

5xD

S

TiN coated



External Coolant



Straight Shank

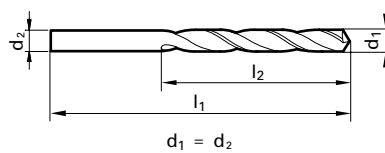
Speeds & Feeds  
information pg 450

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 / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. 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 / letter	mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. 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