

 **DORMER**



**UNION  
BUTTERFIELD®**

Catalog

2017



# List Number Index

0860	147	1985	266	A002S	78	C26M42CO	216	E3304M	399	EP20	255	R10H	101
1215	349	1994	345	A012	78	C26R15	203	E3304MV	399	EP21	255	R10P	74
1290	147	2A	82	A012S	74	C26R15CO	211	E3304V	398	EP30	255	R15	74
1301	369	2AB	82	A022	120	C26R15P	203	E4302	386	EP31	255	R15A	95
1500	287	2ACO	110	A088	114	C26R42	213	E4304	397	EP40	283	R15B	98
1500S	287	209	164	A094	206	C273	427	E500	292	EP41	283	R15CO	110
1500A	290	209CO	174	A095	207	C29HX10	210	E501	300	EX006H	273	R15P	74
1500L	296	229CSET	351	A097	202	C29L10	208	E504	305	EX016H	273	R18	74
1500OV	301	2010	356	A100	82	C29M40CO	216	E513	294	EX10	274	R18A	95
1505	302	2025	365	A101	90	C29R10	201	E5302	390	EX11	274	R18B	98
1508	298	2325M	366	A108	101	C29R10P	201	E5304	400	EX20	269	R18CO	110
1511	149	2510	358	A125	149	C29R40	213	E5304V	400	EX21	269	R18H	101
1519	344	2710M	362	A160	186	C29R40C	215	E547	340	EX30	269	R18P	74
1528	287	3300	323	A170	176	C29R51	217	E550	339	EX31	269	R40	117
1534	306	3300M	324	A190	205	C33R56	218	E620	342	EX40	285	R40C	123
1534NE	315	3300E	325	A191	205	C346	418	E621	342	EX41	285	R41	117
1534NR	311	3850	350	A217	197	C502AB	205	E624	249	F		R41C	123
1541	326	4ASM	126	A218	197	C60M41CO	216	E625	242	F201	364	R42	117
1542	338	4ASMCO	134	A221	198	C60R18	202	E626	251	F302	367	R42C	123
1543	334	411	501	A225	197	C60R18CO	211	E627	244	F312	368	R453	46
1544	329	430	501	A243	156	C60R18P	202	E628	250	F320	360	R454	46
1545	330	4500	462	A244	156	C60R41	213	E629	243	F330	360	R457	40
1545A	330	4531	449	A245	123	C60R41C	215	E630	237	F370	363	R458	40
1548	331	4532	456	A287	209	C8R56	218	E6302	391	G		R459	50
1549	335	4533	445	A345	170	C8R56CO	218	E6302V	391	G132	488	R51	135
1567	336	4535	450	A350	167	C8R57	218	E6304	401	G135	480	R510	44
1568	332	4536	455	A510	60	CO500-12	162	E6304V	401	G136	483	R51FS	141
1572	341	4537	455	A520	53	CO500-6	162	E631	237	G137	489	R52	135
1578	341	4579	460	A530	167	CO501-12	162	E650	347	G138	490	R520	38
1580	321	4579	460	A553	63	CO501-6	162	E651	346	G142	484	R55	135
1580M	322	4587	465	A720	130	D		E653	348	G149	482	R56	178
1582	317	4588	454	A900	65	D33F	187	E654	346	G154	481	R56CO	183
1585	307	4591	466	A901	65	D33L	187	E710	327	G171	486	R57	180
1585A	307	4600	467	A920	56	D33M	190	E711	333	G236	491	R58	182
1585NR	313	4602	479	A921	56	D33W	187	E712	337	G335	480	R88CO	115
1585OV	316	4603	477	A940	68	D444	184	E721	327	G338	490	R89CO	115
1586	317	4608	478	A941	68	DC	195	E764	249	G400	476	R950	19
1587	318	4702	492	A951	172	DS-90	191	E765	242	G560	483	R960	22
1588	318	4703	495	A952	172	DS-120	191	E766	251	G570	485	R970	25
1590	319	4704	496	A976	71	DS-142	191	E767	244	G600	487	S	
1591	319	4705	493	A977	71	E		E768	250	H		S209	164
1592	338	4706	493	ATR41	200	E000	261	E769	243	H853	28	S400HA	378
1593	316	5ATL	139	B		E000TIN	261	E770	237	H855	31	S401HA	379
1595	298	5ATS	167	B100	468	E001	261	E771	237	H858	34	S402HA	380
1599	303	500-12	160	B101	457	E002	275	E772	237	H860	37	S403HA	381
1599M	304	500-6	157	B121	459	E003	275	E808	245	H861	37	S404HA	382
1599SB	304	501-12	160	B122	453	E005	258	E809	238	HX10	92	S405HA	383
1600	303	501-6	157	B157	452	E006	258	E810	248	HX15	92	S406HA	384
1629AP	263	502-12	160	B170	442	E007	272	E811	241	HX18	92	S406HB	385
1630AP	276	502-6	157	B301	470	E008	272	E812	246	K		S407HA	386
1634	309	6541	328	B334	463	E011	261	E813	239	K520	502	SPL-120	194
1641	278	76HA	196	B335	464	E016	258	E814	236	K521	502	SPL-90	194
1659AP	264	883	429	B400	437	E018	272	E815	236	L		SPLG-120	194
1660AP	277	8007	369	B411	439	E021	256	E908	245	L10	89	SPR-120	193
1671	279	905	414	B441	436	E023	270	E909	238	L110	370	SPR-90	193
1672AP	252	920	409	B442	438	E025	253	E910	248	M		SPRG-120	193
1673AP	257	920K	410	B481	440	E026	253	E911	241	M40CO	131	SPRG-90	193
1674	252	923	408	B901	451	E027	268	E912	246	M41CO	131	SPS-120	192
1675	257	930	417	C		E028	268	E913	239	M42CO	131	SPS-90	192
1676AP	267	940	430	C110	406	E031	256	E914	236	M51CO	145	SPSG-120	192
1677AP	271	945	424	C114COMB	204	E033	270	E915	236	M52CO	145	SPSG-90	192
1678	267	948	423	C114COMBC	212	E035	253	QC0860P	154	Q		T	
1679	271	960	431	C114COMBP	203	E036	253	QC1290P	154	QC0860P	154	T400	461
1681AP	280	963	411	C115COMB	204	E037	268	QC21G	106	QC1290P	154	TC9002	419
1687AP	282	980	415	C115COMBC	212	E038	268	QC21GM	109	QC21G	106	TC9003	420
1691AP	281	981	416	C115COMBP	203	E041	284	QC21P	106	QC21GM	109	TN1500	291
1697AP	282	981	416	C123	412	E043	286	QC21PM	109	QC21P	106	TN1534	306
1700M	299	981	416	C13R10CO	211	E044	286	QC41G	128	QC21PM	109	TN1541	326
1700S	277	981	416	C15L10	208	E061	297	QC41P	128	QC41G	128	TN1543	334
1785M	310	981	416	C15R10	201	E071	297	QC91G	142	QC91G	142	TN1585	307
1785NR	314	981	416	C15R10CO	211	E201	265	QC91GM	144	QC91GM	144	TN1785	310
1788M	320	981	416	C15R10P	201	E252	265	QC91P	142	QC91P	142	TS10	199
1800	477	9002	419	C20R18	202	E3302	388	QC91PM	144	QC91PM	144	TS18	199
1813	149	9003	420	C20R18P	202	E3302M	389	R		R10	74	TS41	199
1815	477	9008	422	C21R10CO	211	E3302V	388	R10A	95	R10A	95	TS51	199
1816	477	9009	421	C247	425	E3303	396	R10B	98	R10B	98	TS52	199
1900	478	A002	82	C252A	205	E3303V	396	R10CO	110	R10CO	110	U1511	343
				C252AB	205	E3304	398						

# Table of Contents

004 - 007



Table of Contents

008 - 219



Drills

220 - 351



Taps

352 - 370



Dies

371 - 431



End Mills

432 - 470



Reamers

471 - 497



Countersinks/  
Counterbores

498 - 502



Miscellaneous

503 - 585



Technical

586 - 633

Speed/Feed Info  
EDP # Index

# TABLE OF CONTENTS - DRILLS

## Application Products

### Hydra Replaceable Head

Heads . . . . .	19-27
3 X D Bodies . . . . .	28-30
5 X D Bodies . . . . .	31-33
8 X D Bodies . . . . .	34-36
Screws & Screw Drivers . . . . .	37

### Screw Machine Length (Stub)/Short Length

CDX Carbide . . . . .	38-39
Force X Carbide . . . . .	40-43
ADX HSS . . . . .	53-55
PFX Cobalt Parabolic Flute . . . . .	56-59

### Jobber Length/Standard Length

CDX Carbide . . . . .	44-45
Force X Carbide . . . . .	46-49
ADX Solid Design . . . . .	60-62
ADX Coolant Thru . . . . .	63-64
PFX Cobalt Parabolic Flute . . . . .	65-67

### 8xD Length

Force X Carbide . . . . .	50-52
---------------------------	-------

### Taper Length

PFX Cobalt Parabolic Flute . . . . .	68-70
--------------------------------------	-------

### Extra Length

PFX Cobalt Parabolic Flute . . . . .	71-73
--------------------------------------	-------

## General Purpose

### Jobber Length

HSS	
General Purpose . . . . .	74-91
TiN Tipped . . . . .	78-88
Left Hand . . . . .	89-91
HX Heavy Duty, 135° Split Point . . . . .	92-94
Aircraft Type A, 118° Split Point . . . . .	95-97
Aircraft Type B, 135° Split Point . . . . .	98-100
Quick Spiral . . . . .	101-105
Parabolic Flute . . . . .	106-109
Cobalt	
NAS Type J, 135° Split Point . . . . .	110-114
NAS Type D, 135° Split Point . . . . .	115-116
Sets . . . . .	201-212

### Screw Machine Length (Stub)

HSS	
General Purpose . . . . .	117-119
TiN Tipped . . . . .	120-122
NAS Type C, 135° Split Point . . . . .	123-127
Parabolic Flute . . . . .	128-129
Cobalt	
Micro . . . . .	130
Heavy Duty, 135° Split Point . . . . .	131-134
Sets . . . . .	213-216

### Taper Length

HSS	
General Purpose . . . . .	135-140
High Helix . . . . .	141
Parabolic . . . . .	142-144
Cobalt	
Heavy Duty . . . . .	145-146
Sets . . . . .	217

### Extra Length

HSS	
Overall Length - 8" . . . . .	147-148
Overall Length - 12" . . . . .	147-148
Overall Length - 15" . . . . .	149-153
Overall Length - 18" . . . . .	149-153
Parabolic . . . . .	154-155

### Aircraft Extension

HSS,	
Type A, Overall Length - 6" . . . . .	156
Type B, Overall Length - 6" . . . . .	156-159
Type B, Overall Length - 12" . . . . .	160-161
Cobalt, Type J	
Overall Length - 6" . . . . .	162-163
Overall Length - 12" . . . . .	162-163

### Taper Shank

HSS, General Purpose	
Regular . . . . .	164-173
TiN coated . . . . .	167-169
Small Taper . . . . .	164-166
Long Series . . . . .	167-169
Extra length . . . . .	170-171
Cobalt, Heavy Duty . . . . .	174-175

### Reduced Shank

HSS	
1/2" Shank . . . . .	176-179
1/2" Shank with tri-flats . . . . .	180-181
3/4" Shank . . . . .	182
Cobalt	
1/2" Shank . . . . .	183
Sets . . . . .	218

### Special Purpose Drills

Carbide Tipped . . . . .	184-186
Combined Drill & Countersink . . . . .	195-198
Spotting . . . . .	191-194
Hexagonal Shank . . . . .	199
Tapered Aircraft Router . . . . .	200

### Solid Carbide

General Purpose . . . . .	187-190
Spotting . . . . .	191
Combined Drill & Countersink . . . . .	195

### Sets

Jobber Length . . . . .	201-212
Screw Machine Length . . . . .	213-216
Taper Length . . . . .	217
Reduced Shank . . . . .	218

# TABLE OF CONTENTS - TAPS

## Application Products

### Spiral Point Taps

Multi-Application	
Fractional/Machine Screw	. 238-241,252-256
Internal Coolant - Inch	.....252
Metric	.....242-244,257-262
Internal Coolant - Metric	.....257
Hard Materials	
Fractional/Machine Screw	.....263
Metric	.....264
DDX - High Hook	.....266

### Straight Flute Taps

For cast iron	.....236-237,263-265
---------------	----------------------

### Spiral Flute Taps

Multi-Application	
Fractional/Machine Screw	. 245-248,267-270
Internal Coolant - Inch	.....267
Metric	.....249-251
Internal Coolant, Metric	.....271
Hard Materials	
Fractional/Machine Screw	.....276
Metric	.....277

### Thread Forming Taps

Fractional/Machine Screw	.... 278, 280-281
Metric	.....279, 282

### Pipe Taps

Straight Flute	.....283-284
Spiral Flute	.....285-286

## General Purpose

### Hand Taps (Straight Flute)

Fractional/Machine Screw	
Steam Tempered	.....290
Bright/Gold	.....287-289, 296-298
TiN Coated	.....291
Metric	.....292-295
8-Pitch	.....302
Left Hand	.....296,300
Oversize	.....301
Optional Flute	.....298
For Cast Iron	.....303-305

### Spiral Point Taps

Relieved Style	
Fractional/Machine Screw	.....306-309
Metric	.....310
Non-Relieved Style	
Fractional/Machine Screw	.....311-313
Metric	.....314
Oversize - Relieved Style	
Fractional/Machine Screw	.....316
Extension - Non-Relieved Style	
Fractional/Machine Screw	.....315

### Spiral Flute Taps

30° Regular Spiral	
Fractional/Machine Screw	.....317
52° High Spiral	
Fractional/Machine Screw	.....318
Metric	.....320
40° Spiral - Heavy Duty	
Fractional/Machine Screw	.....319

### Thread Forming Taps

Rol-Rite, Spiral Lobe	
Fractional/Machine Screw	.....321
Metric	.....322

### Rol-Form, Lube Grooves

Fractional/Machine Screw	.....323
Metric	.....324
Extension Rol-Form	
Fractional/ Machine Screw	.....325

### Pipe Taps

NPT	
Medium Hook	.....326-328
High Hook	.....330
Low Rake	.....329
Spiral Flute	.....331
Interrupted Thread	.....332-333
NPTF (Dryseal)	
Medium Hook	.....334,337
Spiral Flute	.....335
Interrupted Thread	.....336
NPS	
Straight Pipe	.....338
NPSF	
Straight Pipe, Dryseal	.....338
Rc (British Standard)	.....339
G (British Standard)	.....340

### Special Purpose Taps

STI (Screw Thread Insert)	.....341-342
Nut Style	.....343
Pulley Style	.....344
Combination Drill & Tap	.....345-348

### Miscellaneous

Tap Wrench	.....349-350
Drill & Tap Sets	.....351

# TABLE OF CONTENTS - DIES

## Round Adjustable, Split Type

Carbon Steel (UNC,UNF,UNS,NPT) . . . .	356-357
HSS (UNC, UNF, M) . . . . .	358-362
HSS (BSP) . . . . .	363

## Hex Rethreading Bolt Dies (Dienuts)

Carbon Steel(UNC,UNF,UNS,NPT,M) . . .	365-366
HSS (M, MF) . . . . .	367-368

## Gun Nosed Dies

HSS, Left Hand (M) . . . . .	364
------------------------------	-----

Die Stocks . . . . .	369-370
----------------------	---------

# TABLE OF CONTENTS - END MILLS

## Application Products

### Solid Carbide, center cutting

2-Flute	
Regular Length	
Square End . . . . .	378
Corner Radius . . . . .	379
Long Reach	
Ball Nose . . . . .	380
3-Flute	
Regular Length	
Square End . . . . .	381
Corner Radius . . . . .	382

### 4-Flute

Regular Length, Unequal Helix, Corner Rad For Stainless Steel	
Cylindrical Shank . . . . .	384
Weldon Shank . . . . .	385
For Steel	
Cylindrical Shank . . . . .	386
Multi-Flute Finishing	
Long length corner radius . . . . .	383

## General Purpose

### Solid Carbide, Center Cutting

2-Flute	
Square End, Single End	
Regular . . . . .	388-389
Long . . . . .	390
Extra-Long . . . . .	391
Square End, Double End	
Regular . . . . .	387
Ball Nose	
Regular . . . . .	392-393
Long . . . . .	394
Extra-Long . . . . .	395
3-Flute	
Square End, Single End	
Regular . . . . .	396
4-Flute	
Square End, Single End	
Regular . . . . .	398-399
Long . . . . .	400
Extra-Long . . . . .	401
Square End, Double End	
Regular . . . . .	397
Ball Nose	
Regular . . . . .	402-403
Long . . . . .	404
Extra-Long . . . . .	405

### HSS and Cobalt Finishing End Mills

2-Flute	
Square End, Single End	
Regular . . . . .	406-407,409,411-413
Regular, Keyway . . . . .	410
Square End, Double End	
Regular . . . . .	408

### Ball Nose

Regular . . . . .	414
High Helix for Aluminum, Square End, Single End	
Regular . . . . .	415
Long . . . . .	416

### 3-Flute

Square End, Single End	
Regular . . . . .	417
Long . . . . .	418

### 4-Flute

Square End, Single End	
Regular . . . . .	424,431
Square End, Double End	
Regular . . . . .	423

### Multi-Flute

Square End, Single End	
Regular . . . . .	425-426,430
Long . . . . .	427-428

### Cobalt Roughing End Mills

#### Fine Profile

Regular Length	
Bright . . . . .	419
TiCN . . . . .	419
Long Length	
Bright . . . . .	422

#### Coarse Profile

Regular Length	
Bright . . . . .	420
TiCN . . . . .	420
Long Length	
Bright . . . . .	421

### Special Purpose Cutters

Corner Rounding . . . . .	429
---------------------------	-----

# TABLE OF CONTENTS - REAMERS

## Application Products

### Carbide Reamer

Machine Reamer, Unequal Spacing . . .	436-439
High Precision, Centesimal . . . . .	440-441

### Cobalt Reamer

High Precision, Centesimal . . . . .	442-444
--------------------------------------	---------

## General Purpose

### High Speed Steel & Cobalt Reamers

#### Straight Shank

Chucking, Straight Flute . . . . .	445-448
Chucking, Spiral Flute . . . . .	450-452
Chucking, Expansion . . . . .	449
Car . . . . .	453

#### Taper Shank

Chucking, Straight Flute . . . . .	455
Chucking, Spiral Flute . . . . .	455,457-458
Chucking, Expansion . . . . .	456
Bridge . . . . .	459-460

#### Taper Pin, Right Hand Cut

Straight Flute . . . . .	465
Spiral Flute, Left Hand . . . . .	466
High Spiral Flute, Left Hand . . . . .	454
Hand Reamer, Straight Flute . . . . .	470

Adjustable Hand Reamer . . . . .	463-464
Core Drill . . . . .	461
Taper Pipe . . . . .	467
Hand . . . . .	462,468-469

# TABLE OF CONTENTS - COUNTERSINKS & COUNTERBORES

## COUNTERSINK

60°	
Single Flute . . . . .	477
3-Flute . . . . .	478
3-Flute, Taper Shank . . . . .	480
4-Flute . . . . .	479

82°	
Single Flute . . . . .	477
3-Flute . . . . .	481

90°	
Single Flute . . . . .	477,482
HSS 3-Flute . . . . .	483-484,486
HSCO 3-Flute . . . . .	485
Long Reach 3-Flute . . . . .	487
Multi-Flute . . . . .	488
Taper Shank 3-Flute . . . . .	489-490
Set 3-Flute . . . . .	491

100°	
3-Flute . . . . .	478,486

## COUNTERBORE

Straight Shank, Interchangeable Pilot Type	
Short . . . . .	492

Aircraft Series	
Short . . . . .	493-494
Long . . . . .	493-494

Taper Shank, Interchangeable Pilot Type	
Short . . . . .	495

Pilots, Detachable . . . . .	496-497
------------------------------	---------

# TABLE OF CONTENTS - MISCELLANEOUS

## MISCELLANEOUS

Screw Extractor . . . . .	499
Drilling & Tapping Fluid . . . . .	500
Drill Sleeves . . . . .	501
Tool Bit Blanks . . . . .	502

# HYDRA DRILL



## How to Use This Chart:

- 1) Determine your Workpiece Material from the Application Material Groups (AMG) below.
- 2) Use the icons to find Product Features.
- 3) Find the Surface Feet Per Minute (SFM) and Alpha Code.

example: **361 W**

361 = SFM

W = Alpha Code used to find your Feed Rate (IPR)

- 4) To find Cutting Feed Rate, refer to chart below.

Fn	Ø						
	1/2"	19/32"	5/8"	3/4"	1"	1.3/16"	1.1/2"
S	0.004	0.005	0.005	0.006	0.007	0.007	0.009
T	0.005	0.006	0.007	0.007	0.008	0.009	0.010
U	0.008	0.009	0.009	0.009	0.011	0.012	0.014
V	0.011	0.012	0.013	0.013	0.016	0.017	0.020
W	0.015	0.016	0.017	0.018	0.019	0.019	0.020

Application Material Groups (AMG)			Hardness HRC
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB
	4.2 Titanium, alloyed	6Al4V, 6Al4V-2Sn, Monel, Monel K	<28
	4.3 Titanium, alloyed	6Al4V-4Mo, 7Al4V-4Mo, 4911-4967	>28<38
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38
6. Copper	6.1 Copper	Commercially Pure	<100 HB
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB
	6.4 High Strength Bronze	Ampco 18-25	<49
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB
8. Synthetic Materials	8.1 Thermoplastics	Ultradid, Polystrol	---
	8.2 Thermosetting plastics	Bakelit, Pertinax	---
	8.3 Reinforced plastic materials	CFK, GFKAFK	---
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54
10. Graphite	10.1 Standard graphite		---



# Visual Index - Drills

Head Style:	R950			R960			R970			
Head Range:	15/32" - 42.00	15/32" - 42.00	13.50 - 30.50	15/32" - 30.50	15/32" - 30.50	13.50 - 30.50	15/32" - 42.00	15/32" - 42.00	13.50 - 42.00	
Body Style:	H853	H855	H858	H853	H855	H858	H853	H855	H858	
Tool Material:	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
Standard:										
Depth of Cut:	3XD	5XD	8XD	3XD	5XD	8XD	3XD	5XD	8XD	
Finish/Coating:										
Shank:										
Direction of Cut:										
Coolant:										
Range:	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	
Page #	19,28	19,31	19,34	22,28	22,31	22,34	25,28	25,31	25,34	ISO
1.1				361W	361V	328U				P 1
1.2				328W	328V	295U				P 1
1.3	328W	328V	295U							P 2
1.4	279W	279V	246U							P 3
1.5	279W	279V	246U							P 4
1.6	197T	197T	197S							H 1
1.7										H 3
1.8										H 4
2.1				197V	164V	148U				M 1
2.2				164T	164S	131S				M 3
2.3				131T	131S	115S				M 2
2.4	115T	115T	98S							S 2
3.1							394V	374V	348U	K 1
3.2							380V	354V	328U	K 2
3.3							289V	279V	262U	K 3
3.4							289V	279V	262U	K 4
4.1				148T	148T	115S				S 1
4.2				115T	115T	98S				S 2
4.3				98S	98S	82S				S 3
5.1				115T	115T	98S				S 1
5.2				98S	98S	82S				S 2
5.3				82S	82S	66S				S 3
6.1										N 3
6.2										N 4
6.3										N 3
6.4										N 4
7.1										N 1
7.2										N 1
7.3										N 1
7.4										N 2
8.1										O
8.2										O
8.3										O
9.1										H
10.1										O

# Visual Index - Drills

## Feed Rate Chart - Drills

Alpha Code	Feed in Inches per Revolution (IPR) ± 25%													Ø Diameter		
	1mm/ 1/32"	2mm/ 3/32"	3mm/ 1/8"	4mm/ 5/32"	5mm/ 3/16"	6mm/ 1/4"	8mm/ 5/16"	10mm/ 3/8"	12mm/ 1/2"	15mm/ 9/16"	16mm/ 5/8"	20mm/ 3/4"	25mm/ 1"	30mm/ 1.1/8"	40mm/ 1.5/8"	50mm/ 2"
A	0.0004	0.0009	0.0011	0.0013	0.0014	0.0017	0.0021	0.0024	0.0027	0.0032	0.0034	0.0043	0.0049	0.0053	0.0061	0.0069
B	0.0006	0.0011	0.0015	0.0016	0.0018	0.0021	0.0026	0.0031	0.0035	0.0041	0.0043	0.0053	0.0060	0.0065	0.0074	0.0082
C	0.0006	0.0013	0.0017	0.0020	0.0022	0.0025	0.0031	0.0039	0.0043	0.0049	0.0051	0.0063	0.0071	0.0077	0.0087	0.0094
D	0.0006	0.0015	0.0021	0.0024	0.0027	0.0031	0.0039	0.0047	0.0051	0.0059	0.0061	0.0074	0.0083	0.0090	0.0100	0.0108
E	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068	0.0071	0.0085	0.0094	0.0102	0.0112	0.0122
F	0.0007	0.0020	0.0029	0.0033	0.0037	0.0043	0.0054	0.0065	0.0070	0.0080	0.0083	0.0098	0.0108	0.0116	0.0126	0.0135
G	0.0007	0.0022	0.0033	0.0038	0.0043	0.0050	0.0063	0.0075	0.0081	0.0091	0.0094	0.0110	0.0122	0.0130	0.0140	0.0148
H	0.0008	0.0026	0.0040	0.0046	0.0051	0.0059	0.0075	0.0090	0.0096	0.0107	0.0110	0.0126	0.0140	0.0148	0.0157	0.0165
I	0.0008	0.0030	0.0047	0.0053	0.0059	0.0068	0.0087	0.0104	0.0110	0.0122	0.0126	0.0142	0.0157	0.0165	0.0173	0.0181
J	0.0009	0.0033	0.0053	0.0060	0.0067	0.0078	0.0098	0.0117	0.0124	0.0137	0.0142	0.0159	0.0175	0.0183	0.0191	0.0198
K	0.0010	0.0036	0.0059	0.0067	0.0075	0.0087	0.0110	0.0130	0.0138	0.0153	0.0157	0.0177	0.0193	0.0201	0.0209	0.0215
L	0.0011	0.0040	0.0065	0.0073	0.0082	0.0094	0.0120	0.0142	0.0152	0.0165	0.0169	0.0191	0.0207	0.0215	0.0224	0.0231
M	0.0012	0.0043	0.0071	0.0080	0.0089	0.0102	0.0130	0.0154	0.0165	0.0177	0.0181	0.0205	0.0220	0.0228	0.0238	0.0248
N	0.0013	0.0047	0.0077	0.0086	0.0095	0.0110	0.0140	0.0165	0.0179	0.0189	0.0193	0.0219	0.0234	0.0242	0.0253	0.0265
S	0.0003	0.0006	0.0008	0.0010	0.0012	0.0015	0.0020	0.0031	0.0039	0.0048	0.0051	0.0059	0.0070	0.0070	0.0090	
T	0.0006	0.0011	0.0016	0.0020	0.0024	0.0028	0.0035	0.0043	0.0051	0.0063	0.0067	0.0075	0.0080	0.0090	0.0100	
U	0.0010	0.0019	0.0028	0.0031	0.0035	0.0042	0.0055	0.0067	0.0079	0.0088	0.0091	0.0094	0.0110	0.0120	0.0140	
V	0.0015	0.0027	0.0039	0.0045	0.0051	0.0060	0.0079	0.0098	0.0110	0.0122	0.0126	0.0134	0.0160	0.0170	0.0200	
W	0.0019	0.0035	0.0051	0.0059	0.0067	0.0079	0.0102	0.0130	0.0150	0.0165	0.0169	0.0177	0.0190	0.0190	0.0200	
X	0.0022	0.0041	0.0059	0.0071	0.0083	0.0098	0.0130	0.0165	0.0189	0.0210	0.0217	0.0228				
Y	0.0027	0.0049	0.0071	0.0087	0.0102	0.0125	0.0169	0.0217	0.0276	0.0276	0.0276	0.0291				
Z	0.0037	0.0068	0.0098	0.0128	0.0157	0.0210	0.0315	0.0394	0.0433	0.0463	0.0472	0.0472				

### How To Use This Chart to Find Cutting Feed Rate (IPR):

1. Find your Alpha Code on the AMG Chart (example: 279 U : U is the Alpha Code)
2. Find the closest diameter for your cutting application on the chart to find your IPR

Application Material Groups (AMG)	Hardness HRC	ISO		
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	S 1
	4.2 Titanium, alloyed	6Al4V, 6Al4V-2Sn, Monel, Monel K	<28	S 2
	4.3 Titanium, alloyed	6Al4V-4Mo, 7Al14V-4Mo, 4911-4967	>28<38	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	N 3
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	N 4
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultrad, Polystrol	---	O
	8.2 Thermosetting plastics	Bakelit, Pertinax	---	O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	H
10. Graphite	10.1 Standard graphite		---	O

# Visual Index - Drills

Tool Material:	HM	HM	HM	HM	HM	HM	HM	HSS	HSS-E	HSS-E	HSS	HSS-E	HSS-E	HSS-E	HSS-E
Standard:	DIN 6539	DIN 6537 K	DIN 6537 K	DIN 338	DIN 6537 L	DIN 6537 L	ISO 9001	DIN 1897	DIN ANSI	DIN ANSI	DIN 338	ISO 9001	DIN ANSI	DIN ANSI	DIN ANSI
Depth of Cut:	2.5XD	3XD	3XD	4XD	5XD	5XD	8XD	2.5XD	3XD	3XD	4XD	5XD	6XD	6XD	10XD
Point Style:	130°	140°	140°	130°	140°	140°	140°	130°	130°	130°	130°	130°	130°	130°	130°
Finish/Coating:	TN	TAN	TAN	TN	TAN	TAN	TAN	TN		Alcona Top	TN	TAN Top		Alcona Top	
Shank:		DIN 6536HA	DIN 6536HA		DIN 6536HA	DIN 6536HA	DIN 6536HA					DIN 6536HA			
Flute Form:	N			N					W	W			W	W	W
Direction of Cut:															
Coolant Through:															
Style:	R520	R458	R457	R510	R454	R453	R459	A520	A920	A921	A510	A553	A900	A901	A940
Range:	3.00 - 16.50	3.00 - 20.00	3.00 - 20.00	3.00 - 14.25	3.00 - 20.00	3.00 - 20.00	3.00 - 16.00	3.00 - 13.00	1.00 - 20.00	2.50 - 16.00	3.00 - 14.00	5.00 - 20.00	1.00 - 20.00	1.50 - 16.00	1.00 - 20.00
Page #	38	40	40	44	46	46	50	53	56	56	60	63	65	65	68
1.1	328X	510W	510W	328W	510V	510V	443V	187M	131J	197M	187M	279L	125H	197J	125F
1.2	295X	440W	460W	295W	440V	460V	394V	154M	112J	171M	154M	230L	108H	164J	108F
1.3	295X	360W	440W	295W	360V	440V	361U	131K	105I	174J	131K	197L	85H	144I	72G
1.4	262X	330V	375V	262W	330V	375V	328U	105I	105I	174J	98H	148H	85H	144I	72G
1.5	180X	245V	295V	180V	245V	295V	262U	69G	75E	125G	69F	92F	69E	108G	56C
1.6	148W	164U	213U	148V	164U	213U	180T	36E	62E	98G	36D	49D	52E	85G	39C
1.7	115U	98U	98U	115T	98U	98U									
1.8	98T	82U	82U	98S	82U	82U									
2.1	164W	148U	246V	164V	148U	246V	246V	98I	49F	56F	92G	131G	49E	56E	49C
2.2		131T	115V		131T	115V	115V	52I	23F	30F	46I	62I	23E	30E	23E
2.3		115T	98U		115T	98U	98U	66G	30D	36D	62G	89G	30C	36C	30B
2.4		115T			115T										
3.1	295Y	295W	394W	295X	295W	394W	394W	157M	112L	174L	138K	230K	79J	190I	
3.2	295Y	295W	394W	295X	295W	394W	394W	121K	85L	138L	105J	164J	62J	154I	52I
3.3	213X	230V	262V	213W	230V	262V	262V	98J	85L	138L	92J	148J	62J	112J	52I
3.4	213X	230V	262V	213W	230V	262V	262V	85F	62J	118J	82F	138F	46I	92I	39H
4.1	197W	164U	180V	148V	164U	180V		112I	98G	157I	105G	148G	72E	115G	59E
4.2	148V	131U	148V		131U	148V		66G	59G	95I	66H	98E	49E	79G	43C
4.3	115U	115T	131U		115T	131U		13B	33C	52E	13B	26C	20C	33E	20C
5.1	164W			164V				56I	49I	79L	56I	82I	46G	72I	
5.2								36G	30G	46I	30E	49E	23G	36I	
5.3								23E	20E	33G	20E	33G	20C	33E	
6.1		328V	410W		328V	410W	410V	131E	213H		131D	230G	213G		213F
6.2		656V	722W		656V	722W	722V	164I	216J		164I	279I	174I		230F
6.3		656V	722W		656V	722W	722V	148K	131J	233J	148I	262I	112H	184I	112G
6.4		262U	328V		262U	328V	328U	66F	102G	164I	66F	115G	98G	157I	98G
7.1	738Z	738W	820W	738Y	738W	820W	935W	180I	246L		164G	230H	197J		174H
7.2	738Z	738W	820W	738Y	738W	820W	935W	164M	148N		164M	328M	148N		148N
7.3	492Y	590V	656V	492X	590V	656V	623V	121K	131N		102I	180I	131N		131N
7.4	213Y	394V	492V	213X	394V	492V	312V	115I	118J	157J	108I	180J	92I	157I	98G
8.1	246Z			246X				213G	180J		213G	295G	180I		180H
8.2	377V			377V				164G	131H		164G		131G		131F
8.3								115F			115F				
9.1															
10.1															

# Visual Index - Drills

	HSS-E	HSS-E	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
	DIN ANSI	DIN 1889/1	DIN 1889/2	DIN 1889/3	ANSI	ANSI	ANSI	ANSI	DIN 338	DIN 338	DIN 338	DIN 338	DIN 338	ANSI	DIN 338	ANSI
	10XD	15XD	20XD	25XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD
	130°	130°	130°	130°	118°	118°	118°	118°	118°	118°	118°	118°	118°	118°	118°	135°
	Acron Top					ET	TR	TR		ET	ET	TR	TR		ET	Open End
	W	W	W	W			N	N	N	N	N	N	N		N	
	A941	A976	A977	A978	R10P R15P R18P	R10 R15 R18	A012	A012S	2A	2AB	A100	A002	A002S	L10	A101	HX10 HX15 HX18
	1.00 - 16.00	1.50 - 14.00	1.50 - 14.00	3.00 - 10.00	N97 - 11/16	N80 - 11/16	N80 - 3/4	1/16 - 1/2	0.15 - 15.00	1.00 - 17.50	0.20 - 20.00	1.00 - 16.00	2.00 - 13.00	1/32 - 1/2	1.00 - 12.00	1/16 - 1/2
	68	71	71	71	74	74	78	78	82	82	82	82	82	89	90	92
1.1	174G	102C	102B	102A	115H	115H	154J	154J	115H	115H	115H	154J	154J	115H	35H	115H
1.2	151G	85C	85B	85A	98H	98H	131J	131J	98H	98H	98H	131J	131J	98H	30H	69H
1.3	118G	72C	72B	72A	82F	82F	115F	115F	82F	82F	82F	115F	115F	82F	25F	75I
1.4	118G	72C	72B	72A	66F	66F	98F	98F	66F	66F	66F	98F	98F	66F	20F	69H
1.5	75D	39A	39A	39A	43E	43E	59F	59F	43E	43E	43E	59F	59F	43E	13E	56F
1.6	56D	33A	33A	33A	30D	30D	33E	33E	30D	30D	30D	33E	33E	30D	9D	
1.7																
1.8																
2.1	56C	39B	39B	39A	49E	49E	66F	66F	49E	49E	49E	66F	66F	49E	15E	105I
2.2	30E	23C	23B	23A	26G	26G	39G	39G	26G	26G	26G	39G	39G	26G	8G	59H
2.3	36B	26A	26A	26A	30C	30C	52C	52C	30C	30C	30C	52C	52C	30C	9C	56F
2.4																
3.1	118I				98H	98H	131J	131J	98H	98H	98H	131J	131J	98H	30H	171L
3.2	98I	75C	75B	75A	79F	79F	98E	98E	79F	79F	79F	98E	98E	79F	24F	89I
3.3	98I	52C	52B	52A	66E	66E	92E	92E	66E	66E	66E	92E	92E	66E	20E	95H
3.4	79H	36A	36A	36A	46E	46E	85E	85E	46E	46E	46E	85E	85E	46E	14E	59F
4.1	82F	49C	49B	49A	75E	75E	75F	75F	75E	75E	75E	75F	75F	75E	23E	95H
4.2	59D	36A	36A	36A	39D	39D	43D	43D	39D	39D	39D	43D	43D	39D	12D	75H
4.3	26D	16A	16A	16A	20B	20B	23B	23B	20B	20B	20B	23B	23B	20B	6B	
5.1					33G	33G	43G	43G	33G	33G	33G	43G	43G	33G	10G	59H
5.2					20E	20E	23E	23E	20E	20E	20E	23E	23E	20E	6E	
5.3					10A	10A	10A	10A	10A	10A	10A	10A	10A	10A	3A	
6.1					108G	108G	164G	164G	108G	108G	108G	164G	164G	108G	33G	
6.2					115I	115I	108I	108I	115I	115I	115I	108I	108I	115I	35I	
6.3	157H	98D	98C	98B	89H	89H	128H	128H	89H	89H	89H	128H	128H	89H	27H	
6.4	138H	89D	89C	89B	52G	52G	98G	98G	52G	52G	52G	98G	98G	52G	16G	
7.1					108J	108J	134K	134K	108J	108J	108J	134K	134K	108J	33J	
7.2					98I	98I	125J	125J	98I	98I	98I	125J	125J	98I	30I	
7.3					89H	89H	108I	108I	89H	89H	89H	108I	108I	89H	27H	
7.4	138H	89D	89C	89B	79F	79F	108I	108I	79F	79F	79F	108I	108I	79F	24F	
8.1					98J	98J	98I	98I	98J	98J	98J	98I	98I	98J	30J	
8.2					92H	92H	164H	164H	92H	92H	92H	164H	164H	92H	28H	
8.3					46F	46F	115F	115F	46F	46F	46F	115F	115F	46F	14F	
9.1					10B	10B	10B	10B	10B	10B	10B	10B	10B	10B	3B	
10.1																

# Visual Index - Drills

	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS-E	HSS	HSS	HSS
	ANSI	ANSI	ANSI	DIN 338	ANSI	ANSI	DIN 338	DIN 338	ANSI	DIN 338	NAS 907	ANSI	DIN ANSI	ANSI
	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	3XD	2.5XD	2.5XD	2.5XD
	118°	135°	118°	135°	135°	135°	135°	135°	135°	135°	135°	118°	135°	135°
			W	W						N			N	
	R10A R15A R18A	R10B R15B R18B	R10H R18H	A108	QC21P	QC21G	QC21PM	QC21GM	R10CO R15CO R18CO	2ACO	R88CO R89CO	R40 R41 R42	A022	R40C R41C R42C
	1/16 - 1/2	1/16 - 1/2	N80 - 1/2	1.00 - 16.00	1/16 - 11/16	1/16 - 1/2	1.50 - 17.50	1.50 - 13.00	N80 - 11/16	1.00 - 13.00	1/16 - 1/2	N60 - 2"	0.50 - 16.00	N60 - 1/2
	95	98	101	101	106	106	109	109	110	110	115	117	120	123
1.1	115J	115J	108I	115I	98F	115F	98F	115F	115J	115J	115J	115J	115K	115J
1.2	98H	98H	92I	98I	59F	69F	59F	69F	98H	98H	98H	98J	105K	98J
1.3	89G	89G		82G	66H	75H	66H	75H	89G	89G	89G	89G	82I	89G
1.4	79F	79F		66F	59F	69F	59F	69F	79F	79F	79F	69G	75H	69G
1.5	56E	56E		43E	46D	56D	46D	56D	56E	56E	56E	46F	52G	46F
1.6	33D	33D		30D					33D	33D	33D	33E	33E	33E
1.7														
1.8														
2.1	72E	72E		49E	89H	105H	89H	105H	72E	72E	72E	52F	49G	52F
2.2	36G	36G		30G	49F	59F	49F	59F	36G	36G	36G	30H	26I	30H
2.3	49C	49C		33D	49D	59D	49D	59D	49C	49C	49C	33D	30E	33D
2.4														
3.1	115H	115H	82F	98H	151H	171H	151H	171H	115H	115H	115H	105J	105K	105J
3.2	92D	92D	66D	79F	79H	89H	79H	89H	92D	92D	92D	89G	82I	89G
3.3	72E	72E	52C	66E	79F	95F	79F	95F	72E	72E	72E	66F	66G	66F
3.4	56E	56E	33C	46E		59D		59D	56E	56E	56E	52F	52G	52F
4.1	92F	92F	49C	82G	89H		89H		92F	92F	92F	89G	82I	89G
4.2	66D	66D		52E	49F		49F		66D	66D	66D	52E	46F	52E
4.3	36C	36C		23B					36C	36C	36C	26C	26C	26C
5.1	49G	49G	23E	39G	49F	59H	49F	59H	49G	49G	49G	43H	43H	43H
5.2	23E	23E		23G					23E	23E	23E	26F	26F	26F
5.3	20B	20B		20E					20B	20B	20B	13B	13B	13B
6.1	125H	125H	115H	108G	89I	98I	89I	98I	125H	125H	125H	118H	118H	118H
6.2	131F	131F	118G	115I	79H	89H	79H	89H	131F	131F	131F	125J	125K	125J
6.3	89H	89H		102H	79H	89H	79H	89H	89H	89H	89H	89I	89I	89I
6.4	69F	69F		52G					69F	69F	69F	52H	52I	52H
7.1	108J	108J	148J	108J	351H	400H	351H	400H	108J	108J	108J	108K	131F	108K
7.2	98I	98I	115J	98I	325H	351H	325H	351H	98I	98I	98I	98J	105K	98J
7.3	98H	98H	98G	89H					98H	98H	98H	98I	105J	98I
7.4	89F	89F	95G	79F	276H	315H	276H	315H	89F	89F	89F	82I	82J	82I
8.1			138J	98J								98K	98K	98K
8.2			131I	92H								115I	115I	115I
8.3			66G	46F								56G	56G	56G
9.1	20C	20C		10B					20C	20C	20C	13C	13C	13C
10.1														



# Visual Index - Drills

	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	
	BS 328	ANSI	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	ANSI	DIN 345	DIN 345	DIN 341	DIN 1870:1	DIN 1870:1	DIN 1870:2	ANSI
	10XD	10XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	4XD	6XD	10XD	15XD	20XD	4XD
	118°	135°	135°	118°	135°	135°	135°	135°	118°	118°	118°	118°	118°	130°	130°	135°
	N		N	N						N	N	N	N	W	W	
	A125	QC0860P QC1290P	A243	A244	500-6 501-6 502-6	500-12 501-12 502-12	CO500-6 CO501-6	CO500-12 CO500-12	209 S209	5ATS	A530	A350	A345	A951	A952	209CO
	1.40 - 1"	1/8 - 1/2	3/32 - 1/4	1/8 - 1/4	N60 - 1/2	3/64 - 1/2	1/16 - 1/4	1/16 - 1/4	1/8 - 2"	5.00 - 50.00	8.50 - 40.00	5.00 - 50.00	8.00 - 50.00	10.00 - 30.00	8.00 - 40.00	1/4 - 1.1/2
	149	154	156	156	157	160	162	162	164	167	167	167	170	172	172	174
1.1	79E	98F							115I	115I	154I	89I	79G	89G	89G	115J
1.2	72E	59F							98I	98I	131I	82I	72G	72G	72G	98H
1.3	52C	66H	82F	82F	82F	82F			82F	82F	98F	66G	56E	62E	62E	89G
1.4	49C	59F	66F	66F	66F	66F			66F	66F	89F	52F	49D	49D	49D	75F
1.5	20A	46D	43E	43E	43E	43E			39E	39E	66E	33E	20C	26C	26C	56E
1.6	16A		30D	30D	30D	30D	20B	20B	30D	30D	33D	20D	16B	20B	20B	33D
1.7																
1.8																
2.1	30C	89H	49E	49E	49E	49E	95H	95H	49E	49E	79E	43E	39C	39C	39C	79E
2.2	13E	49F	26G	26G	26G	26G	56F	56F	30G	30G	43G	13G	13E	20E	20E	36G
2.3	26A	49D	30C	30C	30C	30C	56D	56D	33C	33C	66C	26C	26A	39A	39A	56C
2.4							30D	30D								
3.1	72G	151H	98I	98I	98I	98I	161H	161H	98I	98I	118I	85I	72G	72G	72G	115J
3.2	59D	79H	79F	79F	79F	79F	85H	85H	79E	79E	92E	66F	59D	52D	52D	92G
3.3	43C	79F	66E	66E	66E	66E	85F	85F	66E	66E	89E	59E	43C	43C	43C	72E
3.4	30C		46E	46E	46E	46E	56D	56D	46E	46E	72E	36E	30C	30C	30C	56E
4.1	36D		75F	75F	75F	75F			75F	75F	105F	52F	49D	59D	59D	92G
4.2	30B		39D	39D	39D	39D			43D	43D	59D	30D	30B	33B	33B	66D
4.3	16A		20B	20B	20B	20B	20D	20D	23B	23B	43B	16B	16A	20A	20A	36C
5.1	16E	49F	33G	33G	33G	33G			33G	33G	43G	26G	26E	23E	23E	49G
5.2	13C		20E	20E	20E	20E	20B	20B	23E	23E	20E	13E	13C	16C	16C	23E
5.3	10A		10A	10A	10A	10A	16B	16B	13A	13A	10A	10A	10A	10A	10A	20B
6.1	79D								108F	108F	197G	108F	89D	72D	72D	125L
6.2	108G	79H							115I	115I	180I	115I	108G	108G	108G	131J
6.3	72F	75H	89H	89H	89H	89H			115H	115H	131G	115H	89F	72F	72F	89H
6.4	52D		52G	52G	52G	52G			52F	52F	115E	52F	52D	52D	52D	69F
7.1	79H	348H							85J	85J	180I	108J	108H	98H	98H	108J
7.2	72G	325H							98I	98I	148I	82I	89G	89G	89G	98I
7.3	72F								92H	92H	115G	89H	89F	79F	79F	98H
7.4	66E	276H	79F	79F	79F	79F			75H	75H	92G	82H	79F	72F	72F	89F
8.1	98H	151D							98K	98K	164J	115L	98J	98J	98J	115K
8.2	85F	125D							92J	92J	164H	85J	98H	98H	98H	92J
8.3	33D								46H	46H	115F	39H	33F	33F	33F	66H
9.1	10A		10B	10B	10B	10B			10B	10B	10B	10B	10A	10A	10A	16C
10.1																

# Visual Index - Drills

	HSS	HSS	HSS	HSS	HSS-E	HSS HM	HSS HM	HM	HM	HM	HSS	HSS	HSS	HSS	HSS	HSS
		ANSI	ANSI	ANSI	ANSI		DIN 338									
	4XD	4XD	4XD	1.5XD	4XD	4XD	4XD	3XD	3XD	1XD	1XD	1XD	1XD	1XD	1XD	1XD
							N									
	A170	R56	R57	R58	R56CO	D444	A160	D33F D33W D33L	D33M	DS-90 DS-120 DS-142	SPS-90	SPSG-90	SPS-120	SPSG-120	SPR-90	SPRG-90
	13.00 - 1.1/2	33/64 - 1.1/2	33/64 - 1.1/2	1" - 2"	33/64 - 1"	N32 - 1/2	4.00 - 16.00	N68 - 1/2	0.80 - 12.00	1/8 - 1/2	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 1"
	176	178	180	182	183	184	186	187	190	191	192	192	192	192	193	193
1.1	115H	115H	115H	98F	115H	197E	197E	279S	279S	279S	115E	115E	115E	115E	115E	115E
1.2	98H	98H	98H	59F	98H	197E	197E	246S	246S	246S	98E	98E	98E	98E	98E	98E
1.3	82F	82F	82F	66H	82F	180D	180D	246S	246S	246S	89C	89C	89C	89C	89C	89C
1.4	66E	66E	66E	59F	66E	164D	164D	230S	230S	230S	69C	69C	69C	69C	69C	69C
1.5	43D	43D	43D	46D	43D	131C	131C	148S	148S	148S	46C	46C	46C	46C	46C	46C
1.6	30C	30C	30C		30C	121A	121A	148S	148S	148S	33B	33B	33B	33B	33B	33B
1.7								98S	98S	98S						
1.8								98S	98S	98S						
2.1	49D	49D	49D	89H	49D	131B	131B	98S	98S	174S	52C	52C	52C	52C	52C	52C
2.2	23F	23F	23F	49F	23F	115C	115C			148S	30D	30D	30D	30D	30D	30D
2.3	23B	23B	23B	49D	23B	115A	115A				33B	33B	33B	33B	33B	33B
2.4																
3.1	89H	89H	89H	151H	89H	164C	164C	246T	246T	246T	105E	105E	105E	105E	105E	105E
3.2	72E	72E	72E	79H	72E	131A	131A	246T	246T	246T	89C	89C	89C	89C	89C	89C
3.3	62D	62D	62D	79F	62D	115A	115A	180T	180T	180T	66C	66C	66C	66C	66C	66C
3.4	39D	39D	39D		39D	98A	98A	180T	180T	180T	52B	52B	52B	52B	52B	52B
4.1	56E	56E	56E	89H	56E	115A	115A			148T	89C	89C	89C	89C	89C	89C
4.2	30C	30C	30C	49F	30C	115A	115A			115T	39B	39B	39B	39B	39B	39B
4.3	16A	16A	16A		16A	82A	82A			82S	23A	23A	23A	23A	23A	23A
5.1	26F	26F	26F	49F	26F	98A	98A			148T	43D	43D	43D	43D	43D	43D
5.2	13D	13D	13D	23F	13D	82A	82A			98S	26C	26C	26C	26C	26C	26C
5.3	10A	10A	10A	13B	10A	66A	66A			66S	13A	13A	13A	13A	13A	13A
6.1	115F	115F	115F	108F	115F	180D	180D			902V	89D	89D	89D	89D	89D	89D
6.2	108H	108H	108H	115H	108H	230G	230G	820V	820V	820V	108E	108E	108E	108E	108E	108E
6.3	89G	89G	89G	115H	89G	197C	197C	820V	820V	820V	89D	89D	89D	89D	89D	89D
6.4	52F	52F	52F	52F	52F	164C	164C			230T	52D	52D	52D	52D	52D	52D
7.1	108I	108I	108I	85I	108I	164I	164I	656V	656V	656V	108E	108E	108E	108E	108E	108E
7.2	98H	98H	98H	98H	98H	148H	148H	656V	656V	656V	98E	98E	98E	98E	98E	98E
7.3	89G	89G	89G	92H	89G	131G	131G	367V	367V	367V	98D	98D	98D	98D	98D	98D
7.4	72G	72G	72G	75H	72G	115F	115F	197V	197V	197V	82D	82D	82D	82D	82D	82D
8.1	98I	98I	98I	98I	98I			197X	197X	197X	98F	98F	98F	98F	98F	98F
8.2	92G	92G	92G	92I	92G	197E	197E	328V	328V	328V	115E	115E	115E	115E	115E	115E
8.3	46E	46E	46E	46H	46E						56D	56D	56D	56D	56D	56D
9.1	10A	10A	10A	10B	10A	30C	30C				39A	39A	39A	39A	39A	39A
10.1																



# Visual Index - Drills

	HSS	HSS	HSS	HSS	HSS	HSS	HM	HSS	HSS	HSS	HSS-E	HSS	HSS	HSS	HSS	
	1XD	1XD	1XD	1XD	1XD	1XD	1XD	1XD	1XD	1XD	1XD	1.5XD			4XD	
	SPR-120	SPRG-120	SPL-90	SPLG-90	SPL-120	SPLG-120	DC	76HA	A225	A217	A218	A221	TS41	TS10 TS18	TS51 TS52	ATR41
	1/4 - 1"	1/4 - 1/2	1/4 - 1"	1/4 - 1"	1/4 - 5/8	1/4 - 1/2	N0 - N6	N000 - N8	3/64 - 5/16	N1 - N8	N1 - N8	N00 - N8	N40 - N10	N40 - 1/4	N40 - 1/4	Size 1 - 4
	193	193	194	194	194	194	195	196	197	197	197	198	199	199	199	200
1.1	115E	115E	115E	115E	115E	115E	279S	115I	115I	115I	115I	115I	115J	115J	115J	
1.2	98E	98E	98E	98E	98E	98E	246S	98I	98I	98I	98I	98I	98J	98J	98J	
1.3	89C	89C	89C	89C	89C	89C	246S	82G	82G	82G	82G	82G	89G	89G	89G	82F
1.4	69C	69C	69C	69C	69C	69C	230S	66F	66F	66F	66F	66F	69G	69G	69G	66F
1.5	46C	46C	46C	46C	46C	46C	148S	43E	43E	43E	43E	43E	46F	46F	46F	43E
1.6	33B	33B	33B	33B	33B	33B	148S	30D	30D	30D	30D	30D	33E	33E	33E	30D
1.7							98S									
1.8							98S									
2.1	52C	52C	52C	52C	52C	52C		49E	49E	49E	49E	49E	52F	52F	52F	49E
2.2	30D	30D	30D	30D	30D	30D		26G	26G	26G	26G	26G	30H	30H	30H	26G
2.3	33B	33B	33B	33B	33B	33B		33C	33C	33C	33C	33C	33D	33D	33D	30C
2.4																
3.1	105E	105E	105E	105E	105E	105E	246T	98I	98I	98I	98I	98I	105J	105J	105J	98I
3.2	89C	89C	89C	89C	89C	89C	246T	79F	79F	79F	79F	79F	89G	89G	89G	79F
3.3	66C	66C	66C	66C	66C	66C	180T	66E	66E	66E	66E	66E	66F	66F	66F	66E
3.4	52B	52B	52B	52B	52B	52B	180T	46E	46E	46E	46E	46E	52F	52F	52F	46E
4.1	89C	89C	89C	89C	89C	89C		79F	79F	79F	79F	79F	89G	89G	89G	75F
4.2	39B	39B	39B	39B	39B	39B		43D	43D	43D	43D	43D	52E	52E	52E	39D
4.3	23A	23A	23A	23A	23A	23A		23B	23B	23B	23B	23B	26C	26C	26C	20B
5.1	43D	43D	43D	43D	43D	43D		33G	33G	33G	33G	33G	43H	43H	43H	33G
5.2	26C	26C	26C	26C	26C	26C		16E	16E	16E	16E	16E	26F	26F	26F	20E
5.3	13A	13A	13A	13A	13A	13A		13A	13A	13A	13A	13A	13B	13B	13B	10A
6.1	89D	89D	89D	89D	89D	89D		115G	115G	115G	115G	115G	118H	118H	118H	
6.2	108E	108E	108E	108E	108E	108E		820V	108I	108I	108I	108I	125J	125J	125J	
6.3	89D	89D	89D	89D	89D	89D		820V	89H	89H	89H	89H	89I	89I	89I	89H
6.4	52D	52D	52D	52D	52D	52D		52G	52G	52G	52G	52G	52H	52H	52H	52G
7.1	108E	108E	108E	108E	108E	108E		656V	108J	108J	108J	108J	108K	108K	108K	
7.2	98E	98E	98E	98E	98E	98E		656V	98I	98I	98I	98I	98J	98J	98J	
7.3	98D	98D	98D	98D	98D	98D		367V	89H	89H	89H	89H	98I	98I	98I	
7.4	82D	82D	82D	82D	82D	82D		197V	72H	72H	72H	72H	72H	72H	72H	79F
8.1	98F	98F	98F	98F	98F	98F		197X	98J	98J	98J	98J	98K	98K	98K	
8.2	115E	115E	115E	115E	115E	115E		328V	92H	92H	92H	92H	115I	115I	115I	
8.3	56D	56D	56D	56D	56D	56D			46F	46F	46F	46F	46F	46F	46F	
9.1	39A	39A	39A	39A	39A	39A			10B	10B	10B	10B	10B	10B	10B	
10.1																

# List Number Index - Drills



Pgs. 8 - 219

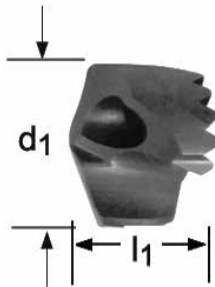
0860 .....	147	A921 .....	56	CO501-6 .....	162	R40 .....	117
209 .....	164	A940 .....	68	D33F .....	187	R40C .....	123
1290 .....	147	A941 .....	68	D33L .....	187	R41 .....	117
1511 .....	149	A951 .....	172	D33M .....	190	R41C .....	123
1813 .....	149	A952 .....	172	D33W .....	187	R42 .....	117
209CO .....	174	A976 .....	71	D444 .....	184	R42C .....	123
2A .....	82	A977 .....	71	DC .....	195	R453 .....	46
2AB .....	82	A978 .....	71	DS-90 .....	191	R454 .....	46
2ACO .....	110	ATR41 .....	200	DS-120 .....	191	R457 .....	40
4ASM .....	126	C114COMB .....	204	DS-142 .....	191	R458 .....	40
4ASMCO .....	134	C114COMBC .....	212	H853 .....	28	R459 .....	50
500-12 .....	160	C114COMBP .....	203	H855 .....	31	R51 .....	135
500-6 .....	157	C115COMB .....	204	H858 .....	34	R510 .....	44
501-12 .....	160	C115COMBC .....	212	H860 .....	37	R51FS .....	141
501-6 .....	157	C115COMBP .....	203	H861 .....	37	R52 .....	135
502-12 .....	160	C13R10CO .....	211	HX10 .....	92	R520 .....	38
502-6 .....	157	C15L10 .....	208	HX15 .....	92	R55 .....	135
5ATL .....	139	C15R10 .....	201	HX18 .....	92	R56 .....	178
5ATS .....	167	C15R10CO .....	211	L10 .....	89	R56CO .....	183
76HA .....	196	C15R10P .....	201	M40CO .....	131	R57 .....	180
A002 .....	82	C20R18 .....	202	M41CO .....	131	R58 .....	182
A012 .....	78	C20R18P .....	202	M42CO .....	131	R88CO .....	115
A022 .....	120	C21R10CO .....	211	M51CO .....	145	R89CO .....	115
A088 .....	114	C252A .....	205	M52CO .....	145	R950 .....	19
A094 .....	206	C252AB .....	205	QC0860P .....	154	R960 .....	22
A095 .....	207	C26M42CO .....	216	QC1290P .....	154	R970 .....	25
A097 .....	202	C26R15 .....	203	QC21G .....	106	S209 .....	164
A100 .....	82	C26R15CO .....	211	QC21GM .....	109	SPL-120 .....	194
A101 .....	90	C26R15P .....	203	QC21P .....	106	SPL-90 .....	194
A108 .....	101	C26R42 .....	213	QC21PM .....	109	SPLG-120 .....	194
A125 .....	149	C29HX10 .....	210	QC41G .....	128	SPLG-90 .....	194
A160 .....	186	C29L10 .....	208	QC41P .....	128	SPR-120 .....	193
A170 .....	176	C29M40CO .....	216	QC91G .....	142	SPR-90 .....	193
A190 .....	205	C29R10 .....	201	QC91GM .....	144	SPRG-120 .....	193
A191 .....	205	C29R10CO .....	211	QC91P .....	142	SPRG-90 .....	193
A217 .....	197	C29R10P .....	201	QC91PM .....	144	SPS-120 .....	192
A218 .....	197	C29R40 .....	213	R10 .....	74	SPS-90 .....	192
A221 .....	198	C29R40C .....	215	R10A .....	95	SPSG-120 .....	192
A225 .....	197	C29R51 .....	217	R10B .....	98	SPSG-90 .....	192
A243 .....	156	C33R56 .....	218	R10CO .....	110	TS10 .....	199
A244 .....	156	C502AB .....	205	R10H .....	101	TS18 .....	199
A245 .....	123	C60M41CO .....	216	R10P .....	74	TS41 .....	199
A287 .....	209	C60R18 .....	202	R15 .....	74	TS51 .....	199
A345 .....	170	C60R18CO .....	211	R15A .....	95	TS52 .....	199
A350 .....	167	C60R18P .....	202	R15B .....	98		
A510 .....	60	C60R41 .....	213	R15CO .....	110		
A520 .....	53	C60R41C .....	215	R15P .....	74		
A530 .....	167	C8R56 .....	218	R18 .....	74		
A553 .....	63	C8R56CO .....	218	R18A .....	95		
A720 .....	130	C8R57 .....	218	R18B .....	98		
A900 .....	65	CO500-12 .....	162	R18CO .....	110		
A901 .....	65	CO500-6 .....	162	R18H .....	101		
A920 .....	56	CO501-12 .....	162	R18P .....	74		

## Hydra Drill Head

### R950

1.3 1.4 1.5 1.6 2.4 3.3 3.4

Replaceable heads in tough micro-grain carbide for quick and easy tool changes. High productivity in a wide range of steels and harder materials. Superior hole accuracy and precise repeatable tolerances. Special Ti-phos coating for longer tool life.



R950



15/32 - 42.00

\* For more information on Hydra, see page 522

$d_1$ $\varnothing h_7$ Inch	$d_1$ $\varnothing h_7$ mm	$d_1$ decimal Inch	$l_1$ mm	Pack Qty	R950
15/32	11.91	0.4688	9.1	1	0010860
	12.00	0.4724	9.1	1	0010877
	12.10	0.4764	9.1	1	0037904
	12.20	0.4803	9.1	1	0037911
31/64	12.30	0.4844	9.1	1	0010884
	12.50	0.4921	9.4	1	0010907
1/2	12.60	0.4961	9.4	1	0037928
	12.70	0.5000	9.4	1	0010914
	12.80	0.5039	9.4	1	0037935
	12.90	0.5079	9.4	1	0037942
33/64	13.00	0.5118	9.7	1	0010921
	13.10	0.5156	9.7	1	0010938
	13.20	0.5197	9.7	1	0037959
17/32	13.49	0.5313	9.7	1	0010945
	13.50	0.5315	10.3	1	0010952
	13.60	0.5354	10.3	1	0037966
	13.70	0.5394	10.3	1	0037973
	13.80	0.5433	10.3	1	0037980
35/64	13.89	0.5469	10.3	1	0010969
	14.00	0.5512	10.3	1	0010983
	14.10	0.5551	10.3	1	0037997
	14.20	0.5591	10.3	1	0038000
9/16	14.29	0.5625	10.3	1	0011003
	14.50	0.5709	10.3	1	0011010
37/64	14.60	0.5748	11.0	1	0038017
	14.68	0.5781	11.0	1	0011140
	14.70	0.5787	11.0	1	0038024
	14.80	0.5827	11.0	1	0038031
	15.00	0.5906	11.0	1	0011201
19/32	15.08	0.5938	11.0	1	0011218
	15.10	0.5945	11.0	1	0038048
	15.20	0.5984	11.0	1	0038055
	15.24	0.6000	11.0	1	0032268

# HYDRA DRILL



d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>1</sub> mm	Pack Qty	R950
39/64	15.48	0.6094	11.0	1	0011232
	15.50	0.6102	11.0	1	0011362
	15.60	0.6142	11.6	1	0038062
5/8	15.70	0.6181	11.6	1	0038079
	15.88	0.6250	11.6	1	0011379
	16.00	0.6299	11.6	1	0011386
	16.08	0.6331	11.6	1	0032275
	16.10	0.6339	11.6	1	0038086
41/64	16.20	0.6378	11.6	1	0038093
	16.27	0.6406	11.6	1	0011393
	16.30	0.6417	11.6	1	0032282
	16.50	0.6496	11.6	1	0011409
	16.60	0.6535	12.2	1	0038109
21/32	16.67	0.6563	12.2	1	0012161
	16.70	0.6575	12.2	1	0038116
	17.00	0.6693	12.2	1	0012185
43/64	17.07	0.6719	12.2	1	0012215
	17.10	0.6732	12.2	1	0038123
	17.20	0.6772	12.2	1	0038130
11/16	17.46	0.6875	12.2	1	0012239
	17.50	0.6890	12.2	1	0012253
	17.60	0.6929	12.9	1	0032299
45/64	17.70	0.6969	12.9	1	0038147
	17.86	0.7031	12.9	1	0012260
	18.00	0.7087	12.9	1	0012277
	18.10	0.7126	12.9	1	0038154
	18.20	0.7165	12.9	1	0038161
23/32	18.26	0.7188	12.9	1	0012284
	18.50	0.7283	12.9	1	0012307
	18.60	0.7323	13.5	1	0038178
47/64	18.65	0.7344	13.5	1	0012321
	18.70	0.7362	13.5	1	0038185
	18.90	0.7441	13.5	1	0038192
	19.00	0.7480	13.5	1	0012338
	3/4	19.05	0.7500	13.5	1
19.10		0.7520	13.5	1	0038208
19.20		0.7559	13.5	1	0038215
19.25		0.7579	13.5	1	0032305
19.30		0.7598	13.5	1	0032312
19.35		0.7618	13.5	1	0032329
49/64	19.45	0.7656	13.5	1	0012376
	19.50	0.7677	13.5	1	0012383
	19.60	0.7717	14.1	1	0038222
	19.70	0.7756	14.1	1	0038239
	25/32	19.84	0.7813	14.1	1
20.00		0.7874	14.1	1	0012413
51/64		20.24	0.7969	14.1	1
	20.50	0.8071	14.1	1	0012451
	13/16	20.64	0.8125	14.8	1
21.00		0.8268	14.8	1	0012475
53/64		21.03	0.8281	14.8	1
27/32	21.43	0.8438	14.8	1	0012550
	21.50	0.8465	14.8	1	0012574
55/64	21.83	0.8594	15.0	1	0012604
	22.00	0.8661	15.0	1	0012628
	7/8	22.22	0.8750	15.0	1
22.50		0.8858	15.0	1	0032336
57/64		22.62	0.8906	15.0	1
	22.70	0.8937	15.0	1	0038246
	23.00	0.9055	15.1	1	0012666
29/32	23.02	0.9063	15.1	1	0012673
59/64	23.42	0.9219	15.1	1	0012680
	23.50	0.9252	15.1	1	0038253
15/16	23.81	0.9375	15.4	1	0012703
	24.00	0.9449	15.4	1	0012727

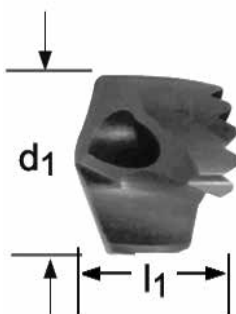
d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>1</sub> mm	Pack Qty	R950
61/64	24.21	0.9531	15.4	1	0012741
	24.50	0.9646	15.4	1	0038260
31/32	24.61	0.9688	15.4	1	0012772
	25.00	0.9844	15.8	1	0012819
63/64	25.00	0.9844	15.8	1	0012826
1"	25.40	1.0000	15.8	1	0012833
	25.50	1.0039	15.8	1	0038277
	25.65	1.0098	15.8	1	0032343
1.1/64	25.80	1.0156	15.8	1	0012840
	26.00	1.0236	16.4	1	0013090
1.1/32	26.19	1.0313	16.4	1	0013120
	26.50	1.0433	16.4	1	0038284
1.3/64	26.59	1.0469	16.4	1	0013229
1.1/16	26.99	1.0625	17.1	1	0013243
	27.00	1.0630	17.1	1	0013267
1.5/64	27.38	1.0781	17.1	1	0013274
	27.50	1.0827	17.1	1	0038291
1.3/32	27.78	1.0938	17.1	1	0013281
	28.00	1.1024	17.7	1	0013304
1.7/64	28.18	1.1094	17.7	1	0013311
	28.50	1.1220	17.7	1	0038307
1.1/8	28.58	1.1250	17.7	1	0013328
1.9/64	28.97	1.1406	18.3	1	0013342
	29.00	1.1417	18.3	1	0013366
1.5/32	29.37	1.1563	18.3	1	0013380
	29.50	1.1614	18.3	1	0038314
1.11/64	29.77	1.1719	18.3	1	0013427
	30.00	1.1811	19.0	1	0013434
1.3/16	30.16	1.1875	19.0	1	0013441
	30.50	1.2008	19.0	1	0013465
1.7/32	30.96	1.2188	21.0	1	46104481
	31.00	1.2205	21.0	1	46104482
1.1/4	31.75	1.2500	21.0	1	46104483
	32.00	1.2598	21.0	1	46104484
	32.50	1.2795	21.0	1	46104485
1.19/64	32.94	1.2969	21.0	1	46104486
	33.00	1.2992	21.0	1	46104487
	33.50	1.3189	21.0	1	46104488
	34.00	1.3386	23.0	1	46104489
1.11/32	34.13	1.3438	23.0	1	46104530
	34.50	1.3583	23.0	1	46104531
1.3/8	34.93	1.3750	23.0	1	46104532
	35.00	1.3780	23.0	1	46104533
	36.00	1.4173	23.0	1	46104534
1.27/64	36.12	1.4219	23.0	1	46104535
	36.50	1.4370	23.0	1	46104536
	37.00	1.4567	25.0	1	46104537
1.15/32	37.31	1.4688	25.0	1	46104538
	37.50	1.4764	25.0	1	46104539
	38.00	1.4961	25.0	1	46104540
1.1/2	38.10	1.5000	25.0	1	46104541
	38.50	1.5157	25.0	1	46104542
1.17/32	38.89	1.5313	25.0	1	46104543
	39.00	1.5354	25.0	1	46104544
	39.50	1.5551	25.0	1	46104545
1.9/16	39.69	1.5625	27.0	1	46104546
	40.00	1.5748	27.0	1	46104547
	41.00	1.6142	27.0	1	46104548
1.5/8	41.28	1.6250	27.0	1	46104549
	42.00	1.6535	27.0	1	46104550

## Hydra Drill Head

### R960

1.1 1.2 2.1 2.2 2.3 3.1 3.2 4.1 4.2 4.3 5.1 5.2 5.3

Replaceable heads in tough micro-grain carbide for quick and easy tool changes. High productivity across a wide range of stainless steel, cast iron & heat resistant materials. Superior hole accuracy and precise repeatable tolerances. Special Ti-phon coating for longer tool life.



R960



15/32 - 30.50

\* For more information on Hydra, see page 522

$d_1$ Øh <sub>7</sub> Inch	$d_1$ Øh <sub>7</sub> mm	$d_1$ decimal Inch	$l_1$ mm	Pack Qty	R960
15/32	11.91	0.4688	9.1	1	0013472
	12.00	0.4724	9.1	1	0013489
	12.10	0.4764	9.1	1	0038338
31/64	12.20	0.4803	9.1	1	0038376
	12.30	0.4844	9.1	1	0013496
	12.50	0.4921	9.4	1	0013519
1/2	12.60	0.4961	9.4	1	0038413
	12.70	0.5000	9.4	1	0013526
	12.80	0.5039	9.4	1	0038437
33/64	12.90	0.5079	9.4	1	0038451
	13.00	0.5118	9.7	1	0013533
	13.10	0.5156	9.7	1	0013540
17/32	13.20	0.5197	9.7	1	0038468
	13.49	0.5313	9.7	1	0013557
	13.50	0.5315	10.3	1	0016022
35/64	13.60	0.5354	10.3	1	0038499
	13.70	0.5394	10.3	1	0038529
	13.80	0.5433	10.3	1	0038543
9/16	13.89	0.5469	10.3	1	0016039
	14.00	0.5512	10.3	1	0016046
	14.10	0.5551	10.3	1	0038567
37/64	14.20	0.5591	10.3	1	0038574
	14.29	0.5625	10.3	1	0016053
	14.50	0.5709	10.3	1	0016060
19/32	14.60	0.5748	11.0	1	0038581
	14.68	0.5781	11.0	1	0016077
	14.70	0.5787	11.0	1	0039601
39/64	14.80	0.5827	11.0	1	0039618
	15.00	0.5906	11.0	1	0016084
	15.08	0.5938	11.0	1	0016091
41/64	15.10	0.5945	11.0	1	0039625
	15.20	0.5984	11.0	1	0039632
	15.24	0.6000	11.0	1	0032350

d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>1</sub> mm	Pack Qty	R960
39/64	15.48	0.6094	11.0	1	0016107
	15.50	0.6102	11.0	1	0016114
	15.60	0.6142	11.6	1	0039649
5/8	15.70	0.6181	11.6	1	0039656
	15.88	0.6250	11.6	1	0016121
	16.00	0.6299	11.6	1	0016138
	16.08	0.6331	11.6	1	0032367
	16.10	0.6339	11.6	1	0039663
41/64	16.20	0.6378	11.6	1	0039670
	16.27	0.6406	11.6	1	0016145
	16.30	0.6417	11.6	1	0032374
	16.50	0.6496	11.6	1	0016152
21/32	16.60	0.6535	12.2	1	0039687
	16.67	0.6563	12.2	1	0016169
	16.70	0.6575	12.2	1	0039694
	17.00	0.6693	12.2	1	0016176
	17.07	0.6719	12.2	1	0016183
43/64	17.10	0.6732	12.2	1	0039700
	17.20	0.6772	12.2	1	0039717
	17.46	0.6875	12.2	1	0016190
11/16	17.50	0.6890	12.2	1	0016503
	17.60	0.6929	12.9	1	0032381
	17.70	0.6969	12.9	1	0039724
45/64	17.86	0.7031	12.9	1	0016640
	18.00	0.7087	12.9	1	0016664
	18.10	0.7126	12.9	1	0039731
	18.20	0.7165	12.9	1	0039748
23/32	18.26	0.7188	12.9	1	0016671
	18.50	0.7283	12.9	1	0016688
47/64	18.60	0.7323	13.5	1	0039755
	18.65	0.7344	13.5	1	0016695
	18.70	0.7362	13.5	1	0039762
	18.90	0.7441	13.5	1	0039779
	19.00	0.7480	13.5	1	0016817
3/4	19.05	0.7500	13.5	1	0016879
	19.10	0.7520	13.5	1	0039786
	19.20	0.7559	13.5	1	0039793
	19.25	0.7579	13.5	1	0032398
	19.30	0.7598	13.5	1	0032404
49/64	19.35	0.7618	13.5	1	0032411
	19.45	0.7656	13.5	1	0016886
	19.50	0.7677	13.5	1	0016947
	19.60	0.7717	14.1	1	0039809
	19.70	0.7756	14.1	1	0039816
25/32	19.84	0.7813	14.1	1	0016954
	20.00	0.7874	14.1	1	0017111
51/64	20.24	0.7969	14.1	1	0017128
	20.50	0.8071	14.1	1	0017159
13/16	20.64	0.8125	14.8	1	0017197
	21.00	0.8268	14.8	1	0017166
53/64	21.03	0.8281	14.8	1	0017203
27/32	21.43	0.8438	14.8	1	0017227
	21.50	0.8465	14.8	1	0017234
55/64	21.83	0.8594	15.0	1	0017241
	22.00	0.8661	15.0	1	0017258
7/8	22.22	0.8750	15.0	1	0017371
	22.50	0.8858	15.0	1	0032428
57/64	22.62	0.8906	15.0	1	0017401
	22.70	0.8937	15.0	1	0039823
	23.00	0.9055	15.1	1	0017425
	23.02	0.9063	15.1	1	0017432
29/32	23.42	0.9219	15.1	1	0017456
59/64	23.50	0.9252	15.1	1	0039830
15/16	23.81	0.9375	15.4	1	0017562
	24.00	0.9449	15.4	1	0017579
61/64	24.21	0.9531	15.4	1	0017586

# HYDRA DRILL



d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>1</sub> mm	Pack Qty	R960
	24.50	0.9646	15.4	1	0039847
31/32	24.61	0.9688	15.4	1	0017593
	25.00	0.9844	15.8	1	0017722
63/64	25.00	0.9844	15.8	1	0017746
1"	25.40	1.0000	15.8	1	0017753
	25.50	1.0039	15.8	1	0039854
	25.65	1.0098	15.8	1	0032435
1.1/64	25.80	1.0156	15.8	1	0018958
	26.00	1.0236	16.4	1	0018965
1.1/32	26.19	1.0312	16.4	1	0018972
	26.50	1.0433	16.4	1	0039878
1.3/64	26.59	1.0469	16.4	1	0018989
1.1/16	26.99	1.0625	17.1	1	0018996
	27.00	1.0630	17.1	1	0019009
1.5/64	27.38	1.0781	17.1	1	0019016
	27.50	1.0827	17.1	1	0039885
1.3/32	27.78	1.0938	17.1	1	0019023
	28.00	1.1024	17.7	1	0019030
1.7/64	28.18	1.1094	17.7	1	0019047
	28.50	1.1220	17.7	1	0039892
1.1/8	28.58	1.1250	17.7	1	0019054
1.9/64	28.97	1.1406	18.3	1	0019061
	29.00	1.1417	18.3	1	0019078
1.5/32	29.37	1.1563	18.3	1	0019085
	29.50	1.1614	18.3	1	0039908
1.11/64	29.77	1.1719	18.3	1	0019092
	30.00	1.1811	19.0	1	0019108
1.3/16	30.16	1.1875	19.0	1	0019115
	30.50	1.2008	19.0	1	0019122

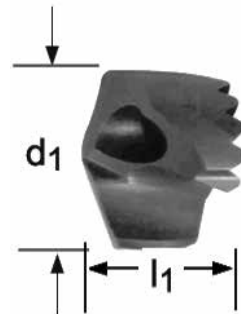


## Hydra Drill Head

### R970

1.1 1.2 2.1 2.2 2.3 3.1 3.2 4.1 4.2 4.3 5.1 5.2 5.3

Replaceable heads in tough micro-grain carbide for quick and easy tool changes. Engineered for high productivity of cast iron materials. Superior hole accuracy and precise repeatable tolerances. Special Ti-phos coating for longer tool life.



R970



15/32 - 30.50

\* For more information on Hydra, see page 522

$d_1$ $\varnothing h_7$ Inch	$d_1$ $\varnothing h_7$ mm	$d_1$ decimal Inch	$l_1$ mm	Pack Qty	R970
15/32		0.4689	9.1	1	7332946
	12.0	0.4724	9.1	1	7332947
	12.1	0.4764	9.1	1	7332948
	12.2	0.4803	9.1	1	7332949
31/64		0.4844	9.1	1	7332980
	12.5	0.4921	9.4	1	7332981
1/2	12.6	0.4961	9.4	1	7332982
		0.5000	9.4	1	7332983
	12.8	0.5039	9.4	1	7332984
	12.9	0.5079	9.4	1	7332985
33/64	13.0	0.5118	9.7	1	7332986
		0.5156	9.7	1	7332987
	13.2	0.5197	9.7	1	7332988
17/32		0.5313	9.7	1	7332989
	13.5	0.5315	10.3	1	7332990
	13.6	0.5354	10.3	1	7332991
	13.7	0.5394	10.3	1	7332992
	13.8	0.5433	10.3	1	7332993
	35/64	0.5469	10.3	1	7332994
		0.5512	10.3	1	7332995
		0.5551	10.3	1	7332996
9/16	14.2	0.5591	10.3	1	7332997
		0.5625	10.3	1	7332998
	14.5	0.5709	10.3	1	7332999
	14.6	0.5748	11.0	1	7333000
37/64		0.5781	11.0	1	7333001
	14.7	0.5787	11.0	1	7333002
	14.8	0.5827	11.0	1	7333003
	15.0	0.5906	11.0	1	7333004
	19/32	0.5938	11.0	1	7333005
	15.1	0.5945	11.0	1	7333006
	15.2	0.5984	11.0	1	7333007

# HYDRA DRILL



d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>1</sub> mm	Pack Qty	R970
	15.24	0.6000	11.0	1	7333008
39/64		0.6094	11.0	1	7333009
	15.5	0.6102	11.6	1	7333010
	15.6	0.6142	11.6	1	7333011
	15.7	0.6181	11.6	1	7333012
5/8		0.6250	11.6	1	7333013
	16.0	0.6299	11.6	1	7333014
	16.08	0.6331	11.6	1	7333015
	16.1	0.6339	11.6	1	7333016
	16.2	0.6378	11.6	1	7333017
41/64		0.6406	11.6	1	7333018
	16.3	0.6417	11.6	1	7333019
	16.5	0.6496	11.6	1	7333020
	16.6	0.6535	12.2	1	7333021
21/32		0.6563	12.2	1	7333022
	16.7	0.6575	12.2	1	7333023
	17.0	0.6693	12.2	1	7333024
43/64		0.6719	12.2	1	7333025
	17.1	0.6732	12.2	1	7333026
	17.2	0.6772	12.2	1	7333027
11/16		0.6875	12.2	1	7333028
	17.5	0.6890	12.2	1	7333029
	17.6	0.6929	12.9	1	7333030
	17.7	0.6969	12.9	1	7333031
45/64		0.7031	12.9	1	7333032
	18.0	0.7087	12.9	1	7333033
	18.1	0.7126	12.9	1	7333034
	18.2	0.7165	12.9	1	7333035
23/32		0.7188	12.9	1	7333036
	18.5	0.7283	12.9	1	7333037
	18.6	0.7323	13.5	1	7333038
47/64		0.7344	13.5	1	7333039
	18.7	0.7362	13.5	1	7333040
	18.9	0.7441	13.5	1	7333041
	19.0	0.7480	13.5	1	7333042
3/4		0.7500	13.5	1	7333043
	19.1	0.7520	13.5	1	7333044
	19.2	0.7559	13.5	1	7333045
	19.25	0.7579	13.5	1	7333046
	19.3	0.7598	13.5	1	7333047
	19.35	0.7618	13.5	1	7333048
49/64		0.7656	13.5	1	7333049
	19.5	0.7677	13.5	1	7333050
	19.6	0.7717	14.1	1	7333051
	19.7	0.7756	14.1	1	7333052
25/32		0.7813	14.1	1	7333053
	20.0	0.7874	14.1	1	7333054
51/64		0.7969	14.1	1	7333055
	20.5	0.8071	14.1	1	7333056
13/16		0.8125	14.8	1	7333057
	21.0	0.8268	14.8	1	7333058
53/64		0.8281	14.8	1	7333059
27/32		0.8438	14.8	1	7333060
	21.5	0.8465	14.8	1	7333061
55/64		0.8594	15.0	1	7333062
	22.0	0.8661	15.0	1	7333063
7/8		0.8750	15.0	1	7333064
	22.5	0.8858	15.0	1	7333065
57/64		0.8906	15.0	1	7333066
	22.7	0.8937	15.0	1	7333067
	23.0	0.9055	15.1	1	7333068
29/32		0.9063	15.1	1	7333069
59/64		0.9219	15.1	1	7333070
	23.5	0.9252	15.1	1	7333071
15/16		0.9375	15.4	1	7333072
	24.0	0.9449	15.4	1	7333073

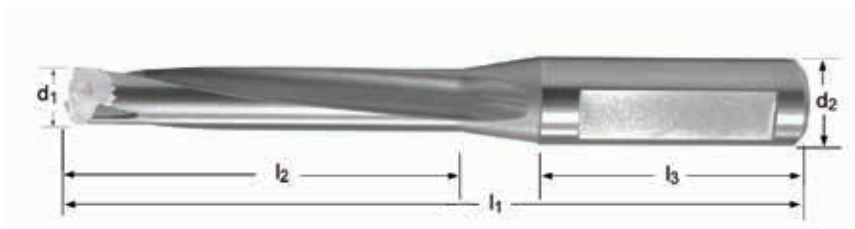
$d_1$ $\varnothing h_7$ Inch	$d_1$ $\varnothing h_7$ mm	$d_1$ decimal Inch	$l_1$ mm	Pack Qty	R970
61/64		0.9531	15.4	1	7333074
	24.5	0.9646	15.4	1	7333075
31/32		0.9688	15.4	1	7333076
	25.0	0.9843	15.8	1	7333077
63/64		0.9844	15.8	1	7333078
1		1.0000	15.8	1	7333079
	25.5	1.0039	15.8	1	7333080
	25.65	1.0098	15.8	1	7333081
1.1/64		1.0156	15.8	1	7333082
	26.0	1.0236	16.4	1	7333083
1.1/32		1.0313	16.4	1	7333084
	26.5	1.0433	16.4	1	7333085
1.3/64		1.0469	16.4	1	7333086
1.1/16		1.0625	17.1	1	7333087
	27.0	1.0630	17.1	1	7333088
1.5/64		1.0781	17.1	1	7333089
	27.5	1.0827	17.1	1	7333090
1.3/32		1.0938	17.1	1	7333091
	28.0	1.1024	17.7	1	7333092
1.7/64		1.1094	17.7	1	7333093
	28.5	1.1220	17.7	1	7333094
1.1/8		1.1250	17.7	1	7333095
1.9/64		1.1406	18.3	1	7333096
	29.0	1.1417	18.3	1	7333097
1.5/32		1.1563	18.3	1	7333098
	29.5	1.1614	18.3	1	7333099
1.11/64		1.1719	18.3	1	7333100
	30.0	1.1811	19.0	1	7333101
1.3/16		1.1875	19.0	1	7333102
	30.5	1.2008	19.0	1	7333103
1.7/32		1.2188	21.0	1	7333104
	31.0	1.2205	21.0	1	7333105
1.1/4		1.2500	21.0	1	7333106
	32.0	1.2598	21.0	1	7333107
	32.5	1.2795	21.0	1	7333108
1.19/64		1.2968	21.0	1	7333109
	33.0	1.2992	21.0	1	7333110
	33.5	1.3189	21.0	1	7333111
	34.0	1.3386	23.0	1	7333112
1.11/32		1.3438	23.0	1	7333113
	34.5	1.3583	23.0	1	7333114
1.3/8		1.3750	23.0	1	7333115
	35.0	1.3780	23.0	1	7333116
	36.0	1.4173	23.0	1	7333117
1.27/64		1.4219	23.0	1	7333118
	36.5	1.4370	23.0	1	7333119
	37.0	1.4567	25.0	1	7333120
1.15/32		1.4688	25.0	1	7333121
	37.5	1.4764	25.0	1	7333122
	38.0	1.4961	25.0	1	7333123
1.1/2		1.5000	25.0	1	7333124
	38.5	1.5157	25.0	1	7333125
1.17/32		1.5313	25.0	1	7333126
	39.0	1.5354	25.0	1	7333127
	39.5	1.5551	25.0	1	7333128
1.9/16		1.5625	27.0	1	7333129
	40.0	1.5748	27.0	1	7333130
	41.0	1.6142	27.0	1	7333131
1.5/8		1.6250	27.0	1	7333132
	42.0	1.6535	27.0	1	7333133



## 3xD Hydra Bodies

### H853

Cylindrical shank with flat for multi-purpose tool holding. Allows accurate clamping for reliable use of internal coolant.



**H853**  
Coolant Through



12.00 - 42.50

Four (4) screws and one (1) screwdriver are included with a drill body

\* For more information on Hydra, see page 522

Hydra Head Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#
15/32	0010860	0013472	7332946	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.0	0010877	0013489	7332947	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.1	0037904	0038338	7332948	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.2	0037911	0038376	7332949	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
31/64	0010884	0013496	7332980	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.5	0010907	0013519	7332981	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.6	0037928	0038413	7332982	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
1/2	0010914	0013526	7332983	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.8	0037935	0038437	7332984	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.9	0037942	0038451	7332985	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
13.0	0010921	0013533	7332986	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
33/64	0010938	0013540	7332987	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
13.2	0037959	0038468	7332988	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
17/32	0010945	0013557	7332989	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
13.5	0010952	0016022	7332990	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.6	0037966	0038499	7332991	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.7	0037973	0038529	7332992	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.8	0037980	0038543	7332993	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
35/64	0010969	0016039	7332994	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.0	0010983	0016046	7332995	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.1	0037997	0038567	7332996	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.2	0038000	0038574	7332997	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
9/16	0011003	0016053	7332998	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.5	0011010	0016060	7332999	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.6	0038017	0038581	7333000	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
37/64	0011140	0016077	7333001	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
14.7	0038024	0039601	7333002	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
14.8	0038031	0039618	7333003	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.0	0011201	0016084	7333004	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
19/32	0011218	0016091	7333005	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.1	0038048	0039625	7333006	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.2	0038055	0039632	7333007	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.24	0032268	0032350	7333008	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
39/64	0011232	0016107	7333009	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.5	0011362	0016114	7333010	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293

Hydra Head d <sub>1</sub> Ø	Hydra Head R950	Hydra Head R960	Hydra Head R970	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
	EDP#	EDP#	EDP#	d <sub>2</sub> Øh <sub>6</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#
15.6	0038062	0039649	7333011	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
15.7	0038079	0039656	7333012	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
5/8	0011379	0016121	7333013	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.0	0011386	0016138	7333014	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.08	0032275	0032367	7333015	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.1	0038086	0039663	7333016	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.2	0038093	0039670	7333017	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
41/64	0011393	0016145	7333018	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.3	0032282	0032374	7333019	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.5	0011409	0016152	7333020	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.6	0038109	0039687	7333021	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
21/32	0012161	0016169	7333022	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
16.7	0038116	0039694	7333023	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.0	0012185	0016176	7333024	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
43/64	0012215	0016183	7333025	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.1	0038123	0039700	7333026	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.2	0038130	0039717	7333027	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
11/16	0012239	0016190	7333028	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.5	0012253	0016503	7333029	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.6	0032299	0032381	7333030	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
17.7	0038147	0039724	7333031	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
45/64	0012260	0016640	7333032	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.0	0012277	0016664	7333033	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.1	0038154	0039731	7333034	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.2	0038161	0039748	7333035	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
23/32	0012284	0016671	7333036	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.5	0012307	0016688	7333037	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.6	0038178	0039755	7333038	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
47/64	0012321	0016695	7333039	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
18.7	0038185	0039762	7333040	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
18.9	0038192	0039779	7333041	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.0	0012338	0016817	7333042	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
3/4	0012345	0016879	7333043	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.1	0038208	0039786	7333044	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.2	0038215	0039793	7333045	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.25	0032305	0032398	7333046	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.3	0032312	0032404	7333047	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.35	0032329	0032411	7333048	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
49/64	0012376	0016886	7333049	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.5	0012383	0016947	7333050	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.6	0038222	0039809	7333051	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
19.7	0038239	0039816	7333052	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
25/32	0012406	0016954	7333053	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
20.0	0012413	0017111	7333054	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
51/64	0012437	0017128	7333055	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
20.5	0012451	0017159	7333056	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
13/16	0012468	0017197	7333057	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
21.0	0012475	0017166	7333058	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
53/64	0012536	0017203	7333059	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
27/32	0012550	0017227	7333060	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
21.5	0012574	0017234	7333061	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
55/64	0012604	0017241	7333062	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.0	0012628	0017258	7333063	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
7/8	0012635	0017371	7333064	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.5	0032336	0032428	7333065	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
57/64	0012642	0017401	7333066	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.7	0038246	0039823	7333067	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
23.0	0012666	0017425	7333068	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
29/32	0012673	0017432	7333069	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
59/64	0012680	0017456	7333070	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
23.5	0038253	0039830	7333071	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385

# HYDRA DRILL



Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H853 EDP#
15/16	0012703	0017562	7333072	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
24.0	0012727	0017579	7333073	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
61/64	0012741	0017586	7333074	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
24.5	0038260	0039847	7333075	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
31/32	0012772	0017593	7333076	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
25.0	0012819	0017722	7333077	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
63/64	0012826	0017746	7333078	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
1	0012833	0017753	7333079	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
25.5	0038277	0039854	7333080	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
25.65	0032343	0032435	7333081	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
1.1/64	0012840	0018958	7333082	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
26.0	0013090	0018965	7333083	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.1/32	0013120	0018972	7333084	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
26.5	0038284	0039878	7333085	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.3/64	0013229	0018989	7333086	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.1/16	0013243	0018996	7333087	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
27.0	0013267	0019009	7333088	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
1.5/64	0013274	0019016	7333089	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
27.5	0038291	0039885	7333090	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
1.3/32	0013281	0019023	7333091	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
28.0	0013304	0019030	7333092	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.7/64	0013311	0019047	7333093	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
28.5	0038307	0039892	7333094	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.1/8	0013328	0019054	7333095	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.9/64	0013342	0019061	7333096	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
29.0	0013366	0019078	7333097	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
1.5/32	0013380	0019085	7333098	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
29.5	0038314	0039908	7333099	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
1.11/64	0013427	0019092	7333100	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
30.0	0013434	0019108	7333101	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
1.3/16	0013441	0019115	7333102	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
30.5	0013465	0019122	7333103	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
1.7/32	46104481	—	7333104	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
31.00	46104482	—	7333105	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
1.1/4	46104483	—	7333106	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
32.00	46104484	—	7333107	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
32.50	46104485	—	7333108	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
1.19/64	46104486	—	7333109	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
33.00	46104487	—	7333110	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
33.50	46104488	—	7333111	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
34.00	46104489	—	7333112	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
1.11/32	46104530	—	7333113	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
34.50	46104531	—	7333114	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
1.3/8	46104532	—	7333115	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
35.00	46104533	—	7333116	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
36.00	46104534	—	7333117	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
1.27/64	46104535	—	7333118	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
36.50	46104536	—	7333119	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
37.00	46104537	—	7333120	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
1.15/32	46104538	—	7333121	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
37.50	46104539	—	7333122	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
38.00	46104540	—	7333123	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
1.1/2	46104541	—	7333124	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
38.50	46104542	—	7333125	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
1.17/32	46104543	—	7333126	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
39.00	46104544	—	7333127	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
39.50	46104545	—	7333128	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
1.9/16	46104546	—	7333129	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
40.00	46104547	—	7333130	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
41.00	46104548	—	7333131	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
1.5/8	46104549	—	7333132	—	—	—	—	—	40.0	151.5	251.5	70.0	46111412
42.00	46104550	—	7333133	—	—	—	—	—	40.0	151.5	251.5	70.0	46111412

## 5xD Hydra Bodies

### H855

Cylindrical shank with flat for multi-purpose tool holding. Allows accurate clamping for reliable use of internal coolant.



Four (4) screws and one (1) screwdriver are included with a drill body

\* For more information on Hydra, see page 522

**H855 Coolant Through**

DIN 6535HE

5XD

HSS

140°

12.00 - 42.50

Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	5xD Hydra Body - Fractional Shank					5xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>5</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#
15/32	0010860	0013472	7332946	5/8	69.0	130.0	48.0	0033586	16.0	69.0	130.0	48.0	0018460
12.0	0010877	0013489	7332947	5/8	69.0	130.0	48.0	0033586	16.0	69.0	130.0	48.0	0018460
12.1	0037904	0038338	7332948	5/8	69.0	130.0	48.0	0033586	16.0	69.0	130.0	48.0	0018460
12.2	0037911	0038376	7332949	5/8	69.0	130.0	48.0	0033586	16.0	69.0	130.0	48.0	0018460
31/64	0010884	0013496	7332980	5/8	69.0	130.0	48.0	0033586	16.0	69.0	130.0	48.0	0018460
12.5	0010907	0013519	7332981	5/8	69.0	130.0	48.0	0034095	16.0	69.0	130.0	48.0	0018477
12.6	0037928	0038413	7332982	5/8	69.0	130.0	48.0	0034095	16.0	69.0	130.0	48.0	0018477
1/2	0010914	0013526	7332983	5/8	69.0	130.0	48.0	0034095	16.0	69.0	130.0	48.0	0018477
12.8	0037935	0038437	7332984	5/8	69.0	130.0	48.0	0034095	16.0	69.0	130.0	48.0	0018477
12.9	0037942	0038451	7332985	5/8	69.0	130.0	48.0	0034095	16.0	69.0	130.0	48.0	0018477
13.0	0010921	0013533	7332986	5/8	74.0	140.0	48.0	0034132	16.0	74.0	140.0	48.0	0018484
33/64	0010938	0013540	7332987	5/8	74.0	140.0	48.0	0034132	16.0	74.0	140.0	48.0	0018484
13.2	0037959	0038468	7332988	5/8	74.0	140.0	48.0	0034132	16.0	74.0	140.0	48.0	0018484
17/32	0010945	0013557	7332989	5/8	74.0	140.0	48.0	0034132	16.0	74.0	140.0	48.0	0018484
13.5	0010952	0016022	7332990	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
13.6	0037966	0038499	7332991	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
13.7	0037973	0038529	7332992	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
13.8	0037980	0038543	7332993	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
35/64	0010969	0016039	7332994	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
14.0	0010983	0016046	7332995	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
14.1	0037997	0038567	7332996	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
14.2	0038000	0038574	7332997	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
9/16	0011003	0016053	7332998	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
14.5	0011010	0016060	7332999	3/4	81.5	146.5	48.0	0034699	16.0	81.5	146.5	48.0	0018491
14.6	0038017	0038581	7333000	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
37/64	0011140	0016077	7333001	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
14.7	0038024	0039601	7333002	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
14.8	0038031	0039618	7333003	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.0	0011201	0016084	7333004	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
19/32	0011218	0016091	7333005	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507

# HYDRA DRILL



Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	5xD Hydra Body - Fractional Shank					5xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#
15.1	0038048	0039625	7333006	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.2	0038055	0039632	7333007	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.24	0032268	0032350	7333008	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
39/64	0011232	0016107	7333009	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.5	0011362	0016114	7333010	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.6	0038062	0039649	7333011	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
15.7	0038079	0039656	7333012	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
5/8	0011379	0016121	7333013	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.0	0011386	0016138	7333014	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.08	0032275	0032367	7333015	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.1	0038086	0039663	7333016	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.2	0038093	0039670	7333017	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
41/64	0011393	0016145	7333018	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.3	0032282	0032374	7333019	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.5	0011409	0016152	7333020	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.6	0038109	0039687	7333021	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
21/32	0012161	0016169	7333022	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
16.7	0038116	0039694	7333023	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.0	0012185	0016176	7333024	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
43/64	0012215	0016183	7333025	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.1	0038123	0039700	7333026	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.2	0038130	0039717	7333027	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
11/16	0012239	0016190	7333028	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.5	0012253	0016503	7333029	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.6	0032299	0032381	7333030	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
17.7	0038147	0039724	7333031	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
45/64	0012260	0016640	7333032	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.0	0012277	0016664	7333033	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.1	0038154	0039731	7333034	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.2	0038161	0039748	7333035	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
23/32	0012284	0016671	7333036	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.5	0012307	0016688	7333037	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.6	0038178	0039755	7333038	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
47/64	0012321	0016695	7333039	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
18.7	0038185	0039762	7333040	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
18.9	0038192	0039779	7333041	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.0	0012338	0016817	7333042	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
3/4	0012345	0016879	7333043	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.1	0038208	0039786	7333044	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.2	0038215	0039793	7333045	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.25	0032305	0032398	7333046	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.3	0032312	0032404	7333047	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.35	0032329	0032411	7333048	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
49/64	0012376	0016886	7333049	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.5	0012383	0016947	7333050	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.6	0038222	0039809	7333051	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
19.7	0038239	0039816	7333052	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
25/32	0012406	0016954	7333053	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
20.0	0012413	0017111	7333054	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
51/64	0012437	0017128	7333055	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
20.5	0012451	0017159	7333056	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
13/16	0012468	0017197	7333057	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
21.0	0012475	0017166	7333058	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
53/64	0012536	0017203	7333059	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
27/32	0012550	0017227	7333060	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
21.5	0012574	0017234	7333061	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
55/64	0012604	0017241	7333062	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.0	0012628	0017258	7333063	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
7/8	0012635	0017371	7333064	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.5	0032336	0032428	7333065	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
57/64	0012642	0017401	7333066	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.7	0038246	0039823	7333067	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
23.0	0012666	0017425	7333068	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
29/32	0012673	0017432	7333069	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583



Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	5xD Hydra Body - Fractional Shank					5xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H855 EDP#
59/64	0012680	0017456	7333070	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
23.5	0038253	0039830	7333071	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
15/16	0012703	0017562	7333072	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
24.0	0012727	0017579	7333073	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
61/64	0012741	0017586	7333074	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
24.5	0038260	0039847	7333075	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
31/32	0012772	0017593	7333076	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
25.0	0012819	0017722	7333077	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
63/64	0012826	0017746	7333078	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
1	0012833	0017753	7333079	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
25.5	0038277	0039854	7333080	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
25.65	0032343	0032435	7333081	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
1.1/64	0012840	0018958	7333082	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
26.0	0013090	0018965	7333083	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.1/32	0013120	0018972	7333084	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
26.5	0038284	0039878	7333085	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.3/64	0013229	0018989	7333086	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.1/16	0013243	0018996	7333087	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
27.0	0013267	0019009	7333088	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
1.5/64	0013274	0019016	7333089	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
27.5	0038291	0039885	7333090	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
1.3/32	0013281	0019023	7333091	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
28.0	0013304	0019030	7333092	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.7/64	0013311	0019047	7333093	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
28.5	0038307	0039892	7333094	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.1/8	0013328	0019054	7333095	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.9/64	0013342	0019061	7333096	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
29.0	0013366	0019078	7333097	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
1.5/32	0013380	0019085	7333098	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
29.5	0038314	0039908	7333099	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
1.11/64	0013427	0019092	7333100	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
30.0	0013434	0019108	7333101	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
1.3/16	0013441	0019115	7333102	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
30.5	0013465	0019122	7333103	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
1.7/32	46104481	—	7333104	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
31.00	46104482	—	7333105	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
1.1/4	46104483	—	7333106	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
32.00	46104484	—	7333107	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
32.50	46104485	—	7333108	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
1.19/64	46104486	—	7333109	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
33.00	46104487	—	7333110	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
33.50	46104488	—	7333111	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
34.00	46104489	—	7333112	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
1.11/32	46104530	—	7333113	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
34.50	46104531	—	7333114	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
1.3/8	46104532	—	7333115	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
35.00	46104533	—	7333116	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
36.00	46104534	—	7333117	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
1.27/64	46104535	—	7333118	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
36.50	46104536	—	7333119	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
37.00	46104537	—	7333120	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
1.15/32	46104538	—	7333121	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
37.50	46104539	—	7333122	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
38.00	46104540	—	7333123	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
1.1/2	46104541	—	7333124	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
38.50	46104542	—	7333125	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
1.17/32	46104543	—	7333126	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
39.00	46104544	—	7333127	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
39.50	46104545	—	7333128	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
1.9/16	46104546	—	7333129	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
40.00	46104547	—	7333130	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
41.00	46104548	—	7333131	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
1.5/8	46104549	—	7333132	—	—	—	—	—	40.0	236.5	336.5	70.0	46111420
42.00	46104550	—	7333133	—	—	—	—	—	40.0	236.5	336.5	70.0	46111420

## 8xD Hydra Bodies

### H858

Cylindrical shank with flat for multi-purpose tool holding. Allows accurate clamping for reliable use of internal coolant.



**H858  
Coolant  
Through**

DIN  
6535HE  
DIN  
6535HE

**8XD**

**HSS**

**140°**



13.50 - 42.00



Four (4) screws and one (1) screwdriver are included with a drill body

\* For more information on Hydra, see page 522

Hydra Head $d_1 \text{ } \varnothing$	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	8xD Hydra Body - Metric Shank				
				$d_2 \text{ } \varnothing h_6$ mm	$l_2$ mm	$l_1$ mm	$l_3$ mm	H858 EDP#
13.5	0010952	0016022	7332990	16.0	124.5	191.5	48.0	0018668
13.6	0037966	0038499	7332991	16.0	124.5	191.5	48.0	0018668
13.7	0037973	0038529	7332992	16.0	124.5	191.5	48.0	0018668
13.8	0037980	0038543	7332993	16.0	124.5	191.5	48.0	0018668
35/64	0010969	0016039	7332994	16.0	124.5	191.5	48.0	0018668
14.0	0010983	0016046	7332995	16.0	124.5	191.5	48.0	0018668
14.1	0037997	0038567	7332996	16.0	124.5	191.5	48.0	0018668
14.2	0038000	0038574	7332997	16.0	124.5	191.5	48.0	0018668
9/16	0011003	0016053	7332998	16.0	124.5	191.5	48.0	0018668
14.5	0011010	0016060	7332999	16.0	124.5	191.5	48.0	0018668
14.6	0038017	0038581	7333000	20.0	133.5	201.5	50.0	0018675
37/64	0011140	0016077	7333001	20.0	133.5	201.5	50.0	0018675
14.7	0038024	0039601	7333002	20.0	133.5	201.5	50.0	0018675
14.8	0038031	0039618	7333003	20.0	133.5	201.5	50.0	0018675
15.0	0011201	0016084	7333004	20.0	133.5	201.5	50.0	0018675
19/32	0011218	0016091	7333005	20.0	133.5	201.5	50.0	0018675
15.1	0038048	0039625	7333006	20.0	133.5	201.5	50.0	0018675
15.2	0038055	0039632	7333007	20.0	133.5	201.5	50.0	0018675
15.24	0032268	0032350	7333008	20.0	133.5	201.5	50.0	0018675
39/64	0011232	0016107	7333009	20.0	133.5	201.5	50.0	0018675
15.5	0011362	0016114	7333010	20.0	133.5	201.5	50.0	0018675
15.6	0038062	0039649	7333011	20.0	141.5	211.5	50.0	0018682
15.7	0038079	0039656	7333012	20.0	141.5	211.5	50.0	0018682
5/8	0011379	0016121	7333013	20.0	141.5	211.5	50.0	0018682
16.0	0011386	0016138	7333014	20.0	141.5	211.5	50.0	0018682
16.08	0032275	0032367	7333015	20.0	141.5	211.5	50.0	0018682
16.1	0038086	0039663	7333016	20.0	141.5	211.5	50.0	0018682
16.2	0038093	0039670	7333017	20.0	141.5	211.5	50.0	0018682
41/64	0011393	0016145	7333018	20.0	141.5	211.5	50.0	0018682
16.3	0032282	0032374	7333019	20.0	141.5	211.5	50.0	0018682

Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	8xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H858 EDP#
16.5	0011409	0016152	7333020	20.0	141.5	211.5	50.0	0018682
16.6	0038109	0039687	7333021	20.0	150.5	221.5	50.0	0018699
21/32	0012161	0016169	7333022	20.0	150.5	221.5	50.0	0018699
16.7	0038116	0039694	7333023	20.0	150.5	221.5	50.0	0018699
17.0	0012185	0016176	7333024	20.0	150.5	221.5	50.0	0018699
43/64	0012215	0016183	7333025	20.0	150.5	221.5	50.0	0018699
17.1	0038123	0039700	7333026	20.0	150.5	221.5	50.0	0018699
17.2	0038130	0039717	7333027	20.0	150.5	221.5	50.0	0018699
11/16	0012239	0016190	7333028	20.0	150.5	221.5	50.0	0018699
17.5	0012253	0016503	7333029	20.0	150.5	221.5	50.0	0018699
17.6	0032299	0032381	7333030	20.0	158.5	226.5	50.0	0018705
17.7	0038147	0039724	7333031	20.0	158.5	226.5	50.0	0018705
45/64	0012260	0016640	7333032	20.0	158.5	226.5	50.0	0018705
18.0	0012277	0016664	7333033	20.0	158.5	226.5	50.0	0018705
18.1	0038154	0039731	7333034	20.0	158.5	226.5	50.0	0018705
18.2	0038161	0039748	7333035	20.0	158.5	226.5	50.0	0018705
23/32	0012284	0016671	7333036	20.0	158.5	226.5	50.0	0018705
18.5	0012307	0016688	7333037	20.0	158.5	226.5	50.0	0018705
18.6	0038178	0039755	7333038	25.0	167.5	251.5	56.0	0018712
47/64	0012321	0016695	7333039	25.0	167.5	251.5	56.0	0018712
18.7	0038185	0039762	7333040	25.0	167.5	251.5	56.0	0018712
18.9	0038192	0039779	7333041	25.0	167.5	251.5	56.0	0018712
19.0	0012338	0016817	7333042	25.0	167.5	251.5	56.0	0018712
3/4	0012345	0016879	7333043	25.0	167.5	251.5	56.0	0018712
19.1	0038208	0039786	7333044	25.0	167.5	251.5	56.0	0018712
19.2	0038215	0039793	7333045	25.0	167.5	251.5	56.0	0018712
19.25	0032305	0032398	7333046	25.0	167.5	251.5	56.0	0018712
19.3	0032312	0032404	7333047	25.0	167.5	251.5	56.0	0018712
19.35	0032329	0032411	7333048	25.0	167.5	251.5	56.0	0018712
49/64	0012376	0016886	7333049	25.0	167.5	251.5	56.0	0018712
19.5	0012383	0016947	7333050	25.0	167.5	251.5	56.0	0018712
19.6	0038222	0039809	7333051	25.0	175.5	264.5	56.0	0018729
19.7	0038239	0039816	7333052	25.0	175.5	264.5	56.0	0018729
25/32	0012406	0016954	7333053	25.0	175.5	264.5	56.0	0018729
20.0	0012413	0017111	7333054	25.0	175.5	264.5	56.0	0018729
51/64	0012437	0017128	7333055	25.0	175.5	264.5	56.0	0018729
20.5	0012451	0017159	7333056	25.0	175.5	264.5	56.0	0018729
13/16	0012468	0017197	7333057	25.0	184.5	266.5	56.0	0018736
21.0	0012475	0017166	7333058	25.0	184.5	266.5	56.0	0018736
53/64	0012536	0017203	7333059	25.0	184.5	266.5	56.0	0018736
27/32	0012550	0017227	7333060	25.0	184.5	266.5	56.0	0018736
21.5	0012574	0017234	7333061	25.0	184.5	266.5	56.0	0018736
55/64	0012604	0017241	7333062	25.0	192.1	271.1	56.0	0018743
22.0	0012628	0017258	7333063	25.0	192.1	271.1	56.0	0018743
7/8	0012635	0017371	7333064	25.0	192.1	271.1	56.0	0018743
22.5	0032336	0032428	7333065	25.0	192.1	271.1	56.0	0018743
57/64	0012642	0017401	7333066	25.0	192.1	271.1	56.0	0018743
22.7	0038246	0039823	7333067	25.0	192.1	271.1	56.0	0018743
23.0	0012666	0017425	7333068	25.0	200.5	280.5	56.0	0018750
29/32	0012673	0017432	7333069	25.0	200.5	280.5	56.0	0018750
59/64	0012680	0017456	7333070	25.0	200.5	280.5	56.0	0018750
23.5	0038253	0039830	7333071	25.0	200.5	280.5	56.0	0018750
15/16	0012703	0017562	7333072	32.0	208.2	295.2	60.0	0018767
24.0	0012727	0017579	7333073	32.0	208.2	295.2	60.0	0018767
61/64	0012741	0017586	7333074	32.0	208.2	295.2	60.0	0018767
24.5	0038260	0039847	7333075	32.0	208.2	295.2	60.0	0018767
31/32	0012772	0017593	7333076	32.0	208.2	295.2	60.0	0018767
25.0	0012819	0017722	7333077	32.0	217.0	300.0	60.0	0018774
63/64	0012826	0017746	7333078	32.0	217.0	300.0	60.0	0018774
1	0012833	0017753	7333079	32.0	217.0	300.0	60.0	0018774
25.5	0038277	0039854	7333080	32.0	217.0	300.0	60.0	0018774
25.65	0032343	0032435	7333081	32.0	217.0	300.0	60.0	0018774
1.1/64	0012840	0018958	7333082	32.0	217.0	300.0	60.0	0018774
26.0	0013090	0018965	7333083	32.0	225.0	310.0	60.0	0018781
1.1/32	0013120	0018972	7333084	32.0	225.0	310.0	60.0	0018781

# HYDRA DRILL



Hydra Head d <sub>1</sub> Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	Hydra Head R970 EDP#	8xD Hydra Body - Metric Shank				
				d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	H858 EDP#
26.5	0038284	0039878	7333085	32.0	225.0	310.0	60.0	0018781
1.3/64	0013229	0018989	7333086	32.0	225.0	310.0	60.0	0018781
1.1/16	0013243	0018996	7333087	32.0	234.0	320.0	60.0	0018798
27.0	0013267	0019009	7333088	32.0	234.0	320.0	60.0	0018798
1.5/64	0013274	0019016	7333089	32.0	234.0	320.0	60.0	0018798
27.5	0038291	0039885	7333090	32.0	234.0	320.0	60.0	0018798
1.3/32	0013281	0019023	7333091	32.0	234.0	320.0	60.0	0018798
28.0	0013304	0019030	7333092	32.0	242.0	325.0	60.0	0018804
1.7/64	0013311	0019047	7333093	32.0	242.0	325.0	60.0	0018804
28.5	0038307	0039892	7333094	32.0	242.0	325.0	60.0	0018804
1.1/8	0013328	0019054	7333095	32.0	242.0	325.0	60.0	0018804
1.9/64	0013342	0019061	7333096	32.0	251.0	335.0	60.0	0018811
29.0	0013366	0019078	7333097	32.0	251.0	335.0	60.0	0018811
1.5/32	0013380	0019085	7333098	32.0	251.0	335.0	60.0	0018811
29.5	0038314	0039908	7333099	32.0	251.0	335.0	60.0	0018811
1.11/64	0013427	0019092	7333100	32.0	251.0	335.0	60.0	0018811
30.0	0013434	0019108	7333101	32.0	259.0	345.0	60.0	0018828
1.3/16	0013441	0019115	7333102	32.0	259.0	345.0	60.0	0018828
30.5	0013465	0019122	7333103	32.0	259.0	345.0	60.0	0018828
1.7/32	46104481	—	7333104	32.0	271.5	356.5	60.0	46111421
31.00	46104482	—	7333105	32.0	271.5	356.5	60.0	46111421
1.1/4	46104483	—	7333106	32.0	271.5	356.5	60.0	46111421
32.00	46104484	—	7333107	32.0	271.5	356.5	60.0	46111421
32.50	46104485	—	7333108	40.0	286.5	371.5	60.0	46111422
1.19/64	46104486	—	7333109	40.0	286.5	371.5	60.0	46111422
33.00	46104487	—	7333110	40.0	286.5	371.5	60.0	46111422
33.50	46104488	—	7333111	40.0	286.5	371.5	60.0	46111422
34.00	46104489	—	7333112	40.0	301.5	396.5	70.0	46111423
1.11/32	46104530	—	7333113	40.0	301.5	396.5	70.0	46111423
34.50	46104531	—	7333114	40.0	301.5	396.5	70.0	46111423
1.3/8	46104532	—	7333115	40.0	301.5	396.5	70.0	46111423
35.00	46104533	—	7333116	40.0	301.5	396.5	70.0	46111423
36.00	46104534	—	7333117	40.0	311.5	406.5	70.0	46111424
1.27/64	46104535	—	7333118	40.0	311.5	406.5	70.0	46111424
36.50	46104536	—	7333119	40.0	311.5	406.5	70.0	46111424
37.00	46104537	—	7333120	40.0	326.5	421.5	70.0	46111425
1.15/32	46104538	—	7333121	40.0	326.5	421.5	70.0	46111425
37.50	46104539	—	7333122	40.0	326.5	421.5	70.0	46111425
38.00	46104540	—	7333123	40.0	326.5	421.5	70.0	46111425
1.1/2	46104541	—	7333124	40.0	336.5	431.5	70.0	46111426
38.50	46104542	—	7333125	40.0	336.5	431.5	70.0	46111426
1.17/32	46104543	—	7333126	40.0	336.5	431.5	70.0	46111426
39.00	46104544	—	7333127	40.0	336.5	431.5	70.0	46111426
39.50	46104545	—	7333128	40.0	336.5	431.5	70.0	46111426
1.9/16	46104546	—	7333129	40.0	351.5	451.5	70.0	46111427
40.00	46104547	—	7333130	40.0	351.5	451.5	70.0	46111427
41.00	46104548	—	7333131	40.0	351.5	451.5	70.0	46111427
1.5/8	46104549	—	7333132	40.0	361.5	461.5	70.0	46111428
42.00	46104550	—	7333133	40.0	361.5	461.5	70.0	46111428

## Screws & Screw Driver

### H860

Set of 2 Hydra Screws

### H861

Hydra Drill Screw Driver



NOTE: Four (4) screws and one (1) screwdriver are included with a drill body



\* For more information on Hydra, see page 522

H860	H861	For Hydra Head Range	Pack Qty	H860	H861
H860N1	H861N1	15/32 - 15.5	1	0018835	0018897
H860N2	H861N2	15.6 - 18.5	1	0018842	0018903
H860N3	H861N3	18.6 - 21.5	1	0018859	0018910
H860N3	H861N3	55/64 - 31/32	1	0018866	0018910
H860N4	H861N4	25.0 - 1.3/32	1	0018873	0018927
H860N5	H861N5	28.0 - 33.5	1	0018880	0018934
H860N6	H861N6	34.0 - 42.0	1	46111949	46260354

# CDX SOLID CARBIDE DRILL



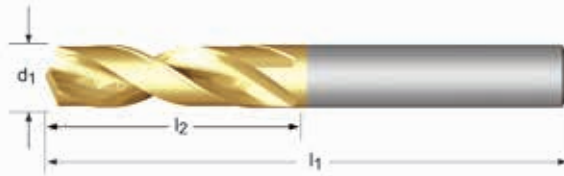
## Multi-Application, Screw Machine Length, Parallel Shank

R520

1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 7.1 7.2 7.3 7.4 8.1 8.2

# CDX

Heavy-Duty design. Self centering Split Point for easier penetration. TiN coating increases wear resistance and improves tool life.



R520

DIN  
6539

2.5XD

HM

130°



3.00 - 16.50

$d_1$ Øh <sub>7</sub> Inch	$d_1$ Øh <sub>7</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	R520
	3.00	0.1181	16	46	1	0116067
	3.10	0.1220	18	49	1	0116074
1/8	3.18	0.1250	18	49	1	0210666
	3.20	0.1260	18	49	1	0116081
	3.30	0.1299	18	49	1	0116098
	3.40	0.1339	20	52	1	0116104
	3.50	0.1378	20	52	1	0116111
	3.60	0.1417	20	52	1	0116128
	3.70	0.1457	20	52	1	0116135
	3.80	0.1496	22	55	1	0116142
	3.90	0.1535	22	55	1	0116159
	4.00	0.1575	22	55	1	0116166
	4.10	0.1614	22	55	1	0116173
	4.20	0.1654	22	55	1	0116180
	4.30	0.1693	24	58	1	0116197
	4.40	0.1732	24	58	1	0116203
	4.50	0.1772	24	58	1	0116210
	4.60	0.1811	24	58	1	0116227
	4.70	0.1850	24	58	1	0116234
	4.80	0.1890	26	62	1	0116241
	4.90	0.1929	26	62	1	0116258
	5.00	0.1969	26	62	1	0116265
	5.10	0.2008	26	62	1	0116272
	5.20	0.2047	26	62	1	0116289
	5.30	0.2087	26	62	1	0116296
	5.40	0.2126	28	66	1	0116302
	5.50	0.2165	28	66	1	0116319
	5.60	0.2205	28	66	1	0116326
	5.70	0.2244	28	66	1	0116333
	5.80	0.2283	28	66	1	0116340
	5.90	0.2323	28	66	1	0116357
	6.00	0.2362	28	66	1	0116364
	6.10	0.2402	31	70	1	0116371

d <sub>1</sub> Øh <sub>7</sub> Inch	d <sub>1</sub> Øh <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	R520
	6.20	0.2441	31	70	1	0116388
	6.30	0.2480	31	70	1	0116395
1/4	6.35	0.2500	31	70	1	0210741
	6.40	0.2520	31	70	1	0116401
	6.50	0.2559	31	70	1	0116418
	6.60	0.2598	31	70	1	0346402
	6.70	0.2638	31	70	1	0346419
	6.80	0.2677	34	74	1	0116425
	6.90	0.2717	34	74	1	0116432
	7.00	0.2756	34	74	1	0116449
	7.10	0.2795	34	74	1	0346426
	7.20	0.2835	34	74	1	0346433
	7.30	0.2874	34	74	1	0116456
	7.40	0.2913	34	74	1	0116463
	7.50	0.2953	34	74	1	0116470
	7.60	0.2992	37	79	1	0346440
	7.70	0.3031	37	79	1	0346457
	7.80	0.3071	37	79	1	0116487
	7.90	0.3110	37	79	1	0346464
5/16	7.94	0.3125	37	79	1	0210789
	8.00	0.3150	37	79	1	0116494
	8.10	0.3189	37	79	1	0346471
	8.20	0.3228	37	79	1	0346488
	8.30	0.3268	37	79	1	0346495
	8.40	0.3307	37	79	1	0346501
	8.50	0.3346	37	79	1	0116500
	8.60	0.3386	40	84	1	0346518
	8.70	0.3425	40	84	1	0216866
	8.80	0.3465	40	84	1	0346525
	8.90	0.3504	40	84	1	0346532
	9.00	0.3543	40	84	1	0116517
	9.10	0.3583	40	84	1	0346549
	9.20	0.3622	40	84	1	0116524
	9.30	0.3661	40	84	1	0116531
	9.40	0.3701	40	84	1	0216873
	9.50	0.3740	40	84	1	0116548
3/8	9.52	0.3750	43	89	1	0210826
	9.60	0.3780	43	89	1	0346556
	9.70	0.3819	43	89	1	0346563
	9.80	0.3858	43	89	1	0346570
	9.90	0.3898	43	89	1	0346587
	10.00	0.3937	43	89	1	0115923
	10.10	0.3976	43	89	1	0346778
	10.20	0.4016	43	89	1	0115930
	10.30	0.4055	43	89	1	0216880
	10.40	0.4094	43	89	1	0115947
	10.50	0.4134	43	89	1	0115954
	11.00	0.4331	47	95	1	0115961
7/16	11.11	0.4375	47	95	1	0210864
	11.20	0.4409	47	95	1	0216897
	11.50	0.4528	47	95	1	0115978
	12.00	0.4724	51	102	1	0115985
	12.50	0.4921	51	102	1	0115992
1/2	12.70	0.5000	51	102	1	0210901
	13.00	0.5118	51	102	1	0116005
	13.50	0.5315	54	107	1	0216903
	14.00	0.5512	54	107	1	0116012
	14.20	0.5591	56	111	1	0216910
	14.25	0.5610	56	111	1	0216927
	14.50	0.5709	56	111	1	0116029
	15.00	0.5906	56	111	1	0116036
	15.10	0.5945	58	115	1	0216934
5/8	15.88	0.6250	58	115	1	0210925
	16.00	0.6299	58	115	1	0116043
	16.50	0.6496	60	119	1	0116050

# FORCE X SOLID CARBIDE DRILL



## Multi-Application, Short Length, Reinforced Shank

### R458

1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 2.2 2.3 2.4 3.1 3.2 3.3

3.4 4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

Self centering 4-facet split point and CTW flute construction for enhanced penetration rate. TiAlN coating increases wear resistance and improves tool life at high RPM.

