

5xD

Nitrided lands/polished
flutes >2.36mm dia.

External Coolant



Straight Shank

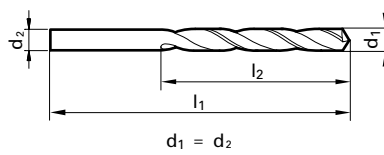
Speeds & Feeds
information pg 446

Series 622

GT 100 Parabolic

Cobalt, GT 100, jobber length, 130° point,
Form A web thinned all dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



Application Materials:



General Steels



Aluminum & Alloys



Universal Steels

Dec. inch	Diameter (d1)			l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.0394			1.000	34.00	12.00	9006220010000
0.0402		60	1.020	34.00	12.00	9006220010200
0.0409		59	1.040	34.00	12.00	9006220010400
0.0413			1.050	34.00	12.00	9006220010500
0.0421		58	1.070	36.00	14.00	9006220010700
0.0429		57	1.090	36.00	14.00	9006220010900
0.0433			1.100	36.00	14.00	9006220011000
0.0453			1.150	36.00	14.00	9006220011500
0.0465		56	1.180	36.00	14.00	9006220011800
0.0469	3/64		1.190	38.00	16.00	9006220011900
0.0472			1.200	38.00	16.00	9006220012000
0.0492			1.250	38.00	16.00	9006220012500
0.0500			1.270	38.00	16.00	9006220012700
0.0512			1.300	38.00	16.00	9006220013000
0.0520		55	1.320	38.00	16.00	9006220013200
0.0531			1.350	40.00	18.00	9006220013500
0.0551		54	1.400	40.00	18.00	9006220014000
0.0563			1.430	40.00	18.00	9006220014300
0.0571			1.450	40.00	18.00	9006220014500
0.0591			1.500	40.00	18.00	9006220015000
0.0594		53	1.510	43.00	20.00	9006220015100
0.0610			1.550	43.00	20.00	9006220015500
0.0626	1/16		1.590	43.00	20.00	9006220015900
0.0630			1.600	43.00	20.00	9006220016000
0.0634		52	1.610	43.00	20.00	9006220016100
0.0650			1.650	43.00	20.00	9006220016500
0.0669		51	1.700	43.00	20.00	9006220017000
0.0701		50	1.780	46.00	22.00	9006220017800
0.0709			1.800	46.00	22.00	9006220018000
0.0728		49	1.850	46.00	22.00	9006220018500
0.0748			1.900	46.00	22.00	9006220019000
0.0756			1.920	49.00	24.00	9006220019200
0.0760		48	1.930	49.00	24.00	9006220019300
0.0768			1.950	49.00	24.00	9006220019500
0.0780	5/64		1.980	49.00	24.00	9006220019800
0.0783		47	1.990	49.00	24.00	9006220019900
0.0787			2.000	49.00	24.00	9006220020000
0.0807			2.050	49.00	24.00	9006220020500
0.0811		46	2.060	49.00	24.00	9006220020600
0.0819		45	2.080	49.00	24.00	9006220020800
0.0827			2.100	49.00	24.00	9006220021000
0.0846			2.150	53.00	27.00	9006220021500
0.0858		44	2.180	53.00	27.00	9006220021800
0.0866			2.200	53.00	27.00	9006220022000
0.0886			2.250	53.00	27.00	9006220022500
0.0890		43	2.260	53.00	27.00	9006220022600
0.0906			2.300	53.00	27.00	9006220023000
0.0925			2.350	53.00	27.00	9006220023500
0.0933		42	2.370	57.00	30.00	9006220023700
0.0937	3/32		2.380	57.00	30.00	9006220023800
0.0945			2.400	57.00	30.00	9006220024000
0.0953			2.420	57.00	30.00	9006220024200
0.0961		41	2.440	57.00	30.00	9006220024400
0.0965			2.450	57.00	30.00	9006220024500
0.0980		40	2.490	57.00	30.00	9006220024900

