

# 5xD



TiN coated



External Coolant



Morse Taper Shank

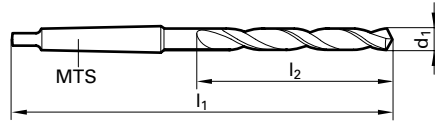
Speeds & Feeds  
information pg 448

# Series 654

## General Purpose

HSS, general purpose (Type N), jobber length, 118° point, Form A web thinned all dia., Morse Taper shank, RH helix

Cut / Shank Dia. = h8 tolerance range



### Application Materials:

- Universal Steels
- Cast Iron
- General Steels

Twist Drills

Dec. inch	Diameter (d1)		Shank size	l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter					
0.1181			3.000	MTS 1	114.00	33.00	9006540030000
0.1720	11/64		4.370	MTS 1	128.00	47.00	9006540043700
0.1874	3/16		4.760	MTS 1	133.00	52.00	9006540047600
0.2031	13/64		5.160	MTS 1	133.00	52.00	9006540051600
0.2559			6.500	MTS 1	144.00	63.00	9006540065000
0.2657	17/64	H	6.750	MTS 1	150.00	69.00	9006540067500
0.2811	9/32	K	7.140	MTS 1	150.00	69.00	9006540071400
0.2969	19/64		7.540	MTS 1	156.00	75.00	9006540075400
0.3031			7.700	MTS 1	156.00	75.00	9006540077000
0.3126	5/16		7.940	MTS 1	156.00	75.00	9006540079400
0.3150			8.000	MTS 1	156.00	75.00	9006540080000
0.3228		P	8.200	MTS 1	156.00	75.00	9006540082000
0.3280	21/64		8.330	MTS 1	156.00	75.00	9006540083300
0.3437	11/32		8.730	MTS 1	162.00	81.00	9006540087300
0.3748	3/8		9.520	MTS 1	168.00	87.00	9006540095200
0.3858		W	9.800	MTS 1	168.00	87.00	9006540098000
0.3937			10.000	MTS 1	168.00	87.00	9006540100000
0.4016			10.200	MTS 1	168.00	87.00	9006540102000
0.4035			10.250	MTS 1	168.00	87.00	9006540102500
0.4063	13/32		10.320	MTS 1	168.00	87.00	9006540103200
0.4134			10.500	MTS 1	168.00	87.00	9006540105000
0.4220	27/64		10.720	MTS 1	175.00	94.00	9006540107200
0.4252			10.800	MTS 1	175.00	94.00	9006540108000
0.4331			11.000	MTS 1	175.00	94.00	9006540110000
0.4374	7/16		11.110	MTS 1	175.00	94.00	9006540111100
0.4409			11.200	MTS 1	175.00	94.00	9006540112000
0.4429			11.250	MTS 1	175.00	94.00	9006540112500
0.4528			11.500	MTS 1	175.00	94.00	9006540115000
0.4531	29/64		11.510	MTS 1	175.00	94.00	9006540115100
0.4626			11.750	MTS 1	175.00	94.00	9006540117500
0.4646			11.800	MTS 1	175.00	94.00	9006540118000
0.4689	15/32		11.910	MTS 1	182.00	101.00	9006540119100
0.4724			12.000	MTS 1	182.00	101.00	9006540120000
0.4803			12.200	MTS 1	182.00	101.00	9006540122000
0.4823			12.250	MTS 1	182.00	101.00	9006540122500
0.4843	31/64		12.300	MTS 1	182.00	101.00	9006540123000
0.4921			12.500	MTS 1	182.00	101.00	9006540125000
0.5000	1/2		12.700	MTS 1	182.00	101.00	9006540127000
0.5020			12.750	MTS 1	182.00	101.00	9006540127500
0.5039			12.800	MTS 1	182.00	101.00	9006540128000
0.5118			13.000	MTS 1	182.00	101.00	9006540130000
0.5157	33/64		13.100	MTS 1	182.00	101.00	9006540131000
0.5217			13.250	MTS 1	189.00	108.00	9006540132500
0.5311	17/32		13.490	MTS 1	189.00	108.00	9006540134900
0.5315			13.500	MTS 1	189.00	108.00	9006540135000
0.5413			13.750	MTS 1	189.00	108.00	9006540137500
0.5469	35/64		13.890	MTS 1	189.00	108.00	9006540138900
0.5512			14.000	MTS 1	189.00	108.00	9006540140000
0.5591			14.200	MTS 2	212.00	114.00	9006540142000
0.5610			14.250	MTS 2	212.00	114.00	9006540142500
0.5626	9/16		14.290	MTS 2	212.00	114.00	9006540142900
0.5709			14.500	MTS 2	212.00	114.00	9006540145000
0.5748			14.600	MTS 2	212.00	114.00	9006540146000
0.5780	37/64		14.680	MTS 2	212.00	114.00	9006540146800
0.5807			14.750	MTS 2	212.00	114.00	9006540147500

