



Tool material

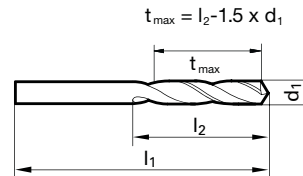
**HSS**

Surface



<b>P</b>	Steel	●	web thinning $\geq \varnothing 1.000$ • relieved cone • for higher tensile steels • bright < 2.36 mm
<b>M</b>	Stainless steel	○	
<b>K</b>	Cast iron	○	free-cutting steels • acid resist./stainless steels • case hardening/heat treatable steels up to 800 N/mm <sup>2</sup> • short/medium chip length Al/Cu-alloys
<b>N</b>	Aluminum	●	
<b>S</b>	Titanium alloys	○	
<b>H</b>	Hardened steel	○	

●=Optimal  
○=Limited



Speeds and feeds information on pg. 520

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				
0.0394		1.00	26.00	4.50	6.00	9005520010000
0.0402	#60	1.02	26.00	4.47	6.00	9005520010200
0.0409	#59	1.04	26.00	4.44	6.00	9005520010400
0.0413		1.05	26.00	4.43	6.00	9005520010500
0.0421	#58	1.07	28.00	5.40	7.00	9005520010700
0.0429	#57	1.09	28.00	5.37	7.00	9005520010900
0.0433		1.10	28.00	5.35	7.00	9005520011000
0.0453		1.15	28.00	5.28	7.00	9005520011500
0.0465	#56	1.18	28.00	5.23	7.00	9005520011800
0.0469	3/64	1.19	30.00	6.22	8.00	9005520011900
0.0472		1.20	30.00	6.20	8.00	9005520012000
0.0492		1.25	30.00	6.13	8.00	9005520012500
0.0512		1.30	30.00	6.05	8.00	9005520013000
0.0520	#55	1.32	30.00	6.02	8.00	9005520013200
0.0531		1.35	32.00	6.98	9.00	9005520013500
0.0551	#54	1.40	32.00	6.90	9.00	9005520014000
0.0571		1.45	32.00	6.83	9.00	9005520014500
0.0591		1.50	32.00	6.75	9.00	9005520015000
0.0594	#53	1.51	34.00	7.74	10.00	9005520015100
0.0602		1.53	34.00	7.71	10.00	9005520015300
0.0610		1.55	34.00	7.68	10.00	9005520015500
0.0626	1/16	1.59	34.00	7.62	10.00	9005520015900
0.0630		1.60	34.00	7.60	10.00	9005520016000
0.0634	#52	1.61	34.00	7.59	10.00	9005520016100
0.0650		1.65	34.00	7.53	10.00	9005520016500
0.0669	#51	1.70	34.00	7.45	10.00	9005520017000
0.0681		1.73	36.00	8.41	11.00	9005520017300
0.0689		1.75	36.00	8.38	11.00	9005520017500
0.0701	#50	1.78	36.00	8.33	11.00	9005520017800
0.0709		1.80	36.00	8.30	11.00	9005520018000
0.0717		1.82	36.00	8.27	11.00	9005520018200
0.0728	#49	1.85	36.00	8.23	11.00	9005520018500
0.0748		1.90	36.00	8.15	11.00	9005520019000
0.0760	#48	1.93	38.00	9.11	12.00	9005520019300
0.0768		1.95	38.00	9.08	12.00	9005520019500
0.0780	5/64	1.98	38.00	9.03	12.00	9005520019800
0.0783	#47	1.99	38.00	9.02	12.00	9005520019900
0.0787		2.00	38.00	9.00	12.00	9005520020000
0.0807		2.05	38.00	8.93	12.00	9005520020500
0.0811	#46	2.06	38.00	8.91	12.00	9005520020600
0.0819	#45	2.08	38.00	8.88	12.00	9005520020800