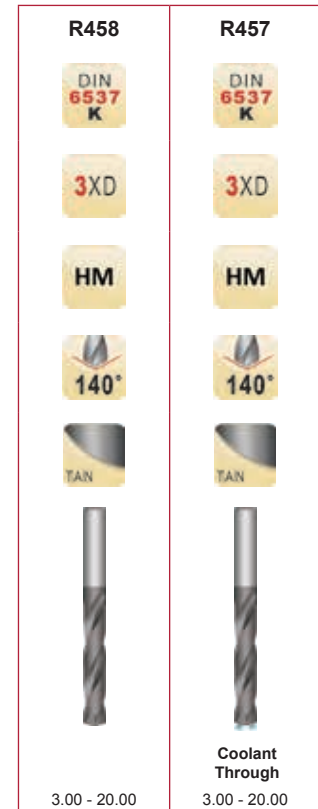
### R457

1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 2.2 2.3 3.1 3.2 3.3 3.4

4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

Coolant through clears chips away from the cutting edge. Self centering 4-facet split point for enhanced penetration rates. TiAlN coating increases surface hardness and improves tool life at high RPM.

### High productivity in a wide range of materials



$d_1$ Ø "/Nr.	$d_1$ Ø <sub>m7</sub> mm	$d_1$ decimal inch	$l_2$ mm	$l_1$ mm	$l_3$ mm	$d_2$ Ø <sub>h5</sub> mm	Pack Qty	R458	R457
	3.00	0.1181	20	62	36	6	1	0615324	0614884
	3.10	0.1220	20	62	36	6	1	0626443	0626115
1/8	3.18	0.1252	20	62	36	6	1	0624845	0624432
	3.20	0.1260	20	62	36	6	1	0626450	0626122
30	3.26	0.1283	20	62	36	6	1	0042267	0041833
	3.30	0.1299	20	62	36	6	1	0615331	0614891
	3.40	0.1339	20	62	36	6	1	0615348	0614907
29	3.45	0.1358	20	62	36	6	1	0042274	0041840
	3.50	0.1378	20	62	36	6	1	0615355	0614914
28	3.57	0.1406	20	62	36	6	1	0042281	0041857
9/64	3.57	0.1406	20	62	36	6	1	0625224	0624814
	3.60	0.1417	20	62	36	6	1	0626467	0626139
27	3.66	0.1441	20	62	36	6	1	0042298	0041864
	3.70	0.1457	20	62	36	6	1	0626474	0626146
26	3.73	0.1469	24	66	36	6	1	0626481	0041871
25	3.80	0.1496	24	66	36	6	1	0626498	0041888
24	3.86	0.1520	24	66	36	6	1	0042328	0041895
	3.90	0.1535	24	66	36	6	1	0626504	0626160
23	3.91	0.1539	24	66	36	6	1	0042335	0041901
5/32	3.97	0.1563	24	66	36	6	1	0625163	0624753
22	3.99	0.1571	24	66	36	6	1	0042342	0041918
	4.00	0.1575	24	66	36	6	1	0615362	0614921
21	4.04	0.1591	24	66	36	6	1	0042359	0041925
	4.05	0.1594	24	66	36	6	1	—	0626177
20	4.09	0.1610	24	66	36	6	1	0042366	0041932
	4.10	0.1614	24	66	36	6	1	0626511	0626184
	4.20	0.1654	24	66	36	6	1	0615379	0614938
19	4.22	0.1661	24	66	36	6	1	0042373	0041949
	4.30	0.1693	24	66	36	6	1	0615386	0614945
18	4.31	0.1697	24	66	36	6	1	0042380	0041956
11/64	4.37	0.1720	24	66	36	6	1	0624876	0624463
17	4.39	0.1728	24	66	36	6	1	0042397	0041963
	4.40	0.1732	24	66	36	6	1	0135013	0134832



d <sub>1</sub> Ø "/Nr.	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R458	R457
16	4.50	0.1772	24	66	36	6	1	0615393	0041970
15	4.57	0.1799	24	66	36	6	1	0042410	0041987
	4.60	0.1811	24	66	36	6	1	0626528	0626191
14	4.62	0.1819	24	66	36	6	1	0042427	0041994
13	4.70	0.1850	24	66	36	6	1	0135020	0042007
3/16	4.76	0.1874	28	66	36	6	1	0625033	0624623
12	4.80	0.1890	28	66	36	6	1	0135037	0042014
11	4.85	0.1909	28	66	36	6	1	0042458	0042021
	4.90	0.1929	28	66	36	6	1	0135044	0622070
10	4.92	0.1937	28	66	36	6	1	0042465	0042038
9	4.98	0.1961	28	66	36	6	1	0042472	0042045
	5.00	0.1969	28	66	36	6	1	0615409	0614969
	5.05	0.1988	28	66	36	6	1	—	0626214
8	5.06	0.1992	28	66	36	6	1	0042489	0042052
	5.10	0.2008	28	66	36	6	1	0615416	0614976
7	5.11	0.2012	28	66	36	6	1	0042496	0042069
13/64	5.16	0.2031	28	66	36	6	1	0624890	0624487
6	5.18	0.2039	28	66	36	6	1	0042502	0042076
	5.20	0.2047	28	66	36	6	1	0135051	0134856
5	5.22	0.2055	28	66	36	6	1	0042519	0042083
	5.30	0.2087	28	66	36	6	1	7361260	7361237
4	5.31	0.2091	28	66	36	6	1	0042526	0042090
	5.40	0.2126	28	66	36	6	1	7361261	7361238
3	5.41	0.2130	28	66	36	6	1	0042533	0042106
	5.50	0.2165	28	66	36	6	1	0615423	0614983
7/32	5.56	0.2189	28	66	36	6	1	0625194	0624784
	5.60	0.2205	28	66	36	6	1	0626535	0626221
2	5.61	0.2209	28	66	36	6	1	0042540	0042113
	5.70	0.2244	28	66	36	6	1	0626542	0626238
1	5.79	0.2280	28	66	36	6	1	0042557	0042120
	5.80	0.2283	28	66	36	6	1	0626559	0626245
	5.90	0.2323	28	66	36	6	1	7361262	7361239
A	5.94	0.2339	28	66	36	6	1	0042564	0042137
15/64	5.95	0.2343	28	66	36	6	1	0624913	0624500
	6.00	0.2362	28	66	36	6	1	0615430	0614990
B	6.03	0.2374	34	79	36	8	1	7361263	7361240
	6.05	0.2382	34	79	36	8	1	—	0626252
	6.10	0.2402	34	79	36	8	1	0626566	0626269
C	6.15	0.2421	34	79	36	8	1	7361264	7361241
	6.20	0.2441	34	79	36	8	1	0135068	0134863
D	6.25	0.2461	34	79	36	8	1	0042571	0042144
	6.30	0.2480	34	79	36	8	1	0626573	0626276
1/4	6.35	0.2500	34	79	36	8	1	0624838	0624425
E	6.35	0.2500	34	79	36	8	1	7361265	7361242
	6.40	0.2520	34	79	36	8	1	0135075	0134870
	6.50	0.2559	34	79	36	8	1	0615447	0615003
F	6.53	0.2571	34	79	36	8	1	7361266	7361243
	6.60	0.2598	34	79	36	8	1	0626580	0626283
G	6.63	0.2610	34	79	36	8	1	7361267	7361244
	6.70	0.2638	34	79	36	8	1	0135082	0134887
17/64	6.75	0.2657	34	79	36	8	1	0624937	0624524
H	6.76	0.2661	34	79	36	8	1	0042588	0042151
	6.80	0.2677	34	79	36	8	1	0615454	0615010
	6.90	0.2717	34	79	36	8	1	0615461	0615027
I	6.91	0.2720	34	79	36	8	1	7361268	7361245
	7.00	0.2756	34	79	36	8	1	0615478	0615034
J	7.04	0.2772	41	79	36	8	1	7361269	7361246
	7.10	0.2795	41	79	36	8	1	0626597	0626290
K	7.14	0.2811	41	79	36	8	1	7361270	7361247
9/32	7.14	0.2811	41	79	36	8	1	0625217	0624807
	7.20	0.2835	41	79	36	8	1	7361271	7361248
	7.30	0.2874	41	79	36	8	1	0626603	0626306
L	7.37	0.2902	41	79	36	8	1	0042595	0042168
	7.40	0.2913	41	79	36	8	1	0615485	0615041
M	7.49	0.2949	41	79	36	8	1	0042601	0042175
	7.50	0.2953	41	79	36	8	1	0615492	0615058

# FORCE X SOLID CARBIDE DRILL



d <sub>1</sub> Ø "/Nr.	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>5</sub> mm	Pack Qty	R458	R457
19/64	7.54	0.2969	41	79	36	8	1	0624951	0624548
	7.60	0.2992	41	79	36	8	1	0626610	0626313
	7.67	0.3020	41	79	36	8	1	0042618	0042182
	7.70	0.3031	41	79	36	8	1	0135099	0134894
	7.80	0.3071	41	79	36	8	1	0626627	0626320
N	7.90	0.3110	41	79	36	8	1	0135105	0134900
	7.94	0.3126	41	79	36	8	1	0625156	0624746
5/16	8.00	0.3150	41	79	36	8	1	0615508	0615065
	8.03	0.3161	47	89	40	10	1	0042625	0042199
O	8.05	0.3169	47	89	40	10	1	—	0626337
	8.10	0.3189	47	89	40	10	1	0626634	0626689
P	8.20	0.3228	47	89	40	10	1	0135112	0134917
	8.20	0.3228	47	89	40	10	1	7361272	7361249
	8.30	0.3268	47	89	40	10	1	7361273	7361250
21/64	8.33	0.3280	47	89	40	10	1	0624975	0624562
	8.40	0.3307	47	89	40	10	1	0135129	0134924
Q	8.43	0.3319	47	89	40	10	1	0042632	0042205
	8.50	0.3346	47	89	40	10	1	0615515	0615072
	8.60	0.3386	47	89	40	10	1	0615522	0615089
R	8.61	0.3390	47	89	40	10	1	7361274	7361251
	8.70	0.3425	47	89	40	10	1	0615539	0615096
11/32	8.73	0.3437	47	89	40	10	1	0624869	0624456
	8.80	0.3465	47	89	40	10	1	0626641	0626344
S	8.84	0.3480	47	89	40	10	1	7361275	7361252
	8.90	0.3504	47	89	40	10	1	7361276	0134931
	9.00	0.3543	47	89	40	10	1	0615546	0615102
T	9.09	0.3579	47	89	40	10	1	0042649	0042212
	9.10	0.3583	47	89	40	10	1	0626658	0626351
23/64	9.13	0.3594	47	89	40	10	1	0624999	0624586
	9.20	0.3622	47	89	40	10	1	7361277	7361253
	9.30	0.3661	47	89	40	10	1	0615553	0615119
U	9.35	0.3681	47	89	40	10	1	0042656	0042229
	9.40	0.3701	47	89	40	10	1	0135136	0134948
	9.50	0.3740	47	89	40	10	1	0615560	0615126
	9.52	0.3748	47	89	40	10	1	0625057	0624647
V	9.58	0.3772	47	89	40	10	1	7361278	7361254
	9.60	0.3780	47	89	40	10	1	0626665	0626368
	9.70	0.3819	47	89	40	10	1	0135143	0629062
	9.80	0.3858	47	89	40	10	1	0626672	0626375
	9.80	0.3858	47	89	40	10	1	7361279	7361255
W	9.90	0.3898	47	89	40	10	1	0135150	0134955
	9.92	0.3906	47	89	40	10	1	0625002	0624593
25/64	10.00	0.3937	47	89	40	10	1	0615133	0614693
	10.05	0.3957	55	102	45	12	1	—	0625958
	10.08	0.3969	55	102	45	12	1	0042663	0042236
X	10.10	0.3976	55	102	45	12	1	0626382	0625965
	10.20	0.4016	55	102	45	12	1	0615140	0614709
	10.26	0.4039	55	102	45	12	1	0042670	0042243
	10.30	0.4055	55	102	45	12	1	0615157	0614716
13/32	10.32	0.4063	55	102	45	12	1	0624883	0624470
	10.40	0.4094	55	102	45	12	1	0615164	0614723
Z	10.49	0.4130	55	102	45	12	1	0042687	0042250
	10.50	0.4134	55	102	45	12	1	0615171	0614730
	10.60	0.4173	55	102	45	12	1	0626399	0625972
	10.70	0.4213	55	102	45	12	1	7361280	—
	10.72	0.4220	55	102	45	12	1	0625019	0624609
27/64	10.80	0.4252	55	102	45	12	1	0042694	7361256
	10.90	0.4291	55	102	45	12	1	7361281	—
	11.00	0.4331	55	102	45	12	1	0615188	0614747
	11.10	0.4370	55	102	45	12	1	7361282	—
7/16	11.11	0.4374	55	102	45	12	1	0625187	0624777
	11.20	0.4409	55	102	45	12	1	0615195	0614754
	11.30	0.4449	55	102	45	12	1	7361283	7361257
	11.40	0.4488	55	102	45	12	1	0135167	0134962

d <sub>1</sub> Ø "Nr.	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R458	R457	
29/64	11.50	0.4528	55	102	45	12	1	0615201	0614761	
	11.51	0.4531	55	102	45	12	1	0625026	0624616	
	11.60	0.4567	55	102	45	12	1	0135174	0134979	
	11.70	0.4606	55	102	45	12	1	7361284	—	
	11.80	0.4646	55	102	45	12	1	0626405	0625989	
15/32	11.90	0.4685	55	102	45	12	1	7361285	—	
	11.91	0.4689	55	102	45	12	1	0624906	0624494	
	12.00	0.4724	55	102	45	12	1	0615218	0614778	
	12.05	0.4744	60	107	45	14	1	—	0625996	
	12.10	0.4764	60	107	45	14	1	0626412	0626009	
31/64	12.20	0.4803	60	107	45	14	1	0615225	0614785	
	12.30	0.4843	60	107	45	14	1	0625064	0624654	
	12.50	0.4921	60	107	45	14	1	0615232	0614792	
	12.70	0.5000	60	107	45	14	1	0626429	0626016	
	1/2	12.70	0.5000	60	107	45	14	1	0624821	0624418
12.80		0.5039	60	107	45	14	1	0135181	0134986	
13.00		0.5118	60	107	45	14	1	0615249	0614808	
33/64	13.10	0.5157	60	107	45	14	1	0625071	0624661	
	13.30	0.5236	60	107	45	14	1	7361286	7361258	
	17/32	13.49	0.5311	60	107	45	14	1	0624920	0624517
	13.50	0.5315	60	107	45	14	1	0615256	0614815	
	13.80	0.5433	60	107	45	14	1	0135198	0134993	
	35/64	13.89	0.5469	60	107	45	14	1	0625088	0624678
	14.00	0.5512	60	107	45	14	1	0615263	0614822	
	14.25	0.5610	65	115	48	16	1	0615270	0614839	
	9/16	14.29	0.5626	65	115	48	16	1	0625200	0624791
	14.50	0.5709	65	115	48	16	1	0615287	0614846	
	37/64	14.68	0.5780	65	115	48	16	1	0625095	0624685
	14.80	0.5827	65	115	48	16	1	0622032	0135006	
	15.00	0.5906	65	115	48	16	1	0615294	0614853	
	19/32	15.08	0.5937	65	115	48	16	1	0624944	0624531
	15.10	0.5945	65	115	48	16	1	0626436	0626023	
	15.30	0.6024	65	115	48	16	1	7361287	7361259	
	39/64	15.48	0.6094	65	115	48	16	1	0625101	0624692
	15.50	0.6102	65	115	48	16	1	0615300	0614860	
	15.80	0.6220	65	115	48	16	1	0135204	0622049	
	5/8	15.88	0.6252	65	115	48	16	1	0625170	0624760
	16.00	0.6299	65	115	48	16	1	0615317	0614877	
41/64	16.27	0.6406	73	123	48	18	1	0625118	0624708	
	16.50	0.6496	73	123	48	18	1	0135211	0626030	
21/32	16.67	0.6563	73	123	48	18	1	0624968	0624555	
	17.00	0.6693	73	123	48	18	1	0135228	0626047	
43/64	17.07	0.6720	73	123	48	18	1	0625125	0624715	
11/16	17.46	0.6874	73	123	48	18	1	0624852	0624449	
	17.50	0.6890	73	123	48	18	1	0135235	0626054	
	17.80	0.7008	73	123	48	18	1	0135273	—	
45/64	17.86	0.7031	73	123	48	18	1	0625132	0624722	
	18.00	0.7087	73	123	48	18	1	0135280	0626061	
23/32	18.26	0.7189	79	131	50	20	1	0624982	0624579	
	18.50	0.7283	79	131	50	20	1	0135297	0626078	
47/64	18.65	0.7343	79	131	50	20	1	0625149	0624739	
	18.80	0.7402	79	131	50	20	1	—	0622056	
	19.00	0.7480	79	131	50	20	1	0135327	0626085	
3/4	19.05	0.7500	79	131	50	20	1	0625040	0624630	
	19.50	0.7677	79	131	50	20	1	0135334	0626092	
	19.80	0.7795	79	131	50	20	1	0135341	0622063	
	20.00	0.7874	79	131	50	20	1	0135358	0626108	

# CDX SOLID CARBIDE DRILL



## Multi-Application, Jobber Length, Parallel Shank

R510

1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 3.1 3.2 3.3 3.4 4.1 5.1  
7.1 7.2 7.3 7.4 8.1 8.2

Heavy-Duty design. Self centering Split Point for easier penetration.  
TiN coating increases wear resistance and improves tool life.

# CDX

R510

DIN  
338

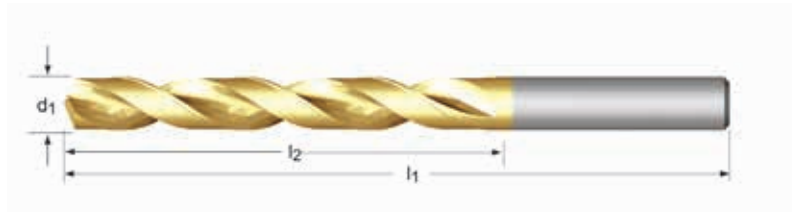
4XD

HM

130°



3.00 - 14.25



$d_1$ Øh <sub>7</sub> Inch	$d_1$ Øh <sub>7</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	R510
	3.00	0.1181	33	61	1	0115657
1/8	3.18	0.1250	36	65	1	0380802
	3.20	0.1260	36	65	1	0148990
	3.30	0.1299	36	65	1	0115664
	3.40	0.1339	39	70	1	0115671
	3.50	0.1378	39	70	1	0115688
	3.70	0.1457	39	70	1	0216781
	3.90	0.1535	43	75	1	0345245
	4.00	0.1575	43	75	1	0115695
	4.10	0.1614	43	75	1	0115701
	4.20	0.1654	43	75	1	0115718
	4.30	0.1693	47	80	1	0115725
	4.50	0.1772	47	80	1	0115732
	4.60	0.1811	47	80	1	0216798
	4.70	0.1850	47	80	1	0216804
3/16	4.76	0.1875	52	86	1	0380949
	4.90	0.1929	52	86	1	0115749
	5.00	0.1969	52	86	1	0115756
	5.10	0.2008	52	86	1	0115763
	5.50	0.2165	57	93	1	0115770
	5.60	0.2205	57	93	1	0216811
	5.70	0.2244	57	93	1	0216828
	6.00	0.2362	57	93	1	0115787
1/4	6.35	0.2500	63	101	1	0381038
	6.50	0.2559	63	101	1	0115794
	6.60	0.2598	63	101	1	0345252
	6.80	0.2677	69	109	1	0115800
	6.90	0.2717	69	109	1	0115817
	7.00	0.2756	69	109	1	0115824
	7.30	0.2874	69	109	1	0115831
	7.40	0.2913	69	109	1	0115848
	7.50	0.2953	69	109	1	0115855
	7.80	0.3071	75	117	1	0345269

$d_1$ $\varnothing h_7$ Inch	$d_1$ $\varnothing h_7$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	R510
5/16	7.90	0.3110	75	117	1	0345276
	7.94	0.3125	75	117	1	0380963
	8.00	0.3150	75	117	1	0115862
	8.50	0.3346	75	117	1	0115879
	8.70	0.3425	81	125	1	0149003
	8.80	0.3465	81	125	1	0345283
	9.00	0.3543	81	125	1	0115886
	9.20	0.3622	81	125	1	0115893
	9.30	0.3661	81	125	1	0115909
	9.40	0.3701	81	125	1	0216835
3/8	9.50	0.3740	81	125	1	0115916
	9.52	0.3750	87	133	1	0381045
	9.90	0.3898	87	133	1	0345290
	10.00	0.3937	87	133	1	0115558
	10.20	0.4016	87	133	1	0115565
	10.30	0.4055	87	133	1	0216842
	10.40	0.4094	87	133	1	0115572
	10.50	0.4134	87	133	1	0115589
	10.80	0.4252	94	142	1	0345306
	11.00	0.4331	94	142	1	0115596
7/16	11.11	0.4375	94	142	1	0380987
	11.20	0.4409	94	142	1	0216859
	11.50	0.4528	94	142	1	0115602
1/2	12.00	0.4724	101	151	1	0115619
	12.70	0.5000	101	151	1	0381021
	13.00	0.5118	101	151	1	0115626
	14.00	0.5512	108	160	1	0115633
	14.25	0.5610	114	169	1	0115640

# FORCE X SOLID CARBIDE DRILL



## Multi-Application, Standard Length, Reinforced Shank

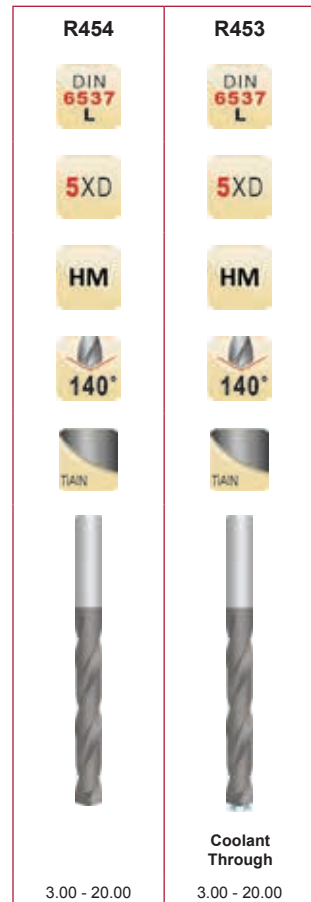
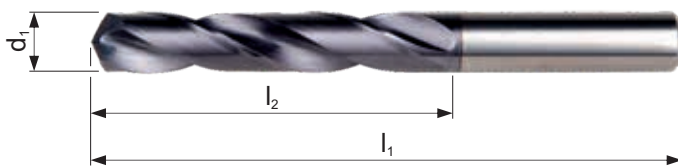
**R454** Self centering 4-facet split point and CTW flute construction for enhanced penetration rate. TiAlN coating increases wear resistance, improves tool life at high RPM.

- 1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 2.2 2.3 2.4 3.1 3.2 3.3  
3.4 4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

**R453** Coolant through clears chips away from the cutting edge. Self centering 4-facet split point and CTW flute construction for enhanced penetration rates. TiAlN coating increases surface hardness, improves tool life at high RPM.

- 1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 2.2 2.3 2.4 3.1 3.2 3.3  
3.4 4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

### High productivity in a wide range of materials



$d_1$ Ø Inch	$d_1$ Ø <sub>m7</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	$l_3$ mm	$d_2$ Ø <sub>h5</sub> mm	Pack Qty	R454	R453
	3.00	0.1181	28	66	36	6	1	0614433	0614051
	3.10	0.1220	28	66	36	6	1	0625712	0625385
1/8	3.18	0.1252	28	66	36	6	1	0624029	0623619
	3.20	0.1260	28	66	36	6	1	0625729	0625392
30	3.26	0.1283	28	66	36	6	1	0041406	0040393
	3.30	0.1299	28	66	36	6	1	0614440	0616147
	3.40	0.1339	28	66	36	6	1	0614457	0614068
29	3.45	0.1358	28	66	36	6	1	0041413	0040409
	3.50	0.1378	28	66	36	6	1	0614464	0614075
28	3.57	0.1406	28	66	36	6	1	0041420	0040416
9/64	3.57	0.1406	28	66	36	6	1	0624401	0623992
	3.60	0.1417	28	66	36	6	1	0625736	0625408
27	3.66	0.1441	28	66	36	6	1	0041437	0040423
	3.70	0.1457	28	66	36	6	1	0625743	0625415
26	3.73	0.1469	36	74	36	6	1	0041444	0040430
25	3.80	0.1496	36	74	36	6	1	0625750	0625422
24	3.86	0.1520	36	74	36	6	1	0041468	0040454
	3.90	0.1535	36	74	36	6	1	0625767	0628911
23	3.91	0.1539	36	74	36	6	1	0041475	0040461
5/32	3.97	0.1563	36	74	36	6	1	0624340	0623930
22	3.99	0.1571	36	74	36	6	1	0041482	0040478
	4.00	0.1575	36	74	36	6	1	0614471	0614082
21	4.04	0.1591	36	74	36	6	1	0041499	0040485
	4.05	0.1594	36	74	36	6	1	—	0625439
20	4.09	0.1610	36	74	36	6	1	0041505	0040492
	4.10	0.1614	36	74	36	6	1	0625774	0625446
	4.20	0.1654	36	74	36	6	1	0614488	0616154
19	4.22	0.1661	36	74	36	6	1	0041512	0040508
	4.30	0.1693	36	74	36	6	1	0614495	0614099
18	4.31	0.1697	36	74	36	6	1	0041529	0040515
11/64	4.37	0.1720	36	74	36	6	1	0624050	0623640
17	4.39	0.1728	36	74	36	6	1	0041536	0040522
	4.40	0.1732	36	74	36	6	1	0134450	0134191

d <sub>1</sub> Ø Inch	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R454	R453
	4.50	0.1772	36	74	36	6	1	0614501	0614105
16	4.50	0.1772	36	74	36	6	1	0041543	0040539
15	4.57	0.1799	36	74	36	6	1	0041550	0040546
	4.60	0.1811	36	74	36	6	1	0625781	0625453
14	4.62	0.1819	36	74	36	6	1	0041567	0040553
13	4.70	0.1850	36	74	36	6	1	0625798	0625460
3/16	4.76	0.1874	44	82	36	6	1	0624210	0623800
12	4.80	0.1890	44	82	36	6	1	0134467	0134207
11	4.85	0.1909	44	82	36	6	1	0041598	0040584
	4.90	0.1929	44	82	36	6	1	0134474	0134214
10	4.92	0.1937	44	82	36	6	1	0041604	0040591
9	4.98	0.1961	44	82	36	6	1	0041611	0040607
	5.00	0.1969	44	82	36	6	1	0614518	0614112
	5.05	0.1988	44	82	36	6	1	—	0625477
8	5.06	0.1992	44	82	36	6	1	0041628	0040614
	5.10	0.2008	44	82	36	6	1	0614525	0614129
7	5.11	0.2012	44	82	36	6	1	0041635	0040621
13/64	5.16	0.2031	44	82	36	6	1	0624074	0623664
6	5.18	0.2039	44	82	36	6	1	0041642	0040638
	5.20	0.2047	44	82	36	6	1	0134481	0134221
5	5.22	0.2055	44	82	36	6	1	0041659	0040645
	5.30	0.2087	44	82	36	6	1	—	7361201
4	5.31	0.2091	44	82	36	6	1	0041666	0040652
	5.40	0.2126	44	82	36	6	1	—	7361202
3	5.41	0.2130	44	82	36	6	1	0041673	0040669
	5.50	0.2165	44	82	36	6	1	0614532	0614136
7/32	5.56	0.2189	44	82	36	6	1	0624371	0623961
	5.60	0.2205	44	82	36	6	1	0625804	0625484
2	5.61	0.2209	44	82	36	6	1	0041680	0040676
	5.70	0.2244	44	82	36	6	1	0625811	0625491
1	5.79	0.2280	44	82	36	6	1	0041697	0040683
	5.80	0.2283	44	82	36	6	1	0625828	0625507
	5.90	0.2323	44	82	36	6	1	—	7361203
A	5.94	0.2339	44	82	36	6	1	0041703	0040690
15/64	5.95	0.2343	44	82	36	6	1	0624098	0623688
	6.00	0.2362	44	82	36	6	1	0614549	0614143
B	6.03	0.2374	53	91	36	8	1	7361224	7361204
	6.05	0.2382	53	91	36	8	1	—	0625514
	6.10	0.2402	53	91	36	8	1	0625835	0625521
C	6.15	0.2421	53	91	36	8	1	7361225	7361205
	6.20	0.2441	53	91	36	8	1	0134498	0134238
D	6.25	0.2461	53	91	36	8	1	0041710	0040706
	6.30	0.2480	53	91	36	8	1	0625842	0625538
1/4	6.35	0.2500	53	91	36	8	1	0624012	0623602
E	6.35	0.2500	53	91	36	8	1	7361226	7361206
	6.40	0.2520	53	91	36	8	1	0134504	0134245
	6.50	0.2559	53	91	36	8	1	0614556	0614150
F	6.53	0.2571	53	91	36	8	1	7361227	7361207
	6.60	0.2598	53	91	36	8	1	0625859	0625545
G	6.63	0.2610	53	91	36	8	1	7361228	7361208
	6.70	0.2638	53	91	36	8	1	0614563	0134252
17/64	6.75	0.2657	53	91	36	8	1	0624111	0623701
H	6.76	0.2661	53	91	36	8	1	0041727	0041291
	6.80	0.2677	53	91	36	8	1	0614570	0616116
	6.90	0.2717	53	91	36	8	1	0614587	0614167
I	6.91	0.2720	53	91	36	8	1	7361229	7361209
	7.00	0.2756	53	91	36	8	1	0614594	0614174
J	7.04	0.2772	53	91	36	8	1	7361230	7361210
	7.10	0.2795	53	91	36	8	1	0625866	0625552
K	7.14	0.2811	53	91	36	8	1	7361231	7361211
9/32	7.14	0.2811	53	91	36	8	1	0624395	0623985
	7.20	0.2835	53	91	36	8	1	—	7361212
	7.30	0.2874	53	91	36	8	1	0625873	0625569
L	7.37	0.2902	53	91	36	8	1	0041734	0041307
	7.40	0.2913	53	91	36	8	1	0614600	0616161

# FORCE X SOLID CARBIDE DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>5</sub> mm	Pack Qty	R454	R453
M	7.49	0.2949	53	91	36	8	1	0041741	0041314
	7.50	0.2953	53	91	36	8	1	0614617	0614181
19/64	7.54	0.2969	53	91	36	8	1	0624135	0623725
	7.60	0.2992	53	91	36	8	1	0625880	0625576
N	7.67	0.3020	53	91	36	8	1	0041758	0041321
	7.70	0.3031	53	91	36	8	1	0134511	0134306
	7.80	0.3071	53	91	36	8	1	0625897	0625583
	7.90	0.3110	53	91	36	8	1	0134528	0134313
5/16	7.94	0.3126	53	91	36	8	1	0624333	0623923
	8.00	0.3150	53	91	36	8	1	0614624	0614198
O	8.03	0.3161	61	103	40	10	1	0041765	0041338
	8.05	0.3169	61	103	40	10	1	—	0625590
	8.10	0.3189	61	103	40	10	1	0625903	0625606
	8.20	0.3228	61	103	40	10	1	0134535	0134320
P	8.20	0.3228	61	103	40	10	1	7361232	7361213
	8.30	0.3268	61	103	40	10	1	—	7361214
21/64	8.33	0.3280	61	103	40	10	1	0624159	0623749
	8.40	0.3307	61	103	40	10	1	0134542	0134337
Q	8.43	0.3319	61	103	40	10	1	0041772	0041345
	8.50	0.3346	61	103	40	10	1	0614631	0614204
	8.60	0.3386	61	103	40	10	1	0614648	0616178
R	8.61	0.3390	61	103	40	10	1	7361233	7361215
	8.70	0.3425	61	103	40	10	1	0614655	0614211
11/32	8.73	0.3437	61	103	40	10	1	0624043	0623633
	8.80	0.3465	61	103	40	10	1	0625910	0625613
S	8.84	0.3480	61	103	40	10	1	7361234	7361216
	8.90	0.3504	61	103	40	10	1	0134559	0134344
	9.00	0.3543	61	103	40	10	1	0614662	0614228
T	9.09	0.3579	61	103	40	10	1	0041789	0041352
	9.10	0.3583	61	103	40	10	1	0625927	0625620
23/64	9.13	0.3594	61	103	40	10	1	0624173	0623763
	9.20	0.3622	61	103	40	10	1	—	7361217
	9.30	0.3661	61	103	40	10	1	0614679	0616123
U	9.35	0.3681	61	103	40	10	1	0041796	0041369
	9.40	0.3701	61	103	40	10	1	0134566	0134351
	9.50	0.3740	61	103	40	10	1	0614686	0614235
3/8	9.52	0.3748	61	103	40	10	1	0624234	0623824
V	9.58	0.3772	61	103	40	10	1	7361235	7361218
	9.60	0.3780	61	103	40	10	1	0625934	0625637
	9.70	0.3819	61	103	40	10	1	0134573	0629055
	9.80	0.3858	61	103	40	10	1	0625941	0625644
W	9.80	0.3858	61	103	40	10	1	7361236	7361219
	9.90	0.3898	61	103	40	10	1	0134580	0134368
25/64	9.92	0.3906	61	103	40	10	1	0624180	0623770
	10.00	0.3937	61	103	40	10	1	0614242	0613870
	10.05	0.3957	70	118	45	12	1	—	0625231
X	10.08	0.3969	70	118	45	12	1	0041802	0041376
	10.10	0.3976	70	118	45	12	1	0625651	0625248
	10.20	0.4016	70	118	45	12	1	0614259	0613887
Y	10.26	0.4039	70	118	45	12	1	0041819	0041383
	10.30	0.4055	70	118	45	12	1	0614266	0613894
13/32	10.32	0.4063	70	118	45	12	1	0624067	0623657
	10.40	0.4094	70	118	45	12	1	0614273	0616130
	10.49	0.4130	70	118	45	12	1	0041826	0041390
Z	10.50	0.4134	70	118	45	12	1	0614280	0613900
	10.60	0.4173	70	118	45	12	1	0625668	0625255
	27/64	10.72	0.4220	70	118	45	12	0624197	0623787
	10.80	0.4252	70	118	45	12	1	—	7361220
7/16	11.00	0.4331	70	118	45	12	1	0614297	0613917
	11.11	0.4374	70	118	45	12	1	0624364	0623954
	11.20	0.4409	70	118	45	12	1	0614303	0613924
	11.30	0.4449	70	118	45	12	1	—	7361221
	11.40	0.4488	70	118	45	12	1	0134597	0134375
	11.50	0.4528	70	118	45	12	1	0614310	0613931



d <sub>1</sub> Ø Inch	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R454	R453
29/64	11.51	0.4531	70	118	45	12	1	0624203	0623794
	11.60	0.4567	70	118	45	12	1	0134603	0134382
	11.80	0.4646	70	118	45	12	1	0625675	0625262
15/32	11.91	0.4689	70	118	45	12	1	0624081	0623671
	12.00	0.4724	70	118	45	12	1	0614327	0613948
	12.05	0.4744	76	124	45	14	1	—	0625279
	12.10	0.4764	76	124	45	14	1	0625682	—
31/64	12.20	0.4803	76	124	45	14	1	0614334	0613955
	12.30	0.4843	76	124	45	14	1	0624241	0623831
	12.50	0.4921	76	124	45	14	1	0614341	0613962
1/2	12.70	0.5000	76	124	45	14	1	0625699	0625286
	12.70	0.5000	76	124	45	14	1	0624005	0623596
	12.80	0.5039	76	124	45	14	1	0134610	0134399
33/64	13.00	0.5118	76	124	45	14	1	0614358	0613979
	13.10	0.5157	76	124	45	14	1	0624258	0623848
	13.30	0.5236	76	124	45	14	1	—	7361222
17/32	13.49	0.5311	76	124	45	14	1	0624104	0623695
	13.50	0.5315	76	124	45	14	1	0614365	0613986
	13.80	0.5433	76	124	45	14	1	0134627	0134405
35/64	13.89	0.5469	76	124	45	14	1	0624265	0623855
	14.00	0.5512	76	124	45	14	1	0614372	0613993
	14.25	0.5610	82	133	48	16	1	0614389	0614006
9/16	14.29	0.5626	82	133	48	16	1	0624388	0623978
	14.50	0.5709	82	133	48	16	1	0614396	0614013
37/64	14.68	0.5780	82	133	48	16	1	0624272	0623862
	14.80	0.5827	82	133	48	16	1	0134634	0134412
	15.00	0.5906	82	133	48	16	1	0614402	0614020
19/32	15.08	0.5937	82	133	48	16	1	0624128	0623718
	15.10	0.5945	82	133	48	16	1	0625705	0625293
	15.30	0.6024	82	133	48	16	1	—	7361223
39/64	15.48	0.6094	82	133	48	16	1	0624289	0623879
	15.50	0.6102	82	133	48	16	1	0614419	0614037
	15.80	0.6220	82	133	48	16	1	0134641	0134429
5/8	15.88	0.6252	82	133	48	16	1	0624357	0623947
	16.00	0.6299	82	133	48	16	1	0614426	0614044
41/64	16.27	0.6406	91	143	48	18	1	0624296	0623886
	16.50	0.6496	91	143	48	18	1	0134658	0625309
21/32	16.67	0.6563	91	143	48	18	1	0624142	0623732
	17.00	0.6693	91	143	48	18	1	0134665	0625316
43/64	17.07	0.6720	91	143	48	18	1	0624302	0623893
11/16	17.46	0.6874	91	143	48	18	1	0624036	0623626
	17.50	0.6890	91	143	48	18	1	0134672	0625323
	17.80	0.7008	91	143	48	18	1	0134689	0134436
45/64	17.86	0.7031	91	143	48	18	1	0624319	0623909
	18.00	0.7087	91	143	48	18	1	0134696	0625330
23/32	18.26	0.7189	99	153	50	20	1	0624166	0623756
	18.50	0.7283	99	153	50	20	1	0134702	0625347
47/64	18.65	0.7343	99	153	50	20	1	0624326	0623916
	19.00	0.7480	99	153	50	20	1	0134719	0625354
3/4	19.05	0.7500	99	153	50	20	1	0624227	0623817
	19.50	0.7677	99	153	50	20	1	0134726	0625361
	19.80	0.7795	99	153	50	20	1	0134733	0134443
	20.00	0.7874	99	153	50	20	1	0134740	0625378

# FORCE X SOLID CARBIDE DRILL

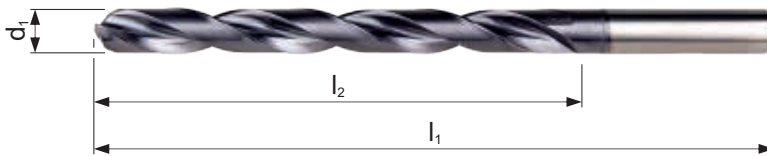


## Multi-Application, 8xD, Reinforced Shank

**R459** Coolant through clears chips away from the cutting edge. Self centering 4-flute split point and CTW flute construction for enhanced penetration rates. TiAlN coating increases surface hardness, improves tool life at high RPM.

- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4  
6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

**High productivity in a wide range of materials**



R459



Coolant Through

3.00 - 16.00

d <sub>1</sub> Øm <sub>7</sub> Inch	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R459
	3.00	0.1181	37	79	36	6	1	46718973
	3.10	0.1220	37	79	36	6	1	46718974
1/8	3.18	0.1252	37	79	36	6	1	46718975
	3.20	0.1260	37	79	36	6	1	46718976
	3.30	0.1299	37	79	36	6	1	46718977
	3.40	0.1339	37	79	36	6	1	46718978
	3.50	0.1378	37	79	36	6	1	46718979
9/64	3.57	0.1406	37	79	36	6	1	46718990
	3.60	0.1417	37	79	36	6	1	46718991
	3.70	0.1457	37	79	36	6	1	46718992
	3.80	0.1496	48	90	36	6	1	46718993
	3.90	0.1535	48	90	36	6	1	46718994
5/32	3.97	0.1563	48	90	36	6	1	46718995
	4.00	0.1575	48	90	36	6	1	46718996
	4.10	0.1614	48	90	36	6	1	46718997
	4.20	0.1654	48	90	36	6	1	46718998
	4.30	0.1693	48	90	36	6	1	46718999
11/64	4.37	0.1720	48	90	36	6	1	46719000
	4.40	0.1732	48	90	36	6	1	46719001
	4.50	0.1772	48	90	36	6	1	46719002
	4.60	0.1811	48	90	36	6	1	46719003
	4.70	0.1850	62	104	36	6	1	46719004
3/16	4.76	0.1874	62	104	36	6	1	46719005
	4.80	0.1890	62	104	36	6	1	46719006
	4.90	0.1929	62	104	36	6	1	46719007
	5.00	0.1969	62	104	36	6	1	46719008
	5.10	0.2008	62	104	36	6	1	46719009
13/64	5.16	0.2031	62	104	36	6	1	46719010
	5.20	0.2047	62	104	36	6	1	46719011
	5.30	0.2087	62	104	36	6	1	46719012
	5.40	0.2126	62	104	36	6	1	46719013
	5.50	0.2165	62	104	36	6	1	46719014

d <sub>1</sub> Øm <sub>7</sub> Inch	d <sub>1</sub> Øm <sub>7</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	R459
7/32	5.56	0.2189	62	104	36	6	1	46719015
	5.60	0.2205	62	104	36	6	1	46719016
	5.70	0.2244	62	104	36	6	1	46719017
	5.80	0.2283	62	104	36	6	1	46719018
	5.90	0.2323	62	104	36	6	1	46719019
15/64	5.95	0.2343	62	104	36	6	1	46719020
	6.00	0.2362	62	104	36	6	1	46719021
	6.10	0.2402	84	126	36	8	1	46719022
	6.20	0.2441	84	126	36	8	1	46719023
	6.30	0.2480	84	126	36	8	1	46719024
1/4	6.35	0.2500	84	126	36	8	1	46719025
	6.40	0.2520	84	126	36	8	1	46719026
	6.50	0.2559	84	126	36	8	1	46719027
	6.60	0.2598	84	126	36	8	1	46719028
	6.70	0.2638	84	126	36	8	1	46719029
17/64	6.75	0.2657	84	126	36	8	1	46719030
	6.80	0.2677	84	126	36	8	1	46719031
	6.90	0.2717	84	126	36	8	1	46719032
	7.00	0.2756	84	126	36	8	1	46719033
	7.10	0.2795	84	126	36	8	1	46719034
9/32	7.14	0.2811	84	126	36	8	1	46719035
	7.20	0.2835	84	126	36	8	1	46719036
	7.30	0.2874	84	126	36	8	1	46719037
	7.40	0.2913	84	126	36	8	1	46719038
	7.50	0.2953	84	126	36	8	1	46719039
19/64	7.54	0.2969	84	126	36	8	1	46719040
	7.60	0.2992	84	126	36	8	1	46719041
	7.70	0.3031	84	126	36	8	1	46719042
	7.80	0.3071	84	126	36	8	1	46719043
	7.90	0.3110	84	126	36	8	1	46719044
5/16	7.94	0.3126	84	126	36	8	1	46719045
	8.00	0.3150	84	126	36	8	1	46719046
	8.10	0.3189	106	152	40	10	1	46719047
	8.20	0.3228	106	152	40	10	1	46719048
	8.30	0.3268	106	152	40	10	1	46719049
21/64	8.33	0.3280	106	152	40	10	1	46719050
	8.40	0.3307	106	152	40	10	1	46719051
	8.50	0.3346	106	152	40	10	1	46719052
	8.60	0.3386	106	152	40	10	1	46719053
	8.70	0.3425	106	152	40	10	1	46719054
11/32	8.73	0.3437	106	152	40	10	1	46719055
	8.80	0.3465	106	152	40	10	1	46719056
	8.90	0.3504	106	152	40	10	1	46719057
	9.00	0.3543	106	152	40	10	1	46719058
	9.10	0.3583	106	152	40	10	1	46719059
23/64	9.13	0.3594	106	152	40	10	1	46719060
	9.20	0.3622	106	152	40	10	1	46719061
	9.30	0.3661	106	152	40	10	1	46719062
	9.40	0.3701	106	152	40	10	1	46719063
	9.50	0.3740	106	152	40	10	1	46719064
3/8	9.53	0.3748	106	152	40	10	1	46719065
	9.60	0.3780	106	152	40	10	1	46719066
	9.70	0.3819	106	152	40	10	1	46719067
	9.80	0.3858	106	152	40	10	1	46719068
	9.90	0.3898	106	152	40	10	1	46719069
25/64	9.92	0.3906	106	152	40	10	1	46719070
	10.00	0.3937	106	152	40	10	1	46719071
	10.20	0.4016	128	180	45	12	1	46719072
	10.30	0.4055	128	180	45	12	1	46719073
13/32	10.32	0.4063	128	180	45	12	1	46719074
	10.40	0.4094	128	180	45	12	1	46719075
	10.50	0.4134	128	180	45	12	1	46719076
27/64	10.72	0.4220	128	180	45	12	1	46719077
	10.80	0.4252	128	180	45	12	1	46719078

# FORCE X SOLID CARBIDE DRILL



$d_1$ $\varnothing m_7$ Inch	$d_1$ $\varnothing m_7$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	$l_3$ mm	$d_2$ $\varnothing h_6$ mm	Pack Qty	R459
	11.00	0.4331	128	180	45	12	1	46719079
7/16	11.11	0.4374	128	180	45	12	1	46719080
	11.20	0.4409	128	180	45	12	1	46719081
	11.30	0.4449	128	180	45	12	1	46719082
	11.50	0.4528	128	180	45	12	1	46719083
29/64	11.51	0.4531	128	180	45	12	1	46719084
	11.80	0.4646	128	180	45	12	1	46719085
15/32	11.91	0.4689	128	180	45	12	1	46719086
	12.00	0.4724	128	180	45	12	1	46719087
	12.20	0.4803	151	202	48	14	1	46719088
31/64	12.30	0.4843	151	202	48	14	1	46719089
	12.50	0.4921	151	202	48	14	1	46719090
1/2	12.70	0.5000	151	202	48	14	1	46719091
	12.80	0.5039	151	202	48	14	1	46719092
	13.00	0.5118	151	202	48	14	1	46719093
33/64	13.10	0.5157	151	202	48	14	1	46719094
17/32	13.49	0.5311	151	202	48	14	1	46719095
	13.50	0.5315	151	202	48	14	1	46719096
35/64	13.89	0.5469	151	202	48	14	1	46719097
	14.00	0.5512	151	202	48	14	1	46719098
	14.25	0.5610	172	227	48	16	1	46719099
9/16	14.29	0.5626	172	227	48	16	1	46719100
	14.50	0.5709	172	227	48	16	1	46719101
37/64	14.68	0.5780	172	227	48	16	1	46719102
	15.00	0.5906	172	227	48	16	1	46719103
19/32	15.08	0.5937	172	227	48	16	1	46719104
	15.10	0.5945	172	227	48	16	1	46719105
39/64	15.48	0.6094	172	227	48	16	1	46719106
	15.50	0.6102	172	227	48	16	1	46719107
5/8	15.88	0.6252	172	227	48	16	1	46719108
	16.00	0.6299	172	227	48	16	1	46719109

## Multi-Application, Screw Machine Length

### A520

- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3

Low thrust design. Notched point improves chip formation for enhanced penetration rate. TiN coating increases wear resistance and improves tool life.

# ADX

A520

DIN 1897

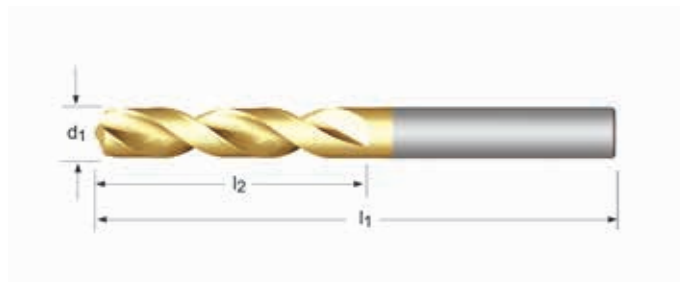
2.5XD

HSS

130°



3.00 - 13.00



$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A520
	3.00	0.1181	16	46	1	0038901
	3.10	0.1220	18	49	1	0038918
1/8	3.18	0.1250	18	49	1	0171264
	3.20	0.1260	18	49	1	0038925
	3.30	0.1299	18	49	1	0038932
	3.40	0.1339	20	52	1	0038949
	3.50	0.1378	20	52	1	0038956
9/64	3.57	0.1406	20	52	1	0171271
	3.60	0.1417	20	52	1	0038963
	3.70	0.1457	20	52	1	0038970
	3.80	0.1496	22	55	1	0038987
	3.90	0.1535	22	55	1	0038994
5/32	3.97	0.1563	22	55	1	0171288
	4.00	0.1575	22	55	1	0039007
	4.10	0.1614	22	55	1	0039014
	4.20	0.1654	22	55	1	0039021
	4.30	0.1693	24	58	1	0039038
11/64	4.37	0.1719	24	58	1	0171295
	4.40	0.1732	24	58	1	0039045
	4.50	0.1772	24	58	1	0039052
	4.60	0.1811	24	58	1	0039069
	4.70	0.1850	24	58	1	0039076
3/16	4.76	0.1875	26	62	1	0171301
	4.80	0.1890	26	62	1	0039083
	4.90	0.1929	26	62	1	0039090
	5.00	0.1969	26	62	1	0039106
	5.10	0.2008	26	62	1	0039113
13/64	5.16	0.2031	26	62	1	0171318
	5.20	0.2047	26	62	1	0039120
	5.30	0.2087	26	62	1	0039137
	5.40	0.2126	28	66	1	0039144
	5.50	0.2165	28	66	1	0039151
7/32	5.56	0.2188	28	66	1	0171325

# ADX SCREW MACHINE DRILL



$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A520
	5.60	0.2205	28	66	1	0039168
	5.70	0.2244	28	66	1	0039175
	5.80	0.2283	28	66	1	0039182
	5.90	0.2323	28	66	1	0039199
15/64	5.95	0.2344	28	66	1	0171332
	6.00	0.2362	28	66	1	0039205
	6.10	0.2402	31	70	1	0039212
	6.20	0.2441	31	70	1	0039229
	6.30	0.2480	31	70	1	0039236
1/4	6.35	0.2500	31	70	1	0171349
	6.40	0.2520	31	70	1	0039243
	6.50	0.2559	31	70	1	0039250
	6.60	0.2598	31	70	1	0039267
	6.70	0.2638	31	70	1	0039274
17/64	6.75	0.2656	34	74	1	0171356
	6.80	0.2677	34	74	1	0039281
	6.90	0.2717	34	74	1	0039298
	7.00	0.2756	34	74	1	0039304
	7.10	0.2795	34	74	1	0039311
9/32	7.14	0.2812	34	74	1	0171363
	7.20	0.2835	34	74	1	0039328
	7.30	0.2874	34	74	1	0039335
	7.40	0.2913	34	74	1	0039342
	7.50	0.2953	34	74	1	0039359
19/64	7.54	0.2969	37	79	1	0171370
	7.60	0.2992	37	79	1	0039366
	7.70	0.3031	37	79	1	0039373
	7.80	0.3071	37	79	1	0039380
	7.90	0.3110	37	79	1	0039397
5/16	7.94	0.3125	37	79	1	0171387
	8.00	0.3150	37	79	1	0039403
	8.10	0.3189	37	79	1	0039410
	8.20	0.3228	37	79	1	0039427
	8.30	0.3268	37	79	1	0039434
21/64	8.33	0.3281	37	79	1	0171394
	8.40	0.3307	37	79	1	0039441
	8.50	0.3346	37	79	1	0039458
	8.60	0.3386	40	84	1	0039465
	8.70	0.3425	40	84	1	0039472
11/32	8.73	0.3437	40	84	1	0171400
	8.80	0.3465	40	84	1	0039489
	8.90	0.3504	40	84	1	0039496
	9.00	0.3543	40	84	1	0039502
	9.10	0.3583	40	84	1	0039519
23/64	9.13	0.3594	40	84	1	0171417
	9.20	0.3622	40	84	1	0039526
	9.30	0.3661	40	84	1	0039533
	9.40	0.3701	40	84	1	0039540
	9.50	0.3740	40	84	1	0039557
3/8	9.52	0.3750	43	89	1	0171424
	9.60	0.3780	43	89	1	0039564
	9.70	0.3819	43	89	1	0039571
	9.80	0.3858	43	89	1	0039588
	9.90	0.3898	43	89	1	0039595
25/64	9.92	0.3906	43	89	1	0171431
	10.00	0.3937	43	89	1	0038598
	10.10	0.3976	43	89	1	0038604
	10.20	0.4016	43	89	1	0038611
	10.30	0.4055	43	89	1	0038628
13/32	10.32	0.4063	43	89	1	0171448
	10.40	0.4094	43	89	1	0038635
	10.50	0.4134	43	89	1	0038642
	10.60	0.4173	43	89	1	0038659
	10.70	0.4213	47	95	1	0038666
27/64	10.72	0.4219	47	95	1	0171455
	10.80	0.4252	47	95	1	0038673

$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A520
	10.90	0.4291	47	95	1	0038680
	11.00	0.4331	47	95	1	0038697
	11.10	0.4370	47	95	1	0038703
7/16	11.11	0.4375	47	95	1	0171462
	11.20	0.4409	47	95	1	0038710
	11.30	0.4449	47	95	1	0038727
	11.40	0.4488	47	95	1	0038734
	11.50	0.4528	47	95	1	0038741
29/64	11.51	0.4531	47	95	1	0171479
	11.60	0.4567	47	95	1	0038758
	11.70	0.4606	47	95	1	0038765
	11.80	0.4646	47	95	1	0038772
	11.90	0.4685	51	102	1	0038789
15/32	11.91	0.4688	51	102	1	0171486
	12.00	0.4724	51	102	1	0038796
	12.10	0.4764	51	102	1	0038802
	12.20	0.4803	51	102	1	0038819
	12.30	0.4843	51	102	1	0038826
31/64	12.30	0.4843	51	102	1	0171493
	12.40	0.4882	51	102	1	0038833
	12.50	0.4921	51	102	1	0038840
	12.60	0.4961	51	102	1	0038857
	12.70	0.5000	51	102	1	0038864
1/2	12.70	0.5000	51	102	1	0171509
	12.80	0.5039	51	102	1	0038871
	12.90	0.5079	51	102	1	0038888
	13.00	0.5118	51	102	1	0038895

# PFX SCREW MACHINE DRILL



## Multi-Application, Premium Cobalt Screw Machine Length - Parabolic Flute for Advanced Chip Removal

### A920

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2

4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2

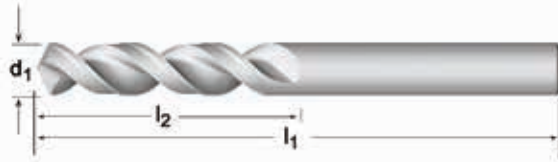
Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched point improves chip formation. Premium cobalt base material increases wear resistance. Bright finish improves chip flow in soft or non-ferrous materials.

### A921

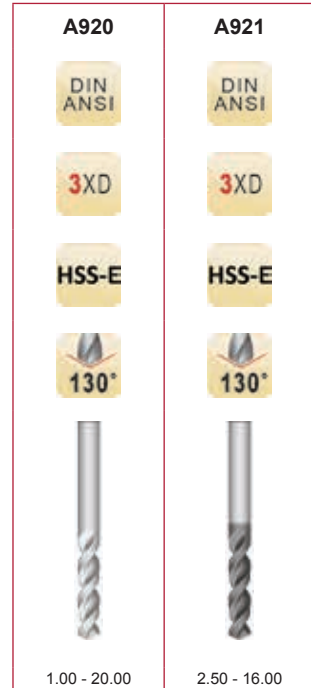
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2

4.3 5.1 5.2 5.3 6.3 6.4 7.4

Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched Point improves chip formation. Premium cobalt base material combined with AlCrN-Top coating increases lubricity and wear resistance which improves tool life.



# PFX



$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A920	A921
	1.00	0.0394	6	26	1	0050217	—
	1.10	0.0433	7	28	1	0050262	—
3/64	1.19	0.0469	13	35	1	0211427	—
	1.20	0.0472	8	30	1	0050309	—
	1.25	0.0492	8	30	1	0211434	—
	1.30	0.0512	8	30	1	0050316	—
	1.35	0.0531	9	32	1	0211458	—
	1.40	0.0551	9	32	1	0050323	—
	1.50	0.0591	9	32	1	0050347	—
	1.55	0.0610	10	34	1	0211489	—
1/16	1.59	0.0625	16	41	1	0050644	—
	1.60	0.0630	10	34	1	0050668	—
	1.70	0.0669	10	34	1	0050675	—
	1.75	0.0689	11	36	1	0211502	—
	1.80	0.0709	11	36	1	0050682	—
	1.90	0.0748	11	36	1	0050699	—
5/64	1.98	0.0781	17	43	1	0050705	—
	2.00	0.0787	12	38	1	0050712	—
	2.10	0.0827	12	38	1	0050729	—
	2.15	0.0846	13	40	1	0211571	—
	2.20	0.0866	13	40	1	0050743	—
	2.30	0.0906	13	40	1	0050750	—
	2.35	0.0925	14	43	1	0211601	—
3/32	2.38	0.0937	19	41	1	0050767	—
	2.40	0.0945	14	43	1	0050781	—
	2.50	0.0984	14	43	1	0050804	0052488
	2.60	0.1024	14	43	1	0050811	0052495
	2.70	0.1063	16	46	1	0050828	0212509
7/64	2.78	0.1094	21	46	1	0050835	0212523
	2.80	0.1102	16	46	1	0050842	—
	2.90	0.1142	16	46	1	0050859	0212561
	3.00	0.1181	16	46	1	0050866	0052501
	3.10	0.1220	18	49	1	0050873	0052518



d <sub>1</sub> Øh <sub>8</sub> Inch	d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	A920	A921
1/8	3.18	0.1250	22	48	1	0050880	0212592
	3.20	0.1260	18	49	1	0050897	0052525
	3.30	0.1299	18	49	1	0050903	0052532
	3.40	0.1339	20	52	1	0050910	0052549
	3.50	0.1378	20	52	1	0050927	0052556
9/64	3.57	0.1406	24	49	1	0050934	0212622
	3.60	0.1417	20	52	1	0050941	0052563
	3.70	0.1457	20	52	1	0050958	0052570
	3.80	0.1496	22	55	1	0050965	0052587
	3.90	0.1535	22	55	1	0050972	0052594
5/32	3.97	0.1563	25	52	1	0050989	0212677
	4.00	0.1575	22	55	1	0051009	0052600
	4.10	0.1614	22	55	1	0051016	0052617
	4.20	0.1654	22	55	1	0051023	0052624
11/64	4.30	0.1693	24	58	1	0051030	0052631
	4.37	0.1719	27	54	1	0051047	0286012
	4.40	0.1732	24	58	1	0051054	0052648
	4.50	0.1772	24	58	1	0051061	0052655
	4.60	0.1811	24	58	1	0051078	0052662
3/16	4.70	0.1850	24	58	1	0051085	0052679
	4.76	0.1875	29	56	1	0051092	0335635
	4.80	0.1890	26	62	1	0051108	0052686
	4.90	0.1929	26	62	1	0051115	0052693
	5.00	0.1969	26	62	1	0051122	0052709
13/64	5.10	0.2008	26	62	1	0051139	0052716
	5.16	0.2031	30	57	1	0051146	0441336
	5.20	0.2047	26	62	1	0051153	0052723
	5.30	0.2087	26	62	1	0051160	0052730
	5.40	0.2126	28	66	1	0051177	0052747
7/32	5.50	0.2165	28	66	1	0051191	0052754
	5.56	0.2188	32	60	1	0051207	0632956
	5.60	0.2205	28	66	1	0051214	0052761
	5.70	0.2244	28	66	1	0051221	0052778
	5.80	0.2283	28	66	1	0051238	0052785
15/64	5.90	0.2323	28	66	1	0051245	0052792
	5.95	0.2344	33	62	1	0051269	0632994
	6.00	0.2362	28	66	1	0051276	0052808
	6.10	0.2402	31	70	1	0051283	0052815
	6.20	0.2441	31	70	1	0051290	0052822
1/4	6.30	0.2480	31	70	1	0051306	0052839
	6.35	0.2500	35	64	1	0051313	0633038
	6.40	0.2520	31	70	1	0051320	0052846
	6.50	0.2559	31	70	1	0051337	0052853
	6.60	0.2598	31	70	1	0051344	0052860
17/64	6.70	0.2638	31	70	1	0051351	0052877
	6.75	0.2656	37	67	1	0051368	0633069
	6.80	0.2677	34	74	1	0051375	0052884
	6.90	0.2717	34	74	1	0051382	0052891
	7.00	0.2756	34	74	1	0051429	0052907
9/32	7.10	0.2795	34	74	1	0051436	0052914
	7.14	0.2812	38	68	1	0051443	0633106
	7.20	0.2835	34	74	1	0051450	0052921
	7.30	0.2874	34	74	1	0051467	0052938
	7.40	0.2913	34	74	1	0051474	0052945
19/64	7.50	0.2953	34	74	1	0051481	0052952
	7.54	0.2969	40	70	1	0051498	0633137
	7.60	0.2992	37	79	1	0051504	0052969
	7.70	0.3031	37	79	1	0051511	0052976
	7.80	0.3071	37	79	1	0051528	0053089
5/16	7.90	0.3110	37	79	1	0051535	0053096
	7.94	0.3125	41	71	1	0051542	0633151
	8.00	0.3150	37	79	1	0051566	0053102
	8.10	0.3189	37	79	1	0051580	0053119
	8.20	0.3228	37	79	1	0051603	0053133
21/64	8.30	0.3268	37	79	1	0051610	0053157
	8.33	0.3281	43	75	1	0051627	0633175

# PFX SCREW MACHINE DRILL



d <sub>1</sub> Øh <sub>8</sub> Inch	d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	A920	A921
	8.40	0.3307	37	79	1	0051634	0053249
	8.50	0.3346	37	79	1	0051658	0053256
	8.60	0.3386	40	84	1	0051665	0053263
	8.70	0.3425	40	84	1	0051672	0053270
11/32	8.73	0.3437	43	76	1	0051689	0633205
	8.80	0.3465	40	84	1	0051702	0053287
	8.90	0.3504	40	84	1	0051719	0053294
	9.00	0.3543	40	84	1	0051726	0053300
	9.10	0.3583	40	84	1	0051733	0053317
23/64	9.13	0.3594	44	78	1	0051740	0633236
	9.20	0.3622	40	84	1	0051757	0053324
	9.30	0.3661	40	84	1	0051764	0053331
	9.40	0.3701	40	84	1	0051771	0053348
	9.50	0.3740	40	84	1	0051788	0053355
3/8	9.52	0.3750	46	79	1	0051795	0633250
	9.60	0.3780	43	89	1	0051801	0053362
	9.70	0.3819	43	89	1	0051818	0053379
	9.80	0.3858	43	89	1	0051825	0053386
	9.90	0.3898	43	89	1	0051832	0053393
25/64	9.92	0.3906	48	83	1	0051849	0633274
	10.00	0.3937	43	89	1	0051856	0053409
	10.20	0.4016	43	89	1	0051863	0053416
	10.30	0.4055	43	89	1	0051870	0053423
13/32	10.32	0.4063	49	84	1	0051887	0633304
	10.50	0.4134	43	89	1	0051900	0053447
27/64	10.72	0.4219	51	86	1	0051917	0633328
	10.80	0.4252	47	95	1	0051924	0053454
	11.00	0.4331	47	95	1	0051931	0053461
7/16	11.11	0.4375	52	87	1	0051948	0633342
	11.50	0.4528	47	95	1	0051962	0053485
29/64	11.51	0.4531	54	90	1	0051979	0633366
	11.80	0.4646	47	95	1	0051986	0053492
15/32	11.91	0.4688	54	92	1	0051993	0633373
	12.00	0.4724	51	102	1	0052006	0053508
	12.20	0.4803	51	102	1	0052013	—
31/64	12.30	0.4843	56	94	1	0052020	0633380
	12.50	0.4921	51	102	1	0052037	0053522
1/2	12.70	0.5000	57	95	1	0052044	0633397
	13.00	0.5118	51	102	1	0052068	0053546
33/64	13.10	0.5156	60	98	1	0212257	0633410
	13.50	0.5315	54	107	1	0052075	0053553
35/64	13.89	0.5469	64	102	1	0212264	0633427
	14.00	0.5512	54	107	1	0052082	0053560
9/16	14.29	0.5625	64	102	1	0212271	0633434
	14.50	0.5709	56	111	1	0052099	0053577
37/64	14.68	0.5781	67	105	1	0212288	0633441
	14.75	0.5807	56	111	1	0212295	0633458
	15.00	0.5906	56	111	1	0052105	0053584
19/32	15.08	0.5937	67	105	1	0212301	0633465
39/64	15.48	0.6094	70	108	1	0212318	0633472
	15.50	0.6102	58	115	1	0052112	0053591
5/8	15.88	0.6250	70	108	1	0212325	0633489
	16.00	0.6299	58	115	1	0052129	0053607
41/64	16.27	0.6406	73	114	1	0212332	—
	16.50	0.6496	60	119	1	0212349	—
21/32	16.67	0.6563	73	114	1	0212356	—
	16.75	0.6594	60	119	1	0212363	—
	17.00	0.6693	60	119	1	0052136	—
43/64	17.07	0.6719	73	117	1	0212370	—
11/16	17.46	0.6875	73	117	1	0212387	—
	17.50	0.6890	62	123	1	0052143	—
45/64	17.86	0.7031	76	121	1	0212394	—
	18.00	0.7087	62	123	1	0052457	—
23/32	18.26	0.7188	76	121	1	0212400	—
	18.50	0.7283	64	127	1	0212417	—
47/64	18.65	0.7344	79	127	1	0212424	—

$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A920	A921
	19.00	0.7480	64	127	1	0052464	—
3/4	19.05	0.7500	79	127	1	0212431	—
49/64	19.45	0.7656	83	130	1	0212448	—
	19.50	0.7677	66	131	1	0212455	—
25/32	19.84	0.7813	83	130	1	0212462	—
	20.00	0.7874	66	131	1	0052471	—

# ADX JOBBER LENGTH DRILL



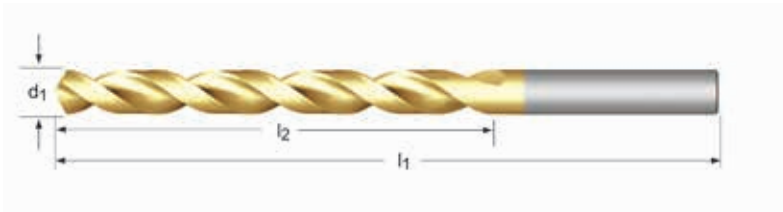
## Multi-Application, Jobber Length

### A510

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3

Low thrust design. Notched point improves chip formation for enhanced penetration rate. TiN coating increases wear resistance and improves tool life.

# ADX



$d_1$ Ø <sub>h8</sub> Inch	$d_1$ Ø <sub>h8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A510
	3.00	0.1181	33	61	1	0036495
	3.10	0.1220	36	65	1	0036501
1/8	3.18	0.1250	36	65	1	0168974
	3.20	0.1260	36	65	1	0036518
	3.30	0.1299	36	65	1	0036525
	3.40	0.1339	39	70	1	0036532
	3.50	0.1378	39	70	1	0036549
9/64	3.57	0.1406	39	70	1	0168981
	3.60	0.1417	39	70	1	0036556
	3.70	0.1457	39	70	1	0036563
	3.80	0.1496	43	75	1	0036570
	3.90	0.1535	43	75	1	0036587
5/32	3.97	0.1563	43	75	1	0168998
	4.00	0.1575	43	75	1	0036594
	4.10	0.1614	43	75	1	0036600
	4.20	0.1654	43	75	1	0036617
	4.30	0.1693	47	80	1	0036624
11/64	4.37	0.1719	47	80	1	0169001
	4.40	0.1732	47	80	1	0036631
	4.50	0.1772	47	80	1	0036648
	4.60	0.1811	47	80	1	0036655
	4.70	0.1850	47	80	1	0036662
3/16	4.76	0.1875	52	86	1	0169018
	4.80	0.1890	52	86	1	0036679
	4.90	0.1929	52	86	1	0036686
	5.00	0.1969	52	86	1	0036693
	5.10	0.2008	52	86	1	0036709
13/64	5.16	0.2031	52	86	1	0169025
	5.20	0.2047	52	86	1	0036716
	5.30	0.2087	52	86	1	0036723
	5.40	0.2126	57	93	1	0036730
	5.50	0.2165	57	93	1	0036747
7/32	5.56	0.2188	57	93	1	0169032

d <sub>1</sub> Øh <sub>8</sub> Inch	d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	A510
	5.60	0.2205	57	93	1	0036754
	5.70	0.2244	57	93	1	0036761
	5.80	0.2283	57	93	1	0036778
	5.90	0.2323	57	93	1	0036785
15/64	5.95	0.2344	57	93	1	0169049
	6.00	0.2362	57	93	1	0036792
	6.10	0.2402	63	101	1	0036808
	6.20	0.2441	63	101	1	0036815
	6.30	0.2480	63	101	1	0036822
1/4	6.35	0.2500	63	101	1	0169056
	6.40	0.2520	63	101	1	0036839
	6.50	0.2559	63	101	1	0036846
	6.60	0.2598	63	101	1	0036853
	6.70	0.2638	63	101	1	0036860
17/64	6.75	0.2656	69	109	1	0169063
	6.80	0.2677	69	109	1	0036877
	6.90	0.2717	69	109	1	0036884
	7.00	0.2756	69	109	1	0036891
	7.10	0.2795	69	109	1	0036907
9/32	7.14	0.2812	69	109	1	0169070
	7.20	0.2835	69	109	1	0036914
	7.30	0.2874	69	109	1	0036921
	7.40	0.2913	69	109	1	0036938
	7.50	0.2953	69	109	1	0036945
19/64	7.54	0.2969	75	117	1	0169087
	7.60	0.2992	75	117	1	0036952
	7.70	0.3031	75	117	1	0036969
	7.80	0.3071	75	117	1	0036976
	7.90	0.3110	75	117	1	0036983
5/16	7.94	0.3125	75	117	1	0169094
	8.00	0.3150	75	117	1	0036990
	8.10	0.3189	75	117	1	0037003
	8.20	0.3228	75	117	1	0037010
	8.30	0.3268	75	117	1	0037027
21/64	8.33	0.3281	75	117	1	0169100
	8.40	0.3307	75	117	1	0037034
	8.50	0.3346	75	117	1	0037041
	8.60	0.3386	81	125	1	0037058
	8.70	0.3425	81	125	1	0037065
11/32	8.73	0.3437	81	125	1	0169117
	8.80	0.3465	81	125	1	0037072
	8.90	0.3504	81	125	1	0037089
	9.00	0.3543	81	125	1	0037096
	9.10	0.3583	81	125	1	0037102
23/64	9.13	0.3594	81	125	1	0169124
	9.20	0.3622	81	125	1	0037119
	9.30	0.3661	81	125	1	0037126
	9.40	0.3701	81	125	1	0037133
	9.50	0.3740	81	125	1	0037140
3/8	9.52	0.3750	87	133	1	0169131
	9.60	0.3780	87	133	1	0037157
	9.70	0.3819	87	133	1	0037164
	9.80	0.3858	87	133	1	0037171
	9.90	0.3898	87	133	1	0037188
25/64	9.92	0.3906	87	133	1	0169148
	10.00	0.3937	87	133	1	0036174
	10.10	0.3976	87	133	1	0036181
	10.20	0.4016	87	133	1	0036198
	10.30	0.4055	87	133	1	0036204
13/32	10.32	0.4063	87	133	1	0169155
	10.40	0.4094	87	133	1	0036211
	10.50	0.4134	87	133	1	0036228
	10.60	0.4173	87	133	1	0036235
	10.70	0.4213	94	142	1	0036242
27/64	10.72	0.4219	94	142	1	0169162
	10.80	0.4252	94	142	1	0036259

# ADX JOBBER LENGTH DRILL



$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A510
	10.90	0.4291	94	142	1	0036266
	11.00	0.4331	94	142	1	0036273
	11.10	0.4370	94	142	1	0036280
7/16	11.11	0.4375	94	142	1	0169179
	11.20	0.4409	94	142	1	0036297
	11.30	0.4449	94	142	1	0036303
	11.40	0.4488	94	142	1	0036310
	11.50	0.4528	94	142	1	0036327
29/64	11.51	0.4531	94	142	1	0169186
	11.60	0.4567	94	142	1	0036334
	11.70	0.4606	94	142	1	0036341
	11.80	0.4646	94	142	1	0036358
	11.90	0.4685	101	151	1	0036365
15/32	11.91	0.4688	101	151	1	0169193
	12.00	0.4724	101	151	1	0036372
	12.10	0.4764	101	151	1	0036389
	12.20	0.4803	101	151	1	0036396
	12.30	0.4843	101	151	1	0036402
31/64	12.30	0.4843	101	151	1	0169209
	12.40	0.4882	101	151	1	0036419
	12.50	0.4921	101	151	1	0036426
	12.60	0.4961	101	151	1	0036433
	12.70	0.5000	101	151	1	0036440
1/2	12.70	0.5000	101	151	1	0169216
	12.80	0.5039	101	151	1	0036457
	12.90	0.5079	101	151	1	0036464
	13.00	0.5118	101	151	1	0036471
	14.00	0.5512	108	160	1	0036488

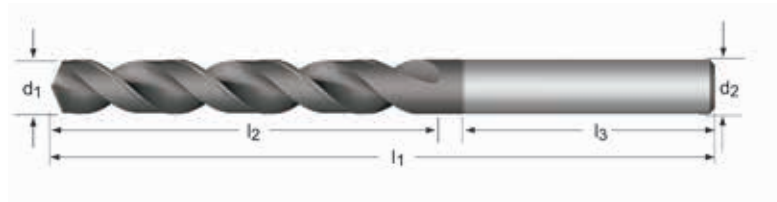
Multi-Application, Premium Cobalt Coolant Feed w/ Reinforced Shank

# ADX

## A553

- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1

Notched point improves chip formation. Low thrust design. Cobalt base material & TiAlN-Top coating increases wear resistance and improves tool life.



d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	A553
5.00	0.1969	36	79	36	6	1	0391204
5.20	0.2047	38	79	36	6	1	0391228
5.50	0.2165	40	79	36	6	1	0391242
6.00	0.2362	43	79	36	6	1	0391280
6.30	0.2480	46	87	36	8	1	0391297
6.50	0.2559	47	87	36	8	1	0391303
6.80	0.2677	48	87	36	8	1	0391327
6.90	0.2717	48	87	36	8	1	0391334
7.00	0.2756	48	87	36	8	1	0391341
7.40	0.2913	54	94	36	8	1	0391365
7.50	0.2953	54	94	36	8	1	0391372
8.00	0.3150	58	94	36	8	1	0391402
8.50	0.3346	75	130	40	10	1	0391419
8.70	0.3425	75	130	40	10	1	0391426
9.00	0.3543	75	130	40	10	1	0391433
9.50	0.3740	75	130	40	10	1	0391457
10.00	0.3937	75	130	40	10	1	0390795
10.20	0.4016	87	150	45	12	1	0390801
10.30	0.4055	87	150	45	12	1	0390818
10.50	0.4134	87	150	45	12	1	0390825
11.00	0.4330	94	150	45	12	1	0390849
11.30	0.4449	94	150	45	12	1	0390856
11.50	0.4528	94	150	45	12	1	0390863
12.00	0.4724	94	150	45	12	1	0390870
12.50	0.4921	101	160	45	14	1	0390887
13.00	0.5118	101	160	45	14	1	0390894
13.50	0.5315	101	160	45	14	1	0390924
14.00	0.5512	101	160	45	14	1	0390948
14.25	0.5610	108	170	48	16	1	0390955
14.50	0.5709	108	170	48	16	1	0390962
15.00	0.5906	108	170	48	16	1	0390986
15.25	0.6004	108	170	48	16	1	0391006
15.50	0.6102	108	170	48	16	1	0391013

# ADX STANDARD LENGTH DRILL



$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	$l_3$ mm	$d_2$ $\varnothing h_6$ mm	Pack Qty	A553
16.00	0.6299	108	170	48	16	1	0391037
16.50	0.6496	125	190	48	18	1	0391051
17.00	0.6693	125	190	48	18	1	0391075
17.50	0.6890	130	190	48	18	1	0391099
17.75	0.6988	130	190	48	18	1	0391105
18.00	0.7087	130	190	48	18	1	0391112
19.00	0.7480	135	200	50	20	1	0391150
19.25	0.7579	140	200	50	20	1	0391167
20.00	0.7874	140	200	50	20	1	0391198



## Premium Cobalt Jobber Length - Parabolic Flute for Advanced Chip Removal

### A900

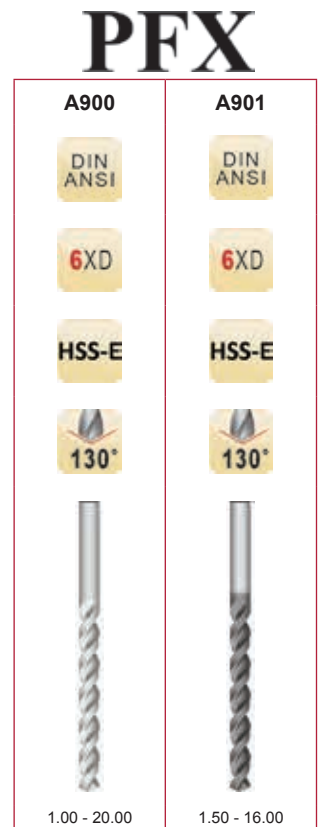
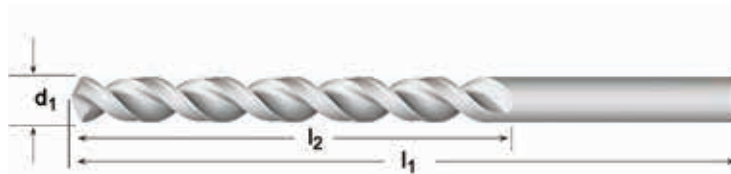
- 1.1
- 1.2
- 1.3
- 1.4
- 1.5
- 1.6
- 2.1
- 2.2
- 2.3
- 3.1
- 3.2
- 3.3
- 3.4
- 4.1
- 4.2
- 4.3
- 5.1
- 5.2
- 5.3
- 6.1
- 6.2
- 6.3
- 6.4
- 7.1
- 7.2
- 7.3
- 7.4
- 8.1
- 8.2

Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched Point improves chip formation. Premium cobalt base material increases wear resistance. Bright finish improves chip flow in soft or non-ferrous materials.

### A901

- 1.1
- 1.2
- 1.3
- 1.4
- 1.5
- 1.6
- 2.1
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- 2.3
- 3.1
- 3.2
- 3.3
- 3.4
- 4.1
- 4.2
- 4.3
- 5.1
- 5.2
- 5.3
- 6.3
- 6.4
- 7.4

Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched point improves chip formation. Premium Cobalt base material combined with AlCrN-Top coating increases lubricity and wear resistance which improves tool life.



$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A900	A901
	1.00	0.0394	12	34	1	0046289	—
	1.10	0.0433	14	36	1	0046296	—
3/64	1.19	0.0469	19	44	1	0633540	—
	1.20	0.0472	16	38	1	0046302	—
	1.25	0.0492	16	36	1	0633557	—
	1.30	0.0512	16	38	1	0046319	—
	1.40	0.0551	18	40	1	0046326	—
	1.50	0.0591	18	40	1	0046333	0047781
	1.55	0.0610	20	43	1	0633601	0634547
1/16	1.59	0.0625	22	48	1	0046340	0634554
	1.60	0.0630	20	43	1	0046357	0634561
	1.70	0.0669	20	43	1	0046364	—
	1.75	0.0689	22	46	1	0633625	0634592
	1.80	0.0709	22	46	1	0046371	0634615
	1.90	0.0748	22	46	1	0046388	0634639
5/64	1.98	0.0781	25	51	1	0046395	0634653
	2.00	0.0787	24	49	1	0046401	0047798
	2.10	0.0827	24	49	1	0046418	0634691
	2.15	0.0846	27	53	1	0633694	0634707
	2.20	0.0866	27	53	1	0046425	—
	2.30	0.0906	27	53	1	0046432	—
3/32	2.38	0.0937	32	57	1	0046449	0634752
	2.40	0.0945	30	57	1	0046456	0634769
	2.50	0.0984	30	57	1	0046463	0047804
	2.60	0.1024	30	57	1	0046470	0047811
	2.70	0.1063	33	61	1	0046487	0634820
7/64	2.78	0.1094	38	67	1	0046494	0634844
	2.80	0.1102	33	61	1	0046500	—
	2.90	0.1142	33	61	1	0046517	0634882
	3.00	0.1181	33	61	1	0046524	0047828
	3.10	0.1220	36	65	1	0046531	0047835
1/8	3.18	0.1250	41	70	1	0046548	0634912
	3.20	0.1260	36	65	1	0046555	0047842
	3.30	0.1299	36	65	1	0046562	0047859

# PFX JOBBER LENGTH DRILL



$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A900	A901
	3.40	0.1339	39	70	1	0046579	0047866
	3.50	0.1378	39	70	1	0046586	0047873
9/64	3.57	0.1406	44	73	1	0046593	0634943
	3.60	0.1417	39	70	1	0046609	0047880
	3.70	0.1457	39	70	1	0046616	0047897
	3.80	0.1496	43	75	1	0046623	0047903
	3.90	0.1535	43	75	1	0046630	0047910
5/32	3.97	0.1563	51	79	1	0046647	0634998
	4.00	0.1575	43	75	1	0046654	0047927
	4.10	0.1614	43	75	1	0046661	0047934
	4.20	0.1654	43	75	1	0046678	0047941
	4.30	0.1693	47	80	1	0046685	0047958
11/64	4.37	0.1719	54	83	1	0046692	0635056
	4.40	0.1732	47	80	1	0046708	0047965
	4.50	0.1772	47	80	1	0046715	0047972
	4.60	0.1811	47	80	1	0046722	0047989
	4.70	0.1850	47	80	1	0046739	0047996
3/16	4.76	0.1875	59	89	1	0046746	0635094
	4.80	0.1890	52	86	1	0046753	0048009
	4.90	0.1929	52	86	1	0046760	0048016
	5.00	0.1969	52	86	1	0046777	0048023
	5.10	0.2008	52	86	1	0046784	0048030
13/64	5.16	0.2031	62	92	1	0046807	0635155
	5.20	0.2047	52	86	1	0046814	0048047
	5.30	0.2087	52	86	1	0046821	0048054
	5.40	0.2126	57	93	1	0046838	0048061
	5.50	0.2165	57	93	1	0046845	0048078
7/32	5.56	0.2188	64	95	1	0046852	0635209
	5.60	0.2205	57	93	1	0046869	0048085
	5.70	0.2244	57	93	1	0046876	0048092
	5.80	0.2283	57	93	1	0046883	0048108
	5.90	0.2323	57	93	1	0046890	0048115
15/64	5.95	0.2344	67	98	1	0046906	0635247
	6.00	0.2362	57	93	1	0046913	0048122
	6.10	0.2402	63	101	1	0046920	0048139
	6.20	0.2441	63	101	1	0046937	0048146
	6.30	0.2480	63	101	1	0046944	0048153
1/4	6.35	0.2500	70	102	1	0046951	0635285
	6.40	0.2520	63	101	1	0046968	0048160
	6.50	0.2559	63	101	1	0046975	0048177
	6.60	0.2598	63	101	1	0046999	0048184
	6.70	0.2638	63	101	1	0047002	0048191
17/64	6.75	0.2656	73	105	1	0047019	0635315
	6.80	0.2677	69	109	1	0047026	0048207
	6.90	0.2717	69	109	1	0047033	0048214
	7.00	0.2756	69	109	1	0047057	0048221
	7.10	0.2795	69	109	1	0047064	0048238
9/32	7.14	0.2812	75	108	1	0047071	0635353
	7.20	0.2835	69	109	1	0047088	0048245
	7.30	0.2874	69	109	1	0047095	0048252
	7.40	0.2913	69	109	1	0047101	0048269
	7.50	0.2953	69	109	1	0047118	0048276
19/64	7.54	0.2969	78	111	1	0047125	0635384
	7.60	0.2992	75	117	1	0047132	0048283
	7.70	0.3031	75	117	1	0047149	0048290
	7.80	0.3071	75	117	1	0047156	0048306
	7.90	0.3110	75	117	1	0047163	0048313
5/16	7.94	0.3125	81	114	1	0047170	0635407
	8.00	0.3150	75	117	1	0047187	0048320
	8.10	0.3189	75	117	1	0047194	0048337
	8.20	0.3228	75	117	1	0047200	0048344
	8.30	0.3268	75	117	1	0047217	0048351
21/64	8.33	0.3280	84	117	1	0047224	0635421
	8.40	0.3307	75	117	1	0047231	0048368
	8.50	0.3346	75	117	1	0047255	0048375
	8.60	0.3386	81	125	1	0047262	0048382

$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A900	A901
11/32	8.70	0.3425	81	125	1	0047286	0048399
	8.73	0.3437	87	121	1	0047293	0635452
	8.80	0.3465	81	125	1	0047309	0048405
	8.90	0.3504	81	125	1	0047316	0048412
	9.00	0.3543	81	125	1	0047323	0048429
23/64	9.10	0.3583	81	125	1	0047330	0048436
	9.13	0.3594	89	124	1	0047347	0635483
	9.20	0.3622	81	125	1	0047354	0048443
	9.30	0.3661	81	125	1	0047361	0048450
	9.40	0.3701	81	125	1	0047378	0048467
3/8	9.50	0.3740	81	125	1	0047385	0048474
	9.52	0.3750	92	127	1	0047392	0635506
	9.60	0.3780	87	133	1	0047408	0048481
	9.70	0.3819	87	133	1	0047415	0048498
	9.80	0.3858	87	133	1	0047422	0048504
25/64	9.90	0.3898	87	133	1	0047439	0048627
	9.92	0.3906	95	130	1	0047446	0635520
	10.00	0.3937	87	133	1	0047453	0048641
	10.20	0.4016	87	133	1	0047460	0048863
	10.30	0.4055	87	133	1	0047477	0048870
13/32	10.32	0.4063	98	133	1	0047484	0635551
	10.40	0.4094	87	133	1	0047491	0048955
	10.50	0.4134	87	133	1	0047507	0049013
27/64	10.72	0.4219	100	137	1	0047514	0635575
	10.80	0.4252	94	142	1	0047521	0049198
	11.00	0.4331	94	142	1	0047538	0049235
7/16	11.11	0.4375	103	140	1	0047545	0635599
	11.50	0.4528	94	142	1	0047569	0049280
29/64	11.51	0.4531	106	143	1	0047576	0635612
	11.80	0.4646	94	142	1	0047583	0049297
15/32	11.91	0.4688	110	146	1	0047590	0635629
	12.00	0.4724	101	151	1	0047606	0049303
31/64	12.30	0.4843	111	149	1	0047620	0635636
	12.50	0.4921	101	151	1	0047637	0049594
1/2	12.70	0.5000	101	151	1	0047644	46073789
	13.00	0.5118	101	151	1	0047668	0049655
33/64	13.10	0.5156	122	168	1	0634318	0635650
	13.50	0.5315	108	160	1	0047675	0049662
35/64	13.89	0.5469	122	168	1	0634325	0635667
	14.00	0.5512	108	160	1	0047682	0049686
9/16	14.29	0.5625	122	168	1	0634332	0635674
	14.50	0.5709	114	169	1	0047699	0049709
37/64	14.68	0.5781	122	168	1	0634349	0635681
	15.00	0.5906	114	169	1	0047705	0049723
19/32	15.08	0.5937	132	181	1	0634363	0635704
39/64	15.48	0.6094	132	181	1	0634370	0635711
	15.50	0.6102	120	178	1	0047712	0050132
5/8	15.88	0.6250	132	181	1	0634387	0635728
	16.00	0.6299	120	178	1	0047729	0050170
41/64	16.27	0.6406	132	181	1	0634394	—
	16.50	0.6496	125	184	1	0634400	—
21/32	16.67	0.6562	132	181	1	0634417	—
	17.00	0.6693	125	184	1	0047736	—
43/64	17.07	0.6719	143	194	1	0634431	—
	17.46	0.6875	143	194	1	0634448	—
11/16	17.50	0.6890	130	191	1	0047743	—
	17.86	0.7031	130	191	1	0634455	—
45/64	18.00	0.7087	130	191	1	0047750	—
	18.26	0.7187	130	191	1	0634462	—
23/32	18.50	0.7283	135	198	1	0634479	—
	18.65	0.7344	135	198	1	0634486	—
47/64	19.00	0.7480	135	198	1	0047767	—
	19.05	0.7500	135	198	1	0634493	—
3/4	19.45	0.7656	135	198	1	0634509	—
49/64	19.50	0.7677	140	205	1	0634516	—
	19.84	0.7812	140	205	1	0634523	—
25/32	20.00	0.7874	140	205	1	0047774	—

# PFX TAPER LENGTH DRILL



Premium Cobalt, Taper Length - Parabolic Flute for Advanced Chip Removal

## A940

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.2 3.3 3.4 4.1 4.2 4.3

6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2

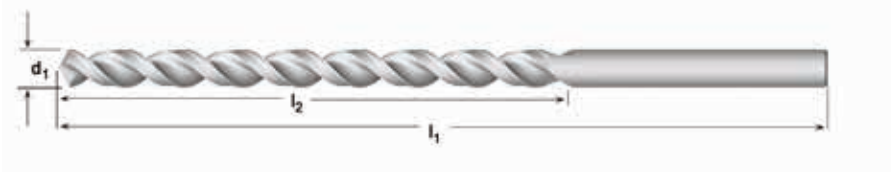
Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched point improves chip formation. Premium cobalt material increases wear resistance. Bright finish improves chip flow in soft or non-ferrous materials.

## A941

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2

4.3 6.3 6.4 7.4

Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched point improves chip formation. Premium cobalt base material combined with AlCrN-Top Coating increases lubricity and wear resistance which improves tool life.



# PFX



$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A940	A941
	1.00	0.0394	33	56	1	0053614	0059371
	1.10	0.0433	37	60	1	0053621	—
3/64	1.19	0.0469	29	57	1	0635735	0635803
	1.20	0.0472	41	65	1	0053638	—
	1.30	0.0512	41	65	1	0053645	—
	1.40	0.0551	45	70	1	0053751	—
	1.50	0.0591	45	70	1	0053768	0059388
1/16	1.59	0.0625	44	76	1	0053775	0635810
	1.60	0.0630	50	76	1	0054253	—
	1.70	0.0669	50	76	1	0054260	—
	1.80	0.0709	53	80	1	0054383	—
	1.90	0.0748	53	80	1	0054390	—
5/64	1.98	0.0781	51	95	1	0054406	0635827
	2.00	0.0787	56	85	1	0054604	0059401
	2.10	0.0827	56	85	1	0054611	—
	2.20	0.0866	59	90	1	0054628	—
	2.30	0.0906	59	90	1	0054710	—
3/32	2.38	0.0937	57	108	1	0054727	0635834
	2.40	0.0945	62	95	1	0054734	—
	2.50	0.0984	62	95	1	0054789	0059418
	2.60	0.1024	62	95	1	0054796	—
	2.70	0.1063	66	100	1	0054802	—
7/64	2.78	0.1094	64	117	1	0054833	0635841
	2.80	0.1102	66	100	1	0054840	—
	2.90	0.1142	66	100	1	0054857	—
	3.00	0.1181	66	100	1	0054871	0059432
	3.10	0.1220	69	106	1	0055465	0059449
1/8	3.18	0.1250	70	130	1	0055472	0635858
	3.20	0.1260	69	106	1	0055533	0059463
	3.30	0.1299	69	106	1	0055540	0059654
	3.40	0.1339	73	112	1	0055588	0059661
	3.50	0.1378	73	112	1	0055595	0059838
9/64	3.57	0.1406	76	137	1	0055618	0635865

$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A940	A941
	3.60	0.1417	73	112	1	0055625	0059944
	3.70	0.1457	73	112	1	0055632	0059968
	3.80	0.1496	78	119	1	0056011	0059982
	3.90	0.1535	78	119	1	0056028	0060216
5/32	3.97	0.1563	76	137	1	0056165	0635872
	4.00	0.1575	78	119	1	0056172	0060223
	4.10	0.1614	78	119	1	0056226	0060315
	4.20	0.1654	78	119	1	0056233	0060322
	4.30	0.1693	82	126	1	0056257	0060377
11/64	4.37	0.1719	86	146	1	0056264	0635889
	4.40	0.1732	82	126	1	0056271	0060384
	4.50	0.1772	82	126	1	0056288	0060414
	4.60	0.1811	82	126	1	0056295	0060421
	4.70	0.1850	82	126	1	0056301	0060445
3/16	4.76	0.1875	86	146	1	0056318	0635896
	4.80	0.1890	87	132	1	0056561	0060452
	4.90	0.1929	87	132	1	0056615	0060476
	5.00	0.1969	87	132	1	0056646	0060490
	5.10	0.2008	87	132	1	0056820	0060513
13/64	5.16	0.2031	92	152	1	0056882	0635902
	5.20	0.2047	87	132	1	0056974	0060605
	5.30	0.2087	87	132	1	0057001	0060612
	5.40	0.2126	91	139	1	0057056	0060674
	5.50	0.2165	91	139	1	0057780	0060681
7/32	5.56	0.2188	92	152	1	0057797	0635919
	5.60	0.2205	91	139	1	0057810	0060728
	5.70	0.2244	91	139	1	0057827	0060735
	5.80	0.2283	91	139	1	0057834	0060766
	5.90	0.2323	91	139	1	0057841	0060773
15/64	5.95	0.2344	95	156	1	0057858	0635926
	6.00	0.2362	91	139	1	0057865	0060797
	6.10	0.2402	97	148	1	0057872	0060889
	6.20	0.2441	97	148	1	0058145	0060940
	6.30	0.2480	97	148	1	0058152	0060995
1/4	6.35	0.2500	95	156	1	0058169	0635933
	6.40	0.2520	97	148	1	0058176	0061022
	6.50	0.2559	97	148	1	0058183	0061046
	6.60	0.2598	97	148	1	0058190	0061053
	6.70	0.2638	97	148	1	0058206	0061091
17/64	6.75	0.2656	98	159	1	0058213	0635940
	6.80	0.2677	102	156	1	0058220	0061107
	6.90	0.2717	102	156	1	0058237	0061114
	7.00	0.2756	102	156	1	0058244	0061121
	7.10	0.2795	102	156	1	0058251	0061138
9/32	7.14	0.2812	98	159	1	0058268	0635957
	7.20	0.2835	102	156	1	0058275	0061145
	7.30	0.2874	102	156	1	0058282	0061152
	7.40	0.2913	102	156	1	0058299	0061169
	7.50	0.2953	102	156	1	0058305	0061176
19/64	7.54	0.2969	102	162	1	0058312	0635964
	7.60	0.2992	109	165	1	0058343	0061183
	7.70	0.3031	109	165	1	0058350	0061190
	7.80	0.3071	109	165	1	0058374	0061206
	7.90	0.3110	109	165	1	0058381	0061213
5/16	7.94	0.3125	102	162	1	0058398	0635971
	8.00	0.3150	109	165	1	0058404	0061220
	8.10	0.3189	109	165	1	0058411	0061237
	8.20	0.3228	109	165	1	0058435	0061244
	8.30	0.3268	109	165	1	0058442	0061251
21/64	8.33	0.3281	105	165	1	0058473	0635988
	8.40	0.3307	109	165	1	0058503	0061268
	8.50	0.3346	109	165	1	0058510	0061275
	8.60	0.3386	115	175	1	0058558	0061282
	8.70	0.3425	115	175	1	0058572	0061299
11/32	8.73	0.3438	105	165	1	0058589	0635995
	8.80	0.3465	115	175	1	0058596	0061305

# PFX TAPER LENGTH DRILL



d <sub>1</sub> Øh <sub>8</sub> Inch	d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	A940	A941
	8.90	0.3504	115	175	1	0058602	0061312
	9.00	0.3543	115	175	1	0058626	0061329
	9.10	0.3583	115	175	1	0058633	0061336
23/64	9.13	0.3594	108	171	1	0058640	0636008
	9.20	0.3622	115	175	1	0058657	0061343
	9.30	0.3661	115	175	1	0058664	0061350
	9.40	0.3701	115	175	1	0058671	0061367
	9.50	0.3740	115	175	1	0058688	0061374
3/8	9.52	0.3750	108	171	1	0058695	0636015
	9.60	0.3780	121	184	1	0058701 <sup>1)</sup>	0061381 <sup>1)</sup>
	9.70	0.3819	121	184	1	0058718 <sup>1)</sup>	0061398 <sup>1)</sup>
	9.80	0.3858	121	184	1	0058725 <sup>1)</sup>	0061404 <sup>1)</sup>
	9.90	0.3898	121	184	1	0058732 <sup>1)</sup>	0061411 <sup>1)</sup>
25/64	9.92	0.3906	111	178	1	0058749 <sup>1)</sup>	0636022 <sup>1)</sup>
	10.00	0.3937	121	184	1	0058756 <sup>1)</sup>	0061428 <sup>1)</sup>
	10.20	0.4016	121	184	1	0058763 <sup>1)</sup>	0061435 <sup>1)</sup>
	10.30	0.4055	121	184	1	0058770 <sup>1)</sup>	0061442 <sup>1)</sup>
13/32	10.32	0.4063	111	178	1	0058787 <sup>1)</sup>	0636039 <sup>1)</sup>
	10.50	0.4134	121	184	1	0058800 <sup>1)</sup>	0061466 <sup>1)</sup>
27/64	10.72	0.4219	117	184	1	0058817 <sup>1)</sup>	0636046 <sup>1)</sup>
	11.00	0.4331	128	195	1	0058831 <sup>1)</sup>	0061480 <sup>1)</sup>
7/16	11.11	0.4375	117	184	1	0058855 <sup>1)</sup>	0636053 <sup>1)</sup>
	11.20	0.4409	128	195	1	0058862 <sup>1)</sup>	0061497 <sup>1)</sup>
	11.50	0.4528	128	195	1	0058886 <sup>1)</sup>	0061633 <sup>1)</sup>
29/64	11.51	0.4531	121	190	1	0058893 <sup>1)</sup>	0636060 <sup>1)</sup>
	11.80	0.4646	128	195	1	0058909 <sup>1)</sup>	0061657 <sup>1)</sup>
15/32	11.91	0.4688	121	190	1	0058916 <sup>1)</sup>	0636077 <sup>1)</sup>
	12.00	0.4724	134	205	1	0058923 <sup>1)</sup>	0061688 <sup>1)</sup>
	12.20	0.4803	134	205	1	0058930 <sup>1)</sup>	0061718 <sup>1)</sup>
31/64	12.30	0.4843	121	197	1	0058978 <sup>1)</sup>	0636084 <sup>1)</sup>
	12.50	0.4921	134	205	1	0058985 <sup>1)</sup>	0061749 <sup>1)</sup>
1/2	12.70	0.5000	121	197	1	0058992 <sup>1)</sup>	0636091 <sup>1)</sup>
	13.00	0.5118	134	205	1	0059012 <sup>1)</sup>	0061817 <sup>1)</sup>
33/64	13.10	0.5156	121	203	1	0059043 <sup>1)</sup>	0636107 <sup>1)</sup>
17/32	13.49	0.5311	121	203	1	0059050 <sup>1)</sup>	—
	13.50	0.5315	140	214	1	0059067 <sup>1)</sup>	0061848 <sup>1)</sup>
35/64	13.89	0.5469	124	210	1	0635742 <sup>1)</sup>	0636114 <sup>1)</sup>
	14.00	0.5512	140	214	1	0059081 <sup>1)</sup>	0061862 <sup>1)</sup>
9/16	14.29	0.5625	124	210	1	0059111 <sup>1)</sup>	0636121 <sup>1)</sup>
	14.50	0.5709	144	220	1	0059128 <sup>1)</sup>	0061886 <sup>1)</sup>
37/64	14.68	0.5781	124	222	1	0059166 <sup>1)</sup>	0636138 <sup>1)</sup>
	15.00	0.5906	144	220	1	0059180 <sup>1)</sup>	0061909 <sup>1)</sup>
19/32	15.08	0.5937	124	222	1	0059203 <sup>1)</sup>	0636145 <sup>1)</sup>
39/64	15.48	0.6094	124	222	1	0635759 <sup>1)</sup>	0636152 <sup>1)</sup>
	15.50	0.6102	149	227	1	0059210 <sup>1)</sup>	0061916 <sup>1)</sup>
5/8	15.88	0.6250	124	222	1	0059227 <sup>1)</sup>	0636169 <sup>1)</sup>
	16.00	0.6299	149	227	1	0059234 <sup>1)</sup>	0061930 <sup>1)</sup>
41/64	16.27	0.6406	130	229	1	0635766 <sup>1)</sup>	—
	16.50	0.6496	154	235	1	0059241 <sup>1)</sup>	—
21/32	16.67	0.6563	130	229	1	0059258 <sup>1)</sup>	—
	17.00	0.6693	154	235	1	0059265 <sup>1)</sup>	—
43/64	17.07	0.6719	137	235	1	0635773 <sup>1)</sup>	—
11/16	17.46	0.6875	137	235	1	0059272 <sup>1)</sup>	—
	17.50	0.6890	158	241	1	0059289 <sup>1)</sup>	—
45/64	17.86	0.7031	143	241	1	0059296 <sup>1)</sup>	—
	18.00	0.7087	158	241	1	0059302 <sup>1)</sup>	—
23/32	18.26	0.7188	143	241	1	0059326 <sup>1)</sup>	—
47/64	18.65	0.7344	149	248	1	0059333 <sup>1)</sup>	—
	19.00	0.7480	162	247	1	0059340 <sup>1)</sup>	—
3/4	19.05	0.7500	149	248	1	0059357 <sup>1)</sup>	—
49/64	19.45	0.7656	152	251	1	0635780 <sup>1)</sup>	—
25/32	19.84	0.7812	152	251	1	0635797 <sup>1)</sup>	—
	20.00	0.7874	166	254	1	0059364 <sup>1)</sup>	—

## PFX Premium Cobalt, Extra Length - Parabolic Flute for Advanced Chip Removal

A976

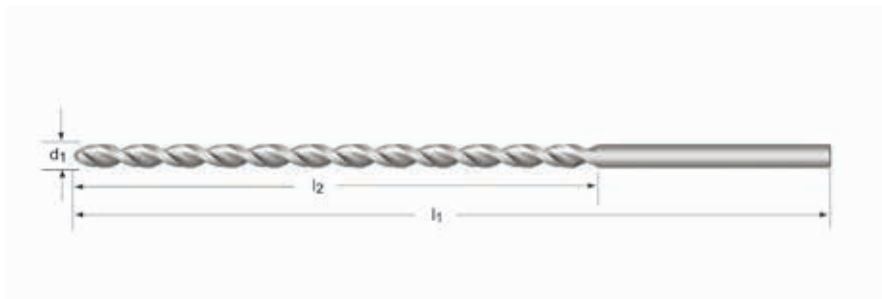
A977

A978

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.2 3.3 3.4 4.1 4.2 4.3

6.3 6.4 7.4

Heavy-Duty parabolic flute design allows greater drilling depths in one pass. Notched point improves chip formation. Premium cobalt base material increases wear resistance. Bright finish improves chip flow in soft or non-ferrous materials.



# PFX



$d_1$ Ø <sub>h8</sub> Inch	$d_1$ Ø <sub>h8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A976	A977	A978
	1.50	0.0591	100	150	1	—	0347386 <sup>1)</sup>	—
	1.50	0.0591	75	115	1	0347362	—	—
1/16	1.59	0.0625	100	150	1	—	0347393 <sup>1)</sup>	—
	2.00	0.0787	110	160	1	—	0347409 <sup>1)</sup>	—
	2.00	0.0787	85	125	1	0148501	—	—
	2.10	0.0827	85	125	1	0279724	—	—
	2.20	0.0866	90	135	1	0148518	—	—
	2.30	0.0906	90	135	1	0279717	—	—
3/32	2.38	0.0937	115	170	1	—	0347416 <sup>1)</sup>	—
	2.40	0.0945	95	140	1	0279731	—	—
	2.50	0.0984	95	140	1	0148525	—	—
	2.60	0.1024	95	140	1	0279748	—	—
	2.70	0.1063	100	150	1	0279755	—	—
	2.80	0.1102	100	150	1	0279762	—	—
	2.90	0.1142	100	150	1	0279779	—	—
	3.00	0.1181	100	150	1	0148532	—	—
	3.00	0.1181	130	190	1	—	0148709	—
	3.00	0.1181	160	240	1	—	—	0347324 <sup>1)</sup>
	3.10	0.1220	105	155	1	0279786	—	—
1/8	3.18	0.1250	105	155	1	0347072	—	—
1/8	3.18	0.1250	135	200	1	—	0347218	—
	3.20	0.1260	105	155	1	0279793	—	—
	3.30	0.1299	105	155	1	0148549	—	—
	3.40	0.1339	115	165	1	0279809	—	—
	3.50	0.1378	115	165	1	0148556	—	—
	3.50	0.1378	145	210	1	—	0148716	—
	3.50	0.1378	180	265	1	—	—	0148853
	3.60	0.1417	115	165	1	0279816	—	—
	3.70	0.1457	115	165	1	0148563	—	—

<sup>1)</sup> Dormer Standard

# PFX EXTRA LENGTH DRILL



d <sub>1</sub> Øh <sub>8</sub> Inch	d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	A976	A977	A978
	3.80	0.1496	120	175	1	0279823	—	—
	3.90	0.1535	120	175	1	0279830	—	—
5/32	3.97	0.1563	120	175	1	0347089	—	—
	4.00	0.1575	120	175	1	0148570	—	—
	4.00	0.1575	150	220	1	—	0148723	—
	4.00	0.1575	190	280	1	—	—	0148860
	4.10	0.1614	120	175	1	0279847	—	—
	4.20	0.1654	120	175	1	0279854	—	—
	4.30	0.1693	125	185	1	0279861	—	—
	4.40	0.1732	125	185	1	0279878	—	—
	4.50	0.1772	125	185	1	0148587	—	—
	4.50	0.1772	160	235	1	—	0148730	—
	4.50	0.1772	200	295	1	—	—	0148877
	4.60	0.1811	125	185	1	0279885	—	—
	4.70	0.1850	125	185	1	0279892	—	—
3/16	4.76	0.1875	135	195	1	0347935	—	—
3/16	4.76	0.1875	170	245	1	—	0347225	—
	4.80	0.1890	135	195	1	0279908	—	—
	4.90	0.1929	135	195	1	0279915	—	—
	5.00	0.1969	135	195	1	0148594	—	—
	5.00	0.1969	170	245	1	—	0148747	—
	5.00	0.1969	210	315	1	—	—	0148884
	5.10	0.2008	135	195	1	0279922	—	—
	5.20	0.2047	135	195	1	0279939	—	—
	5.30	0.2087	135	195	1	0279946	—	—
	5.40	0.2126	140	205	1	0279953	—	—
	5.50	0.2165	140	205	1	0148600	—	—
	5.50	0.2165	180	260	1	—	0148754	—
	5.50	0.2165	225	330	1	—	—	0148891
	5.60	0.2205	140	205	1	0279960	—	—
	5.70	0.2244	140	205	1	0279977	—	—
	5.80	0.2283	140	205	1	0279984	—	—
	5.90	0.2323	140	205	1	0279991	—	—
	6.00	0.2362	140	205	1	0148617	—	—
	6.00	0.2362	180	260	1	—	0148761	—
	6.00	0.2362	225	330	1	—	—	0148907
	6.10	0.2402	150	215	1	0280003	—	—
	6.20	0.2441	150	215	1	0280010	—	—
	6.30	0.2480	150	215	1	0280027	—	—
1/4	6.35	0.2500	150	215	1	0347096	—	—
1/4	6.35	0.2500	190	275	1	—	0347232	—
1/4	6.35	0.2500	235	350	1	—	—	0347331
	6.40	0.2520	150	215	1	0280034	—	—
	6.50	0.2559	150	215	1	0148624	—	—
	6.50	0.2559	190	275	1	—	0148778	—
	6.50	0.2559	235	350	1	—	—	0148914
	6.60	0.2598	150	215	1	0280041	—	—
	6.70	0.2638	150	215	1	0280058	—	—
	6.80	0.2677	155	225	1	0280065	—	—
	6.90	0.2717	155	225	1	0280072	—	—
	7.00	0.2756	155	225	1	0148631	—	—
	7.00	0.2756	200	290	1	—	0148785	—
	7.00	0.2756	250	370	1	—	—	0148921
	7.50	0.2953	155	225	1	0148648	—	—
	7.50	0.2953	200	290	1	—	0148792	—
	7.50	0.2953	250	370	1	—	—	0148938
5/16	7.94	0.3125	165	240	1	0347102	—	—
	8.00	0.3150	165	240	1	0148655	—	—
	8.00	0.3150	210	305	1	—	0148808	—
	8.00	0.3150	265	390	1	—	—	0148945
	8.50	0.3346	165	240	1	0148662	—	—
	8.50	0.3346	210	305	1	—	0148815	—
	8.50	0.3346	265	390	1	—	—	0148952
11/32	8.73	0.3437	175	250	1	0347119	—	—
11/32	8.73	0.3437	220	320	1	—	0347249	—
	9.00	0.3543	175	250	1	0148679	—	—



$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A976	A977	A978
	9.00	0.3543	220	320	1	—	0148822	—
	9.00	0.3543	280	410	1	—	—	0148969
	9.50	0.3740	175	250	1	0148686	—	—
	9.50	0.3740	220	320	1	—	0148839	—
	9.50	0.3740	280	410	1	—	—	0148976
3/8	9.52	0.3750	185	265	1	0347126	—	—
	10.00	0.3937	185	265	1	0148693	—	—
	10.00	0.3937	235	340	1	—	0148846	—
	10.00	0.3937	295	430	1	—	—	0148983
	10.50	0.4134	185	265	1	0347133	—	—
	10.50	0.4134	235	340	1	—	0347256	—
	11.00	0.4331	195	280	1	0347140	—	—
	11.00	0.4331	250	365	1	—	0347263	—
7/16	11.11	0.4375	195	280	1	0347379	—	—
	11.50	0.4528	195	280	1	0347157	—	—
	11.50	0.4528	250	365	1	—	0347270	—
	12.00	0.4724	205	295	1	0347164	—	—
	12.00	0.4724	260	375	1	—	0347287	—
	12.50	0.4921	205	295	1	0347171	—	—
	12.50	0.4921	260	375	1	—	0347294	—
1/2	12.70	0.5000	205	295	1	0347188	—	—
	13.00	0.5118	205	295	1	0347195	—	—
	13.00	0.5118	260	375	1	—	0347300	—
	14.00	0.5512	215	310	1	0347201	—	—
	14.00	0.5512	270	390	1	—	0347317 <sup>1)</sup>	—

# JOBBER DRILL



## General Purpose Jobber Length

\* Sets Available on pgs. 197-200

**R10P** - Fractional Sizes

**R15P** - Letter Sizes

**R18P** - Wire Gauge Sizes

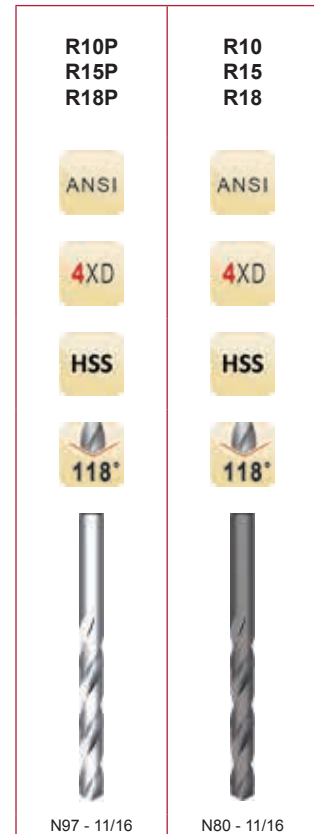
Bright Finish improves chip flow in soft or non-ferrous materials

**R10** - Fractional Sizes

**R15** - Letter Sizes

**R18** - Wire Gauge Sizes

Steam Oxide reduces wear and chip welding in harder ferrous materials for increased wear resistance and lubricity.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	<b>R10P</b> <b>R15P</b> <b>R18P</b>	<b>R10</b> <b>R15</b> <b>R18</b>
	97		0.0059	1/16	3/4	12	018697	—
	96		0.0063	1/16	3/4	12	018696	—
	95		0.0067	1/16	3/4	12	018695	—
	94		0.0071	1/16	3/4	12	018694	—
	93		0.0075	1/16	3/4	12	018693	—
	92		0.0079	1/16	3/4	12	018692	—
	91		0.0083	5/64	3/4	12	018691	—
	90		0.0087	5/64	3/4	12	018690	—
	89		0.0091	5/64	3/4	12	018689	—
	88		0.0095	5/64	3/4	12	018688	—
	87		0.0100	5/64	3/4	12	018687	—
	86		0.0105	3/32	3/4	12	018686	—
	85		0.0110	3/32	3/4	12	018685	—
	84		0.0115	3/32	3/4	12	018684	—
	83		0.0120	3/32	3/4	12	018683	—
	82		0.0125	3/32	3/4	12	018682	—
	81		0.0130	3/32	3/4	12	018681	—
	80		0.0135	1/8	3/4	12	018680	018080
	79		0.0145	1/8	3/4	12	018679	018079
1/64			0.0156	3/16	3/4	12	010601	010001
	78		0.0160	3/16	7/8	12	018678	018078
	77		0.0180	3/16	7/8	12	018677	018077
	76		0.0200	3/16	7/8	12	018676	018076
	75		0.0210	1/4	1"	12	018675	018075
	74		0.0225	1/4	1"	12	018674	018074
	73		0.0240	5/16	1.1/8	12	018673	018073
	72		0.0250	5/16	1.1/8	12	018672	018072
	71		0.0260	3/8	1.1/4	12	018671	018071
	70		0.0280	3/8	1.1/4	12	018670	018070
	69		0.0292	1/2	1.3/8	12	018669	018069



# JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10P R15P R18P	R10 R15 R18
	68		0.0310	1/2	1.3/8	12	018668	018068
1/32			0.0313	1/2	1.3/8	12	010602	010002
	67		0.0320	1/2	1.3/8	12	018667	018067
	66		0.0330	1/2	1.3/8	12	018666	018066
	65		0.0350	5/8	1.1/2	12	018665	018065
	64		0.0360	5/8	1.1/2	12	018664	018064
	63		0.0370	5/8	1.1/2	12	018663	018063
	62		0.0380	5/8	1.1/2	12	018662	018062
	61		0.0390	11/16	1.5/8	12	018661	018061
	60		0.0400	11/16	1.5/8	12	018660	018060
	59		0.0410	11/16	1.5/8	12	018659	018059
	58		0.0420	11/16	1.5/8	12	018658	018058
	57		0.0430	3/4	1.3/4	12	018657	018057
3/64	56		0.0465	3/4	1.3/4	12	018656	018056
			0.0469	3/4	1.3/4	12	010603	010003
	55		0.0520	7/8	1.7/8	12	018655	018055
	54		0.0550	7/8	1.7/8	12	018654	018054
	53		0.0595	7/8	1.7/8	12	018653	018053
1/16			0.0625	7/8	1.7/8	12	010604	010004
	52		0.0635	7/8	1.7/8	12	018652	018052
	51		0.0670	1"	2"	12	018651	018051
	50		0.0700	1"	2"	12	018650	018050
	49		0.0730	1"	2"	12	018649	018049
	48		0.0760	1"	2"	12	018648	018048
5/64			0.0781	1"	2"	12	010605	010005
	47		0.0785	1"	2"	12	018647	018047
	46		0.0810	1.1/8	2.1/8	12	018646	018046
	45		0.0820	1.1/8	2.1/8	12	018645	018045
	44		0.0860	1.1/8	2.1/8	12	018644	018044
	43		0.0890	1.1/4	2.1/4	12	018643	018043
	42		0.0935	1.1/4	2.1/4	12	018642	018042
3/32			0.0938	1.1/4	2.1/4	12	010606	010006
	41		0.0960	1.3/8	2.3/8	12	018641	018041
	40		0.0980	1.3/8	2.3/8	12	018640	018040
	39		0.0995	1.3/8	2.3/8	12	018639	018039
	38		0.1015	1.7/16	2.1/2	12	018638	018038
	37		0.1040	1.7/16	2.1/2	12	018637	018037
	36		0.1065	1.7/16	2.1/2	12	018636	018036
7/64			0.1094	1.1/2	2.5/8	12	010607	010007
	35		0.1100	1.1/2	2.5/8	12	018635	018035
	34		0.1110	1.1/2	2.5/8	12	018634	018034
	33		0.1130	1.1/2	2.5/8	12	018633	018033
	32		0.1160	1.5/8	2.3/4	12	018632	018032
	31		0.1200	1.5/8	2.3/4	12	018631	018031
1/8			0.1250	1.5/8	2.3/4	12	010608	010008
	30		0.1285	1.5/8	2.3/4	12	018630	018030
	29		0.1360	1.3/4	2.7/8	12	018629	018029
	28		0.1405	1.3/4	2.7/8	12	018628	018028
9/64			0.1406	1.3/4	2.7/8	12	010609	010009
	27		0.1440	1.7/8	3"	12	018627	018027
	26		0.1470	1.7/8	3"	12	018626	018026
	25		0.1495	1.7/8	3"	12	018625	018025
	24		0.1520	2"	3.1/8	12	018624	018024
	23		0.1540	2"	3.1/8	12	018623	018023
5/32			0.1563	2"	3.1/8	12	010610	010010
	22		0.1570	2"	3.1/8	12	018622	018022
	21		0.1590	2.1/8	3.1/4	12	018621	018021
	20		0.1610	2.1/8	3.1/4	12	018620	018020
	19		0.1660	2.1/8	3.1/4	12	018619	018019
	18		0.1695	2.1/8	3.1/4	12	018618	018018
11/64			0.1719	2.1/8	3.1/4	12	010611	010011
	17		0.1730	2.3/16	3.3/8	12	018617	018017
	16		0.1770	2.3/16	3.3/8	12	018616	018016

# JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10P R15P R18P	R10 R15 R18
	15		0.1800	2.3/16	3.3/8	12	018615	018015
	14		0.1820	2.3/16	3.3/8	12	018614	018014
	13		0.1850	2.5/16	3.1/2	12	018613	018013
3/16			0.1875	2.5/16	3.1/2	12	010612	010012
	12		0.1890	2.5/16	3.1/2	12	018612	018012
	11		0.1910	2.5/16	3.1/2	12	018611	018011
	10		0.1935	2.7/16	3.5/8	12	018610	018010
	9		0.1960	2.7/16	3.5/8	12	018609	018009
	8		0.1990	2.7/16	3.5/8	12	018608	018008
	7		0.2010	2.7/16	3.5/8	12	018607	018007
13/64			0.2031	2.7/16	3.5/8	12	010613	010013
	6		0.2040	2.1/2	3.3/4	12	018606	018006
	5		0.2055	2.1/2	3.3/4	12	018605	018005
	4		0.2090	2.1/2	3.3/4	12	018604	018004
	3		0.2130	2.1/2	3.3/4	12	018603	018003
7/32			0.2188	2.1/2	3.3/4	12	010614	010014
	2		0.2210	2.5/8	3.7/8	12	018602	018002
	1		0.2280	2.5/8	3.7/8	12	018601	018001
		A	0.2340	2.5/8	3.7/8	12	015601	015001
15/64			0.2344	2.5/8	3.7/8	12	010615	010015
		B	0.2380	2.3/4	4"	12	015602	015002
		C	0.2421	2.3/4	4"	12	015603	015003
		D	0.2461	2.3/4	4"	12	015604	015004
		E	0.2500	2.3/4	4"	12	015605	015005
1/4			0.2500	2.3/4	4"	12	010616	010016
		F	0.2571	2.7/8	4.1/8	12	015606	015006
		G	0.2610	2.7/8	4.1/8	12	015607	015007
17/64			0.2656	2.7/8	4.1/8	12	010617	010017
		H	0.2661	2.7/8	4.1/8	12	015608	015008
		I	0.2720	2.7/8	4.1/8	12	015609	015009
		J	0.2772	2.7/8	4.1/8	12	015610	015010
		K	0.2811	2.15/16	4.1/4	12	015611	015011
9/32			0.2813	2.15/16	4.1/4	12	010618	010018
		L	0.2902	2.15/16	4.1/4	12	015612	015012
		M	0.2949	3.1/16	4.3/8	12	015613	015013
19/64			0.2969	3.1/16	4.3/8	12	010619	010019
		N	0.3020	3.1/16	4.3/8	12	015614	015014
5/16			0.3125	3.3/16	4.1/2	6	010620	010020
		O	0.3161	3.3/16	4.1/2	6	015615	015015
		P	0.3228	3.5/16	4.5/8	6	015616	015016
21/64			0.3281	3.5/16	4.5/8	6	010621	010021
		Q	0.3319	3.7/16	4.3/4	6	015617	015017
		R	0.3390	3.7/16	4.3/4	6	015618	015018
11/32			0.3437	3.7/16	4.3/4	6	010622	010022
		S	0.3480	3.1/2	4.7/8	6	015619	015019
		T	0.3580	3.1/2	4.7/8	6	015620	015020
23/64			0.3594	3.1/2	4.7/8	6	010623	010023
		U	0.3680	3.5/8	5"	6	015621	015021
3/8			0.3750	3.5/8	5"	6	010624	010024
		V	0.3772	3.5/8	5"	6	015622	015022
		W	0.3858	3.3/4	5.1/8	6	015623	015023
25/64			0.3906	3.3/4	5.1/8	6	010625	010025
		X	0.3969	3.3/4	5.1/8	6	015624	015024
		Y	0.4039	3.7/8	5.1/4	6	015625	015025
13/32			0.4063	3.7/8	5.1/4	6	010626	010026
		Z	0.4130	3.7/8	5.1/4	6	015626	015026
27/64			0.4219	3.15/16	5.3/8	6	010627	010027
7/16			0.4375	4.1/16	5.1/2	6	010628	010028
29/64			0.4531	4.3/16	5.5/8	6	010629	010029
15/32			0.4687	4.5/16	5.3/4	6	010630	010030
31/64			0.4844	4.3/8	5.7/8	6	010631	010031
1/2			0.5000	4.1/2	6"	6	010632	010032
33/64			0.5156	4.13/16	6.5/8	1	010633	010033



# JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10P R15P R18P	R10 R15 R18
17/32			0.5313	4.13/16	6.5/8	1	010634	010034
35/64			0.5469	4.13/16	6.5/8	1	010635	010035
9/16			0.5625	4.13/16	6.5/8	1	010636	010036
37/64			0.5781	4.13/16	6.5/8	1	010637	010037
19/32			0.5937	5.3/16	7.1/8	1	010638	010038
39/64			0.6094	5.3/16	7.1/8	1	010639	010039
5/8			0.6250	5.3/16	7.1/8	1	010640	010040
41/64			0.6406	5.3/16	7.1/8	1	010641	010041
21/32			0.6563	5.3/16	7.1/8	1	010642	010042
43/64			0.6719	5.5/8	7.5/8	1	010643	010043
11/16			0.6875	5.5/8	7.5/8	1	010644	010044

# JOBBER DRILL



## General Purpose Jobber Length, Fractional

\* Sets Available on pg. 180

### A012

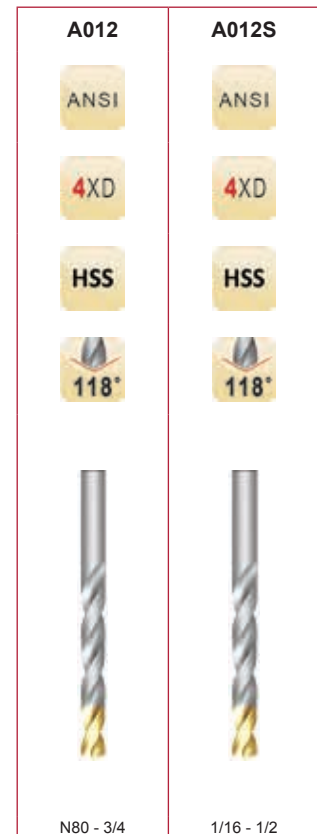
Low thrust design self centering Split Point for easier penetration.  
TiN Coated Tip increases surface hardness and improves tool life.

