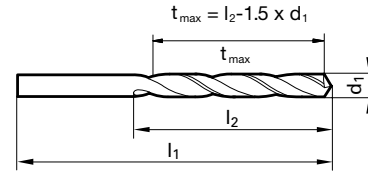




- P** Steel ● web thinning  $\geq \varnothing 1.950$  • relieved cone • wide flutes • for extremely deep holes • in case of unsatisfactory chip evacuation
  - M** Stainless steel ○
  - K** Cast iron ● cast iron and steels up to 1000 N/mm<sup>2</sup> • Not recommended for: CrNi steels, stainless steels
  - N** Aluminum ●
  - S** Titanium alloys ○
  - H** Hardened steel ○
- =Optimal  
○=Limited



Speeds and feeds information on pg. 514

Shank diameter = cut diameter

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr mm				
0.0768	1.95	125.00	82.08	85.00	9005020019500
0.0787	2.00	125.00	82.00	85.00	9005020020000
0.0807	2.05	125.00	81.93	85.00	9005020020500
0.0827	2.10	125.00	81.85	85.00	9005020021000
0.0866	2.20	135.00	86.70	90.00	9005020022000
0.0906	2.30	135.00	86.55	90.00	9005020023000
0.0933	#42 2.37	140.00	91.45	95.00	9005020023700
0.0937	3/32 2.38	140.00	91.43	95.00	9005020023800
0.0945	2.40	140.00	91.40	95.00	9005020024000
0.0984	2.50	140.00	91.25	95.00	9005020025000
0.1004	2.55	140.00	91.18	95.00	9005020025500
0.1016	#38 2.58	140.00	91.13	95.00	9005020025800
0.1024	2.60	140.00	91.10	95.00	9005020026000
0.1063	2.70	150.00	95.95	100.00	9005020027000
0.1094	7/64 2.78	150.00	95.83	100.00	9005020027800
0.1102	2.80	150.00	95.80	100.00	9005020028000
0.1122	2.85	150.00	95.73	100.00	9005020028500
0.1130	#33 2.87	150.00	95.70	100.00	9005020028700
0.1142	2.90	150.00	95.65	100.00	9005020029000
0.1161	#32 2.95	150.00	95.58	100.00	9005020029500
0.1181	3.00	150.00	95.50	100.00	9005020030000
0.1193	3.03	155.00	100.46	105.00	9005020030300
0.1220	3.10	155.00	100.35	105.00	9005020031000
0.1248	1/8 3.17	155.00	100.25	105.00	9005020031700
0.1260	3.20	155.00	100.20	105.00	9005020032000
0.1280	3.25	155.00	100.13	105.00	9005020032500
0.1299	3.30	155.00	100.05	105.00	9005020033000
0.1339	3.40	165.00	109.90	115.00	9005020034000
0.1378	3.50	165.00	109.75	115.00	9005020035000
0.1406	9/64 #28 3.57	165.00	109.65	115.00	9005020035700
0.1417	3.60	165.00	109.60	115.00	9005020036000
0.1457	3.70	165.00	109.45	115.00	9005020037000
0.1476	3.75	165.00	109.38	115.00	9005020037500
0.1496	#25 3.80	175.00	114.30	120.00	9005020038000
0.1520	#24 3.86	175.00	114.21	120.00	9005020038600
0.1535	3.90	175.00	114.15	120.00	9005020039000
0.1563	5/32 3.97	175.00	114.05	120.00	9005020039700
0.1575	4.00	175.00	114.00	120.00	9005020040000
0.1614	4.10	175.00	113.85	120.00	9005020041000
0.1654	4.20	175.00	113.70	120.00	9005020042000
0.1693	#18 4.30	185.00	118.55	125.00	9005020043000

