

10xD

S

TiN coated



External Coolant



Straight Shank

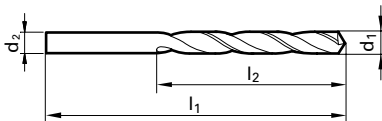
Speeds & Feeds  
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## Series 668

## GT 100 Parabolic

HSS, GT 100 deep hole, taper length, 130° point, Form A  
web thinned all dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range

 $d_1 = d_2$ 

## Application Materials:



General Steels/Brass



Aluminum &amp; Alloys



Universal Steels

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter			
0.0394			56.00	33.00	9006680010000
0.0429		57	60.00	37.00	9006680010900
0.0433			60.00	37.00	9006680011000
0.0465		56	60.00	37.00	9006680011800
0.0469	3/64		65.00	41.00	9006680011900
0.0472			65.00	41.00	9006680012000
0.0512			65.00	41.00	9006680013000
0.0520		55	65.00	41.00	9006680013200
0.0551		54	70.00	45.00	9006680014000
0.0591			70.00	45.00	9006680015000
0.0594		53	76.00	50.00	9006680015100
0.0626	1/16		76.00	50.00	9006680015900
0.0630			76.00	50.00	9006680016000
0.0650			76.00	50.00	9006680016500
0.0669		51	76.00	50.00	9006680017000
0.0709			80.00	53.00	9006680018000
0.0728		49	80.00	53.00	9006680018500
0.0748			80.00	53.00	9006680019000
0.0760		48	85.00	56.00	9006680019300
0.0768			85.00	56.00	9006680019500
0.0780	5/64		85.00	56.00	9006680019800
0.0783		47	85.00	56.00	9006680019900
0.0787			85.00	56.00	9006680020000
0.0811		46	85.00	56.00	9006680020600
0.0819		45	85.00	56.00	9006680020800
0.0827			85.00	56.00	9006680021000
0.0858		44	90.00	59.00	9006680021800
0.0866			90.00	59.00	9006680022000
0.0886			90.00	59.00	9006680022500
0.0890		43	90.00	59.00	9006680022600
0.0906			90.00	59.00	9006680023000
0.0937	3/32		95.00	62.00	9006680023800
0.0945			95.00	62.00	9006680024000
0.0980		40	95.00	62.00	9006680024900
0.0984			95.00	62.00	9006680025000
0.0996		39	95.00	62.00	9006680025300
0.1016		38	95.00	62.00	9006680025800
0.1024			95.00	62.00	9006680026000
0.1039		37	95.00	62.00	9006680026400
0.1063			100.00	66.00	9006680027000
0.1067		36	100.00	66.00	9006680027100
0.1094	7/64		100.00	66.00	9006680027800
0.1102			100.00	66.00	9006680028000
0.1110		34	100.00	66.00	9006680028200
0.1130		33	100.00	66.00	9006680028700
0.1142			100.00	66.00	9006680029000
0.1161		32	100.00	66.00	9006680029500
0.1181			100.00	66.00	9006680030000
0.1201		31	106.00	69.00	9006680030500
0.1220			106.00	69.00	9006680031000
0.1248	1/8		106.00	69.00	9006680031700
0.1260			106.00	69.00	9006680032000
0.1299			106.00	69.00	9006680033000
0.1339			112.00	73.00	9006680034000

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter			
0.1358		29	112.00	73.00	9006680034500
0.1378			112.00	73.00	9006680035000
0.1406	9/64	28	112.00	73.00	9006680035700
0.1417			112.00	73.00	9006680036000
0.1457			112.00	73.00	9006680037000
0.1469		26	112.00	73.00	9006680037300
0.1496		25	119.00	78.00	9006680038000
0.1520		24	119.00	78.00	9006680038600
0.1524			119.00	78.00	9006680038700
0.1535			119.00	78.00	9006680039000
0.1563	5/32		119.00	78.00	9006680039700
0.1575			119.00	78.00	9006680040000
0.1591		21	119.00	78.00	9006680040400
0.1610		20	119.00	78.00	9006680040900
0.1614			119.00	78.00	9006680041000
0.1654			119.00	78.00	9006680042000
0.1661		19	119.00	78.00	9006680042200
0.1693		18	126.00	82.00	9006680043000
0.1720	11/64		126.00	82.00	9006680043700
0.1732			126.00	82.00	9006680044000
0.1772		16	126.00	82.00	9006680045000
0.1811			126.00	82.00	9006680046000
0.1850		13	126.00	82.00	9006680047000
0.1874	3/16		132.00	87.00	9006680047600
0.1890		12	132.00	87.00	9006680048000
0.1909		11	132.00	87.00	9006680048500
0.1929			132.00	87.00	9006680049000
0.1933			132.00	87.00	9006680049100
0.1937		10	132.00	87.00	9006680049200
0.1969			132.00	87.00	9006680050000
0.1992		8	132.00	87.00	9006680050600
0.2008			132.00	87.00	9006680051000
0.2031	13/64		132.00	87.00	9006680051600
0.2047			132.00	87.00	9006680052000
0.2087			132.00	87.00	9006680053000
0.2091		4	139.00	91.00	9006680053100
0.2126			139.00	91.00	9006680054000
0.2165			139.00	91.00	9006680055000
0.2189	7/32		139.00	91.00	9006680055600
0.2205			139.00	91.00	9006680056000
0.2244			139.00	91.00	9006680057000
0.2283			139.00	91.00	9006680058000
0.2323			139.00	91.00	9006680059000
0.2343	15/64		139.00	91.00	9006680059500
0.2362			139.00	91.00	9006680060000
0.2378		B	148.00	97.00	9006680060400
0.2402			148.00	97.00	9006680061000
0.2421		C	148.00	97.00	9006680061500
0.2441			148.00	97.00	9006680062000
0.2461		D	148.00	97.00	9006680062500
0.2480			148.00	97.00	9006680063000
0.2500	1/4	E	148.00	97.00	9006680063500
0.2520			148.00	97.00	9006680064000
0.2559			148.00	97.00	9006680065000

