



Tool material

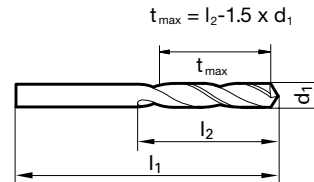
HSS-E-PM

Surface



P	Steel	●	web thinning ≥ Ø 1.000 • relieved cone • PM-Co-alloyed high speed steel • especially high rigidity • especially high wear resistance
M	Stainless steel	●	
K	Cast iron	●	high-alloyed steels • heat treatable and case hardened steels • cast iron, brass, bronze
N	Aluminum	○	
S	Titanium alloys	●	
H	Hardened steel	○	

●=Optimal
○=Limited



Speeds and feeds information on pg. 574

Shank diameter = cut diameter

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0394		1.00	26.00	4.50	6.00	9055210010000
0.0433		1.10	28.00	5.35	7.00	9055210011000
0.0472		1.20	30.00	6.20	8.00	9055210012000
0.0512		1.30	30.00	6.05	8.00	9055210013000
0.0551	#54	1.40	32.00	6.90	9.00	9055210014000
0.0591		1.50	32.00	6.75	9.00	9055210015000
0.0626	1/16	1.59	34.00	7.62	10.00	9055210015900
0.0630		1.60	34.00	7.60	10.00	9055210016000
0.0669	#51	1.70	34.00	7.45	10.00	9055210017000
0.0709		1.80	36.00	8.30	11.00	9055210018000
0.0748		1.90	36.00	8.15	11.00	9055210019000
0.0780	5/64	1.98	38.00	9.03	12.00	9055210019800
0.0787		2.00	38.00	9.00	12.00	9055210020000
0.0827		2.10	38.00	8.85	12.00	9055210021000
0.0866		2.20	40.00	9.70	13.00	9055210022000
0.0906		2.30	40.00	9.55	13.00	9055210023000
0.0937	3/32	2.38	43.00	10.43	14.00	9055210023800
0.0945		2.40	43.00	10.40	14.00	9055210024000
0.0984		2.50	43.00	10.25	14.00	9055210025000
0.1024		2.60	43.00	10.10	14.00	9055210026000
0.1063		2.70	46.00	11.95	16.00	9055210027000
0.1094	7/64	2.78	46.00	11.83	16.00	9055210027800
0.1102		2.80	46.00	11.80	16.00	9055210028000
0.1142		2.90	46.00	11.65	16.00	9055210029000
0.1181		3.00	46.00	11.50	16.00	9055210030000
0.1220		3.10	49.00	13.35	18.00	9055210031000
0.1248	1/8	3.17	49.00	13.25	18.00	9055210031700
0.1260		3.20	49.00	13.20	18.00	9055210032000
0.1299		3.30	49.00	13.05	18.00	9055210033000
0.1339		3.40	52.00	14.90	20.00	9055210034000
0.1378		3.50	52.00	14.75	20.00	9055210035000
0.1406	9/64	#28	52.00	14.65	20.00	9055210035700
0.1417		3.60	52.00	14.60	20.00	9055210036000
0.1457		3.70	52.00	14.45	20.00	9055210037000
0.1496	#25	3.80	55.00	16.30	22.00	9055210038000
0.1535		3.90	55.00	16.15	22.00	9055210039000
0.1563	5/32	3.97	55.00	16.05	22.00	9055210039700
0.1575		4.00	55.00	16.00	22.00	9055210040000
0.1614		4.10	55.00	15.85	22.00	9055210041000
0.1654		4.20	55.00	15.70	22.00	9055210042000
0.1693	#18	4.30	58.00	17.55	24.00	9055210043000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.1720	11/64	4.37	58.00	17.45	24.00	9055210043700
0.1732		4.40	58.00	17.40	24.00	9055210044000
0.1772	#16	4.50	58.00	17.25	24.00	9055210045000
0.1811		4.60	58.00	17.10	24.00	9055210046000
0.1850	#13	4.70	58.00	16.95	24.00	9055210047000
0.1874	3/16	4.76	62.00	18.86	26.00	9055210047600
0.1890	#12	4.80	62.00	18.80	26.00	9055210048000
0.1929		4.90	62.00	18.65	26.00	9055210049000
0.1969		5.00	62.00	18.50	26.00	9055210050000
0.2008		5.10	62.00	18.35	26.00	9055210051000
0.2031	13/64	5.16	62.00	18.26	26.00	9055210051600
0.2047		5.20	62.00	18.20	26.00	9055210052000
0.2087		5.30	62.00	18.05	26.00	9055210053000
0.2126		5.40	66.00	19.90	28.00	9055210054000
0.2165		5.50	66.00	19.75	28.00	9055210055000
0.2189	7/32	5.56	66.00	19.66	28.00	9055210055600
0.2205		5.60	66.00	19.60	28.00	9055210056000
0.2244		5.70	66.00	19.45	28.00	9055210057000
0.2283		5.80	66.00	19.30	28.00	9055210058000
0.2323		5.90	66.00	19.15	28.00	9055210059000
0.2343	15/64	5.95	66.00	19.08	28.00	9055210059500
0.2362		6.00	66.00	19.00	28.00	9055210060000
0.2402		6.10	70.00	21.85	31.00	9055210061000
0.2441		6.20	70.00	21.70	31.00	9055210062000
0.2480		6.30	70.00	21.55	31.00	9055210063000
0.2500	1/4	E	70.00	21.48	31.00	9055210063500
0.2520		6.40	70.00	21.40	31.00	9055210064000
0.2559		6.50	70.00	21.25	31.00	9055210065000
0.2598		6.60	70.00	21.10	31.00	9055210066000
0.2638		6.70	70.00	20.95	31.00	9055210067000
0.2657	17/64	H	74.00	23.88	34.00	9055210067500
0.2677		6.80	74.00	23.80	34.00	9055210068000
0.2717	I	6.90	74.00	23.65	34.00	9055210069000
0.2756		7.00	74.00	23.50	34.00	9055210070000
0.2795		7.10	74.00	23.35	34.00	9055210071000
0.2811	9/32	K	74.00	23.29	34.00	9055210071400
0.2835		7.20	74.00	23.20	34.00	9055210072000
0.2874		7.30	74.00	23.05	34.00	9055210073000
0.2913		7.40	74.00	22.90	34.00	9055210074000
0.2953		7.50	74.00	22.75	34.00	9055210075000
0.2969	19/64	7.54	79.00	25.69	37.00	9055210075400