### A012S

Select A012 sizes available in a pouch pack.

1/16 thru 3/16 2 per pack

13/64 thru 1/2 1 per pack



\* Bright / No split point Below N46

$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	A012	A012S
	80		0.34	0.0135	1/8	3/4	10	0574256 *	—
	79		0.37	0.0145	1/8	3/4	10	0574249 *	—
1/64			0.40	0.0156	3/16	3/4	10	0573952 *	—
	78		0.41	0.0160	3/16	7/8	10	0574232 *	—
	77		0.46	0.0180	3/16	7/8	10	0574225 *	—
	76		0.51	0.0200	3/16	7/8	10	0574218 *	—
	75		0.53	0.0210	1/4	1"	10	0574201 *	—
	74		0.57	0.0225	1/4	1"	10	0574195 *	—
	73		0.61	0.0240	5/16	1.1/8	10	0574188 *	—
	72		0.64	0.0250	5/16	1.1/8	10	0574171 *	—
	71		0.66	0.0260	3/8	1.1/4	10	0574164 *	—
	70		0.71	0.0280	3/8	1.1/4	10	0574157 *	—
	69		0.742	0.0292	1/2	1.3/8	10	0574140 *	—
	68		0.79	0.0310	1/2	1.3/8	10	0574133 *	—
1/32			0.79	0.0313	1/2	1.3/8	10	0573969 *	—
	67		0.81	0.0320	1/2	1.3/8	10	0574126 *	—
	66		0.84	0.0330	1/2	1.3/8	10	0574119 *	—
	65		0.89	0.0350	5/8	1.1/2	10	0574102 *	—
	64		0.91	0.0360	5/8	1.1/2	10	0574096 *	—
	63		0.94	0.0370	5/8	1.1/2	10	0574089 *	—
	62		0.97	0.0380	5/8	1.1/2	10	0574072 *	—
	61		0.99	0.0390	11/16	1.5/8	10	0574065 *	—
	60		1.02	0.0400	11/16	1.5/8	10	0574058 *	—
	59		1.04	0.0410	11/16	1.5/8	10	0574041 *	—
	58		1.07	0.0420	11/16	1.5/8	10	0574034 *	—
	57		1.09	0.0430	3/4	1.3/4	10	0574027 *	—
	56		1.18	0.0465	3/4	1.3/4	10	0574010 *	—
3/64			1.19	0.0469	3/4	1.3/4	10	0573976 *	—
	55		1.32	0.0520	7/8	1.7/8	10	0574003 *	—
	54		1.40	0.0550	7/8	1.7/8	10	0573990 *	—
	53		1.51	0.0595	7/8	1.7/8	10	0573983 *	—
1/16			1.59	0.0625	7/8	1.7/8	2	—	46524892 *

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	A012	A012S
1/16			1.59	0.0625	7/8	1.7/8	10	0578636 *	—
	52		1.61	0.0635	7/8	1.7/8	10	0578704 *	—
	51		1.70	0.0669	1"	2"	10	0578698 *	—
	50		1.78	0.0700	1"	2"	10	0578681 *	—
	49		1.85	0.0730	1"	2"	10	0578674 *	—
	48		1.93	0.0760	1"	2"	10	0578667 *	—
5/64			1.98	0.0781	1"	2"	2	—	46524893 *
5/64			1.98	0.0781	1"	2"	10	0578643 *	—
	47		1.99	0.0785	1"	2"	10	0578650 *	—
	46		2.06	0.0810	1.1/8	2.1/8	10	0571705	—
	45		2.08	0.0820	1.1/8	2.1/8	10	0571699	—
	44		2.18	0.0860	1.1/8	2.1/8	10	0571682	—
	43		2.26	0.0890	1.1/4	2.1/4	10	0571675	—
	42		2.38	0.0935	1.1/4	2.1/4	10	0571668	—
3/32			2.38	0.0938	1.1/4	2.1/4	2	—	46524894
3/32			2.38	0.0938	1.1/4	2.1/4	10	0572061	—
	41		2.44	0.0960	1.3/8	2.3/8	10	0571651	—
	40		2.49	0.0980	1.3/8	2.3/8	10	0571644	—
	39		2.53	0.0995	1.3/8	2.3/8	10	0571620	—
	38		2.58	0.1015	1.7/16	2.1/2	10	0571613	—
	37		2.64	0.1040	1.7/16	2.1/2	10	0571606	—
	36		2.71	0.1065	1.7/16	2.1/2	10	0571590	—
7/64			2.78	0.1094	1.1/2	2.5/8	2	—	46524895
7/64			2.78	0.1094	1.1/2	2.5/8	10	0572184	—
	35		2.79	0.1100	1.1/2	2.5/8	10	0571583	—
	34		2.82	0.1110	1.1/2	2.5/8	10	0571576	—
	33		2.87	0.1130	1.1/2	2.5/8	10	0571569	—
	32		2.95	0.1160	1.5/8	2.3/4	10	0571552	—
	31		3.05	0.1200	1.5/8	2.3/4	10	0571545	—
1/8			3.18	0.1250	1.5/8	2.3/4	2	—	46524896
1/8			3.18	0.1250	1.5/8	2.3/4	10	0571897	—
	30		3.26	0.1285	1.5/8	2.3/4	10	0571538	—
	29		3.45	0.1360	1.3/4	2.7/8	10	0571514	—
	28		3.57	0.1405	1.3/4	2.7/8	10	0571507	—
9/64			3.57	0.1405	1.3/4	2.7/8	2	—	46524897
9/64			3.57	0.1406	1.3/4	2.7/8	10	0572214	—
	27		3.66	0.1440	1.7/8	3"	10	0571491	—
	26		3.73	0.1470	1.7/8	3"	10	0571484	—
	25		3.80	0.1495	1.7/8	3"	10	0571477	—
	24		3.86	0.1520	2"	3.1/8	10	0571460	—
	23		3.91	0.1540	2"	3.1/8	10	0571453	—
5/32	5/32		3.97	0.1563	2"	3.1/8	2	—	46524898
5/32			3.97	0.1563	2"	3.1/8	10	0572146	—
	22		3.99	0.1570	2"	3.1/8	10	0571446	—
	21		4.04	0.1590	2.1/8	3.1/4	10	0571439	—
	20		4.09	0.1610	2.1/8	3.1/4	10	0571422	—
	19		4.22	0.1660	2.1/8	3.1/4	10	0571408	—
	18		4.31	0.1695	2.1/8	3.1/4	10	0571392	—
11/64			4.37	0.1719	2.1/8	3.1/4	2	—	46524899
11/64			4.37	0.1719	2.1/8	3.1/4	10	0571910	—
	17		4.39	0.1730	2.3/16	3.3/8	10	0571385	—
	16		4.50	0.1770	2.3/16	3.3/8	10	0571378	—
	15		4.57	0.1800	2.3/16	3.3/8	10	0571361	—
	14		4.62	0.1820	2.3/16	3.3/8	10	0571354	—
	13		4.70	0.1850	2.5/16	3.1/2	10	0571347	—
3/16			4.76	0.1875	2.5/16	3.1/2	2	—	46524900
3/16			4.76	0.1875	2.5/16	3.1/2	10	0572054	—
	12		4.80	0.1890	2.5/16	3.1/2	10	0571330	—
	11		4.85	0.1910	2.5/16	3.1/2	10	0571323	—
	10		4.92	0.1935	2.7/16	3.5/8	10	0571316	—
	9		4.98	0.1960	2.7/16	3.5/8	10	0571750	—
	8		5.06	0.1990	2.7/16	3.5/8	10	0571743	—
	7		5.11	0.2010	2.7/16	3.5/8	10	0571736	—
13/64			5.16	0.2031	2.7/16	3.5/8	1	—	46524901
13/64			5.16	0.2031	2.7/16	3.5/8	10	0571934	—

# JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	A012	A012S
	6		5.18	0.2040	2.1/2	3.3/4	10	0571729	—
	5		5.22	0.2055	2.1/2	3.3/4	10	0571712	—
	4		5.31	0.2090	2.1/2	3.3/4	10	0571637	—
	3		5.41	0.2130	2.1/2	3.3/4	10	0571521	—
7/32			5.56	0.2188	2.1/2	3.3/4	1	—	46524902
7/32			5.56	0.2188	2.1/2	3.3/4	10	0572177	—
	2		5.61	0.2210	2.5/8	3.7/8	10	0571415	—
	1		5.79	0.2280	2.5/8	3.7/8	10	0571309	—
		A	5.94	0.2340	2.5/8	3.7/8	10	0571163	—
15/64			5.95	0.2344	2.5/8	3.7/8	1	—	46524903
15/64			5.95	0.2344	2.5/8	3.7/8	10	0571958	—
		B	6.03	0.2380	2.3/4	4"	10	0571170	—
		C	6.15	0.2420	2.3/4	4"	10	0571187	—
		D	6.25	0.2460	2.3/4	4"	10	0571194	—
1/4			6.35	0.2500	2.3/4	4"	1	—	46524904
1/4			6.35	0.2500	2.3/4	4"	10	0571125	—
		E	6.35	0.2500	2.3/4	4"	10	0571200	—
		F	6.53	0.2570	2.7/8	4.1/8	10	0571217	—
		G	6.63	0.2610	2.7/8	4.1/8	10	0571224	—
17/64			6.75	0.2656	2.7/8	4.1/8	1	—	46524905
17/64			6.75	0.2656	2.7/8	4.1/8	10	0571972	—
		H	6.76	0.2660	2.7/8	4.1/8	10	0571231	—
		I	6.91	0.2720	2.7/8	4.1/8	10	0571248	—
		J	7.04	0.2770	2.7/8	4.1/8	10	0571255	—
		K	7.14	0.2810	2.15/16	4.1/4	10	0571262	—
9/32			7.14	0.2813	2.15/16	4.1/4	1	—	46524906
9/32			7.14	0.2813	2.15/16	4.1/4	10	0572207	—
		L	7.37	0.2900	2.15/16	4.1/4	10	0571279	—
		M	7.49	0.2950	3.1/16	4.3/8	10	0571286	—
19/64			7.54	0.2968	3.1/16	4.3/8	1	—	46524907
19/64			7.54	0.2968	3.1/16	4.3/8	10	0571996	—
		N	7.67	0.3020	3.1/16	4.3/8	10	0571293	—
5/16			7.94	0.3125	3.3/16	4.1/2	1	—	46524908
5/16			7.94	0.3125	3.3/16	4.1/2	10	0572139	—
		O	8.03	0.3160	3.3/16	4.1/2	10	0571767	—
		P	8.20	0.3230	3.5/16	4.5/8	10	0571774	—
21/64			8.33	0.3281	3.5/16	4.5/8	1	—	46524909
21/64			8.33	0.3281	3.5/16	4.5/8	10	0572009	—
		Q	8.43	0.3320	3.7/16	4.3/4	10	0571781	—
		R	8.61	0.3390	3.7/16	4.3/4	10	0571798	—
11/32			8.73	0.3437	3.7/16	4.3/4	1	—	46524910
11/32			8.73	0.3437	3.7/16	4.3/4	10	0571903	—
		S	8.84	0.3480	3.1/2	4.7/8	10	0571804	—
		T	9.09	0.3580	3.1/2	4.7/8	10	0571811	—
23/64			9.13	0.3594	3.1/2	4.7/8	1	—	46524911
23/64			9.13	0.3594	3.1/2	4.7/8	10	0572016	—
		U	9.35	0.3680	3.5/8	5"	10	0571828	—
3/8			9.52	0.3750	3.5/8	5"	1	—	46524912
3/8			9.52	0.3750	3.5/8	5"	10	0572078	—
		V	9.58	0.3770	3.5/8	5"	10	0571835	—
		W	9.80	0.3860	3.3/4	5.1/8	10	0571842	—
25/64			9.92	0.3906	3.3/4	5.1/8	1	—	46524913
25/64			9.92	0.3906	3.3/4	5.1/8	10	0572023	—
		X	10.08	0.3970	3.3/4	5.1/8	5	0571859	—
		Y	10.26	0.4040	3.7/8	5.1/4	5	0571866	—
13/32			10.32	0.4063	3.7/8	5.1/4	1	—	46524914
13/32			10.32	0.4063	3.7/8	5.1/4	5	0571927	—
		Z	10.49	0.4130	3.7/8	5.1/4	5	0571873	—
27/64			10.72	0.4219	3.15/16	5.3/8	1	—	46524915
27/64			10.72	0.4219	3.15/16	5.3/8	5	0572030	—
7/16			11.11	0.4375	4.1/16	5.1/2	1	—	46524916
7/16			11.11	0.4375	4.1/16	5.1/2	5	0572160	—
29/64			11.51	0.4531	4.3/16	5.5/8	1	—	46524917
29/64			11.51	0.4531	4.3/16	5.5/8	5	0572047	—
15/32			11.91	0.4687	4.5/16	5.3/4	1	—	46524918
15/32			11.91	0.4687	4.5/16	5.3/4	5	0571941	—



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	A012	A012S
31/64			12.30	0.4844	4.3/8	5.7/8	1	—	46524919
31/64			12.30	0.4844	4.3/8	5.7/8	5	0572085	—
1/2			12.70	0.5000	4.1/2	6"	1	—	46524920
1/2			12.70	0.5000	4.1/2	6"	5	0571880	—
33/64			13.10	0.5156	4.13/16	6.5/8	1	0572092	—
17/32			13.49	0.5313	4.13/16	6.5/8	1	0571965	—
35/64			13.89	0.5469	4.13/16	6.5/8	1	0572108	—
9/16			14.29	0.5625	4.13/16	6.5/8	1	0572191	—
37/64			14.68	0.5781	4.13/16	6.5/8	1	0572115	—
19/32			15.08	0.5937	5.3/16	7.1/8	1	0571989	—
39/64			15.48	0.6094	5.3/16	7.1/8	1	0572122	—
5/8			15.88	0.6250	5.3/16	7.1/8	1	0572153	—
21/32			16.67	0.6563	5.3/16	7.1/8	1	0578728	—
11/16			17.46	0.6875	5.5/8	7.5/8	1	0578711	—
45/64			17.86	0.7031	5.5/8	7.5/8	1	0578742	—
23/32			18.26	0.7188	5.5/8	7.5/8	1	0578735	—
47/64			18.65	0.7344	6"	8"	1	0578766	—
3/4			19.05	0.7500	6"	8"	1	0578759	—

**General Purpose Jobber Length, DIN Standard**

**2A** Bright Finish improves chip flow in soft or non-ferrous materials

**2AB** Steam Oxide for increased wear resistance & lubricity.

**A100** Low thrust design self centering Split Point for easier penetration. TiN Coated Tip increases wear resistance and improves tool life.

- \* Bright Below 2mm
- \* No split point below 2mm



2A	2AB	A100	A002	A002S
DIN 338	DIN 338	DIN 338	DIN 338	DIN 338
4XD	4XD	4XD	4XD	4XD
HSS	HSS	HSS	HSS	HSS
118°	118°	118°	118°	118°
0.15 - 15.00	1.00 - 17.50	0.20 - 20.00	1.00 - 16.00	1.00 - 16.00

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> Øh <sub>8</sub> "/Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	2A	2AB	A100	A002	A002S
0.15		0.0059	1.5	19	016215	—	—	—	—
0.16		0.0063	1.5	19	016216	—	—	—	—
0.17		0.0067	1.5	19	016217	—	—	—	—
0.18		0.0070	1.5	19	016218	—	—	—	—
0.19		0.0075	1.5	19	016219	—	—	—	—
0.20		0.0078	2.5	19	016002	—	0000021	—	—
0.21		0.0083	2.5	19	016221	—	—	—	—
0.22		0.0087	2.5	19	016222	—	—	—	—
0.23		0.0091	2.5	19	016223	—	—	—	—
0.24		0.0094	2.5	19	016224	—	—	—	—
0.25		0.0098	3	19	016225	—	0000038	—	—
0.26		0.0102	3	19	016226	—	—	—	—
0.27		0.0106	3	19	016227	—	—	—	—
0.28		0.0110	3	19	016228	—	—	—	—
0.29		0.0114	3	19	016229	—	—	—	—
0.30		0.0118	3	19	016003	—	0000045	—	—
0.32		0.0126	4	19	016232	—	0000052	—	—
	80	0.0135	4	19	—	—	0029480	—	—
0.34		0.0134	4	19	016234	—	—	—	—
0.35		0.0138	4	19	016235	—	0000069	—	—
0.36		0.0142	4	19	016236	—	—	—	—
0.38	79	0.0145	4	19	—	—	0029466	—	—
		0.0150	4	19	016238	—	0000076	—	—
0.40	1/64	0.0156	5	20	—	—	0001219	—	—
		0.0157	5	20	016004	—	0000083	—	—
0.42	78	0.0160	5	20	—	—	0029459	—	—
		0.0165	5	20	016242	—	0000090	—	—
0.44		0.0173	5	20	016244	—	—	—	—
0.45		0.0177	5	20	016245	—	0000106	—	—
	77	0.0180	5	20	—	—	0029442	—	—

Package quantities: **2A and 2AB:** 0.15mm - 7.90mm = 12; 8.00mm - 12.50mm = 6; 12.70mm and above = 1  
**A100 and A002:** 0.20mm - 10.00mm = 10; X - 13.00mm = 5; 33/64 and above = 1  
**A002S:** 0.20mm - 5.00mm = 2; 13/64 - 13.00mm = 1

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> Øh <sub>8</sub> "/Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	2A	2AB	A100	A002	A002S
0.46		0.0181	5	20	016246	—	—	—	—
0.48		0.0189	5	20	016248	—	0000113	—	—
0.50		0.0197	6	22	016005	—	0000120	—	—
	76	0.0200	6	22	—	—	0029435	—	—
0.52		0.0205	6	22	—	—	0000137	—	—
	75	0.0210	6	22	—	—	0029428	—	—
0.55		0.0217	7	24	016250	—	0000144	—	—
	74	0.0225	7	24	—	—	0029411	—	—
0.58		0.0228	7	24	—	—	0000151	—	—
0.60		0.0236	7	24	016006	—	0000168	—	—
	73	0.0240	8	26	—	—	0029404	—	—
0.62		0.0244	8	26	—	—	0000175	—	—
	72	0.0250	8	26	—	—	0029398	—	—
0.65		0.0256	8	26	016251	—	0000182	—	—
	71	0.0260	8	26	—	—	0029381	—	—
0.68		0.0268	9	28	—	—	0000199	—	—
0.70		0.0276	9	28	016007	—	0000205	—	—
	70	0.0280	9	28	—	—	0029374	—	—
0.72		0.0283	9	28	—	—	0000212	—	—
	69	0.0292	9	28	—	—	0029350	—	—
0.75		0.0295	9	28	016252	—	0000229	—	—
0.78		0.0307	10	30	—	—	0000236	—	—
	68	0.0310	10	30	—	—	0029343	—	—
	1/32	0.0313	10	30	—	—	0001059	—	—
0.80		0.0315	10	30	016008	—	0000243	—	—
	67	0.0320	10	30	—	—	0029336	—	—
0.82		0.0323	10	30	—	—	0000250	—	—
	66	0.0330	10	30	—	—	0029329	—	—
0.85		0.0335	10	30	016253	—	0000267	—	—
0.88		0.0346	11	32	—	—	0000274	—	—
	65	0.0350	11	32	—	—	0029312	—	—
0.90		0.0354	11	32	016009	—	0000281	—	—
	64	0.0360	11	32	—	—	0029305	—	—
0.92		0.0362	11	32	—	—	0000298	—	—
	63	0.0370	11	32	—	—	0029299	—	—
0.95		0.0374	11	32	016254	—	0000304	—	—
	62	0.0380	12	34	—	—	0029282	—	—
0.98		0.0386	12	34	—	—	0000311	—	—
	61	0.0390	12	34	—	—	0029275	—	—
1.00		0.0394	12	34	016010	029010	0000328	0376782	—
	60	0.0400	12	34	—	—	0029268	—	—
	59	0.0410	12	34	—	—	0029244	—	—
1.05		0.0413	12	34	—	—	0000335	—	—
	58	0.0420	14	36	—	—	0029237	—	—
	57	0.0430	14	36	—	—	0029220	—	—
1.10		0.0433	14	36	016011	029011	0000342	0376799	—
1.15		0.0453	14	36	016256	029256	0000359	—	—
	56	0.0465	14	36	—	—	0029213	—	—
	3/64	0.0469	16	38	—	—	0001783	0376928	—
1.20		0.0472	16	38	016012	029012	0000366	0376805	—
1.25		0.0492	16	38	016257	029257	0000373	—	—
1.30		0.0512	16	38	016013	029013	0000380	0376812	—
	55	0.0520	16	38	—	—	0029206	—	—
1.35		0.0531	18	40	016258	029258	0000397	—	—
	54	0.0550	18	40	—	—	0029190	—	—
1.40		0.0551	18	40	016014	029014	0000403	0376829	—
1.45		0.0571	18	40	016259	029259	0000410	—	—
1.50		0.0591	18	40	016015	029015	0000427	0376836	—
	53	0.0595	20	43	—	—	0029183	—	—
1.55		0.0610	20	43	016260	029260	0000434	—	—
	1/16	0.0625	20	43	—	—	0000786	0376881	—
1.60		0.0630	20	43	016016	029016	0000441	0376843	—

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**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**

**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**

$d_1$ $\varnothing h_8$ mm	$d_1$ $\varnothing h_8$ "/Nr./letter	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	2A	2AB	A100	A002	A002S
	52	0.0635	20	43	—	—	0029176	—	—
1.65		0.0650	20	43	016261	—	0000458	—	—
1.70		0.0669	20	43	016017	029017	0000465	0376850	—
	51	0.0670	22	46	—	—	0029169	—	—
1.75		0.0689	22	46	016262	029262	0000472	—	—
	50	0.0700	22	46	—	—	0029152	—	—
1.80		0.0709	22	46	016018	029018	0000489	0376867	—
1.85		0.0728	22	46	—	—	0000496	—	—
	49	0.0730	22	46	—	—	0029138	—	—
1.90		0.0748	22	46	016019	029019	0000502	0376874	—
	48	0.0760	24	49	—	—	0029121	—	—
1.95		0.0768	24	49	46790303	029264	0000519	—	—
	5/64	0.0781	24	49	—	—	0002100	0376935	—
	47	0.0785	24	49	—	—	0029114	—	—
2.00		0.0787	24	49	016020	029020	0001332	0376041	46524831
2.05		0.0807	24	49	—	—	0001349	—	—
	46	0.0810	24	49	—	—	0029107	—	—
	45	0.0820	24	49	—	—	0029091	—	—
2.10		0.0827	24	49	016021	029021	0001356	0376058	—
2.15		0.0846	27	53	016266	—	0001363	—	—
	44	0.0860	27	53	—	—	0029084	—	—
2.20		0.0866	27	53	016022	029022	0001370	0376898	—
2.25		0.0886	27	53	016267	—	0001387	—	—
	43	0.0890	27	53	—	—	0029077	—	—
2.30		0.0906	27	53	016023	029023	0001394	0376904	—
2.35		0.0925	27	53	016268	029268	0001400	—	—
	42	0.0935	30	57	—	—	0029060	—	—
	3/32	0.0937	30	57	—	—	0001752	0376119	—
2.40		0.0945	30	57	016024	029024	0001417	0376911	—
	41	0.0960	30	57	—	—	0029053	—	—
2.45		0.0965	30	57	—	—	0001424	—	—
	40	0.0980	30	57	—	—	0029046	—	—
2.50		0.0984	30	57	016025	029025	0001431	0376065	46524832
	39	0.0995	30	57	—	—	0029022	—	—
2.55		0.1004	30	57	—	—	001448	—	—
	38	0.1015	30	57	—	—	0029015	—	—
2.60		0.1024	30	57	016026	029026	0001455	0376072	—
	37	0.1040	30	57	—	—	0029008	—	—
2.65		0.1043	30	57	—	—	0001462	—	—
2.70		0.1063	33	61	016027	029027	0001479	0376089	—
	36	0.1065	33	61	—	—	0028995	—	—
2.75		0.1083	33	61	016270	—	0001486	—	—
	7/64	0.1093	33	61	—	—	0002384	0376126	—
	35	0.1100	33	61	—	—	0028988	—	—
2.82		0.1102	33	61	—	—	0001493	0376096	—
	34	0.1110	33	61	—	—	0028971	—	—
2.85		0.1122	33	61	—	—	0001509	—	—
	33	0.1130	33	61	—	—	0028964	—	—
2.90		0.1142	33	61	016029	029029	0001516	0376102	—
	32	0.1160	33	61	—	—	0028957	—	—
2.95		0.1161	33	61	—	—	0001523	—	—
3.00		0.1181	33	61	016030	029030	0001608	0350577	46524833
	31	0.1200	36	65	—	—	0028940	—	—
3.10		0.1220	36	65	016031	029031	0001615	0350584	—
3.15		0.1240	36	65	—	—	0001622	—	—
	1/8	0.1250	36	65	—	—	0001264	0350591	46524834
3.20		0.1260	36	65	016032	029032	0001639	0350607	46524835
3.25		0.1280	36	65	016271	029271	0001646	0605356	—
	30	0.1285	36	65	—	—	0028933	—	—
3.30		0.1299	36	65	016033	029033	0001653	0350614	46524836
3.40		0.1339	39	70	016034	029034	0001660	0350621	—
	29	0.1360	39	70	—	—	0028919	—	—

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**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**

**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> Øh <sub>8</sub> "/Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	2A	2AB	A100	A002	A002S
3.50		0.1378	39	70	016035	029035	0001677	0350638	46524837
	28	0.1405	39	70	—	—	0028902	—	—
	9/64	0.1406	39	70	—	—	0002650	0350645	—
3.60		0.1417	39	70	016036	029036	0001684	0350652	—
	27	0.1440	39	70	—	—	0028896	—	—
3.70		0.1457	39	70	016037	029037	0001691	0350669	—
	26	0.1470	39	70	—	—	0028889	—	—
3.75		0.1476	39	70	—	—	0001707	—	—
	25	0.1495	43	75	—	—	0028872	—	—
3.80		0.1496	43	75	—	—	0001714	0350676	—
	24	0.1520	43	75	—	—	0028865	—	—
3.90		0.1535	43	75	—	—	0001721	0350683	—
	23	0.1540	43	75	—	—	0028858	—	—
	5/32	0.1562	43	75	—	—	0002094	0350690	46524838
	22	0.1570	43	75	—	—	0028841	—	—
4.00		0.1575	43	75	016040	029040	0001820	0350706	46524839
	21	0.1590	43	75	—	—	0028834	—	—
	20	0.1610	43	75	—	—	0028827	—	—
4.10		0.1614	43	75	016041	029041	0001837	0350713	46524860
4.20		0.1654	43	75	016042	029042	0001844	0350720	46524861
	19	0.1660	43	75	—	—	0028803	—	—
4.25		0.1673	43	75	—	—	0001851	—	—
4.30		0.1693	47	80	—	—	0001868	0350737	—
4.30		0.1693	47	80	016043	029043	0001868	0350737	—
	18	0.1695	47	80	—	—	0028797	—	—
	11/64	0.1719	47	80	—	—	0000793	0350744	—
	17	0.1730	47	80	—	—	0028780	—	—
4.40		0.1732	47	80	016044	029044	0001875	0350751	—
	16	0.1770	47	80	—	—	0028773	—	—
4.50		0.1772	47	80	016045	029045	0001882	0350768	46524862
	15	0.1800	47	80	—	—	0028766	—	—
4.60		0.1811	47	80	016046	029046	0001899	0350775	—
	14	0.1820	47	80	—	—	0028759	—	—
4.70		0.1850	47	80	—	—	0001905	0350782	—
	13	0.1850	47	80	—	—	0028742	—	—
4.75		0.1870	47	80	—	—	0001912	—	—
	3/16	0.1875	52	86	—	—	0001738	0350799	46524863
	12	0.1890	52	86	—	—	0028735	—	—
4.80		0.1890	52	86	016048	029048	0001929	0350805	—
	11	0.1910	52	86	—	—	0028728	—	—
4.90		0.1929	52	86	—	—	0001936	0350812	—
	10	0.1935	52	86	—	—	0028711	—	—
	9	0.1960	52	86	—	—	0029497	—	—
5.00		0.1968	52	86	016050	029050	0001967	0350829	46524864
	8	0.1990	52	86	—	—	0029473	—	—
5.10		0.2008	52	86	016051	029051	0001974	0350836	—
	7	0.2010	52	86	—	—	0029367	—	—
	13/64	0.2031	52	86	—	—	0001073	0350843	46524865
	6	0.2040	52	86	—	—	0029251	—	—
5.20		0.2047	52	86	016052	029052	0001981	0350850	—
	5	0.2055	52	86	—	—	0029145	—	—
5.25		0.2067	52	86	—	—	0001998	—	—
5.30		0.2087	52	86	016053	029053	0002001	0350867	—
	4	0.2090	57	93	—	—	0029039	—	—
5.40		0.2126	57	93	016054	029054	0002018	0350874	—
	3	0.2130	57	93	—	—	0028926	—	—
5.50		0.2165	57	93	016055	029055	0002025	0350881	46524866
	7/32	0.2187	57	93	—	—	0002377	0350898	46524867
5.60		0.2205	57	93	016056	029056	0002032	0350904	—
	2	0.2210	57	93	—	—	0028810	—	—
5.70		0.2244	57	93	016057	029057	0002049	0350911	—
5.75		0.2264	57	93	016276	029276	0002056	—	—

Package quantities: **2A and 2AB:** 0.15mm - 7.90mm = **12**; 8.00mm - 12.50mm = **6**; 12.70mm and above = **1**

**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**

**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> Øh <sub>8</sub> "/Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	2A	2AB	A100	A002	A002S
	1	0.2280	57	93	—	—	0028704	—	—
5.80		0.2283	57	93	016058	029058	0002063	0350928	—
5.90		0.2323	57	93	—	—	0002070	0350935	—
	A	0.2340	57	93	—	—	0028568	—	—
	15/64	0.2344	57	93	—	—	0001189	0350942	—
6.00		0.2362	57	93	016060	029060	0002124	0350959	46524868
	B	0.2380	63	101	—	—	0028575	—	—
6.10		0.2402	63	101	016061	029061	0002131	0350966	—
	C	0.2420	63	101	—	—	0028582	—	—
6.20		0.2441	63	101	016062	029062	0002148	0350973	—
	D	0.2460	63	101	—	—	0028599	—	—
6.25		0.2461	63	101	—	—	0002155	—	—
6.30		0.2480	63	101	016063	029063	0002162	0350980	—
	1/4	0.2500	63	101	—	—	0001080	0350997	46524869
	E	0.2500	63	101	—	—	0028605	—	—
6.40		0.2520	63	101	016064	029064	0002179	0351000	—
6.50		0.2559	63	101	016065	029065	0002186	0351017	46524870
	F	0.2570	63	101	—	—	0028612	—	—
6.60		0.2598	63	101	016066	029066	0002193	0351024	—
	G	0.2610	63	101	—	—	0028629	—	—
6.70		0.2638	63	101	016067	029067	0002209	0351031	—
	17/64	0.2656	69	109	—	—	0001257	0351048	46524871
6.75		0.2657	69	109	016278	029278	0002216	—	—
	H	0.2660	69	109	—	—	0028636	—	—
6.80		0.2677	69	109	016068	029068	0002223	0351055	46524872
6.90		0.2717	69	109	—	—	0002230	0351062	—
	I	0.2720	69	109	—	—	0028643	—	—
7.00		0.2756	69	109	016070	029070	0002247	0351079	46524873
	J	0.2770	69	109	—	—	0028650	—	—
7.10		0.2795	69	109	—	—	0002254	0351086	—
	K	0.2810	69	109	—	—	0028667	—	—
	9/32	0.2812	69	109	—	—	0002643	0351093	—
7.20		0.2835	69	109	016072	029072	0002261	0351109	—
7.25		0.2854	69	109	016279	029279	0002278	—	—
7.30		0.2874	69	109	016073	029073	0002285	0351116	—
	L	0.2900	69	109	—	—	0028674	—	—
7.40		0.2913	69	109	016074	029074	0002292	0351123	—
	M	0.2950	69	109	—	—	0028681	—	—
7.50		0.2953	69	109	016075	029075	0002308	0351130	46524874
	19/64	0.2968	75	117	—	—	0001325	0351147	—
7.60		0.2992	75	117	016076	029076	0002315	0351154	—
	N	0.3020	75	117	—	—	0028698	—	—
7.70		0.3031	75	117	—	—	0002322	0351161	—
7.75		0.3051	75	117	—	—	0002339	—	—
7.80		0.3071	75	117	016078	029078	0002346	0351178	—
7.85		0.3091	75	117	—	029281	—	—	—
7.90		0.3110	75	117	016079	029079	0002353	0351185	—
	5/16	0.3125	75	117	—	—	0002087	0351192	46524875
8.00		0.3150	75	117	016080	029080	0002391	0351208	46524876
	O	0.3160	75	117	—	—	0029503	—	—
8.10		0.3189	75	117	016081	029081	0002407	0351215	—
	P	0.3230	75	117	—	—	0029510	—	—
8.20		0.3228	75	117	016082	029082	0002414	0351222	46524877
8.25		0.3248	75	117	016282	029282	0002421	—	—
8.30		0.3268	75	117	—	—	0002438	0351239	—
	21/64	0.3281	75	117	—	—	0001554	0351246	—
8.40		0.3307	75	117	016084	029084	0002445	0351253	—
	Q	0.3320	75	117	—	—	0029527	—	—
8.50		0.3346	75	117	016085	029085	0002452	0351260	46524878
8.60		0.3386	81	125	016086	029086	0002469	0351277	—
	R	0.3390	81	125	—	—	0029534	—	—
8.70		0.3425	81	125	016087	029087	0002476	—	—
	11/32	0.3437	81	125	—	—	0000779	0351291	—

Package quantities: **2A and 2AB:** 0.15mm - 7.90mm = **12**; 8.00mm - 12.50mm = **6**; 12.70mm and above = **1**

**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**

**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> Øh <sub>8</sub> "/Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	2A	2AB	A100	A002	A002S
8.75		0.3445	81	125	016283	029283	0002483	—	—
8.80		0.3465	81	125	016088	029088	0002490	0351307	—
	S	0.3480	81	125	—	—	0029541	—	—
8.90		0.3504	81	125	016089	029089	0002506	0351314	—
9.00		0.3543	81	125	016090	029090	0002513	0351321	46524879
	T	0.3580	81	125	—	—	0029558	—	—
9.10		0.3583	81	125	—	—	0002520	0351338	—
	23/64	0.3594	81	125	—	—	0001561	0351345	—
9.20		0.3622	81	125	—	—	0002537	0351352	—
9.25		0.3642	81	125	—	—	0002544	—	—
9.30		0.3661	81	125	016093	029093	0002551	0351369	—
	U	0.3680	81	125	—	—	0029565	—	—
9.40		0.3701	81	125	016094	029094	0002568	0351376	—
9.50		0.3740	81	125	016095	029095	0002575	0351383	46524880
	3/8	0.3750	87	133	—	—	0001806	0351390	46524881
	V	0.3770	87	133	—	—	0029572	—	—
9.60		0.3780	87	133	016096	029096	0002582	0351406	—
9.70		0.3819	87	133	016097	029097	0002599	0351413	—
9.75		0.3839	87	133	—	—	0002605	—	—
9.80		0.3858	87	133	016098	029098	0002612	0351420	—
	W	0.3860	87	133	—	—	0029589	—	—
9.90		0.3898	87	133	016099	029099	0002629	0351437	—
	25/64	0.3906	87	133	—	—	0001578	0351444	—
10.00		0.3937	87	133	016100	029100	0000526	0351451	46524882
	X	0.3970	87	133	—	—	0029596	—	—
10.10		0.3976	87	133	—	—	0000533	0351468	—
10.20		0.4016	87	133	016102	029102	0000540	0351475	46524883
10.25		0.4035	87	133	—	—	0000557	—	—
	Y	0.4040	87	133	—	—	0029602	—	—
10.30		0.4055	87	133	016103	029103	0000564	0351482	—
	13/32	0.4062	87	133	—	—	0001066	0351499	—
10.40		0.4094	87	133	—	—	0000571	0351505	—
	Z	0.4130	87	133	—	—	0029619	—	—
10.50		0.4134	87	133	016105	029105	0000588	0351512	46524884
10.60		0.4173	87	133	016106	—	0000595	0351529	—
10.70		0.4213	94	142	—	—	0000601	0351536	—
	27/64	0.4219	94	142	—	—	0001585	0351543	—
10.75		0.4232	94	142	—	—	0000618	—	—
10.80		0.4252	94	142	016108	029108	0000625	0351550	—
10.90		0.4291	94	142	016109	029109	0000632	0351567	—
11.00		0.4331	94	142	016110	029110	0000649	0351574	46524885
11.10		0.4370	94	142	—	—	0000656	0351581	—
	7/16	0.4375	94	142	—	—	0002360	0351598	—
11.20		0.4409	94	142	016112	029112	0000663	0351604	—
11.25		0.4429	94	142	—	—	0000670	—	—
11.30		0.4449	94	142	016113	029113	0000687	0351611	—
11.40		0.4488	94	142	016114	029114	0000694	0351628	—
11.50		0.4528	94	142	016115	029115	0000700	0351635	46524886
	29/64	0.4531	94	142	—	—	0001592	0351642	—
11.60		0.4567	94	142	—	—	0000717	0351659	—
11.70		0.4606	94	142	016117	029117	0000724	0351666	—
11.75		0.4626	94	142	—	—	0000731	—	—
11.80		0.4646	94	142	016118	029118	0000748	0351673	—
11.90		0.4685	101	151	—	—	0000755	0351680	—
	15/32	0.4687	101	151	—	—	0001172	0351697	—
12.00		0.4724	101	151	016120	029120	0000816	0351703	46524887
12.10		0.4764	101	151	016121	029121	0000823	0351710	—
12.20		0.4803	101	151	016122	029122	0000830	0351727	—
12.25		0.4823	101	151	—	—	0000847	—	—
12.30		0.4843	101	151	—	—	0000854	0351734	—
	31/64	0.4843	101	151	—	—	0001745	0351741	—
12.40		0.4882	101	151	—	—	0000861	0351758	—

Package quantities: **2A and 2AB:** 0.15mm - 7.90mm = **12**; 8.00mm - 12.50mm = **6**; 12.70mm and above = **1**

**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**

**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**

$d_1$ $\varnothing h_8$ mm	$d_1$ $\varnothing h_8$ "/Nr./letter	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	2A	2AB	A100	A002	A002S
12.50		0.4921	101	151	016125	029125	0000878	0351765	46524888
12.60		0.4961	101	151	—	—	0000885	0351772	—
	1/2	0.5000	101	151	—	—	0000809	0351789	46524889
12.70		0.5000	101	151	—	029127	0000892	0351796	—
12.75		0.5020	101	151	—	—	0000908	—	—
12.80		0.5039	101	151	016128	029128	0000915	0351802	—
12.90		0.5079	101	151	—	029129	0000922	0351819	—
13.00		0.5118	101	151	016130	029130	0000939	0351826	46524890
	33/64	0.5156	101	151	—	—	0001769	0385333	—
13.10		0.5157	101	151	—	—	0000946	0385180	—
13.20		0.5197	101	151	—	—	0000953	0385524	—
13.25		0.5217	108	160	—	—	0000960	0385579	—
13.30		0.5236	108	160	—	—	0000977	0385197	—
13.40		0.5276	108	160	—	—	0000984	0385531	—
	17/32	0.5313	108	160	—	—	0001240	0385319	—
13.50		0.5315	108	160	034135	016135	0000991	0385548	—
13.60		0.5354	108	160	—	—	0001004	0385203	—
13.70		0.5394	108	160	—	—	0001011	0385210	—
13.75		0.5413	108	160	—	—	0001028	0385586	—
13.80		0.5433	108	160	—	—	0001035	0385227	—
	35/64	0.5469	108	160	—	—	0001776	0385340	—
13.90		0.5472	108	160	—	—	0001042	0385494	—
14.00		0.5512	108	160	034140	016140	0001097	0384497	—
14.25		0.5610	114	169	—	—	0001103	0385234	—
	9/16	0.5625	114	169	—	—	0002636	0385388	—
14.50		0.5709	114	169	034145	016145	0001110	0385241	—
	37/64	0.5781	114	169	—	—	0001790	0385357	—
14.75		0.5807	114	169	—	—	0001127	0385258	—
15.00		0.5906	114	169	034150	016150	0001134	0385265	—
	19/32	0.5937	120	178	—	—	0001318	0385326	—
15.25		0.6004	120	178	—	—	0001141	0385272	—
	39/64	0.6094	120	178	—	—	0001813	0385364	—
15.50		0.6102	120	178	—	016155	0001158	0385289	—
15.75		0.6201	120	178	—	—	0001165	0385296	—
	5/8	0.6250	120	178	—	—	0002117	0385371	—
16.00		0.6299	120	178	—	016160	0001196	0385302	—
	41/64	0.6406	125	184	—	—	0001943	—	—
16.50		0.6496	125	184	—	016165	0001202	—	—
	21/32	0.6562	125	184	—	—	0001547	—	—
17.00		0.6693	125	184	—	016170	0001226	—	—
	43/64	0.6719	130	191	—	—	0001950	—	—
	11/16	0.6875	130	191	—	—	0000762	—	—
17.50		0.6890	130	191	—	016175	0001233	—	—
18.00		0.7087	130	191	—	—	0001271	—	—
18.50		0.7283	135	198	—	—	0001288	—	—
19.00		0.7480	135	198	—	—	0001295	—	—
19.50		0.7677	140	205	—	—	0001301	—	—
20.00		0.7874	140	205	—	—	0001530	—	—

Package quantities: **2A and 2AB:** 0.15mm - 7.90mm = **12**; 8.00mm - 12.50mm = **6**; 12.70mm and above = **1**  
**A100 and A002:** 0.20mm - 10.00mm = **10**; X - 13.00mm = **5**; 33/64 and above = **1**  
**A002S:** 0.20mm - 5.00mm = **2**; 13/64 - 13.00mm = **1**





# JOBBER DRILL

## General Purpose Jobber Length - Left Hand

**L10** Left hand helix for use in machines where spindle is counter-clockwise & can be used to remove broken parts without damaging threaded holes. Bright Finish improves chip flow in soft or non-ferrous materials

L10

ANSI

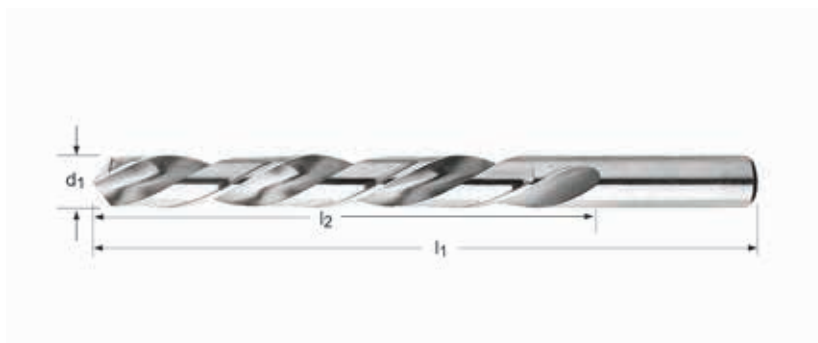
4XD

HSS

118°



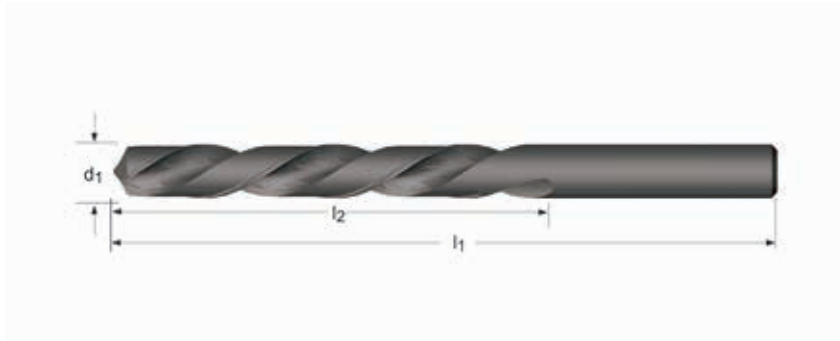
1/32 - 1/2



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	L10
1/32	0.0313	1/2	1.3/8	12	010902
3/64	0.0469	3/4	1.3/4	12	010903
1/16	0.0625	7/8	1.7/8	12	010904
5/64	0.0781	1"	2"	12	010905
3/32	0.0938	1.1/4	2.1/4	12	010906
7/64	0.1094	1.1/2	2.5/8	12	010907
1/8	0.1250	1.5/8	2.3/4	12	010908
9/64	0.1406	1.3/4	2.7/8	12	010909
5/32	0.1563	2"	3.1/8	12	010910
11/64	0.1719	2.1/8	3.1/4	12	010911
3/16	0.1875	2.5/16	3.1/2	12	010912
13/64	0.2031	2.7/16	3.5/8	12	010913
7/32	0.2188	2.1/2	3.3/4	12	010914
15/64	0.2344	2.5/8	3.7/8	12	010915
1/4	0.2500	2.3/4	4"	12	010916
17/64	0.2656	2.7/8	4.1/8	12	010917
9/32	0.2813	2.15/16	4.1/4	12	010918
19/64	0.2969	3.1/16	4.3/8	12	010919
5/16	0.3125	3.3/16	4.1/2	6	010920
21/64	0.3281	3.5/16	4.5/8	6	010921
11/32	0.3437	3.7/16	4.3/4	6	010922
23/64	0.3594	3.1/2	4.7/8	6	010923
3/8	0.3750	3.5/8	5"	6	010924
25/64	0.3906	3.3/4	5.1/8	6	010925
13/32	0.4063	3.7/8	5.1/4	6	010926
27/64	0.4219	3.15/16	5.3/8	6	010927
7/16	0.4375	4.1/16	5.1/2	6	010928
29/64	0.4531	4.3/16	5.5/8	6	010929
15/32	0.4687	4.5/16	5.3/4	6	010930
31/64	0.4844	4.3/8	5.7/8	6	010931
1/2	0.5000	4.1/2	6"	6	010932

## General Purpose Jobber Length - Left Hand

**A101** Left hand helix for use in machines where spindle is counter-clockwise & can be used to remove broken parts without damaging threaded holes.



**A101**

**DIN 338**

**4XD**

**HSS**

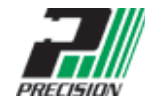
**118°**

1.00 - 12.00

$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	<b>A101</b>
1.00	0.0394	12	34	0002667
1.10	0.0433	14	36	0002674
1.20	0.0472	16	38	0002681
1.25	0.0492	16	38	0002698
1.30	0.0512	16	38	0002704
1.40	0.0551	18	40	0002711
1.50	0.0591	18	40	0002728
1.60	0.0630	20	43	0002735
1.70	0.0669	20	43	0002742
1.80	0.0709	22	46	0002766
1.90	0.0748	22	46	0002773
2.00	0.0787	24	49	0002803
2.10	0.0827	24	49	0002810
2.20	0.0866	27	53	0002827
2.30	0.0906	27	53	0002834
2.40	0.0945	30	57	0002841
2.50	0.0984	30	57	0002858
2.60	0.1024	30	57	0002865
2.70	0.1063	33	61	0002872
2.80	0.1102	33	61	0002889
2.90	0.1142	33	61	0002896
3.00	0.1181	33	61	0002902
3.20	0.1260	36	65	0002919
3.30	0.1299	36	65	0002926
3.50	0.1378	39	70	0002933
3.80	0.1496	43	75	0002940
4.00	0.1575	43	75	0002957
4.20	0.1654	43	75	0002964
4.50	0.1772	47	80	0002971
4.80	0.1890	52	86	0002988
5.00	0.1969	52	86	0002995
5.10	0.2008	52	86	0003008
5.20	0.2047	52	86	0003015

$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	A101
5.50	0.2165	57	93	0003022
6.00	0.2362	57	93	0003039
6.50	0.2559	63	101	0003046
7.00	0.2756	69	109	0003053
7.50	0.2953	69	109	0003060
8.00	0.3150	75	117	0003077
8.50	0.3346	75	117	0003084
9.00	0.3543	81	125	0003091
10.00	0.3937	87	133	0002780
11.00	0.4331	94	142	0149027
12.00	0.4724	101	151	0002797

# JOBBER DRILL

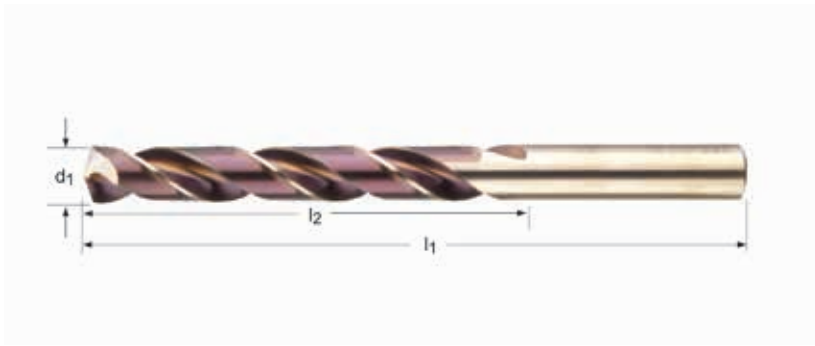


## Heavy Duty Jobber Length (HX Series)

\* HX10 set available on pg. 210

- HX10** - Fractional Sizes
- HX18** - Wire Gauge Sizes
- HX15** - Letter Sizes

Low thrust design self centering Split Point for easier penetration. Stronger and more Rigid. Unique surface treatment for improved wear resistance in hard ferrous alloys.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	HX10	HX18	HX15
1/16			0.0625	7/8	1.7/8	12	022004	—	—
	52		0.0635	7/8	1.7/8	12	—	022152	—
	51		0.0670	1"	2"	12	—	022151	—
	50		0.0700	1"	2"	12	—	022150	—
	49		0.0730	1"	2"	12	—	022149	—
	48		0.0760	1"	2"	12	—	022148	—
5/64			0.0781	1"	2"	12	022005	—	—
	47		0.0785	1"	2"	12	—	022147	—
	46		0.0810	1.1/8	2.1/8	12	—	022146	—
	45		0.0820	1.1/8	2.1/8	12	—	022145	—
	44		0.0860	1.1/8	2.1/8	12	—	022144	—
	43		0.0890	1.1/4	2.1/4	12	—	022143	—
	42		0.0935	1.1/4	2.1/4	12	—	022142	—
3/32			0.0938	1.1/4	2.1/4	12	022006	—	—
	41		0.0960	1.3/8	2.3/8	12	—	022141	—
	40		0.0980	1.3/8	2.3/8	12	—	022140	—
	39		0.0995	1.3/8	2.3/8	12	—	022139	—
	38		0.1015	1.7/16	2.1/2	12	—	022138	—
	37		0.1040	1.7/16	2.1/2	12	—	022137	—
	36		0.1065	1.7/16	2.1/2	12	—	022136	—
7/64			0.1094	1.1/2	2.5/8	12	022007	—	—
	35		0.1100	1.1/2	2.5/8	12	—	022135	—
	34		0.1110	1.1/2	2.5/8	12	—	022134	—
	33		0.1130	1.1/2	2.5/8	12	—	022133	—
	32		0.1160	1.5/8	2.3/4	12	—	022132	—
	31		0.1200	1.5/8	2.3/4	12	—	022131	—
1/8			0.1250	1.5/8	2.3/4	12	022008	—	—
	30		0.1285	1.5/8	2.3/4	12	—	022130	—
	29		0.1360	1.3/4	2.7/8	12	—	022129	—
	28		0.1405	1.3/4	2.7/8	12	—	022128	—
9/64			0.1406	1.3/4	2.7/8	12	022009	—	—
	27		0.1440	1.7/8	3"	12	—	022127	—
	26		0.1470	1.7/8	3"	12	—	022126	—



# JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	HX10	HX18	HX15
	25		0.1495	1.7/8	3"	12	—	022125	—
	24		0.1520	2"	3.1/8	12	—	022124	—
	23		0.1540	2"	3.1/8	12	—	022123	—
5/32			0.1563	2"	3.1/8	12	022010	—	—
	22		0.1570	2"	3.1/8	12	—	022122	—
	21		0.1590	2.1/8	3.1/4	12	—	022121	—
	20		0.1610	2.1/8	3.1/4	12	—	022120	—
	19		0.1660	2.1/8	3.1/4	12	—	022119	—
	18		0.1695	2.1/8	3.1/4	12	—	022118	—
11/64			0.1719	2.1/8	3.1/4	12	022011	—	—
	17		0.1730	2.3/16	3.3/8	12	—	022117	—
	16		0.1770	2.3/16	3.3/8	12	—	022116	—
	15		0.1800	2.3/16	3.3/8	12	—	022115	—
	14		0.1820	2.3/16	3.3/8	12	—	022114	—
	13		0.1850	2.5/16	3.1/2	12	—	022113	—
3/16			0.1875	2.5/16	3.1/2	12	022012	—	—
	12		0.1890	2.5/16	3.1/2	12	—	022112	—
	11		0.1910	2.5/16	3.1/2	12	—	022111	—
	10		0.1935	2.7/16	3.5/8	12	—	022110	—
	9		0.1960	2.7/16	3.5/8	12	—	022109	—
	8		0.1990	2.7/16	3.5/8	12	—	022108	—
	7		0.2010	2.7/16	3.5/8	12	—	022107	—
13/64			0.2031	2.7/16	3.5/8	12	022013	—	—
	6		0.2040	2.1/2	3.3/4	12	—	022106	—
	5		0.2055	2.1/2	3.3/4	12	—	022105	—
	4		0.2090	2.1/2	3.3/4	12	—	022104	—
	3		0.2130	2.1/2	3.3/4	12	—	022103	—
7/32			0.2188	2.1/2	3.3/4	12	022014	—	—
	2		0.2210	2.5/8	3.7/8	12	—	022102	—
	1		0.2280	2.5/8	3.7/8	12	—	022101	—
		A	0.2340	2.5/8	3.7/8	12	—	—	022201
15/64			0.2344	2.5/8	3.7/8	12	022015	—	—
		B	0.2374	2.3/4	4"	12	—	—	022202
		C	0.2421	2.3/4	4"	12	—	—	022203
		D	0.2461	2.3/4	4"	12	—	—	022204
		E	0.2500	2.3/4	4"	12	—	—	022205
1/4			0.2500	2.3/4	4"	12	022016	—	—
		F	0.2571	2.7/8	4.1/8	12	—	—	022206
		G	0.2610	2.7/8	4.1/8	12	—	—	022207
17/64			0.2656	2.7/8	4.1/8	12	0022017	—	—
		H	0.2661	2.7/8	4.1/8	12	—	—	022208
		I	0.2720	2.7/8	4.1/8	12	—	—	022209
		J	0.2772	2.7/8	4.1/8	12	—	—	022210
		K	0.2811	2.15/16	4.1/4	12	—	—	022211
9/32			0.2813	2.15/16	4.1/4	12	022018	—	—
		L	0.2902	2.15/16	4.1/4	12	—	—	022212
		M	0.2949	3.1/16	4.3/8	12	—	—	022213
19/64			0.2969	3.1/16	4.3/8	12	022019	—	—
		N	0.3020	3.1/16	4.3/8	12	—	—	022214
5/16			0.3125	3.3/16	4.1/2	6	022020	—	—
		O	0.3161	3.3/16	4.1/2	6	—	—	022215
		P	0.3228	3.5/16	4.5/8	6	—	—	022216
21/64			0.3281	3.5/16	4.5/8	6	022021	—	—
		Q	0.3319	3.7/16	4.3/4	6	—	—	022217
		R	0.3390	3.7/16	4.3/4	6	—	—	022218
11/32			0.3437	3.7/16	4.3/4	6	022022	—	—
		S	0.3480	3.1/2	4.7/8	6	—	—	022219
		T	0.3580	3.1/2	4.7/8	6	—	—	022220
23/64			0.3594	3.1/2	4.7/8	6	022023	—	—
		U	0.3680	3.5/8	5"	6	—	—	022221
3/8			0.3750	3.5/8	5"	6	022024	—	—
		V	0.3772	3.5/8	5"	6	—	—	022222
		W	0.3858	3.3/4	5.1/8	6	—	—	022223
25/64			0.3906	3.3/4	5.1/8	6	022025	—	—
		X	0.3969	3.3/4	5.1/8	6	—	—	022224
		Y	0.4039	3.7/8	5.1/4	6	—	—	022225

# JOBBER DRILL



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	HX10	HX18	HX15
13/32			0.4063	3.7/8	5.1/4	6	022026	—	—
		Z	0.4130	3.7/8	5.1/4	6	—	—	022226
27/64			0.4219	3.15/16	5.3/8	6	022027	—	—
7/16			0.4375	4.1/16	5.1/2	6	022028	—	—
29/64			0.4531	4.3/16	5.5/8	6	022029	—	—
15/32			0.4687	4.5/16	5.3/4	6	022030	—	—
31/64			0.4844	4.3/8	5.7/8	6	022031	—	—
1/2			0.5000	4.1/2	6"	6	022032	—	—



# JOBBER DRILL

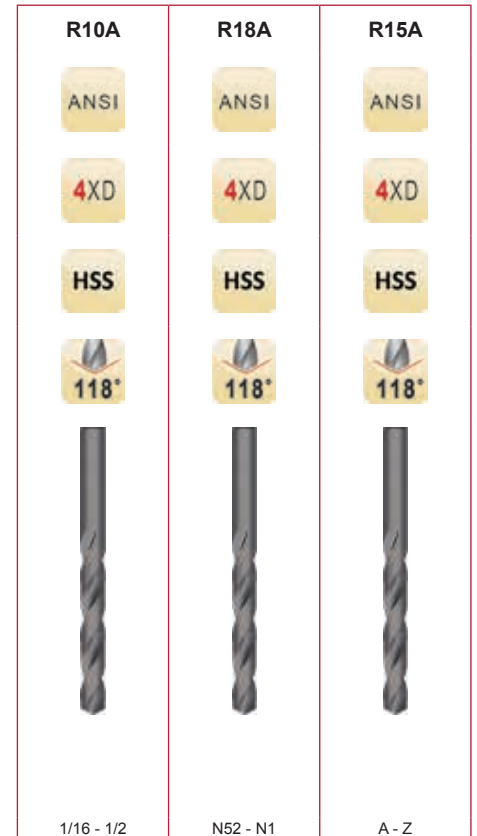
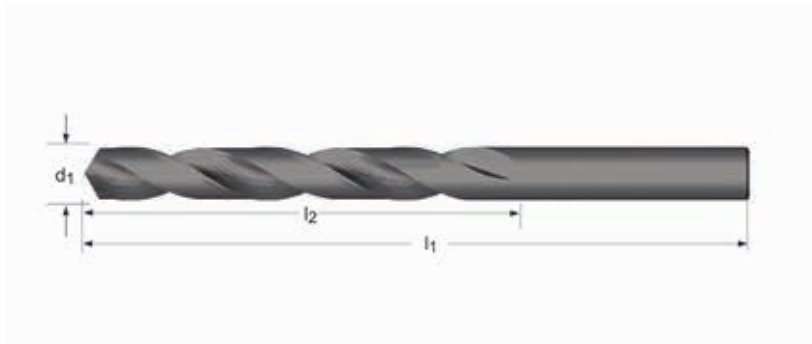
## General Purpose Jobber Length (NAS 907 Type A)

**R10A** - Fractional Sizes

**R18A** - Wire Gauge Sizes

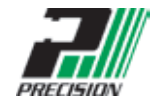
**R15A** - Letter Sizes

Low thrust design self centering Split Point for easier penetration.  
Steam oxide surface treatment for increased wear resistance & lubricity



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R10A	R18A	R15A
1/16			0.0625	7/8	1.7/8	12	010104	—	—
	52		0.0635	7/8	1.7/8	12	—	018152	—
	51		0.0670	1"	2"	12	—	018151	—
	50		0.0700	1"	2"	12	—	018150	—
	49		0.0730	1"	2"	12	—	018149	—
	48		0.0760	1"	2"	12	—	018148	—
5/64			0.0781	1"	2"	12	010105	—	—
	47		0.0785	1"	2"	12	—	018147	—
	46		0.0810	1.1/8	2.1/8	12	—	018146	—
	45		0.0820	1.1/8	2.1/8	12	—	018145	—
	44		0.0860	1.1/8	2.1/8	12	—	018144	—
	43		0.0890	1.1/4	2.1/4	12	—	018143	—
	42		0.0935	1.1/4	2.1/4	12	—	018142	—
3/32			0.0938	1.1/4	2.1/4	12	010106	—	—
	41		0.0960	1.3/8	2.3/8	12	—	018141	—
	40		0.0980	1.3/8	2.3/8	12	—	018140	—
	39		0.0995	1.3/8	2.3/8	12	—	018139	—
	38		0.1015	1.7/16	2.1/2	12	—	018138	—
	37		0.1040	1.7/16	2.1/2	12	—	018137	—
	36		0.1065	1.7/16	2.1/2	12	—	018136	—
7/64			0.1094	1.1/2	2.5/8	12	010107	—	—
	35		0.1100	1.1/2	2.5/8	12	—	018135	—
	34		0.1110	1.1/2	2.5/8	12	—	018134	—
	33		0.1130	1.1/2	2.5/8	12	—	018133	—
	32		0.1160	1.5/8	2.3/4	12	—	018132	—
	31		0.1200	1.5/8	2.3/4	12	—	018131	—
1/8			0.1250	1.5/8	2.3/4	12	010108	—	—
	30		0.1285	1.5/8	2.3/4	12	—	018130	—
	29		0.1360	1.3/4	2.7/8	12	—	018129	—
	28		0.1405	1.3/4	2.7/8	12	—	018128	—
9/64			0.1406	1.3/4	2.7/8	12	010109	—	—
	27		0.1440	1.7/8	3"	12	—	018127	—

# JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10A	R18A	R15A
	26		0.1470	1.7/8	3"	12	—	018126	—
	25		0.1495	1.7/8	3"	12	—	018125	—
	24		0.1520	2"	3.1/8	12	—	018124	—
	23		0.1540	2"	3.1/8	12	—	018123	—
5/32			0.1563	2"	3.1/8	12	010110	—	—
	22		0.1570	2"	3.1/8	12	—	018122	—
	21		0.1590	2.1/8	3.1/4	12	—	018121	—
	20		0.1610	2.1/8	3.1/4	12	—	018120	—
	19		0.1660	2.1/8	3.1/4	12	—	018119	—
	18		0.1695	2.1/8	3.1/4	12	—	018118	—
11/64			0.1719	2.1/8	3.1/4	12	010111	—	—
	17		0.1730	2.3/16	3.3/8	12	—	018117	—
	16		0.1770	2.3/16	3.3/8	12	—	018116	—
	15		0.1800	2.3/16	3.3/8	12	—	018115	—
	14		0.1820	2.3/16	3.3/8	12	—	018114	—
	13		0.1850	2.5/16	3.1/2	12	—	018113	—
3/16			0.1875	2.5/16	3.1/2	12	010112	—	—
	12		0.1890	2.5/16	3.1/2	12	—	018112	—
	11		0.1910	2.5/16	3.1/2	12	—	018111	—
	10		0.1935	2.7/16	3.5/8	12	—	018110	—
	9		0.1960	2.7/16	3.5/8	12	—	018109	—
	8		0.1990	2.7/16	3.5/8	12	—	018108	—
	7		0.2010	2.7/16	3.5/8	12	—	018107	—
13/64			0.2031	2.7/16	3.5/8	12	010113	—	—
	6		0.2040	2.1/2	3.3/4	12	—	018106	—
	5		0.2055	2.1/2	3.3/4	12	—	018105	—
	4		0.2090	2.1/2	3.3/4	12	—	018104	—
	3		0.2130	2.1/2	3.3/4	12	—	018103	—
7/32			0.2188	2.1/2	3.3/4	12	010114	—	—
	2		0.2210	2.5/8	3.7/8	12	—	018102	—
	1		0.2280	2.5/8	3.7/8	12	—	018101	—
		A	0.2340	2.5/8	3.7/8	12	—	—	015101
15/64			0.2344	2.5/8	3.7/8	12	010115	—	—
		B	0.2374	2.3/4	4"	12	—	—	015102
		C	0.2421	2.3/4	4"	12	—	—	015103
		D	0.2461	2.3/4	4"	12	—	—	015104
		E	0.2500	2.3/4	4"	12	—	—	015105
1/4			0.2500	2.3/4	4"	12	010116	—	—
		F	0.2571	2.7/8	4.1/8	12	—	—	015106
		G	0.2610	2.7/8	4.1/8	12	—	—	015107
17/64			0.2656	2.7/8	4.1/8	12	010117	—	—
		H	0.2661	2.7/8	4.1/8	12	—	—	015108
		I	0.2720	2.7/8	4.1/8	12	—	—	015109
		J	0.2772	2.7/8	4.1/8	12	—	—	015110
		K	0.2811	2.15/16	4.1/4	12	—	—	015111
9/32			0.2813	2.15/16	4.1/4	12	010118	—	—
		L	0.2902	2.15/16	4.1/4	12	—	—	015112
		M	0.2949	3.1/16	4.3/8	12	—	—	015113
19/64			0.2969	3.1/16	4.3/8	12	010119	—	—
		N	0.3020	3.1/16	4.3/8	12	—	—	015114
5/16			0.3125	3.3/16	4.1/2	6	010120	—	—
		O	0.3161	3.3/16	4.1/2	6	—	—	015115
		P	0.3228	3.5/16	4.5/8	6	—	—	015116
21/64			0.3281	3.5/16	4.5/8	6	010121	—	—
		Q	0.3319	3.7/16	4.3/4	6	—	—	015117
		R	0.3390	3.7/16	4.3/4	6	—	—	015118
11/32			0.3437	3.7/16	4.3/4	6	010122	—	—
		S	0.3480	3.1/2	4.7/8	6	—	—	015119
		T	0.3580	3.1/2	4.7/8	6	—	—	015120
23/64			0.3594	3.1/2	4.7/8	6	010123	—	—
		U	0.3680	3.5/8	5"	6	—	—	015121
3/8			0.3750	3.5/8	5"	6	010124	—	—
		V	0.3772	3.5/8	5"	6	—	—	015122
		W	0.3858	3.3/4	5.1/8	6	—	—	015123
25/64			0.3906	3.3/4	5.1/8	6	0010125	—	—





# JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10A	R18A	R15A
		X	0.3969	3.3/4	5.1/8	6	—	—	015124
		Y	0.4039	3.7/8	5.1/4	6	—	—	015125
13/32			0.4063	3.7/8	5.1/4	6	010126	—	—
		Z	0.4130	3.7/8	5.1/4	6	—	—	015126
27/64			0.4219	3.15/16	5.3/8	6	010127	—	—
7/16			0.4375	4.1/16	5.1/2	6	010128	—	—
29/64			0.4531	4.3/16	5.5/8	6	010129	—	—
15/32			0.4687	4.5/16	5.3/4	6	010130	—	—
31/64			0.4844	4.3/8	5.7/8	6	010131	—	—
1/2			0.5000	4.1/2	6"	6	010132	—	—

# JOBBER DRILL



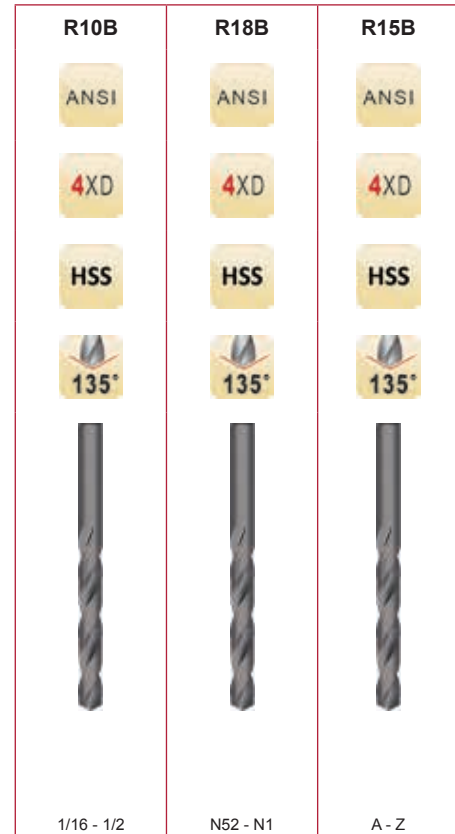
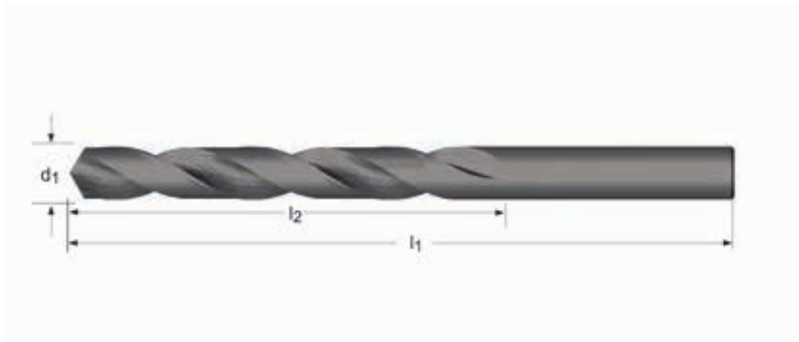
## Heavy Duty Jobber Length (NAS 907 Type B)

**R10B** - Fractional Sizes

**R18B** - Wire Gauge Sizes

**R15B** - Letter Sizes

Low thrust design self centering Split Point for easier penetration. Steam Oxide surface treatment for increased wear resistance & lubricity. Recommended for tougher ferrous materials.



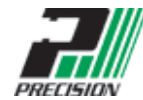
$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R10B	R18B	R15B
1/16			0.0625	7/8	1.7/8	12	010204	—	—
	52		0.0635	7/8	1.7/8	12	—	018252	—
	51		0.0670	1"	2"	12	—	018251	—
	50		0.0700	1"	2"	12	—	018250	—
	49		0.0730	1"	2"	12	—	018249	—
	48		0.0760	1"	2"	12	—	018248	—
5/64			0.0781	1"	2"	12	010205	—	—
	47		0.0785	1"	2"	12	—	018247	—
	46		0.0810	1.1/8	2.1/8	12	—	018246	—
	45		0.0820	1.1/8	2.1/8	12	—	018245	—
	44		0.0860	1.1/8	2.1/8	12	—	018244	—
	43		0.0890	1.1/4	2.1/4	12	—	018243	—
	42		0.0935	1.1/4	2.1/4	12	—	018242	—
3/32			0.0938	1.1/4	2.1/4	12	010206	—	—
	41		0.0960	1.3/8	2.3/8	12	—	018241	—
	40		0.0980	1.3/8	2.3/8	12	—	018240	—
	39		0.0995	1.3/8	2.3/8	12	—	018239	—
	38		0.1015	1.7/16	2.1/2	12	—	018238	—
	37		0.1040	1.7/16	2.1/2	12	—	018237	—
	36		0.1065	1.7/16	2.1/2	12	—	018236	—
7/64			0.1094	1.1/2	2.5/8	12	010207	—	—
	35		0.1100	1.1/2	2.5/8	12	—	018235	—
	34		0.1110	1.1/2	2.5/8	12	—	018234	—
	33		0.1130	1.1/2	2.5/8	12	—	018233	—
	32		0.1160	1.5/8	2.3/4	12	—	018232	—
	31		0.1200	1.5/8	2.3/4	12	—	018231	—
1/8			0.1250	1.5/8	2.3/4	12	010208	—	—
	30		0.1285	1.5/8	2.3/4	12	—	018230	—
	29		0.1360	1.3/4	2.7/8	12	—	018229	—
	28		0.1405	1.3/4	2.7/8	12	—	018228	—
9/64			0.1406	1.3/4	2.7/8	12	010209	—	—
	27		0.1440	1.7/8	3"	12	—	018227	—



# JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R10B	R18B	R15B
	26		0.1470	1.7/8	3"	12	—	018226	—
	25		0.1495	1.7/8	3"	12	—	018225	—
	24		0.1520	2"	3.1/8	12	—	018224	—
	23		0.1540	2"	3.1/8	12	—	018223	—
5/32			0.1563	2"	3.1/8	12	010210	—	—
	22		0.1570	2"	3.1/8	12	—	018222	—
	21		0.1590	2.1/8	3.1/4	12	—	018221	—
	20		0.1610	2.1/8	3.1/4	12	—	018220	—
	19		0.1660	2.1/8	3.1/4	12	—	018219	—
	18		0.1695	2.1/8	3.1/4	12	—	018218	—
11/64			0.1719	2.1/8	3.1/4	12	010211	—	—
	17		0.1730	2.3/16	3.3/8	12	—	018217	—
	16		0.1770	2.3/16	3.3/8	12	—	018216	—
	15		0.1800	2.3/16	3.3/8	12	—	018215	—
	14		0.1820	2.3/16	3.3/8	12	—	018214	—
	13		0.1850	2.5/16	3.1/2	12	—	018213	—
3/16			0.1875	2.5/16	3.1/2	12	010212	—	—
	12		0.1890	2.5/16	3.1/2	12	—	018212	—
	11		0.1910	2.5/16	3.1/2	12	—	018211	—
	10		0.1935	2.7/16	3.5/8	12	—	018210	—
	9		0.1960	2.7/16	3.5/8	12	—	018209	—
	8		0.1990	2.7/16	3.5/8	12	—	018208	—
	7		0.2010	2.7/16	3.5/8	12	—	018207	—
13/64			0.2031	2.7/16	3.5/8	12	010213	—	—
	6		0.2040	2.1/2	3.3/4	12	—	018206	—
	5		0.2055	2.1/2	3.3/4	12	—	018205	—
	4		0.2090	2.1/2	3.3/4	12	—	018204	—
	3		0.2130	2.1/2	3.3/4	12	—	018203	—
7/32			0.2188	2.1/2	3.3/4	12	010214	—	—
	2		0.2210	2.5/8	3.7/8	12	—	018202	—
	1		0.2280	2.5/8	3.7/8	12	—	018201	—
		A	0.2340	2.5/8	3.7/8	12	—	—	015201
15/64			0.2344	2.5/8	3.7/8	12	010215	—	—
		B	0.2380	2.3/4	4"	12	—	—	015202
		C	0.2421	2.3/4	4"	12	—	—	015203
		D	0.2461	2.3/4	4"	12	—	—	015204
		E	0.2500	2.3/4	4"	12	—	—	015205
1/4			0.2500	2.3/4	4"	12	010216	—	—
		F	0.2571	2.7/8	4.1/8	12	—	—	015206
		G	0.2610	2.7/8	4.1/8	12	—	—	015207
17/64			0.2656	2.7/8	4.1/8	12	010217	—	—
		H	0.2661	2.7/8	4.1/8	12	—	—	015208
		I	0.2720	2.7/8	4.1/8	12	—	—	015209
		J	0.2772	2.7/8	4.1/8	12	—	—	015210
		K	0.2811	2.15/16	4.1/4	12	—	—	015211
9/32			0.2813	2.15/16	4.1/4	12	010218	—	—
		L	0.2902	2.15/16	4.1/4	12	—	—	015212
		M	0.2949	3.1/16	4.3/8	12	—	—	015213
19/64			0.2969	3.1/16	4.3/8	12	010219	—	—
		N	0.3020	3.1/16	4.3/8	12	—	—	015214
5/16			0.3125	3.3/16	4.1/2	6	010220	—	—
		O	0.3161	3.3/16	4.1/2	6	—	—	015215
		P	0.3228	3.5/16	4.5/8	6	—	—	015216
21/64			0.3281	3.5/16	4.5/8	6	010221	—	—
		Q	0.3319	3.7/16	4.3/4	6	—	—	015217
		R	0.3390	3.7/16	4.3/4	6	—	—	015218
11/32			0.3437	3.7/16	4.3/4	6	010222	—	—
		S	0.3480	3.1/2	4.7/8	6	—	—	015219
		T	0.3580	3.1/2	4.7/8	6	—	—	015220
23/64			0.3594	3.1/2	4.7/8	6	010223	—	—
		U	0.3680	3.5/8	5"	6	—	—	015221
3/8			0.3750	3.5/8	5"	6	010224	—	—
		V	0.3772	3.5/8	5"	6	—	—	015222
		W	0.3858	3.3/4	5.1/8	6	—	—	015223
25/64			0.3906	3.3/4	5.1/8	6	010225	—	—
		X	0.3969	3.3/4	5.1/8	6	—	—	015224

# JOBBER DRILL



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R10B	R18B	R15B
		Y	0.4039	3.7/8	5.1/4	6	—	—	015225
13/32			0.4063	3.7/8	5.1/4	6	010226	—	—
		Z	0.4130	3.7/8	5.1/4	6	—	—	015226
27/64			0.4219	3.15/16	5.3/8	6	010227	—	—
7/16			0.4375	4.1/16	5.1/2	6	010228	—	—
29/64			0.4531	4.3/16	5.5/8	6	010229	—	—
15/32			0.4687	4.5/16	5.3/4	6	010230	—	—
31/64			0.4844	4.3/8	5.7/8	6	010231	—	—
1/2			0.5000	4.1/2	6"	6	010232	—	—

## High Helix Jobber Length

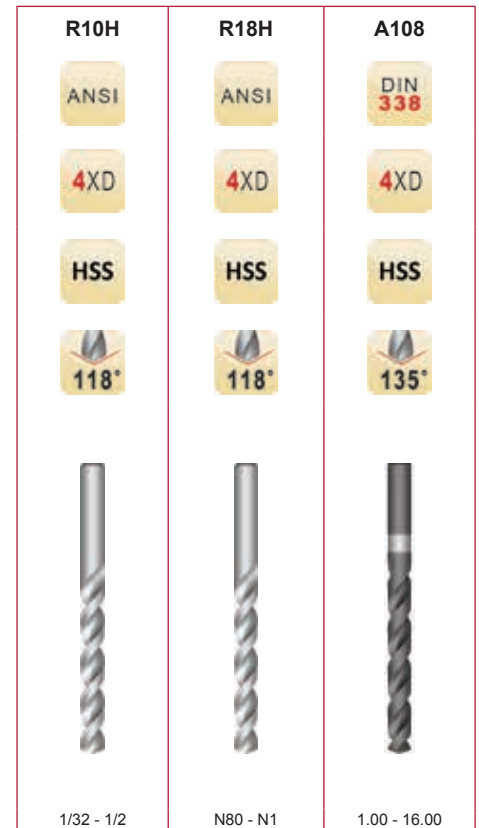
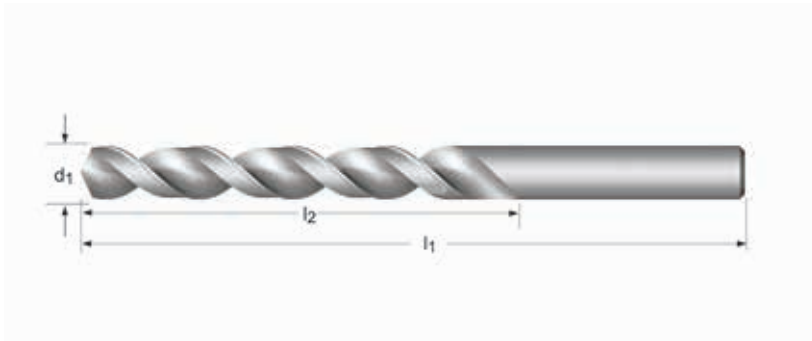
**R10H** - Fractional Sizes

**R18H** - Wire Gauge Sizes

High Helix and Bright Finish for better chip flow in soft or non-ferrous materials.

**A108** - Fractional & Metric Sizes

Low thrust design self centering Split Point for easier penetration. Steam Oxide for increased wear resistance & lubricity. Fast spiral for stainless.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ Inch	$l_2$ mm	$l_1$ Inch	$l_1$ mm	Pack Qty	R10H	R18H	A108
	80		0.0135	1/8		3/4		12	—	018580	—
	79		0.0145	1/8		3/4		12	—	018579	—
	78		0.0160	3/16		7/8		12	—	018578	—
	77		0.0180	3/16		7/8		12	—	018577	—
	76		0.0200	3/16		7/8		12	—	018576	—
	75		0.0210	1/4		1"		12	—	018575	—
	74		0.0225	1/4		1"		12	—	018574	—
	73		0.0240	5/16		1.1/8		12	—	018573	—
	72		0.0250	5/16		1.1/8		12	—	018572	—
	71		0.0260	3/8		1.1/4		12	—	018571	—
	70		0.0280	3/8		1.1/4		12	—	018570	—
	69		0.0292	1/2		1.3/8		12	—	018569	—
	68		0.0310	1/2		1.3/8		12	—	018568	—
1/32			0.0313	1/2		1.3/8		12	010502	—	—
	67		0.0320	1/2		1.3/8		12	—	018567	—
	66		0.0330	1/2		1.3/8		12	—	018566	—
	65		0.0350	5/8		1.1/2		12	—	018565	—
	64		0.0360	5/8		1.1/2		12	—	018564	—
	63		0.0370	5/8		1.1/2		12	—	018563	—
	62		0.0380	5/8		1.1/2		12	—	018562	—
	61		0.0390	11/16		1.5/8		12	—	018561	—
		1.00	0.0394		12		34	10	—	—	0007549
	60		0.0400	11/16		1.5/8		12	—	018560	—
	59		0.0410	11/16		1.5/8		12	—	018559	—
	58		0.0420	11/16		1.5/8		12	—	018558	—
	57		0.0430	3/4		1.3/4		12	—	018557	—
		1.10	0.0433		14		36	10	—	—	0007556
	56		0.0465	3/4		1.3/4		12	—	018556	—
3/64			0.0469	3/4		1.3/4		12	010503	—	—
		1.20	0.0472		16		38	10	—	—	0007563
		1.30	0.0512		16		38	10	—	—	0007570
	55		0.0520	7/8		1.7/8		12	—	018555	—
	54		0.0550	7/8		1.7/8		12	—	018554	—

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10H	R18H	A108
		1.40	0.0551		18		40	10	—	—	0007587
		1.50	0.0591		18		40	10	—	—	0007594
	53		0.0595	7/8		1.7/8		12	—	018553	—
1/16			0.0625	7/8		1.7/8		12	010504	—	—
1/16			0.0625		20		43	10	—	—	0007723
		1.60	0.0630		20		43	10	—	—	0007600
	52		0.0635	7/8		1.7/8		12	—	018552	—
		1.70	0.0669		20		43	10	—	—	0007617
	51		0.0670	1"		2"		12	—	018551	—
	50		0.0700	1"		2"		12	—	018550	—
		1.80	0.0709		22		46	10	—	—	0007624
	49		0.0730	1"		2"		12	—	018549	—
		1.90	0.0748		22		46	10	—	—	0007631
	48		0.0760	1"		2"		12	—	018548	—
5/64			0.0781	1"		2"		12	010505	—	—
5/64			0.0781		24		49	10	—	—	0008478
	47		0.0785	1"		2"		12	—	018547	—
		2.00	0.0787		24		49	10	—	—	0007969
	46		0.0810	1.1/8		2.1/8		12	—	018546	—
	45		0.0820	1.1/8		2.1/8		12	—	018545	—
		2.10	0.0827		24		49	10	—	—	0007976
	44		0.0860	1.1/8		2.1/8		12	—	018544	—
		2.20	0.0866		27		53	10	—	—	0007983
	43		0.0890	1.1/4		2.1/4		12	—	018543	—
		2.30	0.0906		27		53	10	—	—	0007990
	42		0.0935	1.1/4		2.1/4		12	—	018542	—
3/32			0.0938	1.1/4		2.1/4		12	010506	—	—
3/32			0.0938		30		57	10	—	—	0008232
		2.40	0.0945		30		57	10	—	—	0008003
	41		0.0960	1.3/8		2.3/8		12	—	018541	—
	40		0.0980	1.3/8		2.3/8		12	—	018540	—
		2.50	0.0984		30		57	10	—	—	0008010
	39		0.0995	1.3/8		2.3/8		12	—	018539	—
	38		0.1015	1.7/16		2.1/2		12	—	018538	—
		2.60	0.1024		30		57	10	—	—	0008027
	37		0.1040	1.7/16		2.1/2		12	—	018537	—
		2.70	0.1063		33		61	10	—	—	0008034
	36		0.1065	1.7/16		2.1/2		12	—	018536	—
7/64			0.1094	1.1/2		2.5/8		12	010507	—	—
7/64			0.1094		33		61	10	—	—	0008706
	35		0.1100	1.1/2		2.5/8		12	—	018535	—
		2.80	0.1102		33		61	10	—	—	0008041
	34		0.1110	1.1/2		2.5/8		12	—	018534	—
	33		0.1130	1.1/2		2.5/8		12	—	018533	—
		2.90	0.1142		33		61	10	—	—	0008058
	32		0.1160	1.5/8		2.3/4		12	—	018532	—
		3.00	0.1181		33		61	10	—	—	0008119
	31		0.1200	1.5/8		2.3/4		12	—	018531	—
		3.10	0.1220		36		65	10	—	—	0008126
1/8			0.1250	1.5/8		2.3/4		12	010508	—	—
1/8			0.1250		36		65	10	—	—	0007945
		3.20	0.1260		36		65	10	—	—	0008133
	30		0.1285	1.5/8		2.3/4		12	—	018530	—
		3.30	0.1299		36		65	10	—	—	0008140
		3.40	0.1339		39		70	10	—	—	0008157
	29		0.1360	1.3/4		2.7/8		12	—	018529	—
		3.50	0.1378		39		70	10	—	—	0008164
	28		0.1405	1.3/4		2.7/8		12	—	018528	—
9/64			0.1406	1.3/4		2.7/8		12	010509	—	—
9/64			0.1406		39		70	10	—	—	0008928
		3.60	0.1417		39		70	10	—	—	0008171
	27		0.1440	1.7/8		3"		12	—	018527	—
		3.70	0.1457		39		70	10	—	—	0008188
	26		0.1470	1.7/8		3"		12	—	018526	—
	25		0.1495	1.7/8		3"		12	—	018525	—
		3.80	0.1496		43		75	10	—	—	0008195

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10H	R18H	A108
	24		0.1520	2"		3.1/8		12	—	018524	—
		3.90	0.1535		43		75	10	—	—	0008201
	23		0.1540	2"		3.1/8		12	—	018523	—
5/32			0.1563	2"		3.1/8		12	010510	—	—
5/32			0.1563		43		75	10	—	—	0008461
	22		0.1570	2"		3.1/8		12	—	018522	—
		4.00	0.1575		43		75	10	—	—	0008256
	21		0.1590	2.1/8		3.1/4		12	—	018521	—
	20		0.1610	2.1/8		3.1/4		12	—	018520	—
		4.10	0.1614		43		75	10	—	—	0008263
		4.20	0.1654		43		75	10	—	—	0008270
	19		0.1660	2.1/8		3.1/4		12	—	018519	—
		4.30	0.1693		47		80	10	—	—	0008287
	18		0.1695	2.1/8		3.1/4		12	—	018518	—
11/64			0.1719	2.1/8		3.1/4		12	010511	—	—
11/64			0.1719		47		80	10	—	—	0007730
	17		0.1730	2.3/16		3.3/8		12	—	018517	—
		4.40	0.1732		47		80	10	—	—	0008294
	16		0.1770	2.3/16		3.3/8		12	—	018516	—
		4.50	0.1772		47		80	10	—	—	0008300
	15		0.1800	2.3/16		3.3/8		12	—	018515	—
		4.60	0.1811		47		80	10	—	—	0008317
	14		0.1820	2.3/16		3.3/8		12	—	018514	—
	13		0.1850	2.5/16		3.1/2		12	—	018513	—
		4.70	0.1850		47		80	10	—	—	0008324
3/16			0.1875	2.5/16		3.1/2		12	010512	—	—
3/16			0.1875		52		86	10	—	—	0008218
	12		0.1890	2.5/16		3.1/2		12	—	018512	—
		4.80	0.1890		52		86	10	—	—	0008331
	11		0.1910	2.5/16		3.1/2		12	—	018511	—
		4.90	0.1929		52		86	10	—	—	0008348
	10		0.1935	2.7/16		3.5/8		12	—	018510	—
	10		0.1935		52		86	10	—	—	46305901
	9		0.1960	2.7/16		3.5/8		12	—	018509	—
		5.00	0.1969		52		86	10	—	—	0008355
	8		0.1990	2.7/16		3.5/8		12	—	018508	—
		5.10	0.2008		52		86	10	—	—	0008362
	7		0.2010	2.7/16		3.5/8		12	—	018507	—
13/64			0.2031	2.7/16		3.5/8		12	010513	—	—
13/64			0.2031		52		86	10	—	—	0007839
	6		0.2040	2.1/2		3.3/4		12	—	018506	—
		5.20	0.2047		52		86	10	—	—	0008379
	5		0.2055	2.1/2		3.3/4		12	—	018505	—
		5.30	0.2087		52		86	10	—	—	0008386
	4		0.2090	2.1/2		3.3/4		12	—	018504	—
		5.40	0.2126		57		93	10	—	—	0008393
	3		0.2130	2.1/2		3.3/4		12	—	018503	—
		5.50	0.2165		57		93	10	—	—	0008409
7/32			0.2188	2.1/2		3.3/4		12	010514	—	—
7/32			0.2188					10	—	—	0008690
		5.60	0.2205		57		93	10	—	—	0008416
	2		0.2210	2.5/8		3.7/8		12	—	018502	—
		5.70	0.2244		57		93	10	—	—	0008423
	1		0.2280	2.5/8		3.7/8		12	—	018501	—
		5.80	0.2283		57		93	10	—	—	0008430
		5.90	0.2323		57		93	10	—	—	0008447
15/64			0.2344	2.5/8		3.7/8		12	010515	—	—
15/64			0.2344		57		93	10	—	—	46305902
		6.00	0.2362		57		93	10	—	—	0008485
		6.10	0.2402		63		101	10	—	—	0008492
		6.20	0.2441		63		101	10	—	—	0008508
		6.30	0.2480		63		101	10	—	—	0008515
1/4			0.2500	2.3/4		4"		12	010516	—	—
1/4			0.2500		63		101	10	—	—	0007846
		6.40	0.2520		63		101	10	—	—	0008522

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10H	R18H	A108
		6.50	0.2559		63		101	10	—	—	0008539
		6.60	0.2598		63		101	10	—	—	0008546
		6.70	0.2638		63		101	10	—	—	0008553
17/64			0.2656	2.7/8		4.1/8		12	010517	—	—
17/64			0.2656		69		109	10	—	—	46305903
		6.80	0.2677		69		109	10	—	—	0008560
		6.90	0.2717		69		109	10	—	—	0008577
		7.00	0.2756		69		109	10	—	—	0008584
		7.10	0.2795		69		109	10	—	—	0008591
9/32			0.2813	2.15/16		4.1/4		12	010518	—	—
9/32			0.2813		69		109	10	—	—	0008911
		7.20	0.2835		69		109	10	—	—	0008607
		7.30	0.2874		69		109	10	—	—	0008614
		7.40	0.2913		69		109	10	—	—	0008621
		7.50	0.2953		69		109	10	—	—	0008638
19/64			0.2969	3.1/16		4.3/8		12	010519	—	—
19/64			0.2969		75		117	10	—	—	46305904
		7.60	0.2992		75		117	10	—	—	0008645
		7.70	0.3031		75		117	10	—	—	0008652
		7.80	0.3071		75		117	10	—	—	0008669
		7.90	0.3110		75		117	10	—	—	0008676
5/16			0.3125	3.3/16		4.1/2		6	010520	—	—
5/16			0.3125		75		117	10	—	—	0008454
		8.00	0.3150		75		117	10	—	—	0008713
		8.10	0.3189		75		117	10	—	—	0008720
		8.20	0.3228		75		117	10	—	—	0008737
		8.30	0.3268		75		117	10	—	—	0008744
21/64			0.3281	3.5/16		4.5/8		6	010521	—	—
21/64			0.3281		75		117	10	—	—	46305905
		8.40	0.3307		75		117	10	—	—	0008751
		8.50	0.3346		75		117	10	—	—	0008768
		8.60	0.3386		81		125	10	—	—	0008775
		8.70	0.3425		81		125	10	—	—	0008782
11/32			0.3437	3.7/16		4.3/4		6	010522	—	—
11/32			0.3437		81		125	10	—	—	0007716
		8.80	0.3465		81		125	10	—	—	0008799
		8.90	0.3504		81		125	10	—	—	0008805
		9.00	0.3543		81		125	10	—	—	0008812
		9.10	0.3583		81		125	10	—	—	0008829
23/64			0.3594	3.1/2		4.7/8		6	010523	—	—
23/64			0.3594		81		125	10	—	—	46305906
		9.20	0.3622		81		125	10	—	—	0008836
		9.30	0.3661		81		125	10	—	—	0008843
		9.40	0.3701		81		125	10	—	—	0008850
		9.50	0.3740		81		125	10	—	—	0008867
3/8			0.3750	3.5/8		5"		6	010524	—	—
3/8			0.3750		87		133	10	—	—	0008249
		9.60	0.3780		87		133	10	—	—	0008874
		9.70	0.3819		87		133	10	—	—	0008881
		9.80	0.3858		87		133	10	—	—	0008898
		9.90	0.3898		87		133	10	—	—	0008904
25/64			0.3906	3.3/4		5.1/8		6	010525	—	—
25/64			0.3906		87		133	10	—	—	46305907
		10.00	0.3937		87		133	10	—	—	0007648
		10.20	0.4016		87		133	5	—	—	0007655
13/32			0.4063	3.7/8		5.1/4		6	010526	—	—
13/32			0.4063		87		133	5	—	—	0007822
		10.50	0.4134		87		133	5	—	—	0007662
27/64			0.4219	3.15/16		5.3/8		6	010527	—	—
27/64			0.4219		94		142	5	—	—	46305908
		10.80	0.4252		94		142	5	—	—	0007679
		11.00	0.4331		94		142	5	—	—	0007686
7/16			0.4375	4.1/16		5.1/2		6	010528	—	—
7/16			0.4375		94		142	5	—	—	0008683
		11.50	0.4528		94		142	5	—	—	0007693



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10H	R18H	A108
29/64			0.4531	4.3/16		5.5/8		6	010529	—	—
29/64			0.4531		94		142	5	—	—	46305909
		11.80	0.4646		94		142	5	—	—	0007709
15/32			0.4687	4.5/16		5.3/4		6	010530	—	—
15/32			0.4687		101		151	5	—	—	0007907
		12.00	0.4724		101		151	5	—	—	0007754
31/64			0.4844	4.3/8		5.7/8		6	010531	—	—
31/64			0.4844		101		151	5	—	—	46305920
		12.50	0.4921		101		151	5	—	—	0007778
1/2			0.5000	4.1/2		6		5	0010532	—	—
1/2			0.5000		101		151	5	—	—	0007747
		12.80	0.5039		101		151	5	—	—	0007785
		12.90	0.5079		101		151	5	—	—	0007792
		13.00	0.5118		101		151	5	—	—	0007808
		13.50	0.5315		108		160	5	—	—	0007815
		14.00	0.5512		108		160	5	—	—	0007853
		14.50	0.5709		114		169	1	—	—	0007860
		15.00	0.5906		114		169	1	—	—	0007877
		15.25	0.6004		120		178	1	—	—	0007884
		15.50	0.6102		120		178	1	—	—	0007891
		16.00	0.6299		120		178	1	—	—	0007921

# JOBBER DRILL

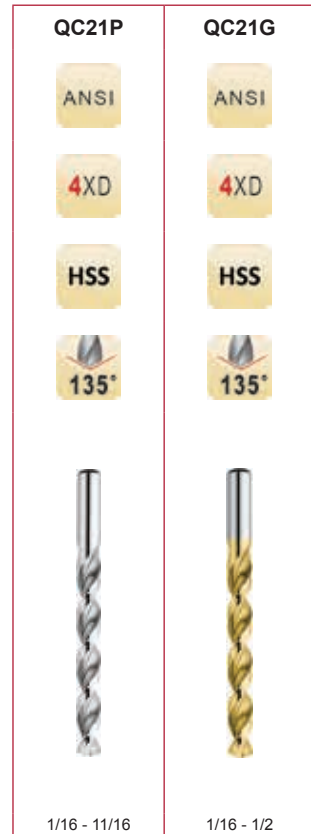
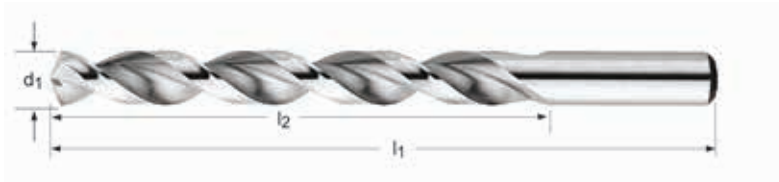


## General Purpose Jobber Length Parabolic Flute

Heavy-Duty Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration.

**QC21P** Bright Finish improves chip flow in soft or non-ferrous materials.

**QC21G** TiN Coating increases wear resistance and improves tool life.



$d_1$ Ø "/Nr./letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	QC21P	QC21G
1/16	0.0625	7/8	1.7/8	12	015804	081704
52	0.0635	7/8	1.7/8	12	019452	080552
51	0.0670	1"	2"	12	019451	080551
50	0.0700	1"	2"	12	019450	080550
49	0.0730	1"	2"	12	019449	080549
48	0.0760	1"	2"	12	019448	080548
5/64	0.0781	1"	2"	12	015805	081705
47	0.0785	1"	2"	12	019447	080547
46	0.0810	1.1/8	2.1/8	12	019446	080546
45	0.0820	1.1/8	2.1/8	12	019445	080545
44	0.0860	1.1/8	2.1/8	12	019444	080544
43	0.0890	1.1/4	2.1/4	12	019443	080543
42	0.0935	1.1/4	2.1/4	12	019442	080542
3/32	0.0938	1.1/4	2.1/4	12	015806	081706
41	0.0960	1.3/8	2.3/8	12	019441	080541
40	0.0980	1.3/8	2.3/8	12	019440	080540
39	0.0995	1.3/8	2.3/8	12	019439	080539
38	0.1015	1.7/16	2.1/2	12	019438	080538
37	0.1040	1.7/16	2.1/2	12	019437	080537
36	0.1065	1.7/16	2.1/2	12	019436	080536
7/64	0.1094	1.1/2	2.5/8	12	015807	081707
35	0.1100	1.1/2	2.5/8	12	019435	080535
34	0.1110	1.1/2	2.5/8	12	019434	080534
33	0.1130	1.1/2	2.5/8	12	019433	080533
32	0.1160	1.5/8	2.3/4	12	019432	080532
31	0.1200	1.5/8	2.3/4	12	019431	080531
1/8	0.1250	1.5/8	2.3/4	12	015808	081708
30	0.1285	1.5/8	2.3/4	12	019430	080530
29	0.1360	1.3/4	2.7/8	12	019429	080529
28	0.1405	1.3/4	2.7/8	12	019428	080528
9/64	0.1406	1.3/4	2.7/8	12	015809	081709
27	0.1440	1.7/8	3"	12	019427	080527
26	0.1470	1.7/8	3"	12	019426	080526



# JOBBER DRILL

d <sub>1</sub> Ø "Nr./letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	QC21P	QC21G
25	0.1495	1.7/8	3"	12	019425	080525
24	0.1520	2"	3.1/8	12	019424	080524
23	0.1540	2"	3.1/8	12	019423	080523
5/32	0.1563	2"	3.1/8	12	015810	081710
22	0.1570	2"	3.1/8	12	019422	080522
21	0.1590	2.1/8	3.1/4	12	019421	080521
20	0.1610	2.1/8	3.1/4	12	019420	080520
19	0.1660	2.1/8	3.1/4	12	019419	080519
18	0.1695	2.1/8	3.1/4	12	019418	080518
11/64	0.1719	2.1/8	3.1/4	12	015811	081711
17	0.1730	2.3/16	3.3/8	12	019417	080517
16	0.1770	2.3/16	3.3/8	12	019416	080516
15	0.1800	2.3/16	3.3/8	12	019415	080515
14	0.1820	2.3/16	3.3/8	12	019414	080514
13	0.1850	2.5/16	3.1/2	12	019413	080513
3/16	0.1875	2.5/16	3.1/2	12	015812	081712
12	0.1890	2.5/16	3.1/2	12	019412	080512
11	0.1910	2.5/16	3.1/2	12	019411	080511
10	0.1935	2.7/16	3.5/8	12	019410	080510
9	0.1960	2.7/16	3.5/8	12	019409	080509
8	0.1990	2.7/16	3.5/8	12	019408	080508
7	0.2010	2.7/16	3.5/8	12	019407	080507
13/64	0.2031	2.7/16	3.5/8	12	015813	081713
6	0.2040	2.1/2	3.3/4	12	019406	080506
5	0.2055	2.1/2	3.3/4	12	019405	080505
4	0.2090	2.1/2	3.3/4	12	019404	080504
3	0.2130	2.1/2	3.3/4	12	019403	080503
7/32	0.2188	2.1/2	3.3/4	12	015814	081714
2	0.2210	2.5/8	3.7/8	12	019402	080502
1	0.2280	2.5/8	3.7/8	12	019401	080501
A	0.2340	2.5/8	3.7/8	12	019301	—
15/64	0.2344	2.5/8	3.7/8	12	015815	081715
B	0.2374	2.3/4	4"	12	019302	—
C	0.2421	2.3/4	4"	12	019303	—
D	0.2461	2.3/4	4"	12	019304	—
1/4	0.2500	2.3/4	4"	12	015816	081716
F	0.2571	2.7/8	4.1/8	12	019306	—
G	0.2610	2.7/8	4.1/8	12	019307	—
17/64	0.2656	2.7/8	4.1/8	12	015817	081717
H	0.2661	2.7/8	4.1/8	12	019308	—
I	0.2720	2.7/8	4.1/8	12	019309	—
J	0.2772	2.7/8	4.1/8	12	019310	—
K	0.2811	2.15/16	4.1/4	12	019311	—
9/32	0.2813	2.15/16	4.1/4	12	015818	081718
L	0.2902	2.15/16	4.1/4	12	019312	—
M	0.2949	3.1/16	4.3/8	12	019313	—
19/64	0.2969	3.1/16	4.3/8	12	015819	081719
N	0.3020	3.1/16	4.3/8	12	019314	—
5/16	0.3125	3.3/16	4.1/2	6	015820	081720
O	0.3161	3.3/16	4.1/2	6	019315	—
P	0.3228	3.5/16	4.5/8	6	019316	—
21/64	0.3281	3.5/16	4.5/8	6	015821	081721
Q	0.3319	3.7/16	4.3/4	6	019317	—
R	0.3390	3.7/16	4.3/4	6	019318	—
11/32	0.3437	3.7/16	4.3/4	6	015822	081722
S	0.3480	3.1/2	4.7/8	6	019319	—
T	0.3580	3.1/2	4.7/8	6	019320	—
23/64	0.3594	3.1/2	4.7/8	6	015823	081723
U	0.3680	3.5/8	5"	6	019321	—
3/8	0.3750	3.5/8	5"	6	015824	081724
V	0.3772	3.5/8	5"	6	019322	—
W	0.3858	3.3/4	5.1/8	6	019323	—
25/64	0.3906	3.3/4	5.1/8	6	015825	081725
X	0.3969	3.3/4	5.1/8	6	019324	—
Y	0.4039	3.7/8	5.1/4	6	019325	—
13/32	0.4063	3.7/8	5.1/4	6	015826	081726

# JOBBER DRILL



$d_1$ Ø "/Nr./letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	QC21P	QC21G
Z	0.4130	3.7/8	5.1/4	6	019326	—
27/64	0.4219	3.15/16	5.3/8	6	015827	081727
7/16	0.4375	4.1/16	5.1/2	6	015828	081728
29/64	0.4531	4.3/16	5.5/8	6	015829	081729
15/32	0.4687	4.5/16	5.3/4	6	015830	081730
31/64	0.4844	4.3/8	5.7/8	6	015831	081731
1/2	0.5000	4.1/2	6"	6	015832	081732
33/64	0.5156	4.13/16	6.5/8	1	015833	—
17/32	0.5313	4.13/16	6.5/8	1	015834	—
35/64	0.5469	4.13/16	6.5/8	1	015835	—
9/16	0.5625	4.13/16	6.5/8	1	015836	—
37/64	0.5781	4.13/16	6.5/8	1	015837	—
19/32	0.5937	5.3/16	7.1/8	1	015838	—
39/64	0.6094	5.3/16	7.1/8	1	015839	—
5/8	0.6250	5.3/16	7.1/8	1	015840	—
41/64	0.6406	5.3/16	7.1/8	1	015841	—
21/32	0.6563	5.3/16	7.1/8	1	015842	—
43/64	0.6719	5.5/8	7.5/8	1	015843	—
11/16	0.6875	5.5/8	7.5/8	1	015844	—



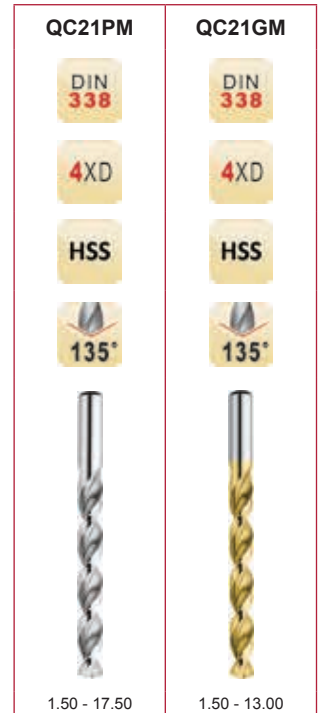
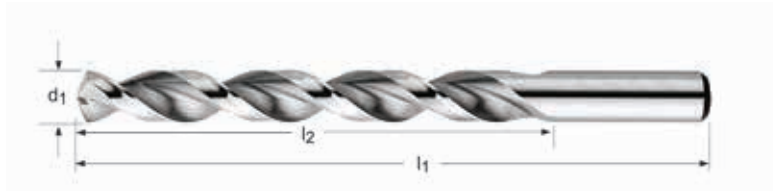
# JOBBER DRILL

## General Purpose Jobber Length Parabolic Flute, Metric

Heavy-Duty Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration.