Dec. inch	Diameter (d1)			l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter	mm			
0.0984			2.500	57.00	30.00	9006220025000
0.0996		39	2.530	57.00	30.00	9006220025300
0.1004			2.550	57.00	30.00	9006220025500
0.1016		38	2.580	57.00	30.00	9006220025800
0.1024			2.600	57.00	30.00	9006220026000
0.1039		37	2.640	57.00	30.00	9006220026400
0.1043			2.650	57.00	30.00	9006220026500
0.1063			2.700	61.00	33.00	9006220027000
0.1067		36	2.710	61.00	33.00	9006220027100
0.1083			2.750	61.00	33.00	9006220027500
0.1094	7/64		2.780	61.00	33.00	9006220027800
0.1098		35	2.790	61.00	33.00	9006220027900
0.1102			2.800	61.00	33.00	9006220028000
0.1110		34	2.820	61.00	33.00	9006220028200
0.1122			2.850	61.00	33.00	9006220028500
0.1130		33	2.870	61.00	33.00	9006220028700
0.1142			2.900	61.00	33.00	9006220029000
0.1161		32	2.950	61.00	33.00	9006220029500
0.1181			3.000	61.00	33.00	9006220030000
0.1201		31	3.050	65.00	36.00	9006220030500
0.1220			3.100	65.00	36.00	9006220031000
0.1248	1/8		3.170	65.00	36.00	9006220031700
0.1260			3.200	65.00	36.00	9006220032000
0.1280			3.250	65.00	36.00	9006220032500
0.1283		30	3.260	65.00	36.00	9006220032600
0.1299			3.300	65.00	36.00	9006220033000
0.1339			3.400	70.00	39.00	9006220034000
0.1358		29	3.450	70.00	39.00	9006220034500
0.1378			3.500	70.00	39.00	9006220035000
0.1406	9/64	28	3.570	70.00	39.00	9006220035700
0.1417			3.600	70.00	39.00	9006220036000
0.1441		27	3.660	70.00	39.00	9006220036600
0.1457			3.700	70.00	39.00	9006220037000
0.1469		26	3.730	70.00	39.00	9006220037300
0.1496		25	3.800	75.00	43.00	9006220038000
0.1520		24	3.860	75.00	43.00	9006220038600
0.1535			3.900	75.00	43.00	9006220039000
0.1539		23	3.910	75.00	43.00	9006220039100
0.1563		5/32	3.970	75.00	43.00	9006220039700
0.1571		22	3.990	75.00	43.00	9006220039900
0.1575			4.000	75.00	43.00	9006220040000
0.1591		21	4.040	75.00	43.00	9006220040400
0.1610		20	4.090	75.00	43.00	9006220040900
0.1614			4.100	75.00	43.00	9006220041000
0.1634			4.150	75.00	43.00	9006220041500
0.1654			4.200	75.00	43.00	9006220042000
0.1661		19	4.220	75.00	43.00	9006220042200
0.1673			4.250	75.00	43.00	9006220042500
0.1693		18	4.300	80.00	47.00	9006220043000
0.1720	11/64		4.370	80.00	47.00	9006220043700
0.1728		17	4.390	80.00	47.00	9006220043900
0.1732			4.400	80.00	47.00	9006220044000
0.1772		16	4.500	80.00	47.00	9006220045000
0.1791			4.550	80.00	47.00	9006220045500
0.1799		15	4.570	80.00	47.00	9006220045700

