

Extra Length

#1

Nitrided lands/
polished lands

External Coolant



Straight Shank

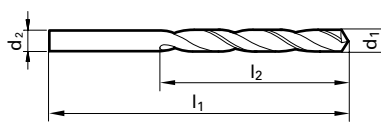
Speeds & Feeds
information pg 445

Series 618

GT 100 Parabolic

Cobalt, GT 100 deep hole, extra length #1, 130° point,
Form A web thinned all dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



$$d_1 = d_2$$

Application Materials:



General Steels



Aluminum & Alloys



Universal Steels

| Dec. inch | Diameter (d1) | | l1 mm | l2 mm | EDP # |
|--------------|----------------|------------------|----------|----------|---------------|
| | Fract. inch | Wire / letter | | | |
| 0.1063 | | | 150.00 | 100.00 | 9006180027000 |
| 0.1142 | | | 150.00 | 100.00 | 9006180029000 |
| 0.1181 | | | 150.00 | 100.00 | 9006180030000 |
| 0.1220 | | | 155.00 | 105.00 | 9006180031000 |
| 0.1248 | 1/8 | | 155.00 | 105.00 | 9006180031700 |
| 0.1260 | | | 155.00 | 105.00 | 9006180032000 |
| 0.1299 | | | 155.00 | 105.00 | 9006180033000 |
| 0.1339 | | | 165.00 | 115.00 | 9006180034000 |
| 0.1378 | | | 165.00 | 115.00 | 9006180035000 |
| 0.1417 | | | 165.00 | 115.00 | 9006180036000 |
| 0.1457 | | | 165.00 | 115.00 | 9006180037000 |
| 0.1496 | | 25 | 175.00 | 120.00 | 9006180038000 |
| 0.1535 | | | 175.00 | 120.00 | 9006180039000 |
| 0.1563 | 5/32 | | 175.00 | 120.00 | 9006180039700 |
| 0.1575 | | | 175.00 | 120.00 | 9006180040000 |
| 0.1614 | | | 175.00 | 120.00 | 9006180041000 |
| 0.1654 | | | 175.00 | 120.00 | 9006180042000 |
| 0.1693 | | 18 | 185.00 | 125.00 | 9006180043000 |
| 0.1720 | 11/64 | | 185.00 | 125.00 | 9006180043700 |
| 0.1732 | | | 185.00 | 125.00 | 9006180044000 |
| 0.1772 | | 16 | 185.00 | 125.00 | 9006180045000 |
| 0.1811 | | | 185.00 | 125.00 | 9006180046000 |
| 0.1874 | 3/16 | | 195.00 | 135.00 | 9006180047600 |
| 0.1890 | | 12 | 195.00 | 135.00 | 9006180048000 |
| 0.1909 | | 11 | 195.00 | 135.00 | 9006180048500 |
| 0.1969 | | | 195.00 | 135.00 | 9006180050000 |
| 0.2008 | | | 195.00 | 135.00 | 9006180051000 |
| 0.2031 | 13/64 | | 195.00 | 135.00 | 9006180051600 |
| 0.2047 | | | 195.00 | 135.00 | 9006180052000 |
| 0.2087 | | | 195.00 | 135.00 | 9006180053000 |
| 0.2126 | | | 205.00 | 140.00 | 9006180054000 |
| 0.2165 | | | 205.00 | 140.00 | 9006180055000 |
| 0.2189 | 7/32 | | 205.00 | 140.00 | 9006180055600 |
| 0.2205 | | | 205.00 | 140.00 | 9006180056000 |
| 0.2244 | | | 205.00 | 140.00 | 9006180057000 |
| 0.2283 | | | 205.00 | 140.00 | 9006180058000 |
| 0.2362 | | | 205.00 | 140.00 | 9006180060000 |
| 0.2402 | | | 215.00 | 150.00 | 9006180061000 |

| Dec. inch | Diameter (d1) | | l1 mm | l2 mm | EDP # |
|--------------|----------------|------------------|----------|----------|---------------|
| | Fract. inch | Wire / letter | | | |
| 0.2441 | | | 215.00 | 150.00 | 9006180062000 |
| 0.2480 | | | 215.00 | 150.00 | 9006180063000 |
| 0.2500 | 1/4 | E | 215.00 | 150.00 | 9006180063500 |
| 0.2520 | | | 215.00 | 150.00 | 9006180064000 |
| 0.2559 | | | 215.00 | 150.00 | 9006180065000 |
| 0.2598 | | | 215.00 | 150.00 | 9006180066000 |
| 0.2638 | | | 215.00 | 150.00 | 9006180067000 |
| 0.2657 | 17/64 | H | 225.00 | 155.00 | 9006180067500 |
| 0.2677 | | | 225.00 | 155.00 | 9006180068000 |
| 0.2756 | | | 225.00 | 155.00 | 9006180070000 |
| 0.2811 | 9/32 | K | 225.00 | 155.00 | 9006180071400 |
| 0.2913 | | | 225.00 | 155.00 | 9006180074000 |
| 0.2953 | | | 225.00 | 155.00 | 9006180075000 |
| 0.2969 | 19/64 | | 240.00 | 165.00 | 9006180075400 |
| 0.3031 | | | 240.00 | 165.00 | 9006180077000 |
| 0.3126 | 5/16 | | 240.00 | 165.00 | 9006180079400 |
| 0.3150 | | | 240.00 | 165.00 | 9006180080000 |
| 0.3228 | | P | 240.00 | 165.00 | 9006180082000 |
| 0.3280 | 21/64 | | 240.00 | 165.00 | 9006180083300 |
| 0.3307 | | | 240.00 | 165.00 | 9006180084000 |
| 0.3346 | | | 240.00 | 165.00 | 9006180085000 |
| 0.3425 | | | 250.00 | 175.00 | 9006180087000 |
| 0.3437 | 11/32 | | 250.00 | 175.00 | 9006180087300 |
| 0.3465 | | | 250.00 | 175.00 | 9006180088000 |
| 0.3543 | | | 250.00 | 175.00 | 9006180090000 |
| 0.3594 | 23/64 | | 250.00 | 175.00 | 9006180091300 |
| 0.3701 | | | 250.00 | 175.00 | 9006180094000 |
| 0.3740 | | | 250.00 | 175.00 | 9006180095000 |
| 0.3748 | 3/8 | | 265.00 | 185.00 | 9006180095200 |
| 0.3819 | | | 265.00 | 185.00 | 9006180097000 |
| 0.3937 | | | 265.00 | 185.00 | 9006180100000 |

Alternative Drill Series:

#502 HSS, GT100, >10xD, 130 pt, Bright
 #670 HSS, GT100, >10xD, 130 pt, TiN
 #524 HSS, GT50, >10xD, 130 pt, Bright