

5xD

S

TiN coated



External Coolant



Straight Shank

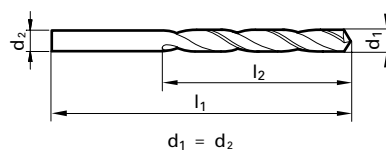
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## Series 664

## General Purpose, LH helix

HSS, general purpose (Type N), jobber length, 118° point, Form A  
web thinned >2.36mm dia., standard straight shank, LH cut

Cut / Shank Dia. = h8 tolerance range



## Application Materials:



General Steels/Brass



Universal Steels



Cast Iron

| Diameter (d1) |                | Wire /<br>letter | mm    | l1<br>mm | l2<br>mm | EDP #         |
|---------------|----------------|------------------|-------|----------|----------|---------------|
| Dec.<br>inch  | Fract.<br>inch |                  |       |          |          |               |
| 0.0157        | 1/64           |                  | 0.400 | 20.00    | 5.00     | 9006640004000 |
| 0.0165        |                |                  | 0.420 | 20.00    | 5.00     | 9006640004200 |
| 0.0169        |                |                  | 0.430 | 20.00    | 5.00     | 9006640004300 |
| 0.0177        |                |                  | 0.450 | 20.00    | 5.00     | 9006640004500 |
| 0.0236        |                |                  | 0.600 | 24.00    | 7.00     | 9006640006000 |
| 0.0264        |                |                  | 0.670 | 26.00    | 8.00     | 9006640006700 |
| 0.0295        |                |                  | 0.750 | 28.00    | 9.00     | 9006640007500 |
| 0.0303        |                |                  | 0.770 | 30.00    | 10.00    | 9006640007700 |
| 0.0315        |                |                  | 0.800 | 30.00    | 10.00    | 9006640008000 |
| 0.0354        |                |                  | 0.900 | 32.00    | 11.00    | 9006640009000 |
| 0.0366        |                |                  | 0.930 | 32.00    | 11.00    | 9006640009300 |
| 0.0374        |                |                  | 0.950 | 32.00    | 11.00    | 9006640009500 |
| 0.0382        | 62             |                  | 0.970 | 34.00    | 12.00    | 9006640009700 |
| 0.0394        |                |                  | 1.000 | 34.00    | 12.00    | 9006640010000 |
| 0.0413        |                |                  | 1.050 | 34.00    | 12.00    | 9006640010500 |
| 0.0421        | 58             |                  | 1.070 | 36.00    | 14.00    | 9006640010700 |
| 0.0429        | 57             |                  | 1.090 | 36.00    | 14.00    | 9006640010900 |
| 0.0433        |                |                  | 1.100 | 36.00    | 14.00    | 9006640011000 |
| 0.0453        |                |                  | 1.150 | 36.00    | 14.00    | 9006640011500 |
| 0.0465        |                | 56               | 1.180 | 36.00    | 14.00    | 9006640011800 |
| 0.0469        | 3/64           |                  | 1.190 | 38.00    | 16.00    | 9006640011900 |
| 0.0472        |                |                  | 1.200 | 38.00    | 16.00    | 9006640012000 |
| 0.0492        |                |                  | 1.250 | 38.00    | 16.00    | 9006640012500 |
| 0.0512        |                |                  | 1.300 | 38.00    | 16.00    | 9006640013000 |
