



Tool material

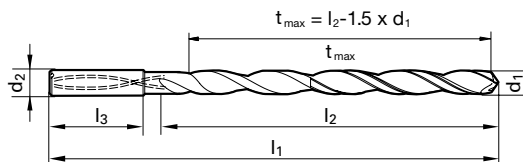
Solid Carbide

Surface



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 ² • 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. 589

Diameter (d1)		d2	l1	t _{max}	l2	EDP #	
inch	wire/ltr	mm	mm	mm	mm		
0.1181		3.00	6.00	125.00	80.50	85.00	9065120030000
0.1220		3.10	6.00	141.00	96.35	101.00	9065120031000
0.1248	1/8	3.18	6.00	141.00	96.23	101.00	9065120031700
0.1260		3.20	6.00	141.00	96.20	101.00	9065120032000
0.1299		3.30	6.00	141.00	96.05	101.00	9065120033000
0.1378		3.50	6.00	156.00	110.75	116.00	9065120035000
0.1406	9/64 #28	3.57	6.00	156.00	110.65	116.00	9065120035700
0.1457		3.70	6.00	156.00	110.45	116.00	9065120037000
0.1496		3.80	6.00	156.00	110.30	116.00	9065120038000
0.1563	5/32	3.97	6.00	156.00	110.05	116.00	9065120039700
0.1575		4.00	6.00	156.00	110.00	116.00	9065120040000
0.1654		4.20	6.00	183.00	136.70	143.00	9065120042000
0.1693		4.30	6.00	183.00	136.55	143.00	9065120043000
0.1720	11/64	4.37	6.00	183.00	136.45	143.00	9065120043700
0.1772		4.50	6.00	183.00	136.25	143.00	9065120045000
0.1811		4.60	6.00	183.00	136.10	143.00	9065120046000
0.1874	3/16	4.76	6.00	183.00	135.86	143.00	9065120047600
0.1890	#12	4.80	6.00	183.00	135.80	143.00	9065120048000
0.1969		5.00	6.00	183.00	135.50	143.00	9065120050000
0.2008		5.10	6.00	210.00	162.35	170.00	9065120051000
0.2031	13/64	5.16	6.00	210.00	162.26	170.00	9065120051600
0.2130	#3	5.41	6.00	210.00	161.89	170.00	9065120054100
0.2165		5.50	6.00	210.00	161.75	170.00	9065120055000
0.2189	7/32	5.56	6.00	210.00	161.66	170.00	9065120055600
0.2283		5.80	6.00	210.00	161.30	170.00	9065120058000
0.2343	15/64	5.95	6.00	210.00	161.08	170.00	9065120059500
0.2362		6.00	6.00	210.00	161.00	170.00	9065120060000
0.2480		6.30	8.00	237.00	187.55	197.00	9065120063000
0.2500	1/4 E	6.35	8.00	237.00	187.48	197.00	9065120063500
0.2559		6.50	8.00	237.00	187.25	197.00	9065120065000
0.2657	17/64 H	6.75	8.00	237.00	186.88	197.00	9065120067500
0.2677		6.80	8.00	237.00	186.80	197.00	9065120068000
0.2756		7.00	8.00	237.00	186.50	197.00	9065120070000

Diameter (d1)		d2	l1	t _{max}	l2	EDP #	
inch	wire/ltr	mm	mm	mm	mm		
0.2811	9/32 K	7.14	8.00	263.00	212.29	223.00	9065120071400
0.2953		7.50	8.00	263.00	211.75	223.00	9065120075000
0.2969	19/64	7.54	8.00	263.00	211.69	223.00	9065120075400
0.3125	5/16	7.94	8.00	263.00	211.09	223.00	9065120079400
0.3150		8.00	8.00	263.00	211.00	223.00	9065120080000
0.3280	21/64	8.33	10.00	294.00	237.51	250.00	9065120083300
0.3346		8.50	10.00	294.00	237.25	250.00	9065120085000
0.3437	11/32	8.73	10.00	294.00	236.91	250.00	9065120087300
0.3465		8.80	10.00	294.00	236.80	250.00	9065120088000
0.3543		9.00	10.00	294.00	236.50	250.00	9065120090000
0.3594	23/64	9.13	10.00	321.00	263.31	277.00	9065120091300
0.3750	3/8	9.52	10.00	321.00	262.72	277.00	9065120095200
0.3906	25/64	9.92	10.00	321.00	262.12	277.00	9065120099200
0.3937		10.00	10.00	321.00	262.00	277.00	9065120100000
0.4063	13/32	10.32	12.00	359.00	294.52	310.00	9065120103200
0.4220	27/64	10.72	12.00	359.00	293.92	310.00	9065120107200
0.4331		11.00	12.00	359.00	293.50	310.00	9065120110000
0.4374	7/16	11.11	12.00	386.00	320.34	337.00	9065120111100
0.4531	29/64	11.51	12.00	386.00	319.74	337.00	9065120115100
0.4689	15/32	11.91	12.00	386.00	319.14	337.00	9065120119100
0.4724		12.00	12.00	386.00	319.00	337.00	9065120120000
0.4843		12.30	14.00	437.00	369.55	388.00	9065120123000
0.5000		12.70	14.00	437.00	368.95	388.00	9065120127000
0.5118		13.00	14.00	437.00	368.50	388.00	9065120130000
0.5157		13.10	14.00	437.00	368.35	388.00	9065120131000
0.5311	17/32	13.49	14.00	437.00	367.77	388.00	9065120134900
0.5469	35/64	13.89	14.00	437.00	367.17	388.00	9065120138900
0.5512		14.00	14.00	437.00	367.00	388.00	9065120140000
0.5626	9/16	14.29	16.00	493.00	419.57	441.00	9065120142900
0.5906		15.00	16.00	493.00	418.50	441.00	9065120150000
0.6248	5/8	15.87	16.00	493.00	417.20	441.00	9065120158700
0.6299		16.00	16.00	493.00	417.00	441.00	9065120160000