		Wire / letter	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch				
0.3268			8.300	117.00	9003080083000
0.3280	21/64		8.330	117.00	9003080083300
0.3346			8.500	117.00	9003080085000
0.3386			8.600	125.00	9003080086000
0.3390		R	8.610	125.00	9003080086100
0.3425			8.700	125.00	9003080087000
0.3437	11/32		8.730	125.00	9003080087300
0.3465			8.800	125.00	9003080088000
0.3480		S	8.840	125.00	9003080088400
0.3504			8.900	125.00	9003080089000
0.3543			9.000	125.00	9003080090000
0.3579		T	9.090	125.00	9003080090900
0.3583			9.100	125.00	9003080091000
0.3594	23/64		9.130	125.00	9003080091300
0.3622			9.200	125.00	9003080092000
0.3661			9.300	125.00	9003080093000
0.3677		U	9.340	125.00	9003080093400
0.3701			9.400	125.00	9003080094000
0.3740			9.500	125.00	9003080095000
0.3748	3/8		9.520	133.00	9003080095200
0.3772		V	9.580	133.00	9003080095800
0.3780			9.600	133.00	9003080096000
0.3819			9.700	133.00	9003080097000
0.3858		W	9.800	133.00	9003080098000
0.3898			9.900	133.00	9003080099000
0.3906	25/64		9.920	133.00	9003080099200
0.3937			10.000	133.00	9003080100000
0.4039		Y	10.260	133.00	9003080102600
0.4063	13/32		10.320	133.00	9003080103200
0.4130		Z	10.490	133.00	9003080104900
0.4134			10.500	133.00	9003080105000
0.4331			11.000	142.00	9003080110000
0.4374	7/16		11.110	142.00	9003080111100
0.4528			11.500	142.00	9003080115000
0.4531	29/64		11.510	142.00	9003080115100
0.4689	15/32		11.910	151.00	9003080119100
0.4744			12.050	151.00	9003080120500
0.4921			12.500	151.00	9003080125000
0.5000	1/2		12.700	151.00	9003080127000

**Alternative Drill Series:**

#208 HSS, GP, LH Helix, 5xD, 118 pt, Bright/Steam Oxide > 6.00