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.2992		7.60	79.00	25.60	37.00	9055210076000
0.3031		7.70	79.00	25.45	37.00	9055210077000
0.3071		7.80	79.00	25.30	37.00	9055210078000
0.3110		7.90	79.00	25.15	37.00	9055210079000
0.3126	5/16	7.94	79.00	25.09	37.00	9055210079400
0.3150		8.00	79.00	25.00	37.00	9055210080000
0.3189		8.10	79.00	24.85	37.00	9055210081000
0.3228	P	8.20	79.00	24.70	37.00	9055210082000
0.3268		8.30	79.00	24.55	37.00	9055210083000
0.3280	21/64	8.33	79.00	24.51	37.00	9055210083300
0.3307		8.40	79.00	24.40	37.00	9055210084000
0.3346		8.50	79.00	24.25	37.00	9055210085000
0.3437	11/32	8.73	84.00	26.91	40.00	9055210087300
0.3465		8.80	84.00	26.80	40.00	9055210088000
0.3543		9.00	84.00	26.50	40.00	9055210090000
0.3594	23/64	9.13	84.00	26.31	40.00	9055210091300
0.3661		9.30	84.00	26.05	40.00	9055210093000
0.3740		9.50	84.00	25.75	40.00	9055210095000
0.3748	3/8	9.52	89.00	28.72	43.00	9055210095200

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.3858	W	9.80	89.00	28.30	43.00	9055210098000
0.3906	25/64	9.92	89.00	28.12	43.00	9055210099200
0.3937		10.00	89.00	28.00	43.00	9055210100000
0.4016		10.20	89.00	27.70	43.00	9055210102000
0.4063	13/32	10.32	89.00	27.52	43.00	9055210103200
0.4134		10.50	89.00	27.25	43.00	9055210105000
0.4220	27/64	10.72	95.00	30.92	47.00	9055210107200
0.4331		11.00	95.00	30.50	47.00	9055210110000
0.4374	7/16	11.11	95.00	30.34	47.00	9055210111100
0.4528		11.50	95.00	29.75	47.00	9055210115000
0.4689	15/32	11.91	102.00	33.14	51.00	9055210119100
0.4724		12.00	102.00	33.00	51.00	9055210120000
0.4843	31/64	12.30	102.00	32.55	51.00	9055210123000
0.4921		12.50	102.00	32.25	51.00	9055210125000
0.5000	1/2	12.70	102.00	31.95	51.00	9055210127000
0.5118		13.00	102.00	31.50	51.00	9055210130000
0.5315		13.50	107.00	33.75	54.00	9055210135000
0.5512		14.00	107.00	33.00	54.00	9055210140000

Stub Length