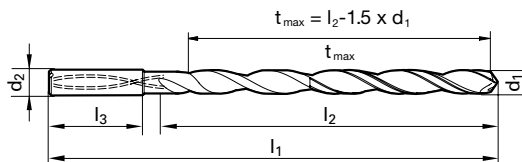


Tool material **Solid Carbide**

Surface **A**

- P** Steel ● double margin • web thinning  $\geq \varnothing 3.000$  • relieved cone • main cutting edge form concave • optimized flute design • maximum diameter of coolant ducts • observe coolant pressure
  - M** Stainless steel ●
  - K** Cast iron ● structural and case hardened steels • free-cutting steels, heat-treatable steels • alloyed steels up to 1200 N/mm<sup>2</sup> • stainless steels • cast materials
  - N** Aluminum ○
  - S** Titanium alloys ○
  - H** Hardened steel ○
- =Optimal  
○=Limited



See page 456 for technical operation info  
Speeds and feeds information on pg. 588

Diameter (d1)			d2	l1	t <sub>max</sub>	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.1181		3.000	6.00	95.00	50.50	55.00	9065090030000
0.1220		3.100	6.00	106.00	62.35	67.00	9065090031000
0.1248	1/8	3.170	6.00	106.00	62.25	67.00	9065090031700
0.1260		3.200	6.00	106.00	62.20	67.00	9065090032000
0.1299		3.300	6.00	106.00	62.05	67.00	9065090033000
0.1378		3.500	6.00	116.00	70.75	76.00	9065090035000
0.1406	9/64 #28	3.570	6.00	116.00	70.65	76.00	9065090035700
0.1457		3.700	6.00	116.00	70.45	76.00	9065090037000
0.1496		3.800	6.00	116.00	70.30	76.00	9065090038000
0.1563	5/32	3.970	6.00	116.00	70.05	76.00	9065090039700
0.1575		4.000	6.00	116.00	70.00	76.00	9065090040000
0.1654		4.200	6.00	133.00	86.70	93.00	9065090042000
0.1693		4.300	6.00	133.00	86.55	93.00	9065090043000
0.1720	11/64	4.370	6.00	133.00	86.45	93.00	9065090043700
0.1772		4.500	6.00	133.00	86.25	93.00	9065090045000
0.1811		4.600	6.00	133.00	86.10	93.00	9065090046000
0.1874	3/16	4.760	6.00	133.00	85.86	93.00	9065090047600
0.1890	#12	4.800	6.00	133.00	85.80	93.00	9065090048000
0.1969		5.000	6.00	133.00	85.50	93.00	9065090050000
0.2008		5.100	6.00	150.00	102.35	110.00	9065090051000
0.2031	13/64	5.160	6.00	150.00	102.26	110.00	9065090051600
0.2130		5.410	6.00	150.00	101.89	110.00	9065090054100
0.2165		5.500	6.00	150.00	101.75	110.00	9065090055000
0.2189	7/32	5.560	6.00	150.00	101.66	110.00	9065090055600
0.2205		5.600	6.00	150.00	101.60	110.00	9065090056000
0.2283		5.800	6.00	150.00	101.30	110.00	9065090058000
0.2343	15/64	5.950	6.00	150.00	101.08	110.00	9065090059500
0.2362		6.000	6.00	150.00	101.00	110.00	9065090060000
0.2480		6.300	8.00	167.00	117.55	127.00	9065090063000
0.2500	1/4 E	6.350	8.00	167.00	117.48	127.00	9065090063500
0.2559		6.500	8.00	167.00	117.25	127.00	9065090065000
0.2657	17/64 H	6.750	8.00	167.00	116.88	127.00	9065090067500
0.2677		6.800	8.00	167.00	116.80	127.00	9065090068000
0.2756		7.000	8.00	167.00	116.50	127.00	9065090070000
0.2811	9/32 K	7.140	8.00	183.00	132.29	143.00	9065090071400
0.2953		7.500	8.00	183.00	131.75	143.00	9065090075000
0.2969	19/64	7.540	8.00	183.00	131.69	143.00	9065090075400

Diameter (d1)			d2	l1	t <sub>max</sub>	l2	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.3071		7.800	8.00	183.00	131.30	143.00	9065090078000
0.3126	5/16	7.940	8.00	183.00	131.09	143.00	9065090079400
0.3150		8.000	8.00	183.00	131.00	143.00	9065090080000
0.3280	21/64	8.330	10.00	204.00	147.51	160.00	9065090083300
0.3346		8.500	10.00	204.00	147.25	160.00	9065090085000
0.3437	11/32	8.730	10.00	204.00	146.91	160.00	9065090087300
0.3465		8.800	10.00	204.00	146.80	160.00	9065090088000
0.3543		9.000	10.00	204.00	146.50	160.00	9065090090000
0.3594	23/64	9.130	10.00	221.00	163.31	177.00	9065090091300
0.3740		9.500	10.00	221.00	162.75	177.00	9065090095000
0.3748	3/8	9.520	10.00	221.00	162.72	177.00	9065090095200
0.3858		9.800	10.00	221.00	162.30	177.00	9065090098000
0.3906	25/64	9.920	10.00	221.00	162.12	177.00	9065090099200
0.3937		10.000	10.00	221.00	162.00	177.00	9065090100000
0.4016		10.200	12.00	247.00	182.70	198.00	9065090102000
0.4063	13/32	10.320	12.00	247.00	182.52	198.00	9065090103200
0.4134		10.500	12.00	247.00	182.25	198.00	9065090105000
0.4220	27/64	10.720	12.00	247.00	181.92	198.00	9065090107200
0.4331		11.000	12.00	247.00	181.50	198.00	9065090110000
0.4374	7/16	11.110	12.00	263.00	197.34	214.00	9065090111100
0.4531	29/64	11.510	12.00	263.00	196.74	214.00	9065090115100
0.4646		11.800	12.00	263.00	196.30	214.00	9065090118000
0.4689	15/32	11.910	12.00	263.00	196.14	214.00	9065090119100
0.4724		12.000	12.00	263.00	196.00	214.00	9065090120000
0.4843	31/64	12.300	14.00	297.00	229.55	248.00	9065090123000
0.4921		12.500	14.00	297.00	229.25	248.00	9065090125000
0.5000	1/2	12.700	14.00	297.00	228.95	248.00	9065090127000
0.5118		13.000	14.00	297.00	228.50	248.00	9065090130000
0.5157	33/64	13.100	14.00	297.00	228.35	248.00	9065090131000
0.5311	17/32	13.490	14.00	297.00	227.77	248.00	9065090134900
0.5469	35/64	13.890	14.00	297.00	227.17	248.00	9065090138900
0.5512		14.000	14.00	297.00	227.00	248.00	9065090140000
0.5626	0.5625	14.290	16.00	333.00	259.57	281.00	9065090142900
0.5906		15.000	16.00	333.00	258.50	281.00	9065090150000
0.6248	0.625	15.870	16.00	333.00	257.20	281.00	9065090158700
0.6299		16.000	16.00	333.00	257.00	281.00	9065090160000