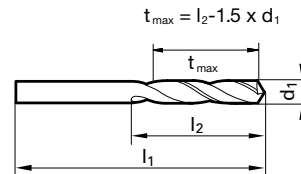




Tool material **HSS**
Surface **S**

- P** Steel ● web thinning $\geq \varnothing 1.000$ • relieved cone • also for hand drilling machines • for use in automatic/capstan lathes
 - M** Stainless steel
 - K** Cast iron ● thin materials
 - N** Aluminum ○
 - S** Titanium alloys
 - H** Hardened steel
- =Optimal
○=Limited



Stub Length

Speeds and feeds information on pg. 535

Shank diameter = cut diameter

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.0197		0.50	20.00	2.25	3.00	9006530005000
0.0236		0.60	21.00	2.60	3.50	9006530006000
0.0276		0.70	23.00	3.45	4.50	9006530007000
0.0295		0.75	23.00	3.38	4.50	9006530007500
0.0315		0.80	24.00	3.80	5.00	9006530008000
0.0354		0.90	25.00	4.15	5.50	9006530009000
0.0394		1.00	26.00	4.50	6.00	9006530010000
0.0402	#60	1.02	26.00	4.47	6.00	9006530010200
0.0413		1.05	26.00	4.43	6.00	9006530010500
0.0421	#58	1.07	28.00	5.40	7.00	9006530010700
0.0429	#57	1.09	28.00	5.37	7.00	9006530010900
0.0433		1.10	28.00	5.35	7.00	9006530011000
0.0437		1.11	28.00	5.34	7.00	9006530011100
0.0453		1.15	28.00	5.28	7.00	9006530011500
0.0465	#56	1.18	28.00	5.23	7.00	9006530011800
0.0469	3/64	1.19	30.00	6.22	8.00	9006530011900
0.0472		1.20	30.00	6.20	8.00	9006530012000
0.0492		1.25	30.00	6.13	8.00	9006530012500
0.0504		1.28	30.00	6.08	8.00	9006530012800
0.0512		1.30	30.00	6.05	8.00	9006530013000
0.0520	#55	1.32	30.00	6.02	8.00	9006530013200
0.0531		1.35	32.00	6.98	9.00	9006530013500
0.0551	#54	1.40	32.00	6.90	9.00	9006530014000
0.0571		1.45	32.00	6.83	9.00	9006530014500
0.0591		1.50	32.00	6.75	9.00	9006530015000
0.0594	#53	1.51	34.00	7.74	10.00	9006530015100
0.0610		1.55	34.00	7.68	10.00	9006530015500
0.0626	1/16	1.59	34.00	7.62	10.00	9006530015900
0.0630		1.60	34.00	7.60	10.00	9006530016000
0.0634	#52	1.61	34.00	7.59	10.00	9006530016100
0.0650		1.65	34.00	7.53	10.00	9006530016500
0.0669	#51	1.70	34.00	7.45	10.00	9006530017000
0.0701	#50	1.78	36.00	8.33	11.00	9006530017800
0.0709		1.80	36.00	8.30	11.00	9006530018000
0.0728	#49	1.85	36.00	8.23	11.00	9006530018500
0.0748		1.90	36.00	8.15	11.00	9006530019000
0.0760	#48	1.93	38.00	9.11	12.00	9006530019300
0.0768		1.95	38.00	9.08	12.00	9006530019500
0.0780	5/64	1.98	38.00	9.03	12.00	9006530019800
0.0783	#47	1.99	38.00	9.02	12.00	9006530019900
0.0787		2.00	38.00	9.00	12.00	9006530020000
0.0811	#46	2.06	38.00	8.91	12.00	9006530020600

