





5xD

Series 8511

Application Materials:

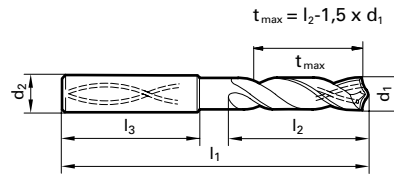
-  Universal Steels
-  Stainless Steels
-  Hardened Materials
-  Ti & Ni Alloys

Twist Drills

RT 100 VA High Penetration

Carbide, RT 100 VA, 5xD, self-centering
140° VA point, reinforced straight shank, RH helix

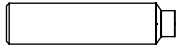
Cut Dia. = m7 tolerance range, Shank Dia. = h6



a
nano-A™ coated



Coolant Through



Reinforced Straight Shank

Speeds & Feeds
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| Diameter (d1) | | | d2 mm | l1 mm | l2 mm | EDP # |
|---------------|----------------|------------------|----------|----------|----------|---------------|
| Dec. inch | Fract. inch | Wire / letter | | | | |
| 0.1181 | | | 3.000 | 66.00 | 28.00 | 9085110030000 |
| 0.1220 | | | 3.100 | 66.00 | 28.00 | 9085110031000 |
| 0.1248 | 1/8 | | 3.170 | 66.00 | 28.00 | 9085110031700 |
| 0.1260 | | | 3.200 | 66.00 | 28.00 | 9085110032000 |
| 0.1280 | | | 3.250 | 66.00 | 28.00 | 9085110032500 |
| 0.1299 | | | 3.300 | 66.00 | 28.00 | 9085110033000 |
| 0.1339 | | | 3.400 | 66.00 | 28.00 | 9085110034000 |
| 0.1378 | | | 3.500 | 66.00 | 28.00 | 9085110035000 |
| 0.1406 | 9/64 | 28 | 3.570 | 66.00 | 28.00 | 9085110035700 |
| 0.1417 | | | 3.600 | 66.00 | 28.00 | 9085110036000 |
| 0.1457 | | | 3.700 | 66.00 | 28.00 | 9085110037000 |
| 0.1496 | | 25 | 3.800 | 66.00 | 28.00 | 9085110038000 |
| 0.1535 | | | 3.900 | 66.00 | 28.00 | 9085110039000 |
| 0.1563 | 5/32 | | 3.970 | 66.00 | 28.00 | 9085110039700 |
| 0.1575 | | | 4.000 | 66.00 | 28.00 | 9085110040000 |
| 0.1614 | | | 4.100 | 66.00 | 28.00 | 9085110041000 |
| 0.1654 | | | 4.200 | 66.00 | 28.00 | 9085110042000 |
| 0.1693 | | 18 | 4.300 | 66.00 | 28.00 | 9085110043000 |
| 0.1720 | 11/64 | | 4.370 | 66.00 | 28.00 | 9085110043700 |
| 0.1732 | | | 4.400 | 66.00 | 28.00 | 9085110044000 |
