

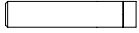
10xD



Bright Finish



External Coolant



Straight Shank

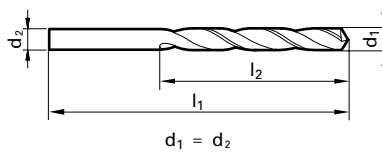
Speeds & Feeds  
information pg 444

## Series 617




## Type Ti

Cobalt, Type Ti, taper length, self-centering 130° split point,  
web thinned all dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



Application Materials:

-  Universal Steels
-  Stainless Steels
-  Ti & Ni Alloys



Dec. inch	Diameter (d1)			l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.0394			1.000	56.00	33.00	9006170010000
0.0402		60	1.020	56.00	33.00	9006170010200
0.0409		59	1.040	56.00	33.00	9006170010400
0.0421		58	1.070	60.00	37.00	9006170010700
0.0429		57	1.090	60.00	37.00	9006170010900
0.0433			1.100	60.00	37.00	9006170011000
0.0465		56	1.180	60.00	37.00	9006170011800
0.0469	3/64		1.190	65.00	41.00	9006170011900
0.0472			1.200	65.00	41.00	9006170012000
0.0512			1.300	65.00	41.00	9006170013000
0.0520		55	1.320	65.00	41.00	9006170013200
0.0551		54	1.400	70.00	45.00	9006170014000
0.0571			1.450	70.00	45.00	9006170014500
0.0591			1.500	70.00	45.00	9006170015000
0.0594		53	1.510	76.00	50.00	9006170015100
0.0626	1/16		1.590	76.00	50.00	9006170015900
0.0630			1.600	76.00	50.00	9006170016000
0.0634		52	1.610	76.00	50.00	9006170016100
0.0650			1.650	76.00	50.00	9006170016500
0.0669		51	1.700	76.00	50.00	9006170017000
0.0689			1.750	80.00	53.00	9006170017500
0.0701		50	1.780	80.00	53.00	9006170017800
0.0709			1.800	80.00	53.00	9006170018000
0.0728		49	1.850	80.00	53.00	9006170018500
0.0748			1.900	80.00	53.00	9006170019000
0.0760		48	1.930	85.00	56.00	9006170019300
0.0768			1.950	85.00	56.00	9006170019500
0.0780	5/64		1.980	85.00	56.00	9006170019800
0.0783		47	1.990	85.00	56.00	9006170019900
0.0787			2.000	85.00	56.00	9006170020000
0.0807			2.050	85.00	56.00	9006170020500
0.0811		46	2.060	85.00	56.00	9006170020600
0.0819		45	2.080	85.00	56.00	9006170020800
0.0827			2.100	85.00	56.00	9006170021000
0.0846			2.150	90.00	59.00	9006170021500
0.0858		44	2.180	90.00	59.00	9006170021800
0.0866			2.200	90.00	59.00	9006170022000
0.0890		43	2.260	90.00	59.00	9006170022600
0.0906			2.300	90.00	59.00	9006170023000
0.0933		42	2.370	95.00	62.00	9006170023700
0.0937	3/32		2.380	95.00	62.00	9006170023800
0.0945			2.400	95.00	62.00	9006170024000
0.0961		41	2.440	95.00	62.00	9006170024400
0.0965			2.450	95.00	62.00	9006170024500
0.0980		40	2.490	95.00	62.00	9006170024900
0.0984			2.500	95.00	62.00	9006170025000
0.1004			2.550	95.00	62.00	9006170025500
0.1016		38	2.580	95.00	62.00	9006170025800
0.1024			2.600	95.00	62.00	9006170026000
0.1039		37	2.640	95.00	62.00	9006170026400
0.1063			2.700	100.00	66.00	9006170027000
0.1067		36	2.710	100.00	66.00	9006170027100
0.1094	7/64		2.780	100.00	66.00	9006170027800

