

Extra Length

#1

Nitrided lands/
polished lands

External Coolant



Straight Shank

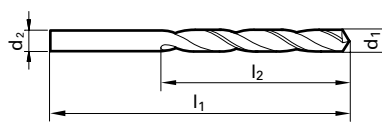
Speeds & Feeds
information pg 445

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