

5xD



TiCN coated



External Coolant



Straight Shank

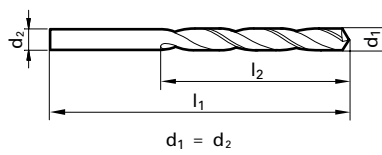
Speeds & Feeds  
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Series 1221

GT 100 Parabolic

Cobalt, GT 100, jobber length, 130° point, Form A web thinned all dia.,  
standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



Application Materials:



Universal Steels



Stainless Steels



Cast Iron

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.1181			3.00	61.00	33.00	9012210030000
0.1201		31	3.050	65.00	36.00	9012210030500
0.1220			3.100	65.00	36.00	9012210031000
0.1248	1/8		3.170	65.00	36.00	9012210031700
0.1260			3.200	65.00	36.00	9012210032000
0.1299			3.300	65.00	36.00	9012210033000
0.1339			3.400	70.00	39.00	9012210034000
0.1358		29	3.450	70.00	39.00	9012210034500
0.1378			3.500	70.00	39.00	9012210035000
0.1406	9/64	28	3.570	70.00	39.00	9012210035700
0.1417			3.600	70.00	39.00	9012210036000
0.1441		27	3.660	70.00	39.00	9012210036600
0.1457			3.700	70.00	39.00	9012210037000
0.1476			3.750	70.00	39.00	9012210037500
0.1496		25	3.800	75.00	43.00	9012210038000
0.1535			3.900	75.00	43.00	9012210039000
0.1563	5/32		3.970	75.00	43.00	9012210039700
0.1575			4.000	75.00	43.00	9012210040000
0.1587			4.030	75.00	43.00	9012210040300
0.1594			4.050	75.00	43.00	9012210040500
0.1614			4.100	75.00	43.00	9012210041000
0.1654			4.200	75.00	43.00	9012210042000
0.1693		18	4.300	80.00	47.00	9012210043000
0.1720	11/64		4.370	80.00	47.00	9012210043700
0.1732			4.400	80.00	47.00	9012210044000
0.1772		16	4.500	80.00	47.00	9012210045000
0.1811			4.600	80.00	47.00	9012210046000
0.1850		13	4.700	80.00	47.00	9012210047000
0.1874	3/16		4.760	86.00	52.00	9012210047600
0.1890		12	4.800	86.00	52.00	9012210048000
0.1929			4.900	86.00	52.00	9012210049000
0.1961		9	4.980	86.00	52.00	9012210049800
0.1969			5.000	86.00	52.00	9012210050000
0.2008			5.100	86.00	52.00	9012210051000
0.2047			5.200	86.00	52.00	9012210052000
0.2087			5.300	86.00	52.00	9012210053000
0.2126			5.400	93.00	57.00	9012210054000
0.2165			5.500	93.00	57.00	9012210055000
0.2189	7/32		5.560	93.00	57.00	9012210055600
0.2205			5.600	93.00	57.00	9012210056000
0.2244			5.700	93.00	57.00	9012210057000
0.2283			5.800	93.00	57.00	9012210058000
0.2323			5.900	93.00	57.00	9012210059000
0.2343	15/64		5.950	93.00	57.00	9012210059500
0.2362			6.000	93.00	57.00	9012210060000
0.2402			6.100	101.00	63.00	9012210061000
0.2441			6.200	101.00	63.00	9012210062000
0.2480			6.300	101.00	63.00	9012210063000
0.2500	1/4	E	6.350	101.00	63.00	9012210063500

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.2520			6.400	101.00	63.00	9012210064000
0.2559			6.500	101.00	63.00	9012210065000
0.2598			6.600	101.00	63.00	9012210066000
0.2638			6.700	101.00	63.00	9012210067000
0.2677			6.800	109.00	69.00	9012210068000
0.2717		I	6.900	109.00	69.00	9012210069000
0.2756			7.000	109.00	69.00	9012210070000
0.2795			7.100	109.00	69.00	9012210071000
0.2811	9/32	K	7.140	109.00	69.00	9012210071400
0.2835			7.200	109.00	69.00	9012210072000
0.2874			7.300	109.00	69.00	9012210073000
0.2913			7.400	109.00	69.00	9012210074000
0.2953			7.500	109.00	69.00	9012210075000
0.3031			7.700	117.00	75.00	9012210077000
0.3071			7.800	117.00	75.00	9012210078000
0.3110			7.900	117.00	75.00	9012210079000
0.3150			8.000	117.00	75.00	9012210080000
0.3189			8.100	117.00	75.00	9012210081000
0.3228		P	8.200	117.00	75.00	9012210082000
0.3307			8.400	117.00	75.00	9012210084000
0.3346			8.500	117.00	75.00	9012210085000
0.3386			8.600	125.00	81.00	9012210086000
0.3425			8.700	125.00	81.00	9012210087000
0.3465			8.800	125.00	81.00	9012210088000
0.3504			8.900	125.00	81.00	9012210089000
0.3543			9.000	125.00	81.00	9012210090000
0.3594	23/64		9.130	125.00	81.00	9012210091300
0.3740			9.500	125.00	81.00	9012210095000
0.3748	3/8		9.520	133.00	87.00	9012210095200
0.3898			9.900	133.00	87.00	9012210099000
0.3906	25/64		9.920	133.00	87.00	9012210099200
0.3937			10.000	133.00	87.00	9012210100000
0.4016			10.200	133.00	87.00	9012210102000
0.4134			10.500	133.00	87.00	9012210105000
0.4213			10.700	142.00	94.00	9012210107000
0.4220	27/64		10.720	142.00	94.00	9012210107200
0.4252			10.800	142.00	94.00	9012210108000
0.4331			11.000	142.00	94.00	9012210110000
0.4528			11.500	142.00	94.00	9012210115000
0.4689	15/32		11.910	151.00	101.00	9012210119100
0.4724			12.000	151.00	101.00	9012210120000

## Alternative Drill Series:

#530 PM Cobalt, GT500, 5xD, 130 pt, FIREX®  
 #622 Cobalt, GT100, 5xD, 130 pt, Bright/Nitrided lands > 2.36  
 #549 HSS, GT100, 5xD, 130 pt, Bright/Nitrided lands > 2.36  
 #652 HSS, GT100, 5xD, 130 pt, TiN