

Extra Length

#1



Bright Finish



External Coolant



Straight Shank

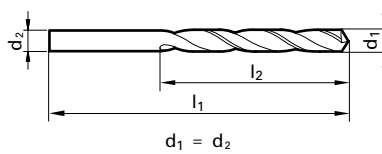
Speeds & Feeds
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Series 524

GT 50 Parabolic

HSS, GT 50 deep hole, extra length #1, 130° point, Form A web thinned
>2.36mm dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



Application Materials:



General Steels



Aluminum & Alloys

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.0787			2.00	125.00	85.00	900524002000
0.0827			2.10	125.00	85.00	9005240021000
0.0866			2.20	135.00	90.00	9005240022000
0.0906			2.30	135.00	90.00	9005240023000
0.0925			2.350	135.00	90.00	9005240023500
0.0937	3/32		2.380	150.00	100.00	9005240023800
0.0945			2.400	150.00	100.00	9005240024000
0.0965			2.450	150.00	100.00	9005240024500
0.0984			2.500	150.00	100.00	9005240025000
0.1024			2.600	150.00	100.00	9005240026000
0.1094	7/64		2.780	150.00	100.00	9005240027800
0.1102			2.800	150.00	100.00	9005240028000
0.1142			2.900	150.00	100.00	9005240029000
0.1161		32	2.950	150.00	100.00	9005240029500
0.1181			3.000	150.00	100.00	9005240030000
0.1220			3.100	155.00	105.00	9005240031000
0.1248	1/8		3.170	155.00	105.00	9005240031700
0.1260			3.200	155.00	105.00	9005240032000
0.1299			3.300	155.00	105.00	9005240033000
0.1319			3.350	155.00	105.00	9005240033500
0.1339			3.400	165.00	115.00	9005240034000
0.1358		29	3.450	165.00	115.00	9005240034500
0.1378			3.500	165.00	115.00	9005240035000
0.1390			3.530	165.00	115.00	9005240035300
0.1406	9/64	28	3.570	165.00	115.00	9005240035700
0.1417			3.600	165.00	115.00	9005240036000
0.1457			3.700	165.00	115.00	9005240037000
0.1496		25	3.800	175.00	120.00	9005240038000
0.1535			3.900	175.00	120.00	9005240039000
0.1563	5/32		3.970	175.00	120.00	9005240039700
0.1575			4.000	175.00	120.00	9005240040000
0.1614			4.100	175.00	120.00	9005240041000
0.1654			4.200	175.00	120.00	9005240042000
0.1673			4.250	175.00	120.00	9005240042500
0.1693		18	4.300	185.00	125.00	9005240043000
0.1720	11/64		4.370	185.00	125.00	9005240043700
0.1732			4.400	185.00	125.00	9005240044000
0.1772		16	4.500	185.00	125.00	9005240045000
0.1811			4.600	185.00	125.00	9005240046000
0.1850		13	4.700	185.00	125.00	9005240047000
0.1874	3/16		4.760	195.00	135.00	9005240047600
0.1890		12	4.800	195.00	135.00	9005240048000
0.1969			5.000	195.00	135.00	9005240050000
0.2008			5.100	195.00	135.00	9005240051000
0.2031	13/64		5.160	195.00	135.00	9005240051600
0.2047			5.200	195.00	135.00	9005240052000
0.2087			5.300	195.00	135.00	9005240053000
0.2126			5.400	205.00	140.00	9005240054000
0.2165			5.500	205.00	140.00	9005240055000

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.2189	7/32		5.560	205.00	140.00	9005240055600
0.2283			5.800	205.00	140.00	9005240058000
0.2343	15/64		5.950	205.00	140.00	9005240059500
0.2362			6.000	205.00	140.00	9005240060000
0.2402			6.100	215.00	150.00	9005240061000
0.2500	1/4	E	6.350	215.00	150.00	9005240063500
0.2520			6.400	215.00	150.00	9005240064000
0.2559			6.500	215.00	150.00	9005240065000
0.2598			6.600	215.00	150.00	9005240066000
0.2638			6.700	215.00	150.00	9005240067000
0.2657	17/64	H	6.750	225.00	155.00	9005240067500
0.2677			6.800	225.00	155.00	9005240068000
0.2756			7.000	225.00	155.00	9005240070000
0.2874			7.300	225.00	155.00	9005240073000
0.2953			7.500	225.00	155.00	9005240075000
0.2969	19/64		7.540	240.00	165.00	9005240075400
0.2992			7.600	240.00	165.00	9005240076000
0.3071			7.800	240.00	165.00	9005240078000
0.3110			7.900	240.00	165.00	9005240079000
0.3126	5/16		7.940	240.00	165.00	9005240079400
0.3150			8.000	240.00	165.00	9005240080000
0.3189			8.100	240.00	165.00	9005240081000
0.3228		P	8.200	240.00	165.00	9005240082000
0.3280	21/64		8.330	240.00	165.00	9005240083300
0.3346			8.500	240.00	165.00	9005240085000
0.3386			8.600	250.00	175.00	9005240086000
0.3437	11/32		8.730	250.00	175.00	9005240087300
0.3504			8.900	250.00	175.00	9005240089000
0.3543			9.000	250.00	175.00	9005240090000
0.3594	23/64		9.130	250.00	175.00	9005240091300
0.3622			9.200	250.00	175.00	9005240092000
0.3740			9.500	250.00	175.00	9005240095000
0.3748	3/8		9.520	265.00	185.00	9005240095200
0.3937			10.000	265.00	185.00	9005240100000
0.4063	13/32		10.320	265.00	185.00	9005240103200
0.4134			10.500	265.00	185.00	9005240105000
0.4331			11.000	280.00	195.00	9005240110000
0.4374	7/16		11.110	280.00	195.00	9005240111100
0.4528			11.500	280.00	195.00	9005240115000
0.4689	15/32		11.910	295.00	205.00	9005240119100
0.4724			12.000	295.00	205.00	9005240120000
0.5000	1/2		12.700	295.00	205.00	9005240127000

Alternative Drill Series:

#502 HSS, GT100, >10xD, 130 pt, Bright
 #670 HSS, GT100, >10xD, 130 pt, TiN
 #618 Cobalt, GT100, >10xD, 130 pt, Bright