

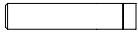
5xD



TiN coated



External Coolant



Straight Shank

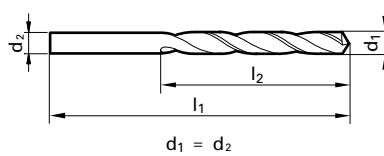
Speeds & Feeds  
information pg 447

Series 652

GT 100 Parabolic

HSS, 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 &amp; Alloys



Universal Steels

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter			
0.0394			34.00	12.00	9006520010000
0.0402		60	34.00	12.00	9006520010200
0.0409		59	34.00	12.00	9006520010400
0.0421		58	36.00	14.00	9006520010700
0.0429		57	36.00	14.00	9006520010900
0.0433			36.00	14.00	9006520011000
0.0465		56	36.00	14.00	9006520011800
0.0469	3/64		38.00	16.00	9006520011900
0.0472			38.00	16.00	9006520012000
0.0480			38.00	16.00	9006520012200
0.0492			38.00	16.00	9006520012500
0.0512			38.00	16.00	9006520013000
0.0520		55	38.00	16.00	9006520013200
0.0531			40.00	18.00	9006520013500
0.0551		54	40.00	18.00	9006520014000
0.0571			40.00	18.00	9006520014500
0.0591			40.00	18.00	9006520015000
0.0594		53	43.00	20.00	9006520015100
0.0602			43.00	20.00	9006520015300
0.0610			43.00	20.00	9006520015500
0.0626	1/16		43.00	20.00	9006520015900
0.0630			43.00	20.00	9006520016000
0.0634		52	43.00	20.00	9006520016100
0.0650			43.00	20.00	9006520016500
0.0669		51	43.00	20.00	9006520017000
0.0677			46.00	22.00	9006520017200
0.0689			46.00	22.00	9006520017500
0.0701		50	46.00	22.00	9006520017800
0.0709			46.00	22.00	9006520018000
0.0728		49	46.00	22.00	9006520018500
0.0748			46.00	22.00	9006520019000
0.0760		48	49.00	24.00	9006520019300
0.0768			49.00	24.00	9006520019500
0.0780	5/64		49.00	24.00	9006520019800
0.0783		47	49.00	24.00	9006520019900
0.0787			49.00	24.00	9006520020000
0.0811		46	49.00	24.00	9006520020600
0.0819		45	49.00	24.00	9006520020800
0.0827			49.00	24.00	9006520021000
0.0846			53.00	27.00	9006520021500
0.0858		44	53.00	27.00	9006520021800
0.0866			53.00	27.00	9006520022000
0.0890		43	53.00	27.00	9006520022600
0.0906			53.00	27.00	9006520023000
0.0925			53.00	27.00	9006520023500
0.0933		42	57.00	30.00	9006520023700
0.0937	3/32		57.00	30.00	9006520023800
0.0945			57.00	30.00	9006520024000
0.0961		41	57.00	30.00	9006520024400
0.0965			57.00	30.00	9006520024500
0.0980		40	57.00	30.00	9006520024900
0.0984			57.00	30.00	9006520025000
0.0996		39	57.00	30.00	9006520025300
0.1004			57.00	30.00	9006520025500

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter			
0.1016		38	57.00	30.00	9006520025800
0.1024			57.00	30.00	9006520026000
0.1039		37	57.00	30.00	9006520026400
0.1043			57.00	30.00	9006520026500
0.1063			61.00	33.00	9006520027000
0.1067		36	61.00	33.00	9006520027100
0.1083			61.00	33.00	9006520027500
0.1094	7/64		61.00	33.00	9006520027800
0.1098		35	61.00	33.00	9006520027900
0.1102			61.00	33.00	9006520028000
0.1110		34	61.00	33.00	9006520028200
0.1122			61.00	33.00	9006520028500
0.1130		33	61.00	33.00	9006520028700
0.1142			61.00	33.00	9006520029000
0.1161		32	61.00	33.00	9006520029500
0.1181			61.00	33.00	9006520030000
0.1201		31	65.00	36.00	9006520030500
0.1220			65.00	36.00	9006520031000
0.1248	1/8		65.00	36.00	9006520031700
0.1260			65.00	36.00	9006520032000
0.1280			65.00	36.00	9006520032500
0.1283		30	65.00	36.00	9006520032600
0.1299			65.00	36.00	9006520033000
0.1339			70.00	39.00	9006520034000
0.1358		29	70.00	39.00	9006520034500
0.1378			70.00	39.00	9006520035000
0.1406	9/64	28	70.00	39.00	9006520035700
0.1417			70.00	39.00	9006520036000
0.1441		27	70.00	39.00	9006520036600
0.1457			70.00	39.00	9006520037000
0.1469		26	70.00	39.00	9006520037300
0.1476			70.00	39.00	9006520037500
0.1496		25	75.00	43.00	9006520038000
0.1520		24	75.00	43.00	9006520038600
0.1535			75.00	43.00	9006520039000
0.1539		23	75.00	43.00	9006520039100
0.1563	5/32		75.00	43.00	9006520039700
0.1571		22	75.00	43.00	9006520039900
0.1575			75.00	43.00	9006520040000
0.1591		21	75.00	43.00	9006520040400
0.1594			75.00	43.00	9006520040500
0.1610		20	75.00	43.00	9006520040900
0.1614			75.00	43.00	9006520041000
0.1654			75.00	43.00	9006520042000
0.1661		19	75.00	43.00	9006520042200
0.1673			75.00	43.00	9006520042500
0.1693		18	80.00	47.00	9006520043000
0.1720	11/64		80.00	47.00	9006520043700
0.1728		17	80.00	47.00	9006520043900
0.1732			80.00	47.00	9006520044000
0.1752			80.00	47.00	9006520044500
0.1772		16	80.00	47.00	9006520045000
0.1799		15	80.00	47.00	9006520045700
0.1811			80.00	47.00	9006520046000

