

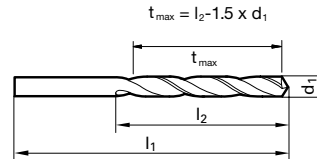


Tool material **HSS**

Surface **(S)**



- P** Steel ● web thinning  $\geq \varnothing 1.000$  • relieved cone • wide flutes • in case of unsatisfactory chip evacuation
  - M** Stainless steel ○
  - K** Cast iron ● cast iron and steels up to 1000 N/mm<sup>2</sup> • Not recommended for: CrNi steels, stainless steels
  - N** Aluminum ●
  - S** Titanium alloys ○
  - H** Hardened steel ○
- =Optimal  
○=Limited



Speeds and feeds information on pg. 540

Shank diameter = cut diameter

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.0394		1.00	56.00	31.50	33.00	9006680010000
0.0429	#57	1.09	60.00	35.37	37.00	9006680010900
0.0433		1.10	60.00	35.35	37.00	9006680011000
0.0465	#56	1.18	60.00	35.23	37.00	9006680011800
0.0469	3/64	1.19	65.00	39.22	41.00	9006680011900
0.0472		1.20	65.00	39.20	41.00	9006680012000
0.0512		1.30	65.00	39.05	41.00	9006680013000
0.0520	#55	1.32	65.00	39.02	41.00	9006680013200
0.0551	#54	1.40	70.00	42.90	45.00	9006680014000
0.0591		1.50	70.00	42.75	45.00	9006680015000
0.0594	#53	1.51	76.00	47.74	50.00	9006680015100
0.0626	1/16	1.59	76.00	47.62	50.00	9006680015900
0.0630		1.60	76.00	47.60	50.00	9006680016000
0.0650		1.65	76.00	47.53	50.00	9006680016500
0.0669	#51	1.70	76.00	47.45	50.00	9006680017000
0.0709		1.80	80.00	50.30	53.00	9006680018000
0.0728	#49	1.85	80.00	50.23	53.00	9006680018500
0.0748		1.90	80.00	50.15	53.00	9006680019000
0.0760	#48	1.93	85.00	53.11	56.00	9006680019300
0.0768		1.95	85.00	53.08	56.00	9006680019500
0.0780	5/64	1.98	85.00	53.03	56.00	9006680019800
0.0783	#47	1.99	85.00	53.02	56.00	9006680019900
0.0787		2.00	85.00	53.00	56.00	9006680020000
0.0811	#46	2.06	85.00	52.91	56.00	9006680020600
0.0819	#45	2.08	85.00	52.88	56.00	9006680020800
0.0827		2.10	85.00	52.85	56.00	9006680021000
0.0858	#44	2.18	90.00	55.73	59.00	9006680021800
0.0866		2.20	90.00	55.70	59.00	9006680022000
0.0886		2.25	90.00	55.63	59.00	9006680022500
0.0890	#43	2.26	90.00	55.61	59.00	9006680022600
0.0906		2.30	90.00	55.55	59.00	9006680023000
0.0937	3/32	2.38	95.00	58.43	62.00	9006680023800
0.0945		2.40	95.00	58.40	62.00	9006680024000
0.0980	#40	2.49	95.00	58.27	62.00	9006680024900
0.0984		2.50	95.00	58.25	62.00	9006680025000
0.0996	#39	2.53	95.00	58.21	62.00	9006680025300
0.1016	#38	2.58	95.00	58.13	62.00	9006680025800
0.1024		2.60	95.00	58.10	62.00	9006680026000
0.1039	#37	2.64	95.00	58.04	62.00	9006680026400
0.1063		2.70	100.00	61.95	66.00	9006680027000
0.1067	#36	2.71	100.00	61.94	66.00	9006680027100