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.0819	#45	2.08	38.00	8.88	12.00	9006530020800
0.0827		2.10	38.00	8.85	12.00	9006530021000
0.0858	#44	2.18	40.00	9.73	13.00	9006530021800
0.0866		2.20	40.00	9.70	13.00	9006530022000
0.0886		2.25	40.00	9.63	13.00	9006530022500
0.0890	#43	2.26	40.00	9.61	13.00	9006530022600
0.0906		2.30	40.00	9.55	13.00	9006530023000
0.0925		2.35	40.00	9.48	13.00	9006530023500
0.0933	#42	2.37	43.00	10.45	14.00	9006530023700
0.0937	3/32	2.38	43.00	10.43	14.00	9006530023800
0.0945		2.40	43.00	10.40	14.00	9006530024000
0.0961	#41	2.44	43.00	10.34	14.00	9006530024400
0.0965		2.45	43.00	10.33	14.00	9006530024500
0.0984		2.50	43.00	10.25	14.00	9006530025000
0.0996	#39	2.53	43.00	10.21	14.00	9006530025300
0.1004		2.55	43.00	10.18	14.00	9006530025500
0.1016	#38	2.58	43.00	10.13	14.00	9006530025800
0.1024		2.60	43.00	10.10	14.00	9006530026000
0.1039	#37	2.64	43.00	10.04	14.00	9006530026400
0.1063		2.70	46.00	11.95	16.00	9006530027000
0.1067	#36	2.71	46.00	11.94	16.00	9006530027100
0.1083		2.75	46.00	11.88	16.00	9006530027500
0.1094	7/64	2.78	46.00	11.83	16.00	9006530027800
0.1102		2.80	46.00	11.80	16.00	9006530028000
0.1130	#33	2.87	46.00	11.70	16.00	9006530028700
0.1142		2.90	46.00	11.65	16.00	9006530029000
0.1161	#32	2.95	46.00	11.58	16.00	9006530029500
0.1181		3.00	46.00	11.50	16.00	9006530030000
0.1201	#31	3.05	49.00	13.43	18.00	9006530030500
0.1220		3.10	49.00	13.35	18.00	9006530031000
0.1248	1/8	3.17	49.00	13.25	18.00	9006530031700
0.1260		3.20	49.00	13.20	18.00	9006530032000
0.1280		3.25	49.00	13.13	18.00	9006530032500
0.1283	#30	3.26	49.00	13.11	18.00	9006530032600
0.1299		3.30	49.00	13.05	18.00	9006530033000
0.1339		3.40	52.00	14.90	20.00	9006530034000
0.1358	#29	3.45	52.00	14.83	20.00	9006530034500
0.1378		3.50	52.00	14.75	20.00	9006530035000
0.1406	9/64	3.57	52.00	14.65	20.00	9006530035700
0.1417		3.60	52.00	14.60	20.00	9006530036000
0.1437		3.65	52.00	14.53	20.00	9006530036500
0.1441	#27	3.66	52.00	14.51	20.00	9006530036600