Dec. inch	Diameter (d1)		Shank size	l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter					
0.5906			15.000	MTS 2	212.00	114.00	9006540150000
0.5937	19/32		15.080	MTS 2	218.00	120.00	9006540150800
0.5945			15.100	MTS 2	218.00	120.00	9006540151000
0.6004			15.250	MTS 2	218.00	120.00	9006540152500
0.6094	39/64		15.480	MTS 2	218.00	120.00	9006540154800
0.6102			15.500	MTS 2	218.00	120.00	9006540155000
0.6201			15.750	MTS 2	218.00	120.00	9006540157500
0.6248	5/8		15.870	MTS 2	218.00	120.00	9006540158700
0.6299			16.000	MTS 2	218.00	120.00	9006540160000
0.6398			16.250	MTS 2	223.00	125.00	9006540162500
0.6406	41/64		16.270	MTS 2	223.00	125.00	9006540162700
0.6496			16.500	MTS 2	223.00	125.00	9006540165000
0.6563	21/32		16.670	MTS 2	223.00	125.00	9006540166700
0.6594			16.750	MTS 2	223.00	125.00	9006540167500
0.6693			17.000	MTS 2	223.00	125.00	9006540170000
0.6720	43/64		17.070	MTS 2	228.00	130.00	9006540170700
0.6791			17.250	MTS 2	228.00	130.00	9006540172500
0.6874	11/16		17.460	MTS 2	228.00	130.00	9006540174600
0.6890			17.500	MTS 2	228.00	130.00	9006540175000
0.6988			17.750	MTS 2	228.00	130.00	9006540177500
0.7087			18.000	MTS 2	228.00	130.00	9006540180000
0.7185			18.250	MTS 2	233.00	135.00	9006540182500
0.7189	23/32		18.260	MTS 2	233.00	135.00	9006540182600
0.7283			18.500	MTS 2	233.00	135.00	9006540185000
0.7343	47/64		18.650	MTS 2	233.00	135.00	9006540186500
0.7382			18.750	MTS 2	233.00	135.00	9006540187500
0.7480			19.000	MTS 2	233.00	135.00	9006540190000
0.7500	3/4		19.050	MTS 2	238.00	140.00	9006540190500
0.7579			19.250	MTS 2	238.00	140.00	9006540192500
0.7657	49/64		19.450	MTS 2	238.00	140.00	9006540194500
0.7677			19.500	MTS 2	238.00	140.00	9006540195000
0.7776			19.750	MTS 2	238.00	140.00	9006540197500
0.7811	25/32		19.840	MTS 2	238.00	140.00	9006540198400
0.7874			20.000	MTS 2	238.00	140.00	9006540200000
0.7972			20.250	MTS 2	243.00	145.00	9006540202500
0.8071			20.500	MTS 2	243.00	145.00	9006540205000
0.8126	13/16		20.640	MTS 2	243.00	145.00	9006540206400
0.8169			20.750	MTS 2	243.00	145.00	9006540207500
0.8268			21.000	MTS 2	243.00	145.00	9006540210000
0.8366			21.250	MTS 2	248.00	150.00	9006540212500
0.8437	27/32		21.430	MTS 2	248.00	150.00	9006540214300
0.8465			21.500	MTS 2	248.00	150.00	9006540215000
0.8563			21.750	MTS 2	248.00	150.00	9006540217500
0.8594	55/64		21.830	MTS 2	248.00	150.00	9006540218300
0.8661			22.000	MTS 2	248.00	150.00	9006540220000
0.8748	7/8		22.220	MTS 2	248.00	150.00	9006540222200
0.8858			22.500	MTS 2	253.00	155.00	9006540225000
0.9055			23.000	MTS 2	253.00	155.00	9006540230000
0.9252			23.500	MTS 3	276.00	155.00	9006540235000
0.9350			23.750	MTS 3	281.00	160.00	9006540237500
0.9374	15/16		23.810	MTS 3	281.00	160.00	9006540238100
0.9449			24.000	MTS 3	281.00	160.00	9006540240000
0.9646			24.500	MTS 3	281.00	160.00	9006540245000
0.9744			24.750	MTS 3	281.00	160.00	9006540247500
0.9843	63/64		25.000	MTS 3	281.00	160.00	9006540250000

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

# Series 654

## Speeds & Feeds information pg 448

Dec. inch	Diameter (d1)		Shank size	l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter				
1.0000	1		MTS 3	286.00	165.00	9006540254000
1.0039			MTS 3	286.00	165.00	9006540255000
1.0236			MTS 3	286.00	165.00	9006540260000
1.0433			MTS 3	286.00	165.00	9006540265000
1.0626	1 1/16		MTS 3	291.00	170.00	9006540269900
1.0630			MTS 3	291.00	170.00	9006540270000
1.1024			MTS 3	291.00	170.00	9006540280000
1.1220			MTS 3	296.00	175.00	9006540285000
1.1248	1 1/8		MTS 3	296.00	175.00	9006540285700

Dec. inch	Diameter (d1)		Shank size	l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter				
1.1417			MTS 3	296.00	175.00	9006540290000
1.1614			MTS 3	296.00	175.00	9006540295000
1.1713			MTS 3	296.00	175.00	9006540297500
1.2008			MTS 3	301.00	180.00	9006540305000

Alternative Drill Series:						
#345 Cobalt, GP, 5xD, 118 pt, Oxide						
#661 Cobalt, GP, 5xD, 118 pt, TiN						