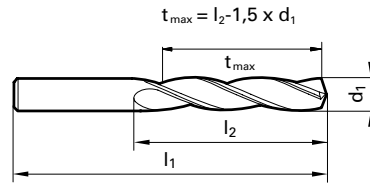




Tool material **Solid Carbide**  
Surface **S**

- P** Steel ○ web thinning ≥ Ø 3.000 • facet point grinding • for holes with high alignment accuracy • very good surface quality of hole • suitable for interrupted cutting
  - M** Stainless steel
  - K** Cast iron ○ cast steel • alloyed/unalloyed steels up to 1000 N/mm<sup>2</sup>
  - N** Aluminum ○
  - S** Titanium alloys
  - H** Hardened steel
- =Optimal  
○=Limited



Speeds and feeds information on pg. 531

Shank diameter = cut diameter

Diameter (d1)		l1 mm	t <sub>max</sub> mm	l2 mm	EDP #
inch	wire/ltr mm				
0.1181	3.00	46.00	17.50	22.00	9006090030000
0.1220	3.10	49.00	19.35	24.00	9006090031000
0.1248	1/8 3.17	49.00	19.25	24.00	9006090031700
0.1260	3.20	49.00	19.20	24.00	9006090032000
0.1299	3.30	49.00	19.05	24.00	9006090033000
0.1339	3.40	52.00	21.90	27.00	9006090034000
0.1378	3.50	52.00	21.75	27.00	9006090035000
0.1406	9/64 #28 3.57	52.00	21.65	27.00	9006090035700
0.1417	3.60	52.00	21.60	27.00	9006090036000
0.1457	3.70	52.00	21.45	27.00	9006090037000
0.1496	#25 3.80	55.00	24.30	30.00	9006090038000
0.1535	3.90	55.00	24.15	30.00	9006090039000
0.1563	5/32 3.97	55.00	24.05	30.00	9006090039700
0.1575	4.00	55.00	24.00	30.00	9006090040000
0.1614	4.10	55.00	23.85	30.00	9006090041000
0.1654	4.20	55.00	23.70	30.00	9006090042000
0.1693	#18 4.30	58.00	25.55	32.00	9006090043000
0.1720	11/64 4.37	58.00	25.45	32.00	9006090043700
0.1732	4.40	58.00	25.40	32.00	9006090044000
0.1772	#16 4.50	58.00	25.25	32.00	9006090045000
0.1811	4.60	58.00	25.10	32.00	9006090046000
0.1850	#13 4.70	58.00	24.95	32.00	9006090047000
0.1874	3/16 4.76	62.00	27.86	35.00	9006090047600
0.1890	#12 4.80	62.00	27.80	35.00	9006090048000
0.1929	4.90	62.00	27.65	35.00	9006090049000
0.1969	5.00	62.00	27.50	35.00	9006090050000
0.2008	5.10	62.00	27.35	35.00	9006090051000
0.2031	13/64 5.16	62.00	27.26	35.00	9006090051600
0.2047	5.20	62.00	27.20	35.00	9006090052000
0.2087	5.30	62.00	27.05	35.00	9006090053000
0.2126	5.40	66.00	30.90	39.00	9006090054000
0.2165	5.50	66.00	30.75	39.00	9006090055000
0.2189	7/32 5.56	66.00	30.66	39.00	9006090055600
0.2205	5.60	66.00	30.60	39.00	9006090056000
0.2244	5.70	66.00	30.45	39.00	9006090057000
0.2283	5.80	66.00	30.30	39.00	9006090058000
0.2323	5.90	66.00	30.15	39.00	9006090059000
0.2343	15/64 5.95	66.00	30.08	39.00	9006090059500
0.2362	6.00	66.00	30.00	39.00	9006090060000
0.2402	6.10	70.00	32.85	42.00	9006090061000
0.2441	6.20	70.00	32.70	42.00	9006090062000
0.2480	6.30	70.00	32.55	42.00	9006090063000