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				
0.0827		2.10	38.00	8.85	12.00	9005520021000
0.0839		2.13	40.00	9.81	13.00	9005520021300
0.0846		2.15	40.00	9.78	13.00	9005520021500
0.0858	#44	2.18	40.00	9.73	13.00	9005520021800
0.0866		2.20	40.00	9.70	13.00	9005520022000
0.0886		2.25	40.00	9.63	13.00	9005520022500
0.0890	#43	2.26	40.00	9.61	13.00	9005520022600
0.0906		2.30	40.00	9.55	13.00	9005520023000
0.0913		2.32	40.00	9.52	13.00	9005520023200
0.0925		2.35	40.00	9.48	13.00	9005520023500
0.0933	#42	2.37	43.00	10.45	14.00	9005520023700
0.0937	3/32	2.38	43.00	10.43	14.00	9005520023800
0.0945		2.40	43.00	10.40	14.00	9005520024000
0.0961	#41	2.44	43.00	10.34	14.00	9005520024400
0.0965		2.45	43.00	10.33	14.00	9005520024500
0.0980	#40	2.49	43.00	10.27	14.00	9005520024900
0.0984		2.50	43.00	10.25	14.00	9005520025000
0.0996	#39	2.53	43.00	10.21	14.00	9005520025300
0.1004		2.55	43.00	10.18	14.00	9005520025500
0.1016	#38	2.58	43.00	10.13	14.00	9005520025800
0.1024		2.60	43.00	10.10	14.00	9005520026000
0.1039	#37	2.64	43.00	10.04	14.00	9005520026400
0.1043		2.65	43.00	10.03	14.00	9005520026500
0.1063		2.70	46.00	11.95	16.00	9005520027000
0.1067	#36	2.71	46.00	11.94	16.00	9005520027100
0.1083		2.75	46.00	11.88	16.00	9005520027500
0.1094	7/64	2.78	46.00	11.83	16.00	9005520027800
0.1098	#35	2.79	46.00	11.82	16.00	9005520027900
0.1102		2.80	46.00	11.80	16.00	9005520028000
0.1110	#34	2.82	46.00	11.77	16.00	9005520028200
0.1130	#33	2.87	46.00	11.70	16.00	9005520028700
0.1142		2.90	46.00	11.65	16.00	9005520029000
0.1161	#32	2.95	46.00	11.58	16.00	9005520029500
0.1181		3.00	46.00	11.50	16.00	9005520030000
0.1201	#31	3.05	49.00	13.43	18.00	9005520030500
0.1220		3.10	49.00	13.35	18.00	9005520031000
0.1240		3.15	49.00	13.28	18.00	9005520031500
0.1248	1/8	3.17	49.00	13.25	18.00	9005520031700
0.1260		3.20	49.00	13.20	18.00	9005520032000
0.1280		3.25	49.00	13.13	18.00	9005520032500
0.1283	#30	3.26	49.00	13.11	18.00	9005520032600