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.1094	7/64	2.78	100.00	61.83	66.00	9006680027800
0.1102		2.80	100.00	61.80	66.00	9006680028000
0.1110	#34	2.82	100.00	61.77	66.00	9006680028200
0.1130	#33	2.87	100.00	61.70	66.00	9006680028700
0.1142		2.90	100.00	61.65	66.00	9006680029000
0.1161	#32	2.95	100.00	61.58	66.00	9006680029500
0.1181		3.00	100.00	61.50	66.00	9006680030000
0.1201	#31	3.05	106.00	64.43	69.00	9006680030500
0.1220		3.10	106.00	64.35	69.00	9006680031000
0.1248	1/8	3.17	106.00	64.25	69.00	9006680031700
0.1260		3.20	106.00	64.20	69.00	9006680032000
0.1299		3.30	106.00	64.05	69.00	9006680033000
0.1339		3.40	112.00	67.90	73.00	9006680034000
0.1358	#29	3.45	112.00	67.83	73.00	9006680034500
0.1378		3.50	112.00	67.75	73.00	9006680035000
0.1406	9/64	#28	112.00	67.65	73.00	9006680035700
0.1417		3.60	112.00	67.60	73.00	9006680036000
0.1457		3.70	112.00	67.45	73.00	9006680037000
0.1469	#26	3.73	112.00	67.41	73.00	9006680037300
0.1496	#25	3.80	119.00	72.30	78.00	9006680038000
0.1520	#24	3.86	119.00	72.21	78.00	9006680038600
0.1524		3.87	119.00	72.20	78.00	9006680038700
0.1535		3.90	119.00	72.15	78.00	9006680039000
0.1563	5/32	3.97	119.00	72.05	78.00	9006680039700
0.1575		4.00	119.00	72.00	78.00	9006680040000
0.1591	#21	4.04	119.00	71.94	78.00	9006680040400
0.1610	#20	4.09	119.00	71.87	78.00	9006680040900
0.1614		4.10	119.00	71.85	78.00	9006680041000
0.1654		4.20	119.00	71.70	78.00	9006680042000
0.1661	#19	4.22	119.00	71.67	78.00	9006680042200
0.1693	#18	4.30	126.00	75.55	82.00	9006680043000
0.1720	11/64	4.37	126.00	75.45	82.00	9006680043700
0.1732		4.40	126.00	75.40	82.00	9006680044000
0.1772	#16	4.50	126.00	75.25	82.00	9006680045000
0.1811		4.60	126.00	75.10	82.00	9006680046000
0.1850	#13	4.70	126.00	74.95	82.00	9006680047000
0.1874	3/16	4.76	132.00	79.86	87.00	9006680047600
0.1890	#12	4.80	132.00	79.80	87.00	9006680048000
0.1909	#11	4.85	132.00	79.73	87.00	9006680048500
0.1929		4.90	132.00	79.65	87.00	9006680049000
0.1933		4.91	132.00	79.64	87.00	9006680049100

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.1937	#10	4.92	132.00	79.62	87.00	9006680049200
0.1969		5.00	132.00	79.50	87.00	9006680050000
0.1992	#8	5.06	132.00	79.41	87.00	9006680050600
0.2008		5.10	132.00	79.35	87.00	9006680051000
0.2031	13/64	5.16	132.00	79.26	87.00	9006680051600
0.2047		5.20	132.00	79.20	87.00	9006680052000
0.2087		5.30	132.00	79.05	87.00	9006680053000
0.2091	#4	5.31	139.00	83.04	91.00	9006680053100
0.2126		5.40	139.00	82.90	91.00	9006680054000
0.2165		5.50	139.00	82.75	91.00	9006680055000
0.2189	7/32	5.56	139.00	82.66	91.00	9006680055600
0.2205		5.60	139.00	82.60	91.00	9006680056000
0.2244		5.70	139.00	82.45	91.00	9006680057000
0.2283		5.80	139.00	82.30	91.00	9006680058000
0.2323		5.90	139.00	82.15	91.00	9006680059000
0.2343	15/64	5.95	139.00	82.08	91.00	9006680059500
0.2362		6.00	139.00	82.00	91.00	9006680060000
0.2378	B	6.04	148.00	87.94	97.00	9006680060400
0.2402		6.10	148.00	87.85	97.00	9006680061000
0.2421	C	6.15	148.00	87.78	97.00	9006680061500
0.2441		6.20	148.00	87.70	97.00	9006680062000
0.2461	D	6.25	148.00	87.63	97.00	9006680062500
0.2480		6.30	148.00	87.55	97.00	9006680063000
0.2500	1/4	6.35	148.00	87.48	97.00	9006680063500
0.2520		6.40	148.00	87.40	97.00	9006680064000
0.2559		6.50	148.00	87.25	97.00	9006680065000
0.2571	F	6.53	148.00	87.21	97.00	9006680065300
0.2598		6.60	148.00	87.10	97.00	9006680066000
0.2638		6.70	148.00	86.95	97.00	9006680067000
0.2657	17/64	6.75	156.00	91.88	102.00	9006680067500
0.2677		6.80	156.00	91.80	102.00	9006680068000
0.2717	I	6.90	156.00	91.65	102.00	9006680069000
0.2756		7.00	156.00	91.50	102.00	9006680070000
0.2795		7.10	156.00	91.35	102.00	9006680071000
0.2811	9/32	7.14	156.00	91.29	102.00	9006680071400
0.2835		7.20	156.00	91.20	102.00	9006680072000
0.2854		7.25	156.00	91.13	102.00	9006680072500
0.2874		7.30	156.00	91.05	102.00	9006680073000
0.2913		7.40	156.00	90.90	102.00	9006680074000
0.2953		7.50	156.00	90.75	102.00	9006680075000
0.2992		7.60	165.00	97.60	109.00	9006680076000
0.3031		7.70	165.00	97.45	109.00	9006680077000
0.3071		7.80	165.00	97.30	109.00	9006680078000
0.3110		7.90	165.00	97.15	109.00	9006680079000