Series 622

Speeds & Feeds information pg 446

Twist Drills

Dec. Inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.1811			4.600	80.00	47.00	9006220046000
0.1819		14	4.620	80.00	47.00	9006220046200
0.1850		13	4.700	80.00	47.00	9006220047000
0.1870			4.750	80.00	47.00	9006220047500
0.1874	3/16		4.760	86.00	52.00	9006220047600
0.1890		12	4.800	86.00	52.00	9006220048000
0.1909		11	4.850	86.00	52.00	9006220048500
0.1929			4.900	86.00	52.00	9006220049000
0.1937		10	4.920	86.00	52.00	9006220049200
0.1961		9	4.980	86.00	52.00	9006220049800
0.1969			5.000	86.00	52.00	9006220050000
0.1992		8	5.060	86.00	52.00	9006220050600
0.2008			5.100	86.00	52.00	9006220051000
0.2012		7	5.110	86.00	52.00	9006220051100
0.2031	13/64		5.160	86.00	52.00	9006220051600
0.2039		6	5.180	86.00	52.00	9006220051800
0.2047			5.200	86.00	52.00	9006220052000
0.2055		5	5.220	86.00	52.00	9006220052200
0.2067			5.250	86.00	52.00	9006220052500
0.2087			5.300	86.00	52.00	9006220053000
0.2091		4	5.310	93.00	57.00	9006220053100
0.2126			5.400	93.00	57.00	9006220054000
0.2130		3	5.410	93.00	57.00	9006220054100
0.2165			5.500	93.00	57.00	9006220055000
0.2189	7/32		5.560	93.00	57.00	9006220055600
0.2205			5.600	93.00	57.00	9006220056000
0.2209		2	5.610	93.00	57.00	9006220056100
0.2244			5.700	93.00	57.00	9006220057000
0.2264			5.750	93.00	57.00	9006220057500
0.2280		1	5.790	93.00	57.00	9006220057900
0.2283			5.800	93.00	57.00	9006220058000
0.2323			5.900	93.00	57.00	9006220059000
0.2339		A	5.940	93.00	57.00	9006220059400
0.2343	15/64		5.950	93.00	57.00	9006220059500
0.2362			6.000	93.00	57.00	9006220060000
0.2378		B	6.040	101.00	63.00	9006220060400
0.2382			6.050	101.00	63.00	9006220060500
0.2402			6.100	101.00	63.00	9006220061000
0.2421		C	6.150	101.00	63.00	9006220061500
0.2441			6.200	101.00	63.00	9006220062000
0.2461		D	6.250	101.00	63.00	9006220062500
0.2480			6.300	101.00	63.00	9006220063000
0.2500	1/4	E	6.350	101.00	63.00	9006220063500
0.2520			6.400	101.00	63.00	9006220064000
0.2559			6.500	101.00	63.00	9006220065000
0.2571		F	6.530	101.00	63.00	9006220065300
0.2598			6.600	101.00	63.00	9006220066000
0.2610		G	6.630	101.00	63.00	9006220066300
0.2638			6.700	101.00	63.00	9006220067000
0.2657	17/64	H	6.750	109.00	69.00	9006220067500
0.2677			6.800	109.00	69.00	9006220068000
0.2717		I	6.900	109.00	69.00	9006220069000
0.2756			7.000	109.00	69.00	9006220070000
0.2768		J	7.030	109.00	69.00	9006220070300
0.2795			7.100	109.00	69.00	9006220071000
0.2811	9/32	K	7.140	109.00	69.00	9006220071400
0.2835			7.200	109.00	69.00	9006220072000
0.2874			7.300	109.00	69.00	9006220073000
0.2902		L	7.370	109.00	69.00	9006220073700
0.2913			7.400	109.00	69.00	9006220074000
0.2949		M	7.490	109.00	69.00	9006220074900
0.2953			7.500	109.00	69.00	9006220075000
0.2969	19/64		7.540	117.00	75.00	9006220075400
0.2992			7.600	117.00	75.00	9006220076000
0.3020		N	7.670	117.00	75.00	9006220076700
0.3031			7.700	117.00	75.00	9006220077000
0.3051			7.750	117.00	75.00	9006220077500
0.3071			7.800	117.00	75.00	9006220078000
0.3110			7.900	117.00	75.00	9006220079000