| 0.0520        | 55             |                  | 1.320 | 38.00    | 16.00    | 9006640013200 |
| 0.0531        |                |                  | 1.350 | 40.00    | 18.00    | 9006640013500 |
| 0.0551        |                | 54               | 1.400 | 40.00    | 18.00    | 9006640014000 |
| 0.0559        |                |                  | 1.420 | 40.00    | 18.00    | 9006640014200 |
| 0.0571        |                |                  | 1.450 | 40.00    | 18.00    | 9006640014500 |
| 0.0591        |                |                  | 1.500 | 40.00    | 18.00    | 9006640015000 |
| 0.0610        |                |                  | 1.550 | 43.00    | 20.00    | 9006640015500 |
| 0.0626        | 1/16           |                  | 1.590 | 43.00    | 20.00    | 9006640015900 |
| 0.0630        |                |                  | 1.600 | 43.00    | 20.00    | 9006640016000 |
| 0.0650        |                |                  | 1.650 | 43.00    | 20.00    | 9006640016500 |
| 0.0669        |                | 51               | 1.700 | 43.00    | 20.00    | 9006640017000 |
| 0.0689        |                |                  | 1.750 | 46.00    | 22.00    | 9006640017500 |
| 0.0709        |                |                  | 1.800 | 46.00    | 22.00    | 9006640018000 |
| 0.0717        |                |                  | 1.820 | 46.00    | 22.00    | 9006640018200 |
| 0.0728        |                | 49               | 1.850 | 46.00    | 22.00    | 9006640018500 |
| 0.0748        |                |                  | 1.900 | 46.00    | 22.00    | 9006640019000 |
| 0.0787        |                |                  | 2.000 | 49.00    | 24.00    | 9006640020000 |
| 0.0807        |                |                  | 2.050 | 49.00    | 24.00    | 9006640020500 |
| 0.0827        |                |                  | 2.100 | 49.00    | 24.00    | 9006640021000 |
| 0.0846        |                |                  | 2.150 | 53.00    | 27.00    | 9006640021500 |
| 0.0866        |                |                  | 2.200 | 53.00    | 27.00    | 9006640022000 |
| 0.0906        |                |                  | 2.300 | 53.00    | 27.00    | 9006640023000 |
| 0.0937        | 3/32           |                  | 2.380 | 57.00    | 30.00    | 9006640023800 |
| 0.0945        |                |                  | 2.400 | 57.00    | 30.00    | 9006640024000 |
| 0.0965        |                |                  | 2.450 | 57.00    | 30.00    | 9006640024500 |
| 0.0984        |                |                  | 2.500 | 57.00    | 30.00    | 9006640025000 |
| 0.0996        |                | 39               | 2.530 | 57.00    | 30.00    | 9006640025300 |
| 0.1016        |                | 38               | 2.580 | 57.00    | 30.00    | 9006640025800 |
| 0.1024        |                |                  | 2.600 | 57.00    | 30.00    | 9006640026000 |
| 0.1063        |                |                  | 2.700 | 61.00    | 33.00    | 9006640027000 |
| 0.1067        |                | 36               | 2.710 | 61.00    | 33.00    | 9006640027100 |
| 0.1083        |                |                  | 2.750 | 61.00    | 33.00    | 9006640027500 |

