

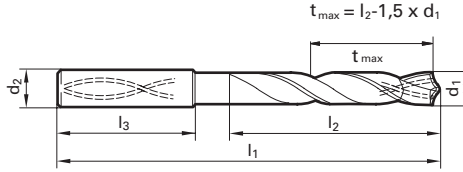
12xD

Series 5525

RT 100 C High Penetration

Carbide, RT 100 C high penetration, 12xD, self-centering
135° SC, double margin, reinforced straight shank, RH helix

Cut Dia. = h7 tolerance range, Shank Dia. = h6



Application Materials:

- General Steels/Brass
- Universal Steels
- Stainless Steels
- Hardened Materials
- Cast Iron
- Ti & Ni Alloys

Twist Drills

N

nano-FIREX® coated



Coolant Through



Reinforced Straight Shank

Speeds & Feeds
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Diameter (d1)		Wire / letter	mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch						
0.1181			3.000	6.000	90.00	50.00	9055250030000
0.1220			3.100	6.000	90.00	50.00	9055250031000
0.1250	1/8		3.170	6.000	90.00	50.00	9055250031700
0.1260			3.200	6.000	90.00	50.00	9055250032000
0.1280			3.250	6.000	90.00	50.00	9055250032500
0.1299			3.300	6.000	90.00	50.00	9055250033000
0.1339			3.400	6.000	90.00	50.00	9055250034000
0.1378			3.500	6.000	90.00	50.00	9055250035000
0.1406	9/64		3.570	6.000	90.00	50.00	9055250035700
0.1417			3.600	6.000	90.00	50.00	9055250036000
0.1457			3.700	6.000	90.00	50.00	9055250037000
0.1496		25	3.800	6.000	90.00	50.00	9055250038000
0.1535			3.900	6.000	90.00	50.00	9055250039000
0.1563	5/32		3.970	6.000	90.00	50.00	9055250039700
0.1575			4.000	6.000	102.00	64.00	9055250040000
0.1614			4.100	6.000	102.00	64.00	9055250041000
0.1654			4.200	6.000	102.00	64.00	9055250042000
0.1693		18	4.300	6.000	102.00	64.00	9055250043000
0.1720	11/64		4.370	6.000	102.00	64.00	9055250043700
0.1732			4.400	6.000	102.00	64.00	9055250044000
0.1772		16	4.500	6.000	102.00	64.00	9055250045000
0.1811			4.600	6.000	102.00	64.00	9055250046000
0.1831			4.650	6.000	102.00	64.00	9055250046500
0.1850			4.700	6.000	102.00	64.00	9055250047000
0.1874	3/16		4.760	6.000	102.00	64.00	9055250047600
0.1890			4.800	6.000	116.00	78.00	9055250048000
0.1929			4.900	6.000	116.00	78.00	9055250049000
0.1969			5.000	6.000	116.00	78.00	9055250050000
0.2008			5.100	6.000	116.00	78.00	9055250051000
0.2031	13/64		5.160	6.000	116.00	78.00	9055250051600
0.2047			5.200	6.000	116.00	78.00	9055250052000
0.2087			5.300	6.000	116.00	78.00	9055250053000
0.2126			5.400	6.000	116.00	78.00	9055250054000
0.2165			5.500	6.000	116.00	78.00	9055250055000
0.2189	7/32		5.560	6.000	116.00	78.00	9055250055600
0.2205			5.600	6.000	116.00	78.00	9055250056000
0.2244			5.700	6.000	116.00	78.00	9055250057000
0.2283			5.800	6.000	116.00	78.00	9055250058000
0.2323			5.900	6.000	116.00	78.00	9055250059000
0.2343	15/64		5.950	6.000	116.00	78.00	9055250059500
0.2362			6.000	6.000	116.00	78.00	9055250060000
0.2402			6.100	8.000	146.00	108.00	9055250061000
0.2441			6.200	8.000	146.00	108.00	9055250062000
0.2480			6.300	8.000	146.00	108.00	9055250063000
0.2500	1/4	E	6.350	8.000	146.00	108.00	9055250063500
0.2520			6.400	8.000	146.00	108.00	9055250064000
0.2559			6.500	8.000	146.00	108.00	9055250065000
0.2598			6.600	8.000	146.00	108.00	9055250066000
0.2638			6.700	8.000	146.00	108.00	9055250067000
0.2657	17/64		6.750	8.000	146.00	108.00	9055250067500