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					
0.1299		3.30	49.00	13.05	18.00	9005520033000	
0.1319		3.35	49.00	12.98	18.00	9005520033500	
0.1339		3.40	52.00	14.90	20.00	9005520034000	
0.1358	#29	3.45	52.00	14.83	20.00	9005520034500	
0.1378		3.50	52.00	14.75	20.00	9005520035000	
0.1398		3.55	52.00	14.68	20.00	9005520035500	
0.1406	9/64	#28	3.57	52.00	14.65	20.00	9005520035700
0.1417		3.60	52.00	14.60	20.00	9005520036000	
0.1437		3.65	52.00	14.53	20.00	9005520036500	
0.1441	#27	3.66	52.00	14.51	20.00	9005520036600	
0.1457		3.70	52.00	14.45	20.00	9005520037000	
0.1469	#26	3.73	52.00	14.41	20.00	9005520037300	
0.1476		3.75	52.00	14.38	20.00	9005520037500	
0.1496	#25	3.80	55.00	16.30	22.00	9005520038000	
0.1520	#24	3.86	55.00	16.21	22.00	9005520038600	
0.1535		3.90	55.00	16.15	22.00	9005520039000	
0.1539	#23	3.91	55.00	16.14	22.00	9005520039100	
0.1555		3.95	55.00	16.08	22.00	9005520039500	
0.1563	5/32	3.97	55.00	16.05	22.00	9005520039700	
0.1571	#22	3.99	55.00	16.02	22.00	9005520039900	
0.1575		4.00	55.00	16.00	22.00	9005520040000	
0.1591	#21	4.04	55.00	15.94	22.00	9005520040400	
0.1594		4.05	55.00	15.93	22.00	9005520040500	
0.1610	#20	4.09	55.00	15.87	22.00	9005520040900	
0.1614		4.10	55.00	15.85	22.00	9005520041000	
0.1634		4.15	55.00	15.78	22.00	9005520041500	
0.1654		4.20	55.00	15.70	22.00	9005520042000	
0.1661	#19	4.22	55.00	15.67	22.00	9005520042200	
0.1673		4.25	55.00	15.63	22.00	9005520042500	
0.1693	#18	4.30	58.00	17.55	24.00	9005520043000	
0.1713		4.35	58.00	17.48	24.00	9005520043500	
0.1720	11/64	4.37	58.00	17.45	24.00	9005520043700	
0.1728	#17	4.39	58.00	17.42	24.00	9005520043900	
0.1732		4.40	58.00	17.40	24.00	9005520044000	
0.1752		4.45	58.00	17.33	24.00	9005520044500	
0.1772	#16	4.50	58.00	17.25	24.00	9005520045000	
0.1799	#15	4.57	58.00	17.15	24.00	9005520045700	
0.1811		4.60	58.00	17.10	24.00	9005520046000	
0.1819	#14	4.62	58.00	17.07	24.00	9005520046200	
0.1831		4.65	58.00	17.03	24.00	9005520046500	
0.1850	#13	4.70	58.00	16.95	24.00	9005520047000	
0.1870		4.75	58.00	16.88	24.00	9005520047500	
0.1874	3/16	4.76	62.00	18.86	26.00	9005520047600	
0.1890	#12	4.80	62.00	18.80	26.00	9005520048000	
0.1909	#11	4.85	62.00	18.73	26.00	9005520048500	
0.1929		4.90	62.00	18.65	26.00	9005520049000	
0.1937	#10	4.92	62.00	18.62	26.00	9005520049200	
0.1961	#9	4.98	62.00	18.53	26.00	9005520049800	
0.1969		5.00	62.00	18.50	26.00	9005520050000	
0.1992	#8	5.06	62.00	18.41	26.00	9005520050600	
0.2008		5.10	62.00	18.35	26.00	9005520051000	
0.2012	#7	5.11	62.00	18.34	26.00	9005520051100	
0.2031	13/64	5.16	62.00	18.26	26.00	9005520051600	
0.2039	#6	5.18	62.00	18.23	26.00	9005520051800	
0.2047		5.20	62.00	18.20	26.00	9005520052000	
0.2055	#5	5.22	62.00	18.17	26.00	9005520052200	
0.2087		5.30	62.00	18.05	26.00	9005520053000	
0.2091	#4	5.31	66.00	20.04	28.00	9005520053100	
0.2126		5.40	66.00	19.90	28.00	9005520054000	
0.2130	#3	5.41	66.00	19.89	28.00	9005520054100	
0.2165		5.50	66.00	19.75	28.00	9005520055000	
0.2189	7/32	5.56	66.00	19.66	28.00	9005520055600	