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.3126	5/16	7.94	165.00	97.09	109.00	9006680079400
0.3150		8.00	165.00	97.00	109.00	9006680080000
0.3189		8.10	165.00	96.85	109.00	9006680081000
0.3228	P	8.20	165.00	96.70	109.00	9006680082000
0.3268		8.30	165.00	96.55	109.00	9006680083000
0.3307		8.40	165.00	96.40	109.00	9006680084000
0.3319	Q	8.43	165.00	96.36	109.00	9006680084300
0.3346		8.50	165.00	96.25	109.00	9006680085000
0.3386		8.60	175.00	102.10	115.00	9006680086000
0.3390	R	8.61	175.00	102.09	115.00	9006680086100
0.3425		8.70	175.00	101.95	115.00	9006680087000
0.3437	11/32	8.73	175.00	101.91	115.00	9006680087300
0.3465		8.80	175.00	101.80	115.00	9006680088000
0.3504		8.90	175.00	101.65	115.00	9006680089000
0.3543		9.00	175.00	101.50	115.00	9006680090000
0.3583		9.10	175.00	101.35	115.00	9006680091000
0.3594	23/64	9.13	175.00	101.31	115.00	9006680091300
0.3661		9.30	175.00	101.05	115.00	9006680093000
0.3677	U	9.34	175.00	100.99	115.00	9006680093400
0.3701		9.40	175.00	100.90	115.00	9006680094000
0.3740		9.50	175.00	100.75	115.00	9006680095000
0.3748	3/8	9.52	184.00	106.72	121.00	9006680095200
0.3780		9.60	184.00	106.60	121.00	9006680096000
0.3819		9.70	184.00	106.45	121.00	9006680097000
0.3858	W	9.80	184.00	106.30	121.00	9006680098000
0.3898		9.90	184.00	106.15	121.00	9006680099000
0.3906	25/64	9.92	184.00	106.12	121.00	9006680099200
0.3937		10.00	184.00	106.00	121.00	9006680100000
0.4016		10.20	184.00	105.70	121.00	9006680102000
0.4063	13/32	10.32	184.00	105.52	121.00	9006680103200
0.4134		10.50	184.00	105.25	121.00	9006680105000
0.4220	27/64	10.72	195.00	111.92	128.00	9006680107200
0.4331		11.00	195.00	111.50	128.00	9006680110000
0.4374	7/16	11.11	195.00	111.34	128.00	9006680111100
0.4528		11.50	195.00	110.75	128.00	9006680115000
0.4531	29/64	11.51	195.00	110.74	128.00	9006680115100
0.4689	15/32	11.91	205.00	116.14	134.00	9006680119100
0.4724		12.00	205.00	116.00	134.00	9006680120000
0.4843	31/64	12.30	205.00	115.55	134.00	9006680123000
0.4921		12.50	205.00	115.25	134.00	9006680125000
0.5000	1/2	12.70	205.00	114.95	134.00	9006680127000
0.5118		13.00	205.00	114.50	134.00	9006680130000
0.5157	33/64	13.10	205.00	114.35	134.00	9006680131000
0.5512		14.00	214.00	119.00	140.00	9006680140000

Taper Length