Diameter (d1)		Wire / letter	mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch						
0.2677			6.800	8.000	146.00	108.00	9055250068000
0.2717			6.900	8.000	146.00	108.00	9055250069000
0.2756			7.000	8.000	146.00	108.00	9055250070000
0.2795			7.100	8.000	146.00	108.00	9055250071000
0.2811	9/32		7.140	8.000	146.00	108.00	9055250071400
0.2835			7.200	8.000	146.00	108.00	9055250072000
0.2874			7.300	8.000	146.00	108.00	9055250073000
0.2913			7.400	8.000	146.00	108.00	9055250074000
0.2953			7.500	8.000	146.00	108.00	9055250075000
0.2969	19/64		7.540	8.000	146.00	108.00	9055250075400
0.2992			7.600	8.000	146.00	108.00	9055250076000
0.3031			7.700	8.000	146.00	108.00	9055250077000
0.3071			7.800	8.000	146.00	108.00	9055250078000
0.3110			7.900	8.000	146.00	108.00	9055250079000
0.3126	5/16		7.940	8.000	146.00	108.00	9055250079400
0.3150			8.000	8.000	146.00	108.00	9055250080000
0.3189			8.100	10.000	162.00	120.00	9055250081000
0.3228			8.200	10.000	162.00	120.00	9055250082000
0.3268			8.300	10.000	162.00	120.00	9055250083000
0.3280	21/64		8.330	10.000	162.00	120.00	9055250083300
0.3307			8.400	10.000	162.00	120.00	9055250084000
0.3346			8.500	10.000	162.00	120.00	9055250085000
0.3386			8.600	10.000	162.00	120.00	9055250086000
0.3425			8.700	10.000	162.00	120.00	9055250087000
0.3437	11/32		8.730	10.000	162.00	120.00	9055250087300
0.3465			8.800	10.000	162.00	120.00	9055250088000
0.3504			8.900	10.000	162.00	120.00	9055250089000
0.3543			9.000	10.000	162.00	120.00	9055250090000
0.3583			9.100	10.000	162.00	120.00	9055250091000
0.3594	23/64		9.130	10.000	162.00	120.00	9055250091300
0.3622			9.200	10.000	162.00	120.00	9055250092000
0.3642			9.250	10.000	162.00	120.00	9055250092500
0.3661			9.300	10.000	162.00	120.00	9055250093000
0.3701			9.400	10.000	162.00	120.00	9055250094000
0.3740			9.500	10.000	162.00	120.00	9055250095000
0.3748	3/8		9.520	10.000	162.00	120.00	9055250095200
0.3780			9.600	10.000	162.00	120.00	9055250096000
0.3819			9.700	10.000	162.00	120.00	9055250097000
0.3858			9.800	10.000	162.00	120.00	9055250098000
0.3898			9.900	10.000	162.00	120.00	9055250099000
0.3906	25/64		9.920	10.000	162.00	120.00	9055250099200
0.3937			10.000	10.000	162.00	120.00	9055250100000
0.3976			10.100	12.000	204.00	156.00	9055250101000
0.4016			10.200	12.000	204.00	156.00	9055250102000
0.4055			10.300	12.000	204.00	156.00	9055250103000
0.4063	13/32		10.320	12.000	204.00	156.00	9055250103200
0.4134			10.500	12.000	204.00	156.00	9055250105000
0.4173			10.600	12.000	204.00	156.00	9055250106000
0.4213			10.700	12.000	204.00	156.00	9055250107000
0.4220	27/64		10.720	12.000	204.00	156.00	9055250107200



All deep hole drills must utilize a pilot hole.

Deep hole drills must never operate at full speed without support in the pilot hole.

Series 5525

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Dec. inch	Diameter (d1)		d2 mm	l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter					
0.4252			10.800	12.000	204.00	156.00	9055250108000
0.4291			10.900	12.000	204.00	156.00	9055250109000
0.4331			11.000	12.000	204.00	156.00	9055250110000
0.4374	7/16		11.110	12.000	204.00	156.00	9055250111100
0.4528			11.500	12.000	204.00	156.00	9055250115000
0.4531	29/64		11.510	12.000	204.00	156.00	9055250115100
0.4689	15/32		11.910	12.000	204.00	156.00	9055250119100
0.4724			12.000	12.000	204.00	156.00	9055250120000
0.4843	31/64		12.300	14.000	230.00	182.00	9055250123000
0.4921			12.500	14.000	230.00	182.00	9055250125000
0.5000	1/2		12.700	14.000	230.00	182.00	9055250127000
0.5118			13.000	14.000	230.00	182.00	9055250130000
0.5311	17/32		13.490	14.000	230.00	182.00	9055250134900
0.5315			13.500	14.000	230.00	182.00	9055250135000
0.5469	35/64		13.890	14.000	230.00	182.00	9055250138900
0.5512			14.000	14.000	230.00	182.00	9055250140000
0.5709			14.500	16.000	260.00	208.00	9055250145000
0.5906			15.000	16.000	260.00	208.00	9055250150000
0.6094	39/64		15.480	16.000	260.00	208.00	9055250154800

Dec. inch	Diameter (d1)		d2 mm	l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter					
0.6102			15.500	16.000	260.00	208.00	9055250155000
0.6299			16.000	16.000	260.00	208.00	9055250160000
0.6496			16.500	18.000	285.00	234.00	9055250165000
0.6693			17.000	18.000	285.00	234.00	9055250170000
0.6890			17.500	18.000	285.00	234.00	9055250175000
0.7087			18.000	18.000	285.00	234.00	9055250180000
0.7283			18.500	20.000	285.00	234.00	9055250185000
0.7480			19.000	20.000	310.00	258.00	9055250190000
0.7500	3/4		19.050	20.000	310.00	258.00	9055250190500
0.7677			19.500	20.000	310.00	258.00	9055250195000
0.7874			20.000	20.000	310.00	258.00	9055250200000

Alternative Drill Series:

#5512 Carbide, RT100, 7xD, 140 U pt, FIREX®
 #6511 Carbide, FT100T, 20xD, 135 pt, TiAIN tipped



All deep hole drills must utilize a pilot hole.

Deep hole drills must never operate at full speed without support in the pilot hole.