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					
0.2205		5.60	66.00	19.60	28.00	9005520056000	
0.2209	#2	5.61	66.00	19.59	28.00	9005520056100	
0.2244		5.70	66.00	19.45	28.00	9005520057000	
0.2280	#1	5.79	66.00	19.32	28.00	9005520057900	
0.2283		5.80	66.00	19.30	28.00	9005520058000	
0.2323		5.90	66.00	19.15	28.00	9005520059000	
0.2339	A	5.94	66.00	19.09	28.00	9005520059400	
0.2343	15/64	5.95	66.00	19.08	28.00	9005520059500	
0.2362		6.00	66.00	19.00	28.00	9005520060000	
0.2378	B	6.04	70.00	21.94	31.00	9005520060400	
0.2402		6.10	70.00	21.85	31.00	9005520061000	
0.2421	C	6.15	70.00	21.78	31.00	9005520061500	
0.2441		6.20	70.00	21.70	31.00	9005520062000	
0.2461	D	6.25	70.00	21.63	31.00	9005520062500	
0.2480		6.30	70.00	21.55	31.00	9005520063000	
0.2500	1/4	E	6.35	70.00	21.48	31.00	9005520063500
0.2520		6.40	70.00	21.40	31.00	9005520064000	
0.2559		6.50	70.00	21.25	31.00	9005520065000	
0.2571		6.53	70.00	21.21	31.00	9005520065300	
0.2598		6.60	70.00	21.10	31.00	9005520066000	
0.2610	G	6.63	70.00	21.06	31.00	9005520066300	
0.2638		6.70	70.00	20.95	31.00	9005520067000	
0.2657	17/64	H	6.75	74.00	23.88	34.00	9005520067500
0.2677		6.80	74.00	23.80	34.00	9005520068000	
0.2717		6.90	74.00	23.65	34.00	9005520069000	
0.2756		7.00	74.00	23.50	34.00	9005520070000	
0.2768	J	7.03	74.00	23.46	34.00	9005520070300	
0.2795		7.10	74.00	23.35	34.00	9005520071000	
0.2811	9/32	K	7.14	74.00	23.29	34.00	9005520071400
0.2835		7.20	74.00	23.20	34.00	9005520072000	
0.2874		7.30	74.00	23.05	34.00	9005520073000	
0.2902	L	7.37	74.00	22.95	34.00	9005520073700	
0.2913		7.40	74.00	22.90	34.00	9005520074000	
0.2949	M	7.49	74.00	22.77	34.00	9005520074900	
0.2953		7.50	74.00	22.75	34.00	9005520075000	
0.2969	19/64	7.54	79.00	25.69	37.00	9005520075400	
0.2992		7.60	79.00	25.60	37.00	9005520076000	
0.3020	N	7.67	79.00	25.50	37.00	9005520076700	
0.3031		7.70	79.00	25.45	37.00	9005520077000	
0.3071		7.80	79.00	25.30	37.00	9005520078000	
0.3110		7.90	79.00	25.15	37.00	9005520079000	
0.3126	5/16	7.94	79.00	25.09	37.00	9005520079400	
0.3150		8.00	79.00	25.00	37.00	9005520080000	
0.3161	O	8.03	79.00	24.96	37.00	9005520080300	
0.3189		8.10	79.00	24.85	37.00	9005520081000	
0.3228	P	8.20	79.00	24.70	37.00	9005520082000	
0.3268		8.30	79.00	24.55	37.00	9005520083000	
0.3280	21/64	8.33	79.00	24.51	37.00	9005520083300	
0.3307		8.40	79.00	24.40	37.00	9005520084000	
0.3319	Q	8.43	79.00	24.36	37.00	9005520084300	
0.3346		8.50	79.00	24.25	37.00	9005520085000	
0.3386		8.60	84.00	27.10	40.00	9005520086000	
0.3390	R	8.61	84.00	27.09	40.00	9005520086100	
0.3425		8.70	84.00	26.95	40.00	9005520087000	
0.3437	11/32	8.73	84.00	26.91	40.00	9005520087300	
0.3465		8.80	84.00	26.80	40.00	9005520088000	
0.3480	S	8.84	84.00	26.74	40.00	9005520088400	
0.3504		8.90	84.00	26.65	40.00	9005520089000	
0.3543		9.00	84.00	26.50	40.00	9005520090000	
0.3579	T	9.09	84.00	26.37	40.00	9005520090900	
0.3583		9.10	84.00	26.35	40.00	9005520091000	
0.3594	23/64	9.13	84.00	26.31	40.00	9005520091300	