Stub Length

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.1457		3.70	52.00	14.45	20.00	9006530037000
0.1469	#26	3.73	52.00	14.41	20.00	9006530037300
0.1476		3.75	52.00	14.38	20.00	9006530037500
0.1496	#25	3.80	55.00	16.30	22.00	9006530038000
0.1535		3.90	55.00	16.15	22.00	9006530039000
0.1563	5/32	3.97	55.00	16.05	22.00	9006530039700
0.1571	#22	3.99	55.00	16.02	22.00	9006530039900
0.1575		4.00	55.00	16.00	22.00	9006530040000
0.1591	#21	4.04	55.00	15.94	22.00	9006530040400
0.1610	#20	4.09	55.00	15.87	22.00	9006530040900
0.1614		4.10	55.00	15.85	22.00	9006530041000
0.1634		4.15	55.00	15.78	22.00	9006530041500
0.1654		4.20	55.00	15.70	22.00	9006530042000
0.1673		4.25	55.00	15.63	22.00	9006530042500
0.1693	#18	4.30	58.00	17.55	24.00	9006530043000
0.1720	11/64	4.37	58.00	17.45	24.00	9006530043700
0.1732		4.40	58.00	17.40	24.00	9006530044000
0.1772	#16	4.50	58.00	17.25	24.00	9006530045000
0.1799	#15	4.57	58.00	17.15	24.00	9006530045700
0.1811		4.60	58.00	17.10	24.00	9006530046000
0.1819	#14	4.62	58.00	17.07	24.00	9006530046200
0.1831		4.65	58.00	17.03	24.00	9006530046500
0.1850	#13	4.70	58.00	16.95	24.00	9006530047000
0.1874	3/16	4.76	62.00	18.86	26.00	9006530047600
0.1890	#12	4.80	62.00	18.80	26.00	9006530048000
0.1909	#11	4.85	62.00	18.73	26.00	9006530048500
0.1929		4.90	62.00	18.65	26.00	9006530049000
0.1937	#10	4.92	62.00	18.62	26.00	9006530049200
0.1961	#9	4.98	62.00	18.53	26.00	9006530049800
0.1969		5.00	62.00	18.50	26.00	9006530050000
0.1988		5.05	62.00	18.43	26.00	9006530050500
0.1992	#8	5.06	62.00	18.41	26.00	9006530050600
0.2008		5.10	62.00	18.35	26.00	9006530051000
0.2012	#7	5.11	62.00	18.34	26.00	9006530051100
0.2031	13/64	5.16	62.00	18.26	26.00	9006530051600
0.2039	#6	5.18	62.00	18.23	26.00	9006530051800
0.2047		5.20	62.00	18.20	26.00	9006530052000
0.2067		5.25	62.00	18.13	26.00	9006530052500
0.2087		5.30	62.00	18.05	26.00	9006530053000
0.2091	#4	5.31	66.00	20.04	28.00	9006530053100
0.2126		5.40	66.00	19.90	28.00	9006530054000
0.2130	#3	5.41	66.00	19.89	28.00	9006530054100
0.2165		5.50	66.00	19.75	28.00	9006530055000
0.2189	7/32	5.56	66.00	19.66	28.00	9006530055600
0.2197		5.58	66.00	19.63	28.00	9006530055800
0.2205		5.60	66.00	19.60	28.00	9006530056000
0.2209	#2	5.61	66.00	19.59	28.00	9006530056100
0.2244		5.70	66.00	19.45	28.00	9006530057000
0.2264		5.75	66.00	19.38	28.00	9006530057500
0.2283		5.80	66.00	19.30	28.00	9006530058000
0.2323		5.90	66.00	19.15	28.00	9006530059000
0.2343	15/64	5.95	66.00	19.08	28.00	9006530059500
0.2362		6.00	66.00	19.00	28.00	9006530060000
0.2382		6.05	70.00	21.93	31.00	9006530060500
0.2402		6.10	70.00	21.85	31.00	9006530061000
0.2421	C	6.15	70.00	21.78	31.00	9006530061500
0.2441		6.20	70.00	21.70	31.00	9006530062000
0.2461	D	6.25	70.00	21.63	31.00	9006530062500
0.2480		6.30	70.00	21.55	31.00	9006530063000
0.2500	1/4	6.35	70.00	21.48	31.00	9006530063500
0.2520		6.40	70.00	21.40	31.00	9006530064000
0.2539		6.45	70.00	21.33	31.00	9006530064500
0.2559		6.50	70.00	21.25	31.00	9006530065000
0.2571	F	6.53	70.00	21.21	31.00	9006530065300
0.2598		6.60	70.00	21.10	31.00	9006530066000
0.2638		6.70	70.00	20.95	31.00	9006530067000