| 0.1772 | | 16 | 4.500 | 66.00 | 28.00 | 9085110045000 |
| 0.1811 | | | 4.600 | 66.00 | 28.00 | 9085110046000 |
| 0.1831 | | | 4.650 | 66.00 | 28.00 | 9085110046500 |
| 0.1850 | | 13 | 4.700 | 66.00 | 28.00 | 9085110047000 |
| 0.1874 | 3/16 | | 4.760 | 66.00 | 28.00 | 9085110047600 |
| 0.1890 | | 12 | 4.800 | 66.00 | 28.00 | 9085110048000 |
| 0.1929 | | | 4.900 | 66.00 | 28.00 | 9085110049000 |
| 0.1969 | | | 5.000 | 66.00 | 28.00 | 9085110050000 |
| 0.2008 | | | 5.100 | 66.00 | 28.00 | 9085110051000 |
| 0.2031 | 13/64 | | 5.160 | 66.00 | 28.00 | 9085110051600 |
| 0.2047 | | | 5.200 | 66.00 | 28.00 | 9085110052000 |
| 0.2087 | | | 5.300 | 66.00 | 28.00 | 9085110053000 |
| 0.2126 | | | 5.400 | 66.00 | 28.00 | 9085110054000 |
| 0.2165 | | | 5.500 | 66.00 | 28.00 | 9085110055000 |
| 0.2185 | | | 5.550 | 66.00 | 28.00 | 9085110055500 |
| 0.2189 | 7/32 | | 5.560 | 66.00 | 28.00 | 9085110055600 |
| 0.2205 | | | 5.600 | 66.00 | 28.00 | 9085110056000 |
| 0.2244 | | | 5.700 | 66.00 | 28.00 | 9085110057000 |
| 0.2283 | | | 5.800 | 66.00 | 28.00 | 9085110058000 |
| 0.2323 | | | 5.900 | 66.00 | 28.00 | 9085110059000 |
| 0.2343 | 15/64 | | 5.950 | 66.00 | 28.00 | 9085110059500 |
| 0.2362 | | | 6.000 | 66.00 | 28.00 | 9085110060000 |
| 0.2402 | | | 6.100 | 66.00 | 28.00 | 9085110061000 |
| 0.2441 | | | 6.200 | 66.00 | 28.00 | 9085110062000 |
| 0.2480 | | | 6.300 | 66.00 | 28.00 | 9085110063000 |
| 0.2500 | 1/4 | E | 6.350 | 66.00 | 28.00 | 9085110063500 |
| 0.2520 | | | 6.400 | 66.00 | 28.00 | 9085110064000 |
| 0.2559 | | | 6.500 | 66.00 | 28.00 | 9085110065000 |
| 0.2598 | | | 6.600 | 66.00 | 28.00 | 9085110066000 |
| 0.2638 | | | 6.700 | 66.00 | 28.00 | 9085110067000 |
| 0.2657 | 17/64 | H | 6.750 | 66.00 | 28.00 | 9085110067500 |
| 0.2677 | | | 6.800 | 66.00 | 28.00 | 9085110068000 |
| 0.2717 | | I | 6.900 | 66.00 | 28.00 | 9085110069000 |
| 0.2756 | | | 7.000 | 66.00 | 28.00 | 9085110070000 |