# Series 652

Speeds & Feeds information pg 447

Twist Drills

Diameter (d1)		Wire / letter	mm	I1 mm	I2 mm	EDP #
Dec. inch	Fract. inch					
0.1819		14	4.620	80.00	47.00	9006520046200
0.1850		13	4.700	80.00	47.00	9006520047000
0.1874	3/16		4.760	86.00	52.00	9006520047600
0.1890		12	4.800	86.00	52.00	9006520048000
0.1909		11	4.850	86.00	52.00	9006520048500
0.1929			4.900	86.00	52.00	9006520049000
0.1937		10	4.920	86.00	52.00	9006520049200
0.1961		9	4.980	86.00	52.00	9006520049800
0.1969			5.000	86.00	52.00	9006520050000
0.1992		8	5.060	86.00	52.00	9006520050600
0.2008			5.100	86.00	52.00	9006520051000
0.2012		7	5.110	86.00	52.00	9006520051100
0.2031	13/64		5.160	86.00	52.00	9006520051600
0.2039		6	5.180	86.00	52.00	9006520051800
0.2047			5.200	86.00	52.00	9006520052000
0.2055		5	5.220	86.00	52.00	9006520052200
0.2087			5.300	86.00	52.00	9006520053000
0.2091		4	5.310	93.00	57.00	9006520053100
0.2126			5.400	93.00	57.00	9006520054000
0.2130		3	5.410	93.00	57.00	9006520054100
0.2165			5.500	93.00	57.00	9006520055000
0.2189	7/32		5.560	93.00	57.00	9006520055600
0.2205			5.600	93.00	57.00	9006520056000
0.2209		2	5.610	93.00	57.00	9006520056100
0.2244			5.700	93.00	57.00	9006520057000
0.2264			5.750	93.00	57.00	9006520057500
0.2280		1	5.790	93.00	57.00	9006520057900
0.2283			5.800	93.00	57.00	9006520058000
0.2323			5.900	93.00	57.00	9006520059000
0.2339		A	5.940	93.00	57.00	9006520059400
0.2343	15/64		5.950	93.00	57.00	9006520059500
0.2362			6.000	93.00	57.00	9006520060000
0.2378		B	6.040	101.00	63.00	9006520060400
0.2402			6.100	101.00	63.00	9006520061000
0.2421		C	6.150	101.00	63.00	9006520061500
0.2441			6.200	101.00	63.00	9006520062000
0.2461		D	6.250	101.00	63.00	9006520062500
0.2480			6.300	101.00	63.00	9006520063000
0.2500	1/4	E	6.350	101.00	63.00	9006520063500
0.2520			6.400	101.00	63.00	9006520064000
0.2559			6.500	101.00	63.00	9006520065000
0.2571		F	6.530	101.00	63.00	9006520065300
0.2598			6.600	101.00	63.00	9006520066000
0.2610		G	6.630	101.00	63.00	9006520066300
0.2638			6.700	101.00	63.00	9006520067000
0.2657	17/64	H	6.750	109.00	69.00	9006520067500
0.2677			6.800	109.00	69.00	9006520068000
0.2717		I	6.900	109.00	69.00	9006520069000
0.2756			7.000	109.00	69.00	9006520070000
0.2768		J	7.030	109.00	69.00	9006520070300
0.2795			7.100	109.00	69.00	9006520071000
0.2811	9/32	K	7.140	109.00	69.00	9006520071400
0.2835			7.200	109.00	69.00	9006520072000
0.2874			7.300	109.00	69.00	9006520073000
0.2902		L	7.370	109.00	69.00	9006520073700
0.2913			7.400	109.00	69.00	9006520074000
0.2949		M	7.490	109.00	69.00	9006520074900
0.2953			7.500	109.00	69.00	9006520075000
0.2969	19/64		7.540	117.00	75.00	9006520075400
0.2992			7.600	117.00	75.00	9006520076000
0.3020		N	7.670	117.00	75.00	9006520076700
0.3031			7.700	117.00	75.00	9006520077000
0.3071			7.800	117.00	75.00	9006520078000
0.3110			7.900	117.00	75.00	9006520079000
0.3126	5/16		7.940	117.00	75.00	9006520079400
0.3150			8.000	117.00	75.00	9006520080000

