3xD Ratio drills

Series no. **1702**

3xD	RT 100 F	140°	m7		Cyl	R
Cutting depth	Type	Point angle	Tolerance on Ø	Without Internal coolant	Shank form	Cutting direction

Tool material: **Solid Carbide**

Surface: **S**

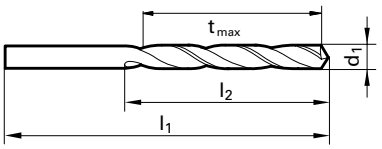
P	Steel	○
M	Stainless steel	●
K	Cast iron	○
N	Aluminum	○
S	Titanium alloys	○
H	Hardened steel	○

●=Optimal
○=Limited

web thinning ≥ Ø 3.000 • relieved cone • main cutting edge form concave • optimized cutting geometry • sharp cutting edges

stainless/acid-/heat-resistant steels • Inconel, Hastelloy, Monel • brass, bronzes • aluminum and Al-alloys • magnesium and magnesium alloys • Titanium and Titanium alloys • sintered powder metals • high-alloyed steels

$t_{max} = l_2\text{-}1.5 \times d_1$



Speeds and feeds information on pg. 555

Shank diameter = cut diameter

Diameter (d1) inch	wire/ltr	mm	l1 mm	t_{max} mm	l2 mm	EDP #
0.1181		3.00	46.00	11.50	16.00	**9017020030000**
0.1220		3.10	49.00	13.35	18.00	**9017020031000**
0.1248	1/8	3.17	49.00	13.25	18.00	**9017020031700**
0.1260		3.20	49.00	13.20	18.00	**9017020032000**
0.1299		3.30	49.00	13.05	18.00	**9017020033000**
0.1339		3.40	52.00	14.90	20.00	**9017020034000**
0.1378		3.50	52.00	14.75	20.00	**9017020035000**
0.1406	9/64 #28	3.57	52.00	14.65	20.00	**9017020035700**
0.1417		3.60	52.00	14.60	20.00	**9017020036000**
0.1457		3.70	52.00	14.45	20.00	**9017020037000**
0.1496	#25	3.80	55.00	16.30	22.00	**9017020038000**
0.1535		3.90	55.00	16.15	22.00	**9017020039000**
0.1563	5/32	3.97	55.00	16.05	22.00	**9017020039700**
0.1575		4.00	55.00	16.00	22.00	**9017020040000**
0.1614		4.10	55.00	15.85	22.00	**9017020041000**
0.1654		4.20	55.00	15.70	22.00	**9017020042000**
0.1693	#18	4.30	58.00	17.55	24.00	**9017020043000**
0.1720	11/64	4.37	58.00	17.45	24.00	**9017020043700**
0.1732		4.40	58.00	17.40	24.00	**9017020044000**
0.1772	#16	4.50	58.00	17.25	24.00	**9017020045000**
0.1811		4.60	58.00	17.10	24.00	**9017020046000**
0.1850	#13	4.70	58.00	16.95	24.00	**9017020047000**
0.1874	3/16	4.76	62.00	18.86	26.00	**9017020047600**
0.1890	#12	4.80	62.00	18.80	26.00	**9017020048000**
0.1929		4.90	62.00	18.65	26.00	**9017020049000**
0.1969		5.00	62.00	18.50	26.00	**9017020050000**
0.2008		5.10	62.00	18.35	26.00	**9017020051000**
0.2031	13/64	5.16	62.00	18.26	26.00	**9017020051600**
0.2047		5.20	62.00	18.20	26.00	**9017020052000**
0.2087		5.30	62.00	18.05	26.00	**9017020053000**
0.2126		5.40	66.00	19.90	28.00	**9017020054000**
0.2165		5.50	66.00	19.75	28.00	**9017020055000**
0.2189	7/32	5.56	66.00	19.66	28.00	**9017020055600**
0.2205		5.60	66.00	19.60	28.00	**9017020056000**
0.2244		5.70	66.00	19.45	28.00	**9017020057000**
0.2283		5.80	66.00	19.30	28.00	**9017020058000**
0.2323		5.90	66.00	19.15	28.00	**9017020059000**
0.2343	15/64	5.95	66.00	19.08	28.00	**9017020059500**
0.2362		6.00	66.00	19.00	28.00	**9017020060000**
0.2402		6.10	70.00	21.85	31.00	**9017020061000**
0.2441		6.20	70.00	21.70	31.00	**9017020062000**
0.2480		6.30	70.00	21.55	31.00	**9017020063000**

