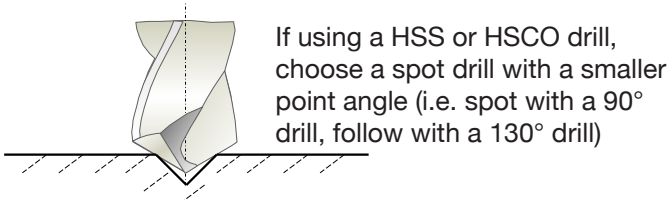


# NC Spot Drill - 90°

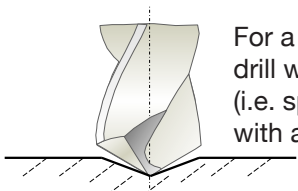
Right-hand helix, standard length  
Cut / Shank Dia. = h6 tolerance range; point angle tolerance +0°/-1°

Standard length 90° Point Angle							<b>NEW</b>	<b>NEW</b>	<b>GUHRING</b> ✓ Select
Series					<b>557</b>	<b>568</b>	<b>1136</b>	<b>1133</b>	<b>723</b>
Substrate					HSS	HSS	HSCO	HSCO	Carbide
Surface Finish					Bright	TiN	Bright	nano-FIREX®	Bright
Diameter d1					EDP #	EDP #	EDP #	EDP #	EDP #
dec.	fract.	mm	l1	l2					
0.1181		3.00	46.00	12.00	9005570030000	9005680030000	9011360030000	9011330030000	
0.1575		4.00	55.00	12.00	9005570040000	9005680040000	9011360040000	9011330040000	9007230040000
0.1969		5.00	62.00	14.00	9005570050000	9005680050000	9011360050000	9011330050000	9007230050000
0.2362		6.00	66.00	16.00	9005570060000	9005680060000	9011360060000	9011330060000	9007230060000
0.2500	1/4	6.35	70.00	17.00	9005570063500	9005680063500			9007230063500
0.3150		8.00	79.00	21.00	9005570080000	9005680080000	9011360080000	9011330080000	9007230080000
0.3748	3/8	9.52	89.00	25.00	9005570095200	9005680095200			9007230095200
0.3937		10.00	89.00	25.00	9005570100000	9005680100000	9011360100000	9011330100000	9007230100000
0.4724		12.00	102.00	30.00	9005570120000	9005680120000	9011360120000	9011330120000	9007230120000
0.5000	1/2	12.70	102.00	30.00	9005570127000	9005680127000			9007230127000
0.6248	5/8	15.87	115.00	37.50	9005570158700	9005680158700			9007230158700
0.6299		16.00	115.00	37.50	9005570160000	9005680160000	9011360160000	9011330160000	9007230160000
0.7500	3/4	19.05	131.00	45.00	9005570190500	9005680190500			9007230190500
0.7874		20.00	131.00	45.00	9005570200000	9005680200000	9011360200000	9011330200000	9007230200000
0.9843		25.00	151.00	53.00	9005570250000	9005680250000			
1.0000	1	25.40	156.00	53.00	9005570254000	9005680254000			

\* Weldon flat on drills ≥ 6mm diameter



If using a HSS or HSCO drill, choose a spot drill with a smaller point angle (i.e. spot with a 90° drill, follow with a 130° drill)



For a carbide drill, choose a spot drill with a larger point angle (i.e. spot with a 142° drill, follow with a 140° carbide drill)

Long length - 90°					Series	<b>559</b>
					Substrate	HSS
					Surface Finish	Bright
Diameter d1					EDP #	
dec.	fract.	mm	l1	l2		
0.2500	1/4	6.35	105.0	17.0	9005590063500	
0.3150		8.00	118.0	21.0	9005590080000	
0.3748	3/8	9.52	132.0	25.0	9005590095200	
0.5000	1/2	12.70	159.0	30.0	9005590127000	
0.6248	5/8	15.87	186.0	37.5	9005590158700	
0.7500	3/4	19.05	213.0	45.0	9005590190500	
1.0000	1	25.40	216.0	53.0	9005590254000	