Diameter (d1)		Wire / letter	mm	I1 mm	I2 mm	EDP #
Dec. inch	Fract. inch					
0.3161		O	8.030	117.00	75.00	9006520080300
0.3189			8.100	117.00	75.00	9006520081000
0.3228		P	8.200	117.00	75.00	9006520082000
0.3280	21/64		8.330	117.00	75.00	9006520083300
0.3307			8.400	117.00	75.00	9006520084000
0.3319		Q	8.430	117.00	75.00	9006520084300
0.3346			8.500	117.00	75.00	9006520085000
0.3386			8.600	125.00	81.00	9006520086000
0.3390		R	8.610	125.00	81.00	9006520086100
0.3425			8.700	125.00	81.00	9006520087000
0.3437	11/32		8.730	125.00	81.00	9006520087300
0.3465			8.800	125.00	81.00	9006520088000
0.3480		S	8.840	125.00	81.00	9006520088400
0.3504			8.900	125.00	81.00	9006520089000
0.3543			9.000	125.00	81.00	9006520090000
0.3583			9.100	125.00	81.00	9006520091000
0.3594	23/64		9.130	125.00	81.00	9006520091300
0.3622			9.200	125.00	81.00	9006520092000
0.3661			9.300	125.00	81.00	9006520093000
0.3677		U	9.340	125.00	81.00	9006520093400
0.3701			9.400	125.00	81.00	9006520094000
0.3740			9.500	125.00	81.00	9006520095000
0.3748	3/8		9.520	133.00	87.00	9006520095200
0.3780			9.600	133.00	87.00	9006520096000
0.3819			9.700	133.00	87.00	9006520097000
0.3858		W	9.800	133.00	87.00	9006520098000
0.3898			9.900	133.00	87.00	9006520099000
0.3906	25/64		9.920	133.00	87.00	9006520099200
0.3937			10.000	133.00	87.00	9006520100000
0.4016			10.200	133.00	87.00	9006520102000
0.4063	13/32		10.320	133.00	87.00	9006520103200
0.4130		Z	10.490	133.00	87.00	9006520104900
0.4134			10.500	133.00	87.00	9006520105000
0.4213			10.700	142.00	94.00	9006520107000
0.4220	27/64		10.720	142.00	94.00	9006520107200
0.4331			11.000	142.00	94.00	9006520110000
0.4374	7/16		11.110	142.00	94.00	9006520111100
0.4409			11.200	142.00	94.00	9006520112000
0.4528			11.500	142.00	94.00	9006520115000
0.4531	29/64		11.510	142.00	94.00	9006520115100
0.4606			11.700	142.00	94.00	9006520117000
0.4689	15/32		11.910	151.00	101.00	9006520119100
0.4724			12.000	151.00	101.00	9006520120000
0.4764			12.100	151.00	101.00	9006520121000
0.4843	31/64		12.300	151.00	101.00	9006520123000
0.4921			12.500	151.00	101.00	9006520125000
0.5000	1/2		12.700	151.00	101.00	9006520127000
0.5039			12.800	151.00	101.00	9006520128000
0.5118			13.000	151.00	101.00	9006520130000
0.5157	33/64		13.100	151.00	101.00	9006520131000
0.5311	17/32		13.490	160.00	108.00	9006520134900
0.5315			13.500	160.00	108.00	9006520135000
0.5469	35/64		13.890	160.00	108.00	9006520138900
0.5512			14.000	160.00	108.00	9006520140000
0.5626	9/16		14.290	169.00	114.00	9006520142900
0.5906			15.000	169.00	114.00	9006520150000
0.6299			16.000	178.00	120.00	9006520160000

### Alternative Drill Series:

- #549 HSS, GT100, 5xD, 130 pt, Bright/Nitrided lands > 2.36
- #658 Cobalt, GT100, 5xD, 130 pt, TiN
- #622 Cobalt, GT100, 5xD, 130 pt, Bright/Nitrided lands > 2.36
- #1221 Cobalt, GT100, 5xD, 130 pt, TiCN
- #530 PM Cobalt, GT500, 5xD, 130 pt, FIREX®

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