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #	
inch	wire/ltr	mm					
0.2657	17/64	H	6.75	74.00	23.88	34.00	9006530067500
0.2677			6.80	74.00	23.80	34.00	9006530068000
0.2717		I	6.90	74.00	23.65	34.00	9006530069000
0.2756			7.00	74.00	23.50	34.00	9006530070000
0.2795			7.10	74.00	23.35	34.00	9006530071000
0.2811	9/32	K	7.14	74.00	23.29	34.00	9006530071400
0.2835			7.20	74.00	23.20	34.00	9006530072000
0.2854			7.25	74.00	23.13	34.00	9006530072500
0.2874			7.30	74.00	23.05	34.00	9006530073000
0.2902		L	7.37	74.00	22.95	34.00	9006530073700
0.2913			7.40	74.00	22.90	34.00	9006530074000
0.2953			7.50	74.00	22.75	34.00	9006530075000
0.2969	19/64		7.54	79.00	25.69	37.00	9006530075400
0.2992			7.60	79.00	25.60	37.00	9006530076000
0.3020		N	7.67	79.00	25.50	37.00	9006530076700
0.3031			7.70	79.00	25.45	37.00	9006530077000
0.3071			7.80	79.00	25.30	37.00	9006530078000
0.3110			7.90	79.00	25.15	37.00	9006530079000
0.3126	5/16		7.94	79.00	25.09	37.00	9006530079400
0.3150			8.00	79.00	25.00	37.00	9006530080000
0.3161		O	8.03	79.00	24.96	37.00	9006530080300
0.3189			8.10	79.00	24.85	37.00	9006530081000
0.3228		P	8.20	79.00	24.70	37.00	9006530082000
0.3248			8.25	79.00	24.63	37.00	9006530082500
0.3268			8.30	79.00	24.55	37.00	9006530083000
0.3280	21/64		8.33	79.00	24.51	37.00	9006530083300
0.3307			8.40	79.00	24.40	37.00	9006530084000
0.3319		Q	8.43	79.00	24.36	37.00	9006530084300
0.3346			8.50	79.00	24.25	37.00	9006530085000
0.3366			8.55	84.00	27.18	40.00	9006530085500
0.3386			8.60	84.00	27.10	40.00	9006530086000
0.3390		R	8.61	84.00	27.09	40.00	9006530086100
0.3425			8.70	84.00	26.95	40.00	9006530087000
0.3437	11/32		8.73	84.00	26.91	40.00	9006530087300
0.3445			8.75	84.00	26.88	40.00	9006530087500
0.3465			8.80	84.00	26.80	40.00	9006530088000
0.3504			8.90	84.00	26.65	40.00	9006530089000
0.3543			9.00	84.00	26.50	40.00	9006530090000
0.3579		T	9.09	84.00	26.37	40.00	9006530090900
0.3594	23/64		9.13	84.00	26.31	40.00	9006530091300
0.3622			9.20	84.00	26.20	40.00	9006530092000
0.3642			9.25	84.00	26.13	40.00	9006530092500
0.3661			9.30	84.00	26.05	40.00	9006530093000
0.3701			9.40	84.00	25.90	40.00	9006530094000
0.3740			9.50	84.00	25.75	40.00	9006530095000
0.3748	3/8		9.52	89.00	28.72	43.00	9006530095200
0.3772		V	9.58	89.00	28.63	43.00	9006530095800
0.3819			9.70	89.00	28.45	43.00	9006530097000
0.3858		W	9.80	89.00	28.30	43.00	9006530098000
0.3898			9.90	89.00	28.15	43.00	9006530099000
0.3906	25/64		9.92	89.00	28.12	43.00	9006530099200
0.3937			10.00	89.00	28.00	43.00	9006530100000
0.3976			10.10	89.00	27.85	43.00	9006530101000
0.4016			10.20	89.00	27.70	43.00	9006530102000
0.4055			10.30	89.00	27.55	43.00	9006530103000
0.4063	13/32		10.32	89.00	27.52	43.00	9006530103200
0.4130		Z	10.49	89.00	27.27	43.00	9006530104900
0.4134			10.50	89.00	27.25	43.00	9006530105000
0.4173			10.60	89.00	27.10	43.00	9006530106000
0.4220	27/64		10.72	95.00	30.92	47.00	9006530107200
0.4232			10.75	95.00	30.88	47.00	9006530107500
0.4252			10.80	95.00	30.80	47.00	9006530108000
0.4331			11.00	95.00	30.50	47.00	9006530110000
0.4374	7/16		11.11	95.00	30.34	47.00	9006530111100
0.4409			11.20	95.00	30.20	47.00	9006530112000
0.4449			11.30	95.00	30.05	47.00	9006530113000