Diameter (d1)			l1 mm	t <sub>max</sub> mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.2500	1/4 E	6.35	70.00	32.48	42.00	9006090063500
0.2520	6.40	70.00	32.40	42.00	9006090064000	
0.2559	6.50	70.00	32.25	42.00	9006090065000	
0.2598	6.60	70.00	32.10	42.00	9006090066000	
0.2638	6.70	70.00	31.95	42.00	9006090067000	
0.2657	17/64 H	6.75	74.00	34.88	45.00	9006090067500
0.2677	6.80	74.00	34.80	45.00	9006090068000	
0.2717	I	6.90	74.00	34.65	45.00	9006090069000
0.2756	7.00	74.00	34.50	45.00	9006090070000	
0.2795	7.10	74.00	34.35	45.00	9006090071000	
0.2811	9/32 K	7.14	74.00	34.29	45.00	9006090071400
0.2835	7.20	74.00	34.20	45.00	9006090072000	
0.2874	7.30	74.00	34.05	45.00	9006090073000	
0.2913	7.40	74.00	33.90	45.00	9006090074000	
0.2953	7.50	74.00	33.75	45.00	9006090075000	
0.2969	19/64	7.54	79.00	36.69	48.00	9006090075400
0.2992	7.60	79.00	36.60	48.00	9006090076000	
0.3031	7.70	79.00	36.45	48.00	9006090077000	
0.3071	7.80	79.00	36.30	48.00	9006090078000	
0.3110	7.90	79.00	36.15	48.00	9006090079000	
0.3126	5/16	7.94	79.00	36.09	48.00	9006090079400
0.3150	8.00	79.00	36.00	48.00	9006090080000	
0.3189	8.10	79.00	35.85	48.00	9006090081000	
0.3228	P	8.20	79.00	35.70	48.00	9006090082000
0.3268	8.30	79.00	35.55	48.00	9006090083000	
0.3280	21/64	8.33	79.00	35.51	48.00	9006090083300
0.3307	8.40	79.00	35.40	48.00	9006090084000	
0.3346	8.50	79.00	35.25	48.00	9006090085000	
0.3386	8.60	84.00	39.10	52.00	9006090086000	
0.3425	8.70	84.00	38.95	52.00	9006090087000	
0.3437	11/32	8.73	84.00	38.91	52.00	9006090087300
0.3465	8.80	84.00	38.80	52.00	9006090088000	
0.3504	8.90	84.00	38.65	52.00	9006090089000	
0.3543	9.00	84.00	38.50	52.00	9006090090000	
0.3583	9.10	84.00	38.35	52.00	9006090091000	
0.3594	23/64	9.13	84.00	38.31	52.00	9006090091300
0.3622	9.20	84.00	38.20	52.00	9006090092000	
0.3661	9.30	84.00	38.05	52.00	9006090093000	
0.3701	9.40	84.00	37.90	52.00	9006090094000	
0.3740	9.50	84.00	37.75	52.00	9006090095000	
0.3748	3/8	9.52	89.00	40.72	55.00	9006090095200
0.3780	9.60	89.00	40.60	55.00	9006090096000	