**QC21PM** Bright Finish improves chip flow in soft or non-ferrous materials.

**QC21GM** TiN Coating increases wear resistance and improves tool life.



$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	QC21PM	QC21GM
1.50	0.0591	18	40	12	013115	019815
2.00	0.0787	24	49	12	013120	019820
2.50	0.0984	30	57	12	013125	019825
3.00	0.1181	33	61	12	013130	019830
3.50	0.1378	39	70	12	013135	—
4.00	0.1575	43	75	12	013140	019840
4.50	0.1772	47	80	12	013145	—
5.00	0.1969	52	86	12	013150	019850
5.20	0.2047	52	86	12	013152	019852
5.50	0.2165	57	93	12	013155	019855
5.60	0.2205	57	93	12	013156	019856
6.00	0.2362	57	93	12	013160	019860
6.50	0.2559	63	101	12	013165	019865
6.80	0.2677	69	109	12	013168	019868
7.00	0.2756	69	109	12	013170	019870
7.50	0.2953	69	109	12	013175	019875
8.00	0.3150	75	117	6	013180	019880
8.20	0.3228	75	117	6	013182	019882
8.50	0.3346	75	117	6	013185	019885
8.60	0.3386	81	125	6	013186	019886
9.00	0.3543	81	125	6	013190	019890
9.50	0.3740	81	125	6	013195	019895
10.00	0.3937	87	133	6	014900	019900
10.50	0.4134	87	133	6	014905	019905
11.00	0.4331	94	142	6	014910	019910
11.50	0.4528	94	142	6	014915	—
12.00	0.4724	101	151	6	014920	019920
12.50	0.4921	101	151	6	014925	019925
13.00	0.5118	101	151	1	014930	019930
13.50	0.5315	108	160	1	014935	—
14.00	0.5512	108	160	1	014940	—
14.50	0.5709	114	169	1	014945	—
15.00	0.5906	114	169	1	014950	—
15.50	0.6102	120	178	1	014955	—
16.00	0.6299	120	178	1	014960	—
16.50	0.6496	125	184	1	014965	—
17.00	0.6693	125	184	1	014970	—
17.50	0.6890	130	191	1	014975	—

# COBALT JOBBER DRILL



## Heavy Duty Jobber Length (NAS 907 Type J)

**R10CO** - Fractional Sizes

**R18CO** - Wire Gauge Sizes

**R15CO** - Letter Sizes

**2ACO** - Metric Sizes

Low thrust design self centering Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance & lubricity. For enhanced tool life in ferrous materials



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10CO	R18CO	R15CO	2ACO
	80			0.0135	1/8		3/4		12	—	<sup>1)</sup>	018380	—
	79			0.0145	1/8		3/4		12	—	<sup>1)</sup>	018379	—
1/64				0.0156	3/16		3/4		12	010301	<sup>1)</sup>	—	—
	78			0.0160	3/16		7/8		12	—	<sup>1)</sup>	018378	—
	77			0.0180	3/16		7/8		12	—	<sup>1)</sup>	018377	—
	76			0.0200	3/16		7/8		12	—	<sup>1)</sup>	018376	—
	75			0.0210	1/4		1"		12	—	<sup>1)</sup>	018375	—
	74			0.0225	1/4		1"		12	—	<sup>1)</sup>	018374	—
	73			0.0240	5/16		1.1/8		12	—	<sup>1)</sup>	018373	—
	72			0.0250	5/16		1.1/8		12	—	<sup>1)</sup>	018372	—
	71			0.0260	3/8		1.1/4		12	—	<sup>1)</sup>	018371	—
	70			0.0280	3/8		1.1/4		12	—	<sup>1)</sup>	018370	—
	69			0.0292	1/2		1.3/8		12	—	<sup>1)</sup>	018369	—
	68			0.0310	1/2		1.3/8		12	—	<sup>1)</sup>	018368	—
1/32				0.0313	1/2		1.3/8		12	010302	<sup>1)</sup>	—	—
	67			0.0320	1/2		1.3/8		12	—	<sup>1)</sup>	018367	—
	66			0.0330	1/2		1.3/8		12	—	<sup>1)</sup>	018366	—
	65			0.0350	5/8		1.1/2		12	—	<sup>1)</sup>	018365	—
	64			0.0360	5/8		1.1/2		12	—	<sup>1)</sup>	018364	—
	63			0.0370	5/8		1.1/2		12	—	<sup>1)</sup>	018363	—
	62			0.0380	5/8		1.1/2		12	—	<sup>1)</sup>	018362	—
	61			0.0390	11/16		1.5/8		12	—	<sup>1)</sup>	018361	—
		1.00		0.0394		12		34	12	—	—	—	016410
	60			0.0400	11/16		1.5/8		12	—	—	018360	—
	59			0.0410	11/16		1.5/8		12	—	—	018359	—
		1.05		0.0413		12		34	12	—	—	—	016355
	58			0.0420	11/16		1.5/8		12	—	—	018358	—
	57			0.0430	3/4		1.3/4		12	—	—	018357	—
		1.10		0.0433		14		36	12	—	—	—	016411
		1.15		0.0453		14		36	12	—	—	—	016356
	56			0.0465	3/4		1.3/4		12	—	—	018356	—
3/64				0.0469	3/4		1.3/4		12	010303	—	—	—

<sup>1)</sup> No Split Point



# COBALT JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10CO	R18CO	R15CO	2ACO
			1.20	0.0472		16		38	12	—	—	—	016412
			1.25	0.0492		16		38	12	—	—	—	016357
			1.30	0.0512		16		38	12	—	—	—	016413
	55		0.0520		7/8		1.7/8		12	—	018355	—	—
			1.35	0.0531		18		40	12	—	—	—	016358
			1.40	0.0551		18		40	12	—	—	—	016414
	54		0.0550		7/8		1.7/8		12	—	018354	—	—
			1.45	0.0571		18		40	12	—	—	—	016359
			1.50	0.0591		18		40	12	—	—	—	016415
	53		0.0595		7/8		1.7/8		12	—	018353	—	—
			1.55	0.0610		20		43	12	—	—	—	016360
1/16			0.0625		7/8		1.7/8		12	010304	—	—	—
			1.60	0.0630		20		43	12	—	—	—	016416
	52		0.0635		7/8		1.7/8		12	—	018352	—	—
			1.65	0.0650		20		43	12	—	—	—	016361
			1.70	0.0669		20		43	12	—	—	—	016417
	51		0.0670		1"		2"		12	—	018351	—	—
			1.75	0.0689		22		46	12	—	—	—	016362
	50		0.0700		1"		2"		12	—	018350	—	—
			1.80	0.0709		22		46	12	—	—	—	016418
			1.85	0.0728		22		46	12	—	—	—	016363
	49		0.0730		1"		2"		12	—	018349	—	—
			1.90	0.0748		22		46	12	—	—	—	016419
	48		0.0760		1"		2"		12	—	018348	—	—
			1.95	0.0768		24		49	12	—	—	—	016364
5/64			0.0781		1"		2"		12	010305	—	—	—
	47		0.0785		1"		2"		12	—	018347	—	—
			2.00	0.0787		24		49	12	—	—	—	016420
			2.05	0.0807		24		49	12	—	—	—	016365
	46		0.0810		1.1/8		2.1/8		12	—	018346	—	—
	45		0.0820		1.1/8		2.1/8		12	—	018345	—	—
			2.10	0.0827		24		49	12	—	—	—	016421
	44		0.0860		1.1/8		2.1/8		12	—	018344	—	—
			2.20	0.0866		27		53	12	—	—	—	016422
	43		0.0890		1.1/4		2.1/4		12	—	018343	—	—
			2.30	0.0906		27		53	12	—	—	—	016423
			2.35	0.0925		27		53	12	—	—	—	016368
	42		0.0935		1.1/4		2.1/4		12	—	018342	—	—
3/32			0.0938		1.1/4		2.1/4		12	010306	—	—	—
			2.40	0.0945		30		57	12	—	—	—	016424
	41		0.0960		1.3/8		2.3/8		12	—	018341	—	—
	40		0.0980		1.3/8		2.3/8		12	—	018340	—	—
			2.50	0.0984		30		57	12	—	—	—	016425
	39		0.0995		1.3/8		2.3/8		12	—	018339	—	—
	38		0.1015		1.7/16		2.1/2		12	—	018338	—	—
			2.60	0.1024		30		57	12	—	—	—	016426
	37		0.1040		1.7/16		2.1/2		12	—	018337	—	—
			2.70	0.1063		33		61	12	—	—	—	016427
	36		0.1065		1.7/16		2.1/2		12	—	018336	—	—
7/64			0.1094		1.1/2		2.5/8		12	010307	—	—	—
	35		0.1100		1.1/2		2.5/8		12	—	018335	—	—
			2.80	0.1102		33		61	12	—	—	—	016428
	34		0.1110		1.1/2		2.5/8		12	—	018334	—	—
	33		0.1130		1.1/2		2.5/8		12	—	018333	—	—
			2.90	0.1142		33		61	12	—	—	—	016429
	32		0.1160		1.5/8		2.3/4		12	—	018332	—	—
			3.00	0.1181		33		61	12	—	—	—	016430
	31		0.1200		1.5/8		2.3/4		12	—	018331	—	—
			3.10	0.1220		36		65	12	—	—	—	016431
1/8			0.1250		1.5/8		2.3/4		12	010308	—	—	—
			3.20	0.1260		36		65	12	—	—	—	016432
			3.25	0.1280		36		65	12	—	—	—	016371
	30		0.1285		1.5/8		2.3/4		12	—	018330	—	—
			3.30	0.1299		36		65	12	—	—	—	016433
			3.40	0.1339		39		70	12	—	—	—	016434
	29		0.1360		1.3/4		2.7/8		12	—	018329	—	—

# COBALT JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10CO	R18CO	R15CO	2ACO
			3.50	0.1378		39		70	12	—	—	—	016435
9/64	28			0.1405	1.3/4		2.7/8		12	—	018328	—	—
				0.1406	1.3/4		2.7/8		12	010309	—	—	—
				0.1417		39		70	12	—	—	—	016436
	27			0.1440	1.7/8		3"		12	—	018327	—	—
			3.60	0.1457		39		70	12	—	—	—	016437
	26			0.1470	1.7/8		3"		12	—	018326	—	—
				0.1476		39		70	12	—	—	—	016372
			3.75	0.1496		43		75	12	—	—	—	016438
	25			0.1495	1.7/8		3"		12	—	018325	—	—
	24			0.1520	2"		3.1/8		12	—	018324	—	—
	23			0.1540	2"		3.1/8		12	—	018323	—	—
5/32	22			0.1563	2"		3.1/8		12	010310	—	—	—
				0.1570	2"		3.1/8		12	—	018322	—	—
				0.1575		43		75	12	—	—	—	016440
	21			0.1590	2.1/8		3.1/4		12	—	018321	—	—
	20			0.1610	2.1/8		3.1/4		12	—	018320	—	—
			4.10	0.1614		43		75	12	—	—	—	016441
			4.20	0.1654		43		75	12	—	—	—	016442
	19			0.1660	2.1/8		3.1/4		12	—	018319	—	—
				0.1673		43		75	12	—	—	—	016373
				0.1693		47		80	12	—	—	—	016443
	18			0.1695	2.1/8		3.1/4		12	—	018318	—	—
11/64	17			0.1719	2.1/8		3.1/4		12	010311	—	—	—
				0.1730	2.3/16		3.3/8		12	—	018317	—	—
				0.1732		47		80	12	—	—	—	016444
			4.40	0.1772		47		80	12	—	—	—	016445
	16			0.1770	2.3/16		3.3/8		12	—	018316	—	—
	15			0.1800	2.3/16		3.3/8		12	—	018315	—	—
	14			0.1820	2.3/16		3.3/8		12	—	018314	—	—
			4.70	0.1850		47		80	12	—	—	—	016447
	13			0.1850	2.5/16		3.1/2		12	—	018313	—	—
3/16	10			0.1875	2.5/16		3.1/2		12	010312	—	—	—
				0.1890		52		86	12	—	—	—	016448
				0.1890	2.5/16		3.1/2		12	—	018312	—	—
	11			0.1910	2.5/16		3.1/2		12	—	018311	—	—
	10			0.1935	2.7/16		3.5/8		12	—	018310	—	—
	9			0.1960	2.7/16		3.5/8		12	—	018309	—	—
			5.00	0.1969		52		86	12	—	—	—	016450
	8			0.1990	2.7/16		3.5/8		12	—	018308	—	—
			5.10	0.2008		52		86	12	—	—	—	016451
	7			0.2010	2.7/16		3.5/8		12	—	018307	—	—
13/64	6			0.2031	2.7/16		3.5/8		12	010313	—	—	—
				0.2040	2.1/2		3.3/4		12	—	018306	—	—
				0.2047		52		86	12	—	—	—	016452
	5			0.2055	2.1/2		3.3/4		12	—	018305	—	—
			5.25	0.2067		52		86	12	—	—	—	016375
			5.30	0.2087		52		86	12	—	—	—	016453
	4			0.2090	2.1/2		3.3/4		12	—	018304	—	—
	3			0.2130	2.1/2		3.3/4		12	—	018303	—	—
			5.50	0.2165		57		93	12	—	—	—	016455
7/32	2			0.2188	2.1/2		3.3/4		12	010314	—	—	—
				0.2205		57		93	12	—	—	—	016456
				0.2210	2.5/8		3.7/8		12	—	018302	—	—
	1			0.2244		57		93	12	—	—	—	016457
				0.2280	2.5/8		3.7/8		12	—	018301	—	—
			5.90	0.2323		57		93	12	—	—	—	016459
15/64	A			0.2340	2.5/8		3.7/8		12	—	—	015301	—
				0.2344	2.5/8		3.7/8		12	010315	—	—	—
				0.2362		57		93	12	—	—	—	016460
	B			0.2374	2.3/4		4"		12	—	—	015302	—
			6.10	0.2402		63		101	12	—	—	—	016461
	C			0.2421	2.3/4		4"		12	—	—	015303	—
			6.20	0.2441		63		101	12	—	—	—	016462
	D			0.2461	2.3/4		4"		12	—	—	015304	—
			6.30	0.2480		63		101	12	—	—	—	016463





# COBALT JOBBER DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10CO	R18CO	R15CO	2ACO	
1/4		E		0.2500	2.3/4		4"		12	—	—	015305	—	
				0.2500	2.3/4		4"		12	010316	—	—	—	
			6.40	0.2520		63		101		12	—	—	—	016464
			6.50	0.2559		63		101		12	—	—	—	016465
		F		0.2571	2.7/8		4.1/8		12	—	—	015306	—	
				0.2598	2.7/8		4.1/8		101		12	—	—	—
			6.60	0.2610		63		101		12	—	—	—	015307
			6.70	0.2638		63		101		12	—	—	—	016467
17/64				0.2656	2.7/8		4.1/8		12	010317	—	—	—	
				0.2661	2.7/8		4.1/8		12	—	—	015308	—	
			6.80	0.2677		69		109		12	—	—	—	016468
			6.90	0.2717		69		109		12	—	—	—	016469
		I		0.2720	2.7/8		4.1/8		12	—	—	015309	—	
				0.2756	2.7/8		4.1/8		109		12	—	—	—
			7.00	0.2772		69		109		12	—	—	—	015310
			7.10	0.2795		69		109		12	—	—	—	016471
9/32		K		0.2811	2.15/16		4.1/4		12	—	—	015311	—	
				0.2813	2.15/16		4.1/4		12	010318	—	—	—	
			7.20	0.2835		69		109		12	—	—	—	016472
			7.25	0.2854		69		109		12	—	—	—	016379
				0.2874	2.15/16		4.1/4		12	—	—	—	016473	
				0.2902	2.15/16		4.1/4		12	—	—	015312	—	
			7.50	0.2949		69		109		12	—	—	015313	—
			7.50	0.2953		69		109		12	—	—	—	016475
19/64				0.2969	3.1/16		4.3/8		12	010319	—	—	—	
				0.3020	3.1/16		4.3/8		12	—	—	015314	—	
			7.80	0.3071		75		117		12	—	—	—	016478
			7.90	0.3110		75		117		12	—	—	—	016479
5/16				0.3125	3.3/16		4.1/2		6	010320	—	—	—	
				0.3150	3.3/16		4.1/2		6	—	—	—	016480	
			8.00	0.3161		75		117		6	—	—	015315	—
			8.20	0.3228		75		117		6	—	—	—	016482
21/64		P		0.3228	3.5/16		4.5/8		6	—	—	015316	—	
				0.3281	3.5/16		4.5/8		6	010321	—	—	—	
			8.40	0.3307		75		117		6	—	—	—	016484
			8.40	0.3319		75		117		6	—	—	—	015317
				0.3346	3.7/16		4.3/4		6	—	—	—	016485	
				0.3390	3.7/16		4.3/4		6	—	—	015318	—	
			8.50	0.3437		75		117		6	010322	—	—	—
			8.80	0.3465		81		125		6	—	—	—	016488
		S		0.3480	3.1/2		4.7/8		6	—	—	015319	—	
				0.3504	3.1/2		4.7/8		125		6	—	—	—
			8.90	0.3543		81		125		6	—	—	—	016490
			9.00	0.3580		81		125		6	—	—	—	015320
23/64				0.3583	3.1/2		4.7/8		6	—	—	015320	—	
				0.3594	3.1/2		4.7/8		6	010323	—	—	—	
			9.20	0.3622		81		125		6	—	—	—	016492
			9.30	0.3661		81		125		6	—	—	—	016493
		U		0.3680	3.5/8		5"		6	—	—	015321	—	
				0.3701	3.5/8		5"		125		6	—	—	—
			9.40	0.3740		81		125		6	—	—	—	016495
			9.50	0.3750		81		125		6	010324	—	—	—
3/8		V		0.3772	3.5/8		5"		6	—	—	015322	—	
				0.3780	3.5/8		5"		133		6	—	—	—
			9.60	0.3780		87		133		6	—	—	—	016497
			9.70	0.3819		87		133		6	—	—	—	016498
				0.3858	3.7/8		5.1/4		6	—	—	—	016498	
				0.3858	3.7/8		5.1/4		133		6	—	—	—
			10.00	0.3906		87		133		6	010325	—	—	—
			10.00	0.3937		87		133		6	—	—	—	016300
		X		0.3969	3.3/4		5.1/8		6	—	—	015324	—	
				0.4016	3.3/4		5.1/8		133		6	—	—	—
			10.20	0.4039		87		133		6	—	—	—	015325
			10.20	0.4063		87		133		6	010326	—	—	—
13/32		Z		0.4130	3.7/8		5.1/4		6	—	—	015326	—	
				0.4130	3.7/8		5.1/4		6	—	—	—	—	
				0.4130	3.7/8		5.1/4		6	—	—	—	016305	
				10.50	0.4134		5.1/4		133		6	—	—	—
27/64				0.4219	3.15/16		5.3/8		6	010327	—	—	—	

# COBALT JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> Inch	l <sub>1</sub> mm	Pack Qty	R10CO	R18CO	R15CO	2ACO
			10.80	0.4252		94		142	6	—	—	—	016308
			11.00	0.4331		94		142	6	—	—	—	016310
7/16			0.4375	4.1/16			5.1/2		6	010328	—	—	—
			11.20	0.4409		94		142	6	—	—	—	016312
			11.50	0.4528		94		142	6	—	—	—	016315
29/64			0.4531	4.3/16			5.5/8		6	010329	—	—	—
			11.80	0.4646		94		142	6	—	—	—	016318
15/32			0.4687	4.5/16			5.3/4		6	010330	—	—	—
			12.00	0.4724		101		151	6	—	—	—	016320
			12.20	0.4803		101		151	6	—	—	—	016322
31/64			0.4844	4.3/8			5.7/8		6	010331	—	—	—
			12.50	0.4921		101		151	6	—	—	—	016325
1/2			0.5000	4.1/2			6"		6	010332	—	—	—
			13.00	0.5118		101		151	1	—	—	—	016330
33/64			0.5156	4.13/16			6.5/8		1	010333	—	—	—
17/32			0.5313	4.13/16			6.5/8		1	010334	—	—	—
35/64			0.5469	4.13/16			6.5/8		1	010335	—	—	—
9/16			0.5625	4.13/16			6.5/8		1	010336	—	—	—
37/64			0.5781	4.13/16			6.5/8		1	010337	—	—	—
19/32			0.5937	5.3/16			7.1/8		1	010338	—	—	—
39/64			0.6094	5.3/16			7.1/8		1	010339	—	—	—
5/8			0.6250	5.3/16			7.1/8		1	010340	—	—	—
41/64			0.6406	5.3/16			7.1/8		1	010341	—	—	—
21/32			0.6563	5.3/16			7.1/8		1	010342	—	—	—
43/64			0.6719	5.5/8			7.5/8		1	010343	—	—	—
11/16			0.6875	5.5/8			7.5/8		1	010344	—	—	—



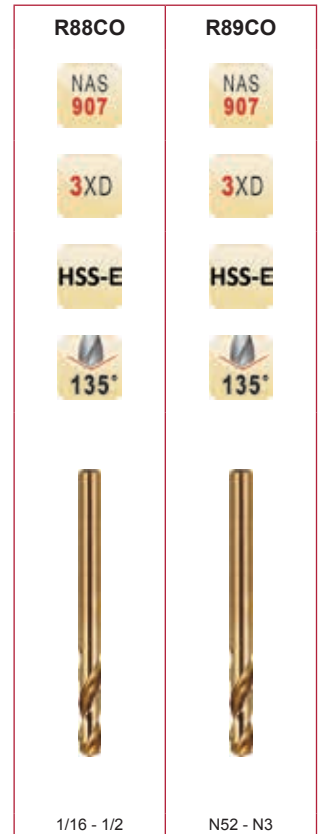
# COBALT JOBBER DRILL

## Heavy Duty Jobber Length (NAS 907 Type D)

**R88CO** - Fractional Sizes

**R89CO** - Wire Gauge Sizes

Low thrust design self centering Split Point for easier penetration. Shorter Flute Lengths. Cobalt base material with Bronze Oxide for wear resistance and lubricity.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R88CO	R89CO
1/16		0.0625	7/16	1.7/8	12	058704	—
	52	0.0635	7/16	1.7/8	12	—	058852
	51	0.0670	1/2	2"	12	—	058851
	50	0.0700	1/2	2"	12	—	058850
	49	0.0730	1/2	2"	12	—	058849
5/64		0.0781	1/2	2"	12	058705	—
	46	0.0810	9/16	2.1/8	12	—	058846
	45	0.0820	9/16	2.1/8	12	—	058845
	44	0.0860	9/16	2.1/8	12	—	058844
	43	0.0890	5/8	2.1/4	12	—	058843
	42	0.0935	5/8	2.1/4	12	—	058842
3/32		0.0938	5/8	2.1/4	12	058706	—
	41	0.0960	5/8	2.3/8	12	—	058841
	40	0.0980	13/16	2.3/8	12	—	058840
	39	0.0995	13/16	2.3/8	12	—	058839
	36	0.1065	13/16	2.1/2	12	—	058836
7/64		0.1094	13/16	2.5/8	12	058707	—
	31	0.1200	7/8	2.3/4	12	—	058831
1/8		0.1250	7/8	2.3/4	12	058708	—
	30	0.1285	15/16	2.3/4	12	—	058830
	29	0.1360	15/16	2.7/8	12	—	058829
9/64		0.1406	15/16	2.7/8	12	058709	—
	27	0.1440	1"	3"	12	—	058827
	26	0.1470	1"	3"	12	—	058826
	25	0.1495	1"	3"	12	—	058825
	24	0.1520	1"	3.1/8	12	—	058824
5/32		0.1563	1"	3.1/8	12	058710	—
	22	0.1570	1.1/16	3.1/8	12	—	058822
	21	0.1590	1.1/16	3.1/4	12	—	058821
	20	0.1610	1.1/16	3.1/4	12	—	058820
11/64		0.1719	1.1/16	3.1/4	12	058711	—
	16	0.1770	1.1/8	3.3/8	12	—	058816
	13	0.1850	1.1/8	3.1/2	12	—	058813

# COBALT JOBBER DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R88CO	R89CO
3/16		0.1875	1.1/8	3.1/2	12	058712	—
	12	0.1890	1.1/8	3.1/2	12	—	058812
	11	0.1910	1.3/16	3.1/2	12	—	058811
	10	0.1935	1.3/16	3.5/8	12	—	058810
	9	0.1960	1.3/16	3.5/8	12	—	058809
	8	0.1990	1.3/16	3.5/8	12	—	058808
	7	0.2010	1.3/16	3.5/8	12	—	058807
13/64		0.2031	1.3/16	3.5/8	12	058713	—
	6	0.2040	1.1/4	3.3/4	12	—	058806
	5	0.2055	1.1/4	3.3/4	12	—	058805
	3	0.2130	1.1/4	3.3/4	12	—	058803
7/32		0.2188	1.1/4	3.3/4	12	058714	—
15/64		0.2344	1.5/16	3.7/8	12	058715	—
1/4		0.2500	1.3/8	4"	12	058716	—
17/64		0.2656	1.7/16	4.1/8	12	058717	—
9/32		0.2813	1.1/2	4.1/4	12	058718	—
19/64		0.2969	1.9/16	4.3/8	12	058719	—
5/16		0.3125	1.5/8	4.1/2	6	058720	—
21/64		0.3281	1.11/16	4.5/8	6	058721	—
11/32		0.3437	1.11/16	4.3/4	6	058722	—
23/64		0.3594	1.3/4	4.7/8	6	058723	—
3/8		0.3750	1.13/16	5"	6	058724	—
25/64		0.3906	1.7/8	5.1/8	6	058725	—
13/32		0.4063	1.15/16	5.1/4	6	058726	—
27/64		0.4219	2"	5.3/8	6	058727	—
7/16		0.4375	2.1/16	5.1/2	6	058728	—
29/64		0.4531	2.1/8	5.5/8	6	058729	—
15/32		0.4687	2.1/8	5.3/4	6	058730	—
31/64		0.4844	2.3/16	5.7/8	6	058731	—
1/2		0.5000	2.1/4	6"	6	058732	—



# SCREW MACHINE DRILL

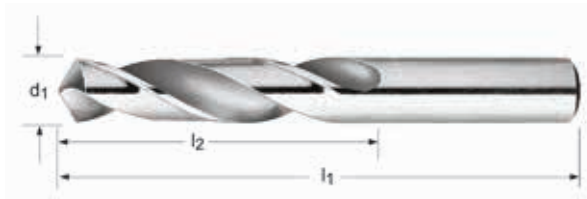
## General Purpose Screw Machine Length

**R40** - Fractional Sizes

**R41** - Wire Gauge Sizes

**R42** - Letter Sizes

Bright Finish improves chip flow in soft or non-ferrous materials

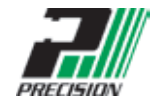


- <sup>1)</sup> Sizes 45/64 and larger are steam oxide
- <sup>2)</sup> 1" reduced shank
- <sup>3)</sup> 1-1/4" reduced shank
- <sup>4)</sup> 1-1/2" reduced shank

R40	R41	R42
ANSI	ANSI	ANSI
2.5XD	2.5XD	2.5XD
HSS	HSS	HSS
118°	118°	118°
3/64 - 2"	N60 - N1	A - Z

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40	R41	R42
	60		0.0400	1/2	1.3/8	12	—	041060	—
	59		0.0410	1/2	1.3/8	12	—	041059	—
	58		0.0420	1/2	1.3/8	12	—	041058	—
	57		0.0430	1/2	1.3/8	12	—	041057	—
	56		0.0465	1/2	1.3/8	12	—	041056	—
3/64			0.0469	1/2	1.3/8	12	040003	—	—
	55		0.0520	5/8	1.5/8	12	—	041055	—
	54		0.0550	5/8	1.5/8	12	—	041054	—
	53		0.0595	5/8	1.5/8	12	—	041053	—
1/16			0.0625	5/8	1.5/8	12	040004	—	—
	52		0.0635	11/16	1.11/16	12	—	041052	—
	51		0.0670	11/16	1.11/16	12	—	041051	—
	50		0.0700	11/16	1.11/16	12	—	041050	—
	49		0.0730	11/16	1.11/16	12	—	041049	—
	48		0.0760	11/16	1.11/16	12	—	041048	—
5/64			0.0781	11/16	1.11/16	12	040005	—	—
	47		0.0785	11/16	1.11/16	12	—	041047	—
	46		0.0810	3/4	1.3/4	12	—	041046	—
	45		0.0820	3/4	1.3/4	12	—	041045	—
	44		0.0860	3/4	1.3/4	12	—	041044	—
	43		0.0890	3/4	1.3/4	12	—	041043	—
	42		0.0935	3/4	1.3/4	12	—	041042	—
3/32			0.0938	3/4	1.3/4	12	040006	—	—
	41		0.0960	13/16	1.13/16	12	—	041041	—
	40		0.0980	13/16	1.13/16	12	—	041040	—
	39		0.0995	13/16	1.13/16	12	—	041039	—
	38		0.1015	13/16	1.13/16	12	—	041038	—
	37		0.1040	13/16	1.13/16	12	—	041037	—
	36		0.1065	13/16	1.13/16	12	—	041036	—
7/64			0.1094	13/16	1.13/16	12	040007	—	—
	35		0.1100	7/8	1.7/8	12	—	041035	—
	34		0.1110	7/8	1.7/8	12	—	041034	—
	33		0.1130	7/8	1.7/8	12	—	041033	—
	32		0.1160	7/8	1.7/8	12	—	041032	—

# SCREW MACHINE DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40	R41	R42
	31		0.1200	7/8	1.7/8	12	—	041031	—
1/8			0.1250	7/8	1.7/8	12	040008	—	—
	30		0.1285	15/16	1.15/16	12	—	041030	—
	29		0.1360	15/16	1.15/16	12	—	041029	—
	28		0.1405	15/16	1.15/16	12	—	041028	—
9/64			0.1406	15/16	1.15/16	12	040009	—	—
	27		0.1440	1"	2.1/16	12	—	041027	—
	26		0.1470	1"	2.1/16	12	—	041026	—
	25		0.1495	1"	2.1/16	12	—	041025	—
	24		0.1520	1"	2.1/16	12	—	041024	—
	23		0.1540	1"	2.1/16	12	—	041023	—
5/32			0.1563	1"	2.1/16	12	040010	—	—
	22		0.1570	1.1/16	2.1/8	12	—	041022	—
	21		0.1590	1.1/16	2.1/8	12	—	041021	—
	20		0.1610	1.1/16	2.1/8	12	—	041020	—
	19		0.1660	1.1/16	2.1/8	12	—	041019	—
	18		0.1695	1.1/16	2.1/8	12	—	041018	—
11/64			0.1719	1.1/16	2.1/8	12	040011	—	—
	17		0.1730	1.1/8	2.3/16	12	—	041017	—
	16		0.1770	1.1/8	2.3/16	12	—	041016	—
	15		0.1800	1.1/8	2.3/16	12	—	041015	—
	14		0.1820	1.1/8	2.3/16	12	—	041014	—
	13		0.1850	1.1/8	2.3/16	12	—	041013	—
3/16			0.1875	1.1/8	2.3/16	12	040012	—	—
	12		0.1890	1.3/16	2.1/4	12	—	041012	—
	11		0.1910	1.3/16	2.1/4	12	—	041011	—
	10		0.1935	1.3/16	2.1/4	12	—	041010	—
	9		0.1960	1.3/16	2.1/4	12	—	041009	—
	8		0.1990	1.3/16	2.1/4	12	—	041008	—
	7		0.2010	1.3/16	2.1/4	12	—	041007	—
13/64			0.2031	1.3/16	2.1/4	12	040013	—	—
	6		0.2040	1.1/4	2.3/8	12	—	041006	—
	5		0.2055	1.1/4	2.3/8	12	—	041005	—
	4		0.2090	1.1/4	2.3/8	12	—	041004	—
	3		0.2130	1.1/4	2.3/8	12	—	041003	—
7/32			0.2188	1.1/4	2.3/8	12	040014	—	—
	2		0.2210	1.5/16	2.7/16	12	—	041002	—
	1		0.2280	1.5/16	2.7/16	12	—	041001	—
		A	0.2340	1.5/16	2.7/16	12	—	—	042001
15/64			0.2344	1.5/16	2.7/16	12	040015	—	—
		B	0.2374	1.3/8	2.1/2	12	—	—	042002
		C	0.2421	1.3/8	2.1/2	12	—	—	042003
		D	0.2461	1.3/8	2.1/2	12	—	—	042004
		E	0.2500	1.3/8	2.1/2	12	—	—	042005
1/4			0.2500	1.3/8	2.1/2	12	040016	—	—
		F	0.2571	1.7/16	2.5/8	12	—	—	042006
		G	0.2610	1.7/16	2.5/8	12	—	—	042007
17/64			0.2656	1.7/16	2.5/8	12	040017	—	—
		H	0.2661	1.1/2	2.11/16	12	—	—	042008
		I	0.2720	1.1/2	2.11/16	12	—	—	042009
		J	0.2772	1.1/2	2.11/16	12	—	—	042010
		K	0.2811	1.1/2	2.11/16	12	—	—	042011
9/32			0.2813	1.1/2	2.11/16	12	040018	—	—
		L	0.2902	1.9/16	2.3/4	12	—	—	042012
		M	0.2949	1.9/16	2.3/4	12	—	—	042013
19/64			0.2969	1.9/16	2.3/4	12	040019	—	—
		N	0.3020	1.5/8	2.13/16	12	—	—	042014
5/16			0.3125	1.5/8	2.13/16	6	040020	—	—
		O	0.3161	1.11/16	2.15/16	6	—	—	042015
		P	0.3228	1.11/16	2.15/16	6	—	—	042016
21/64			0.3281	1.11/16	2.15/16	6	040021	—	—
		Q	0.3319	1.11/16	3"	6	—	—	042017
		R	0.3390	1.11/16	3"	6	—	—	042018
11/32			0.3437	1.11/16	3"	6	040022	—	—
		S	0.3480	1.3/4	3.1/16	6	—	—	042019



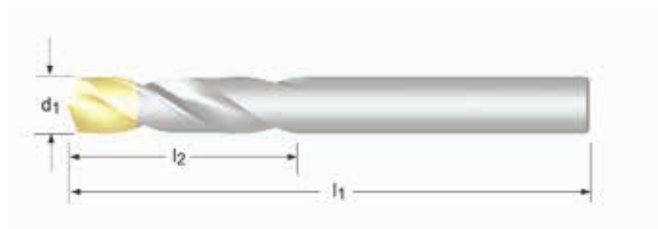
# SCREW MACHINE DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40	R41	R42
		T	0.3580	1.3/4	3.1/16	6	—	—	042020
23/64			0.3594	1.3/4	3.1/16	6	040023	—	—
		U	0.3680	1.13/16	3.1/8	6	—	—	042021
3/8			0.3750	1.13/16	3.1/8	6	040024	—	—
		V	0.3772	1.7/8	3.1/4	6	—	—	042022
		W	0.3858	1.7/8	3.1/4	6	—	—	042023
25/64			0.3906	1.7/8	3.1/4	6	040025	—	—
		X	0.3969	1.15/16	3.5/16	6	—	—	042024
		Y	0.4039	1.15/16	3.5/16	6	—	—	042025
13/32			0.4063	1.15/16	3.5/16	6	040026	—	—
		Z	0.4130	2"	3.3/8	6	—	—	042026
27/64			0.4219	2"	3.3/8	6	040027	—	—
7/16			0.4375	2.1/16	3.7/16	6	040028	—	—
29/64			0.4531	2.1/8	3.9/16	6	040029	—	—
15/32			0.4687	2.1/8	3.5/8	6	040030	—	—
31/64			0.4844	2.3/16	3.11/16	6	040031	—	—
1/2			0.5000	2.1/4	3.3/4	6	040032	—	—
33/64			0.5156	2.3/8	3.7/8	1	040033	—	—
17/32			0.5313	2.3/8	3.7/8	1	040034	—	—
35/64			0.5469	2.1/2	4"	1	040035	—	—
9/16			0.5625	2.1/2	4"	1	040036	—	—
37/64			0.5781	2.5/8	4.1/8	1	040037	—	—
19/32			0.5937	2.5/8	4.1/8	1	040038	—	—
39/64			0.6094	2.3/4	4.1/4	1	040039	—	—
5/8			0.6250	2.3/4	4.1/4	1	040040	—	—
41/64			0.6406	2.7/8	4.1/2	1	040041	—	—
21/32			0.6563	2.7/8	4.1/2	1	040042	—	—
43/64			0.6719	2.7/8	4.5/8	1	040043	—	—
11/16			0.6875	2.7/8	4.5/8	1	040044	—	—
45/64			0.7031	3"	4.3/4	1	040545 <sup>1)</sup>	—	—
23/32			0.7188	3"	4.3/4	1	040546 <sup>1)</sup>	—	—
47/64			0.7344	3.1/8	5"	1	040547 <sup>1)</sup>	—	—
3/4			0.7500	3.1/8	5"	1	040548 <sup>1)</sup>	—	—
49/64			0.7656	3.1/4	5.1/8	1	040549 <sup>1)</sup>	—	—
25/32			0.7813	3.1/4	5.1/8	1	040550 <sup>1)</sup>	—	—
51/64			0.7969	3.3/8	5.1/4	1	040551 <sup>1)</sup>	—	—
13/16			0.8125	3.3/8	5.1/4	1	040552 <sup>1)</sup>	—	—
53/64			0.8281	3.1/2	5.3/8	1	040553 <sup>1)</sup>	—	—
27/32			0.8438	3.1/2	5.3/8	1	040554 <sup>1)</sup>	—	—
55/64			0.8594	3.1/2	5.1/2	1	040555 <sup>1)</sup>	—	—
7/8			0.8750	3.1/2	5.1/2	1	040556 <sup>1)</sup>	—	—
57/64			0.8906	3.5/8	5.5/8	1	040557 <sup>1)</sup>	—	—
29/32			0.9063	3.5/8	5.5/8	1	040558 <sup>1)</sup>	—	—
59/64			0.9219	3.3/4	5.3/4	1	040559 <sup>1)</sup>	—	—
15/16			0.9375	3.3/4	5.3/4	1	040560 <sup>1)</sup>	—	—
61/64			0.9531	3.7/8	5.7/8	1	040561 <sup>1)</sup>	—	—
31/32			0.9688	3.7/8	5.7/8	1	040562 <sup>1)</sup>	—	—
63/64			0.9844	4"	6"	1	040563 <sup>1)</sup>	—	—
1"			1.0000	4"	6"	1	040600 <sup>1)</sup>	—	—
1.1/16			1.0625	4"	6.1/4	1	040604 <sup>1)2)</sup>	—	—
1.1/8			1.1250	4"	6.3/8	1	040608 <sup>1)2)</sup>	—	—
1.3/16			1.1875	4.1/4	6.5/8	1	040612 <sup>1)2)</sup>	—	—
1.1/4			1.2500	4.3/8	6.3/4	1	040616 <sup>1)2)</sup>	—	—
1.5/16			1.3125	4.3/8	7"	1	040620 <sup>1)3)</sup>	—	—
1.3/8			1.3750	4.1/2	7.1/8	1	040624 <sup>1)3)</sup>	—	—
1.7/16			1.4375	4.3/4	7.3/8	1	040628 <sup>1)3)</sup>	—	—
1.1/2			1.5000	4.7/8	7.1/2	1	040632 <sup>1)3)</sup>	—	—
1.9/16			1.5625	4.7/8	7.3/4	1	040636 <sup>1)4)</sup>	—	—
1.5/8			1.6250	4.7/8	7.3/4	1	040640 <sup>1)4)</sup>	—	—
1.3/4			1.7500	5.1/8	8"	1	040648 <sup>1)4)</sup>	—	—
1.13/16			1.8125	5.3/8	8.1/4	1	040652 <sup>1)4)</sup>	—	—
1.7/8			1.8750	5.3/8	8.1/4	1	040656 <sup>1)4)</sup>	—	—
1.15/16			1.9375	5.5/8	8.1/2	1	040660 <sup>1)4)</sup>	—	—
2"			2.0000	5.5/8	8.1/2	1	040700 <sup>1)4)</sup>	—	—

## General Purpose Screw Machine Length

**A022** Low thrust design self centering Split Point for easier penetration. TiN Coated Tip increases wear resistance and improves tool life.

Metric sizes to DIN1897 lengths.  
Fractional sizes to ANSI lengths.



A022

DIN  
ANSI

2.5XD

HSS

135°



0.50 - 16.00

\* 2mm and smaller are bright with no split point

$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A022
	0.50	0.0197	3	20	10	0600382
	0.60	0.0236	3.5	21	10	0600399
	0.70	0.0276	4.5	23	10	0600405
1/32	0.79	0.0313	13	35	10	0600542
	0.80	0.0315	5	24	10	0600412
	0.90	0.0354	5.5	25	10	0600429
	1.00	0.0394	6	26	10	0600436
	1.10	0.0433	7	28	10	0600443
3/64	1.19	0.0469	13	35	10	0600559
	1.20	0.0472	8	30	10	0600450
	1.30	0.0512	8	30	10	0600467
	1.40	0.0551	9	32	10	0600474
	1.50	0.0591	9	32	10	0600481
1/16	1.59	0.0625	16	41	10	0600535
	1.60	0.0630	10	34	10	0600498
	1.70	0.0669	10	34	10	0600504
	1.80	0.0709	11	36	10	0600511
	1.90	0.0748	11	36	10	0600528
5/64	1.98	0.0781	17	43	10	0600566
	2.00	0.0787	12	38	10	0600115
	2.10	0.0827	12	38	10	0600122
	2.20	0.0866	13	40	10	0600139
	2.25	0.0886	13	40	10	0600146
	2.30	0.0906	13	40	10	0600153
3/32	2.38	0.0937	20	45	10	0600238
	2.40	0.0945	14	43	10	0600160
	2.50	0.0984	14	43	10	0600177
	2.60	0.1024	14	43	10	0600184
	2.65	0.1043	14	43	10	0600191
	2.70	0.1063	16	46	10	0600207
7/64	2.78	0.1094	22	47	10	0600245
	2.80	0.1102	16	46	10	0600214
	2.90	0.1142	16	46	10	0600221



$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A022
	3.00	0.1181	16	46	10	0588697
	3.10	0.1220	18	49	10	0589083
1/8	3.18	0.1250	23	49	10	0588727
	3.20	0.1260	18	49	10	0589090
	3.25	0.1280	18	49	10	0589106
	3.30	0.1299	18	49	10	0589113
	3.40	0.1339	20	52	10	0589120
	3.50	0.1378	20	52	10	0589137
9/64	3.57	0.1406	25	50	10	0589878
	3.60	0.1417	20	52	10	0589144
	3.70	0.1457	20	52	10	0589151
	3.80	0.1496	22	55	10	0589168
	3.90	0.1535	22	55	10	0589175
5/32	3.97	0.1563	26	53	10	0589410
	4.00	0.1575	22	55	10	0589205
	4.10	0.1614	22	55	10	0589212
	4.20	0.1654	22	55	10	0589229
	4.30	0.1693	24	58	10	0589236
11/64	4.37	0.1719	28	55	10	0588932
	4.40	0.1732	24	58	10	0589243
	4.50	0.1772	24	58	10	0589250
	4.60	0.1811	24	58	10	0589267
	4.70	0.1850	24	58	10	0589274
3/16	4.76	0.1875	30	57	10	0589182
	4.80	0.1890	26	62	10	0589281
	4.90	0.1929	26	62	10	0589298
	5.00	0.1969	26	62	10	0589304
	5.10	0.2008	26	62	10	0589311
13/64	5.16	0.2031	31	58	10	0589014
	5.20	0.2047	26	62	10	0589328
	5.30	0.2087	26	62	10	0589335
	5.40	0.2126	28	66	10	0589342
	5.50	0.2165	28	66	10	0589359
7/32	5.56	0.2188	33	61	10	0589649
	5.60	0.2205	28	66	10	0589366
	5.70	0.2244	28	66	10	0589373
	5.80	0.2283	28	66	10	0589380
	5.90	0.2323	28	66	10	0589397
15/64	5.95	0.2344	34	63	10	0589069
	6.00	0.2362	28	66	10	0589434
	6.10	0.2402	31	70	10	0589441
	6.20	0.2441	31	70	10	0589458
	6.30	0.2480	31	70	10	0589465
1/4	6.35	0.2500	36	65	10	0588710
	6.40	0.2520	31	70	10	0589472
	6.50	0.2559	31	70	10	0589489
	6.60	0.2598	31	70	10	0589496
	6.70	0.2638	31	70	10	0589502
	6.80	0.2677	34	74	10	0589519
	6.90	0.2717	34	74	10	0589526
	7.00	0.2756	34	74	10	0589533
	7.10	0.2795	34	74	10	0589540
9/32	7.14	0.2813	40	70	10	0589861
	7.20	0.2835	34	74	10	0589557
	7.30	0.2874	34	74	10	0589564
	7.40	0.2913	34	74	10	0589571
	7.50	0.2953	34	74	10	0589588
	7.60	0.2992	37	79	10	0589595
	7.70	0.3031	37	79	10	0589601
	7.80	0.3071	37	79	10	0589618
	7.90	0.3110	37	79	10	0589625
5/16	7.94	0.3125	43	73	10	0589403
	8.00	0.3150	37	79	10	0589656
	8.10	0.3189	37	79	10	0589663
	8.20	0.3228	37	79	10	0589670
	8.30	0.3268	37	79	10	0589687

# SCREW MACHINE DRILL



$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A022
	8.40	0.3307	37	79	10	0589694
	8.50	0.3346	37	79	10	0589700
	8.60	0.3386	40	84	10	0589717
	8.70	0.3425	40	84	10	0589724
11/32	8.73	0.3438	45	78	10	0588925
	8.80	0.3465	40	84	10	0589731
	8.90	0.3504	40	84	10	0589748
	9.00	0.3543	40	84	10	0589755
	9.10	0.3583	40	84	10	0589762
	9.20	0.3622	40	84	10	0589779
	9.30	0.3661	40	84	10	0589786
	9.40	0.3701	40	84	10	0589793
	9.50	0.3740	40	84	10	0589809
3/8	9.52	0.3750	48	81	10	0589199
	9.60	0.3780	43	89	10	0589816
	9.70	0.3819	43	89	10	0589823
	9.80	0.3858	43	89	10	0589830
	9.90	0.3898	43	89	10	0589847
	10.00	0.3937	43	89	10	0588734
	10.10	0.3976	43	89	5	0588741
	10.20	0.4016	43	89	5	0588758
	10.30	0.4055	43	89	5	0588765
13/32	10.32	0.4062	51	86	5	0589007
	10.40	0.4094	43	89	5	0588772
	10.50	0.4134	43	89	5	0588789
	10.60	0.4173	43	89	5	0588796
	10.70	0.4213	47	95	5	0588802
	10.80	0.4252	47	95	5	0588819
	10.90	0.4291	47	95	5	0588826
	11.00	0.4331	47	95	5	0588833
	11.10	0.4370	47	95	5	0588840
7/16	11.11	0.4375	54	89	5	0589632
	11.20	0.4409	47	95	5	0588857
	11.30	0.4449	47	95	5	0588864
	11.50	0.4528	47	95	5	0588871
	11.60	0.4567	47	95	5	0588888
	11.70	0.4606	47	95	5	0588895
	11.80	0.4646	47	95	5	0588901
	11.90	0.4685	51	102	5	0588918
	12.00	0.4724	51	102	5	0588949
	12.10	0.4764	51	102	5	0588956
	12.20	0.4803	51	102	5	0588963
	12.50	0.4921	51	102	5	0588970
1/2	12.70	0.5000	60	98	5	0588703
	13.00	0.5118	51	102	5	0588987
	13.50	0.5315	54	107	1	0588994
	14.00	0.5512	54	107	1	0589021
9/16	14.29	0.5625	67	105	1	0589854
	14.50	0.5709	56	111	1	0589038
	15.00	0.5906	56	111	1	0589045
	15.50	0.6102	58	115	1	0589052
5/8	15.88	0.6250	73	111	1	0589427
	16.00	0.6299	58	115	1	0589076

## Heavy Duty Screw Machine Length (NAS 907 Type C)

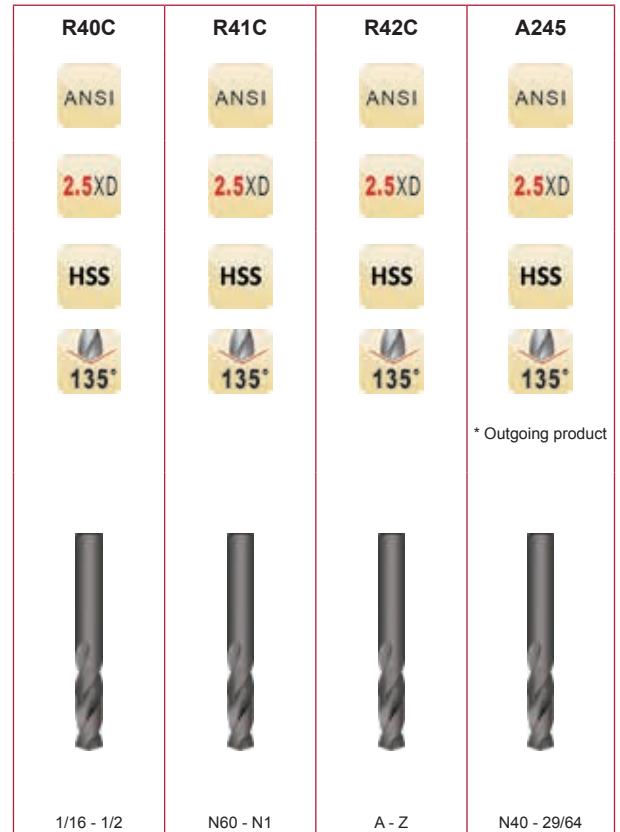
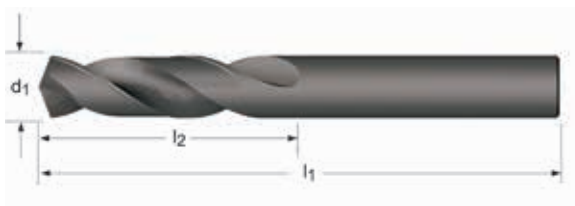
**R40C** - Fractional Sizes

**R41C** - Wire Gauge Sizes

**R42C** - Letter Sizes

**A245** - This fractional style is an outgoing product. Limited quantities available. When stock is depleted please use identical style R40C

Low thrust design self centering Split Point for easier penetration. Steam Oxide surface treatment for increased wear resistance and lubricity.



\* Outgoing product

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40C	R41C	R42C	A245
	60		0.0400	1/2	1.3/8	12	—	041860 <sup>1)</sup>	—	—
	59		0.0410	1/2	1.3/8	12	—	041859 <sup>1)</sup>	—	—
	58		0.0420	1/2	1.3/8	12	—	041858 <sup>1)</sup>	—	—
	57		0.0430	1/2	1.3/8	12	—	041857 <sup>1)</sup>	—	—
	56		0.0465	1/2	1.3/8	12	—	041856 <sup>1)</sup>	—	—
	55		0.0520	5/8	1.5/8	12	—	041855 <sup>1)</sup>	—	—
	54		0.0550	5/8	1.5/8	12	—	041854 <sup>1)</sup>	—	—
	53		0.0595	5/8	1.5/8	12	—	041853 <sup>1)</sup>	—	—
1/16			0.0625	5/8	1.5/8	12	040804	—	—	—
	52		0.0635	11/16	1.11/16	12	—	041852	—	—
	51		0.0670	11/16	1.11/16	12	—	041851	—	—
	50		0.0700	11/16	1.11/16	12	—	041850	—	—
	49		0.0730	11/16	1.11/16	12	—	041849	—	—
	48		0.0760	11/16	1.11/16	12	—	041848	—	—
5/64			0.0781	11/16	1.11/16	12	040805	—	—	—
	47		0.0785	11/16	1.11/16	12	—	041847	—	—
	46		0.0810	3/4	1.3/4	12	—	041846	—	—
	45		0.0820	3/4	1.3/4	12	—	041845	—	—
	44		0.0860	3/4	1.3/4	12	—	041844	—	—
	43		0.0890	3/4	1.3/4	12	—	041843	—	—
	42		0.0935	3/4	1.3/4	12	—	041842	—	—
3/32			0.0938	3/4	1.3/4	12	040806	—	—	—
	41		0.0960	13/16	1.13/16	12	—	041841	—	—
	40		0.0980	13/16	1.13/16	12	—	041840	—	0234341
	39		0.0995	13/16	1.13/16	12	—	041839	—	—
	38		0.1015	13/16	1.13/16	12	—	041838	—	—
	37		0.1040	13/16	1.13/16	12	—	041837	—	—
	36		0.1065	13/16	1.13/16	12	—	041836	—	—
7/64			0.1094	13/16	1.13/16	12	040807	—	—	—
	35		0.1100	7/8	1.7/8	12	—	041835	—	—
	34		0.1110	7/8	1.7/8	12	—	041834	—	—
	33		0.1130	7/8	1.7/8	12	—	041833	—	—

<sup>1)</sup> Not Split Point

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40C	R41C	R42C	A245
	32		0.1160	7/8	1.7/8	12	—	041832	—	—
	31		0.1200	7/8	1.7/8	12	—	041831	—	0234242
1/8			0.1250	7/8	1.7/8	12	040808	—	—	0234914
	30		0.1285	15/16	1.15/16	12	—	041830	—	0234235
	29		0.1360	15/16	1.15/16	12	—	041829	—	0234211
	28		0.1405	15/16	1.15/16	12	—	041828	—	0234204
9/64			0.1406	15/16	1.15/16	12	040809	—	—	0235386
	27		0.1440	1"	2.1/16	12	—	041827	—	0234198
	26		0.1470	1"	2.1/16	12	—	041826	—	0234181
	25		0.1495	1"	2.1/16	12	—	041825	—	0234174
	24		0.1520	1"	2.1/16	12	—	041824	—	0234167
	23		0.1540	1"	2.1/16	12	—	041823	—	0234150
5/32			0.1563	1"	2.1/16	12	040810	—	—	0235232
	22		0.1570	1.1/16	2.1/8	12	—	041822	—	—
	21		0.1590	1.1/16	2.1/8	12	—	041821	—	0234136
	20		0.1610	1.1/16	2.1/8	12	—	041820	—	0234129
	19		0.1660	1.1/16	2.1/8	12	—	041819	—	0234105
	18		0.1695	1.1/16	2.1/8	12	—	041818	—	0234099
11/64			0.1719	1.1/16	2.1/8	12	040811	—	—	0234792
	17		0.1730	1.1/8	2.3/16	12	—	041817	—	—
	16		0.1770	1.1/8	2.3/16	12	—	041816	—	—
	15		0.1800	1.1/8	2.3/16	12	—	041815	—	—
	14		0.1820	1.1/8	2.3/16	12	—	041814	—	—
	13		0.1850	1.1/8	2.3/16	12	—	041813	—	—
3/16			0.1875	1.1/8	2.3/16	12	040812	—	—	0235065
	12		0.1890	1.3/16	2.1/4	12	—	041812	—	—
	11		0.1910	1.3/16	2.1/4	12	—	041811	—	0234020
	10		0.1935	1.3/16	2.1/4	12	—	041810	—	0234013
	9		0.1960	1.3/16	2.1/4	12	—	041809	—	0234594
	8		0.1990	1.3/16	2.1/4	12	—	041808	—	0234587
	7		0.2010	1.3/16	2.1/4	12	—	041807	—	0234570
13/64			0.2031	1.3/16	2.1/4	12	040813	—	—	0234846
	6		0.2040	1.1/4	2.3/8	12	—	041806	—	—
	5		0.2055	1.1/4	2.3/8	12	—	041805	—	0234440
	4		0.2090	1.1/4	2.3/8	12	—	041804	—	—
	3		0.2130	1.1/4	2.3/8	12	—	041803	—	—
7/32			0.2188	1.1/4	2.3/8	12	040814	—	—	0235331
	2		0.2210	1.5/16	2.7/16	12	—	041802	—	0234112
	1		0.2280	1.5/16	2.7/16	12	—	041801	—	0234006
		A	0.2340	1.5/16	2.7/16	12	—	—	042801	—
15/64			0.2344	1.5/16	2.7/16	12	040815	—	—	—
		B	0.2380	1.3/8	2.1/2	12	—	—	042802	—
		C	0.2420	1.3/8	2.1/2	12	—	—	042803	—
		D	0.2460	1.3/8	2.1/2	12	—	—	042804	—
		E	0.2500	1.3/8	2.1/2	12	—	—	042805	—
1/4			0.2500	1.3/8	2.1/2	12	040816	—	—	0234853
		F	0.2570	1.7/16	2.5/8	12	—	—	042806	0235447
		G	0.2610	1.7/16	2.5/8	12	—	—	042807	—
17/64			0.2656	1.7/16	2.5/8	12	040817	—	—	0234907
		H	0.2660	1.1/2	2.11/16	12	—	—	042808	—
		I	0.2720	1.1/2	2.11/16	12	—	—	042809	—
		J	0.2770	1.1/2	2.11/16	12	—	—	042810	—
		K	0.2810	1.1/2	2.11/16	12	—	—	042811	—
9/32			0.2813	1.1/2	2.11/16	12	040818	—	—	0235379
		L	0.2900	1.9/16	2.3/4	12	—	—	042812	—
		M	0.2950	1.9/16	2.3/4	12	—	—	042813	—
19/64			0.2969	1.9/16	2.3/4	12	040819	—	—	—
		N	0.3020	1.5/8	2.13/16	12	—	—	042814	—
5/16			0.3125	1.5/8	2.13/16	6	040820	—	—	0235218
		O	0.3160	1.11/16	2.15/16	6	—	—	042815	—
		P	0.3230	1.11/16	2.15/16	6	—	—	042816	—
21/64			0.3281	1.11/16	2.15/16	6	040821	—	—	—
		Q	0.3320	1.11/16	3"	6	—	—	042817	—
		R	0.3390	1.11/16	3"	6	—	—	042818	—
11/32			0.3437	1.11/16	3"	6	040822	—	—	—
		S	0.3480	1.3/4	3.1/16	6	—	—	042819	—

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R40C	R41C	R42C	A245
		T	0.3580	1.3/4	3.1/16	6	—	—	042820	—
23/64			0.3594	1.3/4	3.1/16	6	040823	—	—	—
		U	0.3680	1.13/16	3.1/8	6	—	—	042821	—
3/8			0.3750	1.13/16	3.1/8	6	040824	—	—	0235140
		V	0.3770	1.7/8	3.1/4	6	—	—	042822	—
		W	0.3860	1.7/8	3.1/4	6	—	—	042823	—
25/64			0.3906	1.7/8	3.1/4	6	040825	—	—	0235003
		X	0.3970	1.15/16	3.5/16	6	—	—	042824	—
		Y	0.4040	1.15/16	3.5/16	6	—	—	042825	—
13/32			0.4063	1.15/16	3.5/16	6	040826	—	—	—
		Z	0.4130	2"	3.3/8	6	—	—	042826	—
27/64			0.4219	2"	3.3/8	6	040827	—	—	—
7/16			0.4375	2.1/16	3.7/16	6	040828	—	—	—
29/64			0.4531	2.1/8	3.9/16	6	040829	—	—	0235041
15/32			0.4687	2.1/8	3.5/8	6	040830	—	—	—
31/64			0.4844	2.3/16	3.11/16	6	040831	—	—	—
1/2			0.5000	2.1/4	3.3/4	6	040832	—	—	—

# SCREW MACHINE DRILL



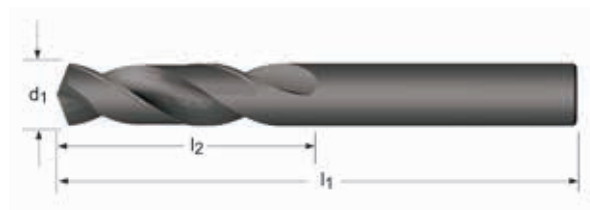
## Heavy Duty Screw Machine Length (NAS 907 Type C), Metric

**4ASM** Low thrust design self centering Split Point for easier penetration.  
Steam Oxide surface treatment for increased wear resistance & lubricity.

4ASM



1.00 - 12.50



d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	4ASM
1.00	0.0394	6	22	12	046100 <sup>1)</sup>
1.25	0.0492	8	30	12	046125 <sup>1)</sup>
1.30	0.0512	8	30	12	046130 <sup>1)</sup>
1.65	0.0650	11	34	12	046165
2.00	0.0787	12	38	12	046200
2.30	0.0906	13	40	12	046230
2.40	0.0945	14	43	12	046240
2.50	0.0984	14	43	12	046250
3.00	0.1181	16	46	12	046300
3.10	0.1220	18	49	12	046310
3.20	0.1260	18	49	12	046320
3.30	0.1299	18	49	12	046330
3.40	0.1339	20	52	12	046340
3.50	0.1378	20	52	12	046350
3.70	0.1457	20	52	12	046370
4.00	0.1575	22	55	12	046400
4.20	0.1654	22	55	12	046420
4.50	0.1772	24	58	12	046450
5.00	0.1969	26	62	12	046500
5.50	0.2165	28	66	12	046550
5.70	0.2244	28	66	12	046570
5.80	0.2283	28	66	12	046580
6.00	0.2362	28	66	12	046600
6.20	0.2441	31	70	12	046620
6.40	0.2520	31	70	12	046640
6.50	0.2559	31	70	12	046650
6.60	0.2598	31	70	12	046660
6.80	0.2677	34	74	12	046680
6.90	0.2717	34	74	12	046690
7.00	0.2756	34	74	12	046700
7.20	0.2835	34	74	12	046720
7.50	0.2953	37	79	12	046750

<sup>1)</sup> Not Split Point



# SCREW MACHINE DRILL

$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	4ASM
8.00	0.3150	37	79	6	046800
8.10	0.3189	37	79	6	046810
8.40	0.3307	37	79	6	046840
8.50	0.3346	37	79	6	046850
8.70	0.3425	40	84	6	046870
9.00	0.3543	40	84	6	046900
9.10	0.3583	40	84	6	046910
9.20	0.3622	40	84	6	046920
9.30	0.3661	40	84	6	046930
9.50	0.3740	40	84	6	046950
9.70	0.3819	43	89	6	046970
10.00	0.3937	43	89	6	047000
10.20	0.4016	43	89	6	047002
10.50	0.4134	43	89	6	047005
10.80	0.4252	47	95	6	047008
11.00	0.4331	47	95	6	047110
11.20	0.4409	47	95	6	047112
11.50	0.4528	47	95	6	047115
11.80	0.4646	47	95	6	047118
12.00	0.4724	51	102	6	047200
12.20	0.4803	51	102	6	047220
12.50	0.4921	51	102	6	047250

# SCREW MACHINE DRILL

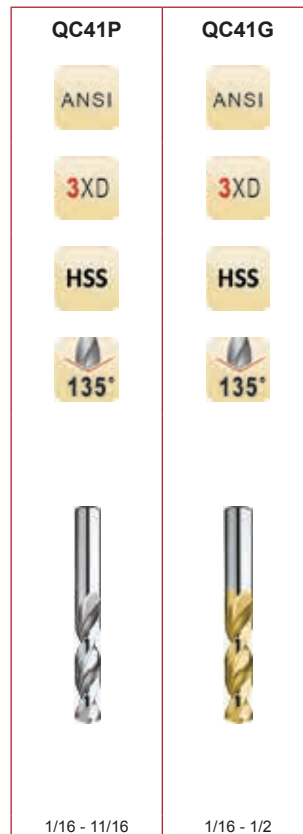
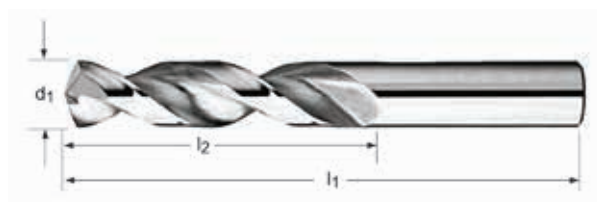


## General Purpose Screw Machine Length Parabolic Flute

Heavy-Duty Parabolic Flute design for efficient chip removal.  
Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration.

**QC41P** Bright Finish improves chip flow in soft or non-ferrous materials.

**QC41G** TiN Coating increases wear resistance and improves tool life.



$d_1$ Ø "/Nr.	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	QC41P	QC41G
1/16	0.0625	5/8	1.5/8	12	058304	062304
5/64	0.0781	11/16	1.11/16	12	058305	062305
3/32	0.0938	3/4	1.3/4	12	058306	062306
40	0.0980	13/16	1.13/16	12	060040	061440
39	0.0995	13/16	1.13/16	12	060039	061439
38	0.1015	13/16	1.13/16	12	060038	061438
37	0.1040	13/16	1.13/16	12	060037	061437
36	0.1065	13/16	1.13/16	12	060036	061436
7/64	0.1094	13/16	1.13/16	12	058307	062307
35	0.1100	7/8	1.7/8	12	060035	061435
34	0.1110	7/8	1.7/8	12	060034	061434
33	0.1130	7/8	1.7/8	12	060033	061433
32	0.1160	7/8	1.7/8	12	060032	061432
31	0.1200	7/8	1.7/8	12	060031	061431
1/8	0.1250	7/8	1.7/8	12	058308	062308
30	0.1285	15/16	1.15/16	12	060030	061430
29	0.1360	15/16	1.15/16	12	060029	061429
28	0.1405	15/16	1.15/16	12	060028	061428
9/64	0.1406	15/16	1.15/16	12	058309	062309
27	0.1440	1"	2.1/16	12	060027	061427
26	0.1470	1"	2.1/16	12	060026	061426
25	0.1495	1"	2.1/16	12	060025	061425
24	0.1520	1"	2.1/16	12	060024	061424
23	0.1540	1"	2.1/16	12	060023	061423
5/32	0.1563	1"	2.1/16	12	058310	062310
22	0.1570	1.1/16	2.1/8	12	060022	061422
21	0.1590	1.1/16	2.1/8	12	060021	061421
20	0.1610	1.1/16	2.1/8	12	060020	061420
19	0.1660	1.1/16	2.1/8	12	060019	061419
18	0.1695	1.1/16	2.1/8	12	060018	061418
11/64	0.1719	1.1/16	2.1/8	12	058311	062311
17	0.1730	1.1/8	2.3/16	12	060017	061417
16	0.1770	1.1/8	2.3/16	12	060016	061416





# SCREW MACHINE DRILL

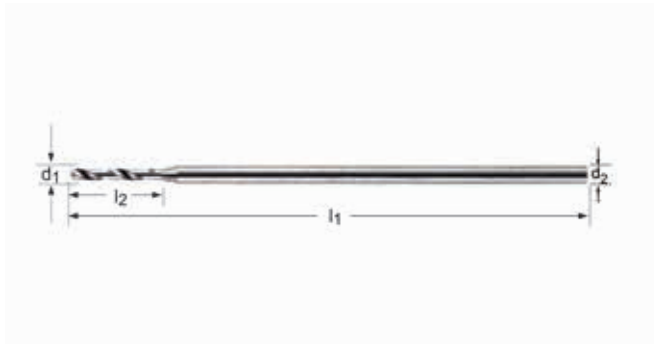
d <sub>1</sub> Ø "/Nr.	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	QC41P	QC41G
15	0.1800	1.1/8	2.3/16	12	060015	061415
14	0.1820	1.1/8	2.3/16	12	060014	061414
13	0.1850	1.1/8	2.3/16	12	060013	061413
3/16	0.1875	1.1/8	2.3/16	12	058312	062312
12	0.1890	1.3/16	2.1/4	12	060012	061412
11	0.1910	1.3/16	2.1/4	12	060011	061411
10	0.1935	1.3/16	2.1/4	12	060010	061410
9	0.1960	1.3/16	2.1/4	12	060009	061409
8	0.1990	1.3/16	2.1/4	12	060008	061408
7	0.2010	1.3/16	2.1/4	12	060007	061407
13/64	0.2031	1.3/16	2.1/4	12	058313	062313
6	0.2040	1.1/4	2.3/8	12	060006	061406
5	0.2055	1.1/4	2.3/8	12	060005	061405
4	0.2090	1.1/4	2.3/8	12	060004	061404
3	0.2130	1.1/4	2.3/8	12	060003	061403
7/32	0.2188	1.1/4	2.3/8	12	058314	062314
2	0.2210	1.5/16	2.7/16	12	060002	061402
1	0.2280	1.5/16	2.7/16	12	060001	061401
15/64	0.2344	1.5/16	2.7/16	12	058315	062315
1/4	0.2500	1.3/8	2.1/2	12	058316	062316
17/64	0.2656	1.7/16	2.5/8	12	058317	062317
9/32	0.2812	1.1/2	2.11/16	12	058318	062318
19/64	0.2969	1.9/16	2.3/4	12	058319	062319
5/16	0.3125	1.5/8	2.13/16	6	058320	062320
21/64	0.3281	1.11/16	2.15/16	6	058321	062321
11/32	0.3437	1.11/16	3"	6	058322	062322
23/64	0.3594	1.3/4	3.1/16	6	058323	062323
3/8	0.3750	1.13/16	3.1/8	6	058324	062324
25/64	0.3906	1.7/8	3.1/4	6	058325	062325
13/32	0.4063	1.15/16	3.5/16	6	058326	062326
27/64	0.4219	2"	3.3/8	6	058327	062327
7/16	0.4375	2.1/16	3.7/16	6	058328	062328
29/64	0.4531	2.1/8	3.9/16	6	058329	062329
15/32	0.4687	2.1/8	3.5/8	6	058330	062330
31/64	0.4844	2.3/16	3.3/4	6	058331	062331
1/2	0.5000	2.1/4	3.3/4	6	058332	062332
33/64	0.5156	2.3/8	3.7/8	1	058333	—
17/32	0.5313	2.3/8	3.7/8	1	058334	—
35/64	0.5469	2.1/2	4"	1	058335	—
9/16	0.5625	2.1/2	4"	1	058336	—
37/64	0.5781	2.5/8	4.1/8	1	058337	—
19/32	0.5937	2.5/8	4.1/8	1	058338	—
5/8	0.6250	2.3/4	4.1/4	1	058340	—
11/16	0.6875	2.7/8	4.5/8	1	058344	—

## MICRO - Screw Machine Length Drills

### A720

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2

Smallest size range available. Bright finish improves chip flow in soft or non-ferrous materials. Good wear resistance in abrasive or hard materials.



A720

DIN  
1899

2.5XD

HSS-E

118°



0.15 - 1.40

$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	$d_2$ Ø mm	Pack Qty	A720
0.15	0.0059	1.0	25	1	10	0044988
0.16	0.0063	1.4	25	1	10	0566961
0.17	0.0067	1.4	25	1	10	0612057
0.18	0.0070	1.4	25	1	10	0044995
0.20	0.0078	1.8	25	1	10	0045008
0.22	0.0087	1.8	25	1	10	0045015
0.25	0.0098	2.2	25	1	10	0045022
0.27	0.0106	2.2	25	1	10	0566978
0.28	0.0110	2.2	25	1	10	0045039
0.30	0.0118	2.2	25	1	10	0045046
0.35	0.0138	2.8	25	1	10	0045053
0.38	0.0150	2.8	25	1	10	0045060
0.39	0.0154	3.6	25	1	10	0045077
0.40	0.0157	3.6	25	1	10	0045084
0.45	0.0177	3.6	25	1	10	0045107
0.50	0.0197	4.0	25	1	10	0045114
0.55	0.0217	4.5	25	1	10	0612064
0.60	0.0236	4.5	25	1	10	0045121
0.62	0.0244	5.0	25	1	10	0612071
0.65	0.0256	5.0	25	1	10	0612088
0.70	0.0276	5.6	25	1	10	0615577
0.75	0.0295	5.6	25	1	10	0612101
0.80	0.0315	6.3	25	1.5	10	0615584
0.85	0.0335	6.3	25	1.5	10	0612125
0.90	0.0354	7.1	25	1.5	10	0615591
0.95	0.0374	7.1	25	1.5	10	0612149
1.00	0.0394	8.0	25	1.5	10	0615607
1.05	0.0413	8.0	25	1.5	10	0612163
1.10	0.0433	9.0	25	1.5	10	0615614
1.20	0.0472	10.0	25	1.5	10	0615621
1.30	0.0512	10.0	25	1.5	10	0615638
1.40	0.0551	11.2	25	1.5	10	0615645



# COBALT SCREW MACHINE DRILL

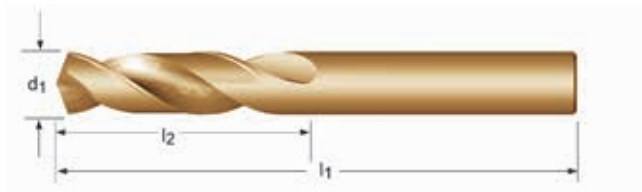
## Heavy Duty Screw Machine Length

**M40CO** - Fractional Sizes

**M41CO** - Wire Gauge Sizes

**M42CO** - Letter Sizes

Low thrust design self centering Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance and lubricity.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	M40CO	M41CO	M42CO
	60		0.0400	1/2	1.3/8	12	—	041360 <sup>1)</sup>	—
	59		0.0410	1/2	1.3/8	12	—	041359 <sup>1)</sup>	—
	58		0.0420	1/2	1.3/8	12	—	041358 <sup>1)</sup>	—
	57		0.0430	1/2	1.3/8	12	—	041357 <sup>1)</sup>	—
	56		0.0465	1/2	1.3/8	12	—	041356 <sup>1)</sup>	—
	55		0.0520	5/8	1.5/8	12	—	041355 <sup>1)</sup>	—
	54		0.0550	5/8	1.5/8	12	—	041354 <sup>1)</sup>	—
	53		0.0595	5/8	1.5/8	12	—	041353 <sup>1)</sup>	—
1/16			0.0625	5/8	1.5/8	12	040304	—	—
	52		0.0635	11/16	1.11/16	12	—	041352	—
	51		0.0670	11/16	1.11/16	12	—	041351	—
	50		0.0700	11/16	1.11/16	12	—	041350	—
	49		0.0730	11/16	1.11/16	12	—	041349	—
	48		0.0760	11/16	1.11/16	12	—	041348	—
5/64			0.0781	11/16	1.11/16	12	040305	—	—
	47		0.0785	11/16	1.11/16	12	—	041347	—
	46		0.0810	3/4	1.3/4	12	—	041346	—
	45		0.0820	3/4	1.3/4	12	—	041345	—
	44		0.0860	3/4	1.3/4	12	—	041344	—
	43		0.0890	3/4	1.3/4	12	—	041343	—
	42		0.0935	3/4	1.3/4	12	—	041342	—
3/32			0.0938	3/4	1.3/4	12	040306	—	—
	41		0.0960	13/16	1.13/16	12	—	041341	—
	40		0.0980	13/16	1.13/16	12	—	041340	—
	39		0.0995	13/16	1.13/16	12	—	041339	—
	38		0.1015	13/16	1.13/16	12	—	041338	—
	37		0.1040	13/16	1.13/16	12	—	041337	—
	36		0.1065	13/16	1.13/16	12	—	041336	—
7/64			0.1094	13/16	1.13/16	12	040307	—	—
	35		0.1100	7/8	1.7/8	12	—	041335	—
	34		0.1110	7/8	1.7/8	12	—	041334	—
	33		0.1130	7/8	1.7/8	12	—	041333	—

<sup>1)</sup>Not Split Point

# COBALT SCREW MACHINE DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	M40CO	M41CO	M42CO
	32		0.1160	7/8	1.7/8	12	—	041332	—
	31		0.1200	7/8	1.7/8	12	—	041331	—
1/8			0.1250	7/8	1.7/8	12	040308	—	—
	30		0.1285	15/16	1.15/16	12	—	041330	—
	29		0.1360	15/16	1.15/16	12	—	041329	—
	28		0.1405	15/16	1.15/16	12	—	041328	—
9/64			0.1406	15/16	1.15/16	12	040309	—	—
	27		0.1440	1"	2.1/16	12	—	041327	—
	26		0.1470	1"	2.1/16	12	—	041326	—
	25		0.1495	1"	2.1/16	12	—	041325	—
	24		0.1520	1"	2.1/16	12	—	041324	—
	23		0.1540	1"	2.1/16	12	—	041323	—
5/32			0.1563	1"	2.1/16	12	040310	—	—
	22		0.1570	1.1/16	2.1/8	12	—	041322	—
	21		0.1590	1.1/16	2.1/8	12	—	041321	—
	20		0.1610	1.1/16	2.1/8	12	—	041320	—
	19		0.1660	1.1/16	2.1/8	12	—	041319	—
	18		0.1695	1.1/16	2.1/8	12	—	041318	—
11/64			0.1719	1.1/16	2.1/8	12	040311	—	—
	17		0.1730	1.1/8	2.3/16	12	—	041317	—
	16		0.1770	1.1/8	2.3/16	12	—	041316	—
	15		0.1800	1.1/8	2.3/16	12	—	041315	—
	14		0.1820	1.1/8	2.3/16	12	—	041314	—
	13		0.1850	1.1/8	2.3/16	12	—	041313	—
3/16			0.1875	1.1/8	2.3/16	12	040312	—	—
	12		0.1890	1.3/16	2.1/4	12	—	041312	—
	11		0.1910	1.3/16	2.1/4	12	—	041311	—
	10		0.1935	1.3/16	2.1/4	12	—	041310	—
	9		0.1960	1.3/16	2.1/4	12	—	041309	—
	8		0.1990	1.3/16	2.1/4	12	—	041308	—
	7		0.2010	1.3/16	2.1/4	12	—	041307	—
13/64			0.2031	1.3/16	2.1/4	12	040313	—	—
	6		0.2040	1.1/4	2.3/8	12	—	041306	—
	5		0.2055	1.1/4	2.3/8	12	—	041305	—
	4		0.2090	1.1/4	2.3/8	12	—	041304	—
	3		0.2130	1.1/4	2.3/8	12	—	041303	—
7/32			0.2188	1.1/4	2.3/8	12	040314	—	—
	2		0.2210	1.5/16	2.7/16	12	—	041302	—
	1		0.2280	1.5/16	2.7/16	12	—	041301	—
		A	0.2340	1.5/16	2.7/16	12	—	—	042301
15/64			0.2344	1.5/16	2.7/16	12	040315	—	—
		B	0.2380	1.3/8	2.1/2	12	—	—	042302
		C	0.2420	1.3/8	2.1/2	12	—	—	042303
		D	0.2460	1.3/8	2.1/2	12	—	—	042304
		E	0.2500	1.3/8	2.1/2	12	—	—	042305
1/4			0.2500	1.3/8	2.1/2	12	040316	—	—
		F	0.2570	1.7/16	2.5/8	12	—	—	042306
		G	0.2610	1.7/16	2.5/8	12	—	—	042307
17/64			0.2656	1.7/16	2.5/8	12	040317	—	—
		H	0.2660	1.1/2	2.11/16	12	—	—	042308
		I	0.2720	1.1/2	2.11/16	12	—	—	042309
		J	0.2770	1.1/2	2.11/16	12	—	—	042310
		K	0.2810	1.1/2	2.11/16	12	—	—	042311
9/32			0.2813	1.1/2	2.11/16	12	040318	—	—
		L	0.2900	1.9/16	2.3/4	12	—	—	042312
		M	0.2950	1.9/16	2.3/4	12	—	—	042313
19/64			0.2969	1.9/16	2.3/4	12	040319	—	—
		N	0.3020	1.5/8	2.13/16	12	—	—	042314
5/16			0.3125	1.5/8	2.13/16	6	040320	—	—
		O	0.3160	1.11/16	2.15/16	6	—	—	042315
		P	0.3230	1.11/16	2.15/16	6	—	—	042316
21/64			0.3281	1.11/16	2.15/16	6	040321	—	—
		Q	0.3320	1.11/16	3"	6	—	—	042317
		R	0.3390	1.11/16	3"	6	—	—	042318
11/32			0.3437	1.11/16	3"	6	040322	—	—
		S	0.3480	1.3/4	3.1/16	6	—	—	042319



# COBALT SCREW MACHINE DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	M40CO	M41CO	M42CO
		T	0.3580	1.3/4	3.1/16	6	—	—	042320
23/64			0.3594	1.3/4	3.1/16	6	040323	—	—
		U	0.3680	1.13/16	3.1/8	6	—	—	042321
3/8			0.3750	1.13/16	3.1/8	6	040324	—	—
		V	0.3770	1.7/8	3.1/4	6	—	—	042322
		W	0.3860	1.7/8	3.1/4	6	—	—	042323
25/64			0.3906	1.7/8	3.1/4	6	040325	—	—
		X	0.3970	1.15/16	3.5/16	6	—	—	042324
		Y	0.4040	1.15/16	3.5/16	6	—	—	042325
13/32			0.4063	1.15/16	3.5/16	6	040326	—	—
		Z	0.4130	2"	3.3/8	6	—	—	042326
27/64			0.4219	2"	3.3/8	6	040327	—	—
7/16			0.4375	2.1/16	3.7/16	6	040328	—	—
29/64			0.4531	2.1/8	3.9/16	6	040329	—	—
15/32			0.4687	2.1/8	3.5/8	6	040330	—	—
31/64			0.4844	2.3/16	3.11/16	6	040331	—	—
1/2			0.5000	2.1/4	3.3/4	6	040332	—	—
33/64			0.5156	2.3/8	3.7/8	1	046033	—	—
17/32			0.5313	2.3/8	3.7/8	1	046034	—	—
35/64			0.5469	2.1/2	4"	1	046035	—	—
9/16			0.5625	2.1/2	4"	1	046036	—	—
37/64			0.5781	2.5/8	4.1/8	1	046037	—	—
19/32			0.5937	2.5/8	4.1/8	1	046038	—	—
39/64			0.6094	2.3/4	4.1/4	1	046039	—	—
5/8			0.6250	2.3/4	4.1/4	1	046040	—	—
41/64			0.6406	2.7/8	4.1/2	1	046041	—	—
21/32			0.6563	2.7/8	4.1/2	1	046042	—	—
43/64			0.6719	2.7/8	4.5/8	1	046043	—	—
11/16			0.6875	2.7/8	4.5/8	1	046044	—	—
45/64			0.7031	3"	4.3/4	1	046045	—	—
23/32			0.7188	3"	4.3/4	1	046046	—	—
47/64			0.7344	3.1/8	5"	1	046047	—	—
3/4			0.7500	3.1/8	5"	1	046048	—	—

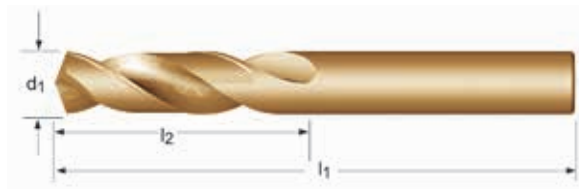
# COBALT SCREW MACHINE DRILL



## Heavy Duty Screw Machine Length, Metric

### 4ASMCO

Low thrust design self centering Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance and lubricity.



4ASMCO

DIN  
1897

2.5XD

HSS-E

135°



2.30 - 12.00

$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	4ASMCO
2.30	0.0906	13	40	12	032230
2.50	0.0984	14	43	12	032250
3.00	0.1181	16	46	12	032300
3.10	0.1220	18	49	12	032310
3.20	0.1260	18	49	12	032320
3.30	0.1299	18	49	12	032330
3.40	0.1339	20	52	12	032340
3.50	0.1378	20	52	12	032350
3.60	0.1417	20	52	12	032360
3.70	0.1457	20	52	12	032370
4.00	0.1575	22	55	12	032400
4.10	0.1614	22	55	12	032410
4.20	0.1654	22	55	12	032420
4.70	0.1850	24	58	12	032470
4.80	0.1890	26	62	12	032480
4.90	0.1929	26	62	12	032490
5.00	0.1969	26	62	12	032500
5.10	0.2008	26	62	12	032510
5.50	0.2165	28	66	12	032550
5.70	0.2244	28	66	12	032570
6.00	0.2362	28	66	12	032600
6.40	0.2520	31	70	12	032640
6.50	0.2559	31	70	12	032650
6.80	0.2677	34	74	12	032680
7.00	0.2756	34	74	12	032700
8.00	0.3150	37	79	6	032800
8.50	0.3346	37	79	6	032850
9.50	0.3740	40	84	6	032950
9.80	0.3858	43	89	6	032980
10.00	0.3937	43	89	6	033000
10.20	0.4016	43	89	6	033002
10.50	0.4134	43	89	6	033005
11.00	0.4331	47	95	6	033110
11.20	0.4409	47	95	6	033112
11.50	0.4528	47	95	6	033115
12.00	0.4724	51	102	6	033200



# TAPER LENGTH DRILL

## General Purpose Taper Length

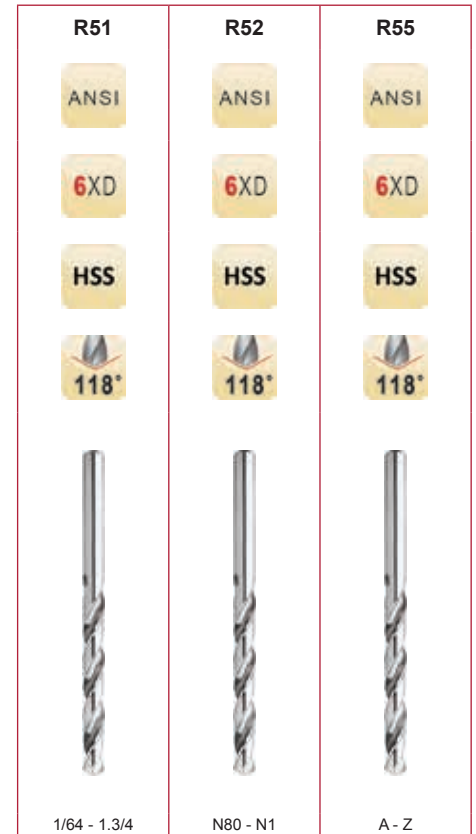
**R51** - Fractional Sizes

**R52** - Wire Gauge Sizes

**R55** - Letter Sizes

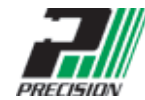
Bright finish improves chip flow in soft or non-ferrous materials.  
Longer flute and Overall length for depth and reach.

\* Sizes 45/64 and larger are steam oxide



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R51	R52	R55
	80		0.0135	5/16	1.1/2	12	—	052080	—
	79		0.0145	5/16	1.1/2	12	—	052079	—
1/64			0.0156	5/16	1.1/2	12	051001	—	—
	78		0.0160	5/16	1.1/2	12	—	052078	—
	77		0.0180	5/16	1.1/2	12	—	052077	—
	76		0.0200	5/16	1.1/2	12	—	052076	—
	75		0.0210	5/16	1.1/2	12	—	052075	—
	74		0.0225	5/16	1.1/2	12	—	052074	—
	73		0.0240	5/16	1.1/2	12	—	052073	—
	72		0.0250	5/16	1.1/2	12	—	052072	—
	71		0.0260	3/4	2"	12	—	052071	—
	70		0.0280	3/4	2"	12	—	052070	—
	69		0.0292	3/4	2"	12	—	052069	—
	68		0.0310	3/4	2"	12	—	052068	—
1/32			0.0313	3/4	2"	12	051002	—	—
	67		0.0320	3/4	2"	12	—	052067	—
	66		0.0330	3/4	2"	12	—	052066	—
	65		0.0350	3/4	2"	12	—	052065	—
	64		0.0360	3/4	2"	12	—	052064	—
	63		0.0370	3/4	2"	12	—	052063	—
	62		0.0380	3/4	2"	12	—	052062	—
	61		0.0390	1.1/8	2.1/4	12	—	052061	—
	60		0.0400	1.1/8	2.1/4	12	—	052060	—
	59		0.0410	1.1/8	2.1/4	12	—	052059	—
	58		0.0420	1.1/8	2.1/4	12	—	052058	—
	57		0.0430	1.1/8	2.1/4	12	—	052057	—
	56		0.0465	1.1/8	2.1/4	12	—	052056	—
3/64			0.0469	1.1/8	2.1/4	12	051003	—	—
	55		0.0520	1.3/4	3"	12	—	052055	—
	54		0.0550	1.3/4	3"	12	—	052054	—
	53		0.0595	1.3/4	3"	12	—	052053	—
1/16			0.0625	1.3/4	3"	12	051004	—	—

# TAPER LENGTH DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R51	R52	R55
	52		0.0635	2"	3.3/4	12	—	052052	—
	51		0.0670	2"	3.3/4	12	—	052051	—
	50		0.0700	2"	3.3/4	12	—	052050	—
	49		0.0730	2"	3.3/4	12	—	052049	—
	48		0.0760	2"	3.3/4	12	—	052048	—
5/64			0.0781	2"	3.3/4	12	051005	—	—
	47		0.0785	2.1/4	4.1/4	12	—	052047	—
	46		0.0810	2.1/4	4.1/4	12	—	052046	—
	45		0.0820	2.1/4	4.1/4	12	—	052045	—
	44		0.0860	2.1/4	4.1/4	12	—	052044	—
	43		0.0890	2.1/4	4.1/4	12	—	052043	—
	42		0.0935	2.1/4	4.1/4	12	—	052042	—
3/32			0.0938	2.1/4	4.1/4	12	051006	—	—
	41		0.0960	2.1/2	4.5/8	12	—	052041	—
	40		0.0980	2.1/2	4.5/8	12	—	052040	—
	39		0.0995	2.1/2	4.5/8	12	—	052039	—
	38		0.1015	2.1/2	4.5/8	12	—	052038	—
	37		0.1040	2.1/2	4.5/8	12	—	052037	—
	36		0.1065	2.1/2	4.5/8	12	—	052036	—
7/64			0.1094	2.1/2	4.5/8	12	051007	—	—
	35		0.1100	2.3/4	5.1/8	12	—	052035	—
	34		0.1110	2.3/4	5.1/8	12	—	052034	—
	33		0.1130	2.3/4	5.1/8	12	—	052033	—
	32		0.1160	2.3/4	5.1/8	12	—	052032	—
	31		0.1200	2.3/4	5.1/8	12	—	052031	—
1/8			0.1250	2.3/4	5.1/8	12	051008	—	—
	30		0.1285	3"	5.3/8	12	—	052030	—
	29		0.1360	3"	5.3/8	12	—	052029	—
	28		0.1405	3"	5.3/8	12	—	052028	—
9/64			0.1406	3"	5.3/8	12	051009	—	—
	27		0.1440	3"	5.3/8	12	—	052027	—
	26		0.1470	3"	5.3/8	12	—	052026	—
	25		0.1495	3"	5.3/8	12	—	052025	—
	24		0.1520	3"	5.3/8	12	—	052024	—
	23		0.1540	3"	5.3/8	12	—	052023	—
5/32			0.1563	3"	5.3/8	12	051010	—	—
	22		0.1570	3.3/8	5.3/4	12	—	052022	—
	21		0.1590	3.3/8	5.3/4	12	—	052021	—
	20		0.1610	3.3/8	5.3/4	12	—	052020	—
	19		0.1660	3.3/8	5.3/4	12	—	052019	—
	18		0.1695	3.3/8	5.3/4	12	—	052018	—
11/64			0.1719	3.3/8	5.3/4	12	051011	—	—
	17		0.1730	3.3/8	5.3/4	12	—	052017	—
	16		0.1770	3.3/8	5.3/4	12	—	052016	—
	15		0.1800	3.3/8	5.3/4	12	—	052015	—
	14		0.1820	3.3/8	5.3/4	12	—	052014	—
	13		0.1850	3.3/8	5.3/4	12	—	052013	—
3/16			0.1875	3.3/8	5.3/4	12	051012	—	—
	12		0.1890	3.5/8	6"	12	—	052012	—
	11		0.1910	3.5/8	6"	12	—	052011	—
	10		0.1935	3.5/8	6"	12	—	052010	—
	9		0.1960	3.5/8	6"	12	—	052009	—
	8		0.1990	3.5/8	6"	12	—	052008	—
	7		0.2010	3.5/8	6"	12	—	052007	—
13/64			0.2031	3.5/8	6"	12	051013	—	—
	6		0.2040	3.5/8	6"	12	—	052006	—
	5		0.2055	3.5/8	6"	12	—	052005	—
	4		0.2090	3.5/8	6"	12	—	052004	—
	3		0.2130	3.5/8	6"	12	—	052003	—
7/32			0.2188	3.5/8	6"	12	051014	—	—
	2		0.2210	3.3/4	6.1/8	12	—	052002	—
	1		0.2280	3.3/4	6.1/8	12	—	052001	—
		A	0.2340	3.3/4	6.1/8	12	—	—	055001
15/64			0.2344	3.3/4	6.1/8	12	051015	—	—
		B	0.2380	3.3/4	6.1/8	12	—	—	055002
		C	0.2420	3.3/4	6.1/8	12	—	—	055003





# TAPER LENGTH DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R51	R52	R55
		D	0.2460	3.3/4	6.1/8	12	—	—	055004
		E	0.2500	3.3/4	6.1/8	12	—	—	055005
1/4			0.2500	3.3/4	6.1/8	12	051016	—	—
		F	0.2570	3.7/8	6.1/4	12	—	—	055006
		G	0.2610	3.7/8	6.1/4	6	—	—	055007
17/64			0.2656	3.7/8	6.1/4	6	051017	—	—
		H	0.2660	3.7/8	6.1/4	6	—	—	—
		I	0.2720	3.7/8	6.1/4	6	—	—	055009
		J	0.2770	3.7/8	6.1/4	6	—	—	055010
		K	0.2810	3.7/8	6.1/4	6	—	—	055011
9/32			0.2813	3.7/8	6.1/4	6	051018	—	—
		L	0.2900	4"	6.3/8	6	—	—	055012
		M	0.2950	4"	6.3/8	6	—	—	055013
19/64			0.2969	4"	6.3/8	6	051019	—	—
		N	0.3020	4"	6.3/8	6	—	—	055014
5/16			0.3125	4"	6.3/8	6	051020	—	—
		O	0.3161	4.1/8	6.1/2	6	—	—	055015
		P	0.3230	4.1/8	6.1/2	6	—	—	055016
21/64			0.3281	4.1/8	6.1/2	6	051021	—	—
		Q	0.3320	4.1/8	6.1/2	6	—	—	055017
		R	0.3390	4.1/8	6.1/2	6	—	—	055018
11/32			0.3437	4.1/8	6.1/2	6	051022	—	—
		S	0.3480	4.1/4	6.3/4	6	—	—	055019
		T	0.3580	4.1/4	6.3/4	6	—	—	055020
23/64			0.3594	4.1/4	6.3/4	6	051023	—	—
		U	0.3680	4.1/4	6.3/4	6	—	—	055021
3/8			0.3750	4.1/4	6.3/4	6	051024	—	—
		V	0.3770	4.3/8	7"	6	—	—	055022
		W	0.3860	4.3/8	7"	6	—	—	055023
25/64			0.3906	4.3/8	7"	6	051025	—	—
		X	0.3970	4.3/8	7"	6	—	—	055024
		Y	0.4040	4.3/8	7"	6	—	—	055025
13/32			0.4063	4.3/8	7"	6	051026	—	—
		Z	0.4130	4.5/8	7.1/4	6	—	—	055026
27/64			0.4219	4.5/8	7.1/4	6	051027	—	—
7/16			0.4375	4.5/8	7.1/4	6	051028	—	—
29/64			0.4531	4.3/4	7.1/2	6	051029	—	—
15/32			0.4687	4.3/4	7.1/2	6	051030	—	—
31/64			0.4844	4.3/4	7.3/4	6	051031	—	—
1/2			0.5000	4.3/4	7.3/4	6	051032	—	—
33/64			0.5156	4.3/4	8"	1	051033	—	—
17/32			0.5313	4.3/4	8"	1	051034	—	—
35/64			0.5469	4.7/8	8.1/4	1	051035	—	—
9/16			0.5625	4.7/8	8.1/4	1	051036	—	—
37/64			0.5781	4.7/8	8.3/4	1	051037	—	—
19/32			0.5937	4.7/8	8.3/4	1	051038	—	—
39/64			0.6094	4.7/8	8.3/4	1	051039	—	—
5/8			0.6250	4.7/8	8.3/4	1	051040	—	—
41/64			0.6406	5.1/8	9"	1	051041	—	—
21/32			0.6563	5.1/8	9"	1	051042	—	—
43/64			0.6719	5.3/8	9.1/4	1	051043	—	—
11/16			0.6875	5.3/8	9.1/4	1	051044	—	—
45/64			0.7031	5.5/8	9.1/2	1	051045	<sup>1)</sup>	—
23/32			0.7188	5.5/8	9.1/2	1	051046	<sup>1)</sup>	—
47/64			0.7344	5.7/8	9.3/4	1	051047	<sup>1)</sup>	—
3/4			0.7500	5.7/8	9.3/4	1	051048	<sup>1)</sup>	—
49/64			0.7656	6"	9.7/8	1	051049	<sup>1)</sup>	—
25/32			0.7813	6"	9.7/8	1	051050	<sup>1)</sup>	—
51/64			0.7969	6.1/8	10"	1	051051	<sup>1)</sup>	—
13/16			0.8125	6.1/8	10"	1	051052	<sup>1)</sup>	—
53/64			0.8281	6.1/8	10"	1	051053	<sup>1)</sup>	—
27/32			0.8438	6.1/8	10"	1	051054	<sup>1)</sup>	—
55/64			0.8594	6.1/8	10"	1	051055	<sup>1)</sup>	—
7/8			0.8750	6.1/8	10"	1	051056	<sup>1)</sup>	—
57/64			0.8906	6.1/8	10"	1	051057	<sup>1)</sup>	—

<sup>1)</sup> steam oxide

# TAPER LENGTH DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	R51	R52	R55
29/32			0.9063	6.1/8	10"	1	051058 <sup>1)</sup>	—	—
59/64			0.9219	6.1/8	10.3/4	1	051059 <sup>1)</sup>	—	—
15/16			0.9375	6.1/8	10.3/4	1	051060 <sup>1)</sup>	—	—
61/64			0.9531	6.3/8	11"	1	051061 <sup>1)</sup>	—	—
31/32			0.9688	6.3/8	11"	1	051062 <sup>1)</sup>	—	—
63/64			0.9844	6.3/8	11"	1	051063 <sup>1)</sup>	—	—
1"			1.0000	6.3/8	11"	1	051100 <sup>1)</sup>	—	—
1.1/64			1.0156	6.1/2	11.1/8	1	051101 <sup>1)</sup>	—	—
1.1/32			1.0312	6.1/2	11.1/8	1	051102 <sup>1)</sup>	—	—
1.3/64			1.0469	6.5/8	11.1/4	1	051103 <sup>1)</sup>	—	—
1.1/16			1.0625	6.5/8	11.1/4	1	051104 <sup>1)</sup>	—	—
1.5/64			1.0781	6.7/8	11.1/2	1	051105 <sup>1)</sup>	—	—
1.3/32			1.0937	6.7/8	11.1/2	1	051106 <sup>1)</sup>	—	—
1.7/64			1.1094	7.1/8	11.3/4	1	051107 <sup>1)</sup>	—	—
1.1/8			1.1250	7.1/8	11.3/4	1	051108 <sup>1)</sup>	—	—
1.9/64			1.1406	7.1/4	11.7/8	1	051109 <sup>1)</sup>	—	—
1.5/32			1.1563	7.1/4	11.7/8	1	051110 <sup>1)</sup>	—	—
1.11/64			1.1719	7.3/8	12"	1	051111 <sup>1)</sup>	—	—
1.3/16			1.1875	7.3/8	12"	1	051112 <sup>1)</sup>	—	—
1.13/64			1.2031	7.1/2	12.1/8	1	051113 <sup>1)</sup>	—	—
1.7/32			1.2187	7.1/2	12.1/8	1	051114 <sup>1)</sup>	—	—
1.15/64			1.2344	7.7/8	12.1/2	1	051115 <sup>1)</sup>	—	—
1.1/4			1.2500	7.7/8	12.1/2	1	051116 <sup>1)</sup>	—	—
1.5/16			1.3125	8.5/8	14.1/4	1	051120 <sup>1)</sup>	—	—
1.3/8			1.3750	8.7/8	14.1/2	1	051124 <sup>1)</sup>	—	—
1.7/16			1.4375	9.1/8	14.3/4	1	051128 <sup>1)</sup>	—	—
1.1/2			1.5000	9.3/8	15"	1	051132 <sup>1)</sup>	—	—
1.9/16			1.5625	9.5/8	15.1/4	1	051136 <sup>1)</sup>	—	—
1.5/8			1.6250	9.7/8	15.5/8	1	051140 <sup>1)</sup>	—	—
1.3/4			1.7500	10.1/2	16.1/4	1	051148 <sup>1)</sup>	—	—

<sup>1)</sup> steam oxide

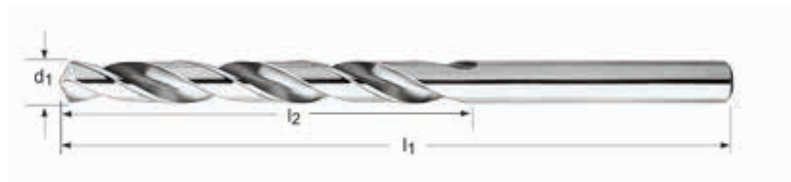


# TAPER LENGTH DRILL

## General Purpose Taper Length, Metric

**5ATL** Bright Finish improves chip flow in soft or non-ferrous materials. Longer Flute and Overall length for depth and reach.

\* 18mm and larger are steam oxide



**5ATL**

**DIN 340**

**6XD**

**HSS**

**118°**



1.00 - 31.00

d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	5ATL
1.00	0.0394	33	56	12	056100
1.20	0.0472	41	65	12	056120
1.25	0.0492	41	65	12	056125
1.30	0.0512	41	65	12	056130
1.40	0.0551	45	70	12	056140
1.50	0.0591	45	70	12	056150
1.60	0.0630	50	76	12	056160
1.70	0.0669	50	76	12	056170
1.80	0.0709	53	80	12	056180
1.90	0.0748	53	80	12	056190
2.00	0.0787	56	85	12	056200
2.10	0.0827	56	85	12	056210
2.15	0.0846	59	90	12	056215
2.20	0.0866	59	90	12	056220
2.30	0.0906	59	90	12	056230
2.40	0.0945	62	95	12	056240
2.50	0.0984	62	95	12	056250
3.00	0.1181	66	100	12	056300
3.10	0.1220	69	106	12	056310
3.20	0.1260	69	106	12	056320
3.30	0.1299	69	106	12	056330
3.40	0.1339	73	112	12	056340
3.50	0.1378	73	112	12	056350
3.60	0.1417	73	112	12	056360
3.70	0.1457	73	112	12	056370
3.80	0.1496	78	119	12	056380
4.00	0.1575	78	119	12	056400
4.20	0.1654	78	119	12	056420
4.30	0.1693	82	126	12	056430
4.50	0.1772	82	126	12	056450
4.60	0.1811	82	126	12	056460
4.80	0.1890	87	132	12	056480

# TAPER LENGTH DRILL



d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	5ATL
5.00	0.1969	87	132	12	056500
5.50	0.2165	91	139	12	056550
5.60	0.2205	91	139	12	056560
5.70	0.2244	91	139	12	056570
6.00	0.2362	91	139	12	056600
6.40	0.2520	97	148	6	056640
6.50	0.2559	97	148	6	056650
6.80	0.2677	102	156	6	056680
7.00	0.2756	102	156	6	056770
7.20	0.2835	102	156	6	056720
7.50	0.2953	102	156	6	056750
7.80	0.3071	109	165	6	056780
8.00	0.3150	109	165	6	056800
8.20	0.3228	109	165	6	056820
8.50	0.3346	109	165	6	056850
9.00	0.3543	115	175	6	056900
9.20	0.3622	115	175	6	056920
9.50	0.3740	115	175	6	056950
9.80	0.3858	121	184	6	056980
10.00	0.3937	121	184	6	057100
10.20	0.4016	121	184	6	057102
10.50	0.4134	121	184	6	057105
11.00	0.4331	128	195	6	057110
11.20	0.4409	128	195	6	057112
11.50	0.4528	128	195	6	057115
12.00	0.4724	134	205	6	057120
12.50	0.4921	134	205	6	057125
13.00	0.5118	134	205	1	057130
13.50	0.5315	140	214	1	057135
13.80	0.5433	140	214	1	057138
14.00	0.5512	140	214	1	057140
14.50	0.5709	144	220	1	057145
15.00	0.5906	144	220	1	057150
15.50	0.6102	149	227	1	057155
16.00	0.6299	149	227	1	057160
16.50	0.6496	154	235	1	057165
17.00	0.6693	154	235	1	057170
17.50	0.6890	158	241	1	057175
18.00	0.7087	158	241	1	057180 <sup>1)</sup>
18.50	0.7283	162	247	1	057185 <sup>1)</sup>
19.00	0.7480	162	247	1	057190 <sup>1)</sup>
19.50	0.7677	166	254	1	057195 <sup>1)</sup>
20.00	0.7874	166	254	1	057200 <sup>1)</sup>
20.50	0.8071	171	261	1	057205 <sup>1)</sup>
21.00	0.8268	171	261	1	057210 <sup>1)</sup>
21.50	0.8465	176	268	1	057215 <sup>1)</sup>
22.00	0.8661	176	268	1	057220 <sup>1)</sup>
22.50	0.8858	180	275	1	057225 <sup>1)</sup>
23.00	0.9055	180	275	1	057230 <sup>1)</sup>
23.50	0.9252	180	275	1	057235 <sup>1)</sup>
24.00	0.9449	185	282	1	057240 <sup>1)</sup>
24.50	0.9646	185	282	1	057245 <sup>1)</sup>
25.00	0.9843	185	282	1	057250 <sup>1)</sup>
25.50	1.0039	190	290	1	057255 <sup>1)</sup>
26.00	1.0236	190	290	1	057260 <sup>1)</sup>
26.50	1.0433	190	290	1	057265 <sup>1)</sup>
27.00	1.0630	195	298	1	057270 <sup>1)</sup>
28.00	1.1024	195	298	1	057280 <sup>1)</sup>
28.50	1.1220	201	307	1	057285 <sup>1)</sup>
29.00	1.1417	201	307	1	057290 <sup>1)</sup>
29.50	1.1614	201	307	1	057295 <sup>1)</sup>
30.00	1.1811	201	307	1	057300 <sup>1)</sup>
30.50	1.2008	207	316	1	057305 <sup>1)</sup>
31.00	1.2205	207	316	1	057310 <sup>1)</sup>

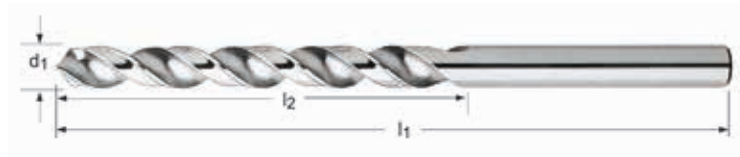
<sup>1)</sup> steam oxide



# TAPER LENGTH DRILL

## High Helix Taper Length

**R51FS** High Helix and Bright Finish for better chip flow in soft or non-ferrous materials. Longer Flute and Overall length for depth and reach.



R51FS



1/16 - 1/2

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	R51FS
1/16	0.0625	1.3/4	3"	12	051504
5/64	0.0781	2"	3.3/4	12	051505
3/32	0.0938	2.1/4	4.1/4	12	051506
7/64	0.1094	2.1/2	4.5/8	12	051507
1/8	0.1250	2.3/4	5.1/8	12	051508
9/64	0.1406	3"	5.3/8	12	051509
5/32	0.1563	3"	5.3/8	12	051510
11/64	0.1719	3.3/8	5.3/4	12	051511
3/16	0.1875	3.3/8	5.3/4	12	051512
13/64	0.2031	3.5/8	6"	12	051513
7/32	0.2188	3.5/8	6"	12	051514
15/64	0.2344	3.3/4	6.1/8	12	051515
1/4	0.2500	3.3/4	6.1/8	12	051516
17/64	0.2656	3.7/8	6.1/4	6	051517
9/32	0.2813	3.7/8	6.1/4	6	051518
19/64	0.2969	4"	6.3/8	6	051519
5/16	0.3125	4"	6.3/8	6	051520
21/64	0.3281	4.1/8	6.1/2	6	051521
11/32	0.3437	4.1/8	6.1/2	6	051522
23/64	0.3594	4.1/4	6.3/4	6	051523
3/8	0.3750	4.1/4	6.3/4	6	051524
25/64	0.3906	4.3/8	7"	6	051525
13/32	0.4063	4.3/8	7"	6	051526
27/64	0.4219	4.5/8	7.1/4	6	051527
7/16	0.4375	4.5/8	7.1/4	6	051528
29/64	0.4531	4.3/4	7.1/2	6	051529
15/32	0.4687	4.3/4	7.1/2	6	051530
31/64	0.4844	4.3/4	7.3/4	6	051531
1/2	0.5000	4.3/4	7.3/4	6	051532

# TAPER LENGTH DRILL

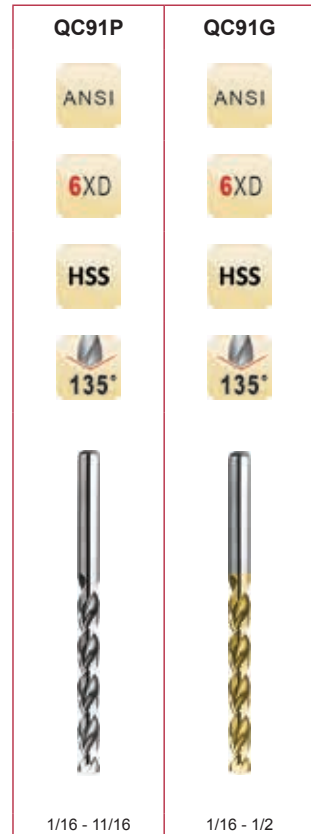


## General Purpose Taper Length Parabolic Flute

Heavy-Duty Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration.

**QC91P** Bright Finish improves chip flow in soft or non-ferrous materials.

**QC91G** TiN Coating increases wear resistance and improves tool life.



$d_1$ Ø "/Nr.	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	QC91P	QC91G
1/16	0.0625	1.3/4	3"	12	057904	055904
52	0.0635	2"	3.3/4	12	059452	050952
51	0.0670	2"	3.3/4	12	059451	050951
50	0.0700	2"	3.3/4	12	059450	050950
49	0.0730	2"	3.3/4	12	059449	050949
48	0.0760	2"	3.3/4	12	059448	—
5/64	0.0781	2"	3.3/4	12	057905	055905
47	0.0785	2.1/4	4.1/4	12	059447	050947
46	0.0810	2.1/4	4.1/4	12	059446	050946
45	0.0820	2.1/4	4.1/4	12	059445	050945
44	0.0860	2.1/4	4.1/4	12	059444	050944
43	0.0890	2.1/4	4.1/4	12	059443	050943
42	0.0935	2.1/4	4.1/4	12	059442	050942
3/32	0.0938	2.1/4	4.1/4	12	057906	055906
41	0.0960	2.1/2	4.5/8	12	059441	050941
40	0.0980	2.1/2	4.5/8	12	059440	050940
39	0.0995	2.1/2	4.5/8	12	059439	050939
38	0.1015	2.1/2	4.5/8	12	059438	050938
37	0.1040	2.1/2	4.5/8	12	059437	050937
36	0.1065	2.1/2	4.5/8	12	059436	050936
7/64	0.1094	2.1/2	4.5/8	12	057907	055907
35	0.1100	2.3/4	5.1/8	12	059435	050935
34	0.1110	2.3/4	5.1/8	12	059434	050934
33	0.1130	2.3/4	5.1/8	12	059433	—
32	0.1160	2.3/4	5.1/8	12	059432	050932
31	0.1200	2.3/4	5.1/8	12	059431	050931
1/8	0.1250	2.3/4	5.1/8	12	057908	055908
30	0.1285	3"	5.3/8	12	059430	050930
29	0.1360	3"	5.3/8	12	059429	050929
28	0.1405	3"	5.3/8	12	059428	050928
9/64	0.1406	3"	5.3/8	12	057909	055909
27	0.1440	3"	5.3/8	12	059427	—
26	0.1470	3"	5.3/8	12	059426	050926



# TAPER LENGTH DRILL

d <sub>1</sub> Ø “/Nr.	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	QC91P	QC91G
25	0.1495	3"	5.3/8	12	059425	050925
24	0.1520	3"	5.3/8	12	059424	050924
23	0.1540	3"	5.3/8	12	059423	—
5/32	0.1563	3"	5.3/8	12	057910	055910
22	0.1570	3.3/8	5.3/4	12	059422	—
21	0.1590	3.3/8	5.3/4	12	059421	050921
20	0.1610	3.3/8	5.3/4	12	059420	050920
19	0.1660	3.3/8	5.3/4	12	059419	050919
18	0.1695	3.3/8	5.3/4	12	059418	050918
11/64	0.1719	3.3/8	5.3/4	12	057911	055911
17	0.1730	3.3/8	5.3/4	12	059417	050917
16	0.1770	3.3/8	5.3/4	12	059416	050916
15	0.1800	3.3/8	5.3/4	12	059415	050915
14	0.1820	3.3/8	5.3/4	12	059414	050914
13	0.1850	3.3/8	5.3/4	12	059413	050913
3/16	0.1875	3.3/8	5.3/4	12	057912	055912
12	0.1890	3.5/8	6"	12	059412	—
11	0.1910	3.5/8	6"	12	059411	050911
10	0.1935	3.5/8	6"	12	059410	—
9	0.1960	3.5/8	6"	12	059409	050909
8	0.1990	3.5/8	6"	12	059408	050908
7	0.2010	3.5/8	6"	12	059407	050907
13/64	0.2031	3.5/8	6"	12	057913	055913
6	0.2040	3.5/8	6"	12	059406	050906
5	0.2055	3.5/8	6"	12	059405	050905
4	0.2090	3.5/8	6"	12	059404	050904
3	0.2130	3.5/8	6"	12	059403	050903
7/32	0.2188	3.5/8	6"	12	057914	055914
2	0.2210	3.3/4	6.1/8	12	059402	050902
1	0.2280	3.3/4	6.1/8	12	059401	—
15/64	0.2344	3.3/4	6.1/8	12	057915	055915
1/4	0.2500	3.3/4	6.1/8	12	057916	055916
17/64	0.2656	3.7/8	6.1/4	6	057917	055917
9/32	0.2813	3.7/8	6.1/4	6	057918	055918
19/64	0.2969	4"	6.3/8	6	057919	055919
5/16	0.3125	4"	6.3/8	6	057920	055920
21/64	0.3281	4.1/8	6.1/2	6	057921	055921
11/32	0.3437	4.1/8	6.1/2	6	057922	055922
23/64	0.3594	4.1/4	6.3/4	6	057923	—
3/8	0.3750	4.1/4	6.3/4	6	057924	055924
25/64	0.3906	4.3/8	7"	6	057925	055925
13/32	0.4063	4.3/8	7"	6	057926	055926
27/64	0.4219	4.5/8	7.1/4	6	057927	055927
7/16	0.4375	4.5/8	7.1/4	6	057928	055928
29/64	0.4531	4.3/4	7.1/2	6	057929	055929
15/32	0.4687	4.3/4	7.1/2	6	057930	—
31/64	0.4844	4.3/4	7.3/4	6	057931	—
1/2	0.5000	4.3/4	7.3/4	6	057932	055932
33/64	0.5156	4.3/4	8"	1	057933	—
17/32	0.5313	4.3/4	8"	1	057934	—
35/64	0.5469	4.7/8	8.1/4	1	057935	—
9/16	0.5625	4.7/8	8.1/4	1	057936	—
37/64	0.5781	4.7/8	8.3/4	1	057937	—
19/32	0.5937	4.7/8	8.3/4	1	057938	—
5/8	0.6250	4.7/8	8.3/4	1	057940	—
21/32	0.6563	5.1/8	9"	1	057942	—
11/16	0.6875	5.3/8	9.1/4	1	057944	—

# TAPER LENGTH DRILL

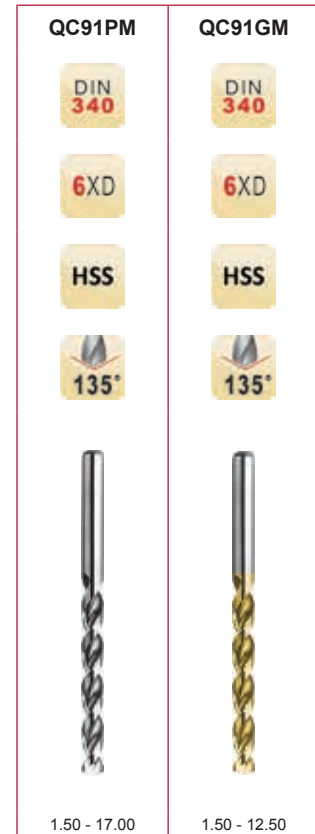
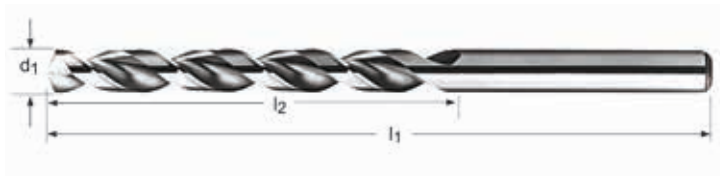


## General Purpose Taper Length Parabolic Flute, Metric

Heavy-Duty Parabolic Flute design for efficient chip evacuation. Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration.

**QC91PM** Bright Finish improves chip flow in soft or non-ferrous materials.

**QC91GM** TiN Coating increases wear resistance and improves tool life.



$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	QC91PM	QC91GM
1.50	0.0591	45	70	12	050015	050215
2.00	0.0787	56	85	12	050020	050220
2.50	0.0984	62	95	12	050025	050225
3.00	0.1181	66	100	12	050030	050230
3.50	0.1378	73	112	12	050035	050235
4.00	0.1575	78	119	12	050040	050240
4.50	0.1772	82	126	12	050045	050245
5.00	0.1969	87	132	12	050050	050250
5.20	0.2047	87	132	12	050052	050252
5.50	0.2165	91	139	12	050055	050255
6.00	0.2362	91	139	12	050060	050260
6.50	0.2559	97	148	6	050065	050265
6.80	0.2677	102	156	6	050068	—
7.00	0.2756	102	156	6	050070	050270
8.00	0.3150	109	165	6	050080	050280
8.20	0.3228	109	165	6	050082	—
8.50	0.3346	109	165	6	050085	050285
8.60	0.3386	115	175	6	050086	050286
9.00	0.3543	115	175	6	050090	050290
9.50	0.3740	115	175	6	050095	—
10.00	0.3937	121	184	6	050100	050300
10.50	0.4134	121	184	6	050105	050305
11.00	0.4331	128	195	6	050110	—
12.00	0.4724	134	205	6	050120	050320
12.50	0.4921	134	205	6	050125	050325
13.00	0.5118	134	205	1	050130	—
13.50	0.5315	140	214	1	050135	—
14.00	0.5512	140	214	1	050140	—
15.00	0.5906	144	220	1	050150	—
15.50	0.6102	149	227	1	050155	—
16.00	0.6299	149	227	1	050160	—
17.00	0.6693	154	235	1	050170	—





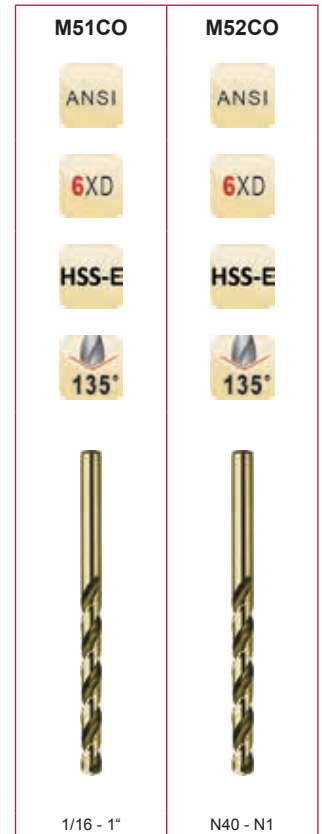
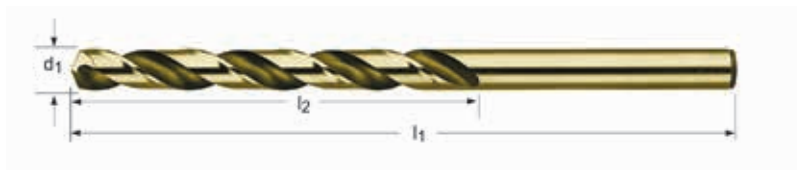
# COBALT TAPER LENGTH DRILL

## Heavy Duty Taper Length

**M51CO** - Fractional Sizes

**M52CO** - Wire Gauge Sizes

Low thrust design Heavy Duty self centering Split Point for easier penetration.  
Cobalt base material with Bronze Oxide for wear resistance and lubricity.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	M51CO	M52CO
1/16		0.0625	1.3/4	3"	12	051304	—
5/64		0.0781	2"	3.3/4	12	051305	—
3/32		0.0938	2.1/4	4.1/4	12	051306	—
	40	0.0980	2.1/2	4.5/8	12	—	052340
	39	0.0995	2.1/2	4.5/8	12	—	052339
	36	0.1065	2.1/2	4.5/8	12	—	052336
7/64		0.1094	2.1/2	4.5/8	12	051307	—
	35	0.1100	2.3/4	5.1/8	12	—	052335
	34	0.1110	2.3/4	5.1/8	12	—	052334
	33	0.1130	2.3/4	5.1/8	12	—	052333
	32	0.1160	2.3/4	5.1/8	12	—	052332
	31	0.1200	2.3/4	5.1/8	12	—	052331
1/8		0.1250	2.3/4	5.1/8	12	051308	—
	30	0.1285	3"	5.3/8	12	—	052330
	29	0.1360	3"	5.3/8	12	—	052329
	28	0.1405	3"	5.3/8	12	—	052328
9/64		0.1406	3"	5.3/8	12	051309	—
	27	0.1440	3"	5.3/8	12	—	052327
	26	0.1470	3"	5.3/8	12	—	052326
	25	0.1495	3"	5.3/8	12	—	052325
	24	0.1520	3"	5.3/8	12	—	052324
5/32		0.1563	3"	5.3/8	12	051310	—
	22	0.1570	3.3/8	5.3/4	12	—	052322
	21	0.1590	3.3/8	5.3/4	12	—	052321
	20	0.1610	3.3/8	5.3/4	12	—	052320
	19	0.1660	3.3/8	5.3/4	12	—	052319
	18	0.1695	3.3/8	5.3/4	12	—	052318
11/64		0.1719	3.3/8	5.3/4	12	051311	—
	17	0.1730	3.3/8	5.3/4	12	—	052317
	16	0.1770	3.3/8	5.3/4	12	—	052316
	15	0.1800	3.3/8	5.3/4	12	—	052315
	14	0.1820	3.3/8	5.3/4	12	—	052314

# COBALT TAPER LENGTH DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	M51CO	M52CO
	13	0.1850	3.3/8	5.3/4	12	—	052313
3/16		0.1875	3.3/8	5.3/4	12	051312	—
	12	0.1890	3.5/8	6"	12	—	052312
	11	0.1910	3.5/8	6"	12	—	052311
	10	0.1935	3.5/8	6"	12	—	052310
	9	0.1960	3.5/8	6"	12	—	052309
	8	0.1990	3.5/8	6"	12	—	052308
	7	0.2010	3.5/8	6"	12	—	052307
13/64		0.2031	3.5/8	6"	12	051313	—
	5	0.2055	3.5/8	6"	12	—	052305
	4	0.2090	3.5/8	6"	12	—	052304
	3	0.2130	3.5/8	6"	12	—	052303
7/32		0.2188	3.5/8	6"	12	051314	—
	2	0.2210	3.3/4	6.1/8	12	—	052302
	1	0.2280	3.3/4	6.1/8	12	—	052301
15/64		0.2344	3.3/4	6.1/8	12	051315	—
1/4		0.2500	3.3/4	6.1/8	12	051316	—
17/64		0.2656	3.7/8	6.1/4	6	051317	—
9/32		0.2813	3.7/8	6.1/4	6	051318	—
19/64		0.2969	4"	6.3/8	6	051319	—
5/16		0.3125	4"	6.3/8	6	051320	—
21/64		0.3281	4.1/8	6.1/2	6	051321	—
11/32		0.3437	4.1/8	6.1/2	6	051322	—
23/64		0.3594	4.1/4	6.3/4	6	051323	—
3/8		0.3750	4.1/4	6.3/4	6	051324	—
25/64		0.3906	4.3/8	7"	6	051325	—
13/32		0.4063	4.3/8	7"	6	051326	—
27/64		0.4219	4.5/8	7.1/4	6	051327	—
7/16		0.4375	4.5/8	7.1/4	6	051328	—
29/64		0.4531	4.3/4	7.1/2	6	051329	—
15/32		0.4687	4.3/4	7.1/2	6	051330	—
31/64		0.4844	4.3/4	7.3/4	6	051331	—
1/2		0.5000	4.3/4	7.3/4	6	051332	—
33/64		0.5156	4.3/4	8"	1	051333	<sup>1)</sup> —
17/32		0.5313	4.3/4	8"	1	051334	<sup>1)</sup> —
35/64		0.5469	4.7/8	8.1/4	1	051335	<sup>1)</sup> —
9/16		0.5625	4.7/8	8.1/4	1	051336	<sup>1)</sup> —
37/64		0.5781	4.7/8	8.3/4	1	051337	<sup>1)</sup> —
19/32		0.5937	4.7/8	8.3/4	1	051338	<sup>1)</sup> —
39/64		0.6094	4.7/8	8.3/4	1	051339	<sup>1)</sup> —
5/8		0.6250	4.7/8	8.3/4	1	051340	<sup>1)</sup> —
41/64		0.6406	5.1/8	9"	1	051341	<sup>1)</sup> —
21/32		0.6563	5.1/8	9"	1	051342	<sup>1)</sup> —
43/64		0.6719	5.3/8	9.1/4	1	051343	<sup>1)</sup> —
11/16		0.6875	5.3/8	9.1/4	1	051344	<sup>1)</sup> —
45/64		0.7031	5.5/8	9.1/2	1	051345	<sup>1)</sup> —
23/32		0.7188	5.5/8	9.1/2	1	051346	<sup>1)</sup> —
47/64		0.7344	5.7/8	9.3/4	1	051347	<sup>1)</sup> —
3/4		0.7500	5.7/8	9.3/4	1	051348	<sup>1)</sup> —
49/64		0.7656	6"	9.7/8	1	051349	<sup>1)</sup> —
25/32		0.7813	6"	9.7/8	1	051350	<sup>1)</sup> —
51/64		0.7969	6.1/8	10"	1	051351	<sup>1)</sup> —
13/16		0.8125	6.1/8	10"	1	051352	<sup>1)</sup> —
53/64		0.8281	6.1/8	10"	1	051353	<sup>1)</sup> —
27/32		0.8438	6.1/8	10"	1	051354	<sup>1)</sup> —
55/64		0.8594	6.1/8	10"	1	051355	<sup>1)</sup> —
7/8		0.8750	6.1/8	10"	1	051356	<sup>1)</sup> —
57/64		0.8906	6.1/8	10"	1	051357	<sup>1)</sup> —
29/32		0.9063	6.1/8	10"	1	051358	<sup>1)</sup> —
59/64		0.9219	6.1/8	10.3/4	1	051359	<sup>1)</sup> —
15/16		0.9375	6.1/8	10.3/4	1	051360	<sup>1)</sup> —
61/64		0.9531	6.3/8	11"	1	051361	<sup>1)</sup> —
31/32		0.9688	6.3/8	11"	1	051362	<sup>1)</sup> —
63/64		0.9844	6.3/8	11"	1	051363	<sup>1)</sup> —
1"		1.0000	6.3/8	11"	1	051364	<sup>1)</sup> —

<sup>1)</sup> Notched Point



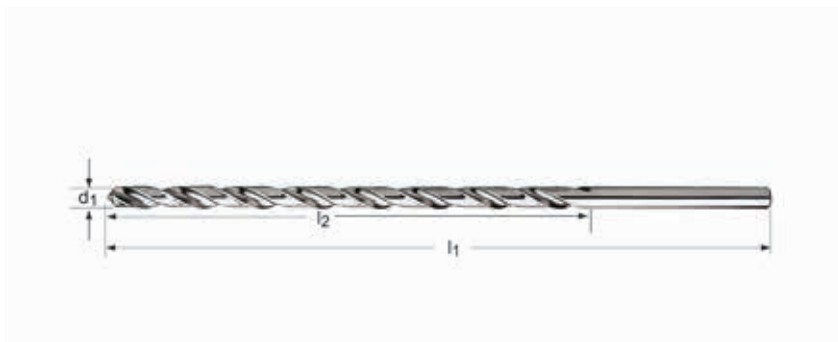
# EXTRA LENGTH DRILL

## General Purpose Extra Length

**0860** 8" Overall length

**1290** 12" Overall length

Bright Finish improves chip flow in soft or non-ferrous materials



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	0860	1290
1/8	0.1250	6"	8"	1	057408	—
1/8	0.1250	9"	12"	1	—	059608
9/64	0.1406	9"	12"	1	—	059609
5/32	0.1563	6"	8"	1	057410	—
5/32	0.1563	9"	12"	1	—	059610
11/64	0.1719	9"	12"	1	—	059611
3/16	0.1875	6"	8"	1	057412	—
3/16	0.1875	9"	12"	1	—	059612
13/64	0.2031	9"	12"	1	—	059613
7/32	0.2188	6"	8"	1	057414	—
7/32	0.2188	9"	12"	1	—	059614
15/64	0.2344	9"	12"	1	—	059615
1/4	0.2500	6"	8"	1	057416	—
1/4	0.2500	9"	12"	1	—	059616
17/64	0.2656	9"	12"	1	—	059617
9/32	0.2813	6"	8"	1	057418	—
9/32	0.2813	9"	12"	1	—	059618
19/64	0.2969	9"	12"	1	—	059619
5/16	0.3125	6"	8"	1	057420	—
5/16	0.3125	9"	12"	1	—	059620
21/64	0.3281	9"	12"	1	—	059621
11/32	0.3437	6"	8"	1	057422	—
11/32	0.3437	9"	12"	1	—	059622
23/64	0.3594	9"	12"	1	—	059623
3/8	0.3750	6"	8"	1	057424	—
3/8	0.3750	9"	12"	1	—	059624
25/64	0.3906	9"	12"	1	—	059625
13/32	0.4063	6"	8"	1	057426	—
13/32	0.4063	9"	12"	1	—	059626
27/64	0.4219	9"	12"	1	—	059627
7/16	0.4375	6"	8"	1	057428	—
7/16	0.4375	9"	12"	1	—	059628

# EXTRA LENGTH DRILL



$d_1$ Ø	$d_1$ decimal	$l_2$	$l_1$	Pack Qty	0860	1290
Inch	Inch	Inch	Inch			
29/64	0.4531	9"	12"	1	—	059629
15/32	0.4687	6"	8"	1	057430	—
15/32	0.4687	9"	12"	1	—	059630
31/64	0.4844	9"	12"	1	—	059631
1/2	0.5000	6"	8"	1	057432	—
1/2	0.5000	9"	12"	1	—	059632
33/64	0.5156	9"	12"	1	—	059633 <sup>1)</sup>
17/32	0.5313	9"	12"	1	—	059634 <sup>1)</sup>
35/64	0.5469	9"	12"	1	—	059635 <sup>1)</sup>
9/16	0.5625	9"	12"	1	—	059636 <sup>1)</sup>
37/64	0.5781	9"	12"	1	—	059637 <sup>1)</sup>
19/32	0.5937	9"	12"	1	—	059638 <sup>1)</sup>
39/64	0.6094	9"	12"	1	—	059639 <sup>1)</sup>
5/8	0.6250	9"	12"	1	—	059640 <sup>1)</sup>
21/32	0.6563	9"	12"	1	—	059642 <sup>1)</sup>
11/16	0.6875	9"	12"	1	—	059644 <sup>1)</sup>
23/32	0.7188	9"	12"	1	—	059646 <sup>1)</sup>
3/4	0.7500	9"	12"	1	—	059648 <sup>1)</sup>

1) 33/64 and larger are steam oxide

## General Purpose Extra Length

**1511** Bright Finish improves chip flow in soft or  
**1813** non-ferrous materials

**A125** Steam Oxide for increased wear  
 resistance & lubricity.



1813 Series - 33/64 and larger are steam oxide  
 1511 Series - 17/32 and larger are steam oxide  
 A125 Series - under 3/32 are bright



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>1</sub> Øh <sub>8</sub> mm	l <sub>2</sub> Inch	l <sub>1</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	1511	1813	A125
	0.0551	1.40			100	160	1	—	—	0019832
	0.0591	1.50			100	160	1	—	—	0019856
	0.0591	1.50			80	125	1	—	—	0019849
1/16	0.0625	1.59			100	160	1	—	—	0173664
1/16	0.0625	1.59			80	125	1	—	—	0173657
	0.0709	1.80			100	160	1	—	—	0019863
5/64	0.0781	1.98			100	160	1	—	—	0173688
5/64	0.0781	1.98			80	125	1	—	—	0173671
	0.0787	2.00			100	160	1	—	—	0020074
	0.0787	2.00			80	125	1	—	—	0020067
	0.0866	2.20			100	160	1	—	—	0020036
3/32	0.0938	2.38			100	160	1	—	—	0173701
3/32	0.0938	2.38			80	125	1	—	—	0173695
	0.0984	2.50			100	160	1	—	—	0020050
	0.0984	2.50			80	125	1	—	—	0020043
7/64	0.1094	2.78			100	160	1	—	—	0173725
7/64	0.1094	2.78			80	125	1	—	—	0173718
	0.1181	3.00			100	160	1	—	—	0020128
	0.1181	3.00			150	200	1	—	—	0020135
	0.1181	3.00			200	250	1	—	—	0020142
1/8	0.1250	3.18			100	160	1	—	—	0173732
1/8	0.1250	3.18			150	200	1	—	—	0173749
1/8	0.1250	3.18			200	250	1	—	—	0173756
1/8	0.1250	3.18			250	310	1	—	—	0173763
	0.1299	3.30			100	160	1	—	—	0020081
	0.1378	3.50			100	160	1	—	—	0020098
	0.1378	3.50			150	200	1	—	—	0020104
	0.1378	3.50			200	250	1	—	—	0020111
9/64	0.1406	3.57			100	160	1	—	—	0173770
9/64	0.1406	3.57			150	200	1	—	—	0173787
9/64	0.1406	3.57			250	310	1	—	—	0214398
5/32	0.1563	3.97			100	160	1	—	—	0173794

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>1</sub> Øh <sub>8</sub> mm	l <sub>2</sub> Inch	l <sub>1</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	1511	1813	A125
5/32	0.1563	3.97			150	200	1	—	—	0173800
5/32	0.1563	3.97			200	250	1	—	—	0173817
5/32	0.1563	3.97			250	310	1	—	—	0173824
	0.1575	4.00			100	160	1	—	—	0020197
	0.1575	4.00			150	200	1	—	—	0020203
	0.1575	4.00			200	250	1	—	—	0020210
	0.1575	4.00			250	310	1	—	—	0020227
11/64	0.1719	4.37			100	160	1	—	—	0173831
11/64	0.1719	4.37			150	200	1	—	—	0173848
11/64	0.1719	4.37			250	310	1	—	—	0214404
	0.1772	4.50			100	160	1	—	—	0020159
	0.1772	4.50			150	200	1	—	—	0020166
	0.1772	4.50			200	250	1	—	—	0020173
	0.1772	4.50			250	310	1	—	—	0020180
3/16	0.1875	4.76			100	160	1	—	—	0173855
3/16	0.1875	4.76			150	200	1	—	—	0173862
3/16	0.1875	4.76			200	250	1	—	—	0173879
3/16	0.1875	4.76			250	310	1	—	—	0173886
3/16	0.1875	4.76			300	400	1	—	—	0173893
3/16	0.1875		11"	15"			1	059512	—	—
	0.1969	5.00			100	160	1	—	—	0020265
	0.1969	5.00			150	200	1	—	—	0020272
	0.1969	5.00			200	250	1	—	—	0020289
	0.1969	5.00			250	310	1	—	—	0020296
	0.1969	5.00			300	400	1	—	—	0020302
13/64	0.2031	5.16			150	200	1	—	—	0173909
13/64	0.2031	5.16			200	250	1	—	—	0173916
13/64	0.2031	5.16			250	310	1	—	—	0173923
	0.2165	5.50			150	200	1	—	—	0020234
	0.2165	5.50			200	250	1	—	—	0020241
	0.2165	5.50			250	310	1	—	—	0020258
7/32	0.2188	5.56			150	200	1	—	—	0173930
7/32	0.2188	5.56			200	250	1	—	—	0173947
7/32	0.2188	5.56			250	310	1	—	—	0173954
15/64	0.2344	5.95			150	200	1	—	—	0173961
15/64	0.2344	5.95			200	250	1	—	—	0173978
15/64	0.2344	5.95			250	310	1	—	—	0214442
	0.2362	6.00			150	200	1	—	—	0020340
	0.2362	6.00			200	250	1	—	—	0020357
	0.2362	6.00			250	310	1	—	—	0020364
	0.2362	6.00			300	400	1	—	—	0020371
1/4	0.2500	6.35			150	200	1	—	—	0173985
1/4	0.2500	6.35			200	250	1	—	—	0173992
1/4	0.2500	6.35			250	310	1	—	—	0174005
1/4	0.2500	6.35			300	400	1	—	—	0174012
1/4	0.2500	6.35			400	460	1	—	—	0174029
1/4	0.2500		11"	15"			1	059516	—	—
1/4	0.2500		13"	18"			1	—	059716	—
	0.2559	6.50			150	200	1	—	—	0020319
	0.2559	6.50			200	250	1	—	—	0020326
	0.2559	6.50			250	310	1	—	—	0020333
17/64	0.2656	6.75			150	200	1	—	—	0174036
17/64	0.2656	6.75			200	250	1	—	—	0174043
17/64	0.2656	6.75			400	460	1	—	—	0214466
17/64	0.2656		13"	18"			1	—	059717	—
	0.2756	7.00			150	200	1	—	—	0020418
	0.2756	7.00			200	250	1	—	—	0020425
	0.2756	7.00			250	310	1	—	—	0020432
9/32	0.2813	7.14			150	200	1	—	—	0174050
9/32	0.2813	7.14			200	250	1	—	—	0174067
9/32	0.2813	7.14			250	310	1	—	—	0174074
9/32	0.2813	7.14			400	460	1	—	—	0214473
9/32	0.2813		13"	18"			1	—	059718	—
	0.2953	7.50			150	200	1	—	—	0020388
	0.2953	7.50			200	250	1	—	—	0020395
	0.2953	7.50			250	310	1	—	—	0020401

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>1</sub> Øh <sub>8</sub> mm	l <sub>2</sub> Inch	l <sub>1</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	1511	1813	A125
19/64	0.2969	7.54			250	310	1	—	—	0214480
19/64	0.2969	7.54			400	460	1	—	—	0214497
19/64	0.2969		13"	18"			1	—	059719	—
5/16	0.3125	7.94			150	200	1	—	—	0174081
5/16	0.3125	7.94			200	250	1	—	—	0174098
5/16	0.3125	7.94			250	310	1	—	—	0174104
5/16	0.3125	7.94			300	400	1	—	—	0174111
5/16	0.3125	7.94			400	460	1	—	—	0174128
5/16	0.3125		11"	15"			1	059520	—	—
5/16	0.3125		13"	18"			1	—	059720	—
	0.3150	8.00			200	250	1	—	—	0020463
	0.3150	8.00			250	310	1	—	—	0020470
	0.3150	8.00			300	400	1	—	—	0020487
21/64	0.3281	8.33			250	310	1	—	—	0174135
21/64	0.3281	8.33			400	460	1	—	—	0214503
21/64	0.3281		13"	18"			1	—	059721	—
	0.3346	8.50			200	250	1	—	—	0020449
	0.3346	8.50			250	310	1	—	—	0020456
11/32	0.3437	8.73			200	250	1	—	—	0174142
11/32	0.3437	8.73			250	310	1	—	—	0174159
11/32	0.3437	8.73			300	400	1	—	—	0174166
11/32	0.3437	8.73			400	460	1	—	—	0214510
11/32	0.3437		11"	15"			1	059522	—	—
11/32	0.3437		13"	18"			1	—	059722	—
	0.3543	9.00			200	250	1	—	—	0020517
	0.3543	9.00			250	310	1	—	—	0020524
	0.3543	9.00			300	400	1	—	—	0020531
23/64	0.3594	9.13			250	310	1	—	—	0174180
23/64	0.3594	9.13			400	460	1	—	—	0214527
23/64	0.3594		13"	18"			1	—	059723	—
	0.3740	9.50			200	250	1	—	—	0020494
	0.3740	9.50			250	310	1	—	—	0020500
3/8	0.3750	9.52			200	250	1	—	—	0174197
3/8	0.3750	9.52			250	310	1	—	—	0174203
3/8	0.3750	9.52			300	400	1	—	—	0174210
3/8	0.3750	9.52			400	460	1	—	—	0174227
3/8	0.3750		11"	15"			1	059524	—	—
3/8	0.3750		13"	18"			1	—	059724	—
25/64	0.3906	9.92			250	310	1	—	—	0214534
25/64	0.3906	9.92			400	460	1	—	—	0214541
25/64	0.3906		13"	18"			1	—	059725	—
	0.3937	10.00			200	250	1	—	—	0019900
	0.3937	10.00			250	310	1	—	—	0019917
	0.3937	10.00			300	400	1	—	—	0019924
13/32	0.4063	10.32			200	250	1	—	—	0174234
13/32	0.4063	10.32			250	310	1	—	—	0174241
13/32	0.4063	10.32			400	460	1	—	—	0214558
13/32	0.4063		13"	18"			1	—	059726	—
	0.4134	10.50			200	250	1	—	—	0019870
	0.4134	10.50			250	310	1	—	—	0019887
	0.4134	10.50			300	400	1	—	—	0019894
27/64	0.4219	10.72			250	310	1	—	—	0214565
27/64	0.4219		13"	18"			1	—	059727	—
	0.4331	11.00			200	250	1	—	—	0019931
	0.4331	11.00			250	310	1	—	—	0019948
	0.4331	11.00			300	400	1	—	—	0019955
7/16	0.4375	11.11			200	250	1	—	—	0174265
7/16	0.4375	11.11			250	310	1	—	—	0174272
7/16	0.4375	11.11			300	400	1	—	—	0174289
7/16	0.4375	11.11			400	460	1	—	—	0214589
7/16	0.4375		11"	15"			1	059528	—	—
7/16	0.4375		13"	18"			1	—	059728	—
29/64	0.4531	11.51			250	310	1	—	—	0214596
29/64	0.4531	11.51			400	460	1	—	—	0214602
29/64	0.4531		13"	18"			1	—	059729	—
15/32	0.4688	11.91			200	250	1	—	—	0174296

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>1</sub> Øh <sub>8</sub> mm	l <sub>2</sub> Inch	l <sub>1</sub> Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	Pack Qty	1511	1813	A125
15/32	0.4687	11.91			250	310	1	—	—	0174302
15/32	0.4687	11.91			400	460	1	—	—	0214619
15/32	0.4687		13"	18"			1	—	059730	—
	0.4724	12.00			200	250	1	—	—	0019962
	0.4724	12.00			250	310	1	—	—	0019979
	0.4724	12.00			300	400	1	—	—	0019986
31/64	0.4844	12.30			250	310	1	—	—	0214626
31/64	0.4844	12.30			400	460	1	—	—	0214633
31/64	0.4844		13"	18"			1	—	059731	—
1/2	0.5000	12.70			200	250	1	—	—	0174319
1/2	0.5000	12.70			250	310	1	—	—	0174326
1/2	0.5000	12.70			300	400	1	—	—	0174333
1/2	0.5000	12.70			400	460	1	—	—	0174340
1/2	0.5000		11"	15"			1	059532	—	—
1/2	0.5000		13"	18"			1	—	059732	—
	0.5118	13.00			250	310	1	—	—	0019993
	0.5118	13.00			300	400	1	—	—	0020005
33/64	0.5156	13.10			250	310	1	—	—	0214640
33/64	0.5156	13.10			400	460	1	—	—	0214657
33/64	0.5156		13"	18"			1	—	059733	—
17/32	0.5313	13.49			250	310	1	—	—	0214664
17/32	0.5313	13.49			400	460	1	—	—	0214671
17/32	0.5313		11"	15"			1	059534	—	—
17/32	0.5313		13"	18"			1	—	059734	—
35/64	0.5469	13.89			250	310	1	—	—	0214688
35/64	0.5469	13.89			400	460	1	—	—	0214695
35/64	0.5469		13"	18"			1	—	059735	—
	0.5512	14.00			250	310	1	—	—	0020012
	0.5512	14.00			300	400	1	—	—	0020029
9/16	0.5625	14.29			250	310	1	—	—	0214701
9/16	0.5625	14.29			400	460	1	—	—	0214718
9/16	0.5625		11"	15"			1	059536	—	—
9/16	0.5625		13"	18"			1	—	059736	—
37/64	0.5781	14.68			250	310	1	—	—	0214725
37/64	0.5781		13"	18"			1	—	059737	—
19/32	0.5937	15.08			250	310	1	—	—	0214749
19/32	0.5937	15.08			400	460	1	—	—	0214756
19/32	0.5937		13"	18"			1	—	059738	—
39/64	0.6094	15.48			250	310	1	—	—	0214763
39/64	0.6094	15.48			400	460	1	—	—	0214770
39/64	0.6094		13"	18"			1	—	059739	—
5/8	0.6250	15.88			250	310	1	—	—	0214787
5/8	0.6250	15.88			400	460	1	—	—	0214794
5/8	0.6250		11"	15"			1	059540	—	—
5/8	0.6250		13"	18"			1	—	059740	—
21/32	0.6563	16.67			250	310	1	—	—	0214800
21/32	0.6563	16.67			400	460	1	—	—	0214817
21/32	0.6563		11"	15"			1	059542	—	—
21/32	0.6563		13"	18"			1	—	059742	—
11/16	0.6875	17.46			250	310	1	—	—	0214824
11/16	0.6875	17.46			400	460	1	—	—	0214831
11/16	0.6875		11"	15"			1	059544	—	—
11/16	0.6875		13"	18"			1	—	059744	—
23/32	0.7188	18.26			250	310	1	—	—	0214848
23/32	0.7188	18.26			400	460	1	—	—	0214855
23/32	0.7188		11"	15"			1	059546	—	—
23/32	0.7188		13"	18"			1	—	059746	—
3/4	0.7500	19.05			250	310	1	—	—	0214862
3/4	0.7500	19.05			400	460	1	—	—	0214879
3/4	0.7500		11"	15"			1	059548	—	—
3/4	0.7500		13"	18"			1	—	059748	—
25/32	0.7813	19.84			400	460	1	—	—	0214886
25/32	0.7813		11"	15"			1	059550	—	—
25/32	0.7813		13"	18"			1	—	059750	—
13/16	0.8125	20.64			400	460	1	—	—	0214893
13/16	0.8125		11"	15"			1	059552	—	—



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_1$ Ø $h_8$ mm	$l_2$ Inch	$l_1$ Inch	$l_2$ mm	$l_1$ mm	Pack Qty	1511	1813	A125
13/16	0.8125		13"	18"			1	—	059752	—
7/8	0.8750	22.22			400	460	1	—	—	0214909
7/8	0.8750		11"	15"			1	059554	—	—
7/8	0.8750		13"	18"			1	—	059756	—
15/16	0.9375	23.81			400	460	1	—	—	0214916
15/16	0.9375		11"	15"			1	059556	—	—
15/16	0.9375		13"	18"			1	—	059760	—
1"	1.0000	25.40			400	460	1	—	—	0214923
1"	1.0000		11"	15"			1	059558	—	—
1"	1.0000		13"	18"			1	—	059764	—

# EXTRA LENGTH DRILL



## General Purpose Extra Length Parabolic Flute

**QC0860P** 8" Overall length

**QC1290P** 12" Overall length

Heavy-Duty Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Low thrust design self centering Split Point for easier penetration. Bright Finish improves chip flow in soft or non-ferrous materials.



