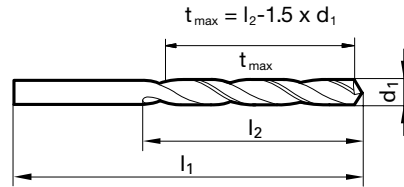




Tool material **HSCO**
Surface **S**

- P** Steel ● web thinning $\geq \varnothing 1.000$ • facet split point • Co-alloyed high speed steel • low feed force required • low torque required • for universal application
- M** Stainless steel ●
- K** Cast iron ● alloyed/unalloyed steels up to 800 N/mm² • cold/hot work steels • antifricition bearing steels • non-ferrous metals • cast materials • stainless steels • plastics
- N** Aluminum ●
- S** Titanium alloys ○
- H** Hardened steel ○

●=Optimal
○=Limited



Speeds and feeds information on pg. 573

Shank diameter = cut diameter

Diameter (d ₁)		l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr				
0.0394		34.00	10.50	12.00	9055190010000
0.0402		34.00	10.47	12.00	9055190010200
0.0409		34.00	10.44	12.00	9055190010400
0.0421		36.00	12.40	14.00	9055190010700
0.0429		36.00	12.37	14.00	9055190010900
0.0433		36.00	12.35	14.00	9055190011000
0.0465		36.00	12.23	14.00	9055190011800
0.0469	3/64	38.00	14.22	16.00	9055190011900
0.0472		38.00	14.20	16.00	9055190012000
0.0512		38.00	14.05	16.00	9055190013000
0.0520		38.00	14.02	16.00	9055190013200
0.0551		40.00	15.90	18.00	9055190014000
0.0591		40.00	15.75	18.00	9055190015000
0.0594		43.00	17.74	20.00	9055190015100
0.0626	1/16	43.00	17.62	20.00	9055190015900
0.0630		43.00	17.60	20.00	9055190016000
0.0634		43.00	17.59	20.00	9055190016100
0.0669		43.00	17.45	20.00	9055190017000
0.0701		46.00	19.33	22.00	9055190017800
0.0709		46.00	19.30	22.00	9055190018000
0.0728		46.00	19.23	22.00	9055190018500
0.0748		46.00	19.15	22.00	9055190019000
0.0760		49.00	21.11	24.00	9055190019300
0.0780	5/64	49.00	21.03	24.00	9055190019800
0.0783		49.00	21.02	24.00	9055190019900
0.0787		49.00	21.00	24.00	9055190020000
0.0811		49.00	20.91	24.00	9055190020600
0.0819		49.00	20.88	24.00	9055190020800
0.0827		49.00	20.85	24.00	9055190021000
0.0858		53.00	23.73	27.00	9055190021800
0.0866		53.00	23.70	27.00	9055190022000
0.0890		53.00	23.61	27.00	9055190022600
0.0906		53.00	23.55	27.00	9055190023000
0.0933		57.00	26.45	30.00	9055190023700
0.0937	3/32	57.00	26.43	30.00	9055190023800
0.0945		57.00	26.40	30.00	9055190024000
0.0961		57.00	26.34	30.00	9055190024400
0.0980		57.00	26.27	30.00	9055190024900
0.0984		57.00	26.25	30.00	9055190025000
0.0996		57.00	26.21	30.00	9055190025300
0.1016		57.00	26.13	30.00	9055190025800
0.1024		57.00	26.10	30.00	9055190026000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.1039		2.64	57.00	26.04	30.00	9055190026400
0.1063		2.70	61.00	28.95	33.00	9055190027000
0.1067		2.71	61.00	28.94	33.00	9055190027100
0.1094	7/64	2.78	61.00	28.83	33.00	9055190027800
0.1098		2.79	61.00	28.82	33.00	9055190027900
0.1102		2.80	61.00	28.80	33.00	9055190028000
0.1110		2.82	61.00	28.77	33.00	9055190028200
0.1130		2.87	61.00	28.70	33.00	9055190028700
0.1142		2.90	61.00	28.65	33.00	9055190029000
0.1161		2.95	61.00	28.58	33.00	9055190029500
0.1181		3.00	61.00	28.50	33.00	9055190030000
0.1201		3.05	65.00	31.43	36.00	9055190030500
0.1220		3.10	65.00	31.35	36.00	9055190031000
0.1248	1/8	3.17	65.00	31.25	36.00	9055190031700
0.1260		3.20	65.00	31.20	36.00	9055190032000
0.1283		3.26	65.00	31.11	36.00	9055190032600
0.1299		3.30	65.00	31.05	36.00	9055190033000
0.1339		3.40	70.00	33.90	39.00	9055190034000
0.1358		3.45	70.00	33.83	39.00	9055190034500
0.1378		3.50	70.00	33.75	39.00	9055190035000
0.1406	9/64 #28	3.57	70.00	33.65	39.00	9055190035700
0.1417		3.60	70.00	33.60	39.00	9055190036000