Dec. Inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.3126	5/16		7.940	117.00	75.00	9006220079400
0.3150			8.000	117.00	75.00	9006220080000
0.3161		O	8.030	117.00	75.00	9006220080300
0.3189			8.100	117.00	75.00	9006220081000
0.3228		P	8.200	117.00	75.00	9006220082000
0.3268			8.300	117.00	75.00	9006220083000
0.3280	21/64		8.330	117.00	75.00	9006220083300
0.3307			8.400	117.00	75.00	9006220084000
0.3319		Q	8.430	117.00	75.00	9006220084300
0.3346			8.500	117.00	75.00	9006220085000
0.3386			8.600	125.00	81.00	9006220086000
0.3390		R	8.610	125.00	81.00	9006220086100
0.3425			8.700	125.00	81.00	9006220087000
0.3437	11/32		8.730	125.00	81.00	9006220087300
0.3465			8.800	125.00	81.00	9006220088000
0.3480		S	8.840	125.00	81.00	9006220088400
0.3504			8.900	125.00	81.00	9006220089000
0.3543			9.000	125.00	81.00	9006220090000
0.3579		T	9.090	125.00	81.00	9006220090900
0.3583			9.100	125.00	81.00	9006220091000
0.3594	23/64		9.130	125.00	81.00	9006220091300
0.3622			9.200	125.00	81.00	9006220092000
0.3661			9.300	125.00	81.00	9006220093000
0.3677		U	9.340	125.00	81.00	9006220093400
0.3701			9.400	125.00	81.00	9006220094000
0.3740			9.500	125.00	81.00	9006220095000
0.3748	3/8		9.520	133.00	87.00	9006220095200
0.3772		V	9.580	133.00	87.00	9006220095800
0.3780			9.600	133.00	87.00	9006220096000
0.3819			9.700	133.00	87.00	9006220097000
0.3858		W	9.800	133.00	87.00	9006220098000
0.3898			9.900	133.00	87.00	9006220099000
0.3906	25/64		9.920	133.00	87.00	9006220099200
0.3937			10.000	133.00	87.00	9006220100000
0.3969		X	10.080	133.00	87.00	9006220100800
0.3976			10.100	133.00	87.00	9006220101000
0.4016			10.200	133.00	87.00	9006220102000
0.4039		Y	10.260	133.00	87.00	9006220102600
0.4055			10.300	133.00	87.00	9006220103000
0.4063	13/32		10.320	133.00	87.00	9006220103200
0.4094			10.400	133.00	87.00	9006220104000
0.4134			10.500	133.00	87.00	9006220105000
0.4173			10.600	133.00	87.00	9006220106000
0.4213			10.700	142.00	94.00	9006220107000
0.4220	27/64		10.720	142.00	94.00	9006220107200
0.4252			10.800	142.00	94.00	9006220108000
0.4291			10.900	142.00	94.00	9006220109000
0.4331			11.000	142.00	94.00	9006220110000
0.4370			11.100	142.00	94.00	9006220111000
0.4374	7/16		11.110	142.00	94.00	9006220111100
0.4409			11.200	142.00	94.00	9006220112000
0.4449			11.300	142.00	94.00	9006220113000
0.4488			11.400	142.00	94.00	9006220114000
0.4528			11.500	142.00	94.00	9006220115000
0.4531	29/64		11.510	142.00	94.00	9006220115100
0.4567			11.600	142.00	94.00	9006220116000
0.4606			11.700	142.00	94.00	9006220117000
0.4646			11.800	142.00	94.00	9006220118000
0.4689	15/32		11.910	151.00	101.00	9006220119100
0.4724			12.000	151.00	101.00	9006220120000
0.4921			12.500	151.00	101.00	9006220125000
0.5000	1/2		12.700	151.00	101.00	9006220127000
0.5118			13.000	151.00	101.00	9006220130000

Alternative Drill Series:

#658 Cobalt, GT100, 5xD, 130 pt, TiN
 #530, PM cobalt, GT 500, 5xD, 130 pt., FIREX®

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