# Series 668

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Dec. inch	Diameter (d1)		mm	l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter				
0.2571		F	6.530	148.00	97.00	9006680065300
0.2598			6.600	148.00	97.00	9006680066000
0.2638			6.700	148.00	97.00	9006680067000
0.2657	17/64	H	6.750	156.00	102.00	9006680067500
0.2677			6.800	156.00	102.00	9006680068000
0.2717		I	6.900	156.00	102.00	9006680069000
0.2756			7.000	156.00	102.00	9006680070000
0.2795			7.100	156.00	102.00	9006680071000
0.2811	9/32	K	7.140	156.00	102.00	9006680071400
0.2835			7.200	156.00	102.00	9006680072000
0.2854			7.250	156.00	102.00	9006680072500
0.2874			7.300	156.00	102.00	9006680073000
0.2913			7.400	156.00	102.00	9006680074000
0.2953			7.500	156.00	102.00	9006680075000
0.2992			7.600	165.00	109.00	9006680076000
0.3031			7.700	165.00	109.00	9006680077000
0.3071			7.800	165.00	109.00	9006680078000
0.3110			7.900	165.00	109.00	9006680079000
0.3126	5/16		7.940	165.00	109.00	9006680079400
0.3150			8.000	165.00	109.00	9006680080000
0.3189			8.100	165.00	109.00	9006680081000
0.3228		P	8.200	165.00	109.00	9006680082000
0.3268			8.300	165.00	109.00	9006680083000
0.3307			8.400	165.00	109.00	9006680084000
0.3319		Q	8.430	165.00	109.00	9006680084300
0.3346			8.500	165.00	109.00	9006680085000
0.3386			8.600	175.00	115.00	9006680086000
0.3390		R	8.610	175.00	115.00	9006680086100
0.3425			8.700	175.00	115.00	9006680087000
0.3437	11/32		8.730	175.00	115.00	9006680087300
0.3465			8.800	175.00	115.00	9006680088000
0.3504			8.900	175.00	115.00	9006680089000
0.3543			9.000	175.00	115.00	9006680090000
0.3583			9.100	175.00	115.00	9006680091000
0.3594	23/64		9.130	175.00	115.00	9006680091300

Dec. inch	Diameter (d1)		mm	l1 mm	l2 mm	EDP #
	Fract. inch	Wire / letter				
0.3661			9.300	175.00	115.00	9006680093000
0.3677		U	9.340	175.00	115.00	9006680093400
0.3701			9.400	175.00	115.00	9006680094000
0.3740			9.500	175.00	115.00	9006680095000
0.3748	3/8		9.520	184.00	121.00	9006680095200
0.3780			9.600	184.00	121.00	9006680096000
0.3819			9.700	184.00	121.00	9006680097000
0.3858		W	9.800	184.00	121.00	9006680098000
0.3898			9.900	184.00	121.00	9006680099000
0.3906	25/64		9.920	184.00	121.00	9006680099200
0.3937			10.000	184.00	121.00	9006680100000
0.4016			10.200	184.00	121.00	9006680102000
0.4063	13/32		10.320	184.00	121.00	9006680103200
0.4134			10.500	184.00	121.00	9006680105000
0.4220	27/64		10.720	195.00	128.00	9006680107200
0.4331			11.000	195.00	128.00	9006680110000
0.4374	7/16		11.110	195.00	128.00	9006680111100
0.4528			11.500	195.00	128.00	9006680115000
0.4531	29/64		11.510	195.00	128.00	9006680115100
0.4689	15/32		11.910	205.00	134.00	9006680119100
0.4724			12.000	205.00	134.00	9006680120000
0.4843	31/64		12.300	205.00	134.00	9006680123000
0.4921			12.500	205.00	134.00	9006680125000
0.5000	1/2		12.700	205.00	134.00	9006680127000
0.5118			13.000	205.00	134.00	9006680130000
0.5157	33/64		13.100	205.00	134.00	9006680131000
0.5512			14.000	214.00	140.00	9006680140000

### Alternative Drill Series:

- #535 HSS, GT100, 10xD, 130 pt, Bright/Nitrided lands > 2.36
- #336 Cobalt, GT100, 10xD, 130 pt, Bright/Nitrided lands > 2.36

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