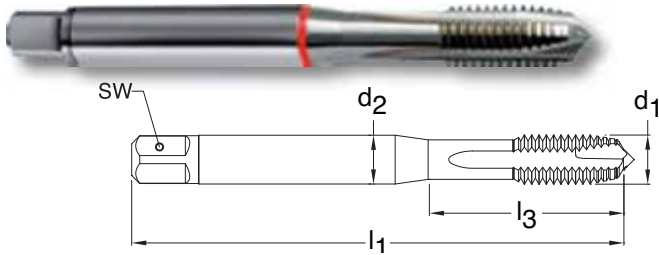


# METRIC



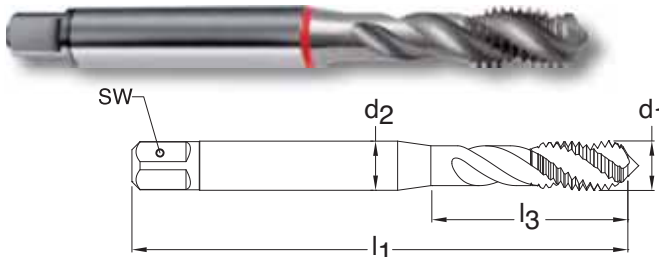
**Series 804**  
**Standard DIN 371**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Point Straight flute**  
**Chamfer Form B • 3.5 - 5**  
**Class of Fit 6H**



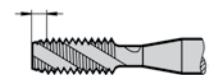
**Through holes**      **bright finish**      **External cooling**

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M2 X 0.40	D2/D3	1.567 - 1.679	3	2.80	2.10	45.00	13.50	2.000	9008040020000	●
M2.2 X 0.45	D2/D3	1.713 - 1.838	3	2.80	2.10	45.00	14.50	2.200	9008040022000	○
M2.3 X 0.40	D2/D3	1.870 - 1.980	3	2.80	2.10	45.00	14.50	2.300	9008040023000	○
M2.5 X 0.45	D2/D3	2.013 - 2.138	3	2.80	2.10	50.00	14.50	2.500	9008040025000	●
M2.6 X 0.45	D2/D3	2.110 - 2.240	3	2.80	2.10	50.00	14.50	2.600	9008040026000	○
M3 X 0.50	D2/D3	2.459 - 2.599	3	3.50	2.70	56.00	18.00	3.000	9008040030000	○
M3.5 X 0.60	D3/D4	2.850 - 3.010	3	4.00	3.00	56.00	20.00	3.500	9008040035000	●
M4 X 0.70	D3/D4	3.242 - 3.422	3	4.50	3.40	63.00	21.00	4.000	9008040040000	●
M5 X 0.80	D3/D4	4.134 - 4.334	3	6.00	4.90	70.00	25.00	5.000	9008040050000	●
M6 X 1.00	D4/D5	4.917 - 5.153	3	6.00	4.90	80.00	30.00	6.000	9008040060000	●
M8 X 1.25	D4/D5	6.647 - 6.912	3	8.00	6.20	90.00	35.00	8.000	9008040080000	●
M10 X 1.50	D4/D5	8.376 - 8.676	3	10.00	8.00	100.00	39.00	10.000	9008040100000	●

# METRIC



**Series 811**  
**Standard DIN 371**  
**Tool Material HSS-E (Cobalt)**  
**Spiral Flute 40° Helix**  
**Chamfer Form C • 2-3**  
**Class of Fit ISO 2(6H)**



**Blind holes**      **bright finish**      **External cooling**

d1 - P	D Limits	Tap Drill Range mm	Number of Flutes	d2 mm	SW mm	l1 mm	l3 mm	Order Code	EDP Number	Stock
M2 X 0.40	D2/D3	1.567 - 1.679	3	2.80	2.10	45.00	13.50	2.000	9008110020000	●
M2.5 X 0.45	D2/D3	2.013 - 2.138	3	2.80	2.10	50.00	14.50	2.500	9008110025000	●
M2.6 X 0.45	D2/D3	2.110 - 2.240	3	2.80	2.10	50.00	14.50	2.600	9008110026000	○
M3 X 0.50	D2/D3	2.459 - 2.599	3	3.50	2.70	56.00	18.00	3.000	9008110030000	○
M3.5 X 0.60	D3/D4	2.850 - 3.010	3	4.00	3.00	56.00	20.00	3.500	9008110035000	○
M4 X 0.70	D3/D4	3.242 - 3.422	3	4.50	3.40	63.00	21.00	4.000	9008110040000	○
M5 X 0.80	D3/D4	4.134 - 4.334	3	6.00	4.90	70.00	25.00	5.000	9008110050000	●
M6 X 1.00	D4/D5	4.917 - 5.153	3	6.00	4.90	80.00	30.00	6.000	9008110060000	○
M7 X 1.00	D4/D5	5.917 - 6.153	3	7.00	5.50	80.00	30.00	7.000	9008110070000	○
M8 X 1.25	D4/D5	6.647 - 6.912	3	8.00	6.20	90.00	35.00	8.000	9008110080000	●
M10 X 1.50	D4/D5	8.376 - 8.676	3	10.00	8.00	100.00	39.00	10.000	9008110100000	●

"Tap drill Range" given is per the Class of Fit shown per Series #  
 Additional Tap Drill sizes & percent of thread engagement can be found on pages 199 - 206.

High-Tensile, Heat-Treatable Hardened and Tool Steels