



Tool material

Solid Carbide

Surface



P Steel web thinning $\geq \varnothing 3.000$ • relieved cone • close diameter tolerances • very good surface quality of hole • observe coolant pressure • double margin

M Stainless steel

K Cast iron

N Aluminum

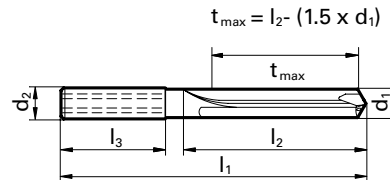
S Titanium alloys

H Hardened steel

aluminum and Al-alloys • Al materials with high Si-content

●=Optimal

○=Limited



Speeds and feeds information on pg. 544

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.1181		3.00	6.00	66.00	19.50	24.00	9007680030000
0.1220		3.10	6.00	66.00	19.35	24.00	9007680031000
0.1260		3.20	6.00	66.00	19.20	24.00	9007680032000
0.1299		3.30	6.00	66.00	19.05	24.00	9007680033000
0.1339		3.40	6.00	66.00	18.90	24.00	9007680034000
0.1378		3.50	6.00	66.00	18.75	24.00	9007680035000
0.1417		3.60	6.00	66.00	18.60	24.00	9007680036000
0.1457		3.70	6.00	66.00	18.45	24.00	9007680037000
0.1496	#25	3.80	6.00	74.00	24.30	30.00	9007680038000
0.1535		3.90	6.00	74.00	24.15	30.00	9007680039000
0.1575		4.00	6.00	74.00	24.00	30.00	9007680040000
0.1614		4.10	6.00	74.00	23.85	30.00	9007680041000
0.1654		4.20	6.00	74.00	23.70	30.00	9007680042000
0.1693	#18	4.30	6.00	74.00	23.55	30.00	9007680043000
0.1732		4.40	6.00	74.00	23.40	30.00	9007680044000
0.1772	#16	4.50	6.00	74.00	23.25	30.00	9007680045000
0.1811		4.60	6.00	74.00	23.10	30.00	9007680046000
0.1850	#13	4.70	6.00	74.00	22.95	30.00	9007680047000
0.1890	#12	4.80	6.00	74.00	22.80	36.00	9007680048000
0.1929		4.90	6.00	74.00	22.65	36.00	9007680049000
0.1969		5.00	6.00	74.00	22.50	36.00	9007680050000
0.2008		5.10	6.00	74.00	22.35	36.00	9007680051000
0.2031	13/64	5.16	6.00	74.00	22.26	36.00	9007680051600
0.2047		5.20	6.00	74.00	22.20	36.00	9007680052000
0.2087		5.30	6.00	74.00	22.05	36.00	9007680053000
0.2126		5.40	6.00	74.00	21.90	36.00	9007680054000
0.2165		5.50	6.00	74.00	21.75	36.00	9007680055000
0.2189	7/32	5.56	6.00	74.00	21.66	36.00	9007680055600
0.2205		5.60	6.00	74.00	21.60	36.00	9007680056000
0.2244		5.70	6.00	74.00	21.45	36.00	9007680057000
0.2283		5.80	6.00	74.00	21.30	36.00	9007680058000
0.2323		5.90	6.00	74.00	21.15	36.00	9007680059000
0.2343	15/64	5.95	6.00	74.00	21.08	36.00	9007680059500
0.2362		6.00	6.00	74.00	21.00	36.00	9007680060000
0.2402		6.10	8.00	91.00	43.85	53.00	9007680061000
0.2441		6.20	8.00	91.00	43.70	53.00	9007680062000
0.2480		6.30	8.00	91.00	43.55	53.00	9007680063000
0.2500	1/4 E	6.35	8.00	91.00	43.48	53.00	9007680063500
0.2520		6.40	8.00	91.00	43.40	53.00	9007680064000
0.2559		6.50	8.00	91.00	43.25	53.00	9007680065000
0.2598		6.60	8.00	91.00	43.10	53.00	9007680066000
0.2638		6.70	8.00	91.00	42.95	53.00	9007680067000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.2657	17/64 H	6.75	8.00	91.00	42.88	53.00	9007680067500
0.2677		6.80	8.00	91.00	42.80	53.00	9007680068000
0.2717	I	6.90	8.00	91.00	42.65	53.00	9007680069000
0.2756		7.00	8.00	91.00	42.50	53.00	9007680070000
0.2795		7.10	8.00	91.00	42.35	53.00	9007680071000
0.2811	9/32 K	7.14	8.00	91.00	42.29	53.00	9007680071400
0.2835		7.20	8.00	91.00	42.20	53.00	9007680072000
0.2874		7.30	8.00	91.00	42.05	53.00	9007680073000
0.2913		7.40	8.00	91.00	41.90	53.00	9007680074000
0.2953		7.50	8.00	91.00	41.75	53.00	9007680075000
0.2969	19/64	7.54	8.00	91.00	41.69	53.00	9007680075400