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	QC0860P	QC1290P
1/8	0.1250	6"	8"	1	055608	—
1/8	0.1250	9"	12"	1	—	060308
9/64	0.1406	6"	8"	1	055609	—
9/64	0.1406	9"	12"	1	—	060309
5/32	0.1563	6"	8"	1	055610	—
5/32	0.1563	9"	12"	1	—	060310
11/64	0.1719	6"	8"	1	055611	—
11/64	0.1719	9"	12"	1	—	060311
3/16	0.1875	6"	8"	1	055612	—
3/16	0.1875	9"	12"	1	—	060312
13/64	0.2031	6"	8"	1	055613	—
13/64	0.2031	9"	12"	1	—	060313
7/32	0.2188	6"	8"	1	055614	—
7/32	0.2188	9"	12"	1	—	060314
15/64	0.2344	6"	8"	1	055615	—
15/64	0.2344	9"	12"	1	—	060315
1/4	0.2500	6"	8"	1	055616	—
1/4	0.2500	9"	12"	1	—	060316
17/64	0.2656	6"	8"	1	055617	—
17/64	0.2656	9"	12"	1	—	060317
9/32	0.2813	6"	8"	1	055618	—
9/32	0.2813	9"	12"	1	—	060318
19/64	0.2969	6"	8"	1	055619	—
19/64	0.2969	9"	12"	1	—	060319
5/16	0.3125	6"	8"	1	055620	—
5/16	0.3125	9"	12"	1	—	060320
21/64	0.3281	6"	8"	1	055621	—
21/64	0.3281	9"	12"	1	—	060321
11/32	0.3437	6"	8"	1	055622	—
11/32	0.3437	9"	12"	1	—	060322
23/64	0.3594	6"	8"	1	055623	—
23/64	0.3594	9"	12"	1	—	060323
3/8	0.3750	6"	8"	1	055624	—



# EXTRA LENGTH DRILL

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	QC0860P	QC1290P
3/8	0.3750	9"	12"	1	—	060324
25/64	0.3906	6"	8"	1	055625	—
25/64	0.3906	9"	12"	1	—	060325
13/32	0.4063	6"	8"	1	055626	—
13/32	0.4063	9"	12"	1	—	060326
27/64	0.4219	6"	8"	1	055627	—
27/64	0.4219	9"	12"	1	—	060327
7/16	0.4375	6"	8"	1	055628	—
7/16	0.4375	9"	12"	1	—	060328
29/64	0.4531	6"	8"	1	055629	—
15/32	0.4687	6"	8"	1	055630	—
15/32	0.4687	9"	12"	1	—	060330
31/64	0.4844	6"	8"	1	055631	—
1/2	0.5000	6"	8"	1	055632	—
1/2	0.5000	9"	12"	1	—	060332

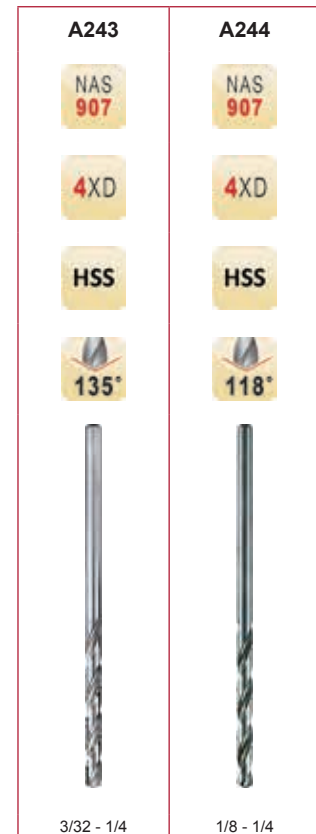
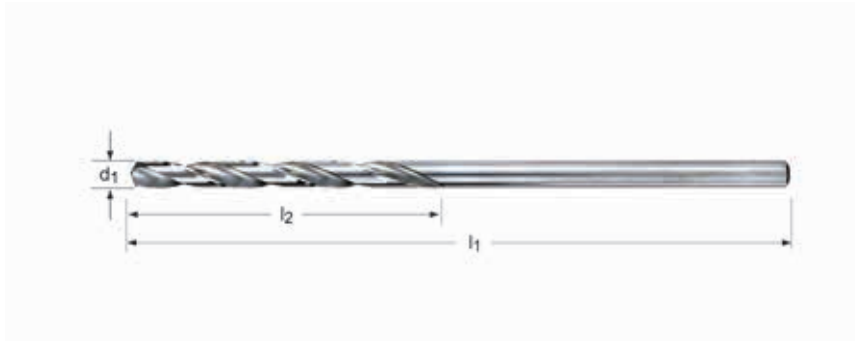
# AIRCRAFT EXTENSION DRILL



## Aircraft Extension (NAS 907)

**A243 (NAS 907 Type B)** Low thrust design self centering 135° Split Point for easier penetration. Bright Finish improves chip flow in soft or non-ferrous materials.

**A244 (NAS 907 Type A)** Low thrust design self centering 118° Split Point for easier penetration. Bright Finish improves chip flow in soft or non-ferrous materials.



$d_1$ $\varnothing h_8$ Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	A243	A244
3/32	0.0938	1.1/4	6"	10	0240458	—
40	0.0980	1.3/8	6"	10	0241141	—
1/8	0.1250	1.5/8	6"	10	0240434	0375914
30	0.1285	1.5/8	6"	10	0241035	—
5/32	0.1563	2"	6"	10	0240465	0375938
21	0.1590	2.1/8	6"	10	0240939	—
20	0.1610	2.1/8	6"	10	0240922	—
3/16	0.1875	2.5/16	6"	10	0240441	0375921
11	0.1910	2.5/16	6"	10	0240823	—
10	0.1935	2.7/16	6"	10	0240816	—
1/4	0.2500	2.3/4	6"	10	0240410	0375907



# AIRCRAFT EXTENSION DRILL

## Aircraft Extension (NAS 907 Type B)

**500-6** - Fractional Sizes

**501-6** - Wire Gauge Sizes

**502-6** - Letter Sizes

Low thrust design self centering 135° Split Point for easier penetration. Steam Oxide for increased wear resistance & lubricity. 6" overall length.



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	500-6	501-6	502-6
	60		0.0400	11/16	6"	12	—	058160 <sup>1)</sup>	—
	59		0.0410	11/16	6"	12	—	058159 <sup>1)</sup>	—
	58		0.0420	11/16	6"	12	—	058158 <sup>1)</sup>	—
	57		0.0430	3/4	6"	12	—	058157 <sup>1)</sup>	—
	56		0.0465	3/4	6"	12	—	058156 <sup>1)</sup>	—
3/64			0.0469	3/4	6"	12	058003	—	—
	55		0.0520	7/8	6"	12	—	058155 <sup>1)</sup>	—
	54		0.0550	7/8	6"	12	—	058154 <sup>1)</sup>	—
	53		0.0595	7/8	6"	12	—	058153 <sup>1)</sup>	—
1/16			0.0625	7/8	6"	12	058004	—	—
	52		0.0635	7/8	6"	12	—	058152	—
	51		0.0670	1"	6"	12	—	058151	—
	50		0.0700	1"	6"	12	—	058150	—
	49		0.0730	1"	6"	12	—	058149	—
	48		0.0760	1"	6"	12	—	058148	—
5/64			0.0781	1"	6"	12	058005	—	—
	47		0.0785	1"	6"	12	—	058147	—
	46		0.0810	1.1/8	6"	12	—	058146	—
	45		0.0820	1.1/8	6"	12	—	058145	—
	44		0.0860	1.1/8	6"	12	—	058144	—
	43		0.0890	1.1/4	6"	12	—	058143	—
	42		0.0935	1.1/4	6"	12	—	058142	—
3/32			0.0938	1.1/4	6"	12	058006	—	—
	41		0.0960	1.3/8	6"	12	—	058141	—
	40		0.0980	1.3/8	6"	12	—	058140	—
	39		0.0995	1.3/8	6"	12	—	058139	—
	38		0.1015	1.7/16	6"	12	—	058138	—
	37		0.1040	1.7/16	6"	12	—	058137	—
	36		0.1065	1.7/16	6"	12	—	058136	—
7/64			0.1094	1.1/2	6"	12	058007	—	—
	35		0.1100	1.1/2	6"	12	—	058135	—
	34		0.1110	1.1/2	6"	12	—	058134	—

<sup>1)</sup> Not Split Point

# AIRCRAFT EXTENSION DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	500-6	501-6	502-6
	33		0.1130	1.1/2	6"	12	—	058133	—
	32		0.1160	1.5/8	6"	12	—	058132	—
	31		0.1200	1.5/8	6"	12	—	058131	—
1/8			0.1250	1.5/8	6"	12	058008	—	—
	30		0.1285	1.5/8	6"	12	—	058130	—
	29		0.1360	1.3/4	6"	12	—	058129	—
	28		0.1405	1.3/4	6"	12	—	058128	—
9/64			0.1406	1.3/4	6"	12	058009	—	—
	27		0.1440	1.7/8	6"	12	—	058127	—
	26		0.1470	1.7/8	6"	12	—	058126	—
	25		0.1495	1.7/8	6"	12	—	058125	—
	24		0.1520	2"	6"	12	—	058124	—
	23		0.1540	2"	6"	12	—	058123	—
5/32			0.1563	2"	6"	12	058010	—	—
	22		0.1570	2"	6"	12	—	058122	—
	21		0.1590	2.1/8	6"	12	—	058121	—
	20		0.1610	2.1/8	6"	12	—	058120	—
	19		0.1660	2.1/8	6"	12	—	058119	—
	18		0.1695	2.1/8	6"	12	—	058118	—
11/64			0.1719	2.1/8	6"	12	058011	—	—
	17		0.1730	2.3/16	6"	12	—	058117	—
	16		0.1770	2.3/16	6"	12	—	058116	—
	15		0.1800	2.3/16	6"	12	—	058115	—
	14		0.1820	2.3/16	6"	12	—	058114	—
	13		0.1850	2.5/16	6"	12	—	058113	—
3/16			0.1875	2.5/16	6"	12	058012	—	—
	12		0.1890	2.5/16	6"	12	—	058112	—
	11		0.1910	2.5/16	6"	12	—	058111	—
	10		0.1935	2.7/16	6"	12	—	058110	—
	9		0.1960	2.7/16	6"	12	—	058109	—
	8		0.1990	2.7/16	6"	12	—	058108	—
	7		0.2010	2.7/16	6"	12	—	058107	—
13/64			0.2031	2.7/16	6"	12	058013	—	—
	6		0.2040	2.1/2	6"	12	—	058106	—
	5		0.2055	2.1/2	6"	12	—	058105	—
	4		0.2090	2.1/2	6"	12	—	058104	—
	3		0.2130	2.1/2	6"	12	—	058103	—
7/32			0.2188	2.1/2	6"	12	058014	—	—
	2		0.2210	2.5/8	6"	12	—	058102	—
	1		0.2280	2.5/8	6"	12	—	058101	—
		A	0.2340	2.5/8	6"	12	—	—	058201
15/64			0.2344	2.5/8	6"	12	058015	—	—
		B	0.2380	2.3/4	6"	12	—	—	058202
		C	0.2420	2.3/4	6"	12	—	—	058203
		D	0.2460	2.3/4	6"	12	—	—	058204
		E	0.2500	2.3/4	6"	12	—	—	058205
1/4			0.2500	2.3/4	6"	12	058016	—	—
		F	0.2570	2.7/8	6"	12	—	—	058206
		G	0.2610	2.7/8	6"	6	—	—	058207
17/64			0.2656	2.7/8	6"	6	058017	—	—
		H	0.2660	2.7/8	6"	6	—	—	058208
		I	0.2720	2.7/8	6"	6	—	—	058209
		J	0.2770	2.7/8	6"	6	—	—	058210
		K	0.2810	2.15/16	6"	6	—	—	058211
9/32			0.2813	2.15/16	6"	6	058018	—	—
		L	0.2900	2.15/16	6"	6	—	—	058212
		M	0.2950	3.1/16	6"	6	—	—	058213
19/64			0.2969	3.1/16	6"	6	058019	—	—
		N	0.3020	3.1/16	6"	6	—	—	058214
5/16			0.3125	3.3/16	6"	6	058020	—	—
		O	0.3160	3.3/16	6"	6	—	—	058215
		P	0.3230	3.5/16	6"	6	—	—	058216
21/64			0.3281	3.5/16	6"	6	058021	—	—
		Q	0.3320	3.7/16	6"	6	—	—	058217
		R	0.3390	3.7/16	6"	6	—	—	058218
11/32			0.3437	3.7/16	6"	6	058022	—	—



# AIRCRAFT EXTENSION DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	500-6	501-6	502-6
		S	0.3480	3.1/2	6"	6	—	—	058219
		T	0.3580	3.1/2	6"	6	—	—	058220
23/64			0.3594	3.1/2	6"	6	058023	—	—
		U	0.3680	3.5/8	6"	6	—	—	058221
3/8			0.3750	3.5/8	6"	6	058024	—	—
		V	0.3770	3.5/8	6"	6	—	—	058222
		W	0.3860	3.3/4	6"	6	—	—	058223
25/64			0.3906	3.3/4	6"	6	058025	—	—
		X	0.3970	3.3/4	6"	6	—	—	058224
		Y	0.4040	3.7/8	6"	6	—	—	058225
13/32			0.4063	3.7/8	6"	6	058026	—	—
		Z	0.4130	3.7/8	6"	6	—	—	058226
27/64			0.4219	3.15/16	6"	6	058027	—	—
7/16			0.4375	4.1/16	6"	6	058028	—	—
29/64			0.4531	4.3/16	6"	6	058029	—	—
15/32			0.4687	4.5/16	6"	6	058030	—	—
31/64			0.4844	4.3/8	6"	6	058031	—	—
1/2			0.5000	4.1/2	6"	6	058032	—	—

# AIRCRAFT EXTENSION DRILL



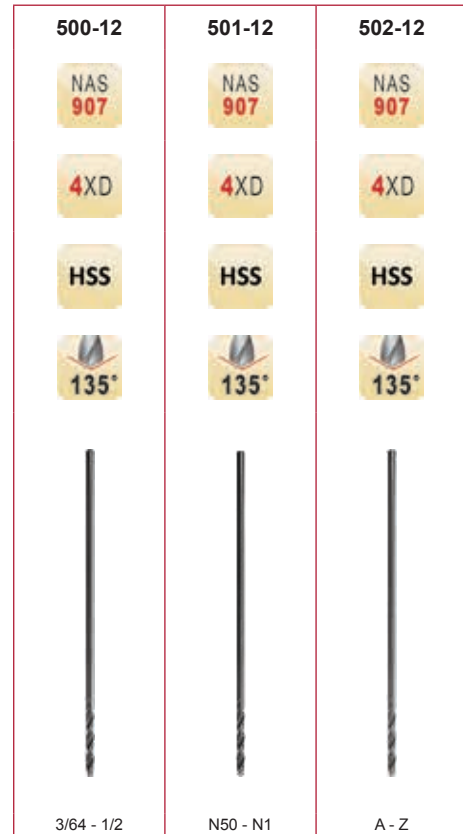
## Aircraft Extension (NAS 907 Type B)

**500-12** - Fractional Sizes

**501-12** - Wire Gauge Sizes

**502-12** - Letter Sizes

Low thrust design self centering 135° Split Point for easier penetration.  
Steam Oxide for increased wear resistance & lubricity.  
12" Over All Length



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	500-12	501-12	502-12
3/64			0.0469	3/4	12"	12	059003 <sup>1)</sup>	—	—
1/16			0.0625	7/8	12"	12	059004	—	—
	50		0.0700	1"	12"	12	—	059150	—
	49		0.0730	1"	12"	12	—	059149	—
	48		0.0760	1"	12"	12	—	059148	—
5/64			0.0781	1"	12"	12	059005	—	—
	47		0.0785	1"	12"	12	—	059147	—
	46		0.0810	1.1/8	12"	12	—	059146	—
	45		0.0820	1.1/8	12"	12	—	059145	—
	44		0.0860	1.1/8	12"	12	—	059144	—
	43		0.0890	1.1/4	12"	12	—	059143	—
	42		0.0935	1.1/4	12"	12	—	059142	—
3/32			0.0938	1.1/4	12"	12	059006	—	—
	41		0.0960	1.3/8	12"	12	—	059141	—
	40		0.0980	1.3/8	12"	12	—	059140	—
	37		0.1040	1.7/16	12"	12	—	059137	—
	36		0.1065	1.7/16	12"	12	—	059136	—
7/64			0.1094	1.1/2	12"	12	059007	—	—
	31		0.1200	1.5/8	12"	12	—	059131	—
1/8			0.1250	1.5/8	12"	12	059008	—	—
	30		0.1285	1.5/8	12"	12	—	059130	—
	29		0.1360	1.3/4	12"	12	—	059129	—
9/64			0.1406	1.3/4	12"	12	059009	—	—
	27		0.1440	1.7/8	12"	12	—	059127	—
	26		0.1470	1.7/8	12"	12	—	059126	—
	25		0.1495	1.7/8	12"	12	—	059125	—
	23		0.1540	2"	12"	12	—	059123	—
5/32			0.1563	2"	12"	12	059010	—	—
	22		0.1570	2"	12"	12	—	059122	—
	21		0.1590	2.1/8	12"	12	—	059121	—
	20		0.1610	2.1/8	12"	12	—	059120	—
	19		0.1660	2.1/8	12"	12	—	059119	—

<sup>1)</sup> Not Split Point





# AIRCRAFT EXTENSION DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	500-12	501-12	502-12
11/64	18		0.1695	2.1/8	12"	12	—	059118	—
			0.1719	2.1/8	12"	12	059011	—	—
	17		0.1730	2.3/16	12"	12	—	059117	—
	16		0.1770	2.3/16	12"	12	—	059116	—
3/16	13		0.1850	2.5/16	12"	12	—	059113	—
			0.1875	2.5/16	12"	6	059012	—	—
	12		0.1890	2.5/16	12"	6	—	059112	—
	11		0.1910	2.5/16	12"	6	—	059111	—
	10		0.1935	2.7/16	12"	6	—	059110	—
	9		0.1960	2.7/16	12"	6	—	059109	—
	7		0.2010	2.7/16	12"	6	—	059107	—
13/64			0.2031	2.7/16	12"	6	059013	—	—
	5		0.2055	2.1/2	12"	6	—	059105	—
	4		0.2090	2.1/2	12"	6	—	059104	—
	3		0.2130	2.1/2	12"	6	—	059103	—
7/32			0.2188	2.1/2	12"	6	059014	—	—
	1		0.2280	2.5/8	12"	6	—	059101	—
15/64		A	0.2340	2.5/8	12"	6	—	—	059201
			0.2344	2.5/8	12"	6	059015	—	—
		B	0.2380	2.3/4	12"	6	—	—	059202
		C	0.2420	2.3/4	12"	6	—	—	059203
		D	0.2460	2.3/4	12"	6	—	—	059204
		E	0.2500	2.3/4	12"	6	—	—	059205
1/4			0.2500	2.3/4	12"	6	059016	—	—
		F	0.2570	2.7/8	12"	6	—	—	059206
		G	0.2610	2.7/8	12"	6	—	—	059207
17/64			0.2656	2.7/8	12"	6	059017	—	—
		H	0.2660	2.7/8	12"	6	—	—	059208
		I	0.2720	2.7/8	12"	6	—	—	059209
		J	0.2770	2.7/8	12"	6	—	—	059210
		K	0.2810	2.15/16	12"	6	—	—	059211
9/32			0.2813	2.15/16	12"	6	059018	—	—
		L	0.2900	2.15/16	12"	6	—	—	059212
		M	0.2950	3.1/16	12"	6	—	—	059213
19/64			0.2969	3.1/16	12"	6	059019	—	—
		N	0.3020	3.1/16	12"	6	—	—	059214
5/16			0.3125	3.3/16	12"	6	059020	—	—
		O	0.3160	3.3/16	12"	6	—	—	059215
		P	0.3230	3.5/16	12"	6	—	—	059216
21/64			0.3281	3.5/16	12"	6	059021	—	—
		Q	0.3320	3.7/16	12"	6	—	—	059217
		R	0.3390	3.7/16	12"	6	—	—	059218
11/32			0.3437	3.7/16	12"	6	059022	—	—
		S	0.3480	3.1/2	12"	3	—	—	059219
		T	0.3580	3.1/2	12"	3	—	—	059220
23/64			0.3594	3.1/2	12"	3	059023	—	—
		U	0.3680	3.5/8	12"	3	—	—	059221
3/8			0.3750	3.5/8	12"	3	059024	—	—
		V	0.3770	3.5/8	12"	3	—	—	059222
		W	0.3860	3.3/4	12"	3	—	—	059223
25/64			0.3906	3.3/4	12"	3	059025	—	—
		X	0.3970	3.3/4	12"	3	—	—	059224
		Y	0.4040	3.7/8	12"	3	—	—	059225
13/32			0.4063	3.7/8	12"	3	059026	—	—
		Z	0.4130	3.7/8	12"	3	—	—	059226
27/64			0.4219	3.15/16	12"	3	059027	—	—
7/16			0.4375	4.1/16	12"	3	059028	—	—
29/64			0.4531	4.3/16	12"	3	059029	—	—
15/32			0.4687	4.5/16	12"	3	059030	—	—
31/64			0.4844	4.3/8	12"	3	059031	—	—
1/2			0.5000	4.1/2	12"	3	059032	—	—

# AIRCRAFT EXTENSION DRILL



## Heavy Duty Cobalt Aircraft Extension (NAS 907 Type J)

**CO500-6** - Fractional Sizes, 6" Over All Length

**CO501-6** - Wire Gauge Sizes, 6" Over All Length

**CO500-12** - Fractional Sizes, 12" Over All Length

**CO501-12** - Wire Gauge Sizes, 12" Over All Length

Low thrust design self centering 135° Split Point for easier penetration. Low thrust design. Cobalt base material with Bronze Oxide for wear resistance and lubricity. For enhanced tool life in ferrous materials.



$d_1$ Ø Inch	$d_1$	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	CO500-6	CO501-6	CO500-12	CO501-12
1/16		0.0625	7/8	12"	12	—	—	052604	—
1/16		0.0625	7/8	6"	12	053604	—	—	—
	52	0.0635	7/8	6"	12	—	053752	—	—
	51	0.0670	1"	6"	12	—	053751	—	—
	50	0.0700	1"	6"	12	—	053750	—	—
	49	0.0730	1"	6"	12	—	053749	—	—
	48	0.0760	1"	6"	12	—	053748	—	—
5/64		0.0781	1"	12"	12	—	—	052605	—
5/64		0.0781	1"	6"	12	053605	—	—	—
	47	0.0785	1"	6"	12	—	053747	—	—
	46	0.0810	1.1/8	6"	12	—	053746	—	—
	45	0.0820	1.1/8	6"	12	—	053745	—	—
	44	0.0860	1.1/8	6"	12	—	053744	—	—
	43	0.0890	1.1/4	6"	12	—	053743	—	—
	42	0.0935	1.1/4	6"	12	—	053742	—	—
3/32		0.0938	1.1/4	12"	12	—	—	052606	—
3/32		0.0938	1.1/4	6"	12	053606	—	—	—
	41	0.0960	1.3/8	6"	12	—	053741	—	—
	40	0.0980	1.3/8	12"	12	—	—	—	052840
	40	0.0980	1.3/8	6"	12	—	053740	—	—
	39	0.0995	1.3/8	6"	12	—	053739	—	—
	38	0.1015	1.7/16	6"	12	—	053738	—	—
	37	0.1040	1.7/16	6"	12	—	053737	—	—
	36	0.1065	1.7/16	6"	12	—	053736	—	—
7/64		0.1094	1.1/2	12"	12	—	—	052607	—
7/64		0.1094	1.1/2	6"	12	053607	—	—	—
	35	0.1100	1.1/2	6"	12	—	053735	—	—
	34	0.1110	1.1/2	6"	12	—	053734	—	—
	33	0.1130	1.1/2	6"	12	—	053733	—	—
	32	0.1160	1.5/8	6"	12	—	053732	—	—
	31	0.1200	1.5/8	6"	12	—	053731	—	—
1/8		0.1250	1.5/8	12"	12	—	—	052608	—
1/8		0.1250	1.5/8	6"	12	053608	—	—	—



# AIRCRAFT EXTENSION DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub>	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	CO500-6	CO501-6	CO500-12	CO501-12
	30	0.1285	1.5/8	12"	12	—	—	—	052830
	30	0.1285	1.5/8	6"	12	—	053730	—	—
	29	0.1360	1.3/4	12"	12	—	—	—	052829
	29	0.1360	1.3/4	6"	12	—	053729	—	—
	28	0.1405	1.3/4	6"	12	—	053728	—	—
9/64		0.1406	1.3/4	12"	12	—	—	052609	—
9/64		0.1406	1.3/4	6"	12	053609	—	—	—
	27	0.1440	1.7/8	12"	12	—	—	—	052827
	27	0.1440	1.7/8	6"	12	—	053727	—	—
	26	0.1470	1.7/8	6"	12	—	053726	—	—
	25	0.1495	1.7/8	6"	12	—	053725	—	—
	24	0.1520	2"	6"	12	—	053724	—	—
	23	0.1540	2"	6"	12	—	053723	—	—
5/32		0.1563	2"	12"	12	—	—	052610	—
5/32		0.1563	2"	6"	12	053610	—	—	—
	22	0.1570	2"	6"	12	—	053722	—	—
	21	0.1590	2.1/8	12"	12	—	—	—	052821
	21	0.1590	2.1/8	6"	12	—	053721	—	—
	20	0.1610	2.1/8	12"	12	—	—	—	052820
	20	0.1610	2.1/8	6"	12	—	053720	—	—
	19	0.1660	2.1/8	12"	12	—	—	—	052819
	19	0.1660	2.1/8	6"	12	—	053719	—	—
	18	0.1695	2.1/8	6"	12	—	053718	—	—
11/64		0.1719	2.1/8	12"	12	—	—	052611	—
11/64		0.1719	2.1/8	6"	12	053611	—	—	—
	17	0.1730	2.3/16	6"	12	—	053717	—	—
	16	0.1770	2.3/16	12"	12	—	—	—	052816
	16	0.1770	2.3/16	6"	12	—	053716	—	—
	15	0.1800	2.3/16	6"	12	—	053715	—	—
	14	0.1820	2.3/16	6"	12	—	053714	—	—
	13	0.1850	2.5/16	6"	12	—	053713	—	—
3/16		0.1875	2.5/16	12"	6	—	—	052612	—
3/16		0.1875	2.5/16	6"	12	053612	—	—	—
	12	0.1890	2.5/16	6"	12	—	053712	—	—
	11	0.1910	2.5/16	12"	12	—	—	—	052811
	11	0.1910	2.5/16	6"	12	—	053711	—	—
	10	0.1935	2.7/16	12"	6	—	—	—	052810
	10	0.1935	2.7/16	6"	12	—	053710	—	—
	9	0.1960	2.7/16	6"	12	—	053709	—	—
	8	0.1990	2.7/16	6"	12	—	053708	—	—
	7	0.2010	2.7/16	6"	12	—	053707	—	—
13/64		0.2031	2.7/16	12"	6	—	—	052613	—
13/64		0.2031	2.7/16	6"	12	053613	—	—	—
	6	0.2040	2.1/2	6"	12	—	053706	—	—
	5	0.2055	2.1/2	6"	12	—	053705	—	—
	4	0.2090	2.1/2	6"	12	—	053704	—	—
	3	0.2130	2.1/2	6"	12	—	053703	—	—
7/32		0.2188	2.1/2	12"	6	—	—	052614	—
7/32		0.2188	2.1/2	6"	12	053614	—	—	—
	2	0.2210	2.5/8	12"	6	—	—	—	052802
	2	0.2210	2.5/8	6"	12	—	053702	—	—
	1	0.2280	2.5/8	6"	12	—	053701	—	—
15/64		0.2344	2.5/8	12"	6	—	—	052615	—
15/64		0.2344	2.5/8	6"	12	053615	—	—	—
1/4		0.2500	2.3/4	12"	6	—	—	052616	—
1/4		0.2500	2.3/4	6"	12	053616	—	—	—

# TAPER SHANK DRILL

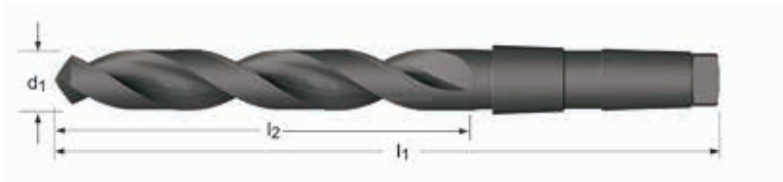


## General Purpose Taper Shank

**209** Standard Taper Type

**S209** Small Taper Type

Steam Oxide for increased tool life & lubricity.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	MTS	Pack Qty	209	S209
1/8	0.1250	1.7/8	5.1/8	1	1	020008	—
9/64	0.1406	2.1/8	5.3/8	1	1	020009	—
5/32	0.1563	2.1/8	5.3/8	1	1	020010	—
11/64	0.1719	2.1/2	5.3/4	1	1	020011	—
3/16	0.1875	2.1/2	5.3/4	1	1	020012	—
13/64	0.2031	2.3/4	6"	1	1	020013	—
7/32	0.2188	2.3/4	6"	1	1	020014	—
15/64	0.2344	2.7/8	6.1/8	1	1	020015	—
1/4	0.2500	2.7/8	6.1/8	1	1	020016	—
17/64	0.2656	3"	6.1/4	1	1	020017	—
9/32	0.2813	3"	6.1/4	1	1	020018	—
19/64	0.2969	3.1/8	6.3/8	1	1	020019	—
5/16	0.3125	3.1/8	6.3/8	1	1	020020	—
21/64	0.3281	3.1/4	6.1/2	1	1	020021	—
11/32	0.3437	3.1/4	6.1/2	1	1	020022	—
23/64	0.3594	3.1/2	6.3/4	1	1	020023	—
3/8	0.3750	3.1/2	6.3/4	1	1	020024	—
25/64	0.3906	3.5/8	7"	1	1	020025	—
13/32	0.4063	3.5/8	7"	1	1	020026	—
27/64	0.4219	3.7/8	7.1/4	1	1	020027	—
7/16	0.4375	3.7/8	7.1/4	1	1	020028	—
29/64	0.4531	4.1/8	7.1/2	1	1	020029	—
15/32	0.4687	4.1/8	7.1/2	1	1	020030	—
31/64	0.4844	4.3/8	8.1/4	2	1	020031	—
1/2	0.5000	4.3/8	7.3/4	1	1	—	023032
1/2	0.5000	4.3/8	8.1/4	2	1	020032	—
33/64	0.5156	4.5/8	8"	1	1	—	023033
33/64	0.5156	4.5/8	8.1/2	2	1	020033	—
17/32	0.5313	4.5/8	8"	1	1	—	023034
17/32	0.5313	4.5/8	8.1/2	2	1	020034	—
35/64	0.5469	4.7/8	8.1/4	1	1	—	023035
35/64	0.5469	4.7/8	8.3/4	2	1	020035	—
9/16	0.5625	4.7/8	8.1/4	1	1	—	023036



# TAPER SHANK DRILL

d <sub>1</sub> Ø	d <sub>1</sub> decimal	l <sub>2</sub>	l <sub>1</sub>	MTS	Pack Qty	209	S209
Inch	Inch	Inch	Inch				
9/16	0.5625	4.7/8	8.3/4	2	1	020036	—
37/64	0.5781	4.7/8	8.3/4	2	1	020037	—
19/32	0.5937	4.7/8	8.3/4	2	1	020038	—
39/64	0.6094	4.7/8	8.3/4	2	1	020039	—
5/8	0.6250	4.7/8	8.3/4	2	1	020040	—
41/64	0.6406	5.1/8	9"	2	1	020041	—
21/32	0.6563	5.1/8	9"	2	1	020042	—
43/64	0.6719	5.3/8	9.1/4	2	1	020043	—
11/16	0.6875	5.3/8	9.1/4	2	1	020044	—
45/64	0.7031	5.5/8	9.1/2	2	1	020045	—
23/32	0.7188	5.5/8	9.1/2	2	1	020046	—
47/64	0.7344	5.7/8	9.3/4	2	1	020047	—
3/4	0.7500	5.7/8	9.3/4	2	1	020048	—
49/64	0.7656	6"	9.7/8	2	1	020049	—
25/32	0.7813	6"	9.7/8	2	1	020050	—
51/64	0.7969	6.1/8	10"	2	1	—	023051
51/64	0.7969	6.1/8	10.3/4	3	1	020051	—
13/16	0.8125	6.1/8	10"	2	1	—	023052
13/16	0.8125	6.1/8	10.3/4	3	1	020052	—
53/64	0.8281	6.1/8	10"	2	1	—	023053
53/64	0.8281	6.1/8	10.3/4	3	1	020053	—
27/32	0.8438	6.1/8	10"	2	1	—	023054
27/32	0.8438	6.1/8	10.3/4	3	1	020054	—
55/64	0.8594	6.1/8	10.3/4	3	1	020055	—
7/8	0.8750	6.1/8	10"	2	1	—	023056
7/8	0.8750	6.1/8	10.3/4	3	1	020056	—
57/64	0.8906	6.1/8	10.3/4	3	1	020057	—
29/32	0.9063	6.1/8	10"	2	1	—	023058
29/32	0.9063	6.1/8	10.3/4	3	1	020058	—
59/64	0.9219	6.1/8	10.3/4	3	1	020059	—
15/16	0.9375	6.1/8	10.3/4	3	1	020060	—
61/64	0.9531	6.3/8	11"	3	1	020061	—
31/32	0.9688	6.3/8	11"	3	1	020062	—
63/64	0.9844	6.3/8	11"	3	1	020063	—
1"	1.0000	6.3/8	11"	3	1	020100	—
1.1/64	1.0156	6.1/2	11.1/8	3	1	020101	—
1.1/32	1.0312	6.1/2	11.1/8	3	1	020102	—
1.3/64	1.0469	6.5/8	11.1/4	3	1	020103	—
1.1/16	1.0625	6.5/8	11.1/4	3	1	020104	—
1.5/64	1.0781	6.7/8	12.1/2	4	1	020105	—
1.3/32	1.0937	6.7/8	11.1/2	3	1	—	023106
1.3/32	1.0937	6.7/8	12.1/2	4	1	020106	—
1.7/64	1.1094	7.1/8	11.3/4	3	1	—	023107
1.7/64	1.1094	7.1/8	12.3/4	4	1	020107	—
1.1/8	1.1250	7.1/8	11.3/4	3	1	—	023108
1.1/8	1.1250	7.1/8	12.3/4	4	1	020108	—
1.9/64	1.1406	7.1/4	11.7/8	3	1	—	023109
1.9/64	1.1406	7.1/4	12.7/8	4	1	020109	—
1.5/32	1.1563	7.1/4	11.7/8	3	1	—	023110
1.5/32	1.1563	7.1/4	12.7/8	4	1	020110	—
1.11/64	1.1719	7.3/8	12"	3	1	—	023111
1.11/64	1.1719	7.3/8	13"	4	1	020111	—
1.3/16	1.1875	7.3/8	12"	3	1	—	023112
1.3/16	1.1875	7.3/8	13"	4	1	020112	—
1.13/64	1.2031	7.1/2	12.1/8	3	1	—	023113
1.7/32	1.2187	7.1/2	12.1/8	3	1	—	023114
1.7/32	1.2187	7.1/2	13.1/8	4	1	020114	—
1.15/64	1.2344	7.7/8	13.1/2	4	1	020115	—
1.1/4	1.2500	7.7/8	12.1/2	3	1	—	023116
1.1/4	1.2500	7.7/8	13.1/2	4	1	020116	—
1.17/64	1.2656	8.1/2	14.1/8	4	1	020117	—
1.9/32	1.2813	8.1/2	14.1/8	4	1	020118	—
1.19/64	1.2969	8.5/8	14.1/4	4	1	020119	—
1.5/16	1.3125	8.5/8	14.1/4	4	1	020120	—
1.21/64	1.3281	8.3/4	14.3/8	4	1	020121	—
1.11/32	1.3437	8.3/4	14.3/8	4	1	020122	—

# TAPER SHANK DRILL



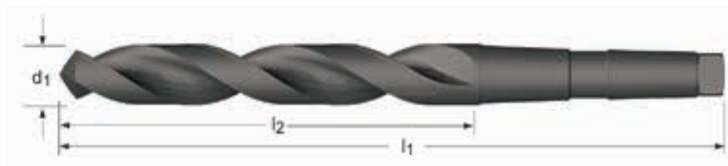
d <sub>1</sub> Ø	d <sub>1</sub> decimal	l <sub>2</sub>	l <sub>1</sub>	MTS	Pack Qty	209	S209
Inch	Inch	Inch	Inch				
1.3/8	1.3750	8.7/8	14.1/2	4	1	020124	—
1.13/32	1.4063	9"	14.5/8	4	1	020126	—
1.27/64	1.4219	9.1/8	14.3/4	4	1	020127	—
1.7/16	1.4375	9.1/8	14.3/4	4	1	020128	—
1.15/32	1.4687	9.1/4	14.7/8	4	1	020130	—
1.31/64	1.4844	9.3/8	15"	4	1	020131	—
1.1/2	1.5000	9.3/8	15"	4	1	020132	—
1.33/64	1.5156	9.3/8	15"	4	1	—	023133
1.17/32	1.5313	9.3/8	15"	4	1	—	023134
1.17/32	1.5313	9.3/8	16.3/8	5	1	020134	—
1.35/64	1.5469	9.5/8	15.1/4	4	1	—	023135
1.9/16	1.5625	9.5/8	15.1/4	4	1	—	023136
1.9/16	1.5625	9.5/8	16.5/8	5	1	020136	—
1.19/32	1.5937	9.7/8	15.1/2	4	1	—	023138
1.39/64	1.6094	10"	15.5/8	4	1	—	023139
1.5/8	1.6250	10"	15.5/8	4	1	—	023140
1.5/8	1.6250	10"	17"	5	1	020140	—
1.21/32	1.6563	10.1/8	15.3/4	4	1	—	023142
1.11/16	1.6875	10.1/8	15.3/4	4	1	—	023144
1.11/16	1.6875	10.1/8	17.1/8	5	1	020144	—
1.47/64	1.7344	10.3/8	16.1/4	4	1	—	023147
1.3/4	1.7500	10.1/8	17.1/8	5	1	020148	—
1.3/4	1.7500	10.3/8	16.1/4	4	1	—	023148
1.25/32	1.7813	10.3/8	16.1/4	4	1	—	023150
1.13/16	1.8125	10.1/8	17.1/8	5	1	020152	—
1.13/16	1.8125	10.3/8	16.1/4	4	1	—	023152
1.7/8	1.8750	10.1/2	16.1/2	4	1	—	023156
1.7/8	1.8750	10.3/8	17.3/8	5	1	020156	—
1.15/16	1.9375	10.3/8	17.3/8	5	1	020160	—
1.15/16	1.9375	10.5/8	16.5/8	4	1	—	023160
1.31/32	1.9687	10.5/8	16.5/8	4	1	—	023162
2"	2.0000	10.3/8	17.3/8	5	1	020200	—
2"	2.0000	10.5/8	16.5/8	4	1	—	023200

## General Purpose Taper Shank, Metric

**5ATS** Steam Oxide for increased wear resistance & lubricity.

**A350** Long series. Steam Oxide for increased wear resistance & lubricity.

**A530** TiN Coating increases wear resistance and improves tool life. Thinned Point design above 14mm diameter to reduce thrust and improve chip formation.



5ATS	A350	A530
5.00 - 50.00	5.00 - 50.00	8.50 - 40.00

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	MTS	Pack Qty	5ATS	A350	A530
5.00	0.1969	74	155	1	1	—	0034071	—
5.00	0.1969	52	133	1	1	026050	—	—
5.50	0.2165	80	161	1	1	—	0034088	—
5.50	0.2165	57	138	1	1	026055	—	—
6.00	0.2362	80	161	1	1	—	0034118	—
6.00	0.2362	57	138	1	1	026060	—	—
6.50	0.2559	63	144	1	1	026065	—	—
6.70	0.2638	86	167	1	1	—	0034125	—
6.80	0.2677	93	174	1	1	—	0034149	—
6.80	0.2677	69	150	1	1	026068	—	—
7.00	0.2756	93	174	1	1	—	0034156	—
7.00	0.2756	69	150	1	1	026070	—	—
7.50	0.2953	93	174	1	1	—	0034163	—
7.50	0.2953	69	150	1	1	026075	—	—
8.00	0.3150	100	181	1	1	—	0034187	—
8.00	0.3150	75	156	1	1	026080	—	—
8.40	0.3307	100	181	1	1	—	0034200	—
8.50	0.3346	100	181	1	1	—	0034217	—
8.50	0.3346	75	156	1	1	026085	—	0041277
8.75	0.3445	107	188	1	1	—	0034224	—
9.00	0.3543	107	188	1	1	—	0034248	—
9.00	0.3543	81	162	1	1	026090	—	0041284
9.50	0.3740	107	188	1	1	—	0034279	—
9.50	0.3740	81	162	1	1	026095	—	—
9.80	0.3858	116	197	1	1	—	0034293	—
10.00	0.3937	116	197	1	1	—	0033241	—
10.00	0.3937	87	168	1	1	026100	—	0040713
10.20	0.4016	116	197	1	1	—	0033265	—
10.20	0.4016	87	168	1	1	026102	—	0040720
10.50	0.4134	116	197	1	1	—	0033289	—
10.50	0.4134	87	168	1	1	026105	—	0040737
10.70	0.4213	125	206	1	1	—	0033296	—
11.00	0.4331	125	206	1	1	—	0033319	—

d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	MTS	Pack Qty	5ATS	A350	A530
11.00	0.4331	94	175	1	1	026110	—	0040744
11.50	0.4528	125	206	1	1	—	0033333	—
11.50	0.4528	94	175	1	1	026115	—	0040751
11.75	0.4626	125	206	1	1	—	0033340	—
11.75	0.4626	94	175	1	1	—	—	0040768
11.80	0.4646	125	206	1	1	—	0033357	—
12.00	0.4724	134	215	1	1	—	0033364	—
12.00	0.4724	101	182	1	1	026120	—	0040775
12.20	0.4803	101	182	1	1	026122	—	—
12.50	0.4921	134	215	1	1	—	0033395	—
12.50	0.4921	101	182	1	1	026125	—	0040799
12.80	0.5039	101	182	1	1	026128	—	—
13.00	0.5118	134	215	1	1	—	0033401	—
13.00	0.5118	101	182	1	1	026130	—	0040812
13.50	0.5315	142	223	1	1	—	0033418	—
13.50	0.5315	108	189	1	1	026135	—	0040829
13.80	0.5433	108	189	1	1	026138	—	—
14.00	0.5512	142	223	1	1	—	0033432	—
14.00	0.5512	108	189	1	1	026140	—	0040836
14.25	0.5610	147	245	2	1	—	0033449	—
14.25	0.5610	114	212	2	1	026142	—	—
14.50	0.5709	147	245	2	1	—	0033456	—
14.50	0.5709	114	212	2	1	026145	—	0040850
14.75	0.5807	147	245	2	1	—	0033463	—
14.75	0.5807	114	212	2	1	026147	—	—
15.00	0.5906	147	245	2	1	—	0033470	—
15.00	0.5906	114	212	2	1	026150	—	0040874
15.25	0.6004	120	218	2	1	—	—	0040881
15.25	0.6004	153	251	2	1	—	0033487	—
15.50	0.6102	153	251	2	1	—	0033494	—
15.50	0.6102	120	218	2	1	026155	—	0040898
15.75	0.6201	153	251	2	1	—	0033500	—
15.75	0.6201	120	218	2	1	026157	—	—
16.00	0.6299	153	251	2	1	—	0033517	—
16.00	0.6299	120	218	2	1	026160	—	0040911
16.25	0.6398	159	257	2	1	—	0033524	—
16.50	0.6496	159	257	2	1	—	0033531	—
16.50	0.6496	125	223	2	1	026165	—	0040935
16.75	0.6594	159	257	2	1	—	0033548	—
17.00	0.6693	159	257	2	1	—	0033555	—
17.00	0.6693	125	223	2	1	026170	—	0040942
17.25	0.6791	165	263	2	1	—	0033562	—
17.50	0.6890	165	263	2	1	—	0033579	—
17.50	0.6890	130	228	2	1	026175	—	0040966
18.00	0.7087	165	263	2	1	—	0033593	—
18.00	0.7087	130	228	2	1	026180	—	0040980
18.50	0.7283	171	269	2	1	—	0033616	—
18.50	0.7283	135	233	2	1	026185	—	0040997
19.00	0.7480	171	269	2	1	—	0033623	—
19.00	0.7480	135	233	2	1	026190	—	0041017
19.50	0.7677	177	275	2	1	—	0033647	—
19.50	0.7677	140	238	2	1	026195	—	0041024
19.75	0.7776	177	275	2	1	—	0033654	—
20.00	0.7874	177	275	2	1	—	0033661	—
20.00	0.7874	140	238	2	1	026200	—	0041048
20.25	0.7972	184	282	2	1	—	0033678	—
20.50	0.8071	184	282	2	1	—	0033685	—
20.50	0.8071	145	243	2	1	026205	—	0041055
21.00	0.8268	184	282	2	1	—	0033692	—
21.00	0.8268	145	243	2	1	026210	—	0041062
21.50	0.8465	191	289	2	1	—	0033708	—
21.50	0.8465	150	248	2	1	026215	—	0041079
22.00	0.8661	191	289	2	1	—	0033715	—
22.00	0.8661	150	248	2	1	026220	—	0041086
22.50	0.8858	198	296	2	1	—	0033722	—
22.50	0.8858	155	253	2	1	026225	—	0041093



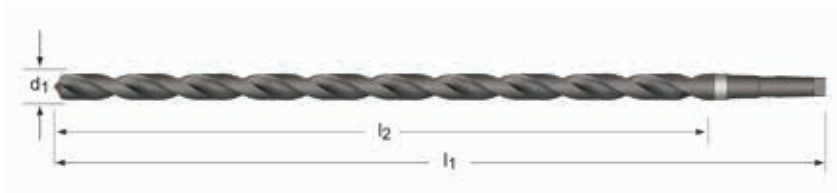
d <sub>1</sub> Øh <sub>8</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	MTS	Pack Qty	5ATS	A350	A530
23.00	0.9055	198	296	2	1	—	0033739	—
23.00	0.9055	155	253	2	1	026230	—	0041109
23.50	0.9252	198	319	3	1	—	0033746	—
23.50	0.9252	155	276	3	1	026235	—	0041116
24.00	0.9449	206	327	3	1	—	0033753	—
24.00	0.9449	160	281	3	1	026240	—	0041123
24.50	0.9646	206	327	3	1	—	0033760	—
24.50	0.9646	160	281	3	1	026245	—	0041130
25.00	0.9843	206	327	3	1	—	0033777	—
25.00	0.9843	160	281	3	1	026250	—	0041147
25.50	1.0039	165	286	3	1	—	—	0041154
25.50	1.0039	214	335	3	1	—	0033784	—
26.00	1.0236	214	335	3	1	—	0033791	—
26.00	1.0236	165	286	3	1	026260	—	0041161
26.50	1.0433	214	335	3	1	—	0033807	—
26.50	1.0433	165	286	3	1	026265	—	0041178
27.00	1.0630	222	343	3	1	—	0033814	—
27.00	1.0630	170	291	3	1	026270	—	0041185
27.50	1.0827	170	291	3	1	—	—	0041192
27.50	1.0827	222	343	3	1	—	0033821	—
28.00	1.1024	222	343	3	1	—	0033838	—
28.00	1.1024	170	291	3	1	026280	—	0041208
28.50	1.1220	175	296	3	1	—	—	0041215
29.00	1.1417	230	351	3	1	—	0033845	—
29.00	1.1417	175	296	3	1	026290	—	0041222
29.50	1.1614	175	296	3	1	—	—	0041239
30.00	1.1811	230	351	3	1	—	0033852	—
30.00	1.1811	175	296	3	1	026300	—	0041246
30.50	1.2008	239	360	3	1	—	0033869	—
31.00	1.2205	239	360	3	1	—	0033876	—
31.00	1.2205	180	301	3	1	026310	—	0041253
31.50	1.2402	239	360	3	1	—	0033883	—
32.00	1.2598	248	397	4	1	—	0033890	—
32.00	1.2598	185	334	4	1	026320	—	0041260
33.00	1.2992	185	334	4	1	—	—	0148433
33.00	1.2992	248	397	4	1	—	0033906	—
34.00	1.3386	257	406	4	1	—	0033913	—
34.00	1.3386	190	339	4	1	026340	—	—
35.00	1.3780	257	406	4	1	—	0033920	—
35.00	1.3780	190	339	4	1	026350	—	0148457
36.00	1.4173	267	416	4	1	—	0033937	—
36.00	1.4173	195	344	4	1	026360	—	—
37.00	1.4567	267	416	4	1	—	0033944	—
37.00	1.4567	195	344	4	1	026370	—	—
38.00	1.4961	277	426	4	1	—	0033951	—
38.00	1.4961	200	349	4	1	026380	—	—
39.00	1.5354	277	426	4	1	—	0033968	—
40.00	1.5748	277	426	4	1	—	0033975	—
40.00	1.5748	200	349	4	1	026400	—	0148471
41.00	1.6142	287	436	4	1	—	0033982	—
42.00	1.6535	287	436	4	1	—	0033999	—
42.00	1.6535	205	354	4	1	026420	—	—
43.00	1.6929	298	447	4	1	—	0034002	—
44.00	1.7323	298	447	4	1	—	0034019	—
44.00	1.7323	210	359	4	1	026440	—	—
45.00	1.7717	298	447	4	1	—	0034026	—
46.00	1.8110	310	459	4	1	—	0034033	—
47.00	1.8504	310	459	4	1	—	0034040	—
48.00	1.8898	321	470	4	1	—	0034057	—
50.00	1.9685	321	470	4	1	—	0034101	—
50.00	1.9685	220	369	4	1	026500	—	—

# TAPER SHANK DRILL



## General Purpose Taper Shank - Extra Length

**A345** Steam Oxide for increase wear resistance & lubricity.



**A345**

DIN 1870/1

10XD

HSS

118°



8.00 - 50.00

$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	MTS	Pack Qty	A345
	8.00	0.3150	165	265	1	1	0418383
	8.50	0.3346	165	265	1	1	0418390
	9.00	0.3543	175	275	1	1	0418406
	9.50	0.3740	175	275	1	1	0420201
3/8	9.52	0.3750	185	285	1	1	0418307
	10.00	0.3937	185	285	1	1	0418062
13/32	10.32	0.4063	185	285	1	1	0418116
	10.50	0.4134	185	285	1	1	0420171
	11.00	0.4331	195	300	1	1	0418079
7/16	11.11	0.4375	195	300	1	1	0418369
	11.50	0.4528	195	300	1	1	0419564
29/64	11.51	0.4531	205	310	1	1	0418284
	12.00	0.4724	205	310	1	1	0418093
	12.50	0.4921	205	310	1	1	0419571
1/2	12.70	0.5000	205	310	1	1	0418055
	13.00	0.5118	205	310	1	1	0418109
17/32	13.49	0.5313	220	325	1	1	0418161
	13.50	0.5315	220	325	1	1	0419588
	14.00	0.5512	220	325	1	1	0418123
9/16	14.29	0.5625	220	340	2	1	0418413
37/64	14.68	0.5781	220	340	2	1	0418321
	15.00	0.5906	220	340	2	1	0418130
39/64	15.48	0.6094	230	355	2	1	0418338
	15.50	0.6102	230	355	2	1	0419601
5/8	15.88	0.6250	230	355	2	1	0418352
	16.00	0.6299	230	355	2	1	0418147
41/64	16.27	0.6406	230	355	2	1	0418345
	16.50	0.6496	230	355	2	1	0419618
21/32	16.67	0.6563	230	355	2	1	0418215
	17.00	0.6693	230	355	2	1	0418154
11/16	17.46	0.6875	245	370	2	1	0418086
	17.50	0.6890	245	370	2	1	0419625

$d_1$ $\varnothing_{h_8}$ Inch	$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	MTS	Pack Qty	A345
	18.00	0.7087	245	370	2	1	0418178
	18.50	0.7283	245	370	2	1	0419632
	19.00	0.7480	245	370	2	1	0418185
3/4	19.05	0.7500	260	385	2	1	0418291
	19.50	0.7677	260	385	2	1	0419649
	20.00	0.7874	260	385	2	1	0418192
	20.50	0.8071	260	385	2	1	0419656
	21.00	0.8268	260	385	2	1	0418208
	21.50	0.8465	270	405	2	1	0419663
	22.00	0.8661	270	405	2	1	0418222
7/8	22.22	0.8750	270	405	2	1	0418376
	22.50	0.8858	270	405	2	1	0419670
	23.00	0.9055	270	405	2	1	0419687
	23.50	0.9252	270	425	3	1	0419694
	24.00	0.9449	290	440	3	1	0418239
	24.50	0.9646	290	440	3	1	0419700
	25.00	0.9843	290	440	3	1	0418246
1"	25.40	1.0000	290	440	3	1	0418031 <sup>1)</sup>
	25.50	1.0039	290	440	3	1	0419717 <sup>1)</sup>
	26.00	1.0236	290	440	3	1	0418253 <sup>1)</sup>
	26.50	1.0433	290	440	3	1	0419724 <sup>1)</sup>
	27.00	1.0630	305	460	3	1	0418260 <sup>1)</sup>
	28.00	1.1024	305	460	3	1	0418277 <sup>1)</sup>
	29.00	1.1417	305	460	3	1	0419731 <sup>1)</sup>
	30.00	1.1811	305	460	3	1	0418314 <sup>1)</sup>
1.1/4	31.75	1.2500	320	480	3	1	0418048 <sup>1)</sup>
	31.00	1.2205	320	480	3	1	0419748 <sup>1)</sup>
	32.00	1.2598	320	505	4	1	0419755 <sup>1)</sup>
	33.00	1.2992	320	505	4	1	0422564 <sup>1)</sup>
	34.00	1.3386	340	530	4	1	0419762 <sup>1)</sup>
	35.00	1.3780	340	530	4	1	0419779 <sup>1)</sup>
	36.00	1.4173	340	530	4	1	0419786 <sup>1)</sup>
	37.00	1.4567	340	530	4	1	0419793 <sup>1)</sup>
	38.00	1.4961	360	555	4	1	0419809 <sup>1)</sup>
1.1/2	38.10	1.5000	360	555	4	1	0419540 <sup>1)</sup>
	39.00	1.5354	360	555	4	1	0419816 <sup>1)</sup>
	40.00	1.5748	360	555	4	1	0419823 <sup>1)</sup>
	41.00	1.6142	360	555	4	1	0419830 <sup>1)</sup>
	42.00	1.6535	360	555	4	1	0419847 <sup>1)</sup>
1.3/4	44.45	1.7500	385	585	4	1	0419557 <sup>1)</sup>
	45.00	1.7717	385	585	4	1	0419854 <sup>1)</sup>
	48.00	1.8898	405	605	4	1	0419861 <sup>1)</sup>
	50.00	1.9685	405	605	4	1	0419878 <sup>1)</sup>

<sup>1)</sup> < 10xD

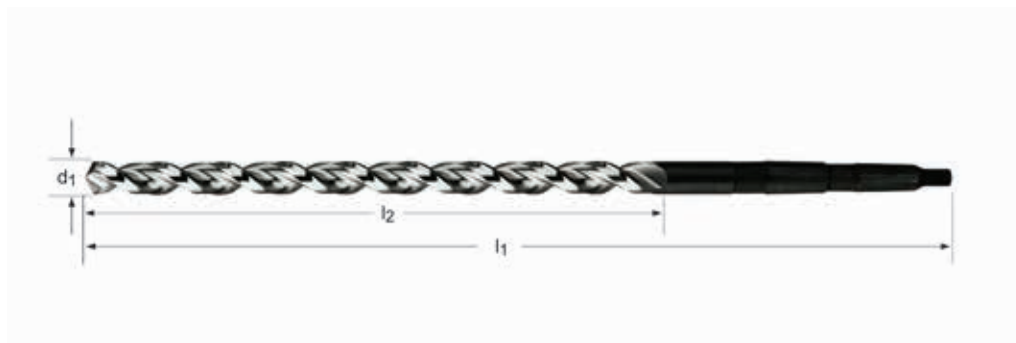
# TAPER SHANK DRILL



## General Purpose Parabolic Flute Taper Shank - Extra Length, Metric

- A951** Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Bright Finish in flutes improves chip flow for soft or non-ferrous materials.
- A952** Parabolic Flute design for efficient chip removal. Allows greater drilling depths in one pass. Bright Finish in flutes improves chip flow for soft or non-ferrous materials.

\* Lands are steam oxide for increased wear resistance & lubricity.



$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	MTS	Pack Qty	A951	A952
8.00	0.3150	210	330	1	1	—	0423639
8.50	0.3346	210	330	1	1	—	0423646
9.00	0.3543	220	345	1	1	—	0423653
10.00	0.3937	185	285	1	1	0418420	—
10.00	0.3937	235	360	1	1	—	0419885
10.50	0.4134	235	360	1	1	—	0419892
11.00	0.4331	195	300	1	1	0418437	—
11.00	0.4331	250	375	1	1	—	0419908
11.50	0.4528	250	375	1	1	—	0419915
12.00	0.4724	205	310	1	1	0418444	—
12.00	0.4724	260	395	1	1	—	0419922
12.50	0.4921	205	310	1	1	0418451	—
12.50	0.4921	260	395	1	1	—	0419939
13.00	0.5118	205	310	1	1	0418468	—
13.00	0.5118	260	395	1	1	—	0420188
13.50	0.5315	220	325	1	1	0418475	—
13.50	0.5315	275	410	1	1	—	0419946
14.00	0.5512	220	325	1	1	0418482	—
14.00	0.5512	275	410	1	1	—	0419953
14.50	0.5709	220	340	2	1	0418499 <sup>1)</sup>	—
14.50	0.5709	275	425	2	1	—	0419960 <sup>2)</sup>
15.00	0.5906	220	340	2	1	0418505 <sup>1)</sup>	—
15.00	0.5906	275	425	2	1	—	0419977 <sup>2)</sup>
15.50	0.6102	230	355	2	1	0418512 <sup>1)</sup>	—
15.50	0.6102	295	445	2	1	—	0419984 <sup>2)</sup>
16.00	0.6299	230	355	2	1	0418529 <sup>1)</sup>	—
16.00	0.6299	295	445	2	1	—	0420195 <sup>2)</sup>
16.50	0.6496	230	355	2	1	0418536 <sup>1)</sup>	—
16.50	0.6496	295	445	2	1	—	0419991 <sup>2)</sup>
17.00	0.6693	230	355	2	1	0418543 <sup>1)</sup>	—
17.00	0.6693	295	445	2	1	—	0420003 <sup>2)</sup>

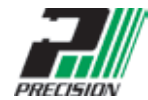
<sup>1)</sup> < 15xD  
<sup>2)</sup> < 20xD

$d_1$ $\varnothing_{h_8}$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	MTS	Pack Qty	A951	A952
17.50	0.6890	245	370	2	1	0418550 <sup>1)</sup>	—
17.50	0.6890	310	465	2	1	—	0420010 <sup>2)</sup>
18.00	0.7087	245	370	2	1	0418567 <sup>1)</sup>	—
18.00	0.7087	310	465	2	1	—	0420027 <sup>2)</sup>
18.50	0.7283	245	370	2	1	0418574 <sup>1)</sup>	—
18.50	0.7283	310	465	2	1	—	0420034 <sup>2)</sup>
19.00	0.7480	245	370	2	1	0418581 <sup>1)</sup>	—
19.00	0.7480	310	465	2	1	—	0420041 <sup>2)</sup>
19.50	0.7677	260	385	2	1	0418598 <sup>1)</sup>	—
19.50	0.7677	325	490	2	1	—	0420058 <sup>2)</sup>
20.00	0.7874	260	385	2	1	0418604 <sup>1)</sup>	—
20.00	0.7874	325	490	2	1	—	0420065 <sup>2)</sup>
21.00	0.8268	260	385	2	1	0418611 <sup>1)</sup>	—
21.00	0.8268	325	490	2	1	—	0420072 <sup>2)</sup>
22.00	0.8661	270	405	2	1	0418628 <sup>1)</sup>	—
22.00	0.8661	345	515	2	1	—	0420089 <sup>2)</sup>
23.00	0.9055	270	405	2	1	0418635 <sup>1)</sup>	—
23.00	0.9055	345	515	2	1	—	0420096 <sup>2)</sup>
24.00	0.9449	290	440	3	1	0418642 <sup>1)</sup>	—
24.00	0.9449	365	555	3	1	—	0420102 <sup>2)</sup>
25.00	0.9843	290	440	3	1	0418659 <sup>1)</sup>	—
25.00	0.9843	365	555	3	1	—	0420119 <sup>2)</sup>
26.00	1.0236	290	440	3	1	0418666 <sup>1)</sup>	—
26.00	1.0236	365	555	3	1	—	0420126 <sup>2)</sup>
27.00	1.0630	305	460	3	1	0418673 <sup>1)</sup>	—
27.00	1.0630	385	580	3	1	—	0420133 <sup>2)</sup>
28.00	1.1024	305	460	3	1	0418680 <sup>1)</sup>	—
28.00	1.1024	385	580	3	1	—	0420140 <sup>2)</sup>
29.00	1.1417	305	460	3	1	0418697 <sup>1)</sup>	—
29.00	1.1417	385	580	3	1	—	0420157 <sup>2)</sup>
30.00	1.1811	305	460	3	1	0418703 <sup>1)</sup>	—
30.00	1.1811	385	580	3	1	—	0420164 <sup>2)</sup>
31.00	1.2205	410	610	3	1	—	0423585 <sup>2)</sup>
32.00	1.2598	410	635	4	1	—	0423592 <sup>2)</sup>
33.00	1.2992	410	635	4	1	—	0423608 <sup>2)</sup>
34.00	1.3386	430	665	4	1	—	0423660 <sup>2)</sup>
35.00	1.3780	430	665	4	1	—	0423677 <sup>2)</sup>
38.00	1.4961	460	695	4	1	—	0423615 <sup>2)</sup>
40.00	1.5748	460	695	4	1	—	0423622 <sup>2)</sup>

<sup>1)</sup> < 15xD

<sup>2)</sup> < 20xD

# COBALT TAPER SHANK DRILL



## Cobalt Heavy Duty Taper Shank

**209CO** Notched Point reduces thrust. Cobalt base material with Bronze Oxide for wear resistance and lubricity. Suitable for ferrous materials.

209CO

ANSI

4XD

HSS-E

135°



1/4 - 1.1/2

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	MTS	Pack Qty	209CO
1/4	0.2500	2.7/8	6.1/8	1	1	021316
9/32	0.2813	3"	6.1/4	1	1	021318
5/16	0.3125	3.1/8	6.3/8	1	1	021320
11/32	0.3437	3.1/4	6.1/2	1	1	021322
3/8	0.3750	3.1/2	7.3/8	2	1	021324
13/32	0.4063	3.5/8	7.1/2	2	1	021326
27/64	0.4219	3.7/8	7.3/4	2	1	021327
7/16	0.4375	3.7/8	7.3/4	2	1	021328
29/64	0.4531	4.1/8	8"	2	1	021329
15/32	0.4687	4.1/8	8"	2	1	021330
31/64	0.4844	4.3/8	8.1/4	2	1	021331
1/2	0.5000	4.3/8	8.1/4	2	1	021332
33/64	0.5156	4.5/8	8.1/2	2	1	021333
17/32	0.5313	4.5/8	8.1/2	2	1	021334
35/64	0.5469	4.7/8	8.3/4	2	1	021335
9/16	0.5625	4.7/8	8.3/4	2	1	021336
37/64	0.5781	4.7/8	8.3/4	2	1	021337
19/32	0.5937	4.7/8	8.3/4	2	1	021338
39/64	0.6094	4.7/8	8.3/4	2	1	021339
5/8	0.6250	4.7/8	8.3/4	2	1	021340
41/64	0.6406	5.1/8	9"	2	1	021341
21/32	0.6563	5.1/8	9.3/4	3	1	021342
43/64	0.6719	5.3/8	10"	3	1	021343
11/16	0.6875	5.3/8	10"	3	1	021344
45/64	0.7031	5.5/8	10.1/4	3	1	021345
23/32	0.7188	5.5/8	10.1/4	3	1	021348
47/64	0.7344	5.7/8	10.1/2	3	1	021347
3/4	0.7500	5.7/8	10.1/2	3	1	021350
49/64	0.7656	6"	10.5/8	3	1	021349
25/32	0.7813	6"	10.5/8	3	1	021352
51/64	0.7969	6.1/8	10.3/4	3	1	021351
13/16	0.8125	6.1/8	10.3/4	3	1	021354
53/64	0.8281	6.1/8	10.3/4	3	1	021353



# COBALT TAPER SHANK DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	MTS	Pack Qty	209CO
27/32	0.8438	6.1/8	10.3/4	3	1	021355
55/64	0.8594	6.1/8	10.3/4	3	1	021357
7/8	0.8750	6.1/8	10.3/4	3	1	021356
57/64	0.8906	6.1/8	10.3/4	3	1	021358
29/32	0.9062	6.1/8	10.3/4	3	1	021359
59/64	0.9219	6.1/8	10.3/4	3	1	021362
15/16	0.9375	6.1/8	10.3/4	3	1	021360
61/64	0.9531	6.3/8	11"	3	1	021363
31/32	0.9688	6.3/8	11"	3	1	021364
63/64	0.9844	6.3/8	11"	3	1	021365
1"	1.0000	6.3/8	11"	3	1	021400
1.1/64	1.0156	6.1/2	12.1/8	4	1	021401
1.1/32	1.0312	6.1/2	12.1/8	4	1	021402
1.1/16	1.0625	6.5/8	12.1/4	4	1	021404
1.3/32	1.0937	6.7/8	12.1/2	4	1	021406
1.7/64	1.1094	7.1/8	12.3/4	4	1	021407
1.1/8	1.1250	7.1/8	12.3/4	4	1	021408
1.11/64	1.1719	7.3/8	13"	4	1	021411
1.3/16	1.1875	7.3/8	13"	4	1	021412
1.7/32	1.2188	7.1/2	13.1/8	4	1	021414
1.1/4	1.2500	7.7/8	13.1/2	4	1	021416
1.9/32	1.2813	8.1/2	14.1/8	4	1	021418
1.11/32	1.3437	8.3/4	14.3/8	4	1	021422
1.3/8	1.3750	8.7/8	14.1/2	4	1	021424
1.7/16	1.4375	9.1/8	14.3/4	4	1	021428
1.1/2	1.5000	9.3/8	15"	4	1	021432

# REDUCED SHANK DRILL



## General Purpose Reduced Shank - 1/2" Shank

**A170** Silver & Deming Drills. Steam Oxide for increased wear resistance & lubricity.

A170



13.00 - 1.1/2



$d_1$ Øh <sub>8</sub> Inch	$d_1$ Øh <sub>8</sub> mm	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A170
	13.00	0.5118			83	156	1	0030165
33/64	13.10	0.5157	3.1/8	6"			1	0121870
17/32	13.49	0.5313	3.1/8	6"			1	0030295
	13.50	0.5315			83	156	1	0030172
35/64	13.89	0.5469	3.1/8	6"			1	0121887
	14.00	0.5512			83	156	1	0030196
9/16	14.29	0.5625	3.1/8	6"			1	0030523
	14.50	0.5709			83	156	1	0030202
37/64	14.68	0.5781	3.1/8	6"			1	0121894
	15.00	0.5906			83	156	1	0030219
19/32	15.08	0.5937	3.1/8	6"			1	0030349
39/64	15.48	0.6094	3.1/8	6"			1	0121900
	15.50	0.6102			83	156	1	0030226
5/8	15.88	0.6250	3.1/8	6"			1	0030509
	16.00	0.6299			84	157	1	0030240
41/64	16.27	0.6406	3.1/8	6"			1	0030479
	16.50	0.6496			84	157	1	0030257
21/32	16.67	0.6563	3.1/8	6"			1	0030370
	17.00	0.6693			84	157	1	0030264
43/64	17.07	0.6719	3.1/8	6"			1	0121917
11/16	17.46	0.6875	3.1/8	6"			1	0030141
	17.50	0.6890			84	157	1	0030271
45/64	17.86	0.7031	3.1/8	6"			1	0030288
	18.00	0.7087			84	157	1	0030301
23/32	18.26	0.7188	3.1/8	6"			1	0030400
	18.50	0.7283			84	157	1	0030318
47/64	18.65	0.7344	3.1/8	6"			1	0121924
	19.00	0.7480			84	157	1	0030325
3/4	19.05	0.7500	3.1/8	6"			1	0030462
49/64	19.45	0.7656	3"	6"			1	0121931
	19.50	0.7677			81	158	1	0030332
25/32	19.84	0.7812	3"	6"			1	0030431
	20.00	0.7874			81	158	1	0030356



$d_1$ $\varnothing h_8$ Inch	$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A170
51/64	20.24	0.7969	3"	6"			1	0030486
13/16	20.64	0.8125	3"	6"			1	0030189
	21.00	0.8268			82	158	1	0030363
53/64	21.03	0.8281	3"	6"			1	0121948
27/32	21.43	0.8437	3"	6"			1	0030448
55/64	21.83	0.8594	3"	6"			1	0121955
	22.00	0.8661			82	158	1	0030387
7/8	22.22	0.8750	3"	6"			1	0030516
57/64	22.62	0.8906	3"	6"			1	0030493
	23.00	0.9055			82	158	1	0030394
29/32	23.02	0.9062	3"	6"			1	0121863
59/64	23.42	0.9220	3"	6"			1	0121962
15/16	23.81	0.9375	3"	6"			1	0030233
	24.00	0.9449			83	159	1	0030417
61/64	24.21	0.9531	3"	6"			1	0121979
31/32	24.61	0.9688	3"	6"			1	0030455
	25.00	0.9843			83	159	1	0030424
63/64	25.00	0.9844	3"	6"			1	0121986
1"	25.40	1.0000	3"	6"			1	0030134
1.1/32	26.19	1.0312	3"	6"			1	0172728
1.1/16	26.99	1.0625	3"	6"			1	0172735
1.7/64	28.18	1.1094	3"	6"			1	0238288
1.1/8	28.58	1.1250	3"	6"			1	0172759
1.9/64	28.97	1.1406	3"	6"			1	0238301
1.5/32	29.37	1.1563	3"	6"			1	0172766
1.3/16	30.16	1.1875	3"	6"			1	0172773
1.7/32	30.96	1.2188	3"	6"			1	0172780
1.1/4	31.75	1.2500	3"	6"			1	0172797
1.5/16	33.34	1.3125	3"	6"			1	0172803
1.3/8	34.93	1.3750	3"	6"			1	0172810
1.7/16	36.51	1.4375	3"	6"			1	0172827
1.1/2	38.10	1.5000	3"	6"			1	0172834

# REDUCED SHANK DRILL



## General Purpose Reduced Shank - 1/2" Shank

**R56** Silver & Deming Drills. Steam Oxide for increased wear resistance & lubricity.



R56

ANSI

4XD

HSS

118°



33/64 - 1.1/2

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R56
33/64	0.5156	3"	6"	1/2	1	091433
17/32	0.5313	3"	6"	1/2	1	091434
35/64	0.5469	3"	6"	1/2	1	091435
9/16	0.5625	3"	6"	1/2	1	091436
37/64	0.5781	3"	6"	1/2	1	091437
19/32	0.5937	3"	6"	1/2	1	091438
39/64	0.6094	3"	6"	1/2	1	091439
5/8	0.6250	3"	6"	1/2	1	091440
41/64	0.6406	3"	6"	1/2	1	091441
21/32	0.6563	3"	6"	1/2	1	091442
43/64	0.6719	3"	6"	1/2	1	091443
11/16	0.6875	3"	6"	1/2	1	091444
45/64	0.7031	3"	6"	1/2	1	091445
23/32	0.7188	3"	6"	1/2	1	091446
47/64	0.7344	3"	6"	1/2	1	091447
3/4	0.7500	3"	6"	1/2	1	091448
49/64	0.7656	3"	6"	1/2	1	091449
25/32	0.7813	3"	6"	1/2	1	091450
51/64	0.7969	3"	6"	1/2	1	091451
13/16	0.8125	3"	6"	1/2	1	091452
53/64	0.8281	3"	6"	1/2	1	091453
27/32	0.8438	3"	6"	1/2	1	091454
55/64	0.8594	3"	6"	1/2	1	091455
7/8	0.8750	3"	6"	1/2	1	091456
57/64	0.8906	3"	6"	1/2	1	091457
29/32	0.9063	3"	6"	1/2	1	091458
59/64	0.9219	3"	6"	1/2	1	091459
15/16	0.9375	3"	6"	1/2	1	091460
61/64	0.9531	3"	6"	1/2	1	091461
31/32	0.9688	3"	6"	1/2	1	091462
63/64	0.9844	3"	6"	1/2	1	091463
1"	1.0000	3"	6"	1/2	1	091464
1.1/64	1.0156	3"	6"	1/2	1	091465



# REDUCED SHANK DRILL

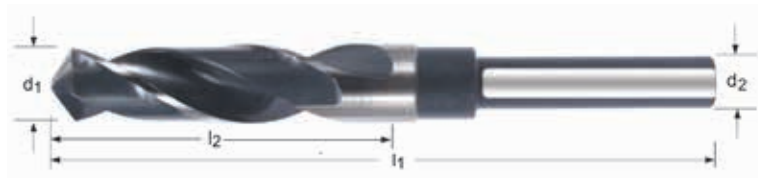
d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R56
1.1/32	1.0312	3"	6"	1/2	1	091486
1.3/64	1.0469	3"	6"	1/2	1	091467
1.1/16	1.0625	3"	6"	1/2	1	091468
1.5/64	1.0781	3"	6"	1/2	1	091469
1.3/32	1.0937	3"	6"	1/2	1	091470
1.7/64	1.1094	3"	6"	1/2	1	091471
1.1/8	1.1250	3"	6"	1/2	1	091472
1.9/64	1.1406	3"	6"	1/2	1	091473
1.5/32	1.1563	3"	6"	1/2	1	091487
1.11/64	1.1719	3"	6"	1/2	1	091474
1.3/16	1.1875	3"	6"	1/2	1	091476
1.13/64	1.2031	3"	6"	1/2	1	091475
1.7/32	1.2187	3"	6"	1/2	1	091488
1.15/64	1.2344	3"	6"	1/2	1	091477
1.1/4	1.2500	3"	6"	1/2	1	091480
1.9/32	1.2813	3"	6"	1/2	1	091479
1.5/16	1.3125	3"	6"	1/2	1	091482
1.11/32	1.3437	3"	6"	1/2	1	091497
1.3/8	1.3750	3"	6"	1/2	1	091483
1.13/32	1.4063	3"	6"	1/2	1	091492
1.7/16	1.4375	3"	6"	1/2	1	091484
1.15/32	1.4687	3"	6"	1/2	1	091495
1.1/2	1.5000	3"	6"	1/2	1	091485

# REDUCED SHANK DRILL



## General Purpose Reduced Shank - 1/2" Shank with 3-Flats

**R57** Silver & Deming Drills with 3-Flat Shank. Steam Oxide for increased wear resistance & lubricity.



R57

ANSI

4XD

HSS

118°



33/64 - 1.1/2

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R57
33/64	0.5156	3"	6"	1/2	1	091533
17/32	0.5313	3"	6"	1/2	1	091534
35/64	0.5469	3"	6"	1/2	1	091535
9/16	0.5625	3"	6"	1/2	1	091536
37/64	0.5781	3"	6"	1/2	1	091537
19/32	0.5937	3"	6"	1/2	1	091538
39/64	0.6094	3"	6"	1/2	1	091539
5/8	0.6250	3"	6"	1/2	1	091540
41/64	0.6406	3"	6"	1/2	1	091541
21/32	0.6563	3"	6"	1/2	1	091542
43/64	0.6719	3"	6"	1/2	1	091543
11/16	0.6875	3"	6"	1/2	1	091544
45/64	0.7031	3"	6"	1/2	1	091545
23/32	0.7188	3"	6"	1/2	1	091546
47/64	0.7344	3"	6"	1/2	1	091547
3/4	0.7500	3"	6"	1/2	1	091548
49/64	0.7656	3"	6"	1/2	1	091549
25/32	0.7813	3"	6"	1/2	1	091550
51/64	0.7969	3"	6"	1/2	1	091551
13/16	0.8125	3"	6"	1/2	1	091552
53/64	0.8281	3"	6"	1/2	1	091553
27/32	0.8438	3"	6"	1/2	1	091554
55/64	0.8594	3"	6"	1/2	1	091555
7/8	0.8750	3"	6"	1/2	1	091556
57/64	0.8906	3"	6"	1/2	1	091557
29/32	0.9063	3"	6"	1/2	1	091558
59/64	0.9219	3"	6"	1/2	1	091559
15/16	0.9375	3"	6"	1/2	1	091560
61/64	0.9531	3"	6"	1/2	1	091561
31/32	0.9688	3"	6"	1/2	1	091562
63/64	0.9844	3"	6"	1/2	1	091563
1"	1.0000	3"	6"	1/2	1	091564
1.1/64	1.0156	3"	6"	1/2	1	091565



# REDUCED SHANK DRILL

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R57
1.1/32	1.0312	3"	6"	1/2	1	091586
1.3/64	1.0469	3"	6"	1/2	1	091567
1.1/16	1.0625	3"	6"	1/2	1	091568
1.5/64	1.0781	3"	6"	1/2	1	091569
1.3/32	1.0937	3"	6"	1/2	1	091570
1.7/64	1.1094	3"	6"	1/2	1	091571
1.1/8	1.1250	3"	6"	1/2	1	091572
1.9/64	1.1406	3"	6"	1/2	1	091573
1.5/32	1.1563	3"	6"	1/2	1	091587
1.11/64	1.1719	3"	6"	1/2	1	091575
1.3/16	1.1875	3"	6"	1/2	1	091576
1.13/64	1.2031	3"	6"	1/2	1	091577
1.7/32	1.2187	3"	6"	1/2	1	091588
1.15/64	1.2344	3"	6"	1/2	1	091579
1.1/4	1.2500	3"	6"	1/2	1	091580
1.9/32	1.2813	3"	6"	1/2	1	091589
1.5/16	1.3125	3"	6"	1/2	1	091582
1.11/32	1.3437	3"	6"	1/2	1	091592
1.3/8	1.3750	3"	6"	1/2	1	091583
1.13/32	1.4063	3"	6"	1/2	1	091595
1.7/16	1.4375	3"	6"	1/2	1	091584
1.15/32	1.4687	3"	6"	1/2	1	091598
1.1/2	1.5000	3"	6"	1/2	1	091585

# REDUCED SHANK DRILL



## General Purpose Reduced Shank - 3/4" Shank

**R58** Silver & Deming Drills. Steam Oxide for increased wear resistance & lubricity

R58



1" - 2"

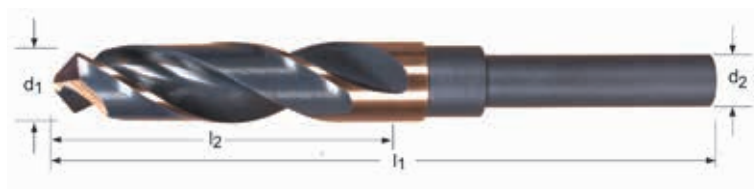
d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R58
1"	1.0000	3"	6"	3/4"	1	091264
1.1/32	1.0312	3"	6"	3/4"	1	091266
1.1/16	1.0625	3"	6"	3/4"	1	091268
1.3/32	1.0937	3"	6"	3/4"	1	091270
1.1/8	1.1250	3"	6"	3/4"	1	091272
1.5/32	1.1563	3"	6"	3/4"	1	091274
1.3/16	1.1875	3"	6"	3/4"	1	091276
1.7/32	1.2187	3"	6"	3/4"	1	091278
1.1/4	1.2500	3"	6"	3/4"	1	091280
1.9/32	1.2813	3"	6"	3/4"	1	091282
1.5/16	1.3125	3"	6"	3/4"	1	091284
1.11/32	1.3437	3"	6"	3/4"	1	091286
1.3/8	1.3750	3"	6"	3/4"	1	091288
1.13/32	1.4063	3"	6"	3/4"	1	091290
1.7/16	1.4375	3"	6"	3/4"	1	091292
1.15/32	1.4687	3"	6"	3/4"	1	091294
1.1/2	1.5000	3"	6"	3/4"	1	091296
1.9/16	1.5625	3"	6"	3/4"	1	091298
1.5/8	1.6250	3"	6"	3/4"	1	091300
1.11/16	1.6875	3"	6"	3/4"	1	091302
1.3/4	1.7500	3"	6"	3/4"	1	091304
1.13/16	1.8125	3"	6"	3/4"	1	091306
1.7/8	1.8750	3"	6"	3/4"	1	091308
1.15/16	1.9375	3"	6"	3/4"	1	091310
2"	2.0000	3"	6"	3/4"	1	091312



# REDUCED SHANK DRILL

## Cobalt, Heavy Duty, Reduced Shank - 1/2" Shank

**R56CO** Silver & Deming Drills. Self centering Split Point reduces thrust. Cobalt base material with Bronze/Steam Oxide for wear resistance and lubricity. Suitable for ferrous materials.



R56CO

ANSI

4XD

HSS-E

118°



33/64 - 1"

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	R56CO
33/64	0.5156	3"	6"	1/2	1	092333
17/32	0.5313	3"	6"	1/2	1	092334
35/64	0.5469	3"	6"	1/2	1	092335
9/16	0.5625	3"	6"	1/2	1	092336
37/64	0.5781	3"	6"	1/2	1	092337
19/32	0.5937	3"	6"	1/2	1	092338
39/64	0.6094	3"	6"	1/2	1	092339
5/8	0.6250	3"	6"	1/2	1	092340
41/64	0.6406	3"	6"	1/2	1	092341
21/32	0.6563	3"	6"	1/2	1	092342
43/64	0.6719	3"	6"	1/2	1	092343
11/16	0.6875	3"	6"	1/2	1	092344
45/64	0.7031	3"	6"	1/2	1	092345
23/32	0.7188	3"	6"	1/2	1	092346
47/64	0.7344	3"	6"	1/2	1	092347
3/4	0.7500	3"	6"	1/2	1	092348
49/64	0.7656	3"	6"	1/2	1	092349
25/32	0.7813	3"	6"	1/2	1	092350
51/64	0.7969	3"	6"	1/2	1	092351
13/16	0.8125	3"	6"	1/2	1	092352
53/64	0.8281	3"	6"	1/2	1	092353
27/32	0.8438	3"	6"	1/2	1	092354
55/64	0.8594	3"	6"	1/2	1	092355
7/8	0.8750	3"	6"	1/2	1	092356
57/64	0.8906	3"	6"	1/2	1	092357
29/32	0.9063	3"	6"	1/2	1	092358
59/64	0.9219	3"	6"	1/2	1	092359
15/16	0.9375	3"	6"	1/2	1	092360
61/64	0.9531	3"	6"	1/2	1	092361
31/32	0.9688	3"	6"	1/2	1	092362
63/64	0.9844	3"	6"	1/2	1	092363
1"	1.0000	3"	6"	1/2	1	092364

# SPECIAL PURPOSE DRILL



## Jobber Length Carbide Tipped

**D444** Heavy-Duty Brazed Carbide Tipped for abrasive materials or non-ferrous materials.

D444



N32 - 1/2



$d_1$ Ø "/Nr./letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	D444
32	0.1160	1.5/8	2.3/4	1	034632
1/8	0.1250	1.5/8	2.3/4	1	034408
30	0.1285	1.5/8	2.3/4	1	034630
29	0.1360	1.3/4	2.7/8	1	034629
9/64	0.1406	1.3/4	2.7/8	1	034409
25	0.1495	1.7/8	3"	1	034625
5/32	0.1563	2"	3.1/8	1	034410
21	0.1590	2.1/8	3.1/4	1	034621
20	0.1610	2.1/8	3.1/4	1	034620
19	0.1660	2.1/8	3.1/4	1	034619
18	0.1695	2.1/8	3.1/4	1	034618
11/64	0.1719	2.1/8	3.1/4	1	034411
17	0.1730	2.3/16	3.3/8	1	034617
15	0.1800	2.3/16	3.3/8	1	034615
14	0.1820	2.3/16	3.3/8	1	034614
13	0.1850	2.5/16	3.1/2	1	034613
3/16	0.1875	2.5/16	3.1/2	1	034412
11	0.1910	2.5/16	3.1/2	1	034611
10	0.1935	2.7/16	3.5/8	1	034610
9	0.1960	2.7/16	3.5/8	1	034609
7	0.2010	2.7/16	3.5/8	1	034607
13/64	0.2031	2.7/16	3.5/8	1	034413
3	0.2130	2.1/2	3.3/4	1	034603
7/32	0.2188	2.1/2	3.3/4	1	034414
1	0.2280	2.5/8	3.7/8	1	034601
15/64	0.2344	2.5/8	3.7/8	1	034415
B	0.2380	2.3/4	4"	1	034502
C	0.2420	2.3/4	4"	1	034503
E	0.2500	2.3/4	4"	1	034505
1/4	0.2500	2.3/4	4"	1	034416
F	0.2570	2.7/8	4.1/8	1	034506
G	0.2610	2.7/8	4.1/8	1	034507
17/64	0.2656	2.7/8	4.1/8	1	034417





# SPECIAL PURPOSE DRILL

$d_1$ Ø "Nr./letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	D444
H	0.2660	2.7/8	4.1/8	1	034508
I	0.2720	2.7/8	4.1/8	1	034509
J	0.2770	2.7/8	4.1/8	1	034510
K	0.2810	2.15/16	4.1/4	1	034511
9/32	0.2813	2.15/16	4.1/4	1	034418
L	0.2900	2.15/16	4.1/4	1	034512
19/64	0.2969	3.1/16	4.3/8	1	034419
N	0.3020	3.1/16	4.3/8	1	034514
5/16	0.3125	3.3/16	4.1/2	1	034420
O	0.3160	3.3/16	4.1/2	1	034515
P	0.3230	3.5/16	4.5/8	1	034516
21/64	0.3281	3.5/16	4.5/8	1	034421
Q	0.3320	3.7/16	4.3/4	1	034517
R	0.3390	3.7/16	4.3/4	1	034518
11/32	0.3437	3.7/16	4.3/4	1	034422
S	0.3480	3.1/2	4.7/8	1	034519
T	0.3580	3.1/2	4.7/8	1	034520
23/64	0.3594	3.1/2	4.7/8	1	034423
U	0.3680	3.5/8	5"	1	034521
3/8	0.3750	3.5/8	5"	1	034424
25/64	0.3906	3.3/4	5.1/8	1	034425
13/32	0.4063	3.7/8	5.1/4	1	034426
Z	0.4130	3.7/8	5.1/4	1	034526
27/64	0.4219	3.15/16	5.3/8	1	034427
7/16	0.4375	4.1/16	5.1/2	1	034428
29/64	0.4531	4.3/16	5.5/8	1	034429
15/32	0.4687	4.5/16	5.3/4	1	034430
31/64	0.4844	4.3/8	5.7/8	1	034431
1/2	0.5000	4.1/2	6"	1	034432

# SPECIAL PURPOSE DRILL



## Jobber Length Carbide Tipped

**A160** Heavy-Duty Brazed Carbide Tipped for abrasive materials or non-ferrous materials.

A160

DIN  
338

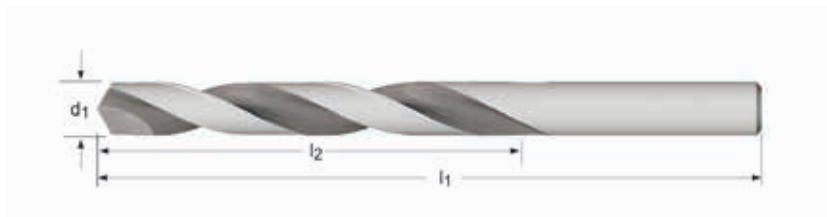
4XD

HSS  
HM

118°



4.00 - 16.00



$d_1$ $\varnothing h_8$ mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	A160
4.00	0.1575	43	75	1	0029725
4.50	0.1772	47	80	1	0029732
5.00	0.1969	52	86	1	0029749
5.50	0.2165	57	93	1	0029756
6.00	0.2362	57	93	1	0029763
6.50	0.2559	63	101	1	0029770
6.80	0.2677	69	109	1	0029787
7.00	0.2756	69	109	1	0029794
7.50	0.2953	69	109	1	0029800
8.00	0.3150	75	117	1	0029817
8.50	0.3346	75	117	1	0029824
9.00	0.3543	81	125	1	0029831
9.50	0.3740	81	125	1	0029848
10.00	0.3937	87	133	1	0029626
10.20	0.4016	87	133	1	0029633
10.50	0.4134	87	133	1	0029640
11.00	0.4331	94	142	1	0029657
11.50	0.4528	94	142	1	0029664
12.00	0.4724	101	151	1	0029671
13.00	0.5118	101	151	1	0029688
14.00	0.5512	108	160	1	0029695
15.00	0.5906	114	169	1	0029701
16.00	0.6299	120	178	1	0029718



# SOLID CARBIDE DRILL

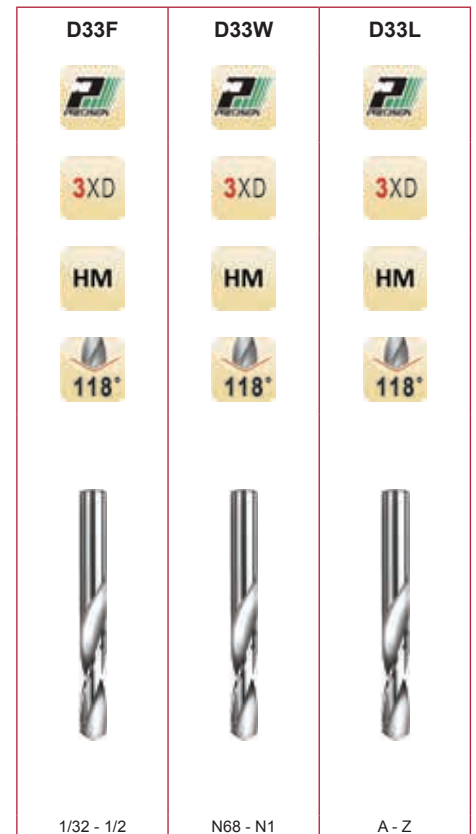
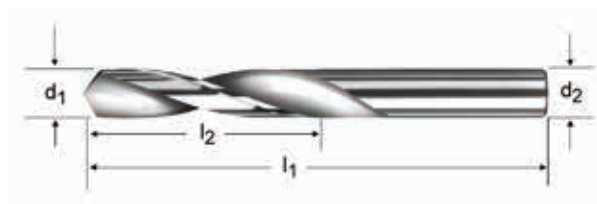
## General Purpose Solid Carbide Jobber Length

**D33F** - Fractional Sizes

**D33W** - Wire Gauge Sizes

**D33L** - Letter Sizes

4-Facet Self Centering Point. Low thrust design. For abrasive or non-ferrous materials.



$d_1$ Ø Inch	$d_1$ Ø Nr.	$d_1$ Ø letter	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	D33F	D33W	D33L	
1/32	68		0.0310	5/16	1.1/4	1	—	003500	—	
			0.0313	5/16	1.1/4	1	003501	—	—	
		67		0.0320	5/16	1.1/4	1	—	003502	—
		66		0.0330	5/16	1.1/4	1	—	003503	—
		65		0.0350	5/8	1.3/8	1	—	003504	—
		64		0.0360	5/8	1.3/8	1	—	003505	—
		63		0.0370	5/8	1.3/8	1	—	003506	—
		62		0.0380	5/8	1.3/8	1	—	003507	—
		61		0.0390	5/8	1.3/8	1	—	003508	—
		60		0.0400	3/4	1.1/2	1	—	003509	—
3/64	59		0.0410	3/4	1.1/2	1	—	003510	—	
	58		0.0420	3/4	1.1/2	1	—	003511	—	
	57		0.0430	3/4	1.1/2	1	—	003512	—	
	56		0.0465	3/4	1.1/2	1	—	003513	—	
			0.0469	3/4	1.1/2	1	003514	—	—	
		55		0.0520	3/4	1.1/2	1	—	003515	—
		54		0.0550	3/4	1.1/2	1	—	003516	—
		53		0.0595	3/4	1.1/2	1	—	003517	—
	1/16			0.0625	3/4	1.1/2	1	003518	—	—
		52		0.0635	3/4	1.1/2	1	—	003519	—
5/64	51		0.0670	3/4	1.1/2	1	—	003520	—	
	50		0.0700	7/8	1.3/4	1	—	003521	—	
	49		0.0730	7/8	1.3/4	1	—	003522	—	
	48		0.0760	7/8	1.3/4	1	—	003523	—	
			0.0781	7/8	1.3/4	1	003524	—	—	
		47		0.0785	7/8	1.3/4	1	—	003525	—
		46		0.0810	7/8	1.3/4	1	—	003526	—
		45		0.0820	7/8	1.3/4	1	—	003527	—
		44		0.0860	1"	2"	1	—	003528	—
		43		0.0890	1"	2"	1	—	003529	—
3/32	42		0.0935	1"	2"	1	—	003530	—	
			0.0938	1"	2"	1	003531	—	—	
		41		0.0960	1"	2"	1	—	003532	—

# SOLID CARBIDE DRILL



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	D33F	D33W	D33L
	40		0.0980	1"	2"	1	—	003533	—
	39		0.0995	1.1/4	2.1/4	1	—	003534	—
	38		0.1015	1.1/4	2.1/4	1	—	003535	—
	37		0.1040	1.1/4	2.1/4	1	—	003536	—
	36		0.1065	1.1/4	2.1/4	1	—	003537	—
7/64			0.1094	1.1/4	2.1/4	1	003538	—	—
	35		0.1100	1.1/4	2.1/4	1	—	003539	—
	34		0.1110	1.1/4	2.1/4	1	—	003540	—
	33		0.1130	1.1/4	2.1/4	1	—	003541	—
	32		0.1160	1.1/4	2.1/4	1	—	003542	—
	31		0.1200	1.1/4	2.1/4	1	—	003543	—
1/8			0.1250	1.1/4	2.1/4	1	003544	—	—
	30		0.1285	1.1/4	2.1/4	1	—	003545	—
	29		0.1360	1.3/8	2.1/2	1	—	003546	—
	28		0.1405	1.3/8	2.1/2	1	—	003547	—
9/64			0.1406	1.3/8	2.1/2	1	003548	—	—
	27		0.1440	1.3/8	2.1/2	1	—	003549	—
	26		0.1470	1.3/8	2.1/2	1	—	003550	—
	25		0.1495	1.3/8	2.1/2	1	—	003551	—
	24		0.1520	1.3/8	2.1/2	1	—	003552	—
	23		0.1540	1.3/8	2.1/2	1	—	003553	—
5/32			0.1563	1.3/8	2.1/2	1	003554	—	—
	22		0.1570	1.3/8	2.1/2	1	—	003555	—
	21		0.1590	1.3/8	2.1/2	1	—	003556	—
	20		0.1610	1.3/8	2.1/2	1	—	003557	—
	19		0.1660	1.5/8	2.3/4	1	—	003558	—
	18		0.1695	1.5/8	2.3/4	1	—	003559	—
11/64			0.1719	1.5/8	2.3/4	1	003560	—	—
	17		0.1730	1.5/8	2.3/4	1	—	003561	—
	16		0.1770	1.5/8	2.3/4	1	—	003562	—
	15		0.1800	1.5/8	2.3/4	1	—	003563	—
	14		0.1820	1.5/8	2.3/4	1	—	003564	—
	13		0.1850	1.5/8	2.3/4	1	—	003565	—
3/16			0.1875	1.5/8	2.3/4	1	003566	—	—
	12		0.1890	1.5/8	2.3/4	1	—	003567	—
	11		0.1910	1.5/8	2.3/4	1	—	003568	—
	10		0.1935	1.5/8	2.3/4	1	—	003569	—
	9		0.1960	1.3/4	3"	1	—	003570	—
	8		0.1990	1.3/4	3"	1	—	003571	—
	7		0.2010	1.3/4	3"	1	—	003572	—
13/64			0.2031	1.3/4	3"	1	003573	—	—
	6		0.2040	1.3/4	3"	1	—	003574	—
	5		0.2055	1.3/4	3"	1	—	003575	—
	4		0.2090	1.3/4	3"	1	—	003576	—
	3		0.2130	1.3/4	3"	1	—	003577	—
7/32			0.2188	1.3/4	3"	1	003578	—	—
	2		0.2210	1.3/4	3"	1	—	003579	—
	1		0.2280	1.3/4	3"	1	—	003580	—
		A	0.2340	2"	3.1/4	1	—	—	003581
15/64			0.2344	2"	3.1/4	1	003582	—	—
		B	0.2380	2"	3.1/4	1	—	—	003583
		C	0.2420	2"	3.1/4	1	—	—	003584
		D	0.2460	2"	3.1/4	1	—	—	003585
1/4			0.2500	2"	3.1/4	1	003586	—	—
		F	0.2570	2"	3.1/4	1	—	—	003587
		G	0.2610	2.1/8	3.1/2	1	—	—	003588
17/64			0.2656	2.1/8	3.1/2	1	003589	—	—
		H	0.2660	2.1/8	3.1/2	1	—	—	003590
		I	0.2720	2.1/8	3.1/2	1	—	—	003591
		J	0.2770	2.1/8	3.1/2	1	—	—	003592
		K	0.2810	2.1/8	3.1/2	1	—	—	003593
9/32			0.2813	2.1/8	3.1/2	1	003594	—	—
		L	0.2900	2.1/8	3.1/2	1	—	—	003595
		M	0.2950	2.3/8	3.3/4	1	—	—	003596
19/64			0.2969	2.3/8	3.3/4	1	003597	—	—
		N	0.3020	2.3/8	3.3/4	1	—	—	003598



# SOLID CARBIDE DRILL

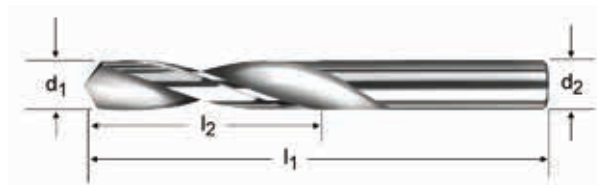
d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø letter	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	D33F	D33W	D33L
5/16			0.3125	2.3/8	3.3/4	1	003599	—	—
		O	0.3160	2.3/8	3.3/4	1	—	—	003600
		P	0.3230	2.3/8	3.3/4	1	—	—	003601
21/64			0.3281	2.1/2	4"	1	003602	—	—
		Q	0.3320	2.1/2	4"	1	—	—	003603
		R	0.3390	2.1/2	4"	1	—	—	003604
11/32			0.3437	2.1/2	4"	1	003605	—	—
		S	0.3480	2.1/2	4"	1	—	—	003606
		T	0.3580	2.1/2	4"	1	—	—	003607
23/64			0.3594	2.3/4	4.1/4	1	003608	—	—
		U	0.3680	2.3/4	4.1/4	1	—	—	003609
3/8			0.3750	2.3/4	4.1/4	1	003610	—	—
		V	0.3770	2.3/4	4.1/4	1	—	—	003611
		W	0.3860	2.7/8	4.1/2	1	—	—	003612
25/64			0.3906	2.7/8	4.1/2	1	003613	—	—
		X	0.3970	2.7/8	4.1/2	1	—	—	003614
		Y	0.4040	2.7/8	4.1/2	1	—	—	003615
13/32			0.4063	2.7/8	4.1/2	1	003616	—	—
		Z	0.4130	2.7/8	4.1/2	1	—	—	003617
27/64			0.4219	2.7/8	4.1/2	1	003618	—	—
7/16			0.4375	2.7/8	4.1/2	1	003619	—	—
29/64			0.4531	3"	4.3/4	1	003620	—	—
15/32			0.4687	3"	4.3/4	1	003621	—	—
31/64			0.4844	3"	4.3/4	1	003622	—	—
1/2			0.5000	3"	4.3/4	1	003623	—	—

# SOLID CARBIDE DRILL



## General Purpose Solid Carbide Jobber Length, Metric

**D33M** Self Centering Point. Low thrust design. For abrasive or non-ferrous materials.



D33M



0.80 - 12.00

$d_1$ Ø mm	$d_1$ decimal Inch	$l_2$ mm	$l_1$ mm	Pack Qty	D33M
0.80	0.0315	12	31	1	003470
0.90	0.0354	16	35	1	003471
1.00	0.0394	16	38	1	003472
1.50	0.0591	19	38	1	003473
2.00	0.0787	22	44	1	003474
2.05	0.0807	22	44	1	003475
2.50	0.0984	25	50	1	003476
3.00	0.1181	32	57	1	003477
3.30	0.1299	32	57	1	003624
3.50	0.1378	35	63	1	003478
4.00	0.1575	35	63	1	003626
4.50	0.1772	41	70	1	003479
5.00	0.1969	44	75	1	003630
5.50	0.2165	44	75	1	003480
6.00	0.2362	50	82	1	003481
6.50	0.2559	50	82	1	003482
7.00	0.2756	54	89	1	003483
7.50	0.2953	60	95	1	003484
8.00	0.3150	60	95	1	003485
8.50	0.3346	63	100	1	003486
9.00	0.3543	70	100	1	003487
9.50	0.3740	70	108	1	003488
10.00	0.3937	73	114	1	003631
10.50	0.4134	73	114	1	003489
10.75	0.4232	73	114	1	003490
11.00	0.4331	73	114	1	003491
11.50	0.4528	76	120	1	003492
12.00	0.4724	76	120	1	003493

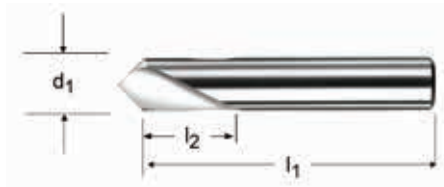


# SOLID CARBIDE DRILL

## General Purpose Solid Carbide Standard Length - Spotting Drill

**DS-90**  
**DS-120**  
**DS-142**

Provides spot location or chamfer for follow-up drilling operations.