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr mm	mm				
0.1720	11/64	4.37	185.00	118.45	125.00	9005020043700
0.1732		4.40	185.00	118.40	125.00	9005020044000
0.1772	#16	4.50	185.00	118.25	125.00	9005020045000
0.1799	#15	4.57	185.00	118.15	125.00	9005020045700
0.1811		4.60	185.00	118.10	125.00	9005020046000
0.1850	#13	4.70	185.00	117.95	125.00	9005020047000
0.1874	3/16 #12	4.76	195.00	127.86	135.00	9005020047600
0.1890	#12	4.80	195.00	127.80	135.00	9005020048000
0.1929		4.90	195.00	127.65	135.00	9005020049000
0.1969		5.00	195.00	127.50	135.00	9005020050000
0.2008		5.10	195.00	127.35	135.00	9005020051000
0.2012	#7	5.11	195.00	127.34	135.00	9005020051100
0.2031	13/64	5.16	195.00	127.26	135.00	9005020051600
0.2047		5.20	195.00	127.20	135.00	9005020052000
0.2087		5.30	195.00	127.05	135.00	9005020053000
0.2126		5.40	205.00	131.90	140.00	9005020054000
0.2165		5.50	205.00	131.75	140.00	9005020055000
0.2189	7/32	5.56	205.00	131.66	140.00	9005020055600
0.2205		5.60	205.00	131.60	140.00	9005020056000
0.2244		5.70	205.00	131.45	140.00	9005020057000
0.2264		5.75	205.00	131.38	140.00	9005020057500
0.2283		5.80	205.00	131.30	140.00	9005020058000
0.2323		5.90	205.00	131.15	140.00	9005020059000
0.2343	15/64	5.95	205.00	131.08	140.00	9005020059500
0.2362		6.00	205.00	131.00	140.00	9005020060000
0.2382		6.05	215.00	140.93	150.00	9005020060500
0.2402		6.10	215.00	140.85	150.00	9005020061000
0.2441		6.20	215.00	140.70	150.00	9005020062000
0.2461	D	6.25	215.00	140.63	150.00	9005020062500
0.2480		6.30	215.00	140.55	150.00	9005020063000
0.2500	1/4 E	6.35	215.00	140.48	150.00	9005020063500
0.2520		6.40	215.00	140.40	150.00	9005020064000
0.2559		6.50	215.00	140.25	150.00	9005020065000
0.2598		6.60	215.00	140.10	150.00	9005020066000
0.2638		6.70	215.00	139.95	150.00	9005020067000
0.2657	17/64 H	6.75	225.00	144.88	155.00	9005020067500
0.2677		6.80	225.00	144.80	155.00	9005020068000
0.2717	I	6.90	225.00	144.65	155.00	9005020069000
0.2756		7.00	225.00	144.50	155.00	9005020070000
0.2795		7.10	225.00	144.35	155.00	9005020071000
0.2835		7.20	225.00	144.20	155.00	9005020072000

Extra Length Drills

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.2874		7.30	225.00	144.05	155.00	9005020073000
0.2913		7.40	225.00	143.90	155.00	9005020074000
0.2953		7.50	225.00	143.75	155.00	9005020075000
0.2969	19/64	7.54	240.00	153.69	165.00	9005020075400
0.2992		7.60	240.00	153.60	165.00	9005020076000
0.3031		7.70	240.00	153.45	165.00	9005020077000
0.3051		7.75	240.00	153.38	165.00	9005020077500
0.3071		7.80	240.00	153.30	165.00	9005020078000
0.3110		7.90	240.00	153.15	165.00	9005020079000
0.3126	5/16	7.94	240.00	153.09	165.00	9005020079400
0.3150		8.00	240.00	153.00	165.00	9005020080000
0.3189		8.10	240.00	152.85	165.00	9005020081000
0.3228	P	8.20	240.00	152.70	165.00	9005020082000
0.3268		8.30	240.00	152.55	165.00	9005020083000
0.3280	21/64	8.33	240.00	152.51	165.00	9005020083300
0.3307		8.40	240.00	152.40	165.00	9005020084000
0.3319	Q	8.43	240.00	152.36	165.00	9005020084300
0.3346		8.50	240.00	152.25	165.00	9005020085000
0.3386		8.60	250.00	162.10	175.00	9005020086000
0.3425		8.70	250.00	161.95	175.00	9005020087000
0.3437	11/32	8.73	250.00	161.91	175.00	9005020087300
0.3465		8.80	250.00	161.80	175.00	9005020088000
0.3543		9.00	250.00	161.50	175.00	9005020090000
0.3622		9.20	250.00	161.20	175.00	9005020092000

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.3661		9.30	250.00	161.05	175.00	9005020093000
0.3701		9.40	250.00	160.90	175.00	9005020094000
0.3740		9.50	250.00	160.75	175.00	9005020095000
0.3748	3/8	9.52	265.00	170.72	185.00	9005020095200
0.3780		9.60	265.00	170.60	185.00	9005020096000
0.3819		9.70	265.00	170.45	185.00	9005020097000
0.3858	W	9.80	265.00	170.30	185.00	9005020098000
0.3898		9.90	265.00	170.15	185.00	9005020099000
0.3906	25/64	9.92	265.00	170.12	185.00	9005020099200
0.3937		10.00	265.00	170.00	185.00	9005020100000
0.4016		10.20	265.00	169.70	185.00	9005020102000
0.4063	13/32	10.32	265.00	169.52	185.00	9005020103200
0.4134		10.50	265.00	169.25	185.00	9005020105000
0.4220	27/64	10.72	280.00	178.92	195.00	9005020107200
0.4331		11.00	280.00	178.50	195.00	9005020110000
0.4374	7/16	11.11	280.00	178.34	195.00	9005020111100
0.4409		11.20	280.00	178.20	195.00	9005020112000
0.4528		11.50	280.00	177.75	195.00	9005020115000
0.4531	29/64	11.51	280.00	177.74	195.00	9005020115100
0.4646		11.80	280.00	177.30	195.00	9005020118000
0.4724		12.00	295.00	187.00	205.00	9005020120000
0.4921		12.50	295.00	186.25	205.00	9005020125000
0.5000	1/2	12.70	295.00	185.95	205.00	9005020127000
0.5118		13.00	295.00	185.50	205.00	9005020130000