Dec. inch	Diameter (d1)			l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.1098		35	2.790	100.00	66.00	9006170027900
0.1102			2.800	100.00	66.00	9006170028000
0.1110		34	2.820	100.00	66.00	9006170028200
0.1130		33	2.870	100.00	66.00	9006170028700
0.1142			2.900	100.00	66.00	9006170029000
0.1161		32	2.950	100.00	66.00	9006170029500
0.1181			3.000	100.00	66.00	9006170030000
0.1201		31	3.050	106.00	69.00	9006170030500
0.1220			3.100	106.00	69.00	9006170031000
0.1248	1/8		3.170	106.00	69.00	9006170031700
0.1260			3.200	106.00	69.00	9006170032000
0.1280			3.250	106.00	69.00	9006170032500
0.1283		30	3.260	106.00	69.00	9006170032600
0.1299			3.300	106.00	69.00	9006170033000
0.1339			3.400	112.00	73.00	9006170034000
0.1358		29	3.450	112.00	73.00	9006170034500
0.1378			3.500	112.00	73.00	9006170035000
0.1406	9/64	28	3.570	112.00	73.00	9006170035700
0.1417			3.600	112.00	73.00	9006170036000
0.1441		27	3.660	112.00	73.00	9006170036600
0.1457			3.700	112.00	73.00	9006170037000
0.1469		26	3.730	112.00	73.00	9006170037300
0.1496		25	3.800	119.00	78.00	9006170038000
0.1520		24	3.860	119.00	78.00	9006170038600
0.1535			3.900	119.00	78.00	9006170039000
0.1539		23	3.910	119.00	78.00	9006170039100
0.1563	5/32		3.970	119.00	78.00	9006170039700
0.1571		22	3.990	119.00	78.00	9006170039900
0.1575			4.000	119.00	78.00	9006170040000
0.1591		21	4.040	119.00	78.00	9006170040400
0.1594			4.050	119.00	78.00	9006170040500
0.1610		20	4.090	119.00	78.00	9006170040900
0.1614			4.100	119.00	78.00	9006170041000
0.1654			4.200	119.00	78.00	9006170042000
0.1661		19	4.220	119.00	78.00	9006170042200
0.1693		18	4.300	126.00	82.00	9006170043000
0.1720	11/64		4.370	126.00	82.00	9006170043700
0.1728		17	4.390	126.00	82.00	9006170043900
0.1732			4.400	126.00	82.00	9006170044000
0.1772		16	4.500	126.00	82.00	9006170045000
0.1799		15	4.570	126.00	82.00	9006170045700
0.1811			4.600	126.00	82.00	9006170046000
0.1819		14	4.620	126.00	82.00	9006170046200
0.1850		13	4.700	126.00	82.00	9006170047000
0.1874	3/16		4.760	132.00	87.00	9006170047600
0.1890		12	4.800	132.00	87.00	9006170048000
0.1909		11	4.850	132.00	87.00	9006170048500
0.1929			4.900	132.00	87.00	9006170049000
0.1937		10	4.920	132.00	87.00	9006170049200
0.1949			4.950	132.00	87.00	9006170049500
0.1961		9	4.980	132.00	87.00	9006170049800
0.1969			5.000	132.00	87.00	9006170050000
0.1988			5.050	132.00	87.00	9006170050500

# Series 617

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Twist Drills

Dec. inch	Diameter (d1)		I1 mm	I2 mm	EDP #	
	Fract. inch	Wire / letter				
0.1992		8	5.060	132.00	87.00	9006170050600
0.2008			5.100	132.00	87.00	9006170051000
0.2012		7	5.110	132.00	87.00	9006170051100
0.2031	13/64		5.160	132.00	87.00	9006170051600
0.2039		6	5.180	132.00	87.00	9006170051800
0.2047			5.200	132.00	87.00	9006170052000
0.2055		5	5.220	132.00	87.00	9006170052200
0.2087			5.300	132.00	87.00	9006170053000
0.2091		4	5.310	139.00	91.00	9006170053100
0.2126			5.400	139.00	91.00	9006170054000
0.2130		3	5.410	139.00	91.00	9006170054100
0.2165			5.500	139.00	91.00	9006170055000
0.2189	7/32		5.560	139.00	91.00	9006170055600
0.2205			5.600	139.00	91.00	9006170056000
0.2209		2	5.610	139.00	91.00	9006170056100
0.2244			5.700	139.00	91.00	9006170057000
0.2280		1	5.790	139.00	91.00	9006170057900
0.2283			5.800	139.00	91.00	9006170058000
0.2323			5.900	139.00	91.00	9006170059000
0.2339		A	5.940	139.00	91.00	9006170059400
0.2343	15/64		5.950	139.00	91.00	9006170059500
0.2362			6.000	139.00	91.00	9006170060000
0.2378		B	6.040	148.00	97.00	9006170060400
0.2402			6.100	148.00	97.00	9006170061000
0.2421		C	6.150	148.00	97.00	9006170061500
0.2441			6.200	148.00	97.00	9006170062000
0.2461		D	6.250	148.00	97.00	9006170062500
0.2480			6.300	148.00	97.00	9006170063000
0.2500	1/4	E	6.350	148.00	97.00	9006170063500
0.2520			6.400	148.00	97.00	9006170064000
0.2559			6.500	148.00	97.00	9006170065000
0.2571		F	6.530	148.00	97.00	9006170065300
0.2598			6.600	148.00	97.00	9006170066000
0.2610		G	6.630	148.00	97.00	9006170066300
0.2638			6.700	148.00	97.00	9006170067000
0.2657	17/64	H	6.750	156.00	102.00	9006170067500
0.2677			6.800	156.00	102.00	9006170068000
0.2717		I	6.900	156.00	102.00	9006170069000
0.2756			7.000	156.00	102.00	9006170070000
0.2768		J	7.030	156.00	102.00	9006170070300
0.2795			7.100	156.00	102.00	9006170071000
0.2811	9/32	K	7.140	156.00	102.00	9006170071400
0.2835			7.200	156.00	102.00	9006170072000
0.2874			7.300	156.00	102.00	9006170073000
0.2902		L	7.370	156.00	102.00	9006170073700
0.2913			7.400	156.00	102.00	9006170074000
0.2949		M	7.490	156.00	102.00	9006170074900
0.2953			7.500	156.00	102.00	9006170075000
0.2969	19/64		7.540	165.00	109.00	9006170075400
0.2992			7.600	165.00	109.00	9006170076000
0.3020		N	7.670	165.00	109.00	9006170076700
0.3031			7.700	165.00	109.00	9006170077000
0.3071			7.800	165.00	109.00	9006170078000
0.3110			7.900	165.00	109.00	9006170079000
0.3126	5/16		7.940	165.00	109.00	9006170079400
0.3150			8.000	165.00	109.00	9006170080000
0.3161		O	8.030	165.00	109.00	9006170080300
0.3189			8.100	165.00	109.00	9006170081000
0.3228		P	8.200	165.00	109.00	9006170082000
0.3268			8.300	165.00	109.00	9006170083000
0.3280	21/64		8.330	165.00	109.00	9006170083300
0.3307			8.400	165.00	109.00	9006170084000