0.1441		3.66	70.00	33.51	39.00	9055190036600
0.1457		3.70	70.00	33.45	39.00	9055190037000
0.1469		3.73	70.00	33.41	39.00	9055190037300
0.1496		3.80	75.00	37.30	43.00	9055190038000
0.1520		3.86	75.00	37.21	43.00	9055190038600
0.1535		3.90	75.00	37.15	43.00	9055190039000
0.1539		3.91	75.00	37.14	43.00	9055190039100
0.1563	5/32	3.97	75.00	37.05	43.00	9055190039700
0.1571		3.99	75.00	37.02	43.00	9055190039900
0.1575		4.00	75.00	37.00	43.00	9055190040000
0.1591		4.04	75.00	36.94	43.00	9055190040400
0.1610		4.09	75.00	36.87	43.00	9055190040900
0.1614		4.10	75.00	36.85	43.00	9055190041000
0.1654		4.20	75.00	36.70	43.00	9055190042000
0.1661		4.22	75.00	36.67	43.00	9055190042200
0.1693		4.30	80.00	40.55	47.00	9055190043000
0.1720	11/64	4.37	80.00	40.45	47.00	9055190043700
0.1728		4.39	80.00	40.42	47.00	9055190043900
0.1732		4.40	80.00	40.40	47.00	9055190044000
0.1772		4.50	80.00	40.25	47.00	9055190045000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #	Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm					inch	wire/ltr	mm				
0.1799		4.57	80.00	40.15	47.00	9055190045700	0.3031		7.70	117.00	63.45	75.00	9055190077000
0.1811		4.60	80.00	40.10	47.00	9055190046000	0.3071		7.80	117.00	63.30	75.00	9055190078000
0.1819		4.62	80.00	40.07	47.00	9055190046200	0.3110		7.90	117.00	63.15	75.00	9055190079000
0.1850		4.70	80.00	39.95	47.00	9055190047000	0.3126	5/16	7.94	117.00	63.09	75.00	9055190079400
0.1874	3/16	4.76	86.00	44.86	52.00	9055190047600	0.3150		8.00	117.00	63.00	75.00	9055190080000
0.1890		4.80	86.00	44.80	52.00	9055190048000	0.3161	0	8.03	117.00	62.96	75.00	9055190080300
0.1909		4.85	86.00	44.73	52.00	9055190048500	0.3189		8.10	117.00	62.85	75.00	9055190081000
0.1929		4.90	86.00	44.65	52.00	9055190049000	0.3228	P	8.20	117.00	62.70	75.00	9055190082000
0.1937		4.92	86.00	44.62	52.00	9055190049200	0.3268		8.30	117.00	62.55	75.00	9055190083000
0.1961		4.98	86.00	44.53	52.00	9055190049800	0.3280	21/64	8.33	117.00	62.51	75.00	9055190083300
0.1969		5.00	86.00	44.50	52.00	9055190050000	0.3307		8.40	117.00	62.40	75.00	9055190084000
0.1992		5.06	86.00	44.41	52.00	9055190050600	0.3319	Q	8.43	117.00	62.36	75.00	9055190084300
0.2008		5.10	86.00	44.35	52.00	9055190051000	0.3346		8.50	117.00	62.25	75.00	9055190085000
0.2012		5.11	86.00	44.34	52.00	9055190051100	0.3386		8.60	125.00	68.10	81.00	9055190086000
0.2031	13/64	5.16	86.00	44.26	52.00	9055190051600	0.3390	R	8.61	125.00	68.09	81.00	9055190086100
0.2039		5.18	86.00	44.23	52.00	9055190051800	0.3425		8.70	125.00	67.95	81.00	9055190087000
0.2047		5.20	86.00	44.20	52.00	9055190052000	0.3437	11/32	8.73	125.00	67.91	81.00	9055190087300
0.2055		5.22	86.00	44.17	52.00	9055190052200	0.3465		8.80	125.00	67.80	81.00	9055190088000
0.2087		5.30	86.00	44.05	52.00	9055190053000	0.3480	S	8.84	125.00	67.74	81.00	9055190088400
0.2091		5.31	93.00	49.04	57.00	9055190053100	0.3504		8.90	125.00	67.65	81.00	9055190089000
0.2126		5.40	93.00	48.90	57.00	9055190054000	0.3543		9.00	125.00	67.50	81.00	9055190090000
0.2130		5.41	93.00	48.89	57.00	9055190054100	0.3579	T	9.09	125.00	67.37	81.00	9055190090900
0.2165		5.50	93.00	48.75	57.00	9055190055000	0.3583		9.10	125.00	67.35	81.00	9055190091000
0.2189	7/32	5.56	93.00	48.66	57.00	9055190055600	0.3594	23/64	9.13	125.00	67.31	81.00	9055190091300
0.2205		5.60	93.00	48.60	57.00	9055190056000	0.3622		9.20	125.00	67.20	81.00	9055190092000
0.2209		5.61	93.00	48.59	57.00	9055190056100	0.3661		9.30	125.00	67.05	81.00	9055190093000
