



Cutting depth Type Point angle Tolerance on Ø Internal coolant Shank form Cutting direction

Tool material

Solid Carbide

Surface



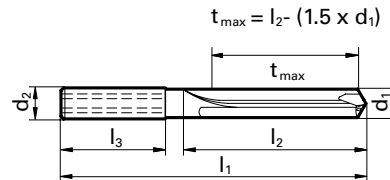
P	Steel
M	Stainless steel
K	Cast iron
N	Aluminum
S	Titanium alloys
H	Hardened steel

●=Optimal

○=Limited

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

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



Speeds and feeds information on pg. 545

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.1181		3.00	6.00	74.00	27.50	32.00	9007690030000
0.1220		3.10	6.00	74.00	27.35	32.00	9007690031000
0.1260		3.20	6.00	74.00	27.20	32.00	9007690032000
0.1299		3.30	6.00	74.00	27.05	32.00	9007690033000
0.1339		3.40	6.00	74.00	28.90	34.00	9007690034000
0.1378		3.50	6.00	74.00	28.75	34.00	9007690035000
0.1417		3.60	6.00	74.00	28.60	34.00	9007690036000
0.1457		3.70	6.00	74.00	28.45	34.00	9007690037000
0.1496	#25	3.80	6.00	97.00	39.30	45.00	9007690038000
0.1535		3.90	6.00	97.00	39.15	45.00	9007690039000
0.1575		4.00	6.00	97.00	39.00	45.00	9007690040000
0.1614		4.10	6.00	97.00	38.85	45.00	9007690041000
0.1654		4.20	6.00	97.00	38.70	45.00	9007690042000
0.1693	#18	4.30	6.00	97.00	38.55	45.00	9007690043000
0.1732		4.40	6.00	97.00	38.40	45.00	9007690044000
0.1772	#16	4.50	6.00	97.00	38.25	45.00	9007690045000
0.1850	#13	4.70	6.00	97.00	37.95	45.00	9007690047000
0.1890	#12	4.80	6.00	97.00	49.80	57.00	9007690048000
0.1929		4.90	6.00	97.00	49.65	57.00	9007690049000
0.1969		5.00	6.00	97.00	49.50	57.00	9007690050000
0.2031	13/64	5.16	6.00	97.00	49.26	57.00	9007690051600
0.2165		5.50	6.00	97.00	48.75	57.00	9007690055000
0.2362		6.00	6.00	97.00	48.00	57.00	9007690060000
0.2500	1/4 E	6.35	8.00	116.00	66.48	76.00	9007690063500
0.2559		6.50	8.00	116.00	66.25	76.00	9007690065000
0.2677		6.80	8.00	116.00	65.80	76.00	9007690068000
0.2756		7.00	8.00	116.00	65.50	76.00	9007690070000
0.2811	9/32 K	7.14	8.00	116.00	65.29	76.00	9007690071400
0.2953		7.50	8.00	116.00	64.75	76.00	9007690075000
0.3071		7.80	8.00	116.00	64.30	76.00	9007690078000
0.3126	5/16	7.94	8.00	116.00	64.09	76.00	9007690079400
0.3150		8.00	8.00	116.00	64.00	76.00	9007690080000
0.3280	21/64	8.33	10.00	139.00	82.51	95.00	9007690083300
0.3346		8.50	10.00	139.00	82.25	95.00	9007690085000

Diameter (d1)			d2	l1	t _{max}	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.3437	11/32	8.73	10.00	139.00	81.91	95.00	9007690087300
0.3543		9.00	10.00	139.00	81.50	95.00	9007690090000
0.3594	23/64	9.13	10.00	139.00	81.31	95.00	9007690091300
0.3740		9.50	10.00	139.00	80.75	95.00	9007690095000
0.3748	3/8	9.52	10.00	139.00	80.72	95.00	9007690095200
0.3937		10.00	10.00	139.00	80.00	95.00	9007690100000
0.4016		10.20	12.00	163.00	98.70	114.00	9007690102000
0.4063	13/32	10.32	12.00	163.00	98.52	114.00	9007690103200
0.4134		10.50	12.00	163.00	98.25	114.00	9007690105000
0.4220	27/64	10.72	12.00	163.00	97.92	114.00	9007690107200
0.4331		11.00	12.00	163.00	97.50	114.00	9007690110000
0.4374	7/16	11.11	12.00	163.00	97.34	114.00	9007690111100
0.4528		11.50	12.00	163.00	96.75	114.00	9007690115000
0.4531	29/64	11.51	12.00	163.00	96.74	114.00	9007690115100
0.4724		12.00	12.00	163.00	96.00	114.00	9007690120000
0.4843	31/64	12.30	14.00	182.00	114.55	133.00	9007690123000
0.4921		12.50	14.00	182.00	114.25	133.00	9007690125000
0.5000	1/2	12.70	14.00	182.00	113.95	133.00	9007690127000
0.5118		13.00	14.00	182.00	113.50	133.00	9007690130000
0.5315		13.50	14.00	182.00	112.75	133.00	9007690135000
0.5512		14.00	14.00	182.00	112.00	133.00	9007690140000
0.5709		14.50	16.00	204.00	130.25	152.00	9007690145000
0.5906		15.00	16.00	204.00	129.50	152.00	9007690150000
0.6102		15.50	16.00	204.00	128.75	152.00	9007690155000
0.6299		16.00	16.00	204.00	128.00	152.00	9007690160000
0.6496		16.50	18.00	223.00	146.25	171.00	9007690165000
0.6693		17.00	18.00	223.00	145.50	171.00	9007690170000
0.6890		17.50	18.00	223.00	144.75	171.00	9007690175000
0.7087		18.00	18.00	223.00	144.00	171.00	9007690180000
0.7283		18.50	20.00	244.00	162.25	190.00	9007690185000
0.7480		19.00	20.00	244.00	161.50	190.00	9007690190000
0.7677		19.50	20.00	244.00	160.75	190.00	9007690195000
0.7874		20.00	20.00	244.00	160.00	190.00	9007690200000