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.4488		11.40	95.00	29.90	47.00	9006530114000
0.4528		11.50	95.00	29.75	47.00	9006530115000
0.4531	29/64	11.51	95.00	29.74	47.00	9006530115100
0.4646		11.80	95.00	29.30	47.00	9006530118000
0.4689	15/32	11.91	102.00	33.14	51.00	9006530119100
0.4724		12.00	102.00	33.00	51.00	9006530120000
0.4764		12.10	102.00	32.85	51.00	9006530121000
0.4803		12.20	102.00	32.70	51.00	9006530122000
0.4843	31/64	12.30	102.00	32.55	51.00	9006530123000
0.4921		12.50	102.00	32.25	51.00	9006530125000
0.5000	1/2	12.70	102.00	31.95	51.00	9006530127000
0.5039		12.80	102.00	31.80	51.00	9006530128000
0.5118		13.00	102.00	31.50	51.00	9006530130000
0.5157	33/64	13.10	102.00	31.35	51.00	9006530131000
0.5311	17/32	13.49	107.00	33.77	54.00	9006530134900
0.5315		13.50	107.00	33.75	54.00	9006530135000
0.5433		13.80	107.00	33.30	54.00	9006530138000
0.5469	35/64	13.89	107.00	33.17	54.00	9006530138900
0.5512		14.00	107.00	33.00	54.00	9006530140000
0.5626	9/16	14.29	111.00	34.57	56.00	9006530142900
0.5709		14.50	111.00	34.25	56.00	9006530145000
0.5827		14.80	111.00	33.80	56.00	9006530148000
0.5906		15.00	111.00	33.50	56.00	9006530150000
0.5937	19/32	15.08	115.00	35.38	58.00	9006530150800
0.6024		15.30	115.00	35.05	58.00	9006530153000
0.6102		15.50	115.00	34.75	58.00	9006530155000
0.6220		15.80	115.00	34.30	58.00	9006530158000
0.6248	5/8	15.87	115.00	34.20	58.00	9006530158700
0.6299		16.00	115.00	34.00	58.00	9006530160000
0.6406	41/64	16.27	119.00	35.60	60.00	9006530162700

Diameter (d1)			l1 mm	t _{max} mm	l2 mm	EDP #
inch	wire/ltr	mm				
0.6496		16.50	119.00	35.25	60.00	9006530165000
0.6563	21/32	16.67	119.00	35.00	60.00	9006530166700
0.6693		17.00	119.00	34.50	60.00	9006530170000
0.6874	11/16	17.46	123.00	35.81	62.00	9006530174600
0.6890		17.50	123.00	35.75	62.00	9006530175000
0.7031	45/64	17.86	123.00	35.21	62.00	9006530178600
0.7087		18.00	123.00	35.00	62.00	9006530180000
0.7185		18.25	127.00	36.63	64.00	9006530182500
0.7189	23/32	18.26	127.00	36.61	64.00	9006530182600
0.7283		18.50	127.00	36.25	64.00	9006530185000
0.7343	47/64	18.65	127.00	36.03	64.00	9006530186500
0.7480		19.00	127.00	35.50	64.00	9006530190000
0.7500	3/4	19.05	131.00	37.43	66.00	9006530190500
0.7677		19.50	131.00	36.75	66.00	9006530195000
0.7874		20.00	131.00	36.00	66.00	9006530200000
0.8071		20.50	136.00	37.25	68.00	9006530205000
0.8126	13/16	20.64	136.00	37.04	68.00	9006530206400
0.8268		21.00	136.00	36.50	68.00	9006530210000
0.8465		21.50	141.00	37.75	70.00	9006530215000
0.8661		22.00	141.00	37.00	70.00	9006530220000
0.8858		22.50	146.00	38.25	72.00	9006530225000
0.8906	57/64	22.62	146.00	38.07	72.00	9006530226200
0.9055		23.00	146.00	37.50	72.00	9006530230000
0.9220	59/64	23.42	146.00	36.87	72.00	9006530234200
0.9449		24.00	151.00	39.00	75.00	9006530240000
0.9646		24.50	151.00	38.25	75.00	9006530245000
0.9843	63/64	25.00	151.00	37.50	75.00	9006530250000
1.0000	1.0000	25.40	156.00	39.90	78.00	9006530254000
1.1220		28.50	168.00	41.25	84.00	9006530285000

Stub Length