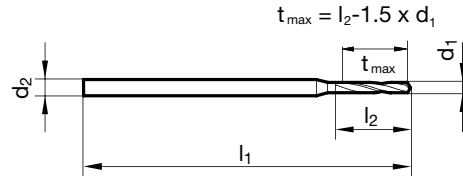




Tool material **Solid Carbide**
Surface **A**

- | | | | |
|----------|-----------------|---|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| P | Steel | ● | web thinning $\geq \varnothing 1.400$ • facet point grinding • main cutting edge form straight • edge preparation |
| M | Stainless steel | ● | |
| K | Cast iron | ● | structural and case hardened steels • free-cutting steels, heat-treatable steels • alloyed steels up to 1200 N/mm ² • stainless steels • cast materials |
| N | Aluminum | ○ | |
| S | Titanium alloys | ○ | |
| H | Hardened steel | | |
- =Optimal
○=Limited



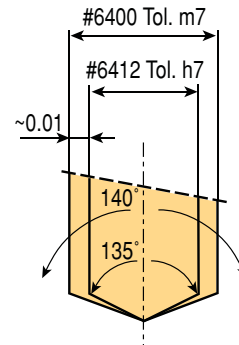
Speeds and feeds information on pg. 587

Diameter (d ₁)			d2 h6	l ₁	t _{max}	l ₂	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.0551		1.40	4.00	62.00	22.80	25.00	9064120014000
0.0591		1.50	4.00	62.00	24.70	27.00	9064120015000
0.0626	1/16	1.59	4.00	62.00	26.50	29.00	9064120015900
0.0630		1.60	4.00	62.00	26.50	29.00	9064120016000
0.0669		1.70	4.00	70.00	28.40	31.00	9064120017000
0.0689		1.75	4.00	70.00	29.30	32.00	9064120017500
0.0709		1.80	4.00	70.00	29.70	32.00	9064120018000
0.0748		1.90	4.00	70.00	31.60	34.00	9064120019000
0.0780	5/64	1.98	4.00	70.00	33.50	36.00	9064120019800
0.0787		2.00	4.00	70.00	33.50	36.00	9064120020000
0.0827		2.10	4.00	78.00	35.40	38.00	9064120021000

Diameter (d ₁)			d2 h6	l ₁	t _{max}	l ₂	EDP #
inch	wire/ltr	mm	mm	mm	mm	mm	
0.0866		2.20	4.00	78.00	37.20	40.00	9064120022000
0.0906		2.30	4.00	78.00	39.10	42.00	9064120023000
0.0937	3/32	2.38	4.00	78.00	41.00	44.00	9064120023800
0.0945		2.40	4.00	78.00	41.00	44.00	9064120024000
0.0984		2.50	4.00	78.00	41.90	45.00	9064120025000
0.1024		2.60	4.00	87.00	43.70	47.00	9064120026000
0.1063		2.70	4.00	87.00	44.60	48.00	9064120027000
0.1094	7/64	2.78	4.00	87.00	46.50	50.00	9064120027800
0.1102		2.80	4.00	87.00	46.50	50.00	9064120028000
0.1142		2.90	4.00	87.00	48.40	52.00	9064120029000
0.1181		3.00	4.00	87.00	50.20	54.00	9064120030000

Pilot drilling

It is recommended to utilize a pilot drill for the series 6412 deep hole micro drill. Use series 6400 or 6405 drills with m7 diameter tolerance and 140° point to drill a minimum of 1xD deep. Then enter the pilot hole with the deep hole drill at max. 300RPM and 20IPM stopping shy of the bottom of the pilot hole. Start high pressure coolant and increase RPM to recommended operating speed. Drill at recommended feed rate to hole depth without pecking. Slow to max. 300RPM before retracting.



Micro Drills