| Diameter (d1) |                | Wire /<br>letter | mm     | l1<br>mm | l2<br>mm | EDP #         |
|---------------|----------------|------------------|--------|----------|----------|---------------|
| Dec.<br>inch  | Fract.<br>inch |                  |        |          |          |               |
| 0.1094        | 7/64           |                  | 2.780  | 61.00    | 33.00    | 9006640027800 |
| 0.1102        |                |                  | 2.800  | 61.00    | 33.00    | 9006640028000 |
| 0.1142        |                |                  | 2.900  | 61.00    | 33.00    | 9006640029000 |
| 0.1161        |                | 32               | 2.950  | 61.00    | 33.00    | 9006640029500 |
| 0.1181        |                |                  | 3.000  | 61.00    | 33.00    | 9006640030000 |
| 0.1201        |                | 31               | 3.050  | 65.00    | 36.00    | 9006640030500 |
| 0.1220        |                |                  | 3.100  | 65.00    | 36.00    | 9006640031000 |
| 0.1248        | 1/8            |                  | 3.170  | 65.00    | 36.00    | 9006640031700 |
| 0.1260        |                |                  | 3.200  | 65.00    | 36.00    | 9006640032000 |
| 0.1299        |                |                  | 3.300  | 65.00    | 36.00    | 9006640033000 |
| 0.1339        |                |                  | 3.400  | 70.00    | 39.00    | 9006640034000 |
| 0.1358        |                | 29               | 3.450  | 70.00    | 39.00    | 9006640034500 |
| 0.1378        |                |                  | 3.500  | 70.00    | 39.00    | 9006640035000 |
| 0.1406        | 9/64           | 28               | 3.570  | 70.00    | 39.00    | 9006640035700 |
| 0.1417        |                |                  | 3.600  | 70.00    | 39.00    | 9006640036000 |
| 0.1457        |                |                  | 3.700  | 70.00    | 39.00    | 9006640037000 |
| 0.1496        |                | 25               | 3.800  | 75.00    | 43.00    | 9006640038000 |
| 0.1535        |                |                  | 3.900  | 75.00    | 43.00    | 9006640039000 |
| 0.1563        | 5/32           |                  | 3.970  | 75.00    | 43.00    | 9006640039700 |
| 0.1575        |                |                  | 4.000  | 75.00    | 43.00    | 9006640040000 |
| 0.1614        |                |                  | 4.100  | 75.00    | 43.00    | 9006640041000 |
| 0.1654        |                |                  | 4.200  | 75.00    | 43.00    | 9006640042000 |
| 0.1693        |                | 18               | 4.300  | 80.00    | 47.00    | 9006640043000 |
| 0.1720        | 11/64          |                  | 4.370  | 80.00    | 47.00    | 9006640043700 |
| 0.1732        |                |                  | 4.400  | 80.00    | 47.00    | 9006640044000 |
| 0.1772        |                | 16               | 4.500  | 80.00    | 47.00    | 9006640045000 |
| 0.1811        |                |                  | 4.600  | 80.00    | 47.00    | 9006640046000 |
| 0.1850        |                | 13               | 4.700  | 80.00    | 47.00    | 9006640047000 |
| 0.1874        | 3/16           |                  | 4.760  | 86.00    | 52.00    | 9006640047600 |
| 0.1890        |                | 12               | 4.800  | 86.00    | 52.00    | 9006640048000 |
| 0.1929        |                |                  | 4.900  | 86.00    | 52.00    | 9006640049000 |
| 0.1969        |                |                  | 5.000  | 86.00    | 52.00    | 9006640050000 |
| 0.1992        |                | 8                | 5.060  | 86.00    | 52.00    | 9006640050600 |
| 0.2008        |                |                  | 5.100  | 86.00    | 52.00    | 9006640051000 |
| 0.2031        | 13/64          |                  | 5.160  | 86.00    | 52.00    | 9006640051600 |
| 0.2047        |                |                  | 5.200  | 86.00    | 52.00    | 9006640052000 |
| 0.2087        |                |                  | 5.300  | 86.00    | 52.00    | 9006640053000 |
| 0.2126        |                |                  | 5.400  | 93.00    | 57.00    | 9006640054000 |
| 0.2165        |                |                  | 5.500  | 93.00    | 57.00    | 9006640055000 |
| 0.2189        | 7/32           |                  | 5.560  | 93.00    | 57.00    | 9006640055600 |
| 0.2205        |                |                  | 5.600  | 93.00    | 57.00    | 9006640056000 |
| 0.2244        |                |                  | 5.700  | 93.00    | 57.00    | 9006640057000 |
| 0.2283        |                |                  | 5.800  | 93.00    | 57.00    | 9006640058000 |
| 0.2323        |                |                  | 5.900  | 93.00    | 57.00    | 9006640059000 |
| 0.2362        |                |                  | 6.000  | 93.00    | 57.00    | 9006640060000 |
| 0.2402        |                |                  | 6.100  | 101.00   | 63.00    | 9006640061000 |
| 0.2441        |                |                  | 6.200  | 101.00   | 63.00    | 9006640062000 |
| 0.2480        |                |                  | 6.300  | 101.00   | 63.00    | 9006640063000 |
| 0.2500        | 1/4            | E                | 6.350  | 101.00   | 63.00    | 9006640063500 |
| 0.2559        |                |                  | 6.500  | 101.00   | 63.00    | 9006640065000 |
| 0.2969        | 19/64          |                  | 7.540  | 117.00   | 75.00    | 9006640075400 |
| 0.3071        |                |                  | 7.800  | 117.00   | 75.00    | 9006640078000 |
| 0.3437        | 11/32          |                  | 8.730  | 125.00   | 81.00    | 9006640087300 |
| 0.3594        | 23/64          |                  | 9.130  | 125.00   | 81.00    | 9006640091300 |
| 0.4016        |                |                  | 10.200 | 133.00   | 87.00    | 9006640102000 |