5xD Drills

Diameter (d1)			l1 mm	t <sub>max</sub> mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.3819		9.70	89.00	40.45	55.00	9006090097000
0.3858	W	9.80	89.00	40.30	55.00	9006090098000
0.3898		9.90	89.00	40.15	55.00	9006090099000
0.3906	25/64	9.92	89.00	40.12	55.00	9006090099200
0.3937		10.00	89.00	40.00	55.00	9006090100000
0.3976		10.10	89.00	39.85	55.00	9006090101000
0.4016		10.20	89.00	39.70	55.00	9006090102000
0.4055		10.30	89.00	39.55	55.00	9006090103000
0.4063	13/32	10.32	89.00	39.52	55.00	9006090103200
0.4094		10.40	89.00	39.40	55.00	9006090104000
0.4134		10.50	89.00	39.25	55.00	9006090105000
0.4173		10.60	89.00	39.10	55.00	9006090106000
0.4213		10.70	95.00	43.95	60.00	9006090107000
0.4220	27/64	10.72	95.00	43.92	60.00	9006090107200
0.4252		10.80	95.00	43.80	60.00	9006090108000
0.4291		10.90	95.00	43.65	60.00	9006090109000
0.4331		11.00	95.00	43.50	60.00	9006090110000
0.4370		11.10	95.00	43.35	60.00	9006090111000
0.4374	7/16	11.11	95.00	43.34	60.00	9006090111100
0.4409		11.20	95.00	43.20	60.00	9006090112000
0.4449		11.30	95.00	43.05	60.00	9006090113000
0.4488		11.40	95.00	42.90	60.00	9006090114000
0.4528		11.50	95.00	42.75	60.00	9006090115000
0.4531	29/64	11.51	95.00	42.74	60.00	9006090115100
0.4567		11.60	95.00	42.60	60.00	9006090116000
0.4606		11.70	95.00	42.45	60.00	9006090117000
0.4646		11.80	95.00	42.30	60.00	9006090118000
0.4685		11.90	102.00	47.15	65.00	9006090119000
0.4689	15/32	11.91	102.00	47.14	65.00	9006090119100
0.4724		12.00	102.00	47.00	65.00	9006090120000
0.4764		12.10	102.00	46.85	65.00	9006090121000
0.4803		12.20	102.00	46.70	65.00	9006090122000
0.4843	31/64	12.30	102.00	46.55	65.00	9006090123000
0.4882		12.40	102.00	46.40	65.00	9006090124000
0.4921		12.50	102.00	46.25	65.00	9006090125000
0.4961		12.60	102.00	46.10	65.00	9006090126000
0.5000	1/2	12.70	102.00	45.95	65.00	9006090127000
0.5039		12.80	102.00	45.80	65.00	9006090128000
0.5079		12.90	102.00	45.65	65.00	9006090129000

Diameter (d1)			l1 mm	t <sub>max</sub> mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.5118		13.00	102.00	45.50	65.00	9006090130000
0.5157	33/64	13.10	102.00	45.35	65.00	9006090131000
0.5197		13.20	102.00	45.20	65.00	9006090132000
0.5236		13.30	107.00	46.05	66.00	9006090133000
0.5276		13.40	107.00	45.90	66.00	9006090134000
0.5315		13.50	107.00	45.75	66.00	9006090135000
0.5354		13.60	107.00	45.60	66.00	9006090136000
0.5394		13.70	107.00	45.45	66.00	9006090137000
0.5433		13.80	107.00	45.30	66.00	9006090138000
0.5472		13.90	107.00	45.15	66.00	9006090139000
0.5512		14.00	107.00	45.00	66.00	9006090140000
0.5551		14.10	111.00	48.85	70.00	9006090141000
0.5591		14.20	111.00	48.70	70.00	9006090142000
0.5626	9/16	14.29	111.00	48.57	70.00	9006090142900
0.5630		14.30	111.00	48.55	70.00	9006090143000
0.5669		14.40	111.00	48.40	70.00	9006090144000
0.5709		14.50	111.00	48.25	70.00	9006090145000
0.5748		14.60	111.00	48.10	70.00	9006090146000
0.5787		14.70	111.00	47.95	70.00	9006090147000
0.5827		14.80	111.00	47.80	70.00	9006090148000
0.5866		14.90	111.00	47.65	70.00	9006090149000
0.5906		15.00	111.00	47.50	70.00	9006090150000
0.5945		15.10	115.00	50.35	73.00	9006090151000
0.5984		15.20	115.00	50.20	73.00	9006090152000
0.6024		15.30	115.00	50.05	73.00	9006090153000
0.6063		15.40	115.00	49.90	73.00	9006090154000
0.6102		15.50	115.00	49.75	73.00	9006090155000
0.6142		15.60	115.00	49.60	73.00	9006090156000
0.6181		15.70	115.00	49.45	73.00	9006090157000
0.6220		15.80	115.00	49.30	73.00	9006090158000
0.6248	5/8	15.87	115.00	49.20	73.00	9006090158700
0.6260		15.90	115.00	49.15	73.00	9006090159000
0.6693		17.00	119.00	47.50	73.00	9006090170000
0.7087		18.00	123.00	49.00	76.00	9006090180000
0.7283		18.50	127.00	48.25	76.00	9006090185000
0.7480		19.00	127.00	47.50	76.00	9006090190000
0.7500	3/4	19.05	131.00	50.43	79.00	9006090190500
0.7677		19.50	131.00	49.75	79.00	9006090195000
0.7874		20.00	131.00	49.00	79.00	9006090200000