DS-90	DS-120	DS-142
1/8 - 1/2	1/8 - 1/2	1/8 - 1/2

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	DS-90	DS-120	DS-142
1/8	0.1250	3/8	2"	1	003332	7378063	7378069
3/16	0.1875	3/4	3"	1	003334	7378064	7378970
1/4	0.2500	3/4	3"	1	003336	7378068	7378974
5/16	0.3125	1"	2.1/2	1	003338	7378066	7378972
3/8	0.3750	1"	3"	1	003340	7378065	7378971
1/2	0.5000	1"	4"	1	003342	7378067	7378973

# SPECIAL PURPOSE DRILL



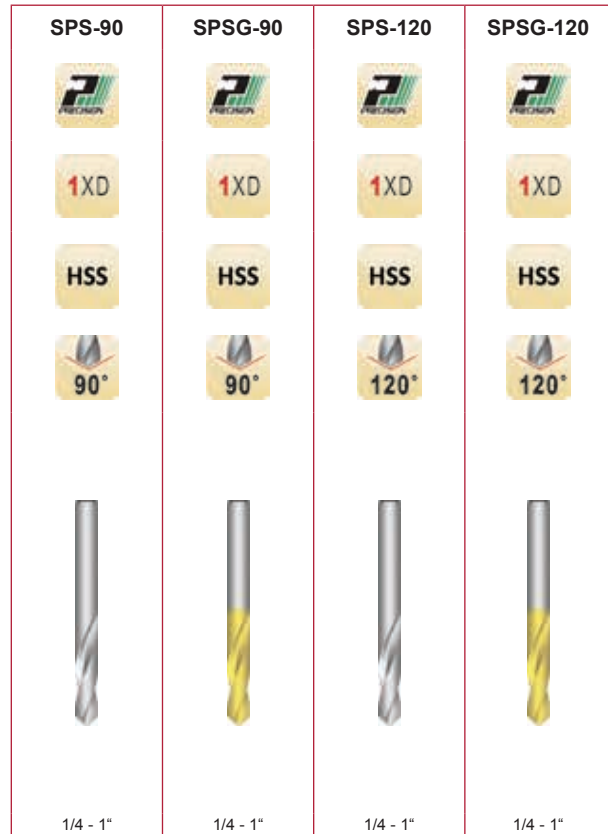
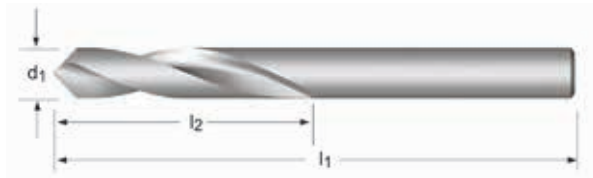
## Spotting Drill - Short Length

**SPS-90** Bright Finish improves chip flow in soft or non-ferrous materials

**SPSG-90** TiN Coating for increased wear resistance and improved tool life.

**SPS-120** Bright Finish improves chip flow in soft or non-ferrous materials

**SPSG-120** TiN Coating for increased wear resistance and improved tool life.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	SPS-90	SPSG-90	SPS-120	SPSG-120
1/4	0.2500	3/4	2.1/2	1	087900	087906	087950	087956
3/8	0.3750	1.1/8	3.1/8	1	087901	087907	087951	087957
1/2	0.5000	1.3/8	3.3/4	1	087902	087908	087952	087958
5/8	0.6250	1.5/8	4.3/8	1	087903	087909	087953	087959
3/4	0.7500	1.7/8	5"	1	087904	087910	087954	087960
1"	1.0000	2.1/4	6"	1	087905	087911	087955	087961





# SPECIAL PURPOSE DRILL

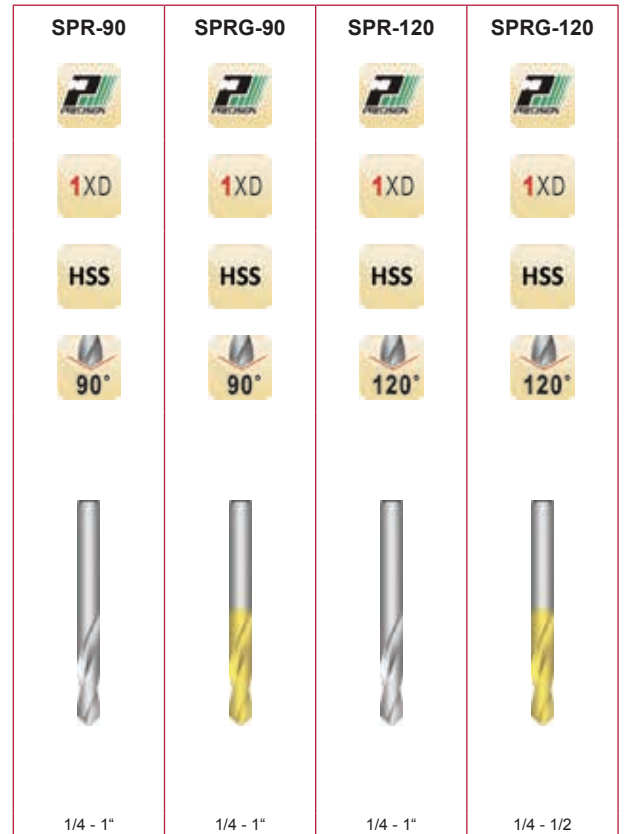
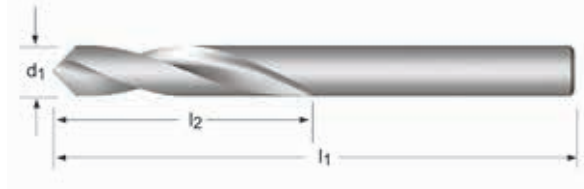
## Spotting Drill - Regular Length

**SPR-90** Bright Finish improves chip flow in soft or non-ferrous materials

**SPRG-90** TiN Coating for increased wear resistance and improved tool life.

**SPR-120** Bright Finish improves chip flow in soft or non-ferrous materials

**SPRG-120** TiN Coating for increased wear resistance and improved tool life.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	SPR-90	SPRG-90	SPR-120	SPRG-120
1/4	0.2500	3/4	4"	1	087912	087918	087962	087968
3/8	0.3750	1.1/8	5"	1	087913	087919	087963	087969
1/2	0.5000	1.3/8	6"	1	087914	087920	087964	087970
5/8	0.6250	1.5/8	7"	1	087915	087921	087965	—
3/4	0.7500	1.7/8	8"	1	087916	087922	087966	—
1"	1.0000	2.1/4	8"	1	087917	087923	087967	—

# SPECIAL PURPOSE DRILL



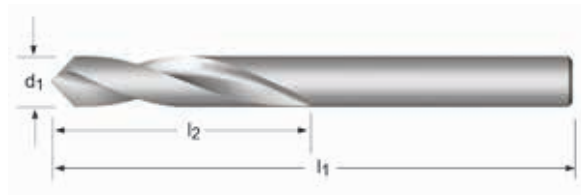
## Spotting Drill - Long Length

**SPL-90** Bright Finish improves chip flow in soft or non-ferrous materials

**SPLG-90** TiN Coating for increased wear resistance and improved tool life.

**SPL-120** Bright Finish improves chip flow in soft or non-ferrous materials

**SPLG-120** TiN Coating for increased wear resistance and improved tool life.



SPL-90	SPLG-90	SPL-120	SPLG-120
1/4 - 1"	1/4 - 1"	1/4 - 5/8	1/4 - 1/2

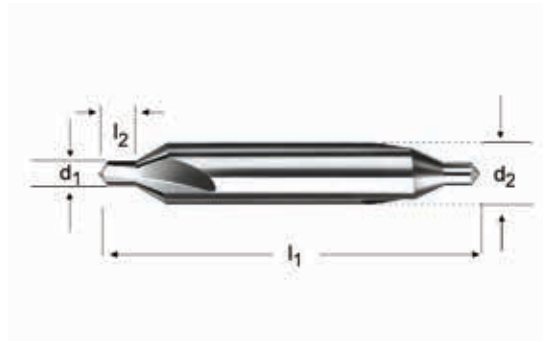
$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	Pack Qty	SPL-90	SPLG-90	SPL-120	SPLG-120
1/4	0.2500	3/4	6"	1	087924	087930	087974	087980
3/8	0.3750	1.1/8	7"	1	087925	087931	087975	087981
1/2	0.5000	1.3/8	8"	1	087926	087932	087976	087982
5/8	0.6250	1.5/8	9"	1	087927	—	087977	—
3/4	0.7500	1.7/8	10"	1	087928	087934	—	—
1"	1.0000	2.1/4	10"	1	087929	087935	—	—



# SOLID CARBIDE DRILL

## General Purpose Combined Drill and Countersink (Center Drill)

**DC** 60° C'sink. Better abrasion resistance / Longer tool life. Bright Finish improves chip flow in soft or non-ferrous materials



DC



1XD

HM



N0 - N6

Nr.	$d_1$ Ø Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	Pack Qty	DC
0	1/32	1/32	1.1/2	1/8	1	003251
1	3/64	3/64	1.1/2	1/8	1	003252
2	5/64	5/64	2"	3/16	1	003253
3	7/64	7/64	2"	1/4	1	003254
4	1/8	1/8	2.1/8	5/16	1	003255
5	3/16	3/16	2.3/4	7/16	1	003256
6	7/32	7/32	3"	1/2	1	003257

# SPECIAL PURPOSE DRILL



## General Purpose Combined Drill and Countersink (Center Drill)

**76HA** 60° C'sink. Bright Finish improves chip flow in soft or non-ferrous materials



76HA

ANSI

1XD

HSS



N000 - N8

Nr.	d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	76HA
000	0.0200	0.0300	1.1/4	1/8	12	097630
00	0.0250	0.0300	1.1/8	1/8	12	097620
0	1/32	0.0380	1.1/8	1/8	12	097610
1	3/64	3/64	1.1/4	1/8	12	097601
2	5/64	5/64	1.7/8	3/16	12	097602
3	7/64	7/64	2"	1/4	12	097603
4	1/8	1/8	2.1/8	5/16	12	097604
5	3/16	3/16	2.3/4	7/16	6	097605
6	7/32	7/32	3"	1/2	6	097606
7	1/4	1/4	3.1/4	5/8	1	097607
8	5/16	5/16	3.1/2	3/4	1	097608

## General Purpose Combined Drill and Countersink (Center Drill)

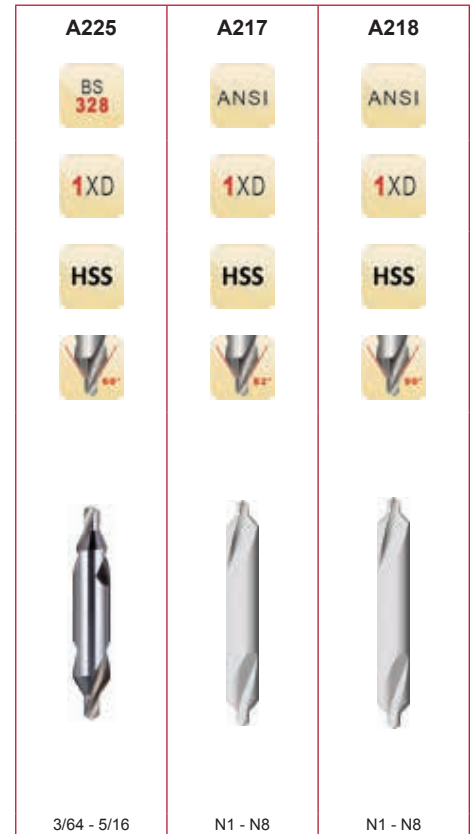
**A225** 60° C'sink. Bright Finish improves chip flow in soft or non-ferrous materials

**A217** 82° C'sink. Bright Finish improves chip flow in soft or non-ferrous materials

**A217SET** 5 pc. set consists of N1, N2, N3, N4 & N5

**A218** 90° C'sink. Bright Finish improves chip flow in soft or non-ferrous materials

**A218SET** 5 pc. set consists of N1, N2, N3, N4 & N5



Nr.	d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> max/min Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	A225	A217	A218
BS1	3/64	0.0469	5/64 - 1/16	1.1/2	1/8	1	0172988	—	—
BS2	1/16	0.0625	3/32 - 5/64	1.3/4	3/16	1	0172995	—	—
BS3	3/32	0.0938	5/32 - 1/8	2"	1/4	1	0173008	—	—
BS4	1/8	0.1250	3/16 - 5/32	2.1/4	5/16	1	0173015	—	—
BS5	3/16	0.1875	9/32 - 1/4	2.1/2	7/16	1	0173022	—	—
BS5A	7/32	0.2188	5/16 - 9/32	2.3/4	1/2	1	0173039	—	—
BS6	1/4	0.2500	3/8 - 5/16	3"	5/8	1	0173046	—	—
BS7	5/16	0.3125	15/32 - 13/32	3.1/2	3/4	1	0173053	—	—
1		0.0469	.055-.067	1.1/4	1/8	1	—	0239216	—
1		0.0469	.055-.067	1.1/4	1/8	1	—	—	0239292
2		0.0781	.094-.106	1.7/8	3/16	1	—	0239223	—
2		0.0781	.094-.106	1.7/8	3/16	1	—	—	0239308
3		0.1094	.130-.154	2"	1/4	1	—	0239230	—
3		0.1094	.130-.154	2"	1/4	1	—	—	0239315
4		0.1250	.150-.173	2.1/8	5/16	1	—	0239247	—
4		0.1250	.150-.173	2.1/8	5/16	1	—	—	0239322
5		0.1875	.232-.256	2.3/4	7/16	1	—	0239254	—
5		0.1875	.232-.256	2.3/4	7/16	1	—	—	0239339
6		0.2188	.272-.295	3"	1/2	1	—	0239261	—
6		0.2188	.272-.295	3"	1/2	1	—	—	0239346
7		0.2500	.315-.339	3.1/4	5/8	1	—	0239278	—
7		0.2500	.315-.339	3.1/4	5/8	1	—	—	0239353
8		0.3125	.394-.417	3.1/2	3/4	1	—	0239285	—
8		0.3125	.394-.417	3.1/2	3/4	1	—	—	0239360

Set	Style	Pieces per set	Contents of set	Pack Qty	A217 set	A218 set
A217SET	A217	5	N1, N2, N3, N4, N5	1	0423912	—
A218SET	A218	5	N1, N2, N3, N4, N5	1	—	0423929

# SPECIAL PURPOSE DRILL



## Cobalt Combined Drill and Countersink (Center Drill)

**A221** 60° C'sink. Cobalt base material for wear resistance. Bright Finish improves chip flow in soft or non-ferrous materials

### A221SET

5 peice set includes N1, N2, N3, N4 & N5



Nr.	Set	d <sub>1</sub> Ø Inch	Style	d <sub>1</sub> decimal Inch	Pieces per Set	l <sub>2</sub> Inch	Contents of set	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	Pack Qty	A221	A221SET
00		0.025		0.0250		1/32		1.1/8	1/8	1	0241851	<sup>1)</sup> —
0		1/32		0.0313		1/32		1.1/8	1/8	1	0241844	<sup>1)</sup> —
1		3/64		0.0469		3/64		1.1/4	1/8	1	0241868	—
2		5/64		0.0781		5/64		1.7/8	3/16	1	0241875	—
3		7/64		0.1094		7/64		2"	1/4	1	0241882	—
4		1/8		0.1250		1/8		2.1/8	5/16	1	0241899	—
5		3/16		0.1875		3/16		2.3/4	7/16	1	0241905	—
6		7/32		0.2188		7/32		3"	1/2	1	0241912	—
7		1/4		0.2500		1/4		3.1/4	5/8	1	0241929	—
8		5/16		0.3125		5/16		3.1/2	3/4	1	0241936	—
	A221SET		A221		5		N1, N2, N3, N4, N5			1	—	0423936

<sup>1)</sup> single ended only



# SPECIAL PURPOSE DRILL

## Threaded Hex Shank Drills

**TS41** - Stub, Wire Gauge Sizes

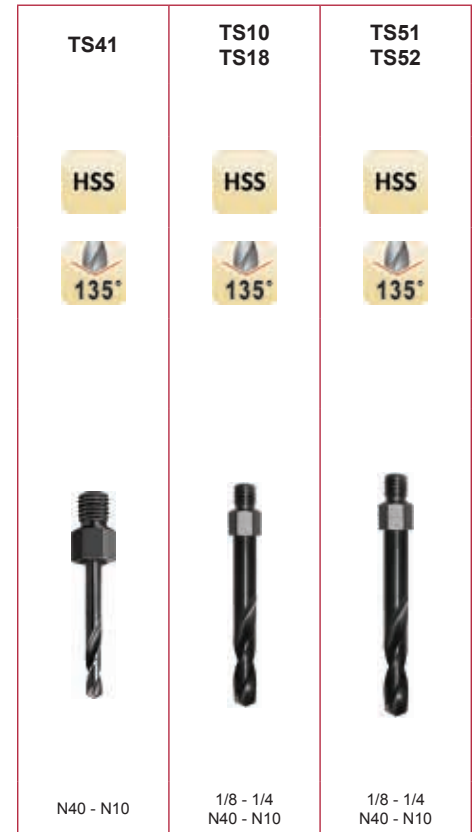
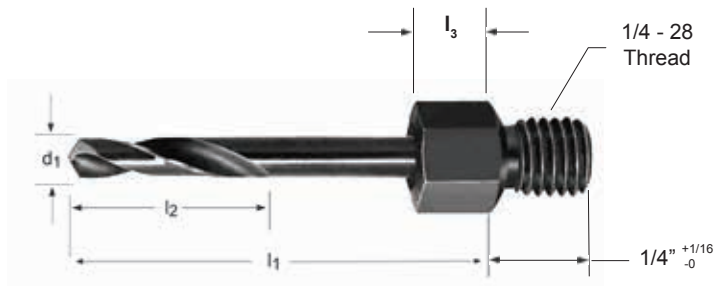
**TS10** - Short, Fractional Sizes

**TS18** - Short, Wire Gauge Sizes

**TS51** - Long, Fractional Sizes

**TS52** - Long, Wire Gauge Sizes

**NAS-965 Type B** Steam Oxide for increased wear resistance & lubricity. Shank design for drilling in confined spaces. Low thrust design self centering Split Point for easier penetration.  
1/4-28 thread



d <sub>1</sub> Ø Nr.	d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	l <sub>3</sub> lgth of hex flat	Pack Qty	TS41	TS10 TS18	TS51 TS52
40		0.0980	5/16	1/2	1/8	1	045840	—	—
40		0.0980	7/8	2.1/8	1/4	1	—	—	017940
40		0.0980	9/16	1"	1/4	1	—	045640	—
	1/8	0.1250	7/8	2.1/8	1/4	1	—	—	017958
	1/8	0.1250	9/16	1"	1/4	1	—	045708	—
30		0.1285	1.1/8	2.1/8	1/4	1	—	—	017930
30		0.1285	5/16	9/16	1/8	1	045830	—	—
30		0.1285	9/16	1.1/4	1/4	1	—	045630	—
	5/32	0.1563	1.1/8	2.1/8	1/4	1	—	—	017960
	5/32	0.1563	9/16	1.1/4	1/4	1	—	045710	—
21		0.1590	9/16	1.1/4	1/4	1	—	045621	—
21		0.1590	1.1/8	2.1/8	1/4	1	—	—	017921
20		0.1610	1.1/8	2.1/8	1/4	1	—	—	017920
20		0.1610	5/16	9/16	1/8	1	045820	—	—
20		0.1610	9/16	1.1/4	1/4	1	—	045620	—
	3/16	0.1875	1.1/8	2.1/8	1/4	1	—	—	017962
	3/16	0.1875	9/16	1.1/4	1/4	1	—	045712	—
11		0.1910	1.1/8	2.1/8	1/4	1	—	—	017911
11		0.1910	5/16	9/16	1/8	1	045811	—	—
11		0.1910	9/16	1.1/4	1/4	1	—	045611	—
10		0.1935	1.1/8	2.1/8	1/4	1	—	—	017910
10		0.1935	5/16	9/16	1/8	1	045810	—	—
10		0.1935	9/16	1.1/4	1/4	1	—	045610	—
	7/32	0.2188	1.1/8	2.1/8	5/16	1	—	—	017964
	7/32	0.2188	9/16	1.1/4	5/16	1	—	045714	—
	1/4	0.2500	1.1/8	2.1/8	5/16	1	—	—	017966
	1/4	0.2500	9/16	1.1/4	5/16	1	—	045716	—

# SPECIAL PURPOSE DRILL



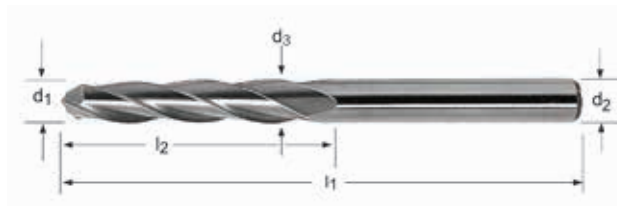
## 3-Flute Tapered Aircraft Router

**ATR41** For cutting, trimming and routing without pre-drilling. 1/4" Taper per foot. Bright Finish improves chip flow in soft or non-ferrous materials

ATR41



N1 - N4



Router Nr.	d <sub>1</sub> Ø Inch	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>3</sub> Ø Inch	# of Flutes	Pack Qty	ATR41
1	0.0810	0.0980	13/16	2"	0.0980	3	12	041701
2	0.1100	0.1280	7/8	2.1/4	0.1280	3	12	041702
3	0.1650	0.1875	1.1/16	2.1/2	0.1875	3	12	041703
4	0.2240	0.2500	1.1/4	2.3/4	0.2500	4	12	041704





# JOBBER DRILL SETS

## General Purpose Jobber Length Sets

**C15R10P** Bright Finish improves chip flow in  
**C29R10P** soft or non-ferrous materials



**C15R10** Steam Oxide reduces wear and chip  
**C29R10** welding in harder ferrous materials.



C15R10P C29R10P	C15R10 C29R10
Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	R10P Sets	R10 Sets
C15R10	R10	15	1/16 - 1/2 x 32nds	1	—	099978
C29R10	R10	29	1/16 - 1/2 x 64ths	1	—	099977
C15R10P	R10P	15	1/16-1/2 x 32nds	1	090163	—
C29R10P	R10P	29	1/16 - 1/2 x 64ths	1	090162	—

## General Purpose Jobber Length Sets

**A097** Self centering Split Point, low thrust design. TiN Coated Tip increases surface hardness and improves tool life.



**C20R18P** Bright Finish improves chip flow in  
**C60R18P** soft or non-ferrous materials



**C20R18** Steam Oxide for increased  
**C60R18** wear resistance & lubricity.



A097	C20R18 C60R18	C20R18P C60R18P
Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	A097	R18 sets	R18P sets
12	A012	60	Nr.1 - Nr.60	1	0574324	—	—
14	A012	26	A - Z	1	0574331	—	—
18	A012	29	1/16 - 1/2 x 1/64	1	0574317	—	—
20	A012	15	1/16 - 1/2 x 1/32	1	0574348	—	—
30	A012	115	1/16 - 1/2 x 1/64, Nr.1 - Nr.60, A-Z	1	0574362	—	—
60	A012	13	1/16 - 1/4 x 1/64	1	0574355	—	—
C20R18	R18	20	N61 - N80	1	—	099981	—
C60R18	R18	60	N1 - N60	1	—	099976	—
C20R18P	R18P	20	N61 - N80	1	—	—	090161
C60R18P	R18P	60	N1 - N60	1	—	—	090101



# JOBBER DRILL SETS

## General Purpose Jobber Length and Combination Sets

### C26R15P

Bright Finish improves chip flow in soft or non-ferrous materials



### C26R15

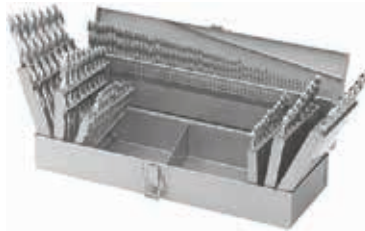
Steam Oxide for increased wear resistance & lubricity.



### C114COMBP

### C115COMBP

Bright Finish improves chip flow in soft or non-ferrous materials



C26R15P	C26R15	C115COMBP	C114COMBP
Set	Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C26R15P	C26R15	C115COMBP	C114COMBP
C114COMBP	R10P, R18P, R10PM	114	1/16-1/2 x 64ths, N1-N60, 1-13mm x 5 mm	1	—	—	—	090114
C115COMBP	R10P, R18P, R15P	115	1/16-1/2 x 64ths, N1-6N0, A-Z	1	—	—	090123	—
C26R15	R15	26	A - Z	1	—	099983	—	—
C26R15P	R15P	26	A - Z	1	090126	—	—	—

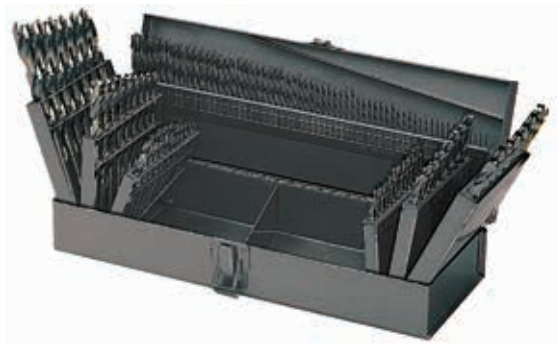
# JOBBER DRILL SETS



## General Purpose Jobber Length Combination Sets

**C114COMB** Steam Oxide for increased wear resistance & lubricity.

**C115COMB**



C114COMB	C115COMB
Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C114COMB	C115COMB
C114COMB	R10, R18, 2AB	114	1/16-1/2 x 64ths, N1-N60, 1-13mm x .5 mm	1	099990	—
C115COMB	R10, R18, R15	115	1/16-1/2 x 64ths, N1-N60, A-Z	1	—	099982

## General Purpose Jobber Length Metric Sets

**A191** Steam Oxide for increased wear resistance & lubricity.  
**A190**



**C252A** Bright Finish improves chip flow in soft or non-ferrous materials



**C252AB** Steam Oxide for increased wear resistance & lubricity.  
**C502AB**



A191	A190	C252A	C252AB C502AB
Set	Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	A191	A190	C252A	C252AB C502AB
12	A100	60	No.1 - No.60	1	—	0179437	—	—
18	A100	29	1/16 inch - 1/2 inch x 1/64 inch	1	—	0179451	—	—
20	A100	15	1/16 inch - 1/2 inch x 1/32 inch	1	—	0179468	—	—
201	A100	19	1.0 mm - 10.0 mm x 0.5 mm	1	—	0030547	—	—
202	A100	51	1.0 mm - 6.0 mm x 0.1 mm	1	—	0030554	—	—
203	A100	41	6.0 mm - 10.0 mm x 0.1 mm	1	—	0030561	—	—
204	A100	25	1.0 mm - 13.0 mm x 0.5 mm	1	—	0030578	—	—
206	A100	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm	1	—	0030585	—	—
209	A100	91	1.0 mm - 10.0 mm x 0.1 mm	1	—	0179482	—	—
3	A100	21	1/16 inch - 3/8 inch x 1/64 inch	1	—	0179413	—	—
31M	A100	20	0.3 mm - 1.0 mm x 0.05 mm + 0.38 mm, 0.52 mm, 0.58 mm, 0.78 mm, 0.82 mm	1	0149133	—	—	—
413	A100	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm	1	0030608	—	—	—
419	A100	19	1.0 mm - 10.0 mm x 0.5 mm	1	0030615	—	—	—
61-80	A100	20	No.61 - No. 80	1	0179499	—	—	—
C252A	2A	25	1.0mm - 13mm x .5mm	1	—	—	099987	—
C252AB	2AB	25	1.0mm - 13mm x .5mm	1	—	—	—	099988
C502AB	2AB	50	1.0mm - 5.9mm x .1mm	1	—	—	—	099985

## General Purpose Jobber Length Metric Sets

**A094** Low thrust design self centering Split Point for easier penetration. TiN Coated Tip increases wear resistance and improves tool life.



A094

DIN  
338

4XD

HSS

118°



Set

Set	Sizes	Pieces per Set	Sizes	Pack Qty	A094
413	A002	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm	1	46610302
419	A002	19	1.0 mm - 10.0 mm x 0.5 mm	1	46610303

## General Purpose Jobber Length Metric Sets

**A095** Low thrust design self centering Split Point for easier penetration. TiN Coated Tip increases wear resistance and improves tool life.



**A095**

**DIN 338**

**4XD**

**HSS**

**118°**



Set

Set	Style	Pieces per Set	C	Pack Qty	A095
18	A002	29	1/16 inch - 1/2 inch x 1/64 inch	1	0385395
20	A002	15	1/16 inch - 1/2 inch x 1/32 inch	1	46610305
200	A002	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm	1	46610306
201	A002	19	1.0 mm - 10.0 mm x 0.5 mm	1	0385418
202	A002	51	1.0 mm - 6.0 mm x 0.1 mm	1	0385425
203	A002	41	6.0 mm - 10.0 mm x 0.1 mm	1	0385432
204	A002	25	1.0 mm - 13.0 mm x 0.5 mm	1	0385449
206	A002	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm	1	0392331
209	A002	91	1.0 mm - 10.0 mm x 0.1 mm	1	0385562

# JOBBER DRILL SETS



## General Purpose Jobber Length Left Hand Sets

**C15L10** Bright Finish improves chip flow in soft or non-ferrous materials  
**C29L10**



C15L10	C29L10
Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C15L10	C29L10
C15L10	L10	15	1/16-1/2 x 32nds, Left Hand	1	099955	—
C29L10	L10	29	1/16 - 1/2 x 64ths, Left Hand	1	—	099935



**High Helix Jobber Length Set**

**A287** Low thrust design self centering Split Point for easier penetration. Steam Oxide surface treatment for increased wear resistance & lubricity. Fast spiral helix for improved chip flow when drilling stainless steel.



**A287**

ANSI

4XD

HSS

135°

Set

Set	Style	Pieces per Set	C	Pack Qty	A287
18	A108	29	1/16 - 1/2 x 1/64	1	0308523

# JOBBER DRILL SETS



## Heavy Duty Jobber Length Set

**C29HX10** Low thrust design self centering Split Point for easier penetration. Stronger and more Rigid. Unique surface treatment for improved wear resistance.



C29HX10

ANSI

4XD

HSS

135°



Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29HX10
C29HX10	HX10	29	1/16 -1/2 x 64ths	1	091010



# JOBBER DRILL SETS

## Heavy Duty Cobalt Jobber Length Sets (NAS 907 Type J)

**C13R10CO**

**C15R10CO**

**C21R10CO**

**C29R10CO**

**C60R18CO**

**C26R15CO**

Low thrust design self centering 135° Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance and lubricity. Suitable for ferrous materials.



C13R10CO C15R10CO C21R10CO C29R10CO	C26R15CO	C60R18CO
ANSI	ANSI	ANSI
4XD	4XD	4XD
HSS-E	HSS-E	HSS-E
135°	135°	135°
Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29R10CO	C26R15CO	C60R18CO
C13R10CO	R10CO	13	1/16-1/4x 64ths	1	099944	—	—
C15R10CO	R10CO	15	1/16-1/2 x 32nds	1	090291	—	—
C21R10CO	R10CO	21	1/16-3/8 x 64ths	1	099701	—	—
C26R15CO	R15CO	26	A - Z	1	—	090292	—
C29R10CO	R10CO	29	1/16 - 1/2 x 64ths	1	090290	—	—
C60R18CO	R18CO	60	N1 - N60	1	—	—	090600

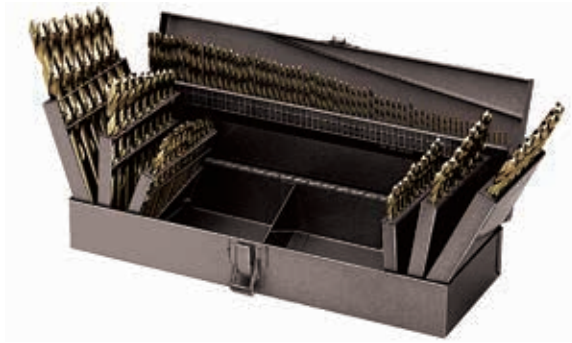
# JOBBER DRILL SETS



## Heavy Duty Cobalt Jobber Length Combination Sets (NAS 907 Type J)

**C115COMBC** Low thrust design self centering 135° Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance and lubricity. Suitable for ferrous materials.

**C114COMBC**



C115COMBC	C114COMBC
Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C115COMBC	C114COMBC
C114COMBC	R10CO, R18CO, 2ACO	114	1/16-1/2 x 64ths, N1-N60, 1-13mm x .5 mm	1	—	099705
C115COMBC	R10CO, R18CO, R15CO	115	1/16-1/2 x 64ths, N1-N60, A-Z	1	099706	—



# SCREW MACHINE DRILL SETS

## General Purpose Screw Machine Drill Sets

**C29R40**

**C60R41**

**C26R42**

Bright Finish improves chip flow in soft or non-ferrous materials



C29R40	C60R41	C26R42
Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29R40	C60R41	C26R42
C26R42	R42	26	A - Z	1	—	—	090173
C29R40	R40	29	1/16-1/2 x 64ths	1	090170	—	—
C60R41	R41	60	N1 - N60	1	—	090174	—

# SCREW MACHINE DRILL SETS



## General Purpose Screw Machine Drill Set

**A088**

Low thrust design self centering Split Point for easier penetration. TiN Coated Tip increases wear resistance and improves tool life.



**A088**

DIN  
ANSI

2.5XD

HSS

135°



Set

Set	Style	Pieces per Set	Sizes	Pack Qty	A088
200S	A022	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm	1	0616185



# SCREW MACHINE DRILL SETS

## Heavy Duty Screw Machine Drill Set

**C29R40C**

**C60R41C**

Low thrust design self centering Split Point for easier penetration. Steam Oxide for increased wear resistance & lubricity.



C29R40C	C60R41C
Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29R40C	C60R41C
C29R40C	R40C	29	1/16 - 1/2 x 64ths	1	099903	—
C60R41C	R41C	60	N1 - N60	1	—	099930

# SCREW MACHINE DRILL SETS



## Cobalt Heavy Duty Screw Machine Drill Sets

- C29M40CO** Low thrust design self centering Split Point for easier penetration. Cobalt base material with Bronze Oxide for wear resistance and lubricity. Suitable for ferrous materials.
- C60M41CO**
- C26M42CO**



C29M40CO	C60M41CO	C26M42CO
Set	Set	Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29M40CO	C60M41CO	C26M42CO
C26M42CO	M42CO	26	A - Z	1	—	—	099961
C29M40CO	M40CO	29	1/16 - 1/2 x 64ths	1	099962	—	—
C60M41CO	M41CO	60	N1 - N60	1	—	099960	—





# TAPER LENGTH DRILL SETS

## General Purpose Taper Length Drill Sets

**C29R51** Bright Finish improves chip flow in soft or non-ferrous materials. Longer Flute and Overall length for depth and reach.



**C29R51**

ANSI

6XD

HSS

118°

Set

Set	Style	Pieces per Set	Sizes	Pack Qty	C29R51
C29R51	R51	29	1/16 - 1/2 x 64ths	1	090154

# REDUCED SHANK DRILL SETS



## Reduced Shank Drill Sets

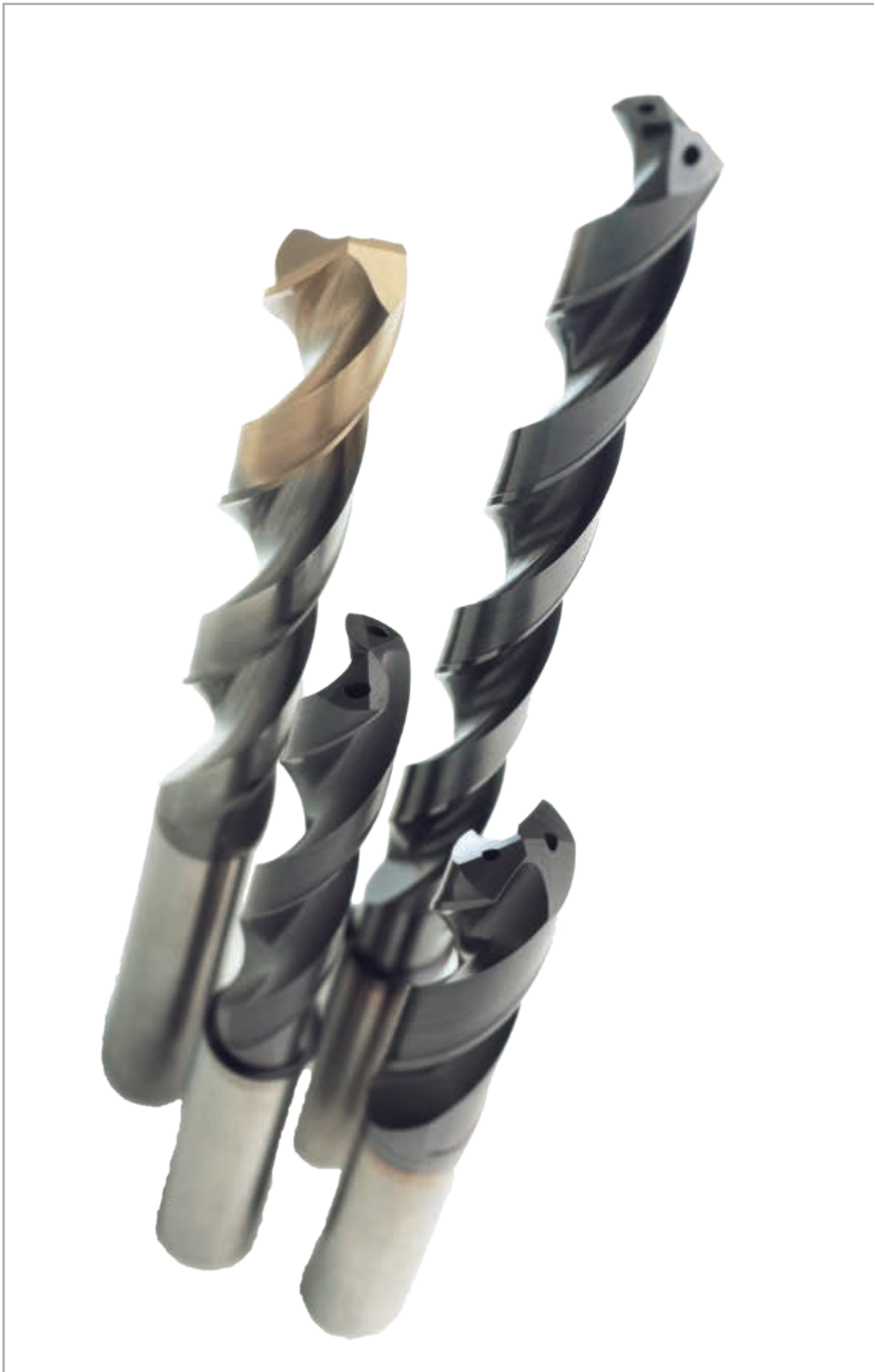
**C8R56** Silver & Deming Drills. Steam Oxide for increased wear resistance & lubricity.  
**C33R56**

**C8R57** Silver & Deming Drills with **Tri-Flat** Shank. Steam Oxide for increased wear resistance & lubricity.

**C8R56CO** Heavy Duty Cobalt Silver & Deming Drills. Self centering 118° Split Point reduces thrust. Cobalt base material with Bronze/ Steam Oxide for wear resistance and lubricity. Suitable for ferrous materials.



Set	Style	Pieces per Set	Sizes	Pack Qty	C8R56 C33R56	C8R57	C8R56CO
C33R56	R56	33	1/2" Reduced Shank, 1/2 - 1"x 64ths, S&D	1	090231	—	—
C8R56	R56	8	1/2" Reduced Shank, 9/16 - 1" x 16ths, S&D	1	090556	—	—
C8R56CO	R56CO	8	1/2" Reduced Shank, 9/16 - 1" x 16ths, S&D	1	—	—	090328
C8R57	R57	8	1/2" Reduced Shank, 9/16 - 1" x 16ths, S&D	1	—	090558	—



Application Material Groups (AMG)			Hardness HRC	ISO
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	S 1
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28	S 2
	4.3 Titanium, alloyed	6Al4V-4Mo, 7A14V-4Mo, 4911-4967	>28<38	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	N 3
	6.2 $\beta$ -Brass, Bronze	314-340, 350-370	<200 HB	N 4
	6.3 $\alpha$ -Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultradid, Polystrol	---	O
	8.2 Thermosetting plastics	Bakelit, Pertinax	---	O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	H
10. Graphite	10.1 Standard graphite		---	O

Thread Form:	UNC	UNC	UNF	UNF	M	M	MF	MF	UNC	UNF	UNC	UNF	UNC	UNF	M
Standard:	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI
Class of Fit:	2BX	2BX	2BX	2BX	6HX	6HX	6HX	6HX	2B	2B	2B 3B	2B 3B	2B	2B	6H
Hole Type:															
Depth of Cut:	2XD	2.5XD	2XD	2.5XD	2XD	2.5XD	2XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD
Tool Material:	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
Chamfer:	C 2-3	E 1.5-2	C 2-3	E 1.5-2	C 2-3	E 1.5-2	C 2-3	E 1.5-2	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5
Flute Geometry:															
Direction of Cut:															
Finish/Coating:	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	TAIN Top	Super B	Super B	TAIN Top	TAIN Top	TAIN Top
Coolant Through:															
Style:	E814	E815	E914	E915	E630	E631	E770	E771	E809	E909	E813	E913	E811	E911	E625
Range:	1/4 - 1"	1/4 - 1"	No.10 - 7/8	1/4 - 1"	M5 - M24	M6 - M24	M8 - M14	M10 - M14	No.4 - 1"	No.10 - 1"	No.4 - 1"	No.10 - 1"	No.4 - 1"	no.10 - 1"	M4 - M24
Page #	236	236	236	236	237	237	237	237	238	238	239	239	241	241	242
AMG															
1.1									■ 108	■ 108					■ 108
1.2									■ 95	■ 95	● 72	● 72			■ 95
1.3									■ 75	■ 75	● 59	● 59			■ 75
1.4									● 69	● 69	● 52	● 52	■ 98	■ 98	● 69
1.5									● 43	● 42	● 33	● 33	■ 66	■ 66	● 43
1.6													● 36	● 36	
1.7															
1.8															
2.1												■ 46	■ 46		
2.2												■ 33	■ 33		
2.3															
2.4												■ 20	■ 20		
3.1	■ 98	■ 98	■ 98	■ 98	■ 98	■ 98	■ 98	■ 98							
3.2	■ 82	■ 82	■ 82	■ 82	■ 82	■ 82	■ 82	■ 82							
3.3	■ 115	■ 115	■ 115	■ 115	■ 115	■ 115	■ 115	■ 115							
3.4	● 82	● 82	● 82	● 82	● 82	● 82	● 82	● 82							
4.1															
4.2													● 33	● 33	
4.3															
5.1															
5.2													● 33	● 33	
5.3															
6.1									■ 39	■ 39					■ 39
6.2	● 98	● 98	● 98	● 98	● 98	● 98	● 98	● 98	● 98	● 98					● 98
6.3									■ 66	■ 66					■ 66
6.4	● 16	● 16	● 16	● 16	● 16	● 16	● 16	● 16							
7.1															
7.2															
7.3															
7.4	● 66	● 66	● 66	● 66	● 66	● 66	● 66	● 66							
8.1															
8.2	■ 49	■ 49	■ 49	■ 49	■ 49	■ 49	■ 49	■ 49							
8.3															
9.1															
10.1															

	MF	M	MF	M	MF	UNC	UNF	UNC	UNF	UNC	UNF	M	MF	M	MF	M	MF	
	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	
	6H	6H	6H	6H	6H	2B	2B	2B 3B	2B 3B	2B	2B	6H	6H	6H	6H	6H	6H	
	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2XD	2XD	2.5XD	2.5XD	2.5XD	2.5XD	2XD	2XD	2.5XD	2.5XD	2.5XD	2.5XD	
	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM	
	B 3,5-5	B 3,5-5	B 3,5-5	B 3,5-5	B 3,5-5	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	
						$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	
	TAIN Top	Super B	Super B	TAIN Top	TAIN Top	TAIN Top	TAIN Top	Super B	Super B	TAIN Top	TAIN Top	TAIN Top	TAIN Top	Super B	Super B	TAIN Top	TAIN Top	
	E765	E629	E769	E627	E767	E808	E908	E812	E912	E810	E910	E624	E764	E628	E768	E626	E766	
	M8 - M18	M4 - M24	M8 - M18	M3 - M24	M8 - M14	No.4 - 1"	No.10 - 1"	No.4 - 1"	No.10 - 1"	No.4 - 1"	No.10 - 1"	M4 - M24	M8 - M18	M4 - M24	M8 - M18	M3 - M24	M8 - M14	
	242	243	243	244	244	245	245	246	246	248	248	249	248	250	250	251	251	
AMG																		ISO
1.1	■ 108					■ 108	■ 108					■ 108	■ 108					P 1
1.2	■ 95	● 72	● 72			■ 95	■ 95	● 72	● 72			■ 95	■ 95	● 72	● 72			P 1
1.3	■ 75	● 59	● 59			■ 75	■ 75	● 59	● 59			■ 75	■ 75	● 59	● 59			P 2
1.4	● 69	● 52	● 52	■ 98	■ 98	● 69	● 69	● 52	● 52	■ 98	■ 98	● 69	● 69	● 52	● 52	■ 98	■ 98	P 3
1.5	● 43	● 33	● 33	■ 66	■ 66	● 43	● 43	● 33	● 33	■ 66	■ 66	● 43	● 43	● 33	● 33	■ 66	■ 66	P 4
1.6				● 36	● 36					● 36	● 36					● 36	● 36	H 1
1.7																		H 3
1.8																		H 4
2.1		■ 46	■ 46					■ 46	■ 46					■ 46	■ 46			M 1
2.2		■ 33	■ 33					■ 33	■ 33					■ 33	■ 33			M 3
2.3		■ 20	■ 20					■ 20	■ 20					■ 20	■ 20			M 2
2.4																		S 2
3.1																		K 1
3.2																		K 2
3.3																		K 3
3.4																		K 4
4.1																		S 1
4.2				● 33	● 33					● 33	● 33					● 33	● 33	S 2
4.3																		S 3
5.1																		S 1
5.2				● 33	● 33					● 33	● 33					● 33	● 33	S 2
5.3																		S 3
6.1	■ 39					■ 39	■ 39					■ 39	■ 39					N 3
6.2	● 98					● 98	● 98					● 98	● 98					N 3
6.3	■ 66					■ 66	■ 66					■ 66	■ 66					N 3
6.4																		N 4
7.1																		N 1
7.2																		N 1
7.3																		N 1
7.4																		N 2
8.1																		O
8.2																		O
8.3																		O
9.1																		H
10.1																		O

	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	M	MF	M
	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	ANSI	ANSI	ANSI	ANSI	DIN 2184-1	DIN 2184-1	DIN 2184-1	DIN 2184-1	ISO 529	ISO 529	DIN ANSI	DIN ANSI	DIN ANSI
	2B	2B	2B	2B	3B	3B	3B	3B	2B	2B	2B	2B	2B	2B	6H	6H	6H
	3XD	3XD	3XD	3XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	3XD	3XD	3XD
	HSS PM	HSS PM	HSS PM	HSS PM	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS PM	HSS PM	HSS PM
	P	P	P	P	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	B 3.5-5	C 2-3	B 3.5-5	B 3.5-5	P	P	P





# Visual Index - Taps

	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	M	MF	
	ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	ANSI	ANSI	ANSI	ANSI	DIN 2184-1	DIN 2184-1	DIN 2184-1	DIN 2184-1	ISO 529	ISO 529	DIN ANSI	DIN ANSI
	2B	2B	2B	2B	2B	3B	3B	3B	3B	2B	2B	2B	2B	2B	2B	6H	6H
	HSS	HSS PM	HSS PM	HSS PM	HSS PM	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS PM	HSS PM	
		Semi-B	Semi-B	Semi-B	Semi-B	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	Semi-B	Semi-B
	ET	TOX	TOX	TOX	TOX			ET	ET			ET	ET	ET	ET	TOX	TOX
	1985 (UNF)	1676AP (UNC)	1676AP (UNF)	1678 (UNC)	1678 (UNF)	E027	E037	E028	E038	EX20	EX30	EX21	EX31	E023	E033	1677AP (M)	1677AP (MF)
	No.4 - 7/8	No.4 - 1"	No.10 - 7/8	1/4 - 1"	1/4 - 7/8	No.6 - 1"	No.10 - 1"	No.4 - 1"	No.10 - 1"	No.4 - 1"	No.8 - 1"	No.4 - 1"	No.8 - 1"	No.2 - 1"	No.8 - 1"	M4 - M24	M8 - M24
	266	267	267	267	267	268	268	268	268	269	269	269	269	270	270	271	271
1.1	75	100	100	110	110	82	82	82	82	82	82	82	82	82	82	100	100
1.2	69	80	80	90	90	72	72	72	72	72	72	72	72	72	72	80	80
1.3	49	50	50	55	55	59	59	59	59	59	59	59	59	59	59	50	50
1.4	49	50	50	55	55	52	52	52	52	52	52	52	52	52	52	50	50
1.5	30	40	40	45	45	33	33	33	33	33	33	33	33	33	33	40	40
1.6	16						16		16						16		
1.7																	
1.8																	
2.1	36	45	45	50	50			23	23			23	23	23	23	45	45
2.2	20	30	30	35	35			20	20			20	20	20	20	30	30
2.3		35	35	40	40			13	13			13	13	13	13	35	35
2.4																	
3.1																	
3.2																	
3.3																	
3.4																	
4.1	20	30	30	35	35	33	33			33	33					30	30
4.2	16	20	20	25	25	16	16			16	16					20	20
4.3	7																
5.1	30	30	30	35	35	39	39			39	39					30	30
5.2	16	15	15	20	20	16	16			16	16					15	15
5.3	10																
6.1		40	40	45	45	39										40	40
6.2		100	100	120	120	98										100	100
6.3		90	90	100	100	66										90	90
6.4																	
7.1		80	80	90	90	52	52			52	52					80	80
7.2		95	95	115	115	115	115			115	115					95	95
7.3		80	80	90	90	66	66			66	66					80	80
7.4		30	30	35	35	49	49			49	49					30	30
8.1						98	98										
8.2																	
8.3																	
9.1																	
10.1																	

# Visual Index - Taps



	M	M	M	MF	M	M	MF	MF	M	M	MF	UNC	UNF	M	UNC	UNF	M	
	DIN ANSI	ANSI	ANSI	ANSI	DIN 3714/10 3719/12	DIN 3714/10 3719/12	DIN 374	DIN 374	ISO 529	ISO 529	ISO 529	DIN ANSI	DIN ANSI	DIN ANSI	ANSI	ANSI	ANSI	
	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	6H	2B	2B	6H	2B 3B	2B 3B	6H	
	HSS PM	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	
	Semi-B	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	Semi-B	Semi-B	Semi-B	E 1.5-2	E 1.5-2	E 1.5-2	
	$\lambda 50^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 45^\circ$	$\lambda 17^\circ$	$\lambda 17^\circ$	$\lambda 17^\circ$				
	1679 (M)(MF)	E007	E008	E018	EX006H	EX016H	EX10	EX11	E002	E003	E013	1630AP (UNC)	1630AP (UNF)	1660AP (M)	1641 (UNC)	1641 (UNF)	1671 (M)	
	M6 - M24	M4 - M16	M4 - M20	M8 - M14	M2 - M64	M2 - M64	M4 - M30	M4 - M30	M2 - M24	M2 - M24	M4 - M22	No.4 - 1"	No.10 - 7/8	M3 - M12	No.4 - 1/2	No.10 - 3/8	M3 - M10	
	271	272	272	272	273	273	274	274	275	275	275	276	276	277	278	278	279	
1.1	110	82	82	82	82	82	82	82	82	82	82				150	150	150	
1.2	90	72	72	72	72	72	72	72	72	72	72				125	125	125	
1.3	55	59	59	59	59	59	59	59	59	59	59				90	90	90	
1.4	55	52	52	52	52	52	52	52	52	52	52				90	90	90	
1.5	45	33	33	33	33	33	33	33	33	33	33	45	45	45				
1.6												25	25	25				
1.7																		
1.8																		
2.1	50		23	23		23		23		23	23					70	70	70
2.2	35		20	20		20		20		20	20					60	60	60
2.3	40		13	13		13		13		13	13					50	50	50
2.4												30	30	30				
3.1												90	90	90				
3.2												70	70	70				
3.3												65	65	65				
3.4												35	35	35				
4.1	35	33			33		33		33						60	60	60	
4.2	25	16			16		16		16									
4.3												10	10	10				
5.1	35	39			39		39		39						45	45	45	
5.2	20	16			16		16		16									
5.3												15	15	15				
6.1	45														55	55	55	
6.2	120														180	180	180	
6.3	100														130	130	130	
6.4												25	25	25				
7.1	89	52			52		52		52						180	180	180	
7.2	115	115			115		115		115						200	200	200	
7.3	90	66			66		66		66						230	230	230	
7.4	35	49			49		49		49									
8.1																		
8.2																		
8.3																		
9.1																		
10.1																		







# Visual Index - Taps



	UNF	UNC	UNF	UNC	UNF	M	M	UNC	UNF	UNS	UNC	UNF	M	UNC	UNF	UNC	UNF
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI
	2B 3B	2B 3B	3B	3B	3B	6H	6H	2B 3B	2B 3B	3B	2B 3B	2B 3B	6H	3B	2B 3B	2B 3B	2B 3B
	2.5XD	2.5XD	2.5XD	2.5XD	1.25XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD
	HSS	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
				P	P									P	P		
	1585A (UNF)	TN1585 (UNC)	TN1585 (UNF)	1634 (UNC)	1634 (UNF)	1785M	TN1785	1534NR (UNC)	1534NR (UNF)	1534NR (UNS)	1585NR (UNC)	1585NR (UNF)	1785NR	1534NE (UNC)	1534NE (UNF)	1593 (UNC)	1593 (UNF)
	1/4 - 3/4	1/4 - 1/2	1/4 - 1/2	No.4 - No.8	No.10	M2 - M18	M4 - M12	No.1 - No.12	No.0 - No.12	No.4	1/4 - 3/4	1/4 - 3/4	M1.6 - M20	No.4 - 1/2	No.10 - 1/2	No.6 - No.10	No.10
	307	307	307	309	309	310	310	311	311	311	313	313	314	315	315	316	316
1.1	66	79	79	66	66	66	79	66	66	66	66	66	66	66	66	66	66
1.2	66	75	75	66	66	66	75	66	66	66	59	59	59	66	66	66	66
1.3	39	49	49	39	39	39	49	39	39	39	46	46	46	39	39	39	39
1.4	39	49	49	39	39	39	49	39	39	39	33	33	33	39	39	39	39
1.5	26	30	30	26	26	26	30	26	26	26	16	16	16	26	26	26	26
1.6	16	20	20	16	16	16	20	16	16	16	10	10	10	16	16	16	16
1.7																	
1.8																	
2.1	30	39	39	30	30	30	39	30	30	30	20	20	20	30	30	30	30
2.2	20	26	26	20	20	20	26	20	20	20	13	13	13	20	20	20	20
2.3	20	26	26	20	20	20	26	20	20	20	10	10	10	20	20	20	20
2.4																	
3.1	46	49	49	46	46	46	49	46	46	46			46	46	46	46	46
3.2	26	30	30	26	26	26	30	26	26	26			26	26	26	26	26
3.3	26	30	30	26	26	26	30	26	26	26			26	26	26	26	26
3.4	16	20	20	16	16	16	20	16	16	16			16	16	16	16	16
4.1	20			20	20	20		20	20	20				20	20	20	20
4.2	16			16	16	16		16	16	16				16	16	16	16
4.3	7			7	7	7		7	7	7	10	10	10	7	7	7	7
5.1	26	30	30	26	26	26	30	26	26	26	33	33	33	26	26	26	26
5.2	10	13	13	10	10	10	13	10	10	10	13	13	13	10	10	10	10
5.3																	
6.1	30	39	39	30	30	30	39	30	30	30	33	33	33	30	30	30	30
6.2	89	115	115	89	89	89	115	89	89	89				89	89	89	89
6.3	69	89	89	69	69	69	89	69	69	69	49	49	49	69	69	69	69
6.4	10	13	13	10	10	10	13	10	10	10				10	10	10	10
7.1	49	66	66	49	49	49	66	49	49	49	33	33	33	49	49	49	49
7.2	98	125	125	98	98	98	125	98	98	98	82	82	82	98	98	98	98
7.3	66	79	79	66	66	66	79	66	66	66	43	43	43	66	66	66	66
7.4	20	26	26	20	20	20	26	20	20	20	33	33	33	20	20	20	20
8.1	98	121	121	98	98	98	121	98	98	98	66	66	66	98	98	98	98
8.2	26	30	30	26	26	26	30	26	26	26				26	26	26	26
8.3																	
9.1																	
10.1																	

# Visual Index - Taps

	UNC	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	M	UNC	UNF	M
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI
	2B	3B	3B	3B	3B	3B	3B	2B 3B	2B 3B	3B	3B	3B	3B	6H	2B 3B	2B 3B	6H
	2XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	1.25XD	2.5XD	2.5XD
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
	1585OV (UNC)	1582 (UNC)	1582 (UNF)	1586 (UNC)	1586 (UNF)	1587 (UNC)	1587 (UNF)	1588 (UNC)	1588 (UNF)	1590 (UNC)	1590 (UNF)	1591 (UNC)	1591 (UNF)	1788 (M)	1580 (UNC)	1580 (UNF)	1580 (M)
	1/4 - 5/8	No.4 - No.10	No.10 - No.10	1/4 - 1/2	1/4 - 1/2	No.3 - No.12	No.4 - No.10	1/4 - 1/2	1/4 - 1/2	No.6 - No.10	No.6 - No.10	1/4 - 1/2	1/4 - 1/2	M3 - M12	No.2 - 3/8	No.10 - 3/8	M3 - M12
		316	317	317	317	318	318	318	318	319	319	319	319	320	321	321	322
1.1	66	66	66	66	66					69	69	69	69		98	98	98
1.2	66	49	49	49	49					59	59	59	59		79	79	79
1.3	39	36	36	36	36					39	39	39	39		49	49	49
1.4	39	36	36	36	36					39	39	39	39		49	49	49
1.5	26									30	30	30	30		30	30	30
1.6	16																
1.7																	
1.8																	
2.1	30	26	26	26	26					30	30	30	30		39	39	39
2.2	20	20	20	20	20					26	26	26	26		30	30	30
2.3	20	20	20	20	20					20	20	20	20				
2.4																	
3.1	46																
3.2	26																
3.3	26																
3.4	16																
4.1	20	20	20	20	20					20	20	20	20		30	30	30
4.2	16	16	16	16	16					16	16	16	16		26	26	26
4.3	7	7	7	7	7					7	7	7	7				
5.1	26	20	20	20	20										30	30	30
5.2	10	16	16	16	16												
5.3										10	10	10	10				
6.1	30					30	30	30	30					30	39	39	39
6.2	89					79	79	79	79					79	121	121	121
6.3	69					79	79	79	79					79	98	98	98
6.4	10																
7.1	49					49	49	49	49					49	79	79	79
7.2	98					66	66	66	66					66	161	161	161
7.3	66					66	66	66	66					66	98	98	98
7.4	20																
8.1	98																
8.2	26																
8.3																	
9.1																	
10.1																	

# Visual Index - Taps



	UNC	UNF	M	UNC	UNF	NPT	NPT	NPT	NPT	NPT	NPT	NPT	NPT	NPT	NPT	NPTF	
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI B94.9	ANSI B94.9	ANSI B94.9	ANSI B94.9	ANSI	ANSI	ANSI	ANSI	ANSI B94.9	ANSI
	2B 3B	2B 3B	6H	2B	2B	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal
	3XD	3XD	3XD	2.5XD	2.5XD	2XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	2XD	2XD	1.5XD	2XD
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
				E 1.5-2	E 1.5-2			C 2-3	C 2-3	C 2-3						C 2-3	
	3300 (UNC)	3300 (UNF)	3300 (M)	3306E (UNC)	3306E (UNF)	1541 (NPT)	TN1541	E710	E721	6541	1544 (NPT)	1545 (NPT)	1545A (NPT)	1548 (NPT)	1568 (NPT)	E711	1543 (NPTF)
	No.1 - 1/2	No.0 - 3/8	M3 - M10	No.4 - 5/16	No.10 - 5/16	1/16 - 2"	1/8 - 3/4	1/16 - 2"	1/8 - 1"	1/8 - 2"	1/16 - 1.1/4	1/8 - 1"	1/16 - 3/4	1/16 - 1"	1/8 - 1.1/2"	1/8 - 1.1/2	1/16 - 1"
	323	323	324	325	325	326	326	327	327	328	329	330	330	331	332	333	334
1.1	98	98	98	98	98	13	16	13	13		13	13	13	13	13	13	13
1.2	79	79	79	79	79	13	16	13	13		13	13	13	13	13	13	13
1.3	49	49	49	49	49	20	23	20	20		20	20	20	20	20	20	20
1.4	49	49	49	49	49	16	20	16	16		16	16	16	16	16	16	16
1.5	30	30	30	30	30	10	13	10	10		10	10	10	10	10	10	10
1.6																	
1.7																	
1.8																	
2.1	39	39	39	39	39												
2.2	30	30	30	30	30												
2.3																	
2.4																	
3.1						20	23	20	20		20	20	20	20	20	20	20
3.2						13	16	13	13		13	13	13	13	13	13	13
3.3						20	23	20	20		20	20	20	20	20	20	20
3.4						13	16	13	13		13	13	13	13	13	13	13
4.1	30	30	30	30	30												
4.2	26	26	26	26	26												
4.3																	
5.1	30	30	30	30	30												
5.2																	
5.3																	
6.1	39	39	39	39	39												
6.2	121	121	121	121	121	36	39	36	36		36	36	36	36	36	36	36
6.3	98	98	98	98	98												
6.4																	
7.1	79	79	79	79	79												
7.2	161	161	161	161	161												
7.3	98	98	98	98	98	36	39	36	36		36	36	36	36	36	36	36
7.4						23	26	23	23		23	23	23	23	23	23	23
8.1						13	16	13	13		13	13	13	13	13	13	13
8.2																	
8.3																	
9.1																	
10.1																	



# Visual Index - Taps

	NPTF	NPTF	NPTF	NPTF	NPSM	NPSF	Rc	G	UNC	UNF	UNC	UNF	EGM	EGM	UNC	UNC	UNC
	ANSI	ANSI	ANSI	ANSI B94.9	ANSI	ANSI	ISO 2284	ISO 2284	ANSI	ANSI	ANSI	ANSI	DORMER ISO	DORMER ISO	ANSI	ANSI	ANSI
	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	3B	3B	2B 3B	2B 3B	6H	6H	3B	3B	2B
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
				C 2-3			C 2-3						C 2-3	C 2-3	T	P	
	TN1543	1549 (NPTF)	1567 (NPTF)	E712	1542 (NPS)	1592 (NPSF)	E550	E547	1572 (UNC)	1572 (UNF)	1578 (UNC)	1578 (UNF)	E620	E621	U1511	1519 (UNC)	1994 (UNC)
	1/8 - 3/4	1/16 - 3/4	1/8 - 1"	1/16 - 1.1/4	1/8 - 1"	1/8 - 3/4	1/8 - 2"	1/8 - 2"	No.4 - 1/2	No.10 - 1/4	No.4 - 1/4	No.10 - 1/4	M3 - M16	M3 - M16	1/4 - 1/2	1/4 - 3/4	No.4 - 1/2
	334	335	336	337	338	338	339	340	341	341	341	341	342	342	343	344	345
1.1	16	13	13	13	13	13	72	23	49	49	66	66	23		39	49	82
1.2	16	13	13	13	13	13	66	20	30	30	59	59	20	59	33	36	72
1.3	23	20	20	20	20	20	52	16	26	26	46	46	16	46	26	26	59
1.4	20	16	16	16	16	16	39	13	26	26	33	33	13	33	20	26	49
1.5	13	10	10	10	10	10	23	10			16	16	10	16	16	16	
1.6							13				10	10				7	
1.7																	
1.8																	
2.1							23		16	16	20	20		20		20	
2.2							16		7	7	13	13		13		13	
2.3							23				10	10		10		13	
2.4																	
3.1	23	20	20	20	20	20	39	39					39		46	39	
3.2	16	13	13	13	13	13	23	23					23		26	26	26
3.3	23	20	20	20	20	20	33	33					33		39	26	
3.4	16	13	13	13	13	13	16	16					16			13	
4.1																16	
4.2																13	
4.3											10	10					
5.1											33	33				16	
5.2											13	13		13		7	
5.3																	
6.1							39	13	26	26	33	33	13			20	
6.2	39	36	36	36	36	36	98	33	66	66			33		52	66	98
6.3							66	23	49	49	49	49	23		39	49	66
6.4							13	7					7			7	
7.1									39	39	33	33		33		39	59
7.2							115	39	79	79	82	82	39	82	66	79	115
7.3	39	36	36	36	36	36	66	23	59	59	43	43	23	43	39	59	
7.4	26	23	23	23	23	23	49	16	16	16	33	33	16	33		16	
8.1	16	13	13	13	13	13					66	66				26	98
8.2							39	16					16		26	13	
8.3							23	10					10				
9.1																	
10.1																	

# Visual Index - Taps



	UNF	UNC	UNF	M	NPT
	ANSI	DORMER DIN	DORMER DIN	DORMER ISO	ANSI
	2B	2B	Medium	6H	Normal
	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD
	HSS	HSS	HSS	HSS	HSS
		C	C	C	
		2-3	2-3	2-3	
	<b>1994 (UNF)</b>	<b>E651</b>	<b>E654</b>	<b>E650</b>	<b>E653</b>
	No.10 - 1/2	No.6 - 5/8	No.8 - 5/8	M3 - M16	1/8 - 1"
	<b>345</b>	<b>346</b>	<b>346</b>	<b>347</b>	<b>348</b>
1.1	82	82	82	82	82
1.2	72	72	72	72	72
1.3	59	59	59	59	59
1.4	49	49	49	49	49
1.5					
1.6					
1.7					
1.8					
2.1					
2.2					
2.3					
2.4					
3.1					
3.2	26	26	26	26	26
3.3					
3.4					
4.1					
4.2					
4.3					
5.1					
5.2					
5.3					
6.1					
6.2	98	98	98	98	98
6.3	66	66	66	66	66
6.4					
7.1	59	59	59	59	59
7.2	115	115	115	115	115
7.3					
7.4					
8.1	98	98	98	98	98
8.2					
8.3					
9.1					
10.1					

# List Number Index - Taps



Pgs. 220 - 351

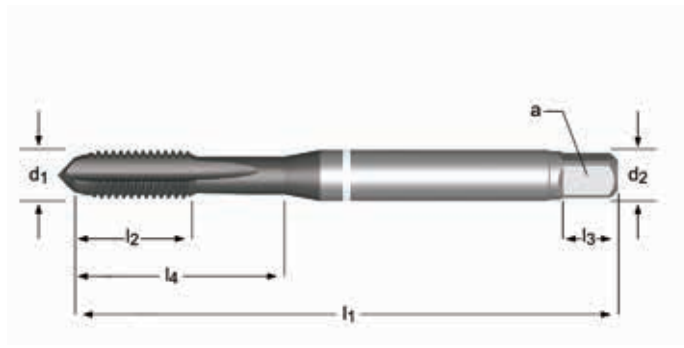
1215.....	349	3850 .....	350	E028.....	268	E809.....	238
1500.....	287	6541 .....	328	E031.....	256	E810.....	248
1500A.....	290	1545A.....	330	E033.....	270	E811.....	241
1500L.....	296	1580M.....	322	E035.....	253	E812.....	246
1500OV.....	301	1585A.....	307	E036.....	253	E813.....	239
1505.....	302	1585NR.....	313	E037.....	268	E814.....	236
1508.....	298	1585OV.....	316	E038.....	268	E815.....	236
1519.....	344	1599M.....	304	E041.....	284	E908.....	245
1528.....	287	1599SB.....	304	E043.....	286	E909.....	238
1534.....	306	1629AP.....	263	E061.....	297	E910.....	248
1534NE.....	315	1630AP.....	276	E071.....	297	E911.....	241
1534NR.....	311	1659AP.....	264	E201.....	265	E912.....	246
1541.....	326	1660AP.....	277	E252.....	265	E913.....	239
1542.....	338	1672AP.....	252	E500.....	292	E914.....	236
1543.....	334	1673AP.....	257	E501.....	300	E915.....	236
1544.....	329	1676AP.....	267	E504.....	305	EP006H.....	259
1545.....	330	1677AP.....	271	E513.....	294	EP016H.....	259
1548.....	331	1681AP.....	280	E547.....	340	EP10.....	260
1549.....	335	1687AP.....	282	E550.....	339	EP11.....	260
1567.....	336	1691AP.....	281	E620.....	342	EP20.....	255
1568.....	332	1697AP.....	282	E621.....	342	EP21.....	255
1572.....	341	1700M.....	299	E624.....	249	EP30.....	255
1578.....	341	1785M.....	310	E625.....	242	EP31.....	255
1580.....	321	1785NR.....	314	E626.....	251	EP40.....	283
1582.....	317	1788M.....	320	E627.....	244	EP41.....	283
1585.....	307	229CSET.....	351	E628.....	250	EX006H.....	273
1586.....	317	3300M.....	324	E629.....	243	EX016H.....	273
1587.....	318	3306E.....	325	E630.....	237	EX10.....	274
1588.....	318	E000.....	261	E631.....	237	EX11.....	274
1590.....	319	E000TIN.....	261	E650.....	347	EX20.....	269
1591.....	319	E001.....	261	E651.....	346	EX21.....	269
1592.....	338	E002.....	275	E653.....	348	EX30.....	269
1593.....	316	E003.....	275	E654.....	346	EX31.....	269
1595.....	298	E005.....	258	E710.....	327	EX40.....	285
1599.....	303	E006.....	258	E711.....	333	EX41.....	285
1600.....	303	E007.....	272	E712.....	337	TN1500.....	291
1634.....	309	E008.....	272	E721.....	327	TN1534.....	306
1641.....	278	E011.....	261	E764.....	249	TN1541.....	326
1671.....	279	E013.....	275	E765.....	242	TN1543.....	334
1674.....	252	E016.....	258	E766.....	251	TN1585.....	307
1675.....	257	E018.....	272	E767.....	244	TN1785.....	310
1678.....	267	E021.....	256	E768.....	250	U1511.....	343
1679.....	271	E023.....	270	E769.....	243		
1985.....	266	E025.....	253	E770.....	237		
1994.....	345	E026.....	253	E771.....	237		
3300.....	323	E027.....	268	E808.....	245		

## DIN ANSI Machine Tap, White Shark for Cast Iron

**E814** **E914** Designed for semi-bottoming or through hole tapping in Cast Iron applications. Premium HSCo Powder Metal substrate with TiAlN-Top Coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times and longer tool life.

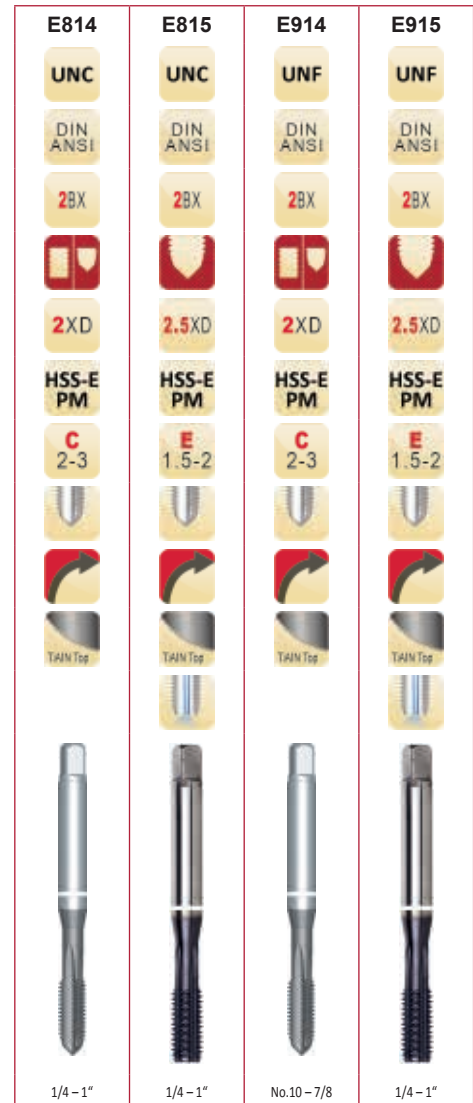
**E815** **E915** Coolant through design allows for higher tapping speeds and better tool life. This design eliminates the problems associated with inadequate coolant supply in some applications. Full Bottoming.

- 3.1 3.2 3.3 8.2
- 3.4 6.2 6.4 7.4



Pack Qty = 1 pc

UNC	UNF	TPI	$l_1$	$l_2$	$l_4$	$d_2$	$\square$	$l_3$	No. of flutes	Limits	E814	E815	E914	E915	
			Inch	Inch	Inch	Inch	Inch	Inch							
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	4	4.10 N21	H4	—	—	7350222	—
1/4	20	3.150	0.591	0.984	0.255	0.189	0.310	4	5.10 N7	H5	7350203	7350231	—	—	
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	4	5.50 N3	H5	—	—	7350223	—
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	4	5.50 N3	H4	—	—	—	7350240
5/16	18	3.543	0.709	1.339	0.318	0.236	0.380	4	6.60 F	H5	7350204	—	—	—	
5/16	18	3.543	0.787	1.339	0.318	0.236	0.380	4	6.60 F	H5	—	7350232	—	—	
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	4	6.90 I	H5	—	—	7350224	—
	5/16	24	3.543	0.787	1.339	0.318	0.236	0.380	4	6.90 I	H5	—	—	—	7350241
3/8	16	3.937	0.787	1.535	0.381	0.284	0.440	4	8.00 5/16	H5	7350205	7350233	—	—	
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	4	8.50 Q	H5	—	—	7350225	7350242
7/16	14	3.937	0.787	—	0.323	0.240	0.410	4	9.40 U	H5	7350206	7350234	—	—	
	7/16	20	3.937	0.787	—	0.323	0.240	0.410	4	9.90 25/64	H5	—	—	7350226	7350243
1/2	13	4.331	0.906	—	0.367	0.273	0.440	4	10.80 27/64	H5	7350207	7350235	—	—	
	1/2	20	3.937	0.827	—	0.367	0.273	0.440	4	11.50 29/64	H5	—	—	7350227	7350244
5/8	11	4.331	0.906	—	0.480	0.358	0.560	4	13.50 17/32	H5	7350208	7350236	—	—	
	5/8	18	3.937	0.827	—	0.480	0.358	0.560	4	14.50 37/64	H5	—	—	7350228	7350245
3/4	10	4.921	1.181	—	0.590	0.439	0.690	4	16.50 21/32	H5	7350209	7350237	—	—	
	3/4	16	4.331	0.906	—	0.590	0.439	0.690	4	17.50 11/16	H6	—	—	7350229	—
	3/4	16	4.331	0.906	—	0.590	0.439	0.690	4	17.50 11/16	H5	—	—	—	7350246
7/8	9	5.512	1.339	—	0.697	0.520	0.750	4	19.50 49/64	H6	7350220	7350238	—	—	
	7/8	14	4.921	0.906	—	0.697	0.520	0.750	4	20.40 13/16	H6	—	—	7350230	7350247
1"	8	6.299	1.417	—	0.800	0.597	0.810	4	22.25 7/8	H6	7350221	7350239	—	—	
	1"	12	5.512	1.063	—	0.800	0.597	0.810	4	23.25 59/64	H6	—	—	—	7350248

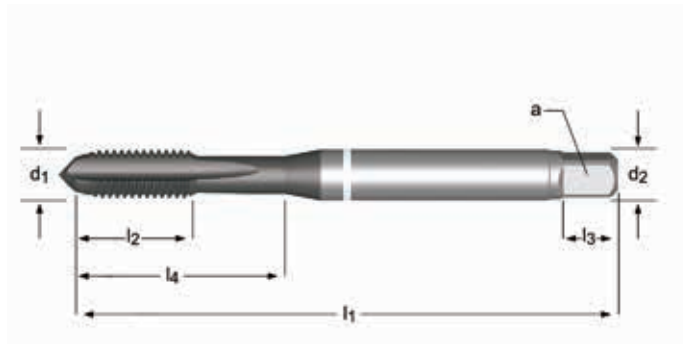


**DIN ANSI Machine Tap, White Shark for Cast Iron**

**E630**      **E770**      Designed for semi-bottoming or through hole tapping in Cast Iron applications. Premium HSCo Powder Metal substrate with TiAIN-Top Coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times and longer tool life.

**E631**      **E771**      Coolant through design allows for higher tapping speeds and better tool life. This design eliminates the problems associated with inadequate coolant supply in some applications. Full Bottoming.

- 3.1 3.2 3.3 8.2
- 3.4 6.2 6.4 7.4



Pack Qty = 1 pc

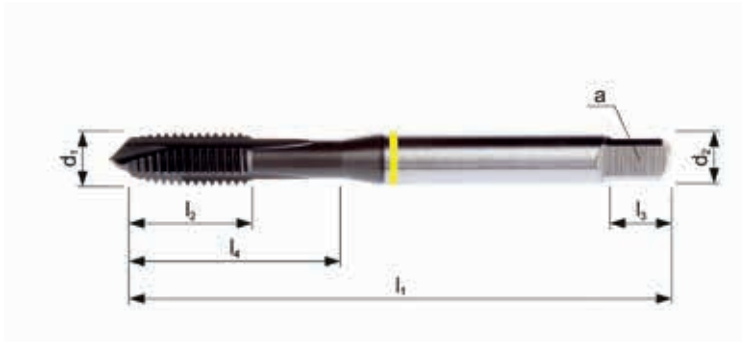
M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	∠	l <sub>3</sub>	No. of flutes	↔	↔	Limits	E630	E631	E770	E771
		mm	mm	mm	mm	Inch	Inch	mm								
5		0.80	70	13	25	0.194	0.150	6	4	4.20	N19	D4	7350249	—	—	—
6		1.00	80	15	25	0.255	0.189	8	4	5.00	N9	D5	—	7350265	—	—
6		1.00	80	15	30	0.255	0.189	8	4	5.00	N9	D5	7350250	—	—	—
	8	1.00	90	18	35	0.318	0.236	10	4	7.00	J	D5	—	—	7350259	—
8		1.25	90	18	35	0.318	0.236	10	4	6.80	H	D5	7350251	—	—	—
8		1.25	90	20	34	0.318	0.236	10	4	6.80	H	D5	—	7350266	—	—
	10	1.00	90	20	35	0.381	0.284	11	4	9.00	T	D6	—	—	7350260	—
	10	1.25	100	20	39	0.381	0.284	11	4	8.80	11/32	D6	—	—	7350261	7350274
10		1.50	100	20	39	0.381	0.284	11	4	8.50	Q	D6	7350252	7350267	—	—
	12	1.25	100	21	—	0.367	0.273	11	4	10.80	27/64	D6	—	—	7350262	7350275
	12	1.50	100	21	—	0.367	0.273	11	4	10.50	Z	D6	—	—	7350263	7350276
12		1.75	110	23	—	0.367	0.273	11	4	10.30	Y	D6	7350253	7350268	—	—
	14	1.50	100	21	—	0.429	0.320	13	4	12.50	31/64	D7	—	—	7350264	7350277
14		2.00	110	23	—	0.429	0.320	13	4	12.00	15/32	D7	7350254	7350269	—	—
16		2.00	110	23	—	0.480	0.358	14	4	14.00	35/64	D7	7350255	7350270	—	—
18		2.50	125	30	—	0.542	0.404	16	4	15.50	39/64	D7	7350256	7350271	—	—
20		2.50	140	30	—	0.652	0.487	18	4	17.50	11/16	D7	7350257	7350272	—	—
24		3.00	160	38	—	0.760	0.567	19	4	21.00	53/64	D8	7350258	7350273	—	—

E630	E631	E770	E771
M	M	MF	MF
DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI
6HX	6HX	6HX	6HX
2XD	2.5XD	2XD	2.5XD
HSS-E PM	HSS-E PM	HSS-E PM	HSS-E PM
C 2-3	E 1.5-2	C 2-3	E 1.5-2
M5—M24	M6—M24	M8—M14	M10—M14

## DIN ANSI Machine Tap, Yellow Shark for Low Alloy Steels

**E809** Designed for through hole tapping in low Alloy Steel applications.  
**E909** Premium HSCo Powder Metal substrate with TiAlN-Top Coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times and longer tool life.

- 1.1 1.2 1.3 6.1 6.3
- 1.4 1.5 6.2



Pack Qty = 1 pc

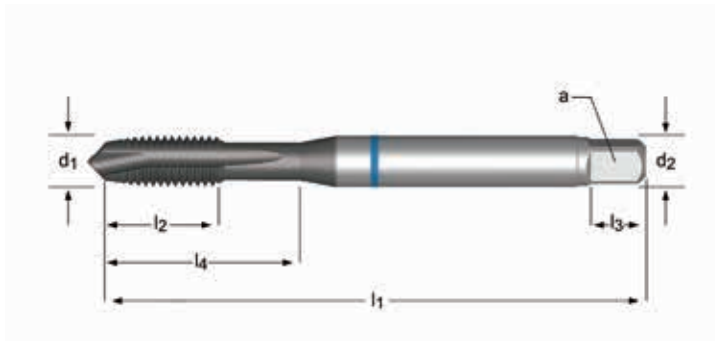
UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch	$d_2$ Inch	$a$ Inch	$l_3$ Inch	No. of flutes			Limits	E809	E909
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	7350469	
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H2	7350470	
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350471	
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350472	
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350482
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350473	
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H4		7350483
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350474	
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4		7350484
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	7350475	
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H4		7350485
7/16		14	3.937	0.787	-	0.323	0.240	0.410	3	9.40	U	H5	7350476	
	7/16	20	3.937	0.787	-	0.323	0.240	0.410	3	9.90	25/64	H5		7350486
1/2		13	4.331	0.906	-	0.367	0.273	0.440	3	10.80	27/64	H5	7350477	
	1/2	20	3.937	0.827	-	0.367	0.273	0.440	3	11.50	29/64	H5		7350487
5/8		11	4.331	0.906	-	0.480	0.358	0.560	3	13.50	17/32	H5	7350478	
	5/8	18	3.937	0.827	-	0.480	0.358	0.560	3	14.50	37/64	H5		7350488
3/4		10	4.921	1.181	-	0.590	0.439	0.690	3	16.50	21(32)	H5	7350479	
	3/4	16	4.331	0.906	-	0.590	0.439	0.690	3	17.50	11/16	H5		7350489
7/8		9	5.512	1.339	-	0.697	0.520	0.750	4	19.50	49/64	H6	7350480	
	7/8	14	4.921	0.906	-	0.697	0.520	0.750	4	20.40	13/16	H6		7350490
1"		8	6.299	1.417	-	0.800	0.597	0.810	4	22.25	7/8	H6	7350481	
	1"	12	5.512	1.063	-	0.800	0.597	0.810	4	23.25	59/64	H6		7350491

## DIN ANSI Machine Tap, Blue Shark for Stainless Steel

**E813** Designed for superior performance through hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment to offer improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

**E913**



- 2.1 2.2 2.3
- 1.2 1.3 1.4 1.5



<b>E813</b>	<b>E913</b>
UNC	UNF
DIN ANSI	DIN ANSI
2B 3B	2B 3B
2.5XD	2.5XD
HSS-E PM	HSS-E PM
B 3.5-5	B 3.5-5
Super B	Super B
No.4-1"	No.10-1"

Pack Qty = 1 pc

UNC	UNF	TPI	l <sub>1</sub> Inch	l <sub>2</sub> Inch	l <sub>4</sub> Inch	d <sub>2</sub> Ø Inch	∠ a Inch	l <sub>3</sub> Inch	No. of flutes			Limits	E813	E913
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	7350278	
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H3	7350279	
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350280	
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350281	
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350299
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350282	
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H3	7350283	
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H5		7350300
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H3		7350301
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350284	
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H3	7350285	
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4		7350302
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H3		7350303
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H3	7350287	
3/8		16	3.937	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H5	7350286	
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H4		7350304
	3/8	24	3.543	0.787	1.476	0.381	0.284	0.440	3	8.50	Q	H3		7350305
5/8		11	4.331	0.906	-	0.480	0.358	0.560	4	13.50	17/32	H5	7350291	
5/8		11	4.331	0.906	-	0.480	0.358	0.560	4	13.50	17/32	H3	7350292	
7/16		14	3.937	0.787	-	0.323	0.240	0.410	4	9.40	U	H5	7350288	
	7/16	20	3.937	0.787	-	0.323	0.240	0.410	4	9.90	25/64	H5		7350306
1/2		13	4.331	0.906	-	0.367	0.273	0.440	4	10.80	27/64	H5	7350289	
1/2		13	4.331	0.906	-	0.367	0.273	0.440	4	10.80	27/64	H3	7350290	
	1/2	20	3.937	0.827	-	0.367	0.273	0.440	4	11.50	29/64	H5		7350307
	1/2	20	3.937	0.827	-	0.367	0.273	0.440	4	11.50	29/64	H3		7350308

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch	$d_2$ $\varnothing$ Inch	$\square$ a Inch	$l_3$ Inch	No. of flutes			Limits	E813	E913
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	4	14.50	37/64	H5		7350309
	5/8	18	3.937	0.827	–	0.480	0.358	0.560	4	14.50	37/64	H3		7350310
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H5	7350293	
3/4		10	4.921	1.181	–	0.590	0.439	0.690	4	16.50	21/32	H3	7350294	
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H5		7350311
	3/4	16	4.331	0.906	–	0.590	0.439	0.690	4	17.50	11/16	H3		7350312
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H6	7350295	
7/8		9	5.512	1.339	–	0.697	0.520	0.750	4	19.50	49/64	H4	7350296	
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H6		7350313
	7/8	14	4.921	0.906	–	0.697	0.520	0.750	4	20.40	13/16	H4		7350314
1"		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H6	7350297	
1"		8	6.299	1.417	–	0.800	0.597	0.810	4	22.25	7/8	H4	7350298	
	1"	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6		7350315
	1"	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H4		7350316

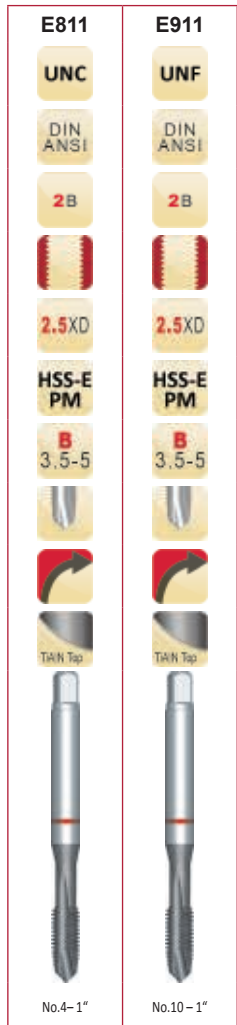
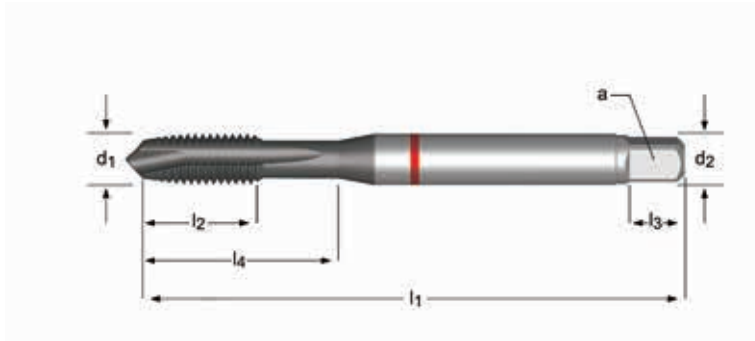


## DIN ANSI Machine Tap, Red Shark for Alloy Steels

**E811** Designed for high performance through hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with an additional edge treatment provides excellent performance and consistency in high production applications.

**E911**

- 1.4 1.5
- 1.6 4.2 5.2



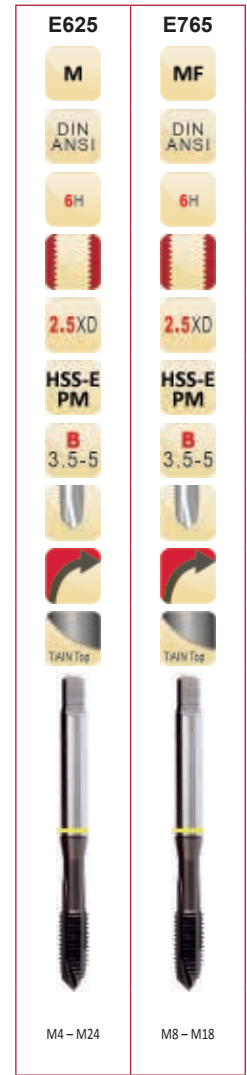
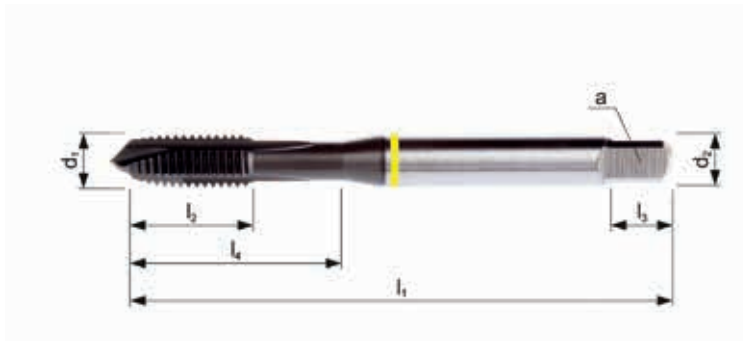
Pack Qty = 1 pc

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch	$d_2$ Inch	$\square$ a Inch	$l_3$ Inch	No. of flutes			Limits	E811	E911
4		40	2.205	0.354	0.709	0.141	0.108	0.190	3	2.35	N43	H2	7350391	
6		32	2.205	0.433	0.787	0.141	0.108	0.190	3	2.85	N36	H2	7350392	
8		32	2.480	0.512	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350393	
	10	32	2.756	0.551	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350404
10		24	2.756	0.551	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350394	
	1/4	28	3.150	0.591	0.984	0.255	0.189	0.310	3	5.50	N3	H4		7350405
1/4		20	3.150	0.591	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350395	
	5/16	24	3.543	0.709	1.339	0.318	0.236	0.380	3	6.90	I	H4		7350406
5/16		18	3.543	0.709	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350396	
	3/8	24	3.543	0.787	1.476	0.318	0.284	0.440	3	8.50	Q	H4		7350407
3/8		16	3.543	0.787	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	7350397	
	7/16	20	3.937	0.787	-	0.323	0.240	0.410	3	9.90	25/64	H5		7350408
7/16		14	3.937	0.787	-	0.323	0.240	0.410	3	9.40	U	H5	7350398	
	1/2	20	3.937	0.827	-	0.367	0.273	0.440	3	11.50	29/64	H5		7350409
1/2		13	4.331	0.906	-	0.367	0.273	0.440	3	10.80	27/64	H5	7350399	
	5/8	18	3.937	0.827	-	0.480	0.358	0.560	3	14.50	37/64	H5		7350410
5/8		11	4.331	0.906	-	0.480	0.358	0.560	3	13.50	17/32	H5	7350400	
	3/4	16	4.331	0.906	-	0.590	0.439	0.690	4	17.50	11/16	H5		7350411
3/4		10	4.921	1.181	-	0.590	0.439	0.690	4	16.50	21/32	H5	7350401	
	7/8	14	4.921	0.906	-	0.697	0.520	0.750	4	20.40	13/16	H6		7350412
7/8		9	5.512	1.339	-	0.697	0.520	0.750	4	19.50	49/64	H6	7350402	
	1"	12	5.512	1.063	-	0.800	0.597	0.810	4	23.25	59/64	H6		7350413
1"		8	6.299	1.417	-	0.800	0.597	0.810	4	22.25	7/8	H6	7350403	

## DIN ANSI Machine Tap, Yellow Shark for Low Alloy Steels

**E625** Designed for through hole tapping in low Alloy Steel applications.  
**E765** Premium HSCo Powder Metal substrate with TiAlN-Top Coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times and longer tool life.

- 1.1 1.2 1.3 6.1 6.3
- 1.4 1.5 6.2



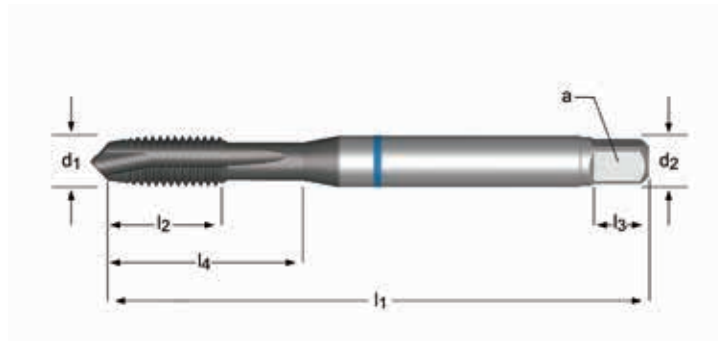
Pack Qty = 1 pc

M	MF	P	$l_1$	$l_2$	$l_4$	$d_2$	$\square$	$l_3$	No. of flutes	$\leftrightarrow$	$\leftrightarrow$	Limits	E625	E765
		mm	mm	mm	mm	Inch	Inch	mm						
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	7350492	
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	7350493	
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	7350494	
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5		7350503
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	7350495	
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6		7350504
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	7350496	
	12	1.25	100	21	-	0.367	0.273	11	3	10.80	27/64	D6		7350505
	12	1.50	100	21	-	0.367	0.273	11	3	10.50	Z	D6		7350506
12		1.75	110	23	-	0.367	0.273	11	3	10.30	Y	D6	7350497	
	14	1.50	100	21	-	0.429	0.320	13	3	12.50	31/64	D7		7350507
14		2.00	110	23	-	0.429	0.320	13	3	12.00	15/32	D7	7350498	
	16	1.50	100	21	-	0.480	0.358	14	3	14.50	9/16	D7		7350508
16		2.00	110	23	-	0.480	0.358	14	3	14.00	35/64	D7	7350499	
	18	1.50	110	24	-	0.542	0.404	16	3	16.50	41/64	D7		7350509
18		2.50	125	30	-	0.542	0.404	16	3	15.50	39/64	D7	7350500	
20		2.50	140	30	-	0.652	0.487	18	3	17.50	11/16	D7	7350501	
24		3.00	160	38	-	0.760	0.567	19	4	21.00	53/64	D8	7350502	

## DIN ANSI Machine Tap, Blue Shark for Stainless Steel

**E629**    **E769**    Designed for superior performance through hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment to offer improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

- **2.1** **2.2** **2.3**
- **1.2** **1.3** **1.4** **1.5**



<b>E629</b>	<b>E769</b>
<b>M</b>	<b>MF</b>
<b>DIN ANSI</b>	<b>DIN ANSI</b>
<b>6H</b>	<b>6H</b>
<b>2.5XD</b>	<b>2.5XD</b>
<b>HSS-E PM</b>	<b>HSS-E PM</b>
<b>B 3.5-5</b>	<b>B 3.5-5</b>
<b>Super B</b>	<b>Super B</b>
<b>M4 - M24</b>	<b>M8 - M18</b>

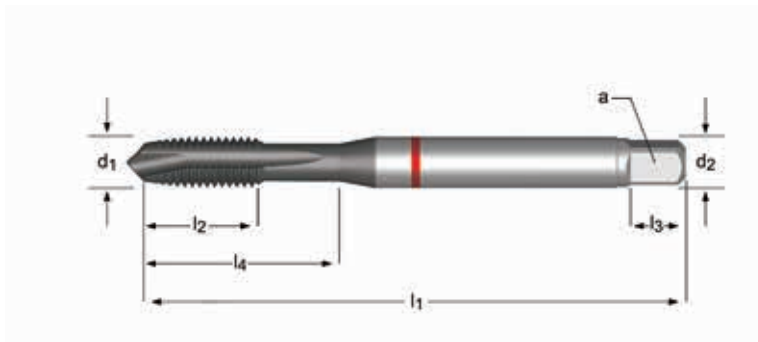
Pack Qty = 1 pc

M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	∠ a	l <sub>3</sub>	No. of flutes			Limits	E629	E769
		mm	mm	mm	mm	Ø	∠	mm						
						Inch	Inch							
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	7350317	
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	7350318	
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	7350319	
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5		7350328
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	7350320	
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6		7350329
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	7350321	
	12	1.25	100	21	-	0.367	0.273	11	4	10.80	27/64	D6		7350330
	12	1.50	100	21	-	0.367	0.273	11	4	10.50	Z	D6		7350331
12		1.75	110	23	-	0.367	0.273	11	4	10.30	Y	D6	7350322	
	14	1.50	100	21	-	0.429	0.320	13	4	12.50	31/64	D7		7350332
14		2.00	110	23	-	0.429	0.320	13	4	12.00	15/32	D7	7350323	
	16	1.50	100	21	-	0.480	0.358	14	4	14.50	9/16	D7		7350333
16		2.00	110	23	-	0.480	0.358	14	4	14.00	35/64	D7	7350324	
	18	1.50	110	24	-	0.542	0.404	16	4	16.50	41/64	D7		7350334
18		2.50	125	30	-	0.542	0.404	16	4	15.50	39/64	D7	7350325	
20		2.50	140	30	-	0.652	0.487	18	4	17.50	11/16	D7	7350326	
24		3.00	160	38	-	0.760	0.567	19	4	21.00	53/64	D8	7350327	

## DIN ANSI Machine Tap, Red Shark for Alloy Steels

**E627** Designed for high performance through hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with an additional edge treatment provides excellent performance and consistency in high production applications.

- 1.4 1.5
- 1.6 4.2 5.2



<b>E627</b>	<b>E767</b>
<b>M</b>	<b>MF</b>
DIN ANSI	DIN ANSI
6H	6H
2.5XD	2.5XD
HSS-E PM	HSS-E PM
B 3.5-5	B 3.5-5
M3 - M24	M8 - M14

Pack Qty = 1 pc

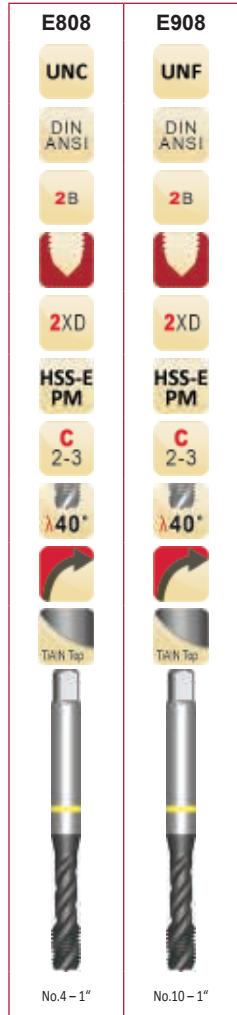
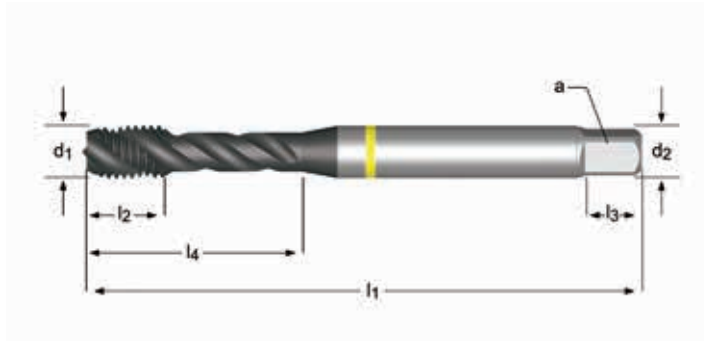
M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	∇ a	l <sub>3</sub>	No. of flutes			Limits	E627	E767
		mm	mm	mm	mm	Inch	Inch	mm						
3		0.50	56	9	18	0.141	0.108	5	3	2.50	N40	D3	7350414	
4		0.70	63	12	21	0.168	0.129	6	3	3.30	N30	D4	7350415	
5		0.80	70	13	25	0.194	0.150	6	3	4.20	N19	D4	7350416	
6		1.00	80	15	30	0.255	0.189	8	3	5.00	N9	D5	7350417	
	8	1.00	90	18	35	0.318	0.236	10	3	7.00	J	D5		7350426
8		1.25	90	18	35	0.318	0.236	10	3	6.80	H	D5	7350418	
	10	1.25	100	20	39	0.381	0.284	11	3	8.80	11/32	D6		7350427
10		1.50	100	20	39	0.381	0.284	11	3	8.50	Q	D6	7350419	
	12	1.50	100	21	-	0.367	0.273	11	3	10.50	Z	D6		7350428
12		1.75	110	23	-	0.367	0.273	11	3	10.30	Y	D6	7350420	
	14	1.50	100	21	-	0.429	0.320	13	3	12.50	31/64	D7		7350429
14		2.00	110	23	-	0.429	0.320	13	3	12.00	15/32	D7	7350421	
16		2.00	110	23	-	0.480	0.358	14	3	14.00	35/64	D7	7350422	
18		2.50	125	30	-	0.542	0.404	16	4	15.50	39/64	D7	7350423	
20		2.50	140	30	-	0.652	0.487	18	4	17.50	11/16	D7	7350424	
24		3.00	160	38	-	0.760	0.567	19	4	21.00	53/64	D8	7350425	

## DIN ANSI Machine Tap, Yellow for Low Alloy Steels

**E808** Designed for blind hole tapping in low Alloy Steel applications. Premium HSCo Powder Metal substrate with TiAlN-Top Coating combined with a special 40° Spiral Flute geometry prevents nesting and reduces the risk of re-cutting chips on reversal allowing taps to operate at higher speeds while providing improved thread quality.

**E908**

- 1.1 1.2 1.3 6.1 6.3
- 1.4 1.5 6.2



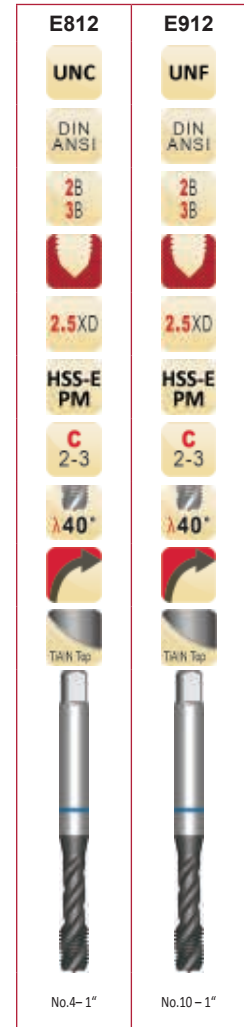
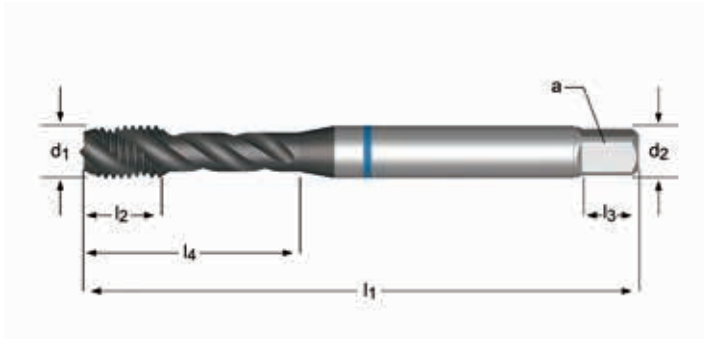
Pack Qty = 1 pc

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch	$d_2$ Inch	$\square$ a Inch	$l_3$ Inch	No. of flutes			Limits	E808	E908
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	7350510	
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.85	N36	H2	7350511	
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350512	
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350513	
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350523
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350514	
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H4		7350524
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350515	
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H4		7350525
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	7350516	
	3/8	24	3.543	0.591	1.476	0.381	0.284	0.440	3	8.50	Q	H4		7350526
7/16		14	3.937	0.591	-	0.323	0.240	0.410	3	9.40	U	H5	7350517	
	7/16	20	3.937	0.591	-	0.323	0.240	0.410	3	9.90	25/64	H5		7350527
1/2		13	4.331	0.709	-	0.367	0.273	0.440	3	10.80	27/64	H5	7350518	
	1/2	20	3.937	0.709	-	0.367	0.273	0.440	3	11.50	29/64	H5		7350528
5/8		11	4.331	0.787	-	0.480	0.358	0.560	4	13.50	17/32	H5	7350519	
	5/8	18	3.937	0.591	-	0.480	0.358	0.560	4	14.50	37/64	H5		7350529
3/4		10	4.921	0.984	-	0.590	0.439	0.690	4	16.50	21/32	H5	7350520	
	3/4	16	4.331	0.984	-	0.590	0.439	0.690	4	17.50	11/16	H5		7350530
7/8		9	5.512	0.984	-	0.697	0.520	0.750	4	19.50	49/64	H6	7350521	
	7/8	14	4.921	0.984	-	0.697	0.520	0.750	4	20.40	13/16	H6		7350531
1"		8	6.299	1.181	-	0.800	0.597	0.810	4	22.25	7/8	H6	7350522	

## DIN ANSI Machine Tap, Blue Shark for Stainless Steel

**E812** **E912** Designed for superior performance blind hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment and a 40° Flute angle facilitates better chip evacuation offering improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

- 2.1 2.2 2.3
- 1.2 1.3 1.4 1.5



Pack Qty = 1 pc

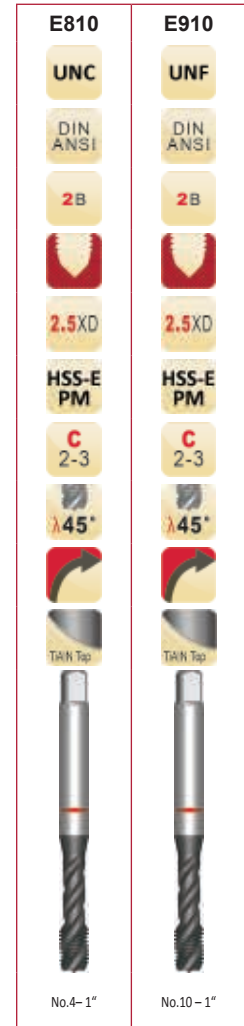
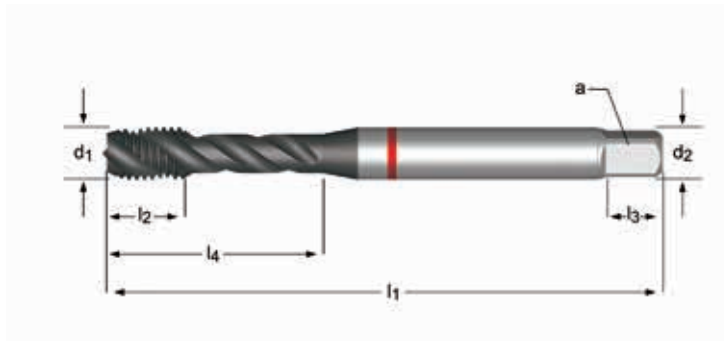
UNC	UNF	TPI	$l_1$	$l_2$	$l_4$	$d_2$	$\square$	$l_3$	No. of flutes			Limits	E812	E912
			Inch	Inch	Inch	Inch	Inch	Inch						
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	7350335	
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.80	N36	H3	7350336	
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350337	
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350338	
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350356
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350339	
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H3	7350340	
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H5		7350357
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H3		7350358
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350341	
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H3	7350342	
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H4		7350359
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.90	I	H3		7350360
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H5	7350343	
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H3	7350344	
	3/8	24	3.543	0.591	1.476	0.318	0.284	0.440	3	8.50	Q	H4		7350361
	3/8	24	3.543	0.591	1.476	0.318	0.284	0.440	3	8.50	Q	H3		7350362
7/16		14	3.937	0.591	-	0.323	0.240	0.410	4	9.40	U	H5	7350345	
	7/16	20	3.937	0.591	-	0.323	0.240	0.410	4	9.90	25/64	H5		7350363
1/2		13	4.331	0.709	-	0.367	0.273	0.440	4	10.70	27/64	H5	7350346	
1/2		13	4.331	0.709	-	0.367	0.273	0.440	4	10.70	27/64	H3	7350347	
	1/2	20	3.937	0.709	-	0.367	0.273	0.440	4	11.50	29/64	H5		7350364
	1/2	20	3.937	0.709	-	0.367	0.273	0.440	4	11.50	29/64	H3		7350365
5/8		11	4.331	0.787	-	0.480	0.358	0.560	4	13.50	17/32	H5	7350348	
5/8		11	4.331	0.787	-	0.480	0.358	0.560	4	13.50	17/32	H3	7350349	
	5/8	18	3.937	0.591	-	0.480	0.358	0.560	4	14.50	37/64	H5		7350366
	5/8	18	3.937	0.591	-	0.480	0.358	0.560	4	14.50	37/64	H3		7350367

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch	$d_2$ $\emptyset$ Inch	$\square$ a Inch	$l_3$ Inch	No. of flutes			Limits	E812	E912
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H5	7350350	
3/4		10	4.921	0.984	–	0.590	0.439	0.690	4	16.50	21/32	H3	7350351	
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H5		7350368
	3/4	16	4.331	0.984	–	0.590	0.439	0.690	4	17.50	11/16	H3		7350369
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H6	7350352	
7/8		9	5.512	0.984	–	0.697	0.520	0.750	4	19.50	49/64	H4	7350353	
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H6		7350370
	7/8	14	4.921	0.984	–	0.697	0.520	0.750	4	20.40	13/16	H4		7350371
1"		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H6	7350354	
1"		8	6.299	1.181	–	0.800	0.597	0.810	4	22.25	7/8	H4	7350355	
	1"	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H6		7350372
	1"	12	5.512	1.063	–	0.800	0.597	0.810	4	23.25	59/64	H4		7350373

## DIN ANSI Machine Tap, Red Shark for Alloy Steels

**E810** Designed for high performance blind hole tapping in most medium Alloy Steels.  
**E910** The TiAlN-Top Coating combined with a special 45° Flute Geometry and an additional edge treatment provides excellent performance and consistency in high production applications. The back taper built into this design further facilitates chip evacuation and reduces torque when the tap reverses. It is recommended to use a toolholder with minimal float or soft start.

- 1.4 1.5
- 1.6 4.2 5.2



Pack Qty = 1 pc

UNC	UNF	TPI	$l_1$	$l_2$	$l_4$	$d_2$	$\square$	$l_3$	No. of flutes	$\leftrightarrow$	$\leftrightarrow$	Limits	E810	E910
			Inch	Inch	Inch	Inch	Inch	Inch						
4		40	2.205	0.256	0.709	0.141	0.108	0.236	3	2.35	N43	H2	7350430	
6		32	2.205	0.256	0.787	0.141	0.108	0.190	3	2.85	N36	H2	7350431	
8		32	2.480	0.276	0.827	0.168	0.129	0.250	3	3.50	N29	H3	7350432	
10		24	2.756	0.315	1.102	0.194	0.150	0.250	3	3.90	N25	H3	7350433	
	10	32	2.756	0.315	1.102	0.194	0.150	0.250	3	4.10	N21	H3		7350443
1/4		20	3.150	0.394	0.984	0.255	0.189	0.310	3	5.10	N7	H5	7350434	
	1/4	28	3.150	0.394	0.984	0.255	0.189	0.310	3	5.50	N3	H4		7350444
5/16		18	3.543	0.472	1.339	0.318	0.236	0.380	3	6.60	F	H5	7350435	
	5/16	24	3.543	0.472	1.339	0.318	0.236	0.380	3	6.9	I	H4		7350445
3/8		16	3.937	0.591	1.535	0.381	0.284	0.440	3	8.00	5/16	H4	7350436	
	3/8	24	3.543	0.591	1.476	0.381	0.284	0.440	3	8.50	Q	H4		7350446
7/16		14	3.937	0.591	-	0.323	0.240	0.410	3	9.40	U	H5	7350437	
	7/16	20	3.937	0.591	-	0.323	0.240	0.410	3	9.90	25/64	H5		7350447
1/2		13	4.331	0.709	-	0.367	0.273	0.440	3	10.80	27/64	H5	7350438	
	1/2	20	3.937	0.709	-	0.367	0.273	0.440	3	11.50	29/64	H5		7350448
5/8		11	4.331	0.787	-	0.480	0.358	0.560	4	13.50	17/32	H5	7350439	
	5/8	18	3.937	0.591	-	0.480	0.358	0.560	4	14.50	37/64	H5		7350449
3/4		10	4.921	0.984	-	0.590	0.439	0.690	4	16.50	21/32	H5	7350440	
	3/4	16	4.331	0.984	-	0.590	0.439	0.690	4	17.50	11/16	H5		7350450
7/8		9	5.512	0.984	-	0.697	0.520	0.750	4	19.50	49/64	H6	7350441	
	7/8	14	4.921	0.984	-	0.697	0.520	0.750	4	20.40	13/16	H6		7350451
1"		8	6.299	1.181	-	0.800	0.597	0.810	4	22.25	7/8	H6	7350442	
	1"	12	5.512	1.063	-	0.800	0.597	0.810	4	23.25	59/64	H6		7350452

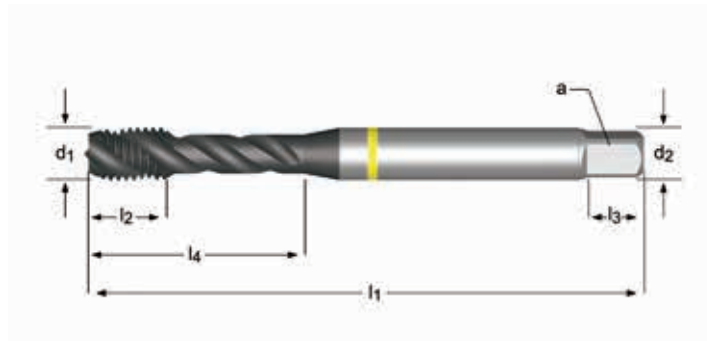


## DIN ANSI Machine Tap, Yellow for Low Alloy Steels

**E624** Designed for blind hole tapping in low Alloy Steel applications. Premium HSCo Powder Metal substrate with TiAlN-Top Coating combined with a special 40° Spiral Flute geometry prevents nesting and reduces the risk of re-cutting chips on reversal allowing taps to operate at higher speeds while providing improved thread quality.

**E764**

- 1.1 1.2 1.3 6.1 6.3
- 1.4 1.5 6.2



<b>E624</b>	<b>E764</b>
M	MF
DIN ANSI	DIN ANSI
6H	6H
2XD	2XD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
λ 40°	λ 40°
M4 – M24	M8 – M18

Pack Qty = 1 pc

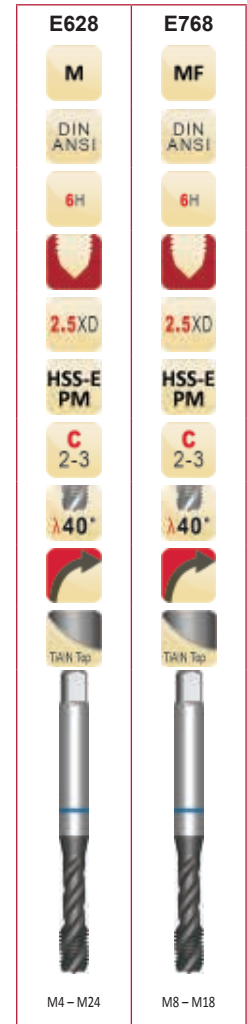
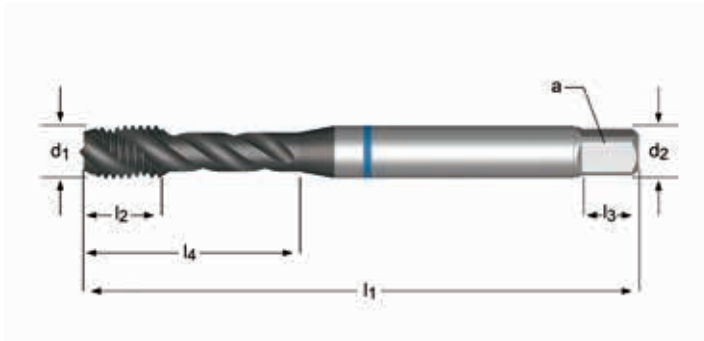
M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	□ a	l <sub>3</sub>	No. of flutes			Limits	E624	E764
		mm	mm	mm	mm	Inch	Inch	mm						
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	7350533	
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	7350534	
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	7350535	
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5		7350544
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	7350536	
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6		7350545
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	7350537	
	12	1.25	100	15	–	0.367	0.273	11	3	10.80	27/64	D6		7350546
	12	1.50	100	15	–	0.367	0.273	11	3	10.50	Z	D6		7350547
12		1.75	110	18	–	0.367	0.273	11	3	10.30	Y	D6	7350538	
	14	1.50	100	15	–	0.429	0.320	13	3	12.50	31/64	D7		7350548
14		2.00	110	20	–	0.429	0.320	13	3	12.00	15/32	D7	7350539	
	16	1.50	100	15	–	0.480	0.358	14	4	14.50	9/16	D7		7350549
16		2.00	110	20	–	0.480	0.358	14	4	14.00	35/64	D7	7350540	
	18	1.50	110	17	–	0.542	0.404	16	4	16.50	41/64	D7		7350550
18		2.50	125	25	–	0.542	0.404	16	4	15.50	39/64	D7	7350541	
20		2.50	140	25	–	0.652	0.487	18	4	17.50	11/16	D7	7350542	
24		3.00	160	30	–	0.760	0.567	19	4	21.00	53/64	D8	7350543	

## DIN ANSI Machine Tap, Blue Shark for Stainless Steel

**E628** **E768** Designed for superior performance blind hole tapping in a wide range of Stainless Steel types. Premium HSCo Powder Metal substrate with Super-B (TiAlN+WC/C) Coating combined with an additional edge treatment and a 40° Flute angle facilitates better chip evacuation offering improved thread quality and longer tool life. Available in both 2B and 3B Class of Fit to cover a wide range of applications.

■ 2.1 2.2 2.3

● 1.2 1.3 1.4 1.5



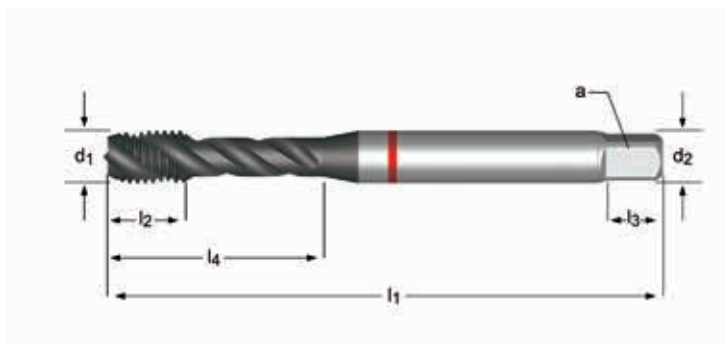
Pack Qty = 1 pc

M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	∠	l <sub>3</sub>	No. of	↔	↔	Limits	E628	E768
		mm	mm	mm	mm	Inch	Inch	mm	flutes					
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	7350374	
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	7350375	
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	7350376	
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5		7350385
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	7350377	
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6		7350386
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	7350378	
	12	1.50	100	15	-	0.367	0.273	11	4	10.50	Z	D6		7350387
12		1.75	110	18	-	0.367	0.273	11	4	10.30	Y	D6	7350379	
	14	1.50	100	15	-	0.429	0.320	13	4	12.50	31/64	D7		7350388
14		2.00	110	20	-	0.429	0.320	13	4	12.00	15/32	D7	7350380	
	16	1.50	100	15	-	0.480	0.358	14	4	14.50	9/16	D7		7350389
16		2.00	110	20	-	0.480	0.358	14	4	14.00	35/64	D7	7350381	
	18	1.50	110	17	-	0.542	0.404	16	4	16.50	41/64	D7		7350390
18		2.50	125	25	-	0.542	0.404	16	4	15.50	39/64	D7	7350382	
20		2.50	140	25	-	0.652	0.487	18	4	17.50	11/16	D7	7350383	
24		3.00	160	30	-	0.760	0.567	19	4	21.00	53/64	D8	7350384	

## DIN ANSI Machine Tap, Red Shark for Alloy Steels

**E626**    **E766**    Designed for high performance blind hole tapping in most medium Alloy Steels. The TiAlN-Top Coating combined with a special 45° Flute Geometry and an additional edge treatment provides excellent performance and consistency in high production applications. The back taper built into this design further facilitates chip evacuation and reduces torque when the tap reverses. It is recommended to use a toolholder with minimal float or soft start.

- 1.4 1.5
- 1.6 4.2 5.2



<b>E626</b>	<b>E766</b>
M	MF
DIN ANSI	DIN ANSI
6H	6H
2.5XD	2.5XD
HSS-E PM	HSS-E PM
C 2-3	C 2-3
$\lambda 45^\circ$	$\lambda 45^\circ$
M3 - M24	M8 - M14

Pack Qty = 1 pc

M	MF	P	$l_1$	$l_2$	$l_4$	$d_2$	$\square$	$l_3$	No. of flutes			Limits	E626	E766
		mm	mm	mm	mm	Inch	Inch	mm						
3		0.50	56	6	18	0.141	0.108	5	3	2.50	N40	D3	7350453	
4		0.70	63	7	21	0.168	0.129	6	3	3.30	N30	D4	7350454	
5		0.80	70	8	25	0.194	0.150	6	3	4.20	N19	D4	7350455	
6		1.00	80	10	30	0.255	0.189	8	3	5.00	N9	D5	7350456	
	8	1.00	90	13	35	0.318	0.236	10	3	7.00	J	D5		7350465
8		1.25	90	13	35	0.318	0.236	10	3	6.80	H	D5	7350457	
	10	1.25	100	15	39	0.381	0.284	11	3	8.80	11/32	D6		7350466
10		1.50	100	15	39	0.381	0.284	11	3	8.50	Q	D6	7350458	
	12	1.25	100	15	-	0.367	0.273	11	3	10.80	27/64	D6		7350467
12		1.75	110	18	-	0.367	0.273	11	3	10.30	Y	D6	7350459	
	14	1.50	100	15	-	0.429	0.320	13	3	12.50	31/64	D7		7350468
14		2.00	110	20	-	0.429	0.320	13	3	12.00	15/32	D7	7350460	
16		2.00	110	20	-	0.480	0.358	14	4	14.00	35/64	D7	7350461	
18		2.50	125	25	-	0.542	0.404	16	4	15.50	39/64	D7	7350462	
20		2.50	140	25	-	0.652	0.487	18	4	17.50	11/16	D7	7350463	
24		3.00	160	30	-	0.760	0.567	19	4	21.00	53/64	D8	7350464	

# APPLIX SPIRAL POINT TAPS

**UNION BUTTERFIELD**

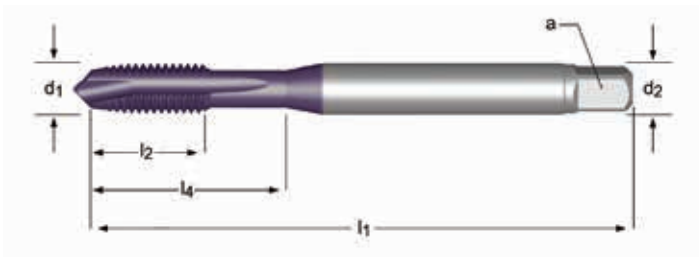
**APPLIX**

## MXP Multi-Application, Plug Chamfer

**1672AP** Designed for through hole tapping in a variety of materials with a hardness up to 36 Rc. The premium substrate and TiCN coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times, and longer tool life.

**1674** Coolant thru design allows higher tapping speeds and eliminates the problems associated with inadequate coolant in horizontal or deep hole applications.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 2.4 4.1 4.2 5.1 5.2 6.1 6.2  
6.3 7.1 7.2 7.3 7.4



1672AP		1674 Coolant Through	
UNC	UNF	UNC	UNF
DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI
2B	2B	2B	2B
HSS PM	HSS PM	HSS PM	HSS PM
No.4 - 1"		1/4 - 1"	

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Pack Qty	1672AP	1674
4		40	2.205	0.433	0.709	0.141	0.110	2	H2	1	46204859	<sup>1)</sup> —
6		32	2.205	0.472	0.787	0.141	0.110	2	H3	1	46204864	<sup>1)</sup> —
8		32	2.480	0.512	0.827	0.168	0.131	3	H3	1	46204869	<sup>1)</sup> —
	10	32	2.756	0.512	0.984	0.194	0.152	3	H3	1	46204852	<sup>1)</sup> —
10		24	2.756	0.591	0.984	0.194	0.152	3	H3	1	46204851	<sup>1)</sup> —
	1/4	28	3.150	0.669	1.181	0.255	0.191	3	H4	1	46204850	<sup>1)</sup> 1716512 <sup>1)</sup>
1/4		20	3.150	0.669	1.181	0.255	0.191	3	H5	1	46204849	<sup>1)</sup> 1716510 <sup>1)</sup>
	5/16	24	3.543	0.669	1.378	0.318	0.238	3	H4	1	46204861	<sup>1)</sup> —
5/16		18	3.543	0.787	1.378	0.318	0.238	3	H5	1	46204860	<sup>1)</sup> 1716514 <sup>1)</sup>
	3/8	24	3.937	0.709	1.535	0.381	0.286	3	H4	1	46204858	<sup>1)</sup> —
3/8		16	3.937	0.866	1.535	0.381	0.286	3	H5	1	46204857	<sup>1)</sup> 1716518 <sup>1)</sup>
	7/16	20	3.937	0.866		0.323	0.242	3	H5	1	46204866	<sup>2)</sup> —
7/16		14	3.937	0.866		0.323	0.242	3	H5	1	46204865	<sup>2)</sup> —
	1/2	20	3.937	0.866		0.367	0.275	3	H5	1	—	—
1/2		20	3.937	0.866		0.397	0.275	3	H5	1	46204848	<sup>2)</sup> —
	1/2	13	4.331	0.984		0.367	0.275	3	H5	1	46204847	<sup>2)</sup> 1716534 <sup>2)</sup>
	5/8	18	3.937	0.866		0.480	0.360	4	H5	1	46204863	<sup>2)</sup> —
5/8		11	4.331	1.063		0.480	0.360	4	H5	1	46204862	<sup>2)</sup> 1716538 <sup>2)</sup>
	3/4	16	4.331	0.984		0.590	0.442	4	H5	1	46204856	<sup>2)</sup> —
3/4		10	4.921	1.181		0.590	0.442	4	H5	1	46204855	<sup>2)</sup> —
3/4		10	4.921	1.181		0.590	0.442	4	H5	1	—	1716542 <sup>2)</sup>
7/8		9	5.512	1.260		0.697	0.523	4	H6	1	46204868	<sup>2)</sup> —
1"		8	6.299	1.417		0.800	0.600	4	H6	1	46204854	<sup>2)</sup> — <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

## Multi-Application, Plug Chamfer

**E025** Premium substrate for through hole tapping in tough or  
**E035** abrasive materials. Bronze oxide body and shank reduces  
 rust and corrosion. Bright finish flutes improve chip flow in  
 soft or non-ferrous materials.

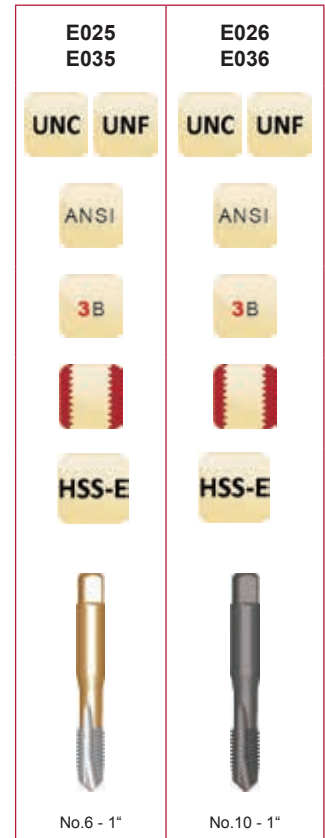
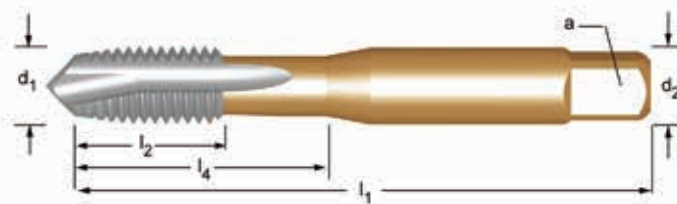
*E025 = UNC Sizes, E035 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1**  
**6.2 6.3 7.1 7.2 7.3 7.4 8.1**

**E026** Premium substrate with steam oxide surface treatment  
**E036** reduces wear and prevents chip welding in abrasive or  
 harder ferrous materials.

*E026 = UNC Sizes, E036 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4**



UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$a$ Inch	# of Flutes	Limits			$l_4$ Inch	Pack Qty	E025 E035	E026 E036
2		56	1.3/4	0.3140	0.1410	0.1100	2	H2	N50	1.80	0.3140	1	—	0583203 <sup>1)</sup>
4		40	1.7/8	0.6091	0.1410	0.1100	2	H2	N43	2.35	0.6091	1	—	0581254 <sup>1)</sup>
5		40	1.15/16	0.7404	0.1410	0.1100	2	H2	N38	2.65	0.7404	1	—	0581261 <sup>1)</sup>
	6	40	2"	0.2610	0.1410	0.1100	2	H2	N33	2.95	0.5938	1	0581957 <sup>1)</sup>	—
6		32	2"	0.2610	0.1410	0.1100	2	H2	N36	2.85	0.5938	1	0581070 <sup>1)</sup>	0581278 <sup>1)</sup>
	8	36	2.1/8	0.2484	0.1680	0.1310	2	H2	N29	3.50	0.6526	1	0581964	—
8		32	2.1/8	0.2484	0.1680	0.1310	2	H2	N29	3.50	0.6526	1	0581087 <sup>1)</sup>	0581285 <sup>1)</sup>
	10	32	2.3/8	0.4303	0.1940	0.1520	2	H2	N21	4.10	0.8434	1	0581971 <sup>1)</sup>	0582145 <sup>1)</sup>
10		24	2.3/8	0.4303	0.1940	0.1520	2	H3	N25	3.90	0.8434	1	0581094 <sup>1)</sup>	0581292 <sup>1)</sup>
	12	28	2.3/8	0.4173	0.2200	0.1650	2	H3	N14	4.70	0.8848	1	— <sup>1)</sup>	0582152 <sup>1)</sup>
12		24	2.3/8	0.4173	0.2200	0.1650	2	H3	N16	4.50	0.8848	1	0581100 <sup>1)</sup>	0581308 <sup>1)</sup>
	1/4	28	2.1/2	0.5075	0.2550	0.1910	2	H3	N3	5.50	1.0073	1	0581995 <sup>1)</sup>	0582169 <sup>1)</sup>
	1/4	28	2.1/2	0.5075	0.2550	0.1910	3	H3	N3	5.50	1.0073	1	0582008 <sup>1)</sup>	0582176 <sup>1)</sup>
1/4		20	2.1/2	0.5075	0.2550	0.1910	2	H3	N7	5.10	1.0073	1	0581117 <sup>1)</sup>	0581315 <sup>1)</sup>
1/4		20	2.1/2	0.5075	0.2550	0.1910	3	H3	N7	5.10	1.0073	1	0581124 <sup>1)</sup>	0581339 <sup>1)</sup>
1/4		20	2.1/2	0.5075	0.2550	0.1910	3	H11	N7	5.10	1.0073	1	—	0581322 <sup>1)3)</sup>
	5/16	24	2.23/32	0.5939	0.3180	0.2380	2	H3	I	6.90	1.1891	1	0582015 <sup>1)</sup>	0582183 <sup>1)</sup>
	5/16	24	2.23/32	0.5939	0.3180	0.2380	3	H3	I	6.90	1.1891	1	0582022 <sup>1)</sup>	0582190 <sup>1)</sup>
5/16		18	2.23/32	0.5939	0.3180	0.2380	2	H3	F	6.60	1.1891	1	0581131 <sup>1)</sup>	0581346 <sup>1)</sup>
5/16		18	2.23/32	0.5939	0.3180	0.2380	3	H3	F	6.60	1.1891	1	0581148 <sup>1)</sup>	0581360 <sup>1)</sup>
5/16		18	2.23/32	0.5939	0.3180	0.2380	3	H11	F	6.60	1.1891	1	—	0581353 <sup>1)3)</sup>
	3/8	24	2.15/16	0.6020	0.3810	0.2860	2	H3	Q	8.50	1.2915	1	0582039 <sup>1)</sup>	0582206 <sup>1)</sup>
	3/8	24	2.15/16	0.6020	0.3810	0.2860	3	H3	Q	8.50	1.2915	1	0582046 <sup>1)</sup>	—
3/8		16	2.15/16	0.6020	0.3810	0.2860	2	H3	5/16	8.00	1.2915	1	0581155 <sup>1)</sup>	0581377 <sup>1)</sup>
3/8		16	2.15/16	0.6020	0.3810	0.2860	3	H3	5/16	8.00	1.2915	1	0581162 <sup>1)</sup>	0581391 <sup>1)</sup>
3/8		16	2.15/16	0.6020	0.3810	0.2860	3	H11	5/16	8.00	1.2915	1	—	0581384 <sup>1)3)</sup>
	7/16	20	3.5/32	0.9055	0.3230	0.2420	3	H3	25/64	9.90	—	1	0582053 <sup>2)</sup>	0582220 <sup>2)</sup>
7/16		14	3.5/32	0.9055	0.3230	0.2420	3	H3	U	9.40	—	1	0581179 <sup>2)</sup>	0581407 <sup>2)</sup>
	1/2	20	3.3/8	0.9055	0.3670	0.2750	2	H3	29/64	11.50	—	1	0582060 <sup>2)</sup>	0582237 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

<sup>3)</sup> Oversize +.005", not 3B

# SPIRAL POINT TAPS



UNC	UNF	TPI	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> ∅ Inch	□ a Inch	# of Flutes	Limits			l <sub>4</sub> Inch	Pack Qty	E025 E035	E026 E036
	1/2	20	3.3/8	0.9055	0.3670	0.2750	3	H3	29/64	11.50	—	1	0582077	2) 0582244
1/2		13	3.3/8	0.9055	0.3670	0.2750	2	H3	27/64	10.80	—	1	0581186	2) 0581414
1/2		13	3.3/8	0.9055	0.3670	0.2750	3	H3	27/64	10.80	—	1	0581193	2) 0581438
1/2		13	3.3/8	0.9055	0.3670	0.2750	3	H11	27/64	10.80	—	1	—	0581421
	9/16	18	3.19/32	0.9843	0.4290	0.3220	3	H3	33/64	12.90	—	1	0582084	2) 0582251
9/16		12	3.19/32	0.9843	0.4290	0.3220	3	H3	31/64	12.20	—	1	0581209	2) 0581445
	5/8	18	3.13/16	0.9843	0.4800	0.3600	3	H3	37/64	14.50	—	1	0582091	2) 0582268
5/8		11	3.13/16	0.9843	0.4800	0.3600	3	H3	17/32	13.50	—	1	0581216	2) 0581469
5/8		11	3.13/16	0.9843	0.4800	0.3600	3	H11	17/32	13.50	—	1	—	0581452
	3/4	16	4.1/4	1.1614	0.5900	0.4420	3	H3	11/16	17.50	—	1	0582107	2) 0582275
3/4		10	4.1/4	1.1614	0.5900	0.4420	3	H4	21/32	16.50	—	1	0581223	2) 0581476
	7/8	14	4.11/16	1.1614	0.6970	0.5230	3	H4	13/16	20.40	—	1	0582114	2) 0582282
7/8		9	4.11/16	1.1614	0.6970	0.5230	3	H4	49/64	19.50	—	1	0581230	2) 0581483
	1"	12	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64	23.25	—	1	—	2) 0582299
	1"	14	5.1/8	1.3976	0.8000	0.6000	3	H4	59/64	23.50	—	1	0582138	2) 0582305
1"		8	5.1/8	1.3976	0.8000	0.6000	3	H4	7/8	22.25	—	1	0581247	2) 0581490

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

<sup>3)</sup> Oversize +.005", not 3B

## Multi-Application, Plug Chamfer

**EP20/EP30** Premium substrate for through hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

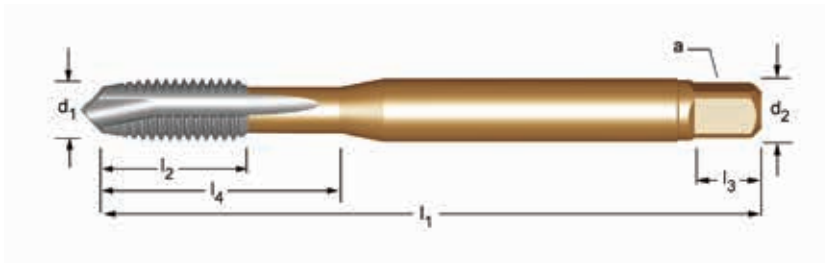
*EP20 = UNC Sizes, EP30 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1**  
**6.2 6.3 7.1 7.2 7.3 7.4 8.1**

**EP21/EP31** Premium substrate with steam oxide surface treatment reduces wear and chip welding in abrasive or harder ferrous materials.