0.2244		5.70	93.00	48.45	57.00	9055190057000	0.3677	U	9.34	125.00	66.99	81.00	9055190093400
0.2280		5.79	93.00	48.32	57.00	9055190057900	0.3701		9.40	125.00	66.90	81.00	9055190094000
0.2283		5.80	93.00	48.30	57.00	9055190058000	0.3740		9.50	125.00	66.75	81.00	9055190095000
0.2323		5.90	93.00	48.15	57.00	9055190059000	0.3748	3/8	9.52	133.00	72.72	87.00	9055190095200
0.2339	A	5.94	93.00	48.09	57.00	9055190059400	0.3772	V	9.58	133.00	72.63	87.00	9055190095800
0.2343	15/64	5.95	93.00	48.08	57.00	9055190059500	0.3780		9.60	133.00	72.60	87.00	9055190096000
0.2362		6.00	93.00	48.00	57.00	9055190060000	0.3819		9.70	133.00	72.45	87.00	9055190097000
0.2378	B	6.04	101.00	53.94	63.00	9055190060400	0.3858	W	9.80	133.00	72.30	87.00	9055190098000
0.2402		6.10	101.00	53.85	63.00	9055190061000	0.3898		9.90	133.00	72.15	87.00	9055190099000
0.2421	C	6.15	101.00	53.78	63.00	9055190061500	0.3906	25/64	9.92	133.00	72.12	87.00	9055190099200
0.2441		6.20	101.00	53.70	63.00	9055190062000	0.3937		10.00	133.00	72.00	87.00	9055190100000
0.2461	D	6.25	101.00	53.63	63.00	9055190062500	0.3969	X	10.08	133.00	71.88	87.00	9055190100800
0.2480		6.30	101.00	53.55	63.00	9055190063000	0.3976		10.10	133.00	71.85	87.00	9055190101000
0.2500	1/4	6.35	101.00	53.48	63.00	9055190063500	0.4016		10.20	133.00	71.70	87.00	9055190102000
0.2520		6.40	101.00	53.40	63.00	9055190064000	0.4039	Y	10.26	133.00	71.61	87.00	9055190102600
0.2559		6.50	101.00	53.25	63.00	9055190065000	0.4055		10.30	133.00	71.55	87.00	9055190103000
0.2571	F	6.53	101.00	53.21	63.00	9055190065300	0.4063	13/32	10.32	133.00	71.52	87.00	9055190103200
0.2598		6.60	101.00	53.10	63.00	9055190066000	0.4094		10.40	133.00	71.40	87.00	9055190104000
0.2610	G	6.63	101.00	53.06	63.00	9055190066300	0.4130	Z	10.49	133.00	71.27	87.00	9055190104900
0.2638		6.70	101.00	52.95	63.00	9055190067000	0.4134		10.50	133.00	71.25	87.00	9055190105000
0.2657	17/64	6.75	109.00	58.88	69.00	9055190067500	0.4220	27/64	10.72	142.00	77.92	94.00	9055190107200
0.2677		6.80	109.00	58.80	69.00	9055190068000	0.4331		11.00	142.00	77.50	94.00	9055190110000
0.2717	I	6.90	109.00	58.65	69.00	9055190069000	0.4374	7/16	11.11	142.00	77.34	94.00	9055190111100
0.2756		7.00	109.00	58.50	69.00	9055190070000	0.4528		11.50	142.00	76.75	94.00	9055190115000
0.2768	J	7.03	109.00	58.46	69.00	9055190070300	0.4531	29/64	11.51	142.00	76.74	94.00	9055190115100
0.2795		7.10	109.00	58.35	69.00	9055190071000	0.4689	15/32	11.91	151.00	83.14	101.00	9055190119100
0.2811	9/32	7.14	109.00	58.29	69.00	9055190071400	0.4724		12.00	151.00	83.00	101.00	9055190120000
0.2835		7.20	109.00	58.20	69.00	9055190072000	0.4843	31/64	12.30	151.00	82.55	101.00	9055190123000
0.2874		7.30	109.00	58.05	69.00	9055190073000	0.4921		12.50	151.00	82.25	101.00	9055190125000
0.2902	L	7.37	109.00	57.95	69.00	9055190073700	0.5000	1/2	12.70	151.00	81.95	101.00	9055190127000
0.2913		7.40	109.00	57.90	69.00	9055190074000	0.5118		13.00	151.00	81.50	101.00	9055190130000
0.2949	M	7.49	109.00	57.77	69.00	9055190074900	0.5157	33/64	13.10	151.00	81.35	101.00	9055190131000
0.2953		7.50	109.00	57.75	69.00	9055190075000	0.5311	17/32	13.49	160.00	87.77	108.00	9055190134900
0.2969	19/64	7.54	117.00	63.69	75.00	9055190075400	0.5315		13.50	160.00	87.75	108.00	9055190135000
0.2992		7.60	117.00	63.60	75.00	9055190076000	0.5512		14.00	160.00	87.00	108.00	9055190140000
0.3020	N	7.67	117.00	63.50	75.00	9055190076700	0.5626	9/16	14.29	169.00	92.57	114.00	9055190142900

Jobber Length