Diameter (d1) inch	wire/ltr		mm	l1 mm	t_{max} mm	l2 mm	EDP #
0.2500	1/4	E	6.35	70.00	21.48	31.00	**9017020063500**
0.2520			6.40	70.00	21.40	31.00	**9017020064000**
0.2559			6.50	70.00	21.25	31.00	**9017020065000**
0.2598			6.60	70.00	21.10	31.00	**9017020066000**
0.2638			6.70	70.00	20.95	31.00	**9017020067000**
0.2657	17/64	H	6.75	74.00	23.88	34.00	**9017020067500**
0.2677			6.80	74.00	23.80	34.00	**9017020068000**
0.2717		I	6.90	74.00	23.65	34.00	**9017020069000**
0.2756			7.00	74.00	23.50	34.00	**9017020070000**
0.2795			7.10	74.00	23.35	34.00	**9017020071000**
0.2811	9/32	K	7.14	74.00	23.29	34.00	**9017020071400**
0.2835			7.20	74.00	23.20	34.00	**9017020072000**
0.2874			7.30	74.00	23.05	34.00	**9017020073000**
0.2913			7.40	74.00	22.90	34.00	**9017020074000**
0.2953			7.50	74.00	22.75	34.00	**9017020075000**
0.2969	19/64		7.54	79.00	25.69	37.00	**9017020075400**
0.2992			7.60	79.00	25.60	37.00	**9017020076000**
0.3031			7.70	79.00	25.45	37.00	**9017020077000**
0.3071			7.80	79.00	25.30	37.00	**9017020078000**
0.3110			7.90	79.00	25.15	37.00	**9017020079000**
0.3126	5/16		7.94	79.00	25.09	37.00	**9017020079400**
0.3150			8.00	79.00	25.00	37.00	**9017020080000**
0.3189			8.10	79.00	24.85	37.00	**9017020081000**
0.3228		P	8.20	79.00	24.70	37.00	**9017020082000**
0.3268			8.30	79.00	24.55	37.00	**9017020083000**
0.3280	21/64		8.33	79.00	24.51	37.00	**9017020083300**
0.3307			8.40	79.00	24.40	37.00	**9017020084000**
0.3346			8.50	79.00	24.25	37.00	**9017020085000**
0.3386			8.60	84.00	27.10	40.00	**9017020086000**
0.3425			8.70	84.00	26.95	40.00	**9017020087000**
0.3437	11/32		8.73	84.00	26.91	40.00	**9017020087300**
0.3465			8.80	84.00	26.80	40.00	**9017020088000**
0.3504			8.90	84.00	26.65	40.00	**9017020089000**
0.3543			9.00	84.00	26.50	40.00	**9017020090000**
0.3583			9.10	84.00	26.35	40.00	**9017020091000**
0.3594	23/64		9.13	84.00	26.31	40.00	**9017020091300**
0.3622			9.20	84.00	26.20	40.00	**9017020092000**
0.3661			9.30	84.00	26.05	40.00	**9017020093000**
0.3701			9.40	84.00	25.90	40.00	**9017020094000**
0.3740			9.50	84.00	25.75	40.00	**9017020095000**
0.3748	3/8		9.52	89.00	28.72	43.00	**9017020095200**
0.3780			9.60	89.00	28.60	43.00	**9017020096000**

3xD Ratio drills

Series no. **1702**

Diameter (d1) inch	wire/ltr	mm	l1 mm	t_{max} mm	l2 mm	EDP #
0.3819		9.70	89.00	28.45	43.00	**9017020097000**
0.3858	W	9.80	89.00	28.30	43.00	**9017020098000**
0.3898		9.90	89.00	28.15	43.00	**9017020099000**
0.3906	25/64	9.92	89.00	28.12	43.00	**9017020099200**
0.3937		10.00	89.00	28.00	43.00	**9017020100000**
0.4016		10.20	89.00	27.70	43.00	**9017020102000**
0.4055		10.30	89.00	27.55	43.00	**9017020103000**
0.4063	13/32	10.32	89.00	27.52	43.00	**9017020103200**
0.4134		10.50	89.00	27.25	43.00	**9017020105000**
0.4213		10.70	95.00	30.95	47.00	**9017020107000**
0.4220	27/64	10.72	95.00	30.92	47.00	**9017020107200**
0.4252		10.80	95.00	30.80	47.00	**9017020108000**
0.4331		11.00	95.00	30.50	47.00	**9017020110000**
0.4374	7/16	11.11	95.00	30.34	47.00	**9017020111100**

Diameter (d1) inch	wire/ltr	mm	l1 mm	t_{max} mm	l2 mm	EDP #
0.4528		11.50	95.00	29.75	47.00	**9017020115000**
0.4531	29/64	11.51	95.00	29.74	47.00	**9017020115100**
0.4646		11.80	95.00	29.30	47.00	**9017020118000**
0.4689	15/32	11.91	102.00	33.14	51.00	**9017020119100**
0.4724		12.00	102.00	33.00	51.00	**9017020120000**
0.4843	31/64	12.30	102.00	32.55	51.00	**9017020123000**
0.4921		12.50	102.00	32.25	51.00	**9017020125000**
0.5000	1/2	12.70	102.00	31.95	51.00	**9017020127000**
0.5118		13.00	102.00	31.50	51.00	**9017020130000**
0.5315		13.50	107.00	33.75	54.00	**9017020135000**
0.5512		14.00	107.00	33.00	54.00	**9017020140000**
0.5709		14.50	111.00	34.25	56.00	**9017020145000**
0.5906		15.00	111.00	33.50	56.00	**9017020150000**