| Diameter (d1) | | | d2 mm | l1 mm | l2 mm | EDP # |
|---------------|----------------|------------------|----------|----------|----------|---------------|
| Dec. inch | Fract. inch | Wire / letter | | | | |
| 0.2795 | | | 7.100 | 91.00 | 53.00 | 9085110071000 |
| 0.2811 | 9/32 | K | 7.140 | 91.00 | 53.00 | 9085110071400 |
| 0.2835 | | | 7.200 | 91.00 | 53.00 | 9085110072000 |
| 0.2874 | | | 7.300 | 91.00 | 53.00 | 9085110073000 |
| 0.2913 | | | 7.400 | 91.00 | 53.00 | 9085110074000 |
| 0.2953 | | | 7.500 | 91.00 | 53.00 | 9085110075000 |
| 0.2969 | 19/64 | | 7.540 | 91.00 | 53.00 | 9085110075400 |
| 0.2992 | | | 7.600 | 91.00 | 53.00 | 9085110076000 |
| 0.3031 | | | 7.700 | 91.00 | 53.00 | 9085110077000 |
| 0.3071 | | | 7.800 | 91.00 | 53.00 | 9085110078000 |
| 0.3110 | | | 7.900 | 91.00 | 53.00 | 9085110079000 |
| 0.3126 | 5/16 | | 7.940 | 91.00 | 53.00 | 9085110079400 |
| 0.3150 | | | 8.000 | 91.00 | 53.00 | 9085110080000 |
| 0.3189 | | | 8.100 | 103.00 | 61.00 | 9085110081000 |
| 0.3228 | | P | 8.200 | 103.00 | 61.00 | 9085110082000 |
| 0.3268 | | | 8.300 | 103.00 | 61.00 | 9085110083000 |
| 0.3280 | 21/64 | | 8.330 | 103.00 | 61.00 | 9085110083300 |
| 0.3307 | | | 8.400 | 103.00 | 61.00 | 9085110084000 |
| 0.3346 | | | 8.500 | 103.00 | 61.00 | 9085110085000 |
| 0.3386 | | | 8.600 | 103.00 | 61.00 | 9085110086000 |
| 0.3425 | | | 8.700 | 103.00 | 61.00 | 9085110087000 |
| 0.3437 | 11/32 | | 8.730 | 103.00 | 61.00 | 9085110087300 |
| 0.3465 | | | 8.800 | 103.00 | 61.00 | 9085110088000 |
| 0.3504 | | | 8.900 | 103.00 | 61.00 | 9085110089000 |
| 0.3543 | | | 9.000 | 103.00 | 61.00 | 9085110090000 |
| 0.3583 | | | 9.100 | 103.00 | 61.00 | 9085110091000 |
| 0.3594 | 23/64 | | 9.130 | 103.00 | 61.00 | 9085110091300 |
| 0.3622 | | | 9.200 | 103.00 | 61.00 | 9085110092000 |
| 0.3642 | | | 9.250 | 103.00 | 61.00 | 9085110092500 |
| 0.3661 | | | 9.300 | 103.00 | 61.00 | 9085110093000 |
| 0.3701 | | | 9.400 | 103.00 | 61.00 | 9085110094000 |
| 0.3740 | | | 9.500 | 103.00 | 61.00 | 9085110095000 |
| 0.3748 | 3/8 | | 9.520 | 103.00 | 61.00 | 9085110095200 |
| 0.3780 | | | 9.600 | 103.00 | 61.00 | 9085110096000 |
| 0.3819 | | | 9.700 | 103.00 | 61.00 | 9085110097000 |
| 0.3858 | | W | 9.800 | 103.00 | 61.00 | 9085110098000 |
| 0.3898 | | | 9.900 | 103.00 | 61.00 | 9085110099000 |
| 0.3906 | 25/64 | | 9.920 | 103.00 | 61.00 | 9085110099200 |
| 0.3937 | | | 10.000 | 103.00 | 61.00 | 9085110100000 |
| 0.3976 | | | 10.100 | 118.00 | 71.00 | 9085110101000 |
| 0.4016 | | | 10.200 | 118.00 | 71.00 | 9085110102000 |
| 0.4055 | | | 10.300 | 118.00 | 71.00 | 9085110103000 |
| 0.4063 | 13/32 | | 10.320 | 118.00 | 71.00 | 9085110103200 |
| 0.4094 | | | 10.400 | 118.00 | 71.00 | 9085110104000 |
| 0.4134 | | | 10.500 | 118.00 | 71.00 | 9085110105000 |
| 0.4173 | | | 10.600 | 118.00 | 71.00 | 9085110106000 |
| 0.4213 | | | 10.700 | 118.00 | 71.00 | 9085110107000 |
| 0.4252 | | | 10.800 | 118.00 | 71.00 | 9085110108000 |
| 0.4291 | | | 10.900 | 118.00 | 71.00 | 9085110109000 |
| 0.4331 | | | 11.000 | 118.00 | 71.00 | 9085110110000 |
| 0.4370 | | | 11.100 | 118.00 | 71.00 | 9085110111000 |
| 0.4374 | 7/16 | | 11.110 | 118.00 | 71.00 | 9085110111100 |
| 0.4409 | | | 11.200 | 118.00 | 71.00 | 9085110112000 |
| 0.4449 | | | 11.300 | 118.00 | 71.00 | 9085110113000 |

