



Cast Iron and Abrasive Materials

METRIC

FINE

**6HX
Class of Fit**



Blind Hole

0° Helix

**Straight Flute
Chamfer Lead**



C · 2 - 3

DIN length - DIN shank

Series 318 - Cobalt, Metric, straight flute, TiAlN coated, DIN 371, axial coolant
Series 1890 - Cobalt, Metric, straight flute, oxide finish, DIN 371, axial coolant



	No.	Shank dia.	Square Size	Overall Length	6HX Approx.	DIN 371 Series	DIN 371 Series	Order
Size	Flutes	mm	dec.	mm	Limits	318	1890	No.
M5 X 0.80	4	6.000	4.900	70.000	D3/D4	°		5.000
M6 X 1.00	4	6.000	4.900	80.000	D4/D5			6.000
M8 X 1.25	4	8.000	6.200	90.000	D4/D5			8.000
M10 X 1.50	4	10.000	8.000	100.000	D4/D5			10.000

DIN length - DIN shank

Series 319 - Cobalt, Metric, straight flute, TiAlN coated, DIN 376, axial coolant
Series 1897 - Cobalt, Metric, straight flute, oxide finish, DIN 376, axial coolant



	No.	Shank dia.	Square Size	Overall Length	6HX Approx.	DIN 376 Series	DIN 376 Series	Order
Size	Flutes	mm	dec.	mm	Limits	319	1897	No.
M12 X 1.75	4	9.000	7.000	110.000	D5/D6			12.000
M14 X 2.00	4	11.000	9.000	110.000	D5/D6		°	14.000
M16 X 2.00	4	12.000	9.000	110.000	D6/D7		°	16.000
M18 X 2.50	5	14.000	11.000	125.000	D6/D7	°	°	18.000
M20 X 2.50	5	16.000	12.000	140.000	D6/D7		°	20.000

DIN length - DIN shank

Series 1904 - Cobalt, Metric Fine, straight flute, oxide finish, DIN 374, axial coolant
Series 347 - Cobalt, Metric Fine, straight flute, TiAlN coated, DIN 374, axial coolant



	No.	Shank dia.	Square Size	Overall Length	ISO2 (6H) Approx.	DIN 374 Series	DIN 374 Series	Order
Size	Flutes	mm	dec.	mm	Limits	1904	347	No.
M8 X 1.00	4	6.000	4.900	90.000	D4/D5	°		8.005
M10 X 1.00	4	7.000	5.500	90.000	D4/D5	°	°	10.005
M12 X 1.00	4	9.000	7.000	100.000	D4/D5	°	°	12.005
M12 X 1.50	4	9.000	7.000	100.000	D5/D6	°		12.007
M14 X 1.50	4	11.000	9.000	100.000	D4/D5			14.007
M16 X 1.50	4	12.000	9.000	100.000	D4/D5			16.007
M18 X 1.50	5	14.000	11.000	110.000	D4/D5	°		18.007
M20 X 1.50	5	16.000	12.000	125.000	D6/D7		°	20.007
M22 X 1.50	5	18.000	14.500	125.000	D6/D7			22.007
M24 X 1.50	5	18.000	14.500	140.000	D6/D7		°	24.007