*EP21 = UNC Sizes, EP31 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4**



UNC	UNF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	l <sub>4</sub> mm	Limits	Pack Qty	EP20/EP30	EP21/EP31	
4		40	2.845	56	9	3.5	2.7	6	3	2.35	18	H2	1	0138021 <sup>1)</sup>	0138175 <sup>1)</sup>
5		40	3.175	56	10	3.5	2.7	6	3	2.65	18	H2	1	0138038 <sup>1)</sup>	0138182 <sup>1)</sup>
6		32	3.505	56	11	4.0	3.0	6	3	2.85	20	H2	1	0138045 <sup>1)</sup>	0138199 <sup>1)</sup>
	8	36	4.166	63	12	4.5	3.4	8	3	3.5	21	H3	1	0138366 <sup>1)</sup>	0138472 <sup>1)</sup>
8		32	4.166	63	12	4.5	3.4	8	3	3.5	21	H3	1	0138052 <sup>1)</sup>	0138205 <sup>1)</sup>
	10	32	4.826	70	13	6.0	4.9	8	3	4.1	25	H3	1	0138373 <sup>1)</sup>	0138489 <sup>1)</sup>
10		24	4.826	70	13	6.0	4.9	8	3	3.9	25	H3	1	0138069 <sup>1)</sup>	0138212 <sup>1)</sup>
12		24	5.486	80	15	6.0	4.9	8	3	4.5	30	H3	1	0138076 <sup>1)</sup>	0138229 <sup>1)</sup>
	1/4	28	6.350	80	15	7.0	5.5	8	3	5.5	30	H4	1	0138380 <sup>1)</sup>	0138496 <sup>1)</sup>
1/4		20	6.350	80	15	7.0	5.5	8	3	5.1	30	H5	1	0138083 <sup>1)</sup>	0138274 <sup>1)</sup>
	5/16	24	7.938	90	18	8.0	6.2	9	3	6.9	35	H4	1	0138397 <sup>1)</sup>	0138502 <sup>1)</sup>
5/16		18	7.938	90	18	8.0	6.2	9	3	6.6	35	H5	1	0138090 <sup>1)</sup>	0138281 <sup>1)</sup>
	3/8	24	9.525	100	20	10.0	8.0	11	3	8.5	39	H4	1	0138403 <sup>1)</sup>	0138519 <sup>1)</sup>
3/8		16	9.525	100	20	10.0	8.0	11	3	8	39	H5	1	0138106 <sup>1)</sup>	0138298 <sup>1)</sup>
	7/16	20	11.112	100	20	8.0	6.2	9	3	9.9	-	H5	1	0138410 <sup>2)</sup>	0138526 <sup>2)</sup>
7/16		14	11.112	100	20	8.0	6.2	9	3	9.4	-	H5	1	0138113 <sup>2)</sup>	0138304 <sup>2)</sup>
	1/2	20	12.700	110	23	9.0	7.0	10	3	11.5	-	H5	1	0138427 <sup>2)</sup>	0138533 <sup>2)</sup>
1/2		13	12.700	110	23	9.0	7.0	10	3	10.8	-	H5	1	0138120 <sup>2)</sup>	0138311 <sup>2)</sup>
	5/8	18	15.875	110	25	12.0	9.0	12	3	14.5	-	H5	1	0138434 <sup>2)</sup>	0138540 <sup>2)</sup>
5/8		11	15.875	110	25	12.0	9.0	12	3	13.5	-	H5	1	0138137 <sup>2)</sup>	0138328 <sup>2)</sup>
	3/4	16	19.050	125	30	14.0	11.0	14	4	17.5	-	H5	1	0138441 <sup>2)</sup>	0138557 <sup>2)</sup>
3/4		10	19.050	125	30	14.0	11.0	14	4	16.5	-	H5	1	0138144 <sup>2)</sup>	0138335 <sup>2)</sup>
	7/8	14	22.225	140	34	18.0	14.5	17	4	20.4	-	H6	1	0138458 <sup>2)</sup>	0138564 <sup>2)</sup>
7/8		9	22.225	140	34	18.0	14.5	17	4	19.5	-	H6	1	0138151 <sup>2)</sup>	0138342 <sup>2)</sup>
	1"	12	25.400	160	38	18.0	14.5	17	4	23.25	-	H6	1	0138465 <sup>2)</sup>	0138571 <sup>2)</sup>
1"		8	25.400	160	38	18.0	14.5	17	4	22.25	-	H6	1	0138168 <sup>2)</sup>	0138359 <sup>2)</sup>

**Note: DIN shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

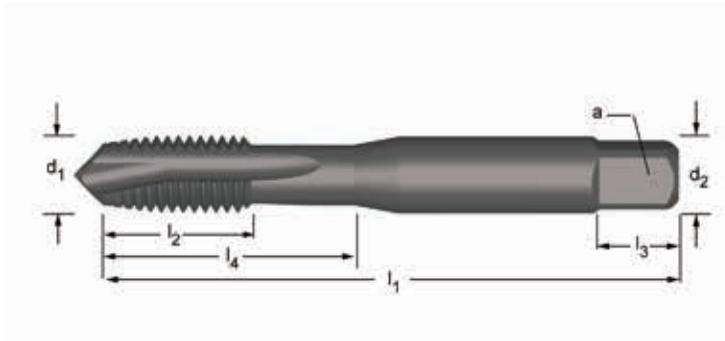
# SPIRAL POINT TAPS



## Multi-Application, PLUG CHAMFER

**E021** Premium substrate with steam oxide surface  
**E031** treatment reduces wear and prevents chip welding  
 in abrasive or harder ferrous materials.  
*E021 = UNC Sizes, E031 = UNF Sizes*

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



UNC	UNF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	a mm	l <sub>3</sub> mm	# of Flutes	↔	l <sub>4</sub> mm	Limits	Pack Qty	E021	E031
2		56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.5	H2	1	0010396 <sup>1)</sup>	—
4		40	2.845	48	14	3.15	2.50	5	3	2.35	14	H2	1	0569108 <sup>1)</sup>	—
5		40	3.175	48	12.5	3.15	2.50	5	3	2.65	12.5	H2	1	0010419 <sup>1)</sup>	—
6		32	3.505	50	16	3.55	2.80	5	3	2.85	16	H3	1	0569115 <sup>1)</sup>	—
	8	36	4.166	53	9.5	4.5	3.55	6	3	3.50	17	H3	1	—	0569641 <sup>1)</sup>
8		32	4.166	53	9.5	4.50	3.55	6	3	3.50	17	H3	1	0569122 <sup>1)</sup>	—
	10	32	4.826	58	11	5.0	4.00	7	3	4.10	20	H3	1	—	0569658 <sup>1)</sup>
10		24	4.826	58	11	5.00	4.00	7	3	3.90	20	H3	1	0569139 <sup>1)</sup>	—
12		24	5.486	62	12	5.60	4.50	7	3	4.50	21	H3	1	0569146 <sup>1)</sup>	—
	1/4	28	6.350	66	13	6.3	5.00	8	3	5.50	26	H4	1	—	0569665 <sup>1)</sup>
1/4		20	6.350	66	13	6.30	5.00	8	3	5.10	26	H5	1	0569153 <sup>1)</sup>	—
	5/16	24	7.938	72	16	8.0	6.30	9	3	6.90	29	H4	1	—	0569672 <sup>1)</sup>
5/16		18	7.938	72	16	8.00	6.30	9	3	6.60	29	H5	1	0569160 <sup>1)</sup>	—
	3/8	24	9.525	80	18	10.0	8.00	11	3	8.50	32	H4	1	—	0569689 <sup>1)</sup>
3/8		16	9.525	80	18	10.00	8.00	11	3	8.00	32	H5	1	0569177 <sup>1)</sup>	—
	7/16	20	11.112	85	19	8.0	6.30	9	3	9.90	-	H5	1	—	0569696 <sup>2)</sup>
7/16		14	11.112	85	19	8.00	6.30	9	3	9.40	-	H5	1	0569184 <sup>2)</sup>	—
	1/2	20	12.700	89	22	9.0	7.10	10	3	11.50	-	H5	1	—	0569702 <sup>2)</sup>
1/2		13	12.700	89	22	9.00	7.10	10	3	10.80	-	H5	1	0569191 <sup>2)</sup>	—
	9/16	18	14.288	95	24	11.2	9.00	12	3	12.90	-	H5	1	—	0569719 <sup>2)</sup>
	5/8	18	15.875	102	24	12.5	10.00	13	3	14.50	-	H5	1	—	0569726 <sup>2)</sup>
5/8		11	15.875	102	24	12.50	10.00	13	3	13.50	-	H5	1	0569207 <sup>2)</sup>	—
	3/4	16	19.050	112	29	14.0	11.20	14	4	17.50	-	H5	1	—	0569733 <sup>2)</sup>
3/4		10	19.050	112	29	14.00	11.20	14	4	16.50	-	H5	1	0569214 <sup>2)</sup>	—
	7/8	14	22.225	118	29	16.0	12.50	16	4	20.40	-	H6	1	—	0569740 <sup>2)</sup>
7/8		9	22.225	118	29	16.00	12.50	16	4	19.50	-	H6	1	0569221 <sup>2)</sup>	—
	1"	12	25.400	130	35	18.0	14.00	18	4	23.25	-	H6	1	—	0569757 <sup>2)</sup>
1"		8	25.400	130	35	18.00	14.00	18	4	22.25	-	H6	1	0569238 <sup>2)</sup>	—

**Note: ISO shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks



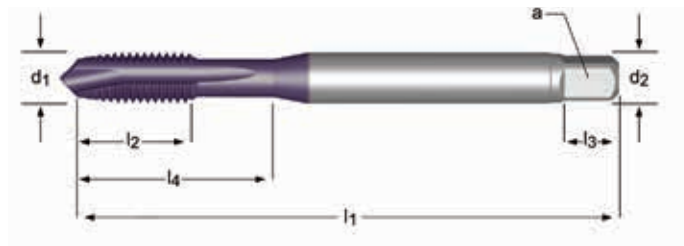
## MXP Multi-Application, Plug Chamfer, Metric



**1673AP** Designed for through hole tapping in a variety of materials with a hardness up to 36 Rc. The premium substrate and TiCN coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times, and longer tool life.

**1675** Coolant thru design allows higher tapping speeds and eliminates the problems associated with inadequate coolant in horizontal or deep hole applications.

- 1.1
- 1.2
- 1.3
- 1.4
- 1.5
- 2.1
- 2.2
- 4.1
- 4.2
- 5.1
- 5.2
- 6.1
- 6.2
- 6.3
  
- 7.1
- 7.2
- 7.3
- 7.4



1673AP		1675 Coolant Through	
M	MF	M	MF
DIN ANSI		DIN ANSI	
6H		6H	
HSS PM		HSS PM	
M4 - M24		M12 - M20	

M	MF	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub>	∇	# of	Limits	Pack Qty	1673AP	1675
		mm	mm	mm	Inch (Neck Length)	Inch Ø	a	Flutes				
4		0.70	63	13	21	0.168	0.131	3	D4	1	46204884 <sup>1)</sup>	—
5		0.80	70	15	25	0.194	0.152	3	D4	1	46204885 <sup>1)</sup>	—
6		1.00	80	17	30	0.255	0.191	3	D5	1	46204886 <sup>1)</sup>	—
	8	1.00	90	17	35	0.318	0.238	3	D5	1	46205008 <sup>1)</sup>	—
8		1.25	90	20	35	0.318	0.238	3	D5	1	46204887 <sup>1)</sup>	—
	10	1.25	100	16	39	0.381	0.286	3	D6	1	46204870 <sup>1)</sup>	—
10		1.50	100	22	39	0.381	0.286	3	D6	1	46204871 <sup>1)</sup>	—
	12	1.25	100	21		0.367	0.275	3	D6	1	46205009 <sup>2)</sup>	—
	12	1.50	100	22		0.367	0.275	3	D6	1	46204872 <sup>2)</sup>	—
12		1.75	110	24		0.367	0.275	3	D6	1	46204873 <sup>2)</sup>	1716722 <sup>2)</sup>
	14	1.50	100	22		0.429	0.322	4	D7	1	46204874 <sup>2)</sup>	—
14		2.00	110	26		0.429	0.322	4	D7	1	46204875 <sup>2)</sup>	—
	16	1.50	100	22		0.480	0.360	4	D7	1	46204876 <sup>2)</sup>	—
16		2.00	110	27		0.480	0.360	4	D7	1	46204877 <sup>2)</sup>	1716730 <sup>2)</sup>
	18	1.50	110	25		0.542	0.406	4	D7	1	46204878 <sup>2)</sup>	—
20		2.50	140	32		0.652	0.489	4	D7	1	46204881 <sup>2)</sup>	1716738 <sup>2)</sup>
	24	2.00	140	27		0.760	0.570	4	D8	1	46204882 <sup>2)</sup>	—
24		3.00	160	34		0.760	0.570	4	D8	1	46204883 <sup>2)</sup>	—

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# SPIRAL POINT TAPS



## Multi-Application, Plug Chamfer

**E005** Premium substrate for through hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

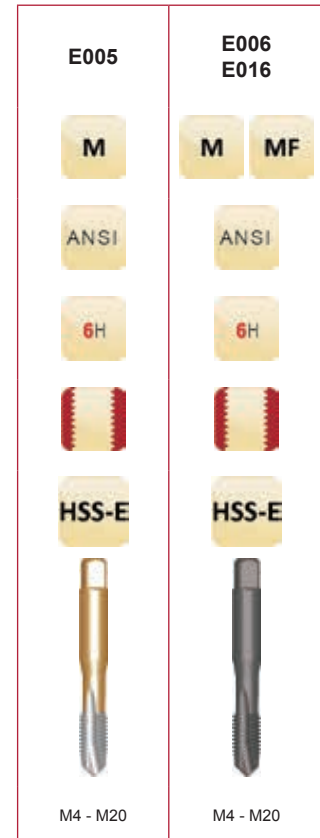
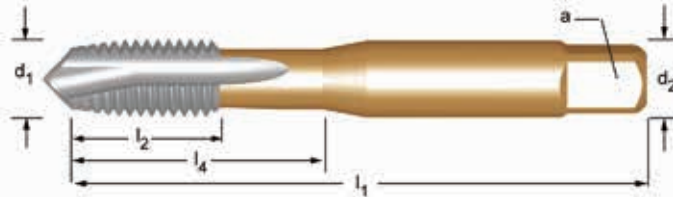
*E005 = Metric Coarse*

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1  
6.2 6.3 7.1 7.2 7.3 7.4 8.1

**E006/  
E016** Premium substrate with steam oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

*E006 = Metric Coarse, E016 = Metric Fine*

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



M	MF	P mm	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch	a Inch	# of Flutes	Flute Width	Flute Angle	l <sub>4</sub> Inch	Limits	Pack Qty	E005	E006 E016
4		0.70	2.1/8	0.2484	0.1680	0.1310	2	3.30	N30	0.6526	D4	1	0580301	0580462
4		0.70	2.1/8	0.2484	0.1680	0.1310	3	3.30	N30	0.6526	D4	1	0580318	0583180
5		0.80	2.3/8	0.4303	0.1940	0.1520	2	4.20	N19	0.8434	D4	1	0580325	0580479
5		0.80	2.3/8	0.4303	0.1940	0.1520	3	4.20	N19	0.8434	D4	1	0580332	0580486
6		1.00	2.1/2	0.5075	0.2550	0.1910	2	5.00	N9	1.0073	D5	1	0580349	0580493
6		1.00	2.1/2	0.5075	0.2550	0.1910	3	5.00	N9	1.0073	D5	1	0580356	0580509
	8	1.00	2.23/32	0.5939	0.3180	0.2380	3	7.00	J	1.1891	D5	1	—	0580950
8		1.25	2.23/32	0.5939	0.3180	0.2380	2	6.80	H	1.1891	D5	1	0580363	0580516
8		1.25	2.23/32	0.5939	0.3180	0.2380	3	6.80	H	1.1891	D5	1	0580370	0583197
	10	1.00	2.15/16	0.6020	0.3810	0.2860	3	9.00	T	1.2915	D6	1	—	0580967
10		1.50	2.15/16	0.6020	0.3810	0.2860	2	8.50	Q	1.2915	D6	1	0580387	0580523
10		1.50	2.15/16	0.6020	0.3810	0.2860	3	8.50	Q	1.2915	D6	1	0580394	0580530
12		1.75	3.3/8	0.9055	0.3670	0.2750	2	10.30	Y		D6	1	0580400	0580547
12		1.75	3.3/8	0.9055	0.3670	0.2750	3	10.30	Y		D6	1	0580417	0580554
	14	1.50	3.19/32	0.9843	0.4290	0.3220	3	12.50	31/64		D7	1	—	0580974
14		2.00	3.19/32	0.9843	0.4290	0.3220	3	12.00	15/32		D7	1	0580424	0580561
16		2.00	3.13/16	0.9843	0.4800	0.3600	3	14.00	35/64		D7	1	0580431	0580578
18		2.50	4.1/32	1.1614	0.5420	0.4060	3	15.50	39/64		D7	1	0580448	0580585
20		2.50	4.15/32	1.1614	0.6520	0.4890	3	17.50	11/16		D7	1	0580455	0580592

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

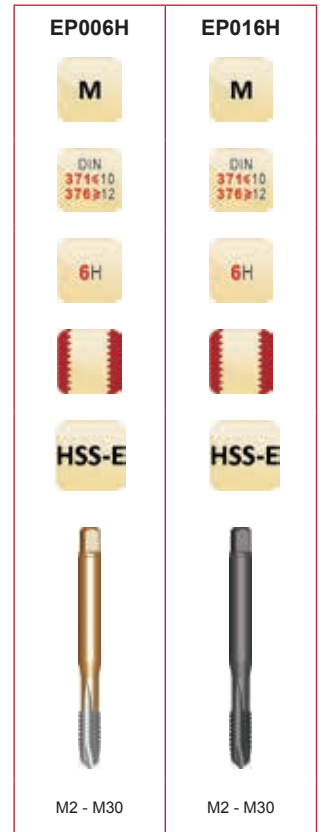
## Multi-Application, Plug Chamfer

**EP006H** Premium substrate for through hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1  
6.2 6.3 7.1 7.2 7.3 7.4 8.1

**EP016H** Premium substrate with steam oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



M	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	a mm	l <sub>3</sub> mm	# of Flutes	↔	l <sub>4</sub> mm	Limits	Pack Qty	EP006H	EP016H
2	0.40	50	6	2.8	2.1	5	2	1.6	9	D3	1	0137239 <sup>1)</sup>	0137253 <sup>1)</sup>
2.5	0.45	50	8	2.8	2.1	5	2	2.1	12.5	D3	1	0137246 <sup>1)</sup>	0137291 <sup>1)</sup>
3	0.50	56	10	2.2	1.8	4	3	2.5	18	D3	1	0135716 <sup>1)</sup>	0136126 <sup>1)</sup>
3	0.50	56	9	3.5	2.7	6	3	2.5	18	D3	1	0135709 <sup>1)</sup>	0136119 <sup>1)</sup>
3.5	0.60	56	11	4.0	3.0	6	3	2.9	20	D4	1	0135723 <sup>1)</sup>	0136133 <sup>1)</sup>
4	0.70	63	12	2.8	2.1	5	3	3.3	21	D4	1	0135747 <sup>1)</sup>	0136157 <sup>1)</sup>
4	0.70	63	12	4.5	3.4	6	3	3.3	21	D4	1	0135730 <sup>1)</sup>	0136140 <sup>1)</sup>
4.5	0.75	70	13	6.0	4.9	8	3	3.8	25	D4	1	0135754 <sup>1)</sup>	0136164 <sup>1)</sup>
5	0.80	70	13	3.5	2.7	6	3	4.2	25	D4	1	0135853 <sup>1)</sup>	0136188 <sup>1)</sup>
5	0.80	70	13	6.0	4.9	8	3	4.2	25	D4	1	0135846 <sup>1)</sup>	0136171 <sup>1)</sup>
6	1.00	80	15	4.5	3.4	6	3	5	30	D5	1	0135877 <sup>1)</sup>	0136201 <sup>1)</sup>
6	1.00	80	15	6.0	4.9	8	3	5	30	D5	1	0135860 <sup>1)</sup>	0136195 <sup>1)</sup>
7	1.00	80	15	7.0	5.5	8	3	6	30	D5	1	0135884 <sup>1)</sup>	0136218 <sup>1)</sup>
8	1.25	90	18	6.0	4.9	8	3	6.8	35	D5	1	0135907 <sup>1)</sup>	0136232 <sup>1)</sup>
8	1.25	90	18	8.0	6.2	9	3	6.8	35	D5	1	0135891 <sup>1)</sup>	0136225 <sup>1)</sup>
10	1.50	100	20	10.0	8.0	11	3	8.5	39	D6	1	0135914 <sup>1)</sup>	0136249 <sup>1)</sup>
10	1.50	100	20	7.0	5.5	8	3	8.5	-	D6	1	0135921 <sup>2)</sup>	0136256 <sup>2)</sup>
12	1.75	110	23	9.0	7.0	10	3	10.3	-	D6	1	0135938 <sup>2)</sup>	0136263 <sup>2)</sup>
14	2.00	110	25	11.0	9.0	12	3	12	-	D7	1	0135945 <sup>2)</sup>	0136317 <sup>2)</sup>
16	2.00	110	25	12.0	9.0	12	3	14	-	D7	1	0135952 <sup>2)</sup>	0136324 <sup>2)</sup>
18	2.50	125	30	14.0	11.0	14	4	15.5	-	D7	1	0135969 <sup>2)</sup>	0136331 <sup>2)</sup>
20	2.50	140	30	16.0	12.0	15	4	17.5	-	D7	1	0135976 <sup>2)</sup>	0136348 <sup>2)</sup>
22	2.50	140	34	18.0	14.5	17	4	19.5	-	D8	1	0135983 <sup>2)</sup>	0136355 <sup>2)</sup>
24	3.00	160	38	18.0	14.5	17	4	21	-	D8	1	0135990 <sup>2)</sup>	0136362 <sup>2)</sup>
27	3.00	160	38	20.0	16.0	19	4	24	-	D8	1	0136003 <sup>2)</sup>	0136379 <sup>2)</sup>
30	3.50	180	45	22.0	18.0	21	4	26.5	-	D9	1	0136010 <sup>2)</sup>	0136386 <sup>2)</sup>

**Note: DIN shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# SPIRAL POINT TAPS



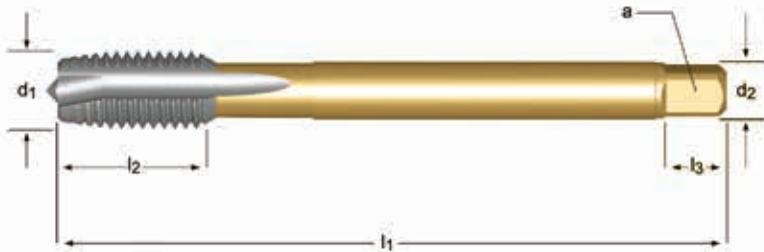
## Multi-Application, Plug Chamfer

**EP10** Premium substrate for through hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1  
6.2 6.3 7.1 7.2 7.3 7.4 8.1

**EP11** Premium substrate with steam oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	Limits	Pack Qty	EP10	EP11	
4	0.50	63	12	2.8	2.1	5	3	3.5	D4	1	0137345	0137642
5	0.50	70	13	3.5	2.7	6	3	4.5	D4	1	0137352	0137659
6	0.75	80	15	4.5	3.4	6	3	5.3	D5	1	0137369	0137666
8	0.75	80	15	6.0	4.9	8	3	7.3	D5	1	0137376	0137673
8	1.00	90	18	6.0	4.9	8	3	7	D5	1	0137383	0137680
10	0.75	90	18	7.0	5.5	8	3	9.3	D6	1	0137390	0137697
10	1.00	90	18	7.0	5.5	8	3	9	D6	1	0137406	0137703
10	1.25	100	20	7.0	5.5	8	3	8.8	D6	1	0137413	0137710
12	1.00	100	21	9.0	7.0	10	3	11	D6	1	0137420	0137727
12	1.25	100	21	9.0	7.0	10	3	10.8	D6	1	0137437	0137819
12	1.50	100	21	9.0	7.0	10	3	10.5	D6	1	0137444	0137826
14	1.00	100	21	11.0	9.0	12	3	13	D7	1	0137451	0137833
14	1.25	100	21	11.0	9.0	12	3	13	D7	1	0137468	0137840
14	1.50	100	21	11.0	9.0	12	3	12.5	D7	1	0137475	0137857
16	1.00	100	21	12.0	9.0	12	3	15	D7	1	0137482	0137864
16	1.50	100	21	12.0	9.0	12	3	14.5	D7	1	0137499	0137871
18	1.00	110	24	14.0	11.0	14	4	17	D7	1	0137505	0137888
18	1.50	110	24	14.0	11.0	14	4	16.5	D7	1	0137512	0137895
20	1.00	125	24	16.0	12.0	15	4	19	D7	1	0137529	0137901
20	1.50	125	24	16.0	12.0	15	4	18.5	D7	1	0137536	0137918
22	1.50	125	25	18.0	14.5	17	4	20.5	D8	1	0137543	0137925
24	1.50	140	28	18.0	14.5	17	4	22.5	D8	1	0137550	0137932
24	2.00	140	28	18.0	14.5	17	4	22	D8	1	0137567	0137949
25	1.50	140	28	18.0	14.5	17	4	23.5	D8	1	0137574	0137956
26	1.50	140	28	18.0	14.5	17	4	24.5	D8	1	0137581	0137963
27	1.50	140	28	20.0	16.0	19	4	25.5	D8	1	0137598	0137970
27	2.00	140	28	20.0	16.0	19	4	25	D8	1	0137604	0137987
28	1.50	140	28	20.0	16.0	19	4	26.5	D9	1	0137611	0137994
30	1.50	150	28	22.0	18.0	21	4	28.5	D9	1	0137628	0138007
30	2.00	150	28	22.0	18.0	21	4	28	D9	1	0137635	0138014

Note: DIN shank and square dimensions will necessitate metric holders

## Multi-Application, Plug Chamfer

**E000** Premium substrate for through hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

*E000 = Metric Coarse, E000TIN = TiN Coated*

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1  
6.2 6.3 7.1 7.2 7.3 7.4 8.1

**E000TIN** E000 with a TiN coat

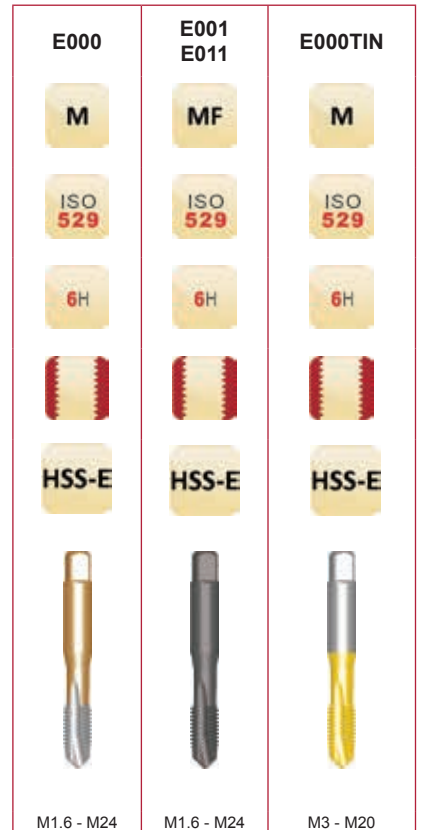
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
5.1 5.2 6.1 6.2 6.3 7.3 7.4 8.2

**E001** Premium substrate with steam oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

**E011**

*E001 = Metric Coarse, E011 = Metric Fine*

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4




M	MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	a mm	l <sub>3</sub> mm	# of Flutes	l <sub>4</sub> mm	Limits	Pack Qty	Series			
												E000	E001 E011	E000TIN	
1.6		0.35	41	7	2.50	2.00	4	2	1.25	7	D3	1	0168769	<sup>1)</sup> 0168790	—
2		0.40	41	8	2.50	2.00	4	2	1.6	8	D3	1	0168776	<sup>1)</sup> 0168806	—
2.5		0.45	44.5	9.5	2.80	2.24	5	2	2.05	9.5	D3	1	0168783	<sup>1)</sup> 0168813	—
3		0.50	48	15	3.15	2.50	5	3	2.5	15	D3	1	0567586	<sup>1)</sup> 0567722	<sup>1)</sup> 46196635
3.5		0.60	50	16	3.55	2.80	5	3	2.9	16	D4	1	0567593	<sup>1)</sup> 0567739	—
	4	0.50	53	17	4.0	3.15	6	3	3.5	17	D4	1	—	0568385	—
4		0.70	53	17	4.00	3.15	6	3	3.3	17	D4	1	0567609	<sup>1)</sup> 0567746	<sup>1)</sup> 46196636
	5	0.50	58	11	5.0	4.00	7	3	4.5	22	D4	1	—	0568392	—
5		0.80	58	11	5.00	4.00	7	3	4.2	22	D4	1	0567616	<sup>1)</sup> 0567753	<sup>1)</sup> 46196637
	6	0.50	66	13	6.3	5.00	8	3	5.5	26	D5	1	—	0568408	—
	6	0.75	66	13	6.3	5.00	8	3	5.3	26	D5	1	—	0568415	—
6		1.00	66	13	6.30	5.00	8	3	5.0	26	D5	1	0567623	<sup>1)</sup> 0567760	<sup>1)</sup> 46196638
	8	0.75	72	16	8.0	6.30	9	3	7.3	29	D5	1	—	0568422	—
	8	1.00	72	16	8.0	6.30	9	3	7.0	29	D5	1	—	0568439	—
8		1.25	72	16	8.00	6.30	9	3	6.8	29	D5	1	0567630	<sup>1)</sup> 0567777	<sup>1)</sup> 46196639
	10	1.00	80	18	10.0	8.00	11	3	9.0	34	D6	1	—	0568446	—
	10	1.25	80	18	10.0	8.00	11	3	8.8	34	D6	1	—	0568453	—
10		1.50	80	18	10.00	8.00	11	3	8.5	34	D6	1	0567647	<sup>1)</sup> 0567784	<sup>1)</sup> 46196690
	12	1.00	89	22	9.0	7.10	10	3	11.0	-	D6	1	—	0568460	<sup>2)</sup> —
	12	1.25	89	22	9.0	7.10	10	3	10.8	-	D6	1	—	0568477	<sup>2)</sup> —
	12	1.50	89	22	9.0	7.10	10	3	10.5	-	D6	1	—	0568484	<sup>2)</sup> —
12		1.75	89	22	9.00	7.10	10	3	10.3	-	D6	1	0567654	<sup>2)</sup> 0567791	<sup>2)</sup> 46196691
	14	1.00	95	24	11.2	9.00	12	3	13.0	-	D7	1	—	0568491	<sup>2)</sup> —
	14	1.25	95	24	11.2	9.00	12	3	12.8	-	D7	1	—	0568507	<sup>2)</sup> —
	14	1.50	95	24	11.2	9.00	12	3	12.5	-	D7	1	—	0568514	<sup>2)</sup> —
14		2.00	95	24	11.20	9.00	12	3	12.0	-	D7	1	0567661	<sup>2)</sup> 0567807	<sup>2)</sup> —
	16	1.00	102	24	12.5	10.00	13	3	15.0	-	D7	1	—	0568521	<sup>2)</sup> —
	16	1.50	102	24	12.5	10.00	13	3	14.5	-	D7	1	—	0568538	<sup>2)</sup> —
16		2.00	102	24	12.50	10.00	13	3	14.0	-	D7	1	0567678	<sup>2)</sup> 0567814	<sup>2)</sup> 46196692

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

# SPIRAL POINT TAPS



M	MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> ∅ mm	∠ a mm	l <sub>3</sub> mm	# of Flutes		l <sub>4</sub> mm	Limits	Pack Qty	E000	E001 E011	E000TIN
	18	1.00	112	29	14.0	11.20	14	4	↔	17.0	- D7	1	—	0568545 <sup>2)</sup>	—
	18	1.50	112	29	14.0	11.20	14	4	↔	16.5	- D7	1	—	0568552 <sup>2)</sup>	—
18		2.50	112	29	14.00	11.20	14	4	↔	15.5	- D7	1	0567685 <sup>2)</sup>	0567821 <sup>2)</sup>	—
	20	1.00	112	29	14.0	11.20	14	4	↔	19.0	- D7	1	—	0568569 <sup>2)</sup>	—
	20	1.50	112	29	14.0	11.20	14	4	↔	18.5	- D7	1	—	0568576 <sup>2)</sup>	—
	20	2.00	112	29	14.0	11.20	14	4	↔	18.0	- D7	1	—	0568583 <sup>2)</sup>	—
20		2.50	112	29	14.00	11.20	14	4	↔	17.5	- D7	1	0567692 <sup>2)</sup>	—	46196693 <sup>2)</sup>
	22	1.50	118	29	16.0	12.50	16	4	↔	20.5	- D8	1	—	0568590 <sup>2)</sup>	—
22		2.50	118	29	16.00	12.50	16	4	↔	19.5	- D8	1	0567708 <sup>2)</sup>	0567845 <sup>2)</sup>	—
	24	1.50	130	35	18.0	14.00	18	4	↔	22.5	- D8	1	—	0568606 <sup>2)</sup>	—
	24	2.00	130	35	18.0	14.00	18	4	↔	22.0	- D8	1	—	0568613 <sup>2)</sup>	—
24		3.00	130	35	18.00	14.00	18	4	↔	21.0	- D8	1	0567715 <sup>2)</sup>	0567852 <sup>2)</sup>	—

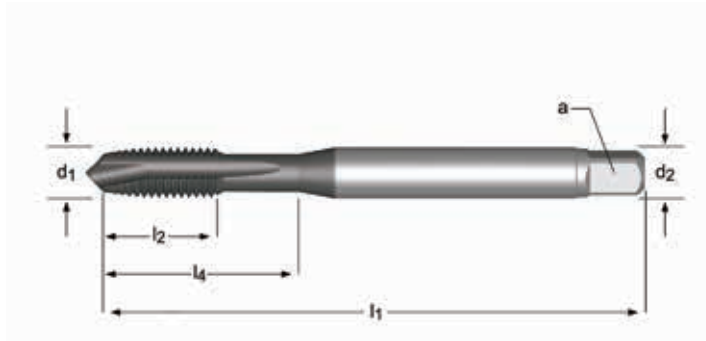
<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

## HMD Hard Materials / Cast Iron, Plug Chamfer

**1629AP** Designed for through hole tapping materials with a hardness of >38 Rc. Premium substrate provides superior abrasion resistance and edge strength. TiAlN-Top coating lowers the coefficient of friction, improves thread quality, affords higher operating speeds, and longer tool life.

**1.5 1.6 2.4 3.1 3.2 3.3 3.4 4.3 5.3 6.4**



**1629AP**

**UNF UNC**

**DIN ANSI**

**2B**

**HSS PM**

No.4 - 1"

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Pack Qty	1629AP
4		40	2.205	0.472	0.709	0.141	0.110	2	H2	1	46204796 <sup>1)</sup>
6		32	2.205	0.472	0.787	0.141	0.110	3	H3	1	46204801 <sup>1)</sup>
8		32	2.480	0.512	0.827	0.168	0.131	3	H3	1	46204805 <sup>1)</sup>
	10	32	2.756	0.512	0.984	0.194	0.152	3	H3	1	46204759 <sup>1)</sup>
10		24	2.756	0.591	0.984	0.194	0.152	3	H3	1	46204758 <sup>1)</sup>
	1/4	28	3.150	0.669	1.181	0.255	0.191	3	H4	1	46204757 <sup>1)</sup>
1/4		20	3.150	0.669	1.181	0.255	0.191	3	H5	1	46204756 <sup>1)</sup>
	5/16	24	3.543	0.669	1.378	0.318	0.238	3	H4	1	46204798 <sup>1)</sup>
5/16		18	3.543	0.787	1.378	0.318	0.238	3	H5	1	46204797 <sup>1)</sup>
	3/8	24	3.937	0.709	1.535	0.381	0.286	3	H4	1	46204795 <sup>1)</sup>
3/8		16	3.937	0.866	1.535	0.381	0.286	3	H5	1	46204794 <sup>1)</sup>
	1/2	20	3.937	0.866		0.367	0.275	3	H5	1	46204755 <sup>1)</sup>
1/2		13	4.331	0.984		0.367	0.275	3	H5	1	46204754 <sup>2)</sup>
	5/8	18	3.937	0.866		0.480	0.360	3	H5	1	46204800 <sup>2)</sup>
5/8		11	4.331	1.063		0.480	0.360	3	H5	1	46204799 <sup>2)</sup>
3/4		10	4.921	1.181		0.590	0.442	3	H5	1	46204792 <sup>2)</sup>
7/8		9	5.512	1.260		0.697	0.523	3	H6	1	46204804 <sup>2)</sup>
1"		8	6.299	1.417		0.800	0.600	3	H6	1	46204791 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

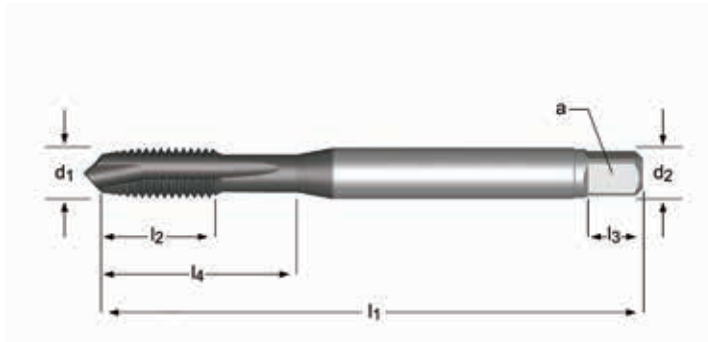
<sup>2)</sup> Reduced Shanks

# SPIRAL POINT TAPS

## HMD Hard Materials / Cast Iron, Plug Chamfer

**1659AP** Designed for through hole tapping materials with a hardness of >38 Rc. Premium substrate provides superior abrasion resistance and edge strength. TiAlN-Top coating lowers the coefficient of friction, improves thread quality, affords higher operating speeds, and longer tool life.

1.5 1.6 2.4 3.1 3.2 3.3 3.4 4.3 5.3 6.4



1659AP(MF)

M MF

DIN  
ANSI

6H



HSS  
PM



M3 - M12

M	P mm	$l_1$ mm	$l_2$ mm	$l_4$ Inch (Neck Length)	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Pack Qty	1659AP
3	0.50	56	11	18	0.141	0.110	3	D3	1	46204832
4	0.70	63	13	21	0.168	0.131	3	D4	1	46204833 <sup>1)</sup>
5	0.80	70	15	25	0.194	0.152	3	D4	1	46204834 <sup>1)</sup>
6	1.00	80	17	30	0.255	0.191	3	D5	1	46204835 <sup>1)</sup>
8	1.25	90	20	35	0.318	0.238	3	D5	1	46204837 <sup>1)</sup>
10	1.50	100	22	39	0.381	0.286	3	D6	1	46204829 <sup>1)</sup>
12	1.75	110	24		0.367	0.275	3	D6	1	46204831 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

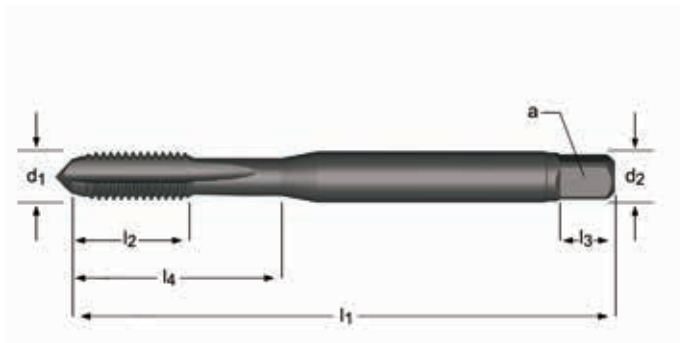


## For Cast Iron, Plug Chamfer

**E201** Designed for through or blind hole tapping with a specific geometry for cast iron and those materials producing broken, powdery chips. Also ideal for non-metallics, cast brass, and other brass materials. Nitride and steam oxide coating reduces wear and chip welding in abrasive materials.

**E252**

3.1 3.2 3.3 3.4 6.2 6.4 7.4 8.2



E201	E252
M	M
DIN 371	DIN 376
6HX	6HX
HSS PM	HSS PM
M3 - M10	M8 - M24

M	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> ∅ mm	□ a mm	l <sub>3</sub> mm	# of Flutes	l <sub>4</sub> mm	Limits	Pack Qty	E201	E252	
3	0.50	56	9	3.5	2.7	6	3	2.5	18	D3	1	0165607 <sup>1)</sup>	—
4	0.70	63	12	4.5	3.4	6	4	3.3	21	D4	1	0085196 <sup>1)</sup>	—
5	0.80	70	13	6.0	4.9	8	4	4.2	25	D4	1	0085202 <sup>1)</sup>	—
6	1.00	80	15	6.0	4.9	8	4	5.0	30	D5	1	0085219 <sup>1)</sup>	—
8	1.25	90	18	6.0	4.9	8	4	6.8		D5	1	—	0087343 <sup>1)</sup>
8	1.25	90	18	8.0	6.2	9	4	6.8	35	D5	1	0085226 <sup>1)</sup>	—
10	1.50	100	20	10.0	8.0	11	4	8.5	39	D6	1	0085189 <sup>1)</sup>	—
10	1.50	100	20	7.0	5.5	8	4	8.5		D6	1	—	0087268 <sup>2)</sup>
12	1.75	110	23	9.0	7.0	10	4	10.3		D6	1	—	0087275 <sup>2)</sup>
14	2.00	110	25	11.0	9.0	12	4	12.0		D7	1	—	0087282 <sup>2)</sup>
16	2.00	110	25	12.0	9.0	12	4	14.0		D7	1	—	0087299 <sup>2)</sup>
18	2.50	125	30	14.0	11.0	14	4	15.5		D7	1	—	0087305 <sup>2)</sup>
20	2.50	140	30	16.0	12.0	15	4	17.5		D7	1	—	0087312 <sup>2)</sup>
22	2.50	140	34	18.0	14.5	17	4	19.5		D8	1	—	0087329 <sup>2)</sup>
24	3.00	160	38	18.0	14.5	17	4	21.0		D8	1	—	0087336 <sup>2)</sup>

**Note:** DIN shank and square dimensions will necessitate metric holders

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# SPIRAL POINT TAPS

## DDX, High Hook, Plug Chamfer

**1985** Type DDX taps feature a special O.D. and P.D. relief and increased back taper. Intended for use in through hole applications where a free cutting action is desirable. Designed to produce a class 2B fit. Sizes No.4 - 3/8" are 'necked' to allow for use in deep hole applications. Steam oxide reduces wear and prevents chip welding when through hole tapping in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 4.1 4.2 4.3 5.1 5.2 5.3



UNC	UNF	TPI	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch	□ a Inch	l <sub>3</sub> Inch	# of Flutes	l <sub>4</sub> Inch	Pack Qty	1985
	4	48	1.7/8	9/16	0.1410	0.1100	3/16	2	0.69	1	1013038 <sup>1)</sup>
4		40	1.7/8	9/16	0.1410	0.1100	3/16	2	0.69	1	1013037 <sup>1)</sup>
	5	44	1.15/16	5/8	0.1410	0.1100	3/16	2	0.75	1	1013040 <sup>1)</sup>
5		40	1.15/16	5/8	0.1410	0.1100	3/16	2	0.75	1	1013039 <sup>1)</sup>
	6	40	2"	11/16	0.1410	0.1100	3/16	2	0.78	1	1013042 <sup>1)</sup>
6		32	2"	11/16	0.1410	0.1100	3/16	2	0.78	1	1013041 <sup>1)</sup>
	8	36	2.1/8	3/4	0.1680	0.1310	1/4	2	0.81	1	1013044 <sup>1)</sup>
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	0.81	1	1013043 <sup>1)</sup>
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	0.94	1	1013046 <sup>1)</sup>
10		24	2.3/8	7/8	0.1940	0.1520	1/4	2	0.94	1	1013045 <sup>1)</sup>
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	2	1.19	1	1013050 <sup>1)</sup>
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	2	1.19	1	1013049 <sup>1)</sup>
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	1.31	1	1013052 <sup>1)</sup>
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	3	1.31	1	1013051 <sup>1)</sup>
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	1.44	1	1013054 <sup>1)</sup>
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	3	1.44	1	1013053 <sup>1)</sup>
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	3	—	1	1013056 <sup>2)</sup>
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	3	—	1	1013055 <sup>2)</sup>
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	—	1	1013058 <sup>2)</sup>
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	3	—	1	1013057 <sup>2)</sup>
	9/16	18	3.19/32	1.21/32	0.4290	0.3220	1/2	3	—	1	1013060 <sup>2)</sup>
9/16		12	3.19/32	1.21/32	0.4290	0.3220	1/2	3	—	1	1013059 <sup>2)</sup>
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	3	—	1	1013062 <sup>2)</sup>
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	3	—	1	1013061 <sup>2)</sup>
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	3	—	1	1013066 <sup>2)</sup>
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	3	—	1	1013065 <sup>2)</sup>
	7/8	14	4.11/16	2.7/32	0.6970	0.5230	3/4	4	—	1	1013068 <sup>2)</sup>
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	—	1	1013067 <sup>2)</sup>
1"		8	5.1/8	2.1/2	0.8000	0.6000	13/16	4	—	1	1013069 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

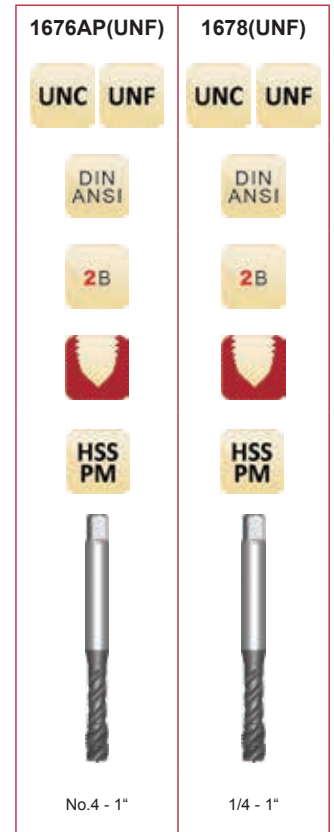
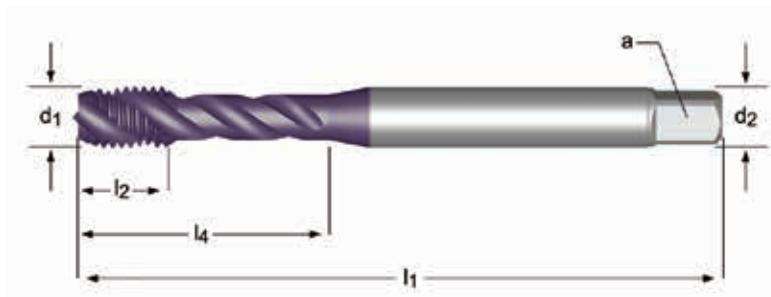
<sup>2)</sup> Reduced Shanks

## MXL Multi-Application, Semi-Bottoming

**1676AP** Designed for blind hole tapping in a variety of materials with a hardness up to 36 Rc. The premium substrate and TiCN coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times, and longer tool life.

**1678** Coolant thru design allows higher tapping speeds and eliminates the problems associated with inadequate coolant in horizontal or deep hole applications.

**1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 4.2 5.1 5.2 6.1 6.2 6.3**  
**7.1 7.2 7.3 7.4**



UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Pack Qty	1676AP	1678
4		40	2.205	0.236	0.709	0.141	0.110	3	H2	1	46204902 <sup>1)</sup>	—
6		32	2.205	0.236	0.787	0.141	0.110	3	H2	1	46204907 <sup>1)</sup>	—
8		32	2.480	0.236	0.827	0.168	0.131	3	H3	1	46204912 <sup>1)</sup>	—
	10	32	2.756	0.354	0.984	0.194	0.152	3	H3	1	46204895 <sup>1)</sup>	—
10		24	2.756	0.354	0.984	0.194	0.152	3	H3	1	46204894 <sup>1)</sup>	—
	1/4	28	3.150	0.433	1.181	0.255	0.191	3	H4	1	46204893 <sup>1)</sup>	1717512 <sup>1)</sup>
1/4		20	3.150	0.433	1.181	0.255	0.191	3	H5	1	46204892 <sup>1)</sup>	1717510 <sup>1)</sup>
	5/16	24	3.543	0.472	1.378	0.318	0.238	3	H4	1	46204904 <sup>1)</sup>	—
5/16		18	3.543	0.472	1.378	0.318	0.238	3	H5	1	46204903 <sup>1)</sup>	1717514 <sup>1)</sup>
	3/8	24	3.937	0.551	1.535	0.381	0.286	3	H4	1	46204901 <sup>1)</sup>	—
3/8		16	3.937	0.551	1.535	0.381	0.286	3	H5	1	46204900 <sup>1)</sup>	1717518 <sup>1)</sup>
	7/16	20	3.937	0.591		0.323	0.242	3	H5	1	46204909 <sup>2)</sup>	1717532 <sup>2)</sup>
7/16		14	3.937	0.591		0.323	0.242	3	H5	1	46204908 <sup>2)</sup>	1717530 <sup>2)</sup>
	1/2	20	3.937	0.630		0.367	0.275	3	H5	1	46204891 <sup>2)</sup>	—
1/2		13	4.331	0.630		0.367	0.275	3	H5	1	46204890 <sup>2)</sup>	1717534 <sup>2)</sup>
	5/8	18	3.937	0.745		0.480	0.360	3	H5	1	46204906 <sup>2)</sup>	—
5/8		11	4.331	0.745		0.480	0.360	3	H5	1	46204905 <sup>2)</sup>	1717538 <sup>2)</sup>
	3/4	16	4.331	0.820		0.590	0.442	3	H5	1	46204899 <sup>2)</sup>	—
3/4		10	4.921	0.820		0.590	0.442	3	H5	1	46204898 <sup>2)</sup>	1717542 <sup>2)</sup>
	7/8	14	4.921	0.910		0.697	0.523	4	H6	1	46204910 <sup>2)</sup>	—
7/8		9	5.512	0.910		0.697	0.523	4	H6	1	46204911 <sup>2)</sup>	46204932 <sup>2)</sup>
1"		8	6.299	1.025		0.800	0.600	4	H6	1	46204897 <sup>2)</sup>	1717546 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

# SPIRAL FLUTE TAPS (45°)



## Multi-Application, Semi-Bottoming

**E027  
E037**

Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

*E027 = UNC Sizes, E037 = UNF Sizes*

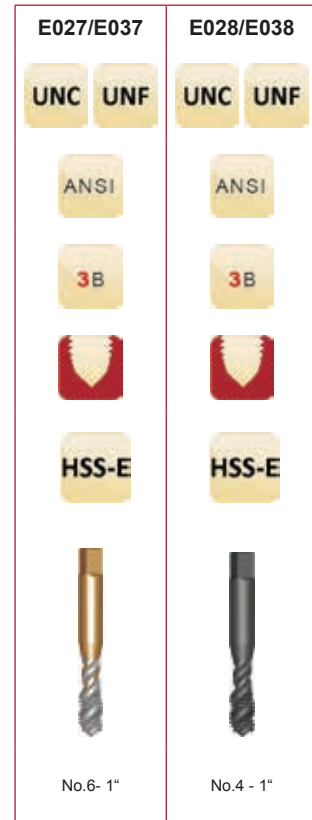
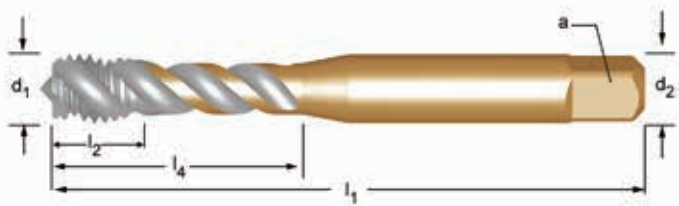
**1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 6.1 6.2 6.3 7.1 7.2 7.3**  
**7.4 8.1**

**E028  
E038**

Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

*E028 = UNC Sizes, E038 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3**



UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits			$l_4$ Inch	Pack Qty	E027 E037	E028 E038
4		40	1.7/8	0.6091	0.1410	0.1100	3	H2	N43	2.35	0.6091	1	—	0581643 <sup>1)</sup>
5		40	1.15/16	0.7404	0.1410	0.1100	3	H2	N38	2.65	0.7404	1	—	0581650 <sup>1)</sup>
6		32	2"	0.2610	0.1410	0.1100	3	H2	N36	2.85	0.5938	1	0581506	0581667 <sup>1)</sup>
8		32	2.1/8	0.2484	0.1680	0.1310	3	H2	N29	3.50	0.6526	1	0581513	0581674 <sup>1)</sup>
	10	32	2.3/8	0.2650	0.1940	0.1520	3	H2	N21	4.10	0.8434	1	0582312	0582435 <sup>1)</sup>
10		24	2.3/8	0.2650	0.1940	0.1520	3	H3	N25	3.90	0.8434	1	0581520	0581681 <sup>1)</sup>
12		24	2.3/8	0.2520	0.2200	0.1650	3	H3	N16	4.50	0.8848	1	0581537	0581698 <sup>1)</sup>
	1/4	28	2.1/2	0.3937	0.2550	0.1910	3	H3	N3	5.50	1.0993	1	0582329	0582442 <sup>1)</sup>
1/4		20	2.1/2	0.3937	0.2550	0.1910	3	H3	N7	5.10	1.0993	1	0581544	0581704 <sup>1)</sup>
	5/16	24	2.23/32	0.4567	0.3180	0.2380	3	H3	I	6.90	1.3094	1	0582336	0582459 <sup>1)</sup>
5/16		18	2.23/32	0.4567	0.3180	0.2380	3	H3	F	6.60	1.3094	1	0581551	0581711 <sup>1)</sup>
	3/8	24	2.15/16	0.5315	0.3810	0.2860	3	H3	Q	8.50	1.4415	1	0582343	0582466 <sup>1)</sup>
3/8		16	2.15/16	0.5315	0.3810	0.2860	3	H3	5/16	8.00	1.4415	1	0581568	0581728 <sup>1)</sup>
3/8		16	2.15/16	0.5315	0.3810	0.2860	3	H5	5/16	8.00	1.4415	1	—	0581735 <sup>1)3)</sup>
	7/16	20	3.5/32	0.6299	0.3230	0.2420	3	H3	25/64	9.90	-	1	0582350	0582473 <sup>2)</sup>
7/16		14	3.5/32	0.6299	0.3230	0.2420	3	H3	U	9.40	-	1	0581575	0581742 <sup>2)</sup>
	1/2	20	3.3/8	0.6890	0.3670	0.2750	3	H3	29/64	11.50	-	1	0582367	0582480 <sup>2)</sup>
1/2		13	3.3/8	0.6890	0.3670	0.2750	3	H3	27/64	10.80	-	1	0581582	0581759 <sup>2)</sup>
	9/16	18	3.19/32	0.7087	0.4290	0.3220	3	H3	33/64	12.90	-	1	0582374	0582497 <sup>2)</sup>
9/16		12	3.19/32	0.7087	0.4290	0.3220	3	H3	31/64	12.20	-	1	0581599	0581766 <sup>2)</sup>
	5/8	18	3.13/16	0.7087	0.4800	0.3600	3	H3	37/64	14.50	-	1	0582381	0582503 <sup>2)</sup>
5/8		11	3.13/16	0.7087	0.4800	0.3600	3	H3	17/32	13.50	-	1	0581605	0581773 <sup>2)</sup>
	3/4	16	4.1/4	0.8858	0.5900	0.4420	3	H3	11/16	17.50	-	1	0582398	0582510 <sup>2)</sup>
3/4		10	4.1/4	0.8858	0.5900	0.4420	3	H4	21/32	16.50	-	1	0581612	0581780 <sup>2)</sup>
	7/8	14	4.11/16	0.9843	0.6970	0.5230	3	H4	13/16	20.40	-	1	0582404	0582527 <sup>2)</sup>
7/8		9	4.11/16	0.9843	0.6970	0.5230	3	H4	49/64	19.50	-	1	0581629	0581797 <sup>2)</sup>
	1"	14	5.1/8	1.1811	0.8000	0.6000	3	H4	59/64	23.50	-	1	0582428	0582541 <sup>2)</sup>
1"		8	5.1/8	1.1811	0.8000	0.6000	3	H4	7/8	22.25	-	1	0581636	0581803 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

<sup>3)</sup> Class of fit: 2B

## Multi-Application, Semi-Bottoming

**EX20** Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

**EX30**

*EX20 = UNC Sizes, EX30 = UNF Sizes*

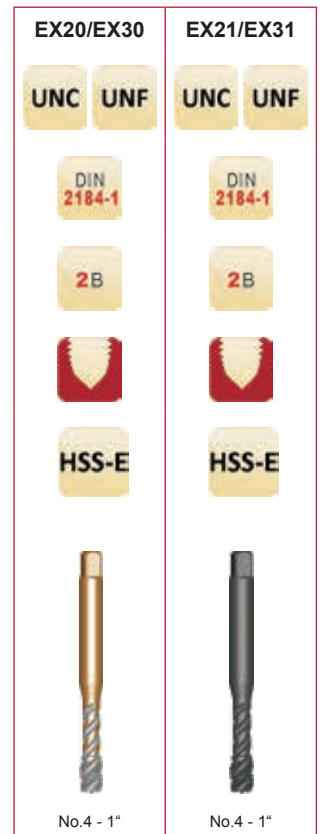
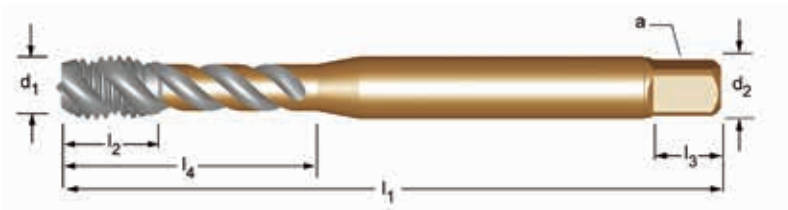
**1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4**

**EX21** Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

**EX31**

*EX21 = UNC Sizes, EX31 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3**



UNC	UNF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	↔	Limits	l <sub>4</sub> mm	Pack Qty	EX20 EX30	EX21 EX31
4		40	2.845	56	6	3.5	2.7	6	3	2.35	H2	18	1	0150269 <sup>1)</sup>	0150412 <sup>1)</sup>
5		40	3.175	56	6	3.5	2.7	6	3	2.65	H2	18	1	0150276 <sup>1)</sup>	0150429 <sup>1)</sup>
6		32	3.505	56	7	4.0	3.0	6	3	2.85	H2	20	1	0150283 <sup>1)</sup>	0150436 <sup>1)</sup>
	8	36	4.166	63	7	4.5	3.4	8	3	3.5	H3	21	1	0168325 <sup>1)</sup>	0168431 <sup>1)</sup>
8		32	4.166	63	7	4.5	3.4	8	3	3.5	H3	21	1	0150290 <sup>1)</sup>	0150443 <sup>1)</sup>
	10	32	4.826	70	8	6.0	4.9	8	3	4.1	H3	25	1	0168332 <sup>1)</sup>	0168448 <sup>1)</sup>
10		24	4.826	70	8	6.0	4.9	8	3	3.9	H3	25	1	0150306 <sup>1)</sup>	0150450 <sup>1)</sup>
12		24	5.486	80	10	6.0	4.9	8	3	4.5	H3	30	1	0150313 <sup>1)</sup>	0150467 <sup>1)</sup>
	1/4	28	6.350	80	10	7.0	5.5	8	3	5.5	H4	30	1	0168349 <sup>1)</sup>	0168455 <sup>1)</sup>
1/4		20	6.350	80	10	7.0	5.5	8	3	5.1	H5	30	1	0150320 <sup>1)</sup>	0150474 <sup>1)</sup>
	5/16	24	7.938	90	12	8.0	6.2	9	3	6.9	H4	35	1	0168356 <sup>1)</sup>	0168462 <sup>1)</sup>
5/16		18	7.938	90	12	8.0	6.2	9	3	6.6	H5	35	1	0150337 <sup>1)</sup>	0150627 <sup>1)</sup>
	3/8	24	9.525	100	15	10.0	8.0	11	3	8.5	H4	39	1	0168363 <sup>1)</sup>	0168479 <sup>1)</sup>
3/8		16	9.525	100	15	10.0	8.0	11	3	8	H5	39	1	0150344 <sup>1)</sup>	0151945 <sup>1)</sup>
	7/16	20	11.112	100	15	8.0	6.2	9	3	9.9	H5	-	1	0168370 <sup>2)</sup>	0168486 <sup>2)</sup>
7/16		14	11.112	100	15	8.0	6.2	9	3	9.4	H5	-	1	0150351 <sup>2)</sup>	0159507 <sup>2)</sup>
	1/2	20	12.700	110	18	9.0	7.0	10	3	11.5	H5	-	1	0168387 <sup>2)</sup>	0168493 <sup>2)</sup>
1/2		13	12.700	110	18	9.0	7.0	10	3	10.8	H5	-	1	0150368 <sup>2)</sup>	0159514 <sup>2)</sup>
	5/8	18	15.875	110	20	12.0	9.0	12	4	14.5	H5	-	1	0168394 <sup>2)</sup>	0168509 <sup>2)</sup>
5/8		11	15.875	110	20	12.0	9.0	12	4	13.5	H5	-	1	0150375 <sup>2)</sup>	0159552 <sup>2)</sup>
	3/4	16	19.050	125	25	14.0	11.0	14	4	17.5	H5	-	1	0168400 <sup>2)</sup>	0168516 <sup>2)</sup>
3/4		10	19.050	125	25	14.0	11.0	14	4	16.5	H5	-	1	0150382 <sup>2)</sup>	0159576 <sup>2)</sup>
	7/8	14	22.225	140	25	18.0	14.5	17	4	20.4	H6	-	1	0168417 <sup>2)</sup>	0168523 <sup>2)</sup>
7/8		9	22.225	140	25	18.0	14.5	17	4	19.5	H6	-	1	0150399 <sup>2)</sup>	0159590 <sup>2)</sup>
	1"	12	25.400	160	30	18.0	14.5	17	4	23.25	H6	-	1	0168424 <sup>2)</sup>	0168530 <sup>2)</sup>
1"		8	25.400	160	30	18.0	14.5	17	4	22.25	H6	-	1	0150405 <sup>2)</sup>	0168318 <sup>2)</sup>

**Note: DIN shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

# SPIRAL FLUTE TAPS (45°)



## Multi-Application, Semi-Bottoming

**E023** Premium substrate with Steam Oxide surface treatment  
**E033** reduces wear and prevents chip welding in abrasive or harder ferrous materials.

*E023 = UNC Sizes, E033 = UNF Sizes*

**1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3**



E023/E033

UNC UNF

ISO  
529

2B



HSS-E



No.2 - 1"

UNC	UNF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	l <sub>4</sub> mm	Limits	Pack Qty	E023 E033	
2		56	2.184	44.5	9.5	2.80	2.24	5	2	1.85	9.5	H2	1	0010440 <sup>1)</sup>
4		40	2.845	48	6	3.15	2.50	5	3	2.35	14	H2	1	0569382 <sup>1)</sup>
5		40	3.175	48	6	3.15	2.50	5	3	2.65	12.5	H2	1	0010471 <sup>1)</sup>
6		32	3.505	50	6	3.55	2.80	5	3	2.85	16	H2	1	0569399 <sup>1)</sup>
	8	36	4.166	53	7	4.5	3.55	6	3	3.50	17	H3	1	0570081 <sup>1)</sup>
8		32	4.166	53	7	4.50	3.55	6	3	3.50	17	H3	1	0569405 <sup>1)</sup>
	10	32	4.826	58	8	5.0	4.00	7	3	4.10	20	H3	1	0570098 <sup>1)</sup>
10		24	4.826	58	8	5.00	4.00	7	3	3.90	20	HH3	1	0569412 <sup>1)</sup>
12		24	5.486	62	12	5.60	4.50	7	3	4.50	21	H3	1	0569429 <sup>1)</sup>
	1/4	28	6.350	66	10	6.3	5.00	8	3	5.50	28	H4	1	0570104 <sup>1)</sup>
1/4		20	6.350	66	10	6.30	5.00	8	3	5.10	28	H5	1	0569436 <sup>1)</sup>
	5/16	24	7.938	72	12	8.0	6.30	9	3	6.90	31	H4	1	0570111 <sup>1)</sup>
5/16		18	7.938	72	12	8.00	6.30	9	3	6.60	31	H5	1	0569443 <sup>1)</sup>
	3/8	24	9.525	80	15	10.0	8.00	11	3	8.50	34	H4	1	0570128 <sup>1)</sup>
3/8		16	9.525	80	15	10.00	8.00	11	3	8.00	34	H5	1	0569450 <sup>1)</sup>
	7/16	20	11.112	85	19	8.0	6.30	9	3	9.90	-	H5	1	0570135 <sup>2)</sup>
7/16		14	11.112	85	19	8.00	6.30	9	3	9.40	-	H5	1	0569467 <sup>2)</sup>
	1/2	20	12.700	89	22	9.0	7.10	10	3	11.50	-	H5	1	0570142 <sup>2)</sup>
1/2		13	12.700	89	19	9.00	7.10	10	3	10.80	-	H5	1	0569474 <sup>2)</sup>
	9/16	18	14.288	95	24	11.2	9.00	12	3	12.90	-	H5	1	0570159 <sup>2)</sup>
	5/8	18	15.875	102	24	12.5	10.00	13	4	14.50	-	H5	1	0570166 <sup>2)</sup>
5/8		11	15.875	102	24	12.50	10.00	13	4	13.50	-	H5	1	0569481 <sup>2)</sup>
	3/4	16	19.050	112	29	14.0	11.20	14	4	17.50	-	H5	1	0570173 <sup>2)</sup>
3/4		10	19.050	112	29	14.00	11.20	14	4	16.50	-	H5	1	0569498 <sup>2)</sup>
	7/8	14	22.225	118	29	16.0	12.50	16	4	20.40	-	H6	1	0570180 <sup>2)</sup>
7/8		9	22.225	118	29	16.00	12.50	16	4	19.50	-	H6	1	0569504 <sup>2)</sup>
	1"	12	25.400	130	35	18.0	14.00	18	4	23.25	-	H6	1	0570197 <sup>2)</sup>
1"		8	25.400	130	35	18.00	14.00	18	4	22.25	-	H6	1	0569511 <sup>2)</sup>

**Note: ISO shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

## MXL Multi-Application, Semi-Bottoming

**1677AP** Designed for blind hole tapping in a variety of materials with a hardness up to 36 Rc. The premium substrate and TiCN coating combine to offer superior abrasion resistance, higher operating speeds, improved thread quality, reduced cycle times, and longer tool life.

**1679** Coolant thru design allows higher tapping speeds and eliminates the problems associated with inadequate coolant in horizontal or deep hole applications.

- 1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 4.2 5.1 5.2 6.1 6.2 6.3  
7.1 7.2 7.3 7.4



1677AP(M)		1679(M)	
M	MF	M	MF
DIN ANSI		DIN ANSI	
6H		6H	
HSS PM		HSS PM	
M4 - M24		M6 - M24	

M	MF	TPI	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> Inch (Neck Length)	Limits	d <sub>2</sub> Ø Inch	a Inch	# of Flutes	Pack Qty	1677AP	1679(M)
4		0.70	63	6	21	D4	0.168	0.131	3	1	46204927	<sup>1)</sup> —
5		0.80	70	9	25	D4	0.194	0.152	3	1	46204928	<sup>1)</sup> —
6		1.00	80	11	30	D5	0.255	0.191	3	1	46204929	<sup>1)</sup> 1717704
	8	1.00	90	12	35	D5	0.318	0.238	3	1	46205010	<sup>1)</sup> —
8		1.25	90	12	35	D5	0.318	0.238	3	1	46204930	<sup>1)</sup> 1717706
	10	1.25	100	14	39	D6	0.381	0.286	3	1	46204913	<sup>1)</sup> 1717708
10		1.50	100	14	39	D6	0.381	0.286	3	1	46204914	<sup>1)</sup> 1717710
	12	1.50	100	16		D6	0.367	0.275	3	1	46204915	<sup>2)</sup> —
12		1.75	110	16		D6	0.367	0.275	3	1	46204916	<sup>2)</sup> 1717722
	14	1.50	100	18		D7	0.429	0.322	3	1	46204917	<sup>2)</sup> —
14		2.00	110	18		D7	0.429	0.322	3	1	46204918	<sup>2)</sup> 1717726
16		2.00	110	19		D7	0.480	0.360	3	1	46204920	<sup>2)</sup> 1717730
	18	1.50	110	21		D7	0.542	0.406	3	1	46204921	<sup>2)</sup> —
18		2.50	125	21		D7	0.542	0.406	3	1	46204922	<sup>2)</sup> 1717734
	20	1.50	125	21		D7	0.652	0.489	3	1	46204923	<sup>2)</sup> —
20		2.50	140	21		D7	0.652	0.489	3	1	46204924	<sup>2)</sup> 1717738
24		3.00	160	26		D8	0.760	0.570	4	1	46204926	<sup>2)</sup> 1717742

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# SPIRAL FLUTE TAPS (45°)



## Multi-Application, Semi-Bottoming

**E007** Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

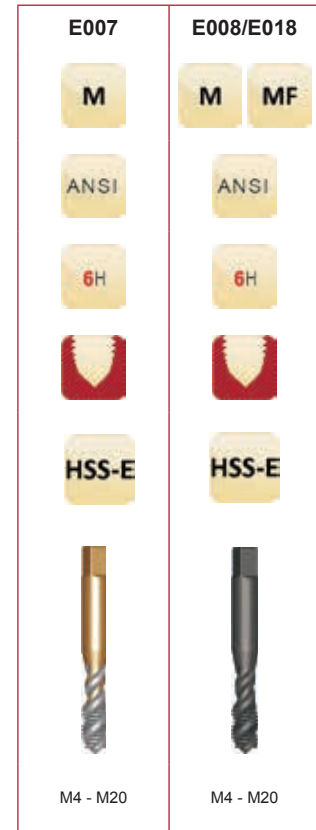
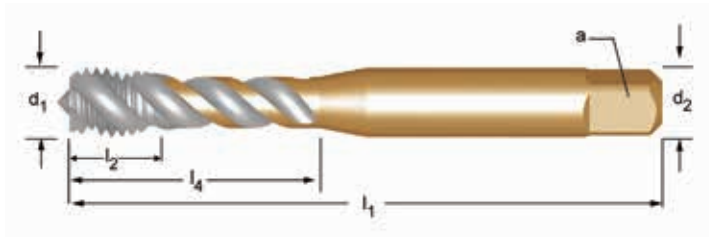
*E007 = Metric Coarse, E017 = Metric Fine*

1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

**E008** Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

*E008 = Metric Coarse, E018 = Metric Fine*

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3



M	MF	P mm	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch	a Inch	# of flutes	Limits		l <sub>4</sub> Inch	Pack Qty	E007	E008 E018	
4		0.70	2.1/8	0.2484	0.1680	0.1310	3	D4	3.30	N30	0.6526	1	0580608 <sup>1)</sup>	0580707 <sup>1)</sup>
5		0.80	2.3/8	0.2650	0.1940	0.1520	3	D4	4.20	N19	0.8434	1	0580615 <sup>1)</sup>	0580714 <sup>1)</sup>
6		1.00	2.1/2	0.3937	0.2550	0.1910	3	D5	5.00	N9	1.0993	1	0580622 <sup>1)</sup>	0580721 <sup>1)</sup>
	8	1.00	2.23/32	0.4567	0.3180	0.2380	3	D5	7.00	J	1.3094	1	—	0581032 <sup>1)</sup>
8		1.25	2.23/32	0.4567	0.3180	0.2380	3	D5	6.80	H	1.3094	1	0580639 <sup>1)</sup>	0580738 <sup>1)</sup>
	10	1.00	2.15/16	0.5315	0.3810	0.2860	3	D6	9.00	T	1.4415	1	—	0581049 <sup>1)</sup>
10		1.50	2.15/16	0.5315	0.3810	0.2860	3	D6	8.50	Q	1.4415	1	0580646 <sup>1)</sup>	0580745 <sup>1)</sup>
12		1.75	3.3/8	0.6890	0.3670	0.2750	3	D6	10.30	Y		1	0580653 <sup>2)</sup>	0580752 <sup>2)</sup>
	14	1.50	3.19/32	0.7087	0.4290	0.3220	3	D7	12.50	31/64		1	—	0581056 <sup>2)</sup>
14		2.00	3.19/32	0.7087	0.4290	0.3220	3	D7	12.00	15/32		1	— <sup>2)</sup>	0580769 <sup>2)</sup>
16		2.00	3.13/16	0.7087	0.4800	0.3600	3	D7	14.00	35/64		1	0580677 <sup>2)</sup>	0580776 <sup>2)</sup>
20		2.50	4.15/32	0.8858	0.6520	0.4890	3	D7	17.50	11/16		1	— <sup>2)</sup>	0580790 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks



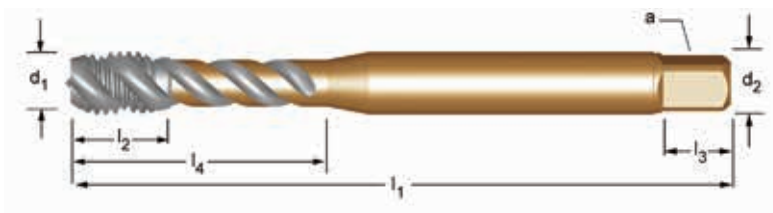
## Multi-Application, Semi-Bottoming

**EX006H** Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

**EX016H** Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3



M	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	a mm	l <sub>3</sub> mm	# of Flutes	↔	l <sub>4</sub> mm	Limits	Pack Qty	EX006H	EX016H
2	0.40	45	4	2.8	2.1	5	3	1.6	9	D3	1	0137307 <sup>1)</sup>	0137321 <sup>1)</sup>
2.5	0.45	50	4	2.8	2.1	5	3	2.05	12.5	D3	1	0137314 <sup>1)</sup>	0137338 <sup>1)</sup>
3	0.50	56	6	3.5	2.7	6	3	2.5	18	D3	1	0136591 <sup>1)</sup>	0136942 <sup>1)</sup>
3.5	0.60	56	7	4.0	3.0	6	3	2.9	20	D4	1	0136607 <sup>1)</sup>	0136966 <sup>1)</sup>
4	0.70	63	7	4.5	3.4	6	3	3.3	21	D4	1	0136614 <sup>1)</sup>	0136973 <sup>1)</sup>
5	0.80	70	8	6.0	4.9	8	3	4.2	25	D4	1	0136621 <sup>1)</sup>	0136980 <sup>1)</sup>
6	1.00	80	10	4.5	3.4	6	3	5	31	D5	1	0136645 <sup>1)</sup>	0137000 <sup>1)</sup>
6	1.00	80	10	6.0	4.9	8	3	5	31	D5	1	0136638 <sup>1)</sup>	0136997 <sup>1)</sup>
7	1.00	80	10	7.0	5.5	8	3	6	31	D5	1	0136652 <sup>1)</sup>	0137017 <sup>1)</sup>
8	1.25	90	12	8.0	6.2	9	3	6.8	35	D5	1	0136669 <sup>1)</sup>	0137024 <sup>1)</sup>
8	1.25	90	13	6.0	4.9	8	3	6.8	35	D5	1	0136676 <sup>1)</sup>	0137031 <sup>1)</sup>
10	1.50	100	15	10.0	8.0	11	3	8.5	39	D6	1	0136683 <sup>1)</sup>	0137048 <sup>1)</sup>
10	1.50	100	15	7.0	5.5	8	3	8.5	39	D6	1	0136690 <sup>1)</sup>	0137055 <sup>1)</sup>
12	1.75	110	16	9.0	7.0	10	3	10.3	-	D6	1	0136706 <sup>2)</sup>	0137062 <sup>2)</sup>
14	2.00	110	20	11.0	9.0	12	3	12	-	D7	1	0136713 <sup>2)</sup>	0137079 <sup>2)</sup>
16	2.00	110	20	12.0	9.0	12	4	14	-	D7	1	0136720 <sup>2)</sup>	0137086 <sup>2)</sup>
18	2.50	125	25	14.0	11.0	14	4	15.5	-	D7	1	0136737 <sup>2)</sup>	0137093 <sup>2)</sup>
20	2.50	140	25	16.0	12.0	15	4	17.5	-	D7	1	0136744 <sup>2)</sup>	0137109 <sup>2)</sup>
22	2.50	140	25	18.0	14.5	17	4	19.5	-	D8	1	0136829 <sup>2)</sup>	0137116 <sup>2)</sup>
24	3.00	160	30	18.0	14.5	17	4	21	-	D8	1	0136836 <sup>2)</sup>	0137123 <sup>2)</sup>
27	3.00	160	30	20.0	16.0	19	4	24	-	D8	1	0136843 <sup>2)</sup>	0137130 <sup>2)</sup>
30	3.50	180	36	22.0	18.0	21	4	26.5	-	D9	1	0136850 <sup>2)</sup>	0137147 <sup>2)</sup>
33	3.50	180	36	25.0	20.0	23	4	29.5	-	D9	1	0136867 <sup>2)</sup>	0137154 <sup>2)</sup>
36	4.00	200	40	28.0	22.0	25	4	32	-	D9	1	0136874 <sup>2)</sup>	0137161 <sup>2)</sup>
39	4.00	200	40	32.0	24.0	27	4	35	-	D9	1	0136881 <sup>2)</sup>	0137178 <sup>2)</sup>
42	4.50	200	45	32.0	24.0	27	4	37.5	-	D10	1	0136898 <sup>2)</sup>	0137185 <sup>2)</sup>
48	5.00	250	50	36.0	29.0	32	4	43	-	D11	1	0136904 <sup>2)</sup>	0137192 <sup>2)</sup>
52	5.00	250	50	40.0	32.0	35	5	47	-	D11	1	0136911 <sup>2)</sup>	0137208 <sup>2)</sup>
56	5.50	250	55	40.0	32.0	35	5	50.5	-	D11	1	0136928 <sup>2)</sup>	0137215 <sup>2)</sup>
64	6.00	315	60	50.0	39.0	42	6	58	-	D12	1	0136935 <sup>2)</sup>	0137222 <sup>2)</sup>

**Note: DIN shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# SPIRAL FLUTE TAPS (45°)



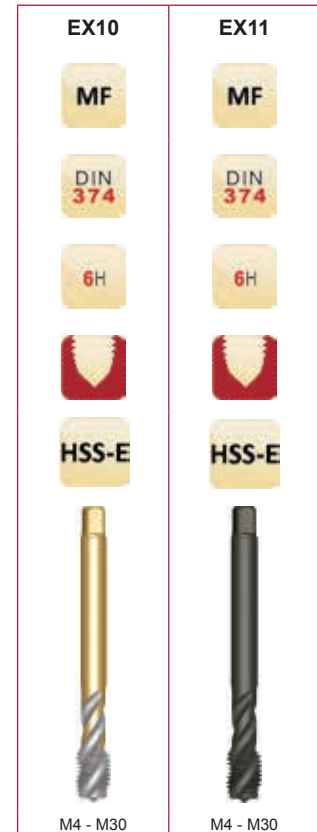
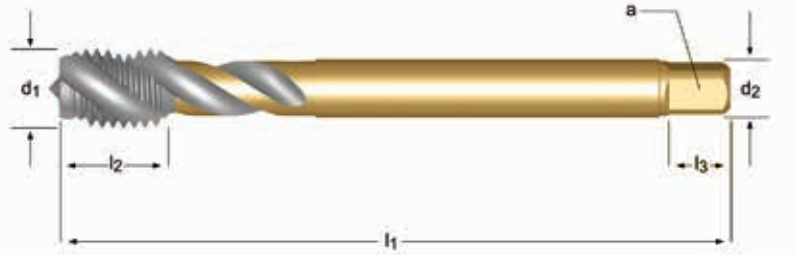
## Multi-Application, Semi-Bottoming

**EX10** Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

**EX11** Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3



MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> ∅ mm	□ a mm	l <sub>3</sub> mm	# of Flutes	↔	Limits	Pack Qty	EX10	EX11
4	0.50	63	7	2.8	2.1	5	3	3.5	D4	1	0149669	0149966
5	0.50	70	8	3.5	2.7	6	3	4.5	D4	1	0149676	0149973
6	0.75	80	10	4.5	3.4	6	3	5.3	D5	1	0149683	0149980
8	0.75	80	13	6.0	4.9	8	3	7.3	D5	1	0149690	0149997
8	1.00	90	13	6.0	4.9	8	3	7	D5	1	0149706	0150009
10	0.75	90	13	7.0	5.5	8	3	9.3	D6	1	0149713	0150016
10	1.00	90	13	7.0	5.5	8	3	9	D6	1	0149720	0150023
10	1.25	100	15	7.0	5.5	8	3	8.8	D6	1	0149737	0150030
12	1.00	100	15	9.0	7.0	10	3	11	D6	1	0149744	0150047
12	1.25	100	15	9.0	7.0	10	3	10.8	D6	1	0149751	0150054
12	1.50	100	15	9.0	7.0	10	3	10.5	D6	1	0149768	0150061
14	1.00	100	15	11.0	9.0	12	3	13	D7	1	0149775	0150078
14	1.25	100	15	11.0	9.0	12	3	12.8	D7	1	0149782	0150085
14	1.50	100	15	11.0	9.0	12	3	12.5	D7	1	0149799	0150092
16	1.00	100	15	12.0	9.0	12	4	15	D7	1	0149805	0150108
16	1.50	100	15	12.0	9.0	12	4	14.5	D7	1	0149812	0150115
18	1.00	110	17	14.0	11.0	14	4	17	D7	1	0149829	0150122
18	1.50	110	17	14.0	11.0	14	4	16.5	D7	1	0149836	0150139
20	1.00	125	17	16.0	12.0	15	4	19	D7	1	0149843	0150146
20	1.50	125	17	16.0	12.0	15	4	18.5	D7	1	0149850	0150153
22	1.50	125	17	18.0	14.5	17	4	20.5	D8	1	0149867	0150160
24	1.50	140	20	18.0	14.5	17	4	22.5	D8	1	0149874	0150177
24	2.00	140	20	18.0	14.5	17	4	22	D8	1	0149881	0150184
25	1.50	140	20	18.0	14.5	17	4	23.5	D8	1	0149898	0150191
26	1.50	140	20	18.0	14.5	17	4	24.5	D8	1	0149904	0150207
27	1.50	140	20	20.0	16.0	19	4	25.5	D8	1	0149911	0150214
27	2.00	140	20	20.0	16.0	19	4	25	D8	1	0149928	0150221
28	1.50	140	20	20.0	16.0	19	4	26.5	D9	1	0149935	0150238
30	1.50	150	20	22.0	18.0	21	4	28.5	D9	1	0149942	0150245
30	2.00	150	20	22.0	18.0	21	4	28	D9	1	0149959	0150252

Note: DIN shank and square dimensions will necessitate metric holders

## Multi-Application, Semi-Bottoming

**E002** Premium substrate for blind hole tapping in tough or abrasive materials. Bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft and non-ferrous materials.

*E002 = Metric Coarse*

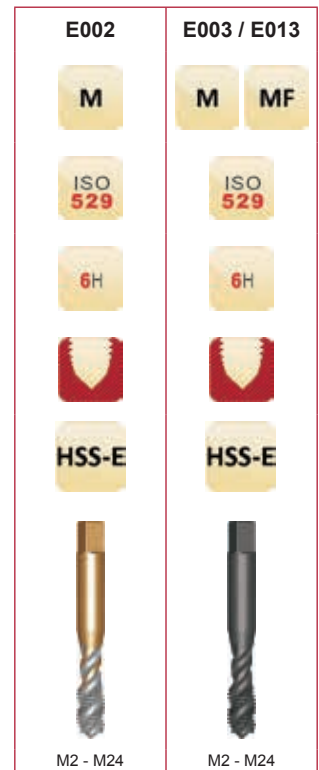
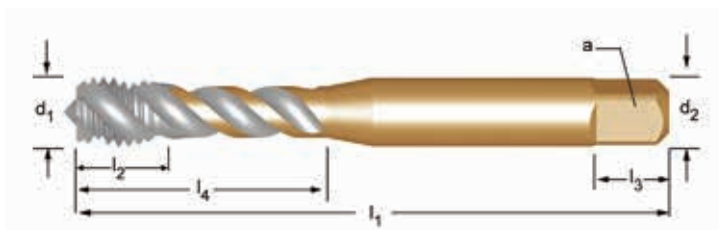
**1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4**

**E003** Premium substrate with Steam Oxide surface treatment reduces wear and prevents chip welding in abrasive or harder ferrous materials.

**E013**

*E003 = Metric Coarse, E013 = Metric Fine*

**1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3**



**Note: ISO shank and square dimensions will necessitate metric holders**

M	MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	Limits	Flute Width	l <sub>4</sub> mm	Pack Qty	E002	E003 E013
2		0.40	41	8	2.50	2.00	4	2	D3	1.6	8	1	0168820 <sup>1)</sup>	0168844 <sup>1)</sup>
2.5		0.45	44.5	9.5	2.80	2.24	5	2	D3	2.05	9.5	1	0168837 <sup>1)</sup>	0168851 <sup>1)</sup>
3		0.50	48	6	3.15	2.50	5	3	D3	2.5	12.5	1	0567869 <sup>1)</sup>	0568002 <sup>1)</sup>
	4	0.50	53	7	4.0	3.15	6	3	D4	3.5	19	1	—	0568798 <sup>1)</sup>
4		0.70	53	7	4.00	3.15	6	3	D4	3.3	19	1	0567883 <sup>1)</sup>	0568026 <sup>1)</sup>
	5	0.50	58	8	5.0	4.0	7	3	D4	4.5	22	1	—	0568804 <sup>1)</sup>
5		0.80	58	8	5.00	4.00	7	3	D4	4.2	22	1	0567890 <sup>1)</sup>	0568033 <sup>1)</sup>
	6	0.50	66	10	6.3	5.0	8	3	D5	5.5	27	1	—	0568811 <sup>1)</sup>
	6	0.75	66	10	6.3	5.0	8	3	D5	5.3	27	1	—	0568828 <sup>1)</sup>
6		1.00	66	10	6.30	5.00	8	3	D5	5.0	27	1	0567906 <sup>1)</sup>	0568040 <sup>1)</sup>
	8	0.75	72	12	8.0	6.3	9	3	D5	7.3	31	1	—	0568835 <sup>1)</sup>
	8	1.00	72	12	8.0	6.3	9	3	D5	7.0	31	1	—	0568842 <sup>1)</sup>
8		1.25	72	12	8.00	6.30	9	3	D5	6.8	31	1	0567913 <sup>1)</sup>	0568057 <sup>1)</sup>
	10	1.00	80	15	10.0	8.0	11	3	D6	9.0	35	1	—	0568859 <sup>1)</sup>
	10	1.25	80	15	10.0	8.0	11	3	D6	8.8	35	1	—	0568866 <sup>1)</sup>
10		1.50	80	15	10.00	8.00	11	3	D6	8.5	35	1	0567920 <sup>1)</sup>	0568064 <sup>1)</sup>
	12	1.00	89	16	9.0	7.1	10	3	D6	11.0	-	1	—	0568873 <sup>2)</sup>
	12	1.25	89	16	9.0	7.1	10	3	D6	10.8	-	1	—	0568880 <sup>2)</sup>
	12	1.50	89	16	9.0	7.1	10	3	D6	10.5	-	1	—	0568897 <sup>2)</sup>
12		1.75	89	16	9.00	7.10	10	3	D6	10.3	-	1	0567937 <sup>2)</sup>	0568071 <sup>2)</sup>
	14	1.50	95	18	11.2	9.0	12	3	D7	12.5	-	1	—	0568903 <sup>2)</sup>
14		2.00	95	18	11.20	9.00	12	3	D7	12.0	-	1	0567944 <sup>2)</sup>	0568088 <sup>2)</sup>
	16	1.00	102	18	12.5	10.0	13	4	D7	15.0	-	1	—	0568910 <sup>2)</sup>
	16	1.50	102	18	12.5	10.0	13	4	D7	14.5	-	1	—	0568927 <sup>2)</sup>
16		2.00	102	18	12.50	10.00	13	4	D7	14.0	-	1	0567951 <sup>2)</sup>	0568095 <sup>2)</sup>
	18	1.50	112	29	14.0	11.2	14	4	D7	16.5	-	1	—	0568934 <sup>2)</sup>
18		2.50	112	29	14.00	11.20	14	4	D7	15.5	-	1	0567968 <sup>2)</sup>	0568101 <sup>2)</sup>
	20	1.50	112	29	14.0	11.2	14	4	D7	18.5	-	1	—	0568941 <sup>2)</sup>
20		2.50	112	29	14.00	11.20	14	4	D7	17.5	-	1	0567975 <sup>2)</sup>	0568118 <sup>2)</sup>
	22	1.50	118	29	16.0	12.5	16	4	D8	20.5	-	1	—	0568958 <sup>2)</sup>
22		2.50	118	29	16.00	12.50	16	4	D8	19.5	-	1	0567982 <sup>2)</sup>	0568125 <sup>2)</sup>
24		3.00	130	35	18.00	14.00	18	4	D8	21.0	-	1	0567999 <sup>2)</sup>	0568132 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks, <sup>2)</sup> Reduced Shanks

# SPIRAL FLUTE TAP (16°-19°)

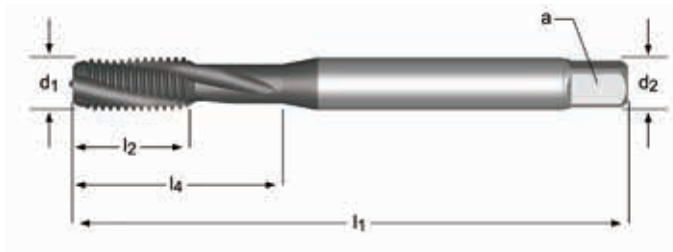
UNION  
BUTTERFIELD

APPLIX

## HMD Hard Materials / Cast Iron, Semi-Bottoming

**1630AP** Designed for blind hole tapping materials with a hardness of >38 Rc. Premium substrate provides superior abrasion resistance and edge strength. TiAlN-Top coating lowers the coefficient of friction, improves thread quality, affords higher operating speeds, and longer tool life.

1.5 1.6 2.4 3.1 3.2 3.3 3.4 4.3 5.3 6.4



1630AP

UNC UNF

DIN  
ANSI

2B



HSS  
PM



No.4 - 1"

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	Limits	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Pack Qty	1630AP
4		40	2.205	0.236	0.709	H2	0.141	0.110	2	1	46204818 <sup>1)</sup>
6		32	2.205	0.236	0.787	H2	0.141	0.110	2	1	46204823 <sup>1)</sup>
8		32	2.480	0.236	0.827	H3	0.168	0.131	2	1	46204828 <sup>1)</sup>
	10	32	2.756	0.354	0.984	H3	0.194	0.152	3	1	46204811 <sup>1)</sup>
10		24	2.756	0.354	0.984	H3	0.194	0.152	3	1	46204810 <sup>1)</sup>
	1/4	28	3.150	0.433	1.181	H4	0.255	0.191	3	1	46204809 <sup>1)</sup>
1/4		20	3.150	0.433	1.181	H5	0.255	0.191	3	1	46204808 <sup>1)</sup>
	5/16	24	3.543	0.472	1.378	H4	0.318	0.238	3	1	46204820 <sup>1)</sup>
5/16		18	3.543	0.472	1.378	H5	0.318	0.238	3	1	46204819 <sup>1)</sup>
	3/8	24	3.937	0.551	1.535	H4	0.381	0.286	3	1	46204817 <sup>1)</sup>
3/8		16	3.937	0.551	1.535	H5	0.381	0.286	3	1	46204816 <sup>1)</sup>
	7/16	20	3.937	0.591	—	H5	0.323	0.242	3	1	46204825 <sup>2)</sup>
7/16		14	3.937	0.591	—	H5	0.323	0.242	3	1	46204824 <sup>2)</sup>
	1/2	20	3.937	0.630	—	H5	0.367	0.275	3	1	46204807 <sup>2)</sup>
1/2		13	4.331	0.630	—	H5	0.367	0.275	3	1	46204806 <sup>2)</sup>
	5/8	18	3.937	0.745	—	H5	0.480	0.360	4	1	46204822 <sup>2)</sup>
5/8		11	4.331	0.745	—	H5	0.480	0.360	4	1	46204821 <sup>2)</sup>
	3/4	16	4.331	0.820	—	H5	0.590	0.442	4	1	46204815 <sup>2)</sup>
3/4		10	4.921	0.820	—	H5	0.590	0.442	4	1	46204814 <sup>2)</sup>
	7/8	14	4.921	0.910	—	H6	0.697	0.523	4	1	46204826 <sup>2)</sup>
7/8		9	5.512	0.910	—	H6	0.697	0.523	4	1	46204827 <sup>2)</sup>
1"		8	6.299	1.025	—	H6	0.800	0.600	4	1	46204813 <sup>2)</sup>

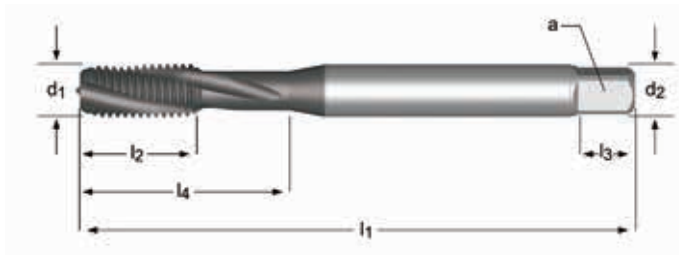
<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

## HMD Hard Materials / Cast Iron, Semi-Bottoming

**1660AP** Designed for blind hole tapping materials with a hardness of >38 Rc. Premium substrate provides superior abrasion resistance and edge strength. TiAlN-Top coating lowers the coefficient of friction, improves thread quality, affords higher operating speeds, and longer tool life.

1.5 1.6 2.4 3.1 3.2 3.3 3.4 4.3 5.3 6.4



1660AP(M)

- M
- DIN ANSI
- 6H
- HSS PM



M3 - M12

M	P mm	$l_1$ mm	$l_2$ mm	$l_4$ Inch (Neck Length)	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Pack Qty	1660AP(M)
3	0.50	56	8	18	0.141	0.110	3	D3	1	46204841
4	0.70	63	6	21	0.168	0.131	3	D4	1	46204842 <sup>1)</sup>
5	0.80	70	9	25	0.194	0.152	3	D4	1	46204843 <sup>1)</sup>
6	1.00	80	11	30	0.255	0.191	3	D5	1	46204844 <sup>1)</sup>
8	1.25	90	12	35	0.318	0.238	3	D5	1	46204846 <sup>1)</sup>
10	1.50	100	14	39	0.381	0.286	3	D6	1	46204838 <sup>1)</sup>
12	1.75	110	16		0.367	0.275	3	D6	1	46204840 <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks  
<sup>2)</sup> Reduced Shanks

# THREAD FORMING TAPS



## Multi-Application / Lube Grooves, Full-Bottoming

**1641** Premium PM substrate provides superior abrasion resistance and edge strength. Multiple Lube Groove design assures lubrication in the forming zone and eliminates the build up of hydraulic pressure in blind holes. TiN coated for enhanced performance. The hard, smooth coating provides a greater lubricity, increases tool life, and improves thread flank finish.

The entry taper is full bottoming style (1-2 thread chamfer) for blind hole tapping.

- 1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 5.1 6.1 6.2 6.3 7.1 7.2  
7.3



1641(UNC)	1641(UNF)
No.4 - 1/2	No.10 - 3/8

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	$l_3$ Inch	$d_2$ Ø Inch	$\square$ a Inch	Limits	Pack Qty	1641(UNC)	1641(UNF)
4		40	1.7/8	5/16	9/16	3/16	0.141	0.110	H3	1	1712221	—
4		40	1.7/8	5/16	9/16	3/16	0.141	0.110	H5	1	1712223	—
6		32	2"	3/8	11/16	3/16	0.141	0.110	H3	1	1712233	—
6		32	2"	3/8	11/16	3/16	0.141	0.110	H5	1	1712235	—
8		32	2.1/8	3/8	3/4	1/4	0.141	0.110	H3	1	1712239	—
8		32	2.1/8	3/8	3/8	1/4	0.141	0.110	H5	1	1712241	—
	10	32	2.3/8	1/2	7/8	1/4	0.194	0.152	H4	1	—	1712258
	10	32	2.3/8	1/2	7/8	1/4	0.194	0.152	H6	1	—	1712260
10		24	2.3/8	1/2	7/8	1/4	0.194	0.152	H6	1	1712254	—
	1/4	28	2.1/2	5/8	1"	5/16	0.255	0.191	H4	1	—	1712270
	1/4	28	2.1/2	5/8	1"	5/16	0.255	0.191	H6	1	—	1712272
1/4		20	2.1/2	5/8	1"	5/16	0.255	0.191	H4	1	1712264	—
1/4		20	2.1/2	5/8	1"	5/16	0.255	0.191	H6	1	1712266	—
	5/16	24	2.23/32	11/16	1.1/8	3/8	0.318	0.238	H7	1	—	1712285
5/16		18	2.23/32	11/16	1.1/8	3/8	0.318	0.238	H5	1	1712277	—
5/16		18	2.23/32	11/16	1.1/8	3/8	0.318	0.238	H7	1	1712279	—
	3/8	24	2.15/16	3/4	1.1/4	7/16	0.381	0.286	H7	1	—	1712297
3/8		16	2.15/16	3/4	1.1/4	7/16	0.381	0.286	H5	1	1712289	—
3/8		16	2.15/16	3/4	1.1/4	7/16	0.381	0.286	H7	1	1712291	—
1/2		13	3.3/8	15/16	1.21/32	7/16	0.367	0.275	H5	1	1712301	—
1/2		13	3.3/8	15/16	1.21/32	7/16	0.367	0.275	H8	1	1712304	—

## Multi-Application / Lube Grooves, Full-Bottoming

**1671** Premium PM substrate provides superior abrasion resistance and edge strength. Multiple Lube Groove design assures lubrication in the forming zone and eliminates the build up of hydraulic pressure in blind holes. TiN coated for enhanced performance. The hard, smooth coating provides a greater lubricity, increases tool life, and improves thread flank finish.

The entry taper is full bottoming style for blind hole tapping.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 5.1 6.1 6.2 6.3 7.1 7.2  
7.3



1671(M)



M3 - M10

M	P mm	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	$l_3$ Inch	$d_2$ Ø Inch	□ a Inch	Limits	Pack Qty	1671(M)
3	0.50	1.15/16	5/16	1/2	3/16	0.141	0.110	D5	1	1713051
4	0.70	2.1/8	3/8	3/4	1/4	0.168	0.131	D6	1	1713052
5	0.80	2.3/8	1/2	7/8	1/4	0.194	0.152	D7	1	1713053
6	1.00	2.1/2	5/8	1"	5/16	0.255	0.191	D8	1	1713054
8	1.00	2.23/32	11/16	1.1/8	3/8	0.318	0.238	D9	1	1713055
8	1.25	2.23/32	11/16	1.1/8	3/8	0.318	0.238	D9	1	1713056
10	1.50	2.15/16	3/4	1.1/4	7/16	0.381	0.286	D10	1	1713057

# THREAD FORMING TAPS

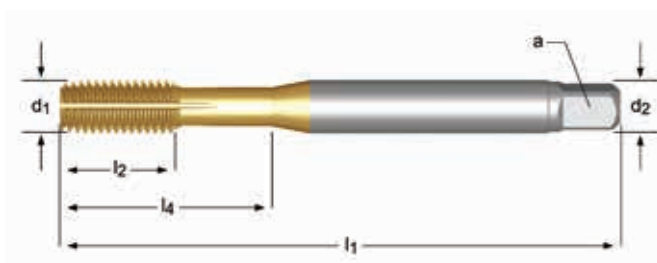
**UNION  
BUTTERFIELD**

**APPLIX**

## MXR Multi-Application / Lube Grooves, Semi-Bottoming

**1681AP** Premium PM substrate provides superior abrasion resistance and edge strength. Multiple Lube Groove design assures lubrication in the forming zone and eliminates the build up of hydraulic pressure in blind holes. The TiN-Top coating process reduces friction, prevents chip welding and improves chip flow.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 5.1 6.1 6.2 6.3 7.1 7.2  
7.3



1681AP(UNC)	1681AP(UNF)
UNC	UNF
DIN ANSI	DIN ANSI
2B	2B
HSS PM	HSS PM
No.4 - 1"	No.10 - 7/8

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	Limits	$d_2$ Ø Inch	$a$ Inch	Pack Qty	1681AP (UNC)	1681AP (UNF)
4		40	2.205	0.433	0.709	H5	0.141	0.110	1	46204945	<sup>1)</sup> —
6		32	2.205	0.472	0.787	H5	0.141	0.110	1	46204950	<sup>1)</sup> —
8		32	2.480	0.512	0.827	H5	0.168	0.131	1	46204955	<sup>1)</sup> —
	10	32	2.756	0.512	0.984	H6	0.194	0.152	1	—	46204938 <sup>1)</sup>
10		24	2.756	0.591	0.984	H6	0.194	0.152	1	46204937	<sup>1)</sup> —
12		24	3.150	0.630	1.142	H6	0.220	0.165	1	46371643	<sup>1)</sup> —
	1/4	28	3.150	0.669	1.181	H6	0.255	0.191	1	—	46204936 <sup>1)</sup>
1/4		20	3.150	0.669	1.181	H6	0.255	0.191	1	46204935	<sup>1)</sup> —
	5/16	24	3.543	0.669	1.378	H7	0.318	0.238	1	—	46204947 <sup>1)</sup>
5/16		18	3.546	0.787	1.378	H7	0.318	0.238	1	46204946	<sup>1)</sup> —
	3/8	24	3.937	0.709	1.535	H7	0.381	0.286	1	—	46204944 <sup>1)</sup>
3/8		16	3.937	0.866	1.535	H7	0.381	0.286	1	46204943	<sup>1)</sup> —
	7/16	20	3.937	0.866	—	H8	0.323	0.242	1	—	46204952 <sup>2)</sup>
7/16		14	3.937	0.866	—	H8	0.323	0.242	1	46204951	<sup>2)</sup> —
	1/2	20	3.937	0.866	—	H8	0.397	0.275	1	—	46204934 <sup>2)</sup>
1/2		13	4.331	0.984	—	H8	0.367	0.275	1	46204933	<sup>2)</sup> —
5/8		11	4.331	1.063	—	H8	0.480	0.360	1	46204948	<sup>2)</sup> —
	3/4	16	4.331	0.984	—	H8	0.590	0.442	1	—	46204942 <sup>2)</sup>
3/4		10	4.921	1.181	—	H8	0.590	0.442	1	46204941	<sup>2)</sup> —
	7/8	14	4.921	1.024	—	H9	0.697	0.523	1	—	46204953 <sup>2)</sup>
7/8		9	5.512	1.260	—	H9	0.697	0.523	1	46204954	<sup>2)</sup> —
1"		8	6.299	1.417	—	H9	0.800	0.600	1	46204940	<sup>2)</sup> —

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

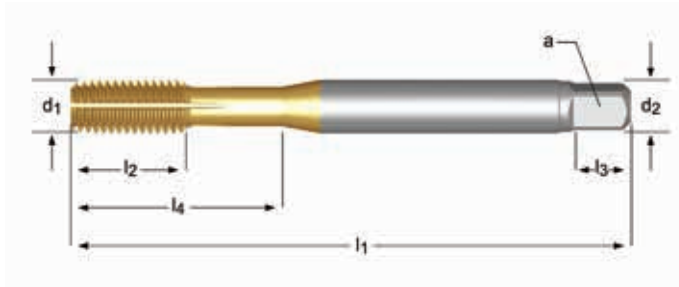


## MXR Multi-Application / Lube Grooves, Semi-Bottoming



**1691AP** Coolant thru premium PM substrate allows higher tapping speeds in soft ferrous or non-ferrous materials. The TiN-Top coating process reduces friction, prevents chip welding and improves chip flow.

- 1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 5.1 6.1 6.2 6.3 7.1 7.2  
7.3



1691AP(UNC)	1691AP(UNF)
UNC	UNF
DIN ANSI	DIN ANSI
2B	2B
HSS PM	HSS PM
1/4 - 1"	5/16 - 1/2

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$l_4$ Inch (Neck Length)	Limits	$d_2$ $\emptyset$ Inch	$\square$ a Inch	Pack Qty	1691AP (UNC)	1691AP (UNF)
1/4		20	3.150	0.669	1.181	H6	0.255	0.191	1	46204976 <sup>1)</sup>	—
	5/16	24	3.543	0.669	1.378	H7	0.318	0.238	1	—	46204985 <sup>1)</sup>
5/16		18	3.546	0.787	1.378	H7	0.318	0.238	1	46204984 <sup>1)</sup>	—
	3/8	24	3.937	0.709	1.535	H7	0.381	0.286	1	—	46204983 <sup>1)</sup>
3/8		16	3.937	0.866	1.535	H7	0.381	0.286	1	46204982 <sup>1)</sup>	—
	7/16	20	3.937	0.866	—	H8	0.323	0.242	1	—	46204989 <sup>2)</sup>
	1/2	20	3.937	0.866	—	H8	0.397	0.275	1	—	46204975 <sup>2)</sup>
1/2		13	4.331	0.984	—	H8	0.367	0.275	1	46204974 <sup>2)</sup>	—
5/8		11	4.331	1.063	—	H8	0.480	0.360	1	46204986 <sup>2)</sup>	—
3/4		10	4.921	1.181	—	H8	0.590	0.442	1	46204980 <sup>2)</sup>	—
1"		8	6.299	1.417	—	H9	0.800	0.600	1	46204979 <sup>2)</sup>	—

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

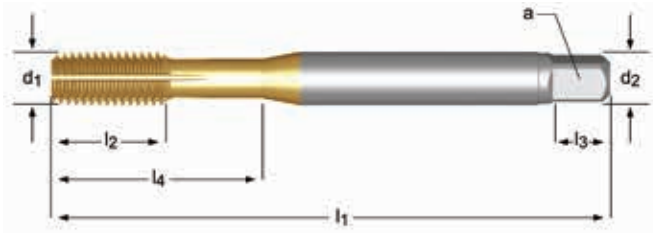
# THREAD FORMING TAPS

## MXR Multi-Application / Lube Grooves, Semi-Bottoming

**1687AP** Premium PM substrate provides superior abrasion resistance and edge strength. Multiple Lube Groove design assures lubrication in the forming zone and eliminates the build up of hydraulic pressure in blind holes. The TiN-Top coating process reduces friction, prevents chip welding and improves chip flow. Features a semi-bottoming lead for improved performance and longer tool life. Can be used for through or blind holes.

**1697AP** Coolant thru premium PM substrate allows higher tapping speeds in soft ferrous or non-ferrous materials. The TiN-Top coating process reduces friction, prevents chip welding and improves chip flow.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3 4.1 5.1 6.1 6.2 6.3 7.1 7.2  
7.3



1687AP		1697AP	
M	MF	M	
DIN ANSI		DIN ANSI	
6H		6H	
HSS PM		HSS PM	
M4 - M20		M6 - M20	

M	MF	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>2</sub> Inch	l <sub>4</sub> Inch (Neck Length)	Limits	d <sub>2</sub> Ø Inch	a Inch	Pack Qty	1687AP	1697AP
4		0.70	63	13		21	D6	0.168	0.131	1	46204970	<sup>1)</sup> —
5		0.80	70	15		25	D7	0.194	0.152	1	46204971	<sup>1)</sup> —
6		1.00	80	17		30	D8	0.255	0.191	1	46204972	<sup>1)</sup> 46205004 <sup>1)</sup>
8		1.25	90	20		25	D9	0.318	0.238	1	46204973	<sup>1)</sup> —
8		1.25	90	20		35	D9	0.318	0.238	1	—	46205005 <sup>1)</sup>
	10	1.25	100	16		39	D10	0.381	0.286	1	46204956	<sup>1)</sup> —
10		1.50	100	22		39	D10	0.381	0.286	1	46204957	<sup>1)</sup> 46204991 <sup>1)</sup>
	12	1.50	100	22			D11	0.367	0.275	1	46204958	<sup>2)</sup> —
12		1.75	110	24			D11	0.367	0.275	1	46204959	<sup>2)</sup> 46204993 <sup>2)</sup>
	14	1.50	100	22			D10	0.429	0.322	1	46204960	<sup>2)</sup> —
14		2.00	110	26			D11	0.429	0.322	1	46204961	<sup>2)</sup> — <sup>2)</sup>
	16	1.50	100	22			D10	0.480	0.360	1	46204962	<sup>2)</sup> —
16		2.00	110	27			D11	0.480	0.360	1	46204963	<sup>2)</sup> 46204997 <sup>2)</sup>
	20	1.50	125		25		D11	0.652	0.489	1	—	46205000 <sup>2)</sup>
20		2.50	140	32			D12	0.652	0.489	1	46204967	<sup>2)</sup> — <sup>2)</sup>

<sup>1)</sup> Reinforced Shanks

<sup>2)</sup> Reduced Shanks

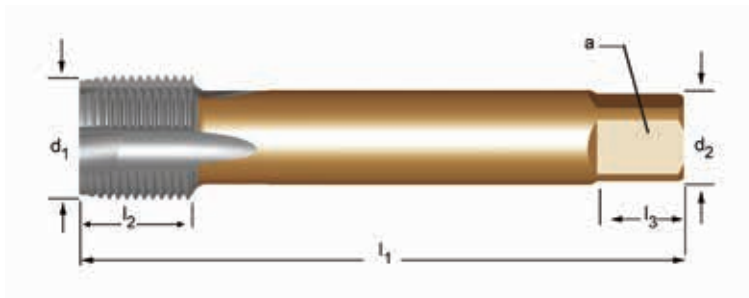
## Parallel Thread, G (BSP), Plug Style

**EP40** Bronze oxide body and shank reduces rust and corrosion. Bright flutes improve chip flow in soft or non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 5.1 5.2 6.1  
6.2 6.3 7.1 7.2 7.3 7.4 8.1

**EP41** Steam oxide surface treatment reduces wear and chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



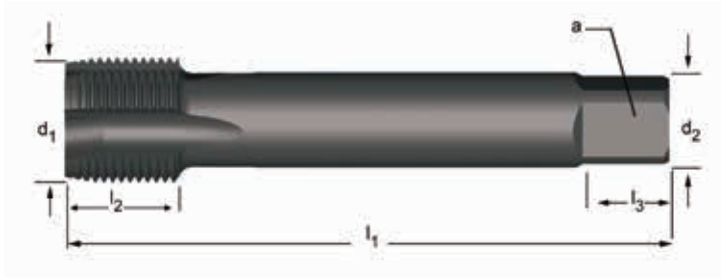
G(BSP)	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of flutes		Pack Qty	EP40	EP41
1/8	28	9.728	90	18	7.0	5.5	8	3	8.8	1	0138588	0138663
1/4	19	13.157	100	21	11.0	9.0	12	3	11.8	1	0138595	0138670
3/8	19	16.662	100	21	12.0	9.0	12	4	15.25	1	0138601	0138687
1/2	14	20.955	125	24	16.0	12.0	15	4	19	1	0138618	0138694
5/8	14	22.911	125	24	18.0	14.5	17	4	21	1	0138625	0138700
3/4	14	26.441	140	28	20.0	16.0	19	4	24.5	1	0138632	0147054
7/8	14	30.201	150	28	22.0	18.0	21	4	28.25	1	0138649	0149645
1"	11	33.249	160	30	25.0	20.0	23	4	30.75	1	0138656	0149652

**Note:** DIN shank and square dimensions will necessitate metric holders

## Parallel Thread, G(BSP), Plug Style

**E041** Steam oxide surface treatment reduces wear and chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4



**E041**

**G**

**DORMER ISO**

Normal

**HSS-E**

1/8 - 3/4

G(BSP)	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes		Pack Qty	E041
1/8	28	9.728	90	15	8.0	6.3	9	3	8.80	1	0569818
1/4	19	13.157	100	19	10.0	8.0	11	3	11.80	1	0569825
3/8	19	16.662	100	21	12.5	10.0	13	3	15.25	1	0569832
1/2	14	20.955	125	26	16.0	12.5	16	4	19.00	1	0569849
3/4	14	26.441	140	28	20.0	16.0	20	4	24.50	1	0569856

**Note:** ISO shank and square dimensions will necessitate metric holders

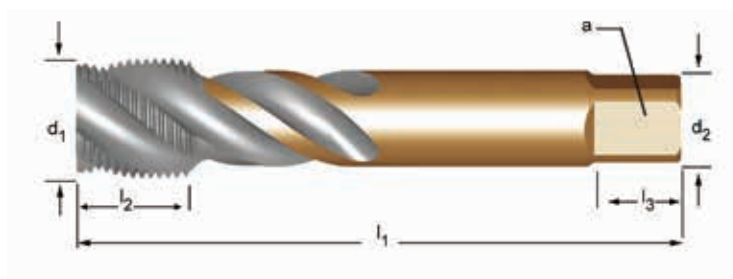
## Parallel Thread, G(BSP), Semi- Bottoming

**EX40** Bronze oxide body and shank reduces rust and corrosion. Bright flutes improve chip flow in soft or non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4 8.1

**EX41** Steam oxide surface treatment reduces wear and chip welding in abrasive or harder ferrous materials.

1.1 1.2 1.3 1.4 1.5 2.1 2.2 2.3



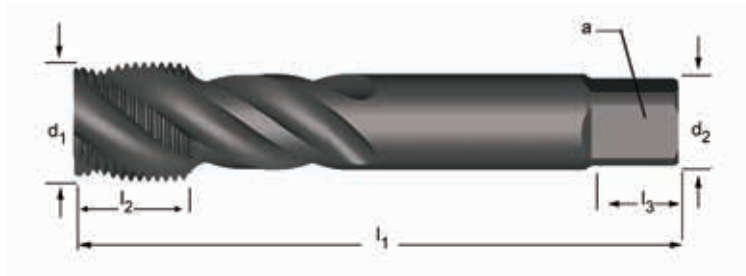
G(BSP)	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of flutes		Pack Qty	EX40	EX41
1/8	28	9.728	90	13	7.0	5.5	8	3	8.8	1	0168547	0168653
1/4	19	13.157	100	15	11.0	9.0	12	3	11.8	1	0168554	0168660
3/8	19	16.662	100	15	12.0	9.0	12	4	15.25	1	0168561	0168677
1/2	14	20.955	125	18	16.0	12.0	15	4	19	1	0168578	0168684
5/8	14	22.911	125	18	18.0	14.5	17	4	21	1	0168585	0168691
3/4	14	26.441	140	20	20.0	16.0	19	4	24.5	1	0168592	0168707
7/8	14	30.201	150	20	22.0	18.0	21	4	28.25	1	0168608	0168714
1"	11	33.249	160	22	25.0	20.0	23	4	30.75	1	0168615	0168721
1.1/8	11	37.897	170	22	28.0	22.0	25	4	35	1	0168622	0168738
1.1/4	11	41.910	170	22	32.0	24.0	27	4	39.5	1	0168639	0168745
1.1/2	11	47.803	190	23	36.0	29.0	32	4	45	1	0168646	0168752

**Note:** DIN shank and square dimensions will necessitate metric holders

## Parallel Thread, G(BSP), Semi-Bottoming

**E043** Steam oxide surface treatment reduces wear and chip welding in abrasive or harder ferrous materials.

**1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3**



E043

G

DORMER  
ISO


Normal



HSS-E



1/8 - 3/4

G(BSP)	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of flutes		Pack Qty	E043
1/8	28	9.728	90	15	8.0	6.3	9	3	8.80	1	0569917
1/4	19	13.157	100	19	10.0	8.0	11	3	11.80	1	0569924
3/8	19	16.662	100	21	12.5	10.0	13	4	15.25	1	0569931
1/2	14	20.955	125	26	16.0	12.5	16	4	19.00	1	0569948
3/4	14	26.441	140	28	20.0	16.0	20	4	24.50	1	0569955

**Note:** ISO shank and square dimensions will necessitate metric holders

## General Purpose

**1500**  
**1500S**  
**1528**  
**1528S**

The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications. Available in 3 chamfer lengths - taper, plug, and bottoming.