0.2992		7.60	8.00	91.00	41.60	53.00	9007680076000
0.3031		7.70	8.00	91.00	41.45	53.00	9007680077000
0.3071		7.80	8.00	91.00	41.30	53.00	9007680078000
0.3110		7.90	8.00	91.00	41.15	53.00	9007680079000
0.3126	5/16	7.94	8.00	91.00	41.09	53.00	9007680079400
0.3150		8.00	8.00	91.00	41.00	53.00	9007680080000
0.3189		8.10	10.00	103.00	48.85	61.00	9007680081000
0.3228	P	8.20	10.00	103.00	48.70	61.00	9007680082000
0.3268		8.30	10.00	103.00	48.55	61.00	9007680083000
0.3280	21/64	8.33	10.00	103.00	48.51	61.00	9007680083300
0.3307		8.40	10.00	103.00	48.40	61.00	9007680084000
0.3346		8.50	10.00	103.00	48.25	61.00	9007680085000
0.3386		8.60	10.00	103.00	48.10	61.00	9007680086000
0.3425		8.70	10.00	103.00	47.95	61.00	9007680087000
0.3437	11/32	8.73	10.00	103.00	47.91	61.00	9007680087300
0.3465		8.80	10.00	103.00	47.80	61.00	9007680088000
0.3504		8.90	10.00	103.00	47.65	61.00	9007680089000
0.3543		9.00	10.00	103.00	47.50	61.00	9007680090000
0.3583		9.10	10.00	103.00	47.35	61.00	9007680091000
0.3594	23/64	9.13	10.00	103.00	47.31	61.00	9007680091300
0.3622		9.20	10.00	103.00	47.20	61.00	9007680092000
0.3661		9.30	10.00	103.00	47.05	61.00	9007680093000
0.3701		9.40	10.00	103.00	46.90	61.00	9007680094000
0.3740		9.50	10.00	103.00	46.75	61.00	9007680095000
0.3748	3/8	9.52	10.00	103.00	46.72	61.00	9007680095200
0.3780		9.60	10.00	103.00	46.60	61.00	9007680096000
0.3819		9.70	10.00	103.00	46.45	61.00	9007680097000
0.3858	W	9.80	10.00	103.00	46.30	61.00	9007680098000
0.3898		9.90	10.00	103.00	46.15	61.00	9007680099000
0.3906	25/64	9.92	10.00	103.00	46.12	61.00	9007680099200
0.3937		10.00	10.00	103.00	46.00	61.00	9007680100000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.4016		10.20	12.00	118.00	55.70	71.00	9007680102000
0.4063	13/32	10.32	12.00	118.00	55.52	71.00	9007680103200
0.4134		10.50	12.00	118.00	55.25	71.00	9007680105000
0.4220	27/64	10.72	12.00	118.00	54.92	71.00	9007680107200
0.4331		11.00	12.00	118.00	54.50	71.00	9007680110000
0.4374	7/16	11.11	12.00	118.00	54.34	71.00	9007680111100
0.4409		11.20	12.00	118.00	54.20	71.00	9007680112000
0.4528		11.50	12.00	118.00	53.75	71.00	9007680115000
0.4531	29/64	11.51	12.00	118.00	53.74	71.00	9007680115100
0.4689	15/32	11.91	12.00	118.00	53.14	71.00	9007680119100
0.4724		12.00	12.00	118.00	53.00	71.00	9007680120000
0.4843	31/64	12.30	14.00	124.00	55.55	74.00	9007680123000
0.4921		12.50	14.00	124.00	55.25	74.00	9007680125000
0.5000	1/2	12.70	14.00	124.00	54.95	74.00	9007680127000
0.5118		13.00	14.00	124.00	54.50	74.00	9007680130000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.5315		13.50	14.00	124.00	53.75	74.00	9007680135000
0.5512		14.00	14.00	124.00	53.00	74.00	9007680140000
0.5709		14.50	16.00	133.00	61.25	83.00	9007680145000
0.5906		15.00	16.00	133.00	60.50	83.00	9007680150000
0.6102		15.50	16.00	133.00	59.75	83.00	9007680155000
0.6299		16.00	16.00	133.00	59.00	83.00	9007680160000
0.6496		16.50	18.00	143.00	68.25	93.00	9007680165000
0.6693		17.00	18.00	143.00	67.50	93.00	9007680170000
0.6890		17.50	18.00	143.00	66.75	93.00	9007680175000
0.7087		18.00	18.00	143.00	66.00	93.00	9007680180000
0.7283		18.50	20.00	153.00	73.25	101.00	9007680185000
0.7480		19.00	20.00	153.00	72.50	101.00	9007680190000
0.7677		19.50	20.00	153.00	71.75	101.00	9007680195000
0.7874		20.00	20.00	153.00	71.00	101.00	9007680200000