Stub Length

Stub Length

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				
0.3622		9.20	84.00	26.20	40.00	9005520092000
0.3661		9.30	84.00	26.05	40.00	9005520093000
0.3677	U	9.34	84.00	25.99	40.00	9005520093400
0.3701		9.40	84.00	25.90	40.00	9005520094000
0.3740		9.50	84.00	25.75	40.00	9005520095000
0.3748	3/8	9.52	89.00	28.72	43.00	9005520095200
0.3772	V	9.58	89.00	28.63	43.00	9005520095800
0.3780		9.60	89.00	28.60	43.00	9005520096000
0.3819		9.70	89.00	28.45	43.00	9005520097000
0.3858	W	9.80	89.00	28.30	43.00	9005520098000
0.3898		9.90	89.00	28.15	43.00	9005520099000
0.3906	25/64	9.92	89.00	28.12	43.00	9005520099200
0.3937		10.00	89.00	28.00	43.00	9005520100000
0.3969	X	10.08	89.00	27.88	43.00	9005520100800
0.4016		10.20	89.00	27.70	43.00	9005520102000
0.4039	Y	10.26	89.00	27.61	43.00	9005520102600
0.4063	13/32	10.32	89.00	27.52	43.00	9005520103200
0.4130	Z	10.49	89.00	27.27	43.00	9005520104900
0.4134		10.50	89.00	27.25	43.00	9005520105000
0.4173		10.60	89.00	27.10	43.00	9005520106000
0.4220	27/64	10.72	95.00	30.92	47.00	9005520107200
0.4252		10.80	95.00	30.80	47.00	9005520108000
0.4331		11.00	95.00	30.50	47.00	9005520110000
0.4374	7/16	11.11	95.00	30.34	47.00	9005520111100
0.4409		11.20	95.00	30.20	47.00	9005520112000
0.4449		11.30	95.00	30.05	47.00	9005520113000
0.4488		11.40	95.00	29.90	47.00	9005520114000
0.4528		11.50	95.00	29.75	47.00	9005520115000
0.4531	29/64	11.51	95.00	29.74	47.00	9005520115100
0.4646		11.80	95.00	29.30	47.00	9005520118000
0.4689	15/32	11.91	102.00	33.14	51.00	9005520119100
0.4724		12.00	102.00	33.00	51.00	9005520120000

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				
0.4843	31/64	12.30	102.00	32.55	51.00	9005520123000
0.4882		12.40	102.00	32.40	51.00	9005520124000
0.4921		12.50	102.00	32.25	51.00	9005520125000
0.5000	1/2	12.70	102.00	31.95	51.00	9005520127000
0.5079		12.90	102.00	31.65	51.00	9005520129000
0.5118		13.00	102.00	31.50	51.00	9005520130000
0.5157	33/64	13.10	102.00	31.35	51.00	9005520131000
0.5311	17/32	13.49	107.00	33.77	54.00	9005520134900
0.5315		13.50	107.00	33.75	54.00	9005520135000
0.5469	35/64	13.89	107.00	33.17	54.00	9005520138900
0.5512		14.00	107.00	33.00	54.00	9005520140000
0.5626	9/16	14.29	111.00	34.57	56.00	9005520142900
0.5709		14.50	111.00	34.25	56.00	9005520145000
0.5780	37/64	14.68	111.00	33.98	56.00	9005520146800
0.5906		15.00	111.00	33.50	56.00	9005520150000
0.5937	19/32	15.08	115.00	35.38	58.00	9005520150800
0.6094	39/64	15.48	115.00	34.78	58.00	9005520154800
0.6102		15.50	115.00	34.75	58.00	9005520155000
0.6248	5/8	15.87	115.00	34.20	58.00	9005520158700
0.6299		16.00	115.00	34.00	58.00	9005520160000
0.6406	41/64	16.27	119.00	35.60	60.00	9005520162700
0.6496		16.50	119.00	35.25	60.00	9005520165000
0.6693		17.00	119.00	34.50	60.00	9005520170000
0.6720	43/64	17.07	123.00	36.40	62.00	9005520170700
0.6874	11/16	17.46	123.00	35.81	62.00	9005520174600
0.7031	45/64	17.86	123.00	35.21	62.00	9005520178600
0.7087		18.00	123.00	35.00	62.00	9005520180000
0.7189	23/32	18.26	127.00	36.61	64.00	9005520182600
0.7480		19.00	127.00	35.50	64.00	9005520190000
0.7500	3/4	19.05	131.00	37.43	66.00	9005520190500
0.7811	25/32	19.84	131.00	36.24	66.00	9005520198400
0.7874		20.00	131.00	36.00	66.00	9005520200000