*Items listed in red are non-stocked items, and may take 2 - 6 weeks to receive

Series 8511

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| Diameter (d1) | | | | | | | |
|---------------|-------------|---------------|--------|--------|--------|-------|---------------|
| Dec. inch | Fract. inch | Wire / letter | d2 mm | l1 mm | l2 mm | EDP # | |
| 0.4488 | | | 11.400 | 12.000 | 118.00 | 71.00 | 9085110114000 |
| 0.4528 | | | 11.500 | 12.000 | 118.00 | 71.00 | 9085110115000 |
| 0.4567 | | | 11.600 | 12.000 | 118.00 | 71.00 | 9085110116000 |
| 0.4606 | | | 11.700 | 12.000 | 118.00 | 71.00 | 9085110117000 |
| 0.4646 | | | 11.800 | 12.000 | 118.00 | 71.00 | 9085110118000 |
| 0.4685 | | | 11.900 | 12.000 | 118.00 | 71.00 | 9085110119000 |
| 0.4689 | 15/32 | | 11.910 | 12.000 | 118.00 | 71.00 | 9085110119100 |
| 0.4724 | | | 12.000 | 12.000 | 118.00 | 71.00 | 9085110120000 |
| 0.4803 | | | 12.200 | 14.000 | 124.00 | 77.00 | 9085110122000 |
| 0.4921 | | | 12.500 | 14.000 | 124.00 | 77.00 | 9085110125000 |
| 0.5000 | 1/2 | | 12.700 | 14.000 | 124.00 | 77.00 | 9085110127000 |
| 0.5039 | | | 12.800 | 14.000 | 124.00 | 77.00 | 9085110128000 |
| 0.5118 | | | 13.000 | 14.000 | 124.00 | 77.00 | 9085110130000 |
| 0.5236 | | | 13.300 | 14.000 | 124.00 | 77.00 | 9085110133000 |
| 0.5315 | | | 13.500 | 14.000 | 124.00 | 77.00 | 9085110135000 |
| 0.5394 | | | 13.700 | 14.000 | 124.00 | 77.00 | 9085110137000 |
| 0.5512 | | | 14.000 | 14.000 | 124.00 | 77.00 | 9085110140000 |
| 0.5591 | | | 14.200 | 16.000 | 133.00 | 83.00 | 9085110142000 |
| 0.5626 | 9/16 | | 14.290 | 16.000 | 133.00 | 83.00 | 9085110142900 |
| 0.5630 | | | 14.300 | 16.000 | 133.00 | 83.00 | 9085110143000 |
| 0.5709 | | | 14.500 | 16.000 | 133.00 | 83.00 | 9085110145000 |
| 0.5787 | | | 14.700 | 16.000 | 133.00 | 83.00 | 9085110147000 |
| 0.5906 | | | 15.000 | 16.000 | 133.00 | 83.00 | 9085110150000 |
| 0.5984 | | | 15.200 | 16.000 | 133.00 | 83.00 | 9085110152000 |

| Diameter (d1) | | | | | | | |
|---------------|-------------|---------------|--------|--------|--------|--------|---------------|
| Dec. inch | Fract. inch | Wire / letter | d2 mm | l1 mm | l2 mm | EDP # | |
| 0.6024 | | | 15.300 | 16.000 | 133.00 | 83.00 | 9085110153000 |
| 0.6102 | | | 15.500 | 16.000 | 133.00 | 83.00 | 9085110155000 |
| 0.6181 | | | 15.700 | 16.000 | 133.00 | 83.00 | 9085110157000 |
| 0.6299 | | | 16.000 | 16.000 | 133.00 | 83.00 | 9085110160000 |
| 0.6417 | | | 16.300 | 18.000 | 143.00 | 93.00 | 9085110163000 |
| 0.6496 | | | 16.500 | 18.000 | 143.00 | 93.00 | 9085110165000 |
| 0.6654 | | | 16.900 | 18.000 | 143.00 | 93.00 | 9085110169000 |
| 0.6693 | | | 17.000 | 18.000 | 143.00 | 93.00 | 9085110170000 |
| 0.6811 | | | 17.300 | 18.000 | 143.00 | 93.00 | 9085110173000 |
| 0.6890 | | | 17.500 | 18.000 | 143.00 | 93.00 | 9085110175000 |
| 0.7087 | | | 18.000 | 18.000 | 143.00 | 93.00 | 9085110180000 |
| 0.7283 | | | 18.500 | 20.000 | 153.00 | 101.00 | 9085110185000 |
| 0.7441 | | | 18.900 | 20.000 | 153.00 | 101.00 | 9085110189000 |
| 0.7480 | | | 19.000 | 20.000 | 153.00 | 101.00 | 9085110190000 |
| 0.7500 | 3/4 | | 19.050 | 20.000 | 153.00 | 101.00 | 9085110190500 |
| 0.7598 | | | 19.300 | 20.000 | 153.00 | 101.00 | 9085110193000 |
| 0.7677 | | | 19.500 | 20.000 | 153.00 | 101.00 | 9085110195000 |
| 0.7874 | | | 20.000 | 20.000 | 153.00 | 101.00 | 9085110200000 |

Alternative Drill Series:

- #5511 Carbide, RT100, 5xD, 140 U pt, FIREX®
- #2479 Carbide, RT100, 5xD, 140 U pt, nano-FIREX®
- #1662, Carbide, RT100, 5xD, 140 F pt, TiN