

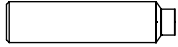
Micro drill

A

TiAlN coated



Coolant Through



Reinforced Straight Shank

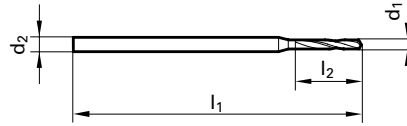
Speeds & Feeds
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Exclusive Line®

Coolant-fed

Carbide, Exclusive Line Micro Drills, 135° 4-facet
ground hone point, reinforced straight shank, RH helix

Cut Dia. = h7 tolerance range, Shank Dia. = h6



Application Materials:

- General Steels/Brass
- Universal Steels
- Stainless Steels
- Cast Iron
- Ti & Ni Alloys
- Aluminum & Alloys

Series 6408 (8xD)

Diameter (d1)		Wire / letter	mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch						
0.0551		54	1.400	4.000	52.00	15.00	9064080014000
0.0571			1.450	4.000	52.00	16.00	9064080014500
0.0591			1.500	4.000	52.00	17.00	9064080015000
0.0610			1.550	4.000	52.00	17.00	9064080015500
0.0626	1/16		1.590	4.000	52.00	18.00	9064080015900
0.0630			1.600	4.000	52.00	18.00	9064080016000
0.0650			1.650	4.000	52.00	18.00	9064080016500
0.0669		51	1.700	4.000	56.00	19.00	9064080017000
0.0689			1.750	4.000	56.00	19.00	9064080017500
0.0709			1.800	4.000	56.00	20.00	9064080018000
0.0728		49	1.850	4.000	56.00	20.00	9064080018500
0.0748			1.900	4.000	56.00	21.00	9064080019000
0.0768			1.950	4.000	56.00	21.00	9064080019500
0.0780	5/64		1.980	4.000	56.00	22.00	9064080019800
0.0787			2.000	4.000	56.00	22.00	9064080020000
0.0807			2.050	4.000	56.00	23.00	9064080020500
0.0827			2.100	4.000	62.00	23.00	9064080021000
0.0846			2.150	4.000	62.00	24.00	9064080021500
0.0866			2.200	4.000	62.00	24.00	9064080022000
0.0886			2.250	4.000	62.00	25.00	9064080022500
0.0906			2.300	4.000	62.00	25.00	9064080023000
0.0913			2.320	4.000	62.00	25.00	9064080023200
0.0925			2.350	4.000	62.00	26.00	9064080023500
0.0937	3/32		2.380	4.000	62.00	26.00	9064080023800
0.0945			2.400	4.000	62.00	26.00	9064080024000
0.0965			2.450	4.000	62.00	27.00	9064080024500
0.0984			2.500	4.000	62.00	28.00	9064080025000
0.1004			2.550	4.000	62.00	28.00	9064080025500
0.1024			2.600	4.000	66.00	29.00	9064080026000
0.1043			2.650	4.000	66.00	29.00	9064080026500
0.1063			2.700	4.000	66.00	30.00	9064080027000
0.1083			2.750	4.000	66.00	30.00	9064080027500
0.1094	7/64		2.780	4.000	66.00	31.00	9064080027800
0.1102			2.800	4.000	66.00	31.00	9064080028000
0.1122			2.850	4.000	66.00	31.00	9064080028500
0.1142			2.900	4.000	66.00	32.00	9064080029000
0.1161		32	2.950	4.000	66.00	32.00	9064080029500
0.1181			3.000	4.000	66.00	33.00	9064080030000

Alternative Drill Series:

#6412 Carbide, Micro, 15xD, 135 pt, TiAlN Tipped

Series 6412 (15xD)

Diameter (d1)		Wire / letter	mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch						
0.0551			1.400	4.000	62.00	25.00	9064120014000
0.0591			1.500	4.000	62.00	27.00	9064120015000
0.0626	1/16		1.590	4.000	62.00	29.00	9064120015900
0.0630			1.600	4.000	62.00	29.00	9064120016000
0.0669			1.700	4.000	70.00	31.00	9064120017000
0.0709			1.800	4.000	70.00	32.00	9064120018000
0.0748			1.900	4.000	70.00	34.00	9064120019000
0.0780	5/64		1.980	4.000	70.00	36.00	9064120019800
0.0787			2.000	4.000	70.00	36.00	9064120020000
0.0827			2.100	4.000	78.00	38.00	9064120021000
0.0866			2.200	4.000	78.00	40.00	9064120022000
0.0906			2.300	4.000	78.00	42.00	9064120023000
0.0937	3/32		2.380	4.000	78.00	44.00	9064120023800
0.0945			2.400	4.000	78.00	44.00	9064120024000
0.0984			2.500	4.000	78.00	45.00	9064120025000
0.1024			2.600	4.000	87.00	47.00	9064120026000
0.1063			2.700	4.000	87.00	48.00	9064120027000
0.1094	7/64		2.780	4.000	87.00	50.00	9064120027800
0.1102			2.800	4.000	87.00	50.00	9064120028000
0.1142			2.900	4.000	87.00	52.00	9064120029000
0.1181			3.000	4.000	87.00	54.00	9064120030000

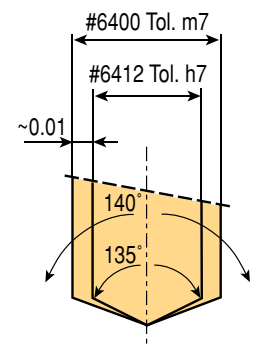
Alternative Drill Series:

#6408 Carbide, Micro, 8xD, 135 pt, TiAlN Tipped

Pilot drilling

For applications using Series 6412 carbide micro-precision drills to drilling depths of 15xD we recommend a pilot hole 1xD up to 2xD depth.

For this pilot hole, the Series 6400 solid carbide micro-precision drill (4xD) is optimally suited. Its 140° point angle and its m7 diameter tolerance are perfectly adapted.



Spot Drilling

In order to achieve full performance with Series 6408 carbide micro-precision drills at 8xD drilling depth, we recommend spot drilling.

The ExclusiveLine Series 6400 solid carbide micro-precision drill (up to 4xD) can be applied for this purpose. The spot drill diameter should be approximately $\frac{2}{3} \times d_1$.