Dec. inch	Diameter (d1)		I1 mm	I2 mm	EDP #	
	Fract. inch	Wire / letter				
0.3319		Q	8.430	165.00	109.00	9006170084300
0.3346			8.500	165.00	109.00	9006170085000
0.3386			8.600	175.00	115.00	9006170086000
0.3390		R	8.610	175.00	115.00	9006170086100
0.3425			8.700	175.00	115.00	9006170087000
0.3437	11/32		8.730	175.00	115.00	9006170087300
0.3465			8.800	175.00	115.00	9006170088000
0.3480		S	8.840	175.00	115.00	9006170088400
0.3504			8.900	175.00	115.00	9006170089000
0.3543			9.000	175.00	115.00	9006170090000
0.3579		T	9.090	175.00	115.00	9006170090900
0.3583			9.100	175.00	115.00	9006170091000
0.3594	23/64		9.130	175.00	115.00	9006170091300
0.3622			9.200	175.00	115.00	9006170092000
0.3661			9.300	175.00	115.00	9006170093000
0.3677		U	9.340	175.00	115.00	9006170093400
0.3701			9.400	175.00	115.00	9006170094000
0.3740			9.500	175.00	115.00	9006170095000
0.3748	3/8		9.520	184.00	121.00	9006170095200
0.3772		V	9.580	184.00	121.00	9006170095800
0.3780			9.600	184.00	121.00	9006170096000
0.3819			9.700	184.00	121.00	9006170097000
0.3858		W	9.800	184.00	121.00	9006170098000
0.3898			9.900	184.00	121.00	9006170099000
0.3906	25/64		9.920	184.00	121.00	9006170099200
0.3937			10.000	184.00	121.00	9006170100000
0.3969		X	10.080	184.00	121.00	9006170100800
0.3976			10.100	184.00	121.00	9006170101000
0.4016			10.200	184.00	121.00	9006170102000
0.4039		Y	10.260	184.00	121.00	9006170102600
0.4063	13/32		10.320	184.00	121.00	9006170103200
0.4130		Z	10.490	184.00	121.00	9006170104900
0.4134			10.500	184.00	121.00	9006170105000
0.4220	27/64		10.720	195.00	128.00	9006170107200
0.4331			11.000	195.00	128.00	9006170110000
0.4374	7/16		11.110	195.00	128.00	9006170111100
0.4528			11.500	195.00	128.00	9006170115000
0.4531	29/64		11.510	195.00	128.00	9006170115100
0.4689	15/32		11.910	205.00	134.00	9006170119100
0.4724			12.000	205.00	134.00	9006170120000
0.4803			12.200	205.00	134.00	9006170122000
0.4843	31/64		12.300	205.00	134.00	9006170123000
0.4921			12.500	205.00	134.00	9006170125000
0.4961			12.600	205.00	134.00	9006170126000
0.5000	1/2		12.700	205.00	134.00	9006170127000
0.5118			13.000	205.00	134.00	9006170130000
0.5157	33/64		13.100	205.00	134.00	9006170131000
0.5311	17/32		13.490	214.00	140.00	9006170134900
0.5469	35/64		13.890	214.00	140.00	9006170138900
0.5626	9/16		14.290	214.00	140.00	9006170142900
0.5780	37/64		14.680	214.00	140.00	9006170146800
0.5906			15.000	214.00	140.00	9006170150000
0.5937	19/32		15.080	227.00	149.00	9006170150800
0.6094	39/64		15.480	227.00	149.00	9006170154800
0.6248	5/8		15.870	227.00	149.00	9006170158700

### Alternative Drill Series:

- #336 Cobalt, GT100, 10xD, 130 pt, Bright/Nitrided lands > 2.36
- #669 Cobalt, Ti, 10xD, 130 pt, TiN
- #535 HSS, GT100, 10xD, 130 pt, Bright/Nitrided lands > 2.36
- #5537, cobalt, GU 500, 10xD, 118 pt., TiN

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