Taper - 7-10 pitch chamfer length

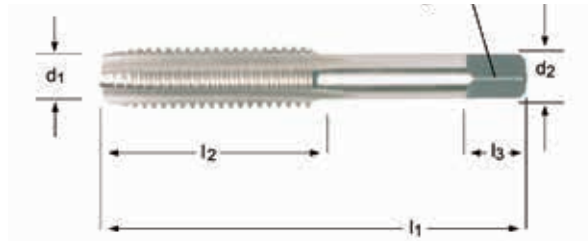
Plug - 3-5 pitch chamfer length

Bottoming - 1-2 pitch chamfer length

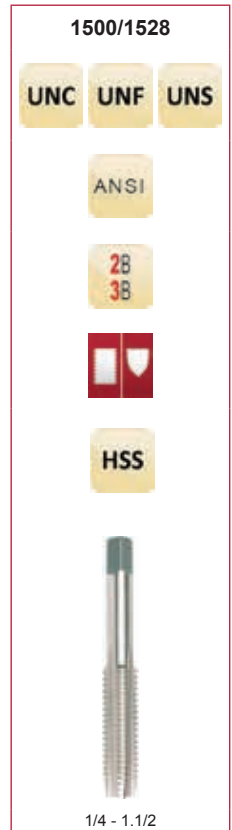
1500 - Fractional sizes

1528 - Machine screw sizes

1500S / 1528S - Sets include 1 of each tap (Taper, Plug, and Bottoming)



- Sizes 0 thru 3/8 have male centers on thread end
- Sizes larger than 3/8 all have female centers / flat ends



Nominal d <sub>1</sub>	TPI UNC	TPI UNF	TPI UNS	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	∠ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming	Sets
0		80		1.5/8	5/16	0.1410	0.1100	3/16	2	H1	1	1010593	1010594	1010596	1010999
0		80		1.5/8	5/16	0.1410	0.1100	3/16	2	H2	1	—	1010595	1010597	—
1	64			1.11/16	3/8	0.1410	0.1100	3/16	2	H1	1	1010598	1010599	1010601	1011000
1		72		1.11/16	3/8	0.1410	0.1100	3/16	2	H1	1	1010603	1010604	1010606	1011001
2	56			1.3/4	7/16	0.1410	0.1100	3/16	2	H2	1	—	1010615	1010617	—
2	56			1.3/4	7/16	0.1410	0.1100	3/16	3	H1	1	1010608	1010610	1010612	—
2	56			1.3/4	7/16	0.1410	0.1100	3/16	3	H2	1	1010609	1010611	1010613	1011003
2		64		1.3/4	7/16	0.1410	0.1100	3/16	3	H2	1	—	—	—	1011073
3	48			1.13/16	1/2	0.1410	0.1100	3/16	2	H2	1	—	1010631	—	—
3	48			1.13/16	1/2	0.1410	0.1100	3/16	3	H2	1	1010625	1010627	1010629	1011005
3		56		1.13/16	1/2	0.1410	0.1100	3/16	3	H2	1	1010634	1010636	1010637	1011074
4	40			1.7/8	9/16	0.1410	0.1100	3/16	2	H2	1	—	1010650	1010652	—
4	40			1.7/8	9/16	0.1410	0.1100	3/16	3	H1	1	1010643	1010645	1010647	—
4	40			1.7/8	9/16	0.1410	0.1100	3/16	3	H2	1	1010644	1010646	1010648	1011008
4		48		1.7/8	9/16	0.1410	0.1100	3/16	3	H2	1	1010653	1010655	1010656	1011075
4			36	1.7/8	9/16	0.1410	0.1100	3/16	3	H2	1	—	—	—	1011006
5	40			1.15/16	5/8	0.1410	0.1100	3/16	3	H2	1	1010660	1010662	1010664	1011010
5		44		1.15/16	5/8	0.1410	0.1100	3/16	3	H2	1	1010669	1010671	1010672	1011076
6	32			2"	11/16	0.1410	0.1100	3/16	2	H2	1	—	1010685	1010688	—
6	32			2"	11/16	0.1410	0.1100	3/16	2	H3	1	—	1010686	1010689	—
6	32			2"	11/16	0.1410	0.1100	3/16	3	H1	1	1010675	1010678	1010681	—
6	32			2"	11/16	0.1410	0.1100	3/16	3	H2	1	1010676	1010679	1010682	1011012
6	32			2"	11/16	0.1410	0.1100	3/16	3	H3	1	1010677	1010680	1010683	1011013
6		40		2"	11/16	0.1410	0.1100	3/16	3	H2	1	1010690	1010692	1010693	1011014

# HAND TAPS



Nominal d <sub>1</sub>	TPI UNC	TPI UNF	TPI UNS	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	□ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming	Sets
8	32			2.1/8	3/4	0.1680	0.1310	1/4	2	H2	1	—	1010706	1010709	—
8	32			2.1/8	3/4	0.1680	0.1310	1/4	2	H3	1	—	1010707	1010710	—
8	32			2.1/8	3/4	0.1680	0.1310	1/4	3	H2	1	—	1010712	1010715	—
8	32			2.1/8	3/4	0.1680	0.1310	1/4	3	H3	1	—	1010713	1010716	—
8	32			2.1/8	3/4	0.1680	0.1310	1/4	4	H1	1	—	1010699	—	—
8	32			2.1/8	3/4	0.1680	0.1310	1/4	4	H2	1	1010697	1010700	1010703	1011016
<b>8</b>	<b>32</b>			<b>2.1/8</b>	<b>3/4</b>	<b>0.1680</b>	<b>0.1310</b>	<b>1/4</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010698</b>	<b>1010701</b>	<b>1010704</b>	<b>1011017</b>
<b>8</b>		<b>36</b>		<b>2.1/8</b>	<b>3/4</b>	<b>0.1680</b>	<b>0.1310</b>	<b>1/4</b>	<b>4</b>	<b>H2</b>	<b>1</b>	<b>1010717</b>	<b>1010719</b>	<b>1010720</b>	<b>1011018</b>
10	24			2.3/8	7/8	0.1940	0.1520	1/4	2	H2	1	—	1010733	1010736	—
10	24			2.3/8	7/8	0.1940	0.1520	1/4	2	H3	1	—	1010734	1010737	—
10	24			2.3/8	7/8	0.1940	0.1520	1/4	3	H2	1	—	1010739	—	—
10	24			2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	—	1010740	1010743	—
10	24			2.3/8	7/8	0.1940	0.1520	1/4	4	H1	1	—	1010726	—	—
10	24			2.3/8	7/8	0.1940	0.1520	1/4	4	H2	1	1010724	1010727	1010730	1011020
<b>10</b>	<b>24</b>			<b>2.3/8</b>	<b>7/8</b>	<b>0.1940</b>	<b>0.1520</b>	<b>1/4</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010725</b>	<b>1010728</b>	<b>1010731</b>	<b>1011021</b>
10		32		2.3/8	7/8	0.1940	0.1520	1/4	2	H2	1	—	1010754	1010757	—
10		32		2.3/8	7/8	0.1940	0.1520	1/4	2	H3	1	—	1010755	1010758	—
10		32		2.3/8	7/8	0.1940	0.1520	1/4	3	H2	1	—	1010760	1010763	—
10		32		2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	—	1010761	1010764	—
10		32		2.3/8	7/8	0.1940	0.1520	1/4	4	H2	1	1010745	1010748	1010751	1011023
<b>10</b>		<b>32</b>		<b>2.3/8</b>	<b>7/8</b>	<b>0.1940</b>	<b>0.1520</b>	<b>1/4</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010746</b>	<b>1010749</b>	<b>1010752</b>	<b>1011024</b>
<b>12</b>	<b>24</b>			<b>2.3/8</b>	<b>15/16</b>	<b>0.2200</b>	<b>0.1650</b>	<b>9/32</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010765</b>	<b>1010767</b>	<b>1010768</b>	<b>1011025</b>
<b>12</b>		<b>28</b>		<b>2.3/8</b>	<b>15/16</b>	<b>0.2200</b>	<b>0.1650</b>	<b>9/32</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010769</b>	<b>1010771</b>	<b>1010772</b>	<b>1011026</b>
1/4	20			2.1/2	1"	0.2550	0.1910	5/16	4	H1	1	1010001	1010004	1010008	—
1/4	20			2.1/2	1"	0.2550	0.1910	5/16	4	H2	1	1010002	1010005	1010009	—
<b>1/4</b>	<b>20</b>			<b>2.1/2</b>	<b>1"</b>	<b>0.2550</b>	<b>0.1910</b>	<b>5/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010003</b>	<b>1010006</b>	<b>1010010</b>	<b>1011029</b>
1/4	20			2.1/2	1"	0.2550	0.1910	5/16	4	H5	1	—	1010007	1010011	—
1/4		28		2.1/2	1"	0.2550	0.1910	5/16	4	H2	1	—	1010016	1010020	—
<b>1/4</b>		<b>28</b>		<b>2.1/2</b>	<b>1"</b>	<b>0.2550</b>	<b>0.1910</b>	<b>5/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010014</b>	<b>1010017</b>	<b>1010021</b>	<b>1011032</b>
1/4		28		2.1/2	1"	0.2550	0.1910	5/16	4	H4	1	—	1010018	1010022	—
5/16	18			2.23/32	1.1/8	0.3180	0.2380	3/8	4	H2	1	1010024	1010027	1010031	—
<b>5/16</b>	<b>18</b>			<b>2.23/32</b>	<b>1.1/8</b>	<b>0.3180</b>	<b>0.2380</b>	<b>3/8</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010025</b>	<b>1010028</b>	<b>1010032</b>	<b>1011035</b>
<b>5/16</b>		<b>24</b>		<b>2.23/32</b>	<b>1.1/8</b>	<b>0.3180</b>	<b>0.2380</b>	<b>3/8</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010036</b>	<b>1010039</b>	<b>1010043</b>	<b>1011038</b>
3/8	16			2.15/16	1.1/4	0.3810	0.2860	7/16	4	H2	1	1010046	1010049	1010053	—
<b>3/8</b>	<b>16</b>			<b>2.15/16</b>	<b>1.1/4</b>	<b>0.3810</b>	<b>0.2860</b>	<b>7/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010047</b>	<b>1010050</b>	<b>1010054</b>	<b>1011041</b>
3/8	16			2.15/16	1.1/4	0.3810	0.2860	7/16	4	H5	1	—	1010051	1010055	—
<b>3/8</b>		<b>24</b>		<b>2.15/16</b>	<b>1.1/4</b>	<b>0.3810</b>	<b>0.2860</b>	<b>7/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010058</b>	<b>1010061</b>	<b>1010065</b>	<b>1011044</b>
<b>7/16</b>	<b>14</b>			<b>3.5/32</b>	<b>1.7/16</b>	<b>0.3230</b>	<b>0.2420</b>	<b>13/32</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010067</b>	<b>1010070</b>	<b>1010074</b>	<b>1011045</b>
<b>7/16</b>		<b>20</b>		<b>3.5/32</b>	<b>1.7/16</b>	<b>0.3230</b>	<b>0.2420</b>	<b>13/32</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010076</b>	<b>1010079</b>	<b>1010083</b>	<b>1011046</b>
1/2	13			3.3/8	1.21/32	0.3670	0.2750	7/16	4	H2	1	—	1010087	1010091	—
<b>1/2</b>	<b>13</b>			<b>3.3/8</b>	<b>1.21/32</b>	<b>0.3670</b>	<b>0.2750</b>	<b>7/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010085</b>	<b>1010088</b>	<b>1010092</b>	<b>1011047</b>
1/2	13			3.3/8	1.21/32	0.3670	0.2750	7/16	4	H5	1	—	1010089	1010093	—
<b>1/2</b>		<b>20</b>		<b>3.3/8</b>	<b>1.21/32</b>	<b>0.3670</b>	<b>0.2750</b>	<b>7/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010094</b>	<b>1010097</b>	<b>1010101</b>	<b>1011048</b>
<b>9/16</b>	<b>12</b>			<b>3.19/32</b>	<b>1.21/32</b>	<b>0.4290</b>	<b>0.3220</b>	<b>1/2</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010103</b>	<b>1010106</b>	<b>1010108</b>	<b>1011049</b>
<b>9/16</b>		<b>18</b>		<b>3.19/32</b>	<b>1.21/32</b>	<b>0.4290</b>	<b>0.3220</b>	<b>1/2</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010110</b>	<b>1010113</b>	<b>1010116</b>	<b>1011050</b>
<b>5/8</b>	<b>11</b>			<b>3.13/16</b>	<b>1.13/16</b>	<b>0.4800</b>	<b>0.3600</b>	<b>9/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010118</b>	<b>1010121</b>	<b>1010123</b>	<b>1011051</b>
<b>5/8</b>		<b>18</b>		<b>3.13/16</b>	<b>1.13/16</b>	<b>0.4800</b>	<b>0.3600</b>	<b>9/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010125</b>	<b>1010128</b>	<b>1010131</b>	<b>1011052</b>
<b>11/16</b>			<b>11</b>	<b>4.1/32</b>	<b>1.13/16</b>	<b>0.5420</b>	<b>0.4060</b>	<b>5/8</b>	<b>4</b>	<b>H3</b>	<b>1</b>	—	—	—	<b>1011053</b>
<b>11/16</b>			<b>16</b>	<b>4.1/32</b>	<b>1.13/16</b>	<b>0.5420</b>	<b>0.4060</b>	<b>5/8</b>	<b>4</b>	<b>H3</b>	<b>1</b>	—	—	—	<b>1011054</b>
<b>3/4</b>	<b>10</b>			<b>4.1/4</b>	<b>2"</b>	<b>0.5900</b>	<b>0.4420</b>	<b>11/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010139</b>	<b>1010142</b>	<b>1010144</b>	<b>1011055</b>
<b>3/4</b>		<b>16</b>		<b>4.1/4</b>	<b>2"</b>	<b>0.5900</b>	<b>0.4420</b>	<b>11/16</b>	<b>4</b>	<b>H3</b>	<b>1</b>	<b>1010146</b>	<b>1010149</b>	<b>1010152</b>	<b>1011056</b>
<b>7/8</b>	<b>9</b>			<b>4.11/16</b>	<b>2.7/32</b>	<b>0.6970</b>	<b>0.5230</b>	<b>3/4</b>	<b>4</b>	<b>H4</b>	<b>1</b>	<b>1010154</b>	<b>1010157</b>	<b>1010159</b>	<b>1011057</b>
<b>7/8</b>		<b>14</b>		<b>4.11/16</b>	<b>2.7/32</b>	<b>0.6970</b>	<b>0.5230</b>	<b>3/4</b>	<b>4</b>	<b>H4</b>	<b>1</b>	<b>1010160</b>	<b>1010163</b>	<b>1010166</b>	<b>1011058</b>



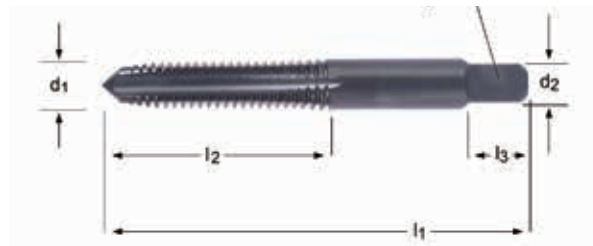
# HAND TAPS

Nominal d <sub>1</sub>	TPI UNC	TPI UNF	TPI UNS	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	□ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming	Sets
1"	8			5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	1	1010167	1010170	1010172	1011059
1"		12		5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	1	1010173	1010174	1010175	1011060
1"			14	5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	1	1010176	1010178	1010181	1011061
1.1/8	7			5.7/16	2.9/16	0.8960	0.6720	7/8	4	H4	1	1010182	1010183	1010184	1011062
1.1/8		12		5.7/16	2.9/16	0.8960	0.6720	7/8	4	H4	1	1010185	1010186	1010187	1011063
1.1/4	7			5.3/4	2.9/16	1.0210	0.7660	1"	4	H4	1	1010188	1010189	1010190	1011064
1.1/4		12		5.3/4	2.9/16	1.0210	0.7660	1"	6	H4	1	1010191	1010192	1010193	1011065
1.3/8	6			6.1/16	3"	1.1000	0.8310	1.1/16	4	H4	1	1010194	1010195	1010196	1011066
1.3/8		12		6.1/16	3"	1.1000	0.8310	1.1/16	6	H4	1	1010197	1010198	1010199	1011067
1.1/2	6			6.3/8	3"	1.2300	0.9250	1.1/8	4	H4	1	1010200	1010201	1010202	1011068
1.1/2		12		6.3/8	3"	1.2300	0.9250	1.1/8	6	H4	1	1010203	1010204	1010205	1011069

# HAND TAPS

## General Purpose

**1500A** Similar in design to the standard 1500 series, but steam oxide treated to reduce wear and chip welding in harder ferrous materials. Not recommended for non-ferrous applications. For through or blind hole tapping.



<sup>1)</sup> Male centers on thread end

<sup>2)</sup> Female centers / flat ends


**1500A**

**UNC UNF**

**ANSI**

**3B**

**HSS**



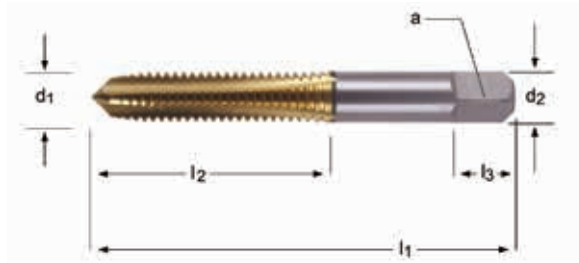
1/4 - 1"

			$l_1$	$l_2$	$d_2$	$\square$	$l_3$	# of Flutes	Limits	Chamfer	Pack Qty	1500A
UNC	UNF	TPI	Inch	Inch	Ø Inch	a Inch	Inch					
1/4		20	2.1/2	1.000	0.2550	0.1910	5/16	4	H3	Plug	1	1050006 <sup>1)</sup>
	1/4	28	2.1/2	1.000	0.2550	0.1910	5/16	4	H3	Bottoming	1	1050021 <sup>1)</sup>
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1050039 <sup>1)</sup>
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1050028 <sup>1)</sup>
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1050061 <sup>1)</sup>
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1050050 <sup>1)</sup>
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1050079 <sup>2)</sup>
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1050070 <sup>2)</sup>
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1050097 <sup>2)</sup>
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1050088 <sup>2)</sup>
	9/16	18	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	Plug	1	1050113 <sup>2)</sup>
9/16		12	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	Plug	1	1050106 <sup>2)</sup>
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1	1050128 <sup>2)</sup>
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1	1050121 <sup>2)</sup>
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Plug	1	1050149 <sup>2)</sup>
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Plug	1	1050142 <sup>2)</sup>
	7/8	14	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1	1050163 <sup>2)</sup>
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1	1050157 <sup>2)</sup>
1"		8	5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	Plug	1	1050170 <sup>2)</sup>

## General Purpose

### TN1500

Similar in design to the 1500 series but TiN coated for enhanced performance. The hard, smooth finish provides greater lubricity, increases tool life, improves thread flank finish, and allows higher tapping speeds. For through or blind hole tapping.



<sup>1)</sup> Male centers on thread end

<sup>2)</sup> Female centers / flat ends

**TN1500**

**UNC UNF**

ANSI

3B

HSS

1/4 - 7/8

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	TN1500
	1/4	28	2.1/2	1.0000	0.2550	0.1910	5/16	4	H3	Plug	1	1060017 <sup>1)</sup>
1/4		20	2.1/2	1.0000	0.2550	0.1910	5/16	4	H3	Plug	1	1060006 <sup>1)</sup>
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1060039 <sup>1)</sup>
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1060028 <sup>1)</sup>
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1060061 <sup>1)</sup>
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1060050 <sup>1)</sup>
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1060079 <sup>2)</sup>
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1060070 <sup>2)</sup>
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1060097 <sup>2)</sup>
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1060088 <sup>2)</sup>
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Bottoming	1	1060092 <sup>2)</sup>
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1	1060121 <sup>2)</sup>
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Bottoming	1	1060131 <sup>2)</sup>
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Bottoming	1	1060123 <sup>2)</sup>
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Bottoming	1	1060152 <sup>2)</sup>
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Bottoming	1	1060144 <sup>2)</sup>
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1	1060157 <sup>2)</sup>

## General Purpose

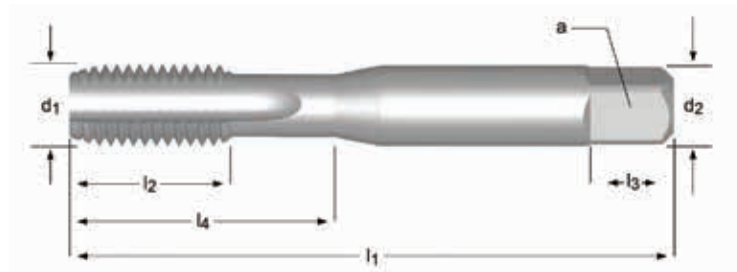
**E500** The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications. Available in 3 chamfer lengths - taper, plug, and semi-bottoming.

Taper - 7-10 pitch chamfer length

Plug - 3-5 pitch chamfer length

Semi-Bottoming - 1-2 pitch chamfer length

Sets include 1 of each tap (Taper, Plug, and Bottoming)



E500

M

ISO  
529

6H




HSS



M1 - M56

**Note: ISO shank and square dimensions will necessitate metric holders**

Nominal d <sub>1</sub>	Pitch M	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	↔ mm	l <sub>4</sub> mm	Pack Qty	Taper	Plug	Semi - Bottoming	Sets
1	0.25	38	4.5	2.50	2.00	4	2	0.75	4.5	1	0160152	0160169	0122464	—
1.2	0.25	38	4.5	2.50	2.00	4	2	0.95	4.5	1	0160176	0160183	0122471	—
1.4	0.30	40	6	2.50	2.00	4	2	0.95	6	1	0160190	0160206	0122488	—
1.6	0.35	41	8	2.50	2.00	4	2	1.25	8	1	0155035	0139950	0093900	0155028
1.7	0.35	41	8	2.50	2.00	4	2	1.35	8	1	0155004	0093924	0093931	0154991
1.8	0.35	41	8	2.50	2.00	4	2	1.45	8	1	0154960	0093948	0093955	—
2	0.40	41	8	2.50	2.00	4	3	1.6	8	1	0094259	0094266	0094273	0154939
2	0.45	41	8	2.50	2.00	4	3	1.55	8	1	0160244	0160251	0160268	—
2.2	0.45	44.5	9.5	2.80	2.24	5	3	1.75	9.5	1	0154915	0094167	0094174	—
2.3	0.45	44.5	9.5	2.80	2.24	5	3	1.85	9.5	1	0154885	0094198	0094204	—
2.5	0.45	44.5	9.5	2.80	2.24	5	3	2.05	9.5	1	0154854	0094228	0094235	0154847
2.6	0.45	44.5	9.5	2.80	2.24	5	3	2.15	9.5	1	0156735	0156742	0122440	—
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	1	0154823	0094440	0094457	0094464
3	0.60	48	12.5	3.15	2.50	5	3	2.4	12.5	1	0159927	0159934	0159941	—
3.5	0.60	50	14	3.55	2.80	5	3	2.9	14	1	0094402	0094419	0094426	0154809
4	0.70	53	14	4.00	3.15	6	3	3.3	14	1	0154786	0094648	0094655	0094662
4	0.75	53	14	4.00	3.15	6	3	3.25	14	1	0160213	0160220	0160237	—
4.5	0.75	53	9.5	4.50	3.55	6	3	3.8	18	1	0154762	0094617	0094624	0154755
5	0.80	58	11	5.00	4.00	7	3	4.2	22	1	0154731	0094761	0094778	0154724
5	0.90	58	11	5.00	4.00	7	3	4.1	22	1	0159958	0159965	0159972	—
5.5	0.90	62	12	5.60	4.50	7	3	4.6	21	1	0159996	0160008	0160015	—
6	1.00	66	13	6.30	5.00	8	3	5	26	1	0094808	0094815	0094822	0154700
7	1.00	66	13	7.10	5.60	8	3	6	26	1	0154687	0139967	0094846	0094853
8	1.25	72	16	8.00	6.30	9	3	6.8	29	1	0154663	0094877	0094884	0094891
9	1.25	72	16	9.00	7.10	10	3	7.8	29	1	0154649	0152119	0094914	0154632
10	1.50	80	18	10.00	8.00	11	3	8.5	34	1	0153246	0093979	0093986	0154618
11	1.50	85	19	8.00	6.30	9	3	9.5		1	0154595	0094006	0094013	0154588
12	1.75	89	22	9.00	7.10	10	3	10.3		1	0154564	0094037	0094044	0094051
14	2.00	95	24	11.20	9.00	12	4	12		1	0152980	0094075	0094082	0154540
16	2.00	102	24	12.50	10.00	13	4	14		1	0154526	0094105	0094112	0154519
18	2.50	112	29	14.00	11.20	14	4	15.5		1	0154496	0094136	0094143	0154489
20	2.50	112	29	14.00	11.20	14	4	17.5		1	0154465	0150719	0094297	0154458

Nominal d <sub>1</sub>	Pitch M	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes		l <sub>4</sub> mm	Pack Qty	Taper	Plug	Semi - Bottoming	Sets
22	2.50	118	29	16.00	12.50	16	4	19.5		1	0154434	0094310	0094327	0154427
24	3.00	130	35	18.00	14.00	18	4	21		1	0154403	0094341	0094358	0154397
27	3.00	135	35	20.00	16.00	20	4	24		1	0154366	0094365	0094372	—
30	3.50	138	41	20.00	16.00	20	4	26.5		1	0154359	0094488	0094495	—
33	3.50	151	41	22.40	18.00	22	4	29.5		1	0154342	0152225	0094525	—
36	4.00	162	47	25.00	20.00	24	4	32		1	0154335	0094549	0094556	—
39	4.00	170	47	28.00	22.40	26	4	35		1	0154328	0152232	0094587	—
42	4.50	170	53	28.00	22.40	26	6	37.5		1	0154311	0152249	0094686	—
45	4.50	187	54	31.50	25.00	28	6	40.5		1	0154304	0152256	0094709	—
48	5.00	187	60	31.50	25.00	28	6	43		1	0154298	0152263	0094730	—
52	5.00	200	60	35.50	28.00	31	6	47		1	—	—	0094792	—
56	5.50	200	60	35.50	28.00	31	6	50.5		1	—	—	0122457	—

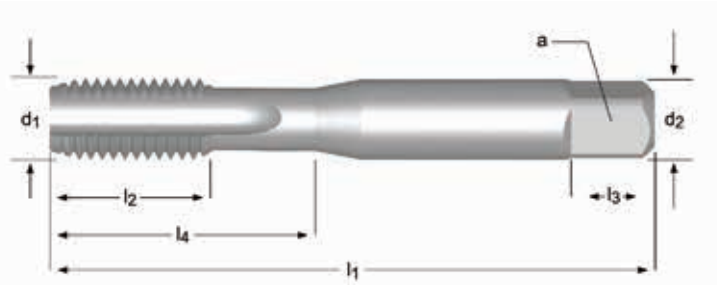
**Note: ISO shank and square dimensions will necessitate metric holders**

## General Purpose

**E513** The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications. Available in 3 chamfer lengths - taper, plug, and semi-bottoming.

- Taper - 7-10 pitch chamfer length
- Plug - 3-5 pitch chamfer length
- Semi-Bottoming - 1-2 pitch chamfer length

3 pc.(No.6) sets include 1 of each tap (Taper, Plug and Bottoming)  
 2 pc.(No.7) sets include 1 of each tap (Plug and Bottoming)



E513

MF

ISO 529

6H




HSS



M3 - M50

Note: ISO shank and square dimensions will necessitate metric holders

Nominal d <sub>1</sub>	Pitch MF	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	# of Flutes	l <sub>3</sub> mm	l <sub>4</sub> mm	Pack Qty	Taper	Plug	Semi - Bottoming	2 Pc Sets	3 Pc Sets	
3	0.35	48	12.5	3.15	2.50	3	5	2.65	12.5	1	0160039	0160046	0096567	—	—
3.5	0.35	48	12.5	3.15	2.50	3	5	3.2	12.5	1	—	—	0343111	—	—
4	0.50	53	14	4.00	3.15	3	6	3.5	14	1	0156766	0152454	0096680	0155561	—
5	0.50	58	11	5.00	4.00	3	7	4.5	22	1	0156728	0096727	0096734	0096741	—
5	0.75	58	11	5.00	4.00	3	7	4.3	22	1	0157046	0156773	0123027	—	—
6	0.50	66	13	6.30	5.00	3	8	5.5	26	1	0156780	0156797	0123034	—	—
6	0.75	66	13	6.30	5.00	3	8	5.3	26	1	0156803	0152461	0096765	0096772	—
7	0.75	66	13	7.10	5.60	3	8	6.3	26	1	0160053	0096789	0096796	—	—
8	0.50	72	16	8.00	6.30	3	9	7.5	29	1	0160060	0160077	0123058	—	—
8	0.75	72	16	8.00	6.30	3	9	7.3	29	1	0157053	0152478	0096802	0096819	—
8	1.00	72	16	8.00	6.30	3	9	7	29	1	0157060	0152485	0096826	0155554	—
9	0.75	72	16	9.00	7.10	3	10	8.3	29	1	—	—	0343128	—	—
9	1.00	72	16	9.00	7.10	3	10	8	29	1	0159644	0155752	0096833	—	—
10	0.50	80	18	10.00	8.00	3	11	9.5	34	1	—	—	0343135	—	—
10	0.75	80	18	10.00	8.00	3	11	9.3	34	1	0160084	0160091	0123065	—	—
10	1.00	80	18	10.00	8.00	3	11	9	34	1	0157077	0152492	0096086	0155547	0157084
10	1.25	80	18	10.00	8.00	3	11	8.8	34	1	0157091	0152508	0096079	0155530	0157107
11	0.75	85	19	8.00	6.30	3	9	10.3	—	1	0160107	0160114	0123072	—	—
11	1.00	85	19	8.00	6.30	3	9	10	—	1	0159651	0096093	0096109	—	—
11	1.25	85	19	8.00	6.30	3	9	9.8	—	1	—	—	0343142	—	—
12	0.75	89	22	9.00	7.10	3	10	11.3	—	1	—	—	0343166	—	—
12	1.00	89	22	9.00	7.10	3	10	11	—	1	0157114	0152515	0096154	0155523	—
12	1.25	89	22	9.00	7.10	3	10	10.8	—	1	0157121	0152522	0096116	0096123	0157138
12	1.50	89	22	9.00	7.10	3	10	10.5	—	1	0157145	0096130	0096147	0155516	0157152
13	1.50	89	22	9.00	7.10	3	10	11.5	—	1	—	—	0343173	—	—
14	1.00	95	24	11.20	9.00	4	12	13	—	1	0156810	0152539	0096185	0155509	—
14	1.25	95	24	11.20	9.00	4	12	12.8	—	1	0156827	0152546	0096161	—	0156834
14	1.50	95	24	11.20	9.00	4	12	12.5	—	1	0156841	0152553	0096178	0155486	0156858
15	1.50	95	24	11.20	9.00	4	12	13.5	—	1	—	0096192	0096208	—	—
16	1.00	102	24	12.50	10.00	4	13	15	—	1	0156865	0152560	0096246	0096253	—
16	1.25	102	24	12.50	10.00	4	13	14.8	—	1	—	—	0343203	—	—
16	1.50	102	24	12.50	10.00	4	13	14.5	—	1	0156872	0152577	0096222	0096239	0156889

Nominal d <sub>1</sub>	Pitch MF	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> ∅ mm	□ a mm	# of Flutes	l <sub>3</sub> mm	 mm	l <sub>4</sub> mm	Pack Qty	Taper	Plug	Semi - Bottoming	2 Pc Sets	3 Pc Sets
18	1.00	112	29	14.00	11.20	4	14	17		1	0156896	0096277	0096284	0096291	—
18	1.50	112	29	14.00	11.20	4	14	16.5		1	0156902	0152584	0096260	0155479	0156919
18	2.00	112	29	14.00	11.20	4	14	16		1	0156926	0096307	0096314	0096321	—
20	1.00	112	29	14.00	11.20	4	14	19		1	0156933	0096345	0096352	0096369	—
20	1.50	112	29	14.00	11.20	4	14	18.5		1	0156940	0152591	0096338	0155462	0156957
20	2.00	112	29	14.00	11.20	4	14	18		1	0156964	0096376	0096383	0155455	—
22	1.00	118	29	16.00	12.50	4	16	21		1	—	0096406	0096413	0155448	—
22	1.50	118	29	16.00	12.50	4	16	20.5		1	0156971	0152607	0096390	0155431	—
22	2.00	118	29	16.00	12.50	4	16	20		1	0156988	0096420	0096437	0096444	—
24	1.00	130	35	18.00	14.00	4	18	23		1	—	0096475	0096482	—	—
24	1.50	130	35	18.00	14.00	4	18	22.5		1	0156995	0152614	0096451	0096468	—
24	2.00	130	35	18.00	14.00	4	18	22		1	0157008	0096499	0096505	0155745	—
25	1.50	130	35	18.00	14.00	4	18	23.5		1	0157015	0152621	0096512	0150740	0157022
26	1.50	130	35	18.00	14.00	4	18	24.5		1	—	0096529	0096536	—	—
27	1.50	135	35	20.00	16.00	4	20	25.5		1	—	0155738	0123010	—	—
27	2.00	135	35	20.00	16.00	4	20	25		1	—	—	0123041	—	—
28	1.50	138	35	20.00	16.00	4	20	26.5		1	—	0096543	0096550	—	—
30	1.50	138	41	20.00	16.00	4	20	28.5		1	—	0096574	0096581	—	—
30	2.00	138	41	20.00	16.00	4	20	28		1	—	0155721	0123003	—	—
32	1.50	151	41	22.40	18.00	4	22	30.5		1	0157039	0155578	0096598	—	—
33	2.00	151	41	22.40	18.00	4	22	31		1	—	0096604	0096611	—	—
35	1.50	162	47	25.00	20.00	4	24	33.5		1	—	0096628	0096635	—	—
36	1.50	162	47	25.00	20.00	4	24	34.5		1	—	—	0343302	—	—
36	2.00	162	47	25.00	20.00	4	24	34		1	—	0152638	0096642	—	—
36	3.00	162	47	25.00	20.00	4	24	33		1	—	0096659	0096666	—	—
39	3.00	170	47	28.00	22.40	4	26	36		1	—	0152645	0096673	—	—
40	1.50	170	53	28.00	22.40	6	26	38.5		1	—	0155691	0096697	—	—
42	1.50	170	53	28.00	22.40	6	26	40.5		1	—	0155684	0096703	—	—
42	3.00	170	53	28.00	22.40	6	26	39		1	—	—	0343319	—	—
45	1.50	187	54	31.50	25.00	6	28	43.5		1	—	0155677	0096710	—	—
48	1.50	187	60	31.50	25.00	6	28	46.5		1	—	—	0343333	—	—
48	2.00	187	60	31.50	25.00	6	28	46		1	—	—	0343340	—	—
48	3.00	187	60	31.50	25.00	6	28	45		1	—	—	0343357	—	—
50	1.50	187	60	31.50	25.00	6	28	48.5		1	—	0155660	0096758	—	—

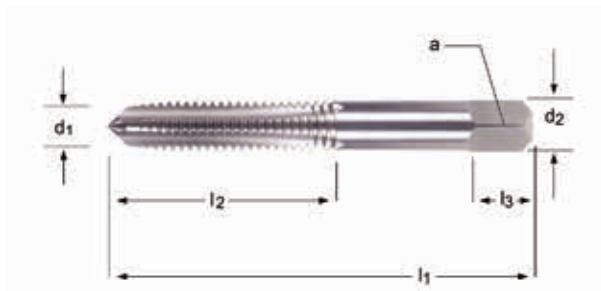
**Note: ISO shank and square dimensions will necessitate metric holders**

# HAND TAPS



## General Purpose, Left Hand

**1500L** Left Hand. Similar in design to the standard 1500 series but finished with left hand threads, which when viewed axially, wind in a counter-clockwise and receding direction. Available in plug chamfer. For through or blind hole applications.



**1500L**

UNC
UNF
UNS

ANSI

3B

HSS

1/4 - 1"

		$l_1$	$l_2$	$d_2$	$\square$	$l_3$			Pack Qty	1500L			
UNC	UNF	UNS	TPI	Inch	Inch	$\varnothing$	$a$	Inch	# of Flutes	Limits	Chamfer		
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	4	H3	Plug	1		1011775
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	4	H3	Plug	1		1011772
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1		1011781
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1		1011778
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1		1011787
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1		1011784
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1		1011793
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1		1011790
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1		1011799
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1		1011796
	9/16	18	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	Plug	1		1011805
9/16		12	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	Plug	1		1011802
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1		1011811
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1		1011808
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Plug	1		1011823
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Plug	1		1011820
	7/8	14	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1		1011829
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1		1011826
	1"	14	5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	Plug	1		1011838
1"		12	5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	Plug	1		1011835
1"		8	5.1/8	2.1/2	0.8000	0.6000	13/16	4	H4	Plug	1		1011832



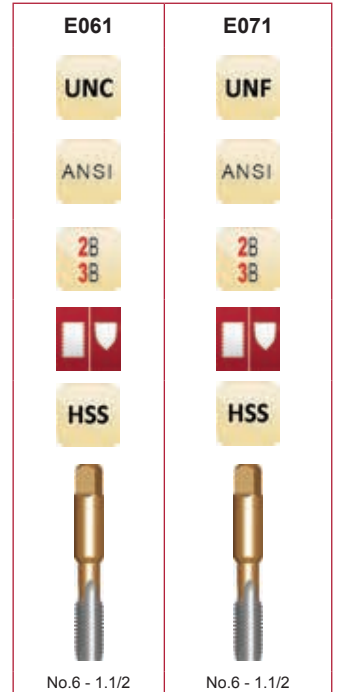
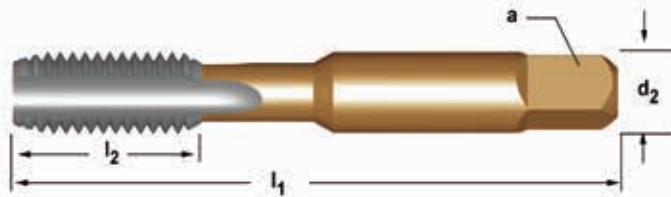
## General Purpose

**E061** The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications.  
**E071** Available in 3 chamfer lengths - taper, plug, and semi-bottoming.

Taper - 7-10 pitch chamfer length  
 Plug - 3-5 pitch chamfer length  
 Semi-Bottoming - 1-2 pitch chamfer length

Premium substrate with bronze oxide body and shank reduces rust and corrosion. Bright finish flutes improve chip flow in soft or non-ferrous materials.

*E061 = UNC Sizes, E071 = UNF Sizes*



Nominal d <sub>1</sub>	TP	TPI	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	□	# of	Flutes	Limits	l <sub>4</sub>	Pack Qty	Taper	Plug	Semi - Bottoming	Sets
d <sub>1</sub>	UNC	UNF	Inch	Inch	Inch /	a	Flutes	Limits	l <sub>4</sub>	Inch					
6	32	2"	0.5800	0.1410	0.1100	3	H3	36	2.85	0.5800	1	0348291	0348307	0348314	0348321
6		40 2"	0.5800	0.1410	0.1100	3	H2	33	2.90	0.5800	1	0349427	0349434	0349441	0349458
8	32	2.1/8	0.6500	0.1680	0.1310	4	H3	29	3.50	0.6500	1	0348284	0348338	0348345	0348352
8		36 2.1/8	0.6500	0.1680	0.1310	4	H2	29	3.50	0.6500	1	0349465	0349472	0349489	0349496
10	24	2.3/8	0.7600	0.1940	0.1520	4	H3	25	3.90	0.7600	1	0348369	0348376	0348383	0348390
10		32 2.3/8	0.7600	0.1940	0.1520	4	H3	21	4.10	0.7600	1	0349502	0349519	0349526	0349533
12	24	2.3/8	0.8100	0.2200	0.1650	4	H3	16	4.50	0.8100	1	0348406	0348413	0348420	0348437
12		28 2.3/8	0.8100	0.2200	0.1650	4	H3	15	4.70	0.8100	1	0349540	0349557	0349564	0349571
1/4	20	2.1/2	0.6500	0.2550	0.1910	4	H3	7	5.10	1.0630	1	0348444	0348451	0348468	0348475
1/4		28 2.1/2	0.6500	0.2550	0.1910	4	H3	3	5.50	1.0630	1	0349588	0349595	0349601	0349618
5/16	18	2.23/32	0.7700	0.3180	0.2380	4	H3	F	6.60	1.2598	1	0348482	0348499	0348505	0348512
5/16		24 2.23/32	0.7700	0.3180	0.2380	4	H3	I	6.90	1.2598	1	0349625	0349632	0349649	0349656
3/8	16	2.15/16	0.8100	0.3810	0.2860	4	H3	5/16	8.00	1.3780	1	0348529	0348536	0348543	0348550
3/8		24 2.15/16	0.8100	0.3810	0.2860	4	H3	Q	8.50	1.3780	1	0349663	0349670	0349687	0349694
7/16	14	3.5/32	0.9055	0.3230	0.2420	4	H3	U	9.40		1	0348567	0348574	0348581	0348598
7/16		20 3.5/32	0.9055	0.3230	0.2420	4	H3	25/64	9.90		1	0349700	0349717	0349724	0349731
1/2	13	3.3/8	0.9055	0.3670	0.2750	4	H3	27/64	10.80		1	0348604	0348611	0348628	0348635
1/2		20 3.3/8	0.9055	0.3670	0.2750	4	H3	29/64	11.50		1	0349748	0349755	0349762	0349779
9/16	12	3.19/32	0.9843	0.4290	0.3220	4	H3	27/64	12.20		1	0351833	0348642	0348659	0348666
9/16		18 3.19/32	0.9843	0.4290	0.3220	4	H3	33/64	12.90		1	0349786	0349793	0349809	0349816
5/8	11	3.13/16	0.9843	0.4800	0.3600	4	H3	17/32	13.50		1	0348673	0348680	0348697	0348703
5/8		18 3.13/16	0.9843	0.4800	0.3600	4	H3	37/64	14.50		1	0349823	0349830	0349847	0349854
3/4	10	4.1/4	1.1811	0.5900	0.4420	4	H3	21/32	16.50		1	0348710	0348727	0348734	0348741
3/4		16 4.1/4	1.1811	0.5900	0.4420	4	H3	11/16	17.50		1	0349861	0349878	0349885	0351932
7/8	9	4.11/16	1.1811	0.6970	0.5230	4	H4	49/64	19.50		1	0348758	0348765	0348772	0348789
7/8		14 4.11/16	1.1811	0.6970	0.5230	4	H4	13/16	20.40		1	0349892	0349908	0349915	0349922
1"	8	5.1/8	1.4173	0.8000	0.6000	4	H4	7/8	22.25		1	0348796	<sup>1)</sup> 0348802	<sup>1)</sup> 0348819	<sup>1)</sup> 0348826
1"		12 5.1/8	1.4173	0.8000	0.6000	4	H4	59/64	23.25		1	0349939	<sup>1)</sup> 0349946	<sup>1)</sup> 0349953	<sup>1)</sup> 0349960
1"		14 5.1/8	1.4173	0.8000	0.6000	4	H4	59/64	23.25		1	0349977	<sup>1)</sup> 0349984	<sup>1)</sup> 0349991	<sup>1)</sup> 0350003
1.1/8	7	5.7/16	1.3976	0.8950	0.6710	4	H4	63/64	25.00		1	0388112	<sup>1)</sup> 0388129	<sup>1)</sup> 0388136	<sup>1)</sup> 0259719
1.1/8		12 5.7/16	1.3976	0.8950	0.6710	4	H4	1.3/64	26.50		1	0388235	<sup>1)</sup> 0388242	<sup>1)</sup> 0388259	—
1.1/4	7	5.3/4	1.6338	1.0210	0.7650	4	H4	1.7/64	28.00		1	0388143	<sup>1)</sup> 0388150	<sup>1)</sup> 0388167	<sup>1)</sup> 0259702
1.1/4		12 5.3/4	1.6338	1.0210	0.7650	6	H4	1.5/32	29.50		1	0388266	<sup>1)</sup> 0388273	<sup>1)</sup> 0388280	—
1.3/8	6	6.1/16	1.8700	1.1090	0.8300	4	H4	1.7/32	30.75		1	0388174	<sup>1)</sup> 0388181	<sup>1)</sup> 0388198	—
1.3/8		12 6.1/16	1.8700	1.1090	0.8300	6	H4	1.9/32	32.75		1	0388297	<sup>1)</sup> 0388303	<sup>1)</sup> 0388310	—
1.1/2	6	6.3/8	1.8700	1.2330	0.9520	4	H4	1.11/32	34.00		1	0388204	<sup>1)</sup> 0388211	<sup>1)</sup> 0388228	<sup>1)</sup> 0259696
1.1/2		12 6.3/8	1.8700	1.2330	0.9250	6	H4	1.27/64	36.00		1	0388327	<sup>1)</sup> 0388334	<sup>1)</sup> 0388341	—

<sup>1)</sup> Bright Finish

# HAND TAPS

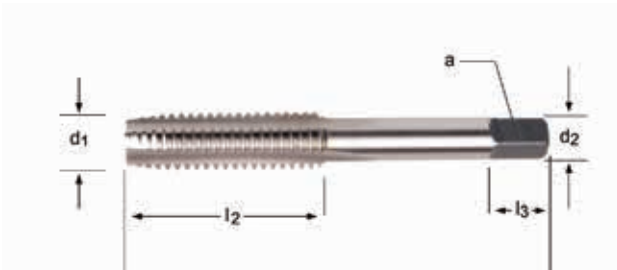


## General Purpose, Optional Flutes

**1508** - *Optional 3 Flute*

**1595** - *Optional 2 Flute*

Fewer flutes than standard, providing more space for chip evacuation and particularly when tapping holes greater than 1.5 tap diameters in depth. For through or blind hole applications.



1508 (UNC)	1508 (UNF)	1595
UNC	UNF	UNF UNC
ANSI	ANSI	ANSI
3B	2B 3B	3B
HSS	HSS	HSS
1/4 - 1/2	1/4 - 5/16	1/4 - 5/16

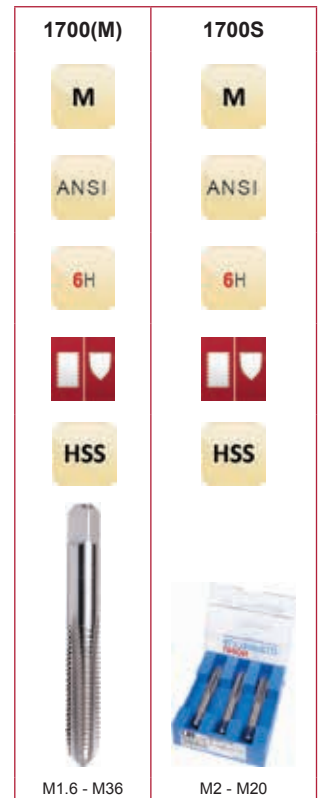
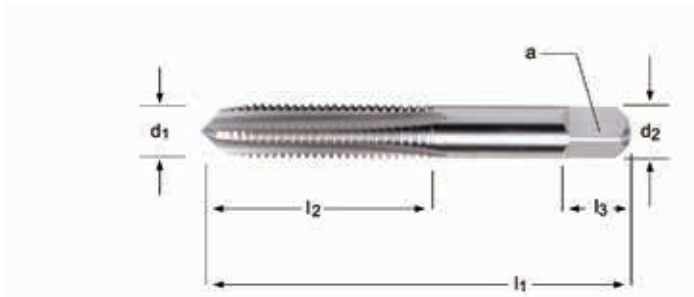
		$l_1$	$l_2$	$d_2$	$\square$	$l_3$				Pack Qty	1508(UNC)	1508(UNF)	1595	
UNC	UNF	TPI	Inch	Inch	$\varnothing$	$a$	Inch	Inch	# of Flutes	Limits	Chamfer			
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Plug	1	—	1010223	—
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	2	H3	Plug	1	—	—	1010208
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Plug	1	1010216	—	—
	1/4	20	2.1/2	1"	0.2550	0.1910	5/16	2	H3	Plug	1	—	—	1010206
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Bottoming	1	—	—	—
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	2	H3	Bottoming	1	—	—	1010209
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Bottoming	1	1010219	—	—
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	2	H3	Bottoming	1	—	—	1010207
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	Plug	1	—	1010236	—
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	Plug	1	1010230	—	—
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	2	H3	Plug	1	—	—	1010210
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	Bottoming	1	—	1010237	—
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	Bottoming	1	1010233	—	—
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	2	H3	Bottoming	1	—	—	1010211
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	Plug	1	—	1010246	—
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	Plug	1	1010240	—	—
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	Bottoming	1	—	1010247	—
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	Bottoming	1	1010243	—	—
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	Plug	1	—	1010250	—
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	Plug	1	1010248	—	—
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	Plug	1	—	1010254	—
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	Plug	1	1010252	—	—
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	Bottoming	1	1010253	—	—

## General Purpose

**1700(M)** The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications. Available in 3 chamfer lengths - taper, plug, and bottoming.

Taper - 7-10 pitch chamfer length  
 Plug - 3-5 pitch chamfer length  
 Bottoming - 1-2 pitch chamfer length

**1700S** Sets include 1 of each tap (Taper, Plug, and Bottoming).

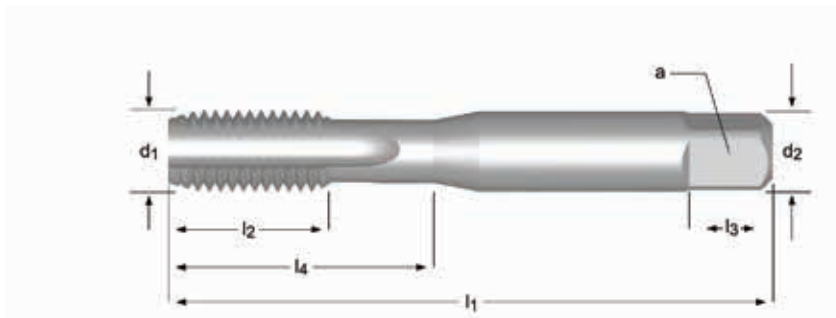


Nominal d <sub>1</sub>	Pitch M	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	l <sub>3</sub> Inch	∠ a Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming	Sets
M1.6	0.35	1.5/8	5/16	0.1410	3/16	0.1100	2	D3	1	1012408	1012409	1012410	—
M1.8	0.35	1.11/16	3/8	0.1410	3/16	0.1100	2	D3	1	1012411	1012412	—	—
M2	0.40	1.3/4	7/16	0.1410	3/16	0.1100	3	D3	1	1012414	1012415	1012416	1012558
M2.3	0.40	1.3/4	7/16	0.1410	3/16	0.1100	3	D3	1	—	1012421	1012422	—
M2.5	0.45	1.13/16	1/2	0.1410	3/16	0.1100	3	D3	1	1012423	1012424	1012425	1012560
M2.6	0.45	1.13/16	1/2	0.1410	3/16	0.1100	3	D3	1	1012426	1012427	—	—
M3	0.50	1.15/16	5/8	0.1410	3/16	0.1100	3	D3	1	1012432	1012433	1012434	1012561
M3.5	0.60	2"	11/16	0.1410	3/16	0.1100	3	D4	1	1012435	1012436	1012437	1012562
M4	0.70	2.1/8	3/4	0.1680	1/4	0.1310	4	D4	1	1012441	1012442	1012443	1012563
M4.5	0.75	2.3/8	7/8	0.1940	1/4	0.1520	4	D4	1	1012444	1012445	—	—
M5	0.80	2.3/8	7/8	0.1940	1/4	0.1520	4	D4	1	1012453	1012454	1012455	1012564
M6	1.00	2.1/2	1"	0.2550	5/16	0.1910	4	D5	1	1012459	1012460	1012461	1012565
M7	1.00	2.23/32	1.1/8	0.3180	3/8	0.2380	4	D5	1	1012465	1012466	1012467	1012576
M8	1.00	2.23/32	1.1/8	0.3180	3/8	0.2380	4	D5	1	1012468	1012469	1012470	1012577
M8	1.25	2.23/32	1.1/8	0.3180	3/8	0.2380	4	D5	1	1012471	1012472	1012473	1012566
M9	1.25	2.15/16	1.1/4	0.3810	7/16	0.2860	4	D5	1	—	1012478	1012479	—
M10	1.25	2.15/16	1.1/4	0.3810	7/16	0.2860	4	D5	1	1012480	1012481	1012482	1012578
M10	1.50	2.15/16	1.1/4	0.3810	7/16	0.2860	4	D6	1	1012483	1012484	1012485	1012567
M11	1.50	3.5/32	1.7/16	0.3230	13/32	0.2420	4	D6	1	—	1012493	1012494	—
M12	1.25	3.3/8	1.21/32	0.3670	7/16	0.2750	4	D5	1	1012498	1012499	1012500	1012579
M12	1.75	3.3/8	1.21/32	0.3670	7/16	0.2750	4	D6	1	1012495	1012496	1012497	1012568
M14	1.50	3.19/32	1.21/32	0.4290	1/2	0.3220	4	D6	1	1012501	1012502	1012503	—
M14	2.00	3.19/32	1.21/32	0.4290	1/2	0.3220	4	D7	1	1012504	1012505	1012506	1012580
M16	1.50	3.13/16	1.13/16	0.4800	9/16	0.3600	4	D6	1	1012513	1012514	1012515	—
M16	2.00	3.13/16	1.13/16	0.4800	9/16	0.3600	4	D7	1	1012516	1012517	1012518	1012581
M18	1.50	4.1/32	1.13/16	0.5420	5/8	0.4060	4	D6	1	1012522	1012523	1012524	—
M18	2.50	4.1/32	1.13/16	0.5420	5/8	0.4060	4	D7	1	1012525	1012526	1012527	1012582
M20	1.50	4.15/32	2"	0.6520	11/16	0.4890	4	D6	1	1012534	1012535	1012536	—
M20	2.50	4.15/32	2"	0.6520	11/16	0.4890	4	D7	1	1012537	1012538	1012539	1012583
M22	1.50	4.11/16	2.7/32	0.6970	3/4	0.5230	4	D6	1	1012540	1012541	1012542	—
M22	2.50	4.11/16	2.7/32	0.6970	3/4	0.5230	4	D7	1	1012543	1012544	1012545	—
M24	2.00	4.29/32	2.7/32	0.7600	3/4	0.5700	4	D7	1	1012546	1012547	1012548	—
M24	3.00	4.29/32	2.7/32	0.7600	3/4	0.5700	4	D8	1	1012555	1012556	1012557	—
M30	3.50	5.7/16	2.9/16	1.0210	1"	0.7660	4	D9	1	1012570	1012571	1012572	—
M36	4.00	6.1/16	3"	1.2330	1.1/8	0.9250	4	D9	1	—	1012574	1012575	—

## General Purpose, Left Hand

### E501

Left Hand. Similar in design to the standard E500 series but finished with left hand threads, which when viewed axially, wind in a counter-clockwise and receding direction. Available in taper, plug, and semi-bottoming chamfer. For through or blind hole applications.



E501

M

ISO  
529

6H



HSS



M3 - M24

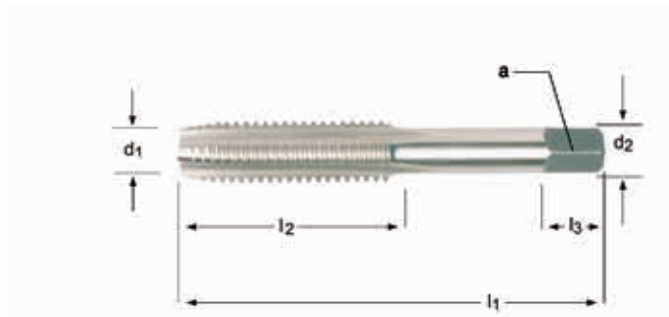
Nominal d <sub>1</sub>	Pitch M	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	Flute Width	l <sub>4</sub> mm	Limits	Pack Qty	Taper	Plug	Semi - Bottoming
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	D3	1	0159828	0095058	0095065
4	0.70	53	14	4.00	3.15	6	3	3.3	14	D4	1	0159835	0095072	0095089
5	0.80	58	11	5.00	4.00	7	3	4.2	22	D4	1	—	0095096	0095102
6	1.00	66	13	6.30	5.00	8	3	5	26	D5	1	0159859	0095119	0095126
8	1.25	72	16	8.00	6.30	9	3	6.8	29	D5	1	0159866	0095133	0095140
10	1.50	80	18	10.00	8.00	11	3	8.5	34	D6	1	0159873	0094938	0094945
12	1.75	89	22	9.00	7.10	10	3	10.3		D6	1	0159880	0094952	0094969
14	2.00	95	24	11.20	9.00	12	4	12		D7	1	0159897	0094976	0094983
16	2.00	102	24	12.50	10.00	13	4	14		D7	1	0159903	0094990	0095003
18	2.50	112	29	14.00	11.20	14	4	15.5		D7	1	—	—	0095010
20	2.50	112	29	14.00	11.20	14	4	17.5		D7	1	0159910	0095027	0095034
22	2.50	118	29	16.00	12.50	16	4	19.5		D7	1	—	—	0122495
24	3.00	130	35	18.00	14.00	18	4	21		D8	1	—	0152447	0095041

Note: ISO shank and square dimensions will necessitate metric holders

## General Purpose, Oversize

### 1500OV(UNC)

0.005" oversize. Similar in design to the standard 1500 series, but with a pitch diameter which is 0.0050" to 0.0055" larger than the basic pitch diameter. Used primarily where a part will be plated or treated after tapping. Available as a standard with a plug chamfer. Oversize P.D. limits are equivalent to H11. For through or blind hole applications.



1500OV(UNC)

UNC

ANSI



HSS



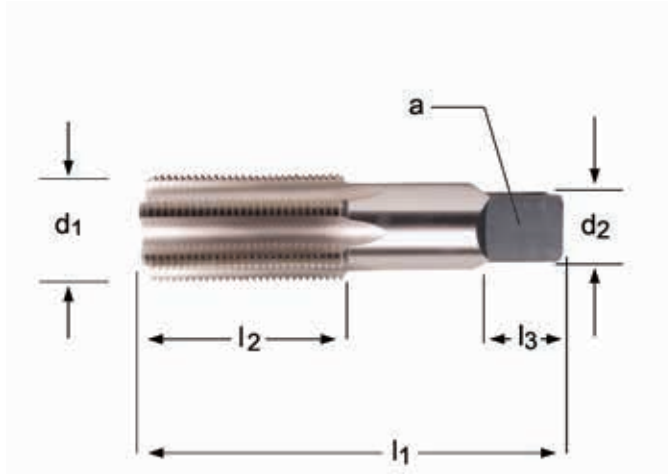
1/4 - 5/8

UNC	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1500OV(UNC)
1/4	20	2.1/2	1.000	0.2550	0.1910	5/16	4	H11	Plug	1	1011748
5/16	18	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H11	Plug	1	1011749
3/8	16	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H11	Plug	1	1011750
1/2	13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H11	Plug	1	1011752
5/8	11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H11	Plug	1	1011753

# HAND TAPS

## General Purpose, 8-Pitch

**1505** Proven performers for manufacturers of oil field equipment, large valves, electric utilities, power generation machinery, and general construction. For through or blind hole applications.



1505(UNS)

UNS

ANSI

2B



HSS



1.1/8 - 2"

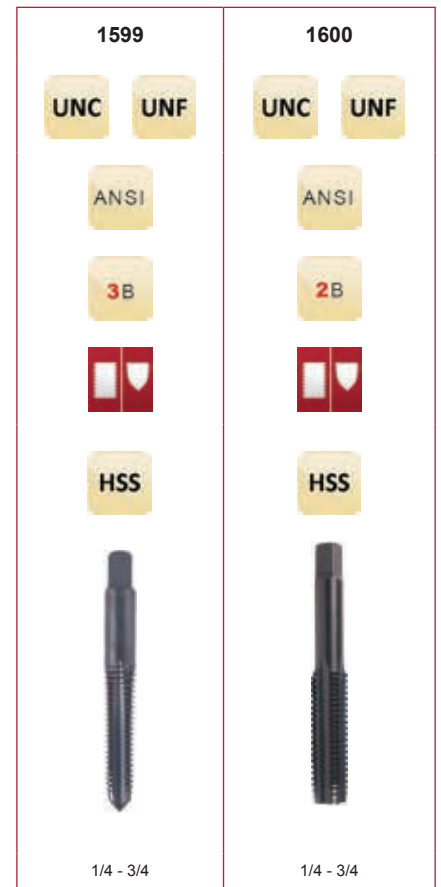
Nominal $d_1$	TPI UNS	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch /	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming
1.1/8	8	5.7/16	2.9/16	0.8960	0.6720	7/8	4	H5	1	1013310	1013311	1013312
1.1/4	8	5.3/4	2.9/16	1.0210	0.7660	1"	4	H5	1	1013313	1013314	1013315
1.3/8	8	6.1/16	3"	1.1080	0.8310	1.1/16	4	H5	1	1013316	1013317	1013318
1.1/2	8	6.3/8	3"	1.2330	0.9250	1.1/8	6	H5	1	1013319	1013320	1013321
1.5/8	8	6.11/16	3.3/16	1.3050	0.9780	1.1/8	6	H6	1	1013322	1013323	1013324
1.3/4	8	7"	3.3/16	1.4300	1.0720	1.1/4	6	H6	1	1013325	1013326	1013327
1.7/8	8	7.5/16	3.9/16	1.5190	1.1390	1.1/4	6	H6	1	1013328	1013329	1013330
2"	8	7.5/8	3.9/16	1.6440	1.2330	1.3/8	6	H6	1	1013331	1013332	1013333

## For Cast Iron

**1599** Designed for through or blind hole tapping with a specific cutting geometry for gray cast irons and those materials producing broken, powdery chips. Also ideal for non-metallics, cast brass, and other brass materials producing broken powdery chips. Nitride and steam oxide coating reduces wear and chip welding in abrasive materials. For through or blind hole applications.

**1600**

1599 - H3  
1600 - H5



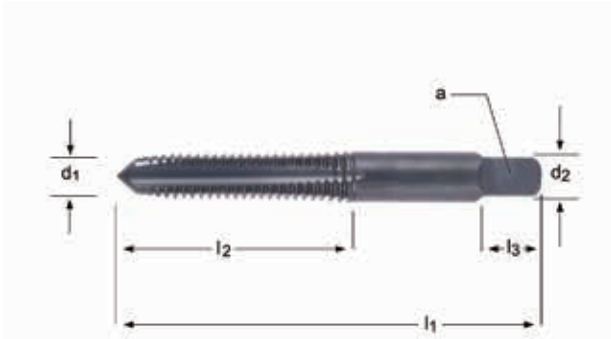
Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	□ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	1599 Plug	1599 Bottoming	1600 Plug	1600 Bottoming
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	4	H3	1	1010256	1010257	—	—
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	4	H5	1	—	—	1011256	1011257
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	4	H5	1	—	—	1011258	1011259
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	1	1010260	1010261	—	—
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	4	H5	1	—	—	—	1011261
5/16		24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	1	—	1010263	—	—
5/16		24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H5	1	—	—	1011262	1011263
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	1	1010264	1010265	—	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	4	H5	1	—	—	1011264	1011265
3/8		24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	1	1010266	1010267	—	—
3/8		24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H5	1	—	—	1011266	1011267
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	4	H5	1	—	—	1011268	1011269
7/16		20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	1	—	1010271	—	—
7/16		20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H5	1	—	—	1011270	1011271
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	1010272	1010273	—	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	4	H5	1	—	—	—	1011273
1/2		20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	1010274	1010275	—	—
1/2		20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H5	1	—	—	1011274	1011275
9/16	12		3.19/32	1.21/32	0.4290	0.3220	1/2	4	H5	1	—	—	1011276	1011277
9/16		18	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	1	—	1010279	—	—
9/16		18	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H5	1	—	—	—	1011279
5/8	11		3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	1	1010280	1010281	—	—
5/8	11		3.13/16	1.13/16	0.4800	0.3600	9/16	4	H5	1	—	—	1011280	1011281
3/4	10		4.1/4	2"	0.5900	0.4420	11/16	4	H3	1	—	1010285	—	—
3/4	10		4.1/4	2"	0.5900	0.4420	11/16	4	H5	1	—	—	—	1011285
3/4		16	4.1/4	2"	0.5900	0.4420	11/16	4	H3	1	1010286	1010287	—	—
3/4		16	4.1/4	2"	0.5900	0.4420	11/16	4	H5	1	—	—	—	1011287

# HAND TAPS

## For Cast Iron

**1599(M)**      Designed for through or blind hole tapping with a specific cutting geometry for gray cast irons and those materials producing broken chips. Also ideal for non-metallics, cast brass, and other brass materials producing broken powdery chips. Nitride and steam oxide coating reduces wear and chip welding in abrasive materials. For through or blind hole applications.

**1599SB(M)**



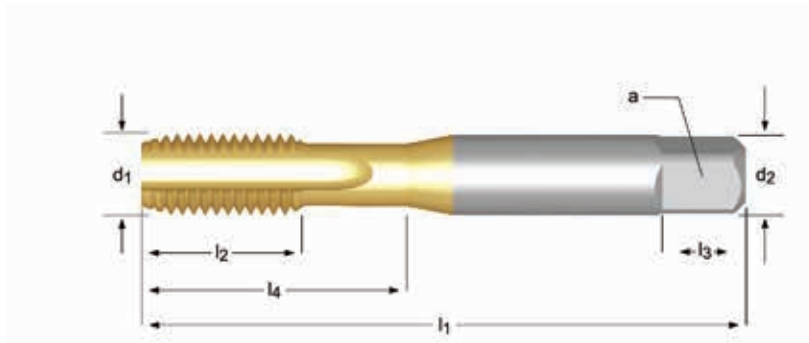
1599(M)	1599SB(M)
M	M
ANSI	ANSI
6H	6H
HSS	HSS
M6 - M14	M6 - M12

Nominal d <sub>1</sub>	Pitch M	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> ∅ Inch /	∠ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	1599M Plug	1599M Bottoming	1599SB Semi-Bottoming
M6	1.00	2.1/2	1"	0.2550	0.1910	5/16	4	D5	1	1012256	1012266	1012276
M8	1.25	2.23/32	1.1/8	0.3180	0.2380	3/8	4	D5	1	1012258	1012268	1012278
M10	1.50	2.15/16	1.1/4	0.3810	0.2860	7/16	4	D6	1	1012260	1012270	1012280
M12	1.75	3.3/8	1.21/32	0.3670	0.2750	7/16	4	D6	1	1012262	1012272	1012282
M14	1.25	3.19/32	1.21/32	0.4290	0.3220	1/2	4	D4	1	1010288	—	—



## For Cast Iron, Semi-Bottoming

**E504** Designed for through or blind hole tapping with a specific cutting geometry for gray cast irons and those materials producing broken chips. Also ideal for non-metallics, cast brass, and other brass materials producing broken powdery chips. TiN coating increases the surface hardness and improves tool life.



**E504**

**M**

**ISO 529**

**6H**

**HSS**

M3 - M24

M	P mm	$l_1$ mm	$l_2$ mm	$d_2$ Ø mm	$a$ mm	$l_3$ mm	# of Flutes		$l_4$ mm	Limits	Pack Qty	E504
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	D3	1	0122563
4	0.70	53	14	4.00	3.15	6	3	3.3	14	D4	1	0122556
5	0.80	58	11	5.00	4.00	7	3	4.2	22	D4	1	0122501
6	1.00	66	13	6.30	5.00	8	3	5	26	D5	1	0122518
8	1.25	72	16	8.00	6.30	9	3	6.8	29	D5	1	0122525
10	1.50	80	18	10.00	8.00	11	3	8.5	34	D6	1	0122532

**Note:** ISO shank and square dimensions will necessitate metric holders

# SPIRAL POINT TAPS



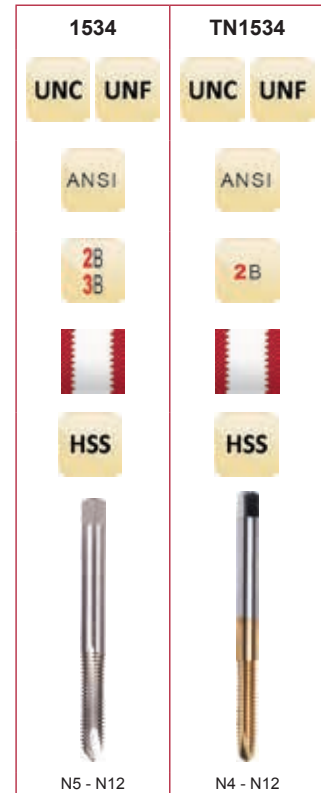
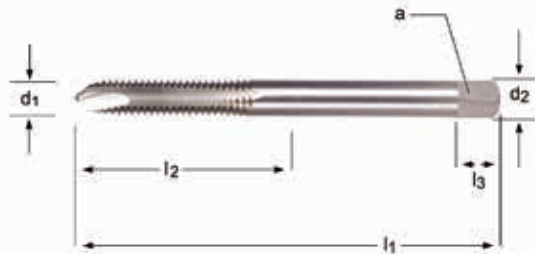
## Relieved Style, Machine Screw Sizes

### 1534 TN1534

Spiral point taps are designed to solve the problem of tap breakage in through hole applications in a variety of materials. The angular flutes in the cutting face propel the chips ahead of the cutting zone, thus reducing loading and clogging in the flutes.

The 1534 style features eccentrically relieved threads with full pitch diameter relief. These taps are extremely free cutting, resulting in longer tool life. The use of rigid tapping equipment is highly recommended with this style of tap.

Bright finish - improves chip flow in soft or non-ferrous materials.  
TiN Coating - increases surface hardness and improves tool life.



				$l_1$	$l_2$	$d_2$	$\square$	$l_3$			Pack Qty	1534	TN1534
UNC	UNF	TPI	Inch	Inch	Inch	Inch	a	Inch	# of Flutes	Limits	Chamfer		
4		40	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Plug	1	—	1060805
	5	44	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Plug	1	1012358	—
5		40	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Plug	1	1012356	—
	6	40	2"	11/16	0.1410	0.1100	3/16	2	H2	Plug	1	1012357	—
6		32	2"	11/16	0.1410	0.1100	3/16	2	H1	Plug	1	1012366	—
	6	40	2"	11/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1012359	—
6		32	2"	11/16	0.1410	0.1100	3/16	2	H2	Plug	1	1012360	—
	6	40	2"	11/16	0.1410	0.1100	3/16	2	H3	Plug	1	1012361	1062361
6		32	2"	11/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1012367	—
	8	36	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Bottoming	1	1012363	—
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H3	Bottoming	1	1012364	—
	8	32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1012375	—
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H1	Plug	1	1012375	—
	8	32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1012368	—
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1012369	—
	8	32	2.1/8	3/4	0.1680	0.1310	1/4	2	H3	Plug	1	1012370	1062370
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Bottoming	1	1012372	—
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Bottoming	1	1012373	—
10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H1	Plug	1	1012381	—
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Plug	1	1012382	—
10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Plug	1	1012383	1062383
	10	24	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Plug	1	1012377	—
10		24	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Plug	1	1012378	1062378
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Bottoming	1	1012385	—
10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Bottoming	1	1012386	—
	10	24	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Bottoming	1	1012379	—
10		24	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Bottoming	1	1012380	—
	12	28	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Plug	1	1012388	—
12		24	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Plug	1	1012389	1062389
	12	24	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Bottoming	1	1012699	—

## Relieved Style, Fractional Sizes

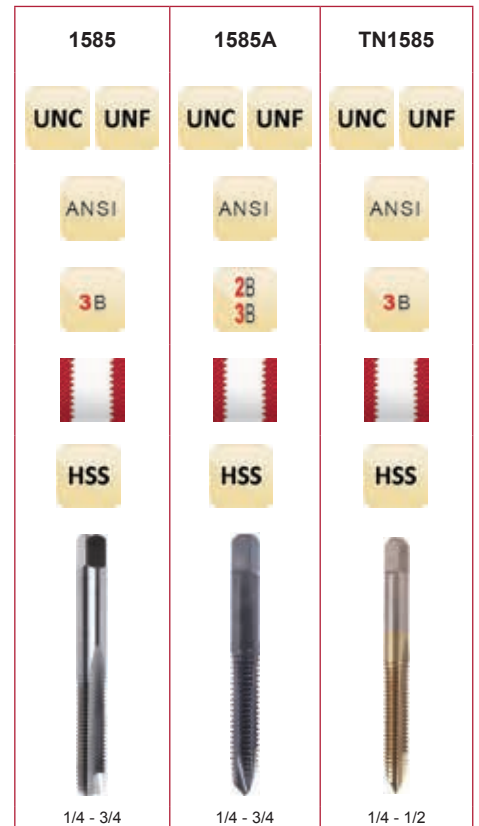
- 1585** Spiral point taps are designed to solve the problem of tap breakage in through hole applications in a variety of materials.
- 1585A** The angular flutes in the cutting face propel the chips ahead of the cutting zone, thus reducing loading and clogging in the flutes.
- TN1585**

The 1585 style features eccentrically relieved threads with full pitch diameter relief. These taps are extremely free cutting, resulting in longer tool life. The use of rigid tapping equipment is highly recommended with this style of tap.

Bright Finish - improves chip flow in soft or non-ferrous materials.

Steam Oxide - reduces wear and prevents chip welding in harder ferrous materials.

TiN Coating - increases surface hardness and improves tool life.



UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Inch	$l_3$ Inch	$\square$ a Inch	# of Flutes	Limits	Chamfer	Pack Qty	1585	1585A	TN1585
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	2	H1	Plug	1	1010290	—	—
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	2	H2	Plug	1	1010291	—	—
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	2	H3	Plug	1	1010292	1050292	1060292
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	3	H3	Plug	1	1010295	—	1060295
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	3	H5	Plug	1	1010296	—	1060296
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	2	H5	Plug	1	1010293	—	1060293
1/4		20	2.1/2	1"	0.2550	5/16	0.1910	2	H3	Bottoming	1	1010294	—	—
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	2	H2	Plug	1	1010298	—	—
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	3	H2	Plug	1	1010302	—	—
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	2	H3	Plug	1	1010299	1050299	1060299
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	2	H4	Plug	1	1010300	—	—
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	3	H4	Plug	1	1010303	—	—
	1/4	28	2.1/2	1"	0.2550	5/16	0.1910	2	H3	Bottoming	1	1010301	—	—
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H1	Plug	1	1010304	—	—
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H2	Plug	1	1010305	—	—
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H3	Plug	1	1010306	1050306	1060306
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	3	H3	Plug	1	1010309	—	1060309
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	3	H5	Plug	1	1010310	—	1060310
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H5	Plug	1	1010307	—	—
5/16		18	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H3	Bottoming	1	1010308	—	—
	5/16	24	2.23/32	1.1/8	0.3180	3/8	0.2380	3	H2	Plug	1	1010316	—	—
	5/16	24	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H3	Plug	1	1010313	1050313	1060313
	5/16	24	2.23/32	1.1/8	0.3180	3/8	0.2380	3	H4	Plug	1	1010317	—	—
	5/16	24	2.23/32	1.1/8	0.3180	3/8	0.2380	2	H3	Bottoming	1	1010315	—	—
3/8		16	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H1	Plug	1	1010318	—	—
3/8		16	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H3	Plug	1	1010320	1050320	1060320
3/8		16	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H2	Plug	1	1010319	—	—
3/8		16	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H5	Plug	1	1010321	—	1060321
	3/8	24	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H3	Plug	1	1010324	1050324	1060324
	3/8	24	2.15/16	1.1/4	0.3810	7/16	0.2860	3	H4	Plug	1	1010325	—	—

# SPIRAL POINT TAPS

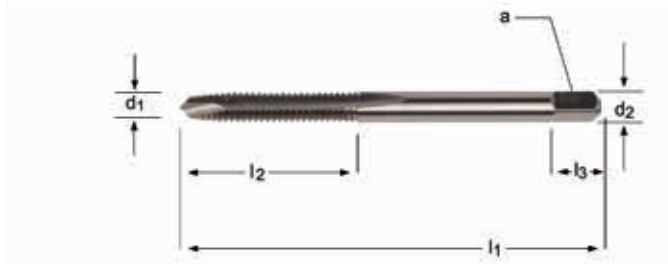


		$l_1$	$l_2$	$d_2$ $\emptyset$	$l_3$	$\square$ a	# of				Pack	1585	1585A	TN1585
UNC	UNF	TPI	Inch	Inch	Inch	Inch	Flutes	Limits	Chamfer		Qty			
7/16		14	3.5/32	1.7/16	0.3230	13/32	0.2420	3	H2	Plug	1	1010327	—	—
7/16		14	3.5/32	1.7/16	0.3230	13/32	0.2420	3	H3	Plug	1	1010328	1050328	1060328
7/16		14	3.5/32	1.7/16	0.3230	13/32	0.2420	3	H5	Plug	1	1010329	—	—
	7/16	20	3.5/32	1.7/16	0.3230	13/32	0.2420	3	H2	Plug	1	1010331	—	—
	7/16	20	3.5/32	1.7/16	0.3230	13/32	0.2420	3	H3	Plug	1	1010332	1050332	1060332
1/2		13	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H1	Plug	1	1010334	—	—
1/2		13	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H2	Plug	1	1010335	—	—
1/2		13	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H3	Plug	1	1010336	1050336	1060336
1/2		13	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H5	Plug	1	1010337	—	—
	1/2	20	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H1	Plug	1	1010338	—	—
	1/2	20	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H2	Plug	1	1010339	—	—
	1/2	20	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H3	Plug	1	1010340	1050340	1060340
	1/2	20	3.3/8	1.21/32	0.3670	7/16	0.2750	3	H5	Plug	1	1010341	—	—
5/8		11	3.13/16	1.13/16	0.4800	9/16	0.3600	3	H3	Plug	1	1010342	1050342	—
5/8		11	3.13/16	1.13/16	0.4800	9/16	0.3600	3	H5	Plug	1	1010343	—	—
	5/8	18	3.13/16	1.13/16	0.4800	9/16	0.3600	3	H3	Plug	1	1012774	—	—
3/4		10	4.1/2	2"	0.5900	11/16	0.4420	3	H3	Plug	1	—	1050344	—
3/4		10	4.1/4	2"	0.5900	11/16	0.4420	3	H3	Plug	1	1010344	—	—
3/4		10	4.1/4	2"	0.5900	11/16	0.4420	3	H5	Plug	1	1010345	—	—
	3/4	16	4.1/2	2"	0.5900	11/16	0.4420	3	H3	Plug	1	—	1052775	—
	3/4	16	4.1/4	2"	0.5900	11/16	0.4420	3	H3	Plug	1	1012775	—	—

## Relieved Style, Machine Screw Sizes

### 1634

Premium Cobalt substrate. Designed for tough jobs in high temperature alloys, stainless steel, cast iron, abrasive non-ferrous materials and other similar materials. Due to their premium steel content and special design, this range will effectively increase productivity through longer tool life. Ideally suited for through hole tapping.



1634(UNF)

UNC UNF

ANSI

3B



HSS-E



N4 - N10

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1634
4		40	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Plug	1	1011102
6		32	2"	11/16	0.1410	0.1100	3/16	2	H2	Plug	1	1011104
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1011105
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Plug	1	1011106

# SPIRAL POINT TAPS



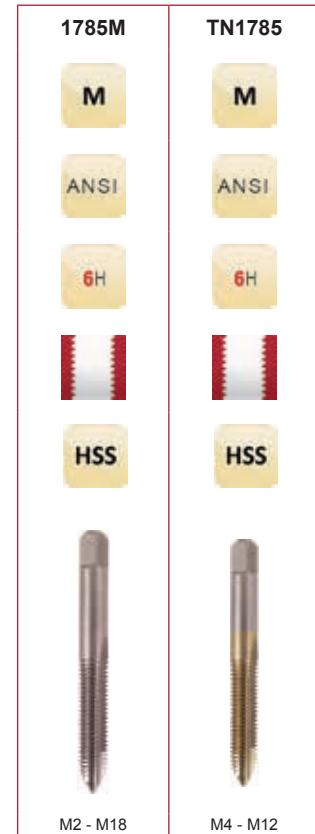
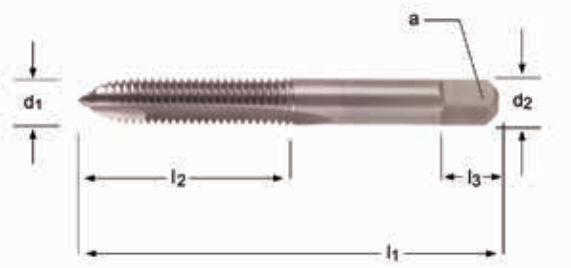
## Relieved Style, Metric

### 1785M TN1785

Spiral point taps are designed to solve the problem of tap breakage in through hole applications in a variety of materials. The angular flutes in the cutting face propel the chips ahead of the cutting zone, thus reducing loading and clogging in the flutes.

The 1785M style features eccentrically relieved threads with full pitch diameter relief. These taps are extremely free cutting, resulting in longer tool life. The use of rigid tapping equipment is highly recommended with this style of tap.

Bright Finish - improves chip flow in soft or non-ferrous materials.  
TiN Coating - increases surface hardness and improves tool life.

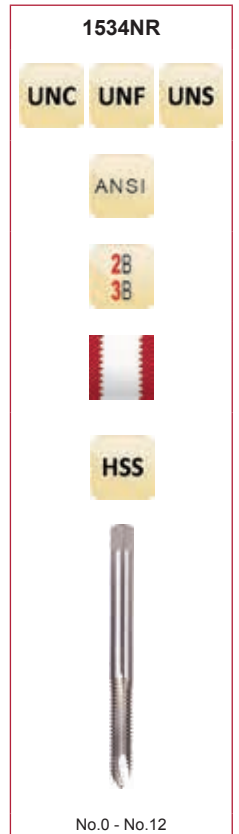
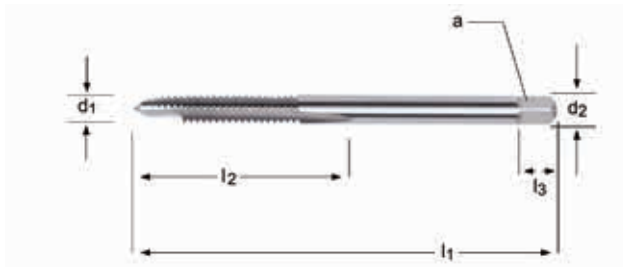


M	P mm	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch	l <sub>3</sub> Inch	∠ a Inch	# of Flutes	Limits	Chamfer	Pack Qty	1785M	TN1785
M2	0.40	1.3/4	7/16	0.1410	3/16	0.1100	2	D3	Plug	1	1012659	—
M2.5	0.45	1.13/16	1/2	0.1410	3/16	0.1100	2	D3	Plug	1	1012662	—
M3	0.50	1.15/16	5/8	0.1410	3/16	0.1100	2	D3	Plug	1	1012664	—
M3.5	0.60	2"	11/16	0.1410	3/16	0.1100	2	D4	Plug	1	1012666	—
M4	0.70	2.1/8	3/4	0.1680	1/4	0.1310	2	D4	Plug	1	—	1062668
M4	0.70	2.1/8	3/4	0.1680	1/4	0.1310	2	D4	Plug	1	1012668	—
M4.5	0.75	2.3/8	7/8	0.1940	1/4	0.1520	2	D4	Plug	1	1012669	—
M5	0.80	2.3/8	7/8	0.1940	1/4	0.1520	2	D4	Plug	1	—	1062672
M5	0.80	2.3/8	7/8	0.1940	1/4	0.1520	2	D4	Plug	1	1012672	—
M6	1.00	2.1/2	1"	0.2550	5/16	0.1910	2	D5	Plug	1	—	1062674
M6	1.00	2.1/2	1"	0.2550	5/16	0.1910	2	D5	Plug	1	1012674	—
M7	1.00	2.23/32	1.1/8	0.3180	3/8	0.2380	2	D5	Plug	1	1012676	—
M8	1.25	2.23/32	1.1/8	0.3180	3/8	0.2380	2	D5	Plug	1	—	1062678
M8	1.25	2.23/32	1.1/8	0.3180	3/8	0.2380	2	D5	Plug	1	1012678	—
M9	1.25	2.15/16	1.1/4	0.3810	7/16	0.2860	3	D5	Plug	1	1012680	—
M10	1.50	2.15/16	1.1/4	0.3810	7/16	0.2860	3	D6	Plug	1	—	1062682
M10	1.50	2.15/16	1.1/4	0.3810	7/16	0.2860	3	D6	Plug	1	1012682	—
M11	1.50	3.5/32	1.7/16	0.3230	13/32	0.2420	3	D6	Plug	1	1012685	—
M12	1.75	3.3/8	1.21/32	0.3670	7/16	0.2750	3	D6	Plug	1	—	1062686
M12	1.75	3.3/8	1.21/32	0.3670	7/16	0.2750	3	D6	Plug	1	1012686	—
M14	2.00	3.19/32	1.21/32	0.4290	1/2	0.3220	3	D7	Plug	1	1012689	—
M16	2.00	3.13/16	1.13/16	0.4800	9/16	0.3600	3	D7	Plug	1	1012693	—
M18	2.50	4.1/32	1.13/16	0.5420	5/8	0.4060	3	D7	Plug	1	1012696	—

## Non-Relieved Style, Machine Screw Sizes

### 1534NR

Feature concentric threads with no pitch diameter relief. These taps are particularly recommended for applications requiring close gauging fits and in older equipment that is not sufficiently rigid to accommodate the free cutting action of the 1534/1585 series. For through hole applications. Sizes in bold font indicate the most commonly used flute and 'H' limit for that size.



No.0 - No.12

UNC	UNF	UNS	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1534NR
	0		80	1.5/8	5/16	0.1410	0.1100	3/16	2	H1	Plug	1	1010775
	0		80	1.5/8	5/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010776
	0		80	1.5/8	5/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010778
	1		72	1.11/16	3/8	0.1410	0.1100	3/16	2	H1	Plug	1	1010783
	1		72	1.11/16	3/8	0.1410	0.1100	3/16	2	H2	Plug	1	1010784
1			64	1.11/16	3/8	0.1410	0.1100	3/16	2	H1	Plug	1	1010779
1			64	1.11/16	3/8	0.1410	0.1100	3/16	2	H2	Plug	1	1010780
	2		64	1.3/4	7/16	0.1410	0.1100	3/16	2	H1	Plug	1	1010791
	2		64	1.3/4	7/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010792
2			56	1.3/4	7/16	0.1410	0.1100	3/16	2	H1	Plug	1	1010787
2			56	1.3/4	7/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010788
2			56	1.3/4	7/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010790
	3		56	1.13/16	1/2	0.1410	0.1100	3/16	2	H1	Plug	1	1010799
	3		56	1.13/16	1/2	0.1410	0.1100	3/16	2	H2	Plug	1	1010800
3			48	1.13/16	1/2	0.1410	0.1100	3/16	2	H2	Plug	1	1010796
3			48	1.13/16	1/2	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010798
		4	36	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010803
	4		48	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010809
4			40	1.7/8	9/16	0.1410	0.1100	3/16	2	H1	Plug	1	1010804
4			40	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010805
	4		48	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010811
4			40	1.7/8	9/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010807
	5		44	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Plug	1	1010817
5			40	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Plug	1	1010813
5			40	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010815
	6		40	2"	11/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010825
6			32	2"	11/16	0.1410	0.1100	3/16	2	H1	Plug	1	1010818
6			32	2"	11/16	0.1410	0.1100	3/16	2	H2	Plug	1	1010819
6			32	2"	11/16	0.1410	0.1100	3/16	2	H3	Plug	1	1010820
	6		40	2"	11/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010827
6			32	2"	11/16	0.1410	0.1100	3/16	2	H2	Bottoming	1	1010822
6			32	2"	11/16	0.1410	0.1100	3/16	2	H3	Bottoming	1	1010823

# SPIRAL POINT TAPS



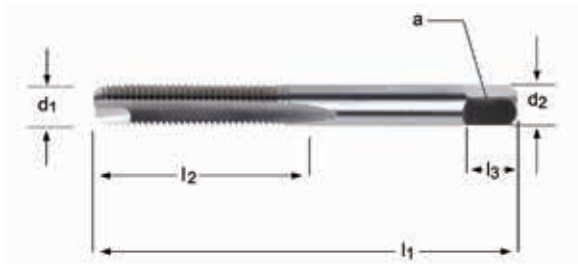
UNC	UNF	UNS	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ $\emptyset$ Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1534NR
	8		36	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1010835
8			32	2.1/8	3/4	0.1680	0.1310	1/4	2	H1	Plug	1	1010828
8			32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Plug	1	1010829
8			32	2.1/8	3/4	0.1680	0.1310	1/4	2	H3	Plug	1	1010830
8			32	2.1/8	3/4	0.1680	0.1310	1/4	2	H2	Bottoming	1	1010832
8			32	2.1/8	3/4	0.1680	0.1310	1/4	2	H3	Bottoming	1	1010833
	10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H1	Plug	1	1010843
	10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Plug	1	1010844
	10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Plug	1	1010845
	10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Bottoming	1	1010847
	10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Bottoming	1	1010848
10			24	2.3/8	7/8	0.1940	0.1520	1/4	2	H1	Plug	1	1010837
10			24	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Plug	1	1010838
10			24	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Plug	1	1010839
10			24	2.3/8	7/8	0.1940	0.1520	1/4	2	H2	Bottoming	1	1010841
10			24	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	Bottoming	1	1010842
	12		28	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Plug	1	1010853
12			24	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Plug	1	1011071
12			24	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Bottoming	1	1011072



## Non-Relieved Style, Fractional Sizes

### 1585NR

Feature concentric threads with no pitch diameter relief. These taps are particularly recommended for applications requiring close gauging fits and in older equipment that is not sufficiently rigid to accommodate the free cutting action of the regular 1534/1585 series. For through hole applications. Sizes in bold font indicate the most commonly used flute and 'H' limit for that size.



**1585NR**

**UNC UNF**

ANSI

**2B  
3B**



**HSS**



1/4 - 3/4

Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	∠ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Plug	Bottoming
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	2	H1	1	1012813	—
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	2	H2	1	1012814	—
1/4	<b>20</b>		<b>2.1/2</b>	<b>1"</b>	<b>0.2550</b>	<b>0.1910</b>	<b>5/16</b>	<b>2</b>	<b>H3</b>	<b>1</b>	<b>1012815</b>	<b>1012817</b>
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	2	H5	1	1012816	—
1/4	<b>20</b>		<b>2.1/2</b>	<b>1"</b>	<b>0.2550</b>	<b>0.1910</b>	<b>5/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012818</b>	—
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	2	H1	1	1012820	—
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	2	H2	1	1012821	—
1/4		<b>28</b>	<b>2.1/2</b>	<b>1"</b>	<b>0.2550</b>	<b>0.1910</b>	<b>5/16</b>	<b>2</b>	<b>H3</b>	<b>1</b>	<b>1012822</b>	<b>1012824</b>
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	2	H2	1	1012828	—
5/16	<b>18</b>		<b>2.23/32</b>	<b>1.1/8</b>	<b>0.3180</b>	<b>0.2380</b>	<b>3/8</b>	<b>2</b>	<b>H3</b>	<b>1</b>	<b>1012829</b>	<b>47197820</b>
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	2	H5	1	1012830	—
5/16	<b>18</b>		<b>2.23/32</b>	<b>1.1/8</b>	<b>0.3180</b>	<b>0.2380</b>	<b>3/8</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012832</b>	<b>1012831</b>
5/16		<b>24</b>	<b>2.23/32</b>	<b>1.1/8</b>	<b>0.3180</b>	<b>0.2380</b>	<b>3/8</b>	<b>2</b>	<b>H3</b>	<b>1</b>	<b>1012836</b>	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H2	1	1012842	—
3/8	<b>16</b>		<b>2.15/16</b>	<b>1.1/4</b>	<b>0.3810</b>	<b>0.2860</b>	<b>7/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012843</b>	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H5	1	1012844	—
3/8		<b>24</b>	<b>2.15/16</b>	<b>1.1/4</b>	<b>0.3810</b>	<b>0.2860</b>	<b>7/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012847</b>	—
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H2	1	1012849	—
7/16	<b>14</b>		<b>3.5/32</b>	<b>1.7/16</b>	<b>0.3230</b>	<b>0.2420</b>	<b>13/32</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012850</b>	—
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H5	1	1012851	—
7/16		<b>20</b>	<b>3.5/32</b>	<b>1.7/16</b>	<b>0.3230</b>	<b>0.2420</b>	<b>13/32</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012853</b>	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H2	1	1012856	—
1/2	<b>13</b>		<b>3.3/8</b>	<b>1.21/32</b>	<b>0.3670</b>	<b>0.2750</b>	<b>7/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012857</b>	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H5	1	1012858	—
1/2		<b>20</b>	<b>3.3/8</b>	<b>1.21/32</b>	<b>0.3670</b>	<b>0.2750</b>	<b>7/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012861</b>	—
5/8	11		3.13/16	1.13/16	0.4800	0.3600	9/16	3	H3	1	1012863	—
5/8	11		3.13/16	1.13/16	0.4800	0.3600	9/16	3	H5	1	1012864	—
5/8		<b>18</b>	<b>3.13/16</b>	<b>1.13/16</b>	<b>0.4800</b>	<b>0.3600</b>	<b>9/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012867</b>	—
3/4	10		4.1/2	2"	0.5900	0.4420	11/16	3	H3	1	1012865	—
3/4	10		4.1/2	2"	0.5900	0.4420	11/16	3	H5	1	1012866	—
3/4		<b>16</b>	<b>4.1/2</b>	<b>2"</b>	<b>0.5900</b>	<b>0.4420</b>	<b>11/16</b>	<b>3</b>	<b>H3</b>	<b>1</b>	<b>1012868</b>	—

# SPIRAL POINT TAPS

## Non-Relieved, Metric Sizes

### 1785NR

Feature concentric threads with no pitch diameter relief. These taps are particularly recommended for applications requiring close gauging fits and in older equipment that is not sufficiently rigid to accommodate the free cutting action of the regular 1785 series. For through hole applications.



1785NR

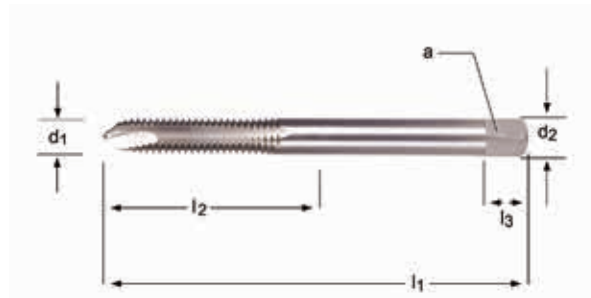


M1.6 - M20

M	P mm	$l_1$ Inch	$l_2$ Inch	$l_3$ Inch	$d_2$ Ø Inch	$\square$ a Inch	# of Flutes	Limits	Chamfer	Pack Qty	1785NR
1.6	0.35	1.5/8	5/16	0.1410	0.1100	3/16	2	D3	Plug	1	1012890
2	0.40	1.3/4	7/16	0.1410	0.1100	3/16	2	D3	Plug	1	1012891
2.5	0.45	1.13/16	1/2	0.1410	0.1100	3/16	2	D3	Plug	1	1012893
3	0.50	1.15/16	5/8	0.1410	0.1100	3/16	2	D3	Plug	1	1012896
3.5	0.60	2"	11/16	0.1410	0.1100	3/16	2	D4	Plug	1	1012897
4	0.70	2.1/8	3/4	0.1680	0.1310	1/4	2	D4	Plug	1	1012898
4.5	0.75	2.3/8	7/8	0.1940	0.1520	1/4	2	D4	Plug	1	1012899
5	0.80	2.3/8	7/8	0.1940	0.1520	1/4	2	D4	Plug	1	1012900
6	1.00	2.1/2	1"	0.2550	0.1910	5/16	2	D5	Plug	1	1012901
7	1.00	2.23/32	1.1/8	0.3180	0.2380	3/8	2	D5	Plug	1	1012902
8	1.25	2.23/32	1.1/8	0.3180	0.2380	3/8	2	D5	Plug	1	1012903
10	1.50	2.15/16	1.1/4	0.3810	0.2860	7/16	3	D6	Plug	1	1012904
12	1.75	3.3/8	1.21/32	0.3670	0.2750	7/16	3	D6	Plug	1	1012905
14	2.00	3.19/32	1.21/32	0.4290	0.3220	1/2	3	D7	Plug	1	1012906
16	2.00	3.13/16	1.13/16	0.4800	0.3600	9/16	3	D7	Plug	1	1012907
20	2.50	4.15/32	2"	0.6520	0.4890	11/16	3	D7	Plug	1	1012909

## Extension / Non-Relieved Style

**1534NE** Similar in design and thread geometries to the standard 1534NR series, but with a longer shank length. Bright finish improves chip flow in soft or non-ferrous materials. For through hole applications.



1534NE(UNC)

UNC UNF

ANSI

3B



HSS



No.4 - 1/2

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Pack Qty	Chamfer	1534NE
4		40	4"	9/16	0.1410	0.1100	3/16	2	H2	1	Plug	1020002
6		32	4"	11/16	0.1410	0.1100	3/16	2	H3	1	Plug	1020004
6		32	6"	11/16	0.1410	0.1100	3/16	2	H3	1	Plug	1020006
8		32	4"	3/4	0.1680	0.1310	1/4	2	H3	1	Plug	1020008
8		32	6"	3/4	0.1680	0.1310	1/4	2	H3	1	Plug	1020010
	10	32	4"	7/8	0.1940	0.1520	1/4	2	H3	1	Plug	1020016
	10	32	6"	7/8	0.1940	0.1520	1/4	2	H3	1	Plug	1020018
10		24	4"	7/8	0.1940	0.1520	1/4	2	H3	1	Plug	1020012
10		24	6"	7/8	0.1940	0.1520	1/4	2	H3	1	Plug	1020014
	1/4	28	4"	1"	0.2550	0.1910	5/16	2	H3	1	Plug	1020024
	1/4	28	6"	1"	0.2550	0.1910	5/16	2	H3	1	Plug	1020026
1/4		20	4"	1"	0.2550	0.1910	5/16	2	H3	1	Plug	1020020
1/4		20	6"	1"	0.2550	0.1910	5/16	2	H3	1	Plug	1020022
	5/16	24	4"	1.1/8	0.3180	0.2380	3/8	2	H3	1	Plug	1020032
	5/16	24	6"	1.1/8	0.3180	0.2380	3/8	2	H3	1	Plug	1020034
5/16		18	4"	1.1/8	0.3180	0.2380	3/8	2	H3	1	Plug	1020028
5/16		18	6"	1.1/8	0.3180	0.2380	3/8	2	H3	1	Plug	1020030
	3/8	24	4"	1.1/4	0.3810	0.2860	7/16	3	H3	1	Plug	1020040
	3/8	24	6"	1.1/4	0.3810	0.2860	7/16	3	H3	1	Plug	1020042
3/8		16	4"	1.1/4	0.3810	0.2860	7/16	3	H3	1	Plug	1020036
3/8		16	6"	1.1/4	0.3810	0.2860	7/16	3	H3	1	Plug	1020038
	7/16	20	6"	1.7/16	0.3230	0.2420	13/32	3	H3	1	Plug	1020046
7/16		14	6"	1.7/16	0.3230	0.2420	13/32	3	H3	1	Plug	1020044
	1/2	20	6"	1.21/32	0.3670	0.2750	7/16	3	H3	1	Plug	1020050
1/2		13	6"	1.21/32	0.3670	0.2750	7/16	3	H3	1	Plug	1020048

# SPIRAL POINT TAPS

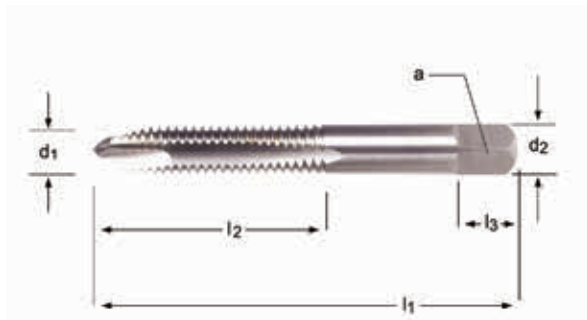


## OverSize / Relieved Style

**1593** Similar in design to the standard 1534/1585 series  
**1585OV** but with a pitch diameter larger than the basic pitch diameter. Used primarily where a part will be plated or treated after tapping. For through hole applications.

1593: 0.003" - 0.0035" Oversize

1585OV: 0.005" Oversize



1593		1585OV
UNC	UNF	UNC
ANSI		ANSI
2B 3B		2B
HSS		HSS
N6 - N10		1/4 - 5/8

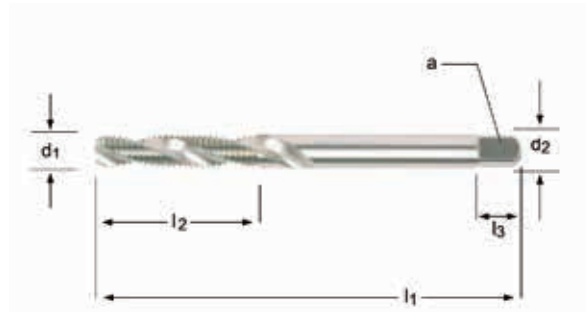
UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$a$ Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1593	1585OV
6		32	2"	11/16	0.1410	0.1100	3/16	2	H7	Plug	1	1010877	—
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H7	Plug	1	1010879	—
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H7	Plug	1	1010883	—
10		24	2.3/8	7/8	0.1940	0.1520	1/4	2	H7	Plug	1	1010881	—
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	2	H11	Plug	1	—	1011754
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	2	H11	Plug	1	—	1011755
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H11	Plug	1	—	1011756
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	3	H11	Plug	1	—	1011757
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H11	Plug	1	—	1011758
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	3	H11	Plug	1	—	1011759

## Regular Spiral 30°

**1582** - Machine Screw Sizes

**1586** - Fractional Sizes

Generally used where chip disposal is a problem. The spiral flute design effectively draws chips out of the hole. Recommended for use when tapping blind or through holes in a variety of materials. Excellent choice for non-ferrous applications.



1582 / 1586

UNC UNF

ANSI

3B



HSS



No.4 - 1/2

Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	∠ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Plug	Bottoming
4	40		1.7/8	9/16	0.1410	0.1100	3/16	2	H2	1	1010905	1010906
6	32		2"	11/16	0.1410	0.1100	3/16	2	H3	1	1010909	1010910
8	32		2.1/8	3/4	0.1680	0.1310	1/4	2	H3	1	1010913	1010914
10	24		2.3/8	7/8	0.1940	0.1520	1/4	2	H3	1	1010915	1010916
10		32	2.3/8	7/8	0.1940	0.1520	1/4	2	H3	1	1010917	1010918
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	2	H3	1	1010346	1010347
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1010348	1010349
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	2	H3	1	1010350	1010351
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1010352	1010353
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010354	1010355
5/16		24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010356	1010357
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1010358	1010359
3/8		24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1010360	1010361
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1010362	1010363
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1010366	1010367
1/2		20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1010368	1010369

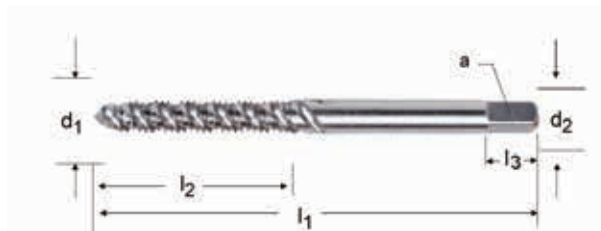
# SPIRAL FLUTE TAPS

## High Spiral Helicut 52°

**1587** - Machine Screw Sizes

**1588** - Fractional Sizes

Similar to the regular spiral flute design of 1582/1586 except that the faster spiral improves the chip drawing action and permits the bridging of larger gaps inside a hole. For blind or through hole applications. Excellent choice for non-ferrous applications.



1587 / 1588

UNC UNF

ANSI

2B  
3B



HSS



N4 - 1/2

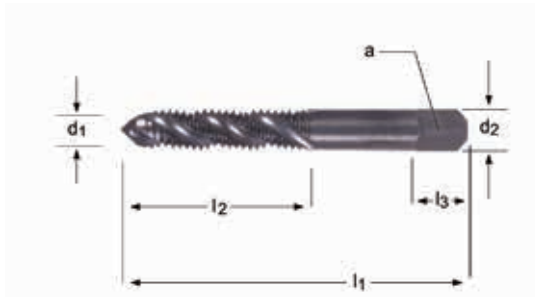
Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	Plug	Bottoming
4	40		1.7/8	9/16	0.1410	0.1100	3/16	2	H2	1	1010887	1010888
6	32		2"	11/16	0.1410	0.1100	3/16	2	H3	1	1010891	1010892
8	32		2.1/8	3/4	0.1680	0.1310	1/4	3	H3	1	1010895	1010896
10	24		2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	1010897	1010898
10		32	2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	1010899	1010900
1/4	20		2.1/2	1.000	0.2550	0.1910	5/16	3	H3	1	1010398	1010399
1/4		28	2.1/2	1.000	0.2550	0.1910	5/16	3	H3	1	1010400	1010401
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010402	1010403
5/16		24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010404	1010405
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1010406	1010407
3/8		24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1010408	1010409
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1010410	1010411
7/16		20	3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1010412	1010413
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1010414	1010415
1/2		20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1010416	1010417

## Heavy Duty Spiral 40°

**1590** - Machine Screw Sizes

**1591** - Fractional Sizes

A slower helix angle, larger core diameter, three flutes and wider throat dimensions than the regular 1587/1588 series. Designed for tough blind or through hole tapping. Chip ejection is more efficient and problems such as chipping and breakage are largely eliminated. A steam oxide finish makes this tap ideal for use in ferrous materials and higher strength alloys.



1590 / 1591

UNC UNF

ANSI

3B



HSS



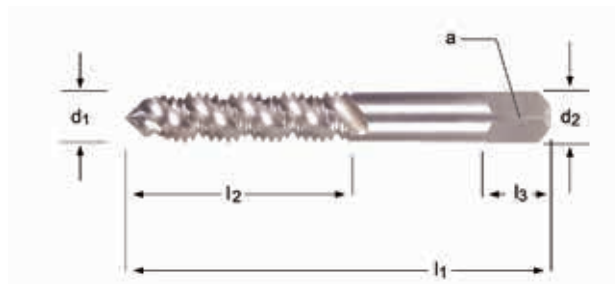
N6 - 1/2

Nominal $d_1$	TPI UNC	TPI UNF	$l_1$ Inch	$l_2$ Inch	$d_2$ $\emptyset$ Inch /	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Pack Qty	Plug	Bottoming
6	32		2"	11/16	0.1410	0.1100	3/16	2	H3	1	1010937	1010938
6		40	2"	11/16	0.1410	0.1100	3/16	2	H3	1	—	1010940
10	24		2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	1010945	1010946
10		32	2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	1010947	1010948
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1010953	1010954
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1010955	1010956
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010957	1010958
3/8	16		2.5/16	1.1.4	0.3810	0.2860	7/16	3	H3	1	1010961	1010962
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1010965	1010966
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1010969	1010970

# SPIRAL FLUTE TAPS

## High Spiral Helicut 52°, Metric

**1788(M)** Similar to the regular spiral flute design of 1582/1586 except that the faster spiral improves the chip drawing action and permits the bridging of larger gaps inside a hole. For blind or through hole applications. Excellent choice for non-ferrous applications.



1788(M)

M

ANSI

6H



HSS



M3 - M12

Nominal $d_1$	Pitch M	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch /	$\square$ a Inch	$l_3$ Inch	No. of Flutes	Limits	Pack Qty	Plug	Bottoming
M3	0.50	1.15/16	5/8	0.1410	0.1100	3/16	2	D3	1	1012920	1012940
M4	0.70	2.1/8	3/4	0.1680	0.1310	1/4	3	D4	1	1012923	1012943
M5	0.80	2.3/8	7/8	0.1940	0.1520	1/4	3	D4	1	1012925	1012945
M6	1.00	2.1/2	1"	0.2550	0.1910	5/16	3	D5	1	1012926	1012946
M8	1.25	2.23/32	1.1/8	0.3180	0.2380	3/8	3	D5	1	1012928	1012948
M10	1.50	2.15/16	1.1/4	0.3810	0.2860	7/16	3	D6	1	1012930	1012950
M12	1.75	3.3/8	1.21/32	0.3670	0.2750	7/16	3	D6	1	1012932	1012952



## Rol-Rite / Spiral Lobe

**1580** The Rol-Rite style has a spiral lobe pattern and no oil or lubrication grooves. It is designed for general purpose applications and is particularly suited for through holes in thin sections and for interrupted holes. For through or blind hole applications.



**1580**

UNC
UNF

ANSI

2B  
3B

HSS

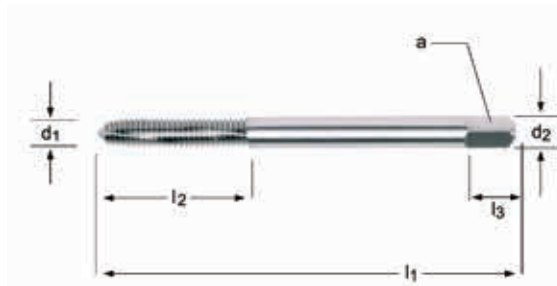
N2 - 3/8

Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> ∅ Inch /	∟ a Inch	l <sub>3</sub> Inch	Limits	Pack Qty	Plug	Bottoming
2	56		1.3/4	7/16	0.1410	0.1100	3/16	H2	1	—	1310004
2	56		1.3/4	7/16	0.1410	0.1100	3/16	H3	1	—	1310005
4	40		1.7/8	9/16	0.1410	0.1100	3/16	H3	1	1310012	1310014
4	40		1.7/8	9/16	0.1410	0.1100	3/16	H5	1	—	1310015
5	40		1.15/16	5/8	0.1410	0.1100	3/16	H3	1	—	1310022
6	32		2"	11/16	0.1410	0.1100	3/16	H3	1	1310028	1310031
6	32		2"	11/16	0.1410	0.1100	3/16	H5	1	1310029	—
8	32		2.1/8	3/4	0.1680	0.1310	1/4	H3	1	1310038	1310041
8	32		2.1/8	3/4	0.1680	0.1310	1/4	H5	1	1310039	1310042
10	24		2.3/8	7/8	0.1940	0.1520	1/4	H4	1	1310048	1310051
10		32	2.3/8	7/8	0.1940	0.1520	1/4	H4	1	—	1310057
10		32	2.3/8	7/8	0.1940	0.1520	1/4	H6	1	1310055	1310058
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	H4	1	1310068	1310071
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	H6	1	1310069	—
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	H4	1	1310074	1310076
5/16	18		2.23/32	1.1/8	0.3180	0.2380	7/16	H5	1	1310078	1310080
5/16	18		2.23/32	1.1/8	0.3180	0.2380	7/16	H7	1	—	1310081
5/16		24	2.23/32	1.1/8	0.3180	0.2380	7/16	H5	1	1310082	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	1/2	H5	1	1310086	1310088
3/8		24	2.15/16	1.1/4	0.3810	0.2860	1/2	H5	1	—	1310092

# THREAD FORMING TAPS

## Rol-Rite, Spiral Lobe

**1580(M)** The Rol-Rite style has a spiral lobe pattern and no oil or lubrication grooves. It is designed for general purpose applications and is particularly suited for through holes in thin sections and for interrupted holes.



1580(M)

M

ANSI

6H



HSS

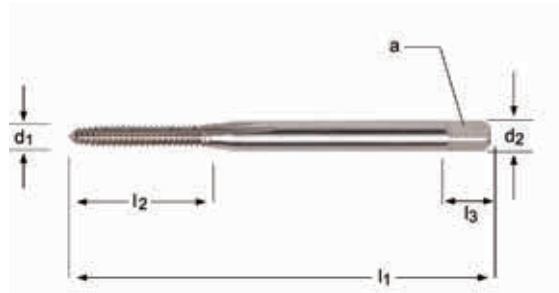


M3 - M12

Nominal $d_1$	Pitch M	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch /	$\square$ a Inch	$l_3$ Inch	Limits	Pack Qty	Plug	Bottoming
M3	0.50	1.15/16	5/8	0.1410	0.1100	3/16	D5	1	1310400	1310401
M4	0.70	2.1/8	3/4	0.1680	0.1310	1/4	D6	1	1310402	1310403
M5	0.80	2.3/8	7/8	0.1940	0.1520	1/4	D7	1	1310404	1310405
M6	1.00	2.1/2	1"	0.2550	0.1910	5/16	D8	1	1310406	1310407
M8	1.25	2.23/32	1.1/8	0.3180	0.2380	3/8	D9	1	1310408	1310409
M10	1.50	2.15/16	1.1/4	0.3810	0.2860	7/16	D10	1	1310410	1310411
M12	1.75	3.3/8	1.21/32	0.3670	0.2750	7/16	D11	1	1310412	1310413

## Rol-Form / Lube Grooves

**3300** The Rol-Form style has 2-4 grooves (depending on size) extending the full length of thread to assure lubrication in the forming zone and to eliminate build up of the hydraulic pressure in blind holes. They are particularly suited to blind holes in thin walled die castings.



3300

UNC UNF

ANSI

2B  
3B

HSS

N0 - 1/2

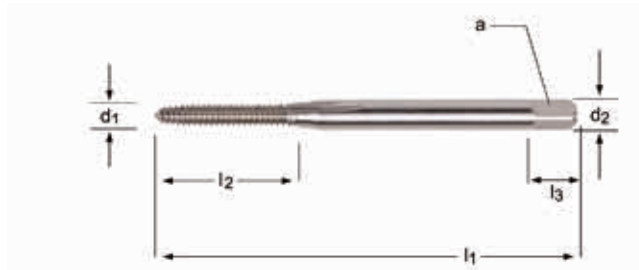
Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	∟ a Inch	l <sub>3</sub> Inch	Limits	Pack Qty	Plug	Bottoming
0		80	1.5/8	5/16	0.1410	0.1100	3/16	H2	1	—	1310110
1	64		1.11/16	3/8	0.1410	0.1100	3/16	H2	1	—	1310111
1		72	1.11/16	3/8	0.1410	0.1100	3/16	H2	1	—	1310112
2	56		1.3/4	7/16	0.1410	0.1100	3/16	H2	1	—	1310113
2	56		1.3/4	7/16	0.1410	0.1100	3/16	H3	1	—	1310114
4	40		1.7/8	9/16	0.1410	0.1100	3/16	H3	1	1310121	1310123
4	40		1.7/8	9/16	0.1410	0.1100	3/16	H5	1	1310122	—
5	40		1.15/16	5/8	0.1410	0.1100	3/16	H3	1	—	1310131
5	40		1.15/16	5/8	0.1410	0.1100	3/16	H5	1	—	1310132
6	32		2"	11/16	0.1410	0.1100	3/16	H3	1	1310137	1310140
6	32		2"	11/16	0.1410	0.1100	3/16	H5	1	1310138	1310141
8	32		2.1/8	3/4	0.1680	0.1310	1/4	H3	1	1310147	1310150
8	32		2.1/8	3/4	0.1680	0.1310	1/4	H5	1	1310148	1310151
10	24		2.3/8	7/8	0.1940	0.1520	1/4	H4	1	1310157	1310160
10	24		2.3/8	7/8	0.1940	0.1520	1/4	H6	1	1310158	1310161
10		32	2.3/8	7/8	0.1940	0.1520	1/4	H4	1	1310163	1310166
10		32	2.3/8	7/8	0.1940	0.1520	1/4	H6	1	1310164	1310167
12	24		2.3/8	15/16	0.2200	0.1650	9/32	H4	1	1310169	—
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	H4	1	1310177	1310180
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	H6	1	1310178	1310181
1/4		28	2.1/2	1"	0.2550	0.1910	5/16	H4	1	1310183	1310185
5/16	18		2.23/32	1.1/8	0.3180	0.2380	7/16	H5	1	1310187	1310189
5/16	18		2.23/32	1.1/8	0.3180	0.2380	7/16	H7	1	1310188	1310190
3/8	16		2.15/16	1.1/4	0.3810	0.2860	1/2	H5	1	1310195	1310197
3/8	16		2.15/16	1.1/4	0.3810	0.2860	1/2	H7	1	1310196	1310198
3/8		24	2.15/16	1.1/4	0.3810	0.2860	1/2	H7	1	1310200	1310202
1/2	13		3.3/8	1.21/32	0.3670	0.2750	23/32	H5	1	1310211	—

# THREAD FORMING TAPS

## Rol-Form, Lube Grooves

### 3300(M)

The Rol-Form style has 1-2 lube grooves (depending on size) extending the full length of thread to assure lubrication in the forming zone and to eliminate build up of the hydraulic pressure in blind holes. They are particularly suited to blind holes in thin walled die castings.



3300(M)

M

ANSI

6H



HSS

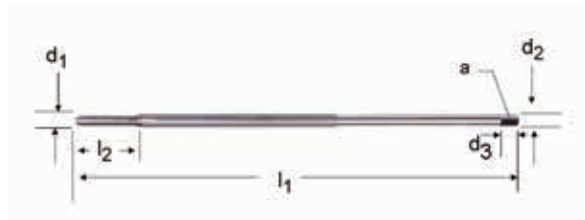


M3 - M10

Nominal $d_1$	Pitch M	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch /	$\square$ a Inch	$l_3$ Inch	Limits	Grooves	Pack Qty	Plug	Bottoming
M3	0.50	1.15/16	5/8	0.1410	0.1100	3/16	D5	1	1	1310500	1310501
M4	0.70	2.1/8	3/4	0.1680	0.1310	1/4	D6	1	1	1310502	1310503
M5	0.80	2.3/8	7/8	0.1940	0.1520	1/4	D7	1	1	1310504	1310505
M6	1.00	2.1/2	1"	0.2550	0.1910	5/16	D8	2	1	1310506	1310507
M8	1.25	2.23/32	1.1/8	0.3180	0.2380	3/8	D9	2	1	1310508	1310509
M10	1.50	2.15/16	1.1/4	0.3810	0.2860	7/16	D10	2	1	1310510	1310511

## Extension Rol-Form / Lube Grooves

**3306E** Similar in design and thread geometries to the standard 3300 series but with longer shank lengths than standard.



3306E(UNF)

UNC UNF

ANSI

2B



HSS



N4 - 5/16

UNC	UNF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	Limits	Chamfer	Pack Qty	3306E
4		40	4"	9/16	0.1410	0.1100	3/16	H3	Bottoming	1	1321002
4		40	4"	9/16	0.1410	0.1100	3/16	H5	Bottoming	1	1321004
6		32	4"	11/16	0.1410	0.1100	3/16	H3	Bottoming	1	1321006
8		32	4"	3/4	0.1680	0.1310	1/4	H3	Bottoming	1	1321014
	10	32	4"	7/8	0.1940	0.1520	1/4	H4	Bottoming	1	1321030
10		24	4"	7/8	0.1940	0.1520	1/4	H4	Bottoming	1	1321022
1/4		20	4"	1"	0.2550	0.1910	5/16	H4	Bottoming	1	1321038
5/16		18	4"	1.1/8	0.3180	0.2380	3/8	H5	Bottoming	1	1321062

# PIPE TAPS

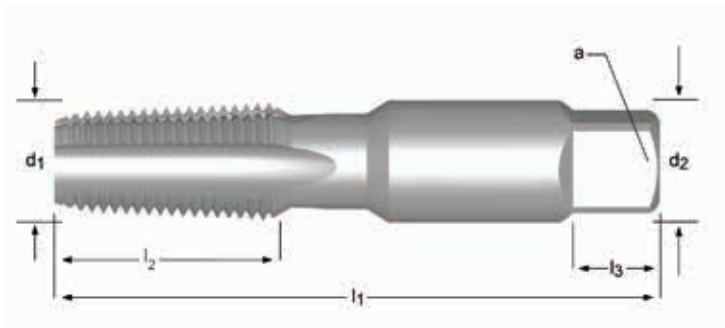
## General Purpose, Medium Hook, NPT

**1541**      Straight Flute. Medium hook for multi-material tapping. Generally used for pipe fittings and couplings in most ferrous and non-ferrous materials. The nominal size of a pipe tap is that of the pipe fitting to be tapped and not the actual size of the tap. NPT threads require the use of a 'sealant' such as teflon tape or pipe compound to ensure a tight joint.

**TN1541**

TiN coating increases surface hardness and improves tool life.

Made to Metal Cutting Tool Institute Standards, table 311



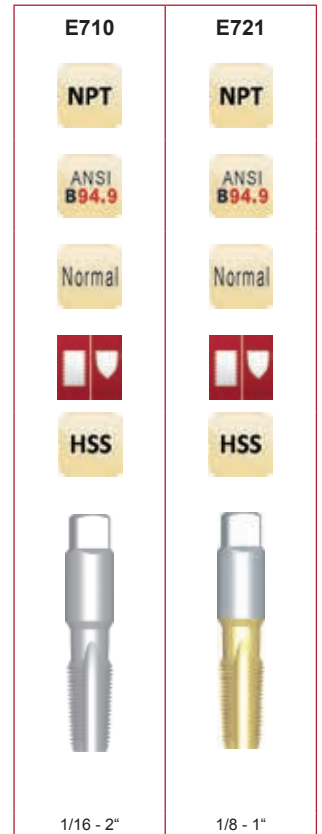
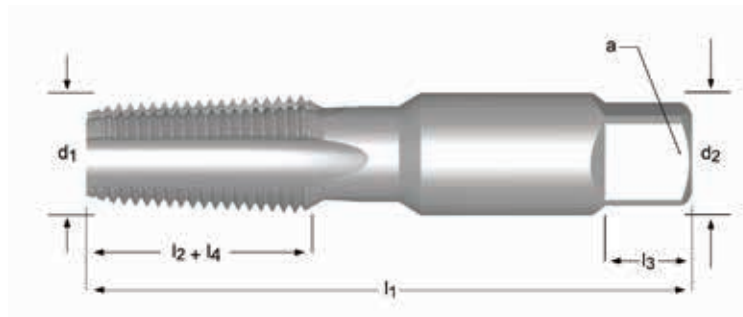
1541(NPT)	TN1541
1/16 - 2"	1/8 - 3/4"

Nominal d <sub>1</sub>	TPI	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	□ a Inch	l <sub>3</sub> Inch	# of Flutes	Pack Qty	1541	TN1541
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1010518	—
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1010528	—
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1010519	1060519
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1010520	1060520
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1010521	1060521
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1010522	1060522
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010523	1060523
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1010524	—
1.1/4	11.5	4"	1.3/4	1.3130	0.9840	15/16	5	1	1010525	—
1.1/2	11.5	4.1/4	1.3/4	1.5000	1.1250	1"	7	1	1010526	—
2"	11.5	4.1/2	1.3/4	1.8750	1.4060	1.1/8	7	1	1010527	—

## General Purpose, Medium Hook, NPT

**E710** Straight Flute. Medium hook for multi-material tapping.  
**E721** Generally used for pipe fittings and couplings in most ferrous and non-ferrous materials. The nominal size of a pipe tap is that of the pipe fitting to be tapped and not the actual size of the tap. NPT threads require the use of a 'sealant' such as teflon tape or pipe compound to ensure a tight joint.

TiN coating increases surface hardness and improves tool life.



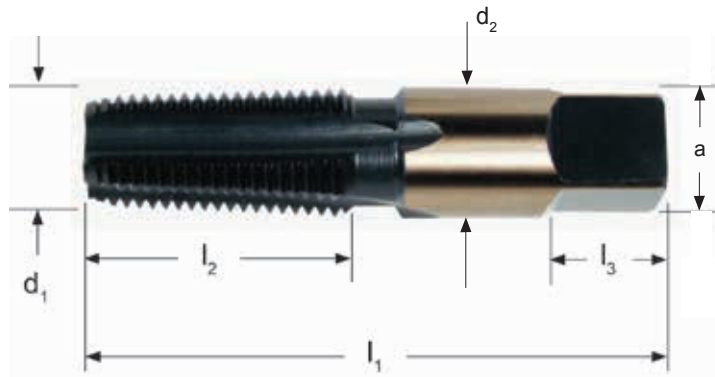
Nominal $d_1$	TPI	$l_1$ mm	$l_2$ mm	$d_2$ $\varnothing$ mm	$\square$ a mm	$l_3$ mm		# of Flutes	$l_4$ mm	Pack Qty	E710	E721
1/16	27	65	17	7.9	5.9	8	6.3	4	11.7	1	0159491	—
1/8	27	70	19	11.1	8.3	10	8.5	4	11.9	1	0099889	0161463
1/8	27	70	19	11.1	8.3	10	8.5	4	11.9	Set of 2	0210314 <sup>1)</sup>	—
1/4	18	75	27	14.3	10.7	11	11	4	17.6	1	0099872	0161470
1/4	18	75	27	14.3	10.7	11	11	4	17.6	Set of 2	0210321 <sup>1)</sup>	—
3/8	18	80	27	17.8	13.5	13	14.5	4	19.5	1	0099919	0161487
3/8	18	80	27	17.8	13.5	13	14.5	4	19.5	Set of 2	0210338 <sup>1)</sup>	—
1/2	14	100	35	17.5	13.1	16	18	4	22.7	1	0099865	0161494
1/2	14	100	35	17.5	13.1	16	18	4	22.7	Set of 2	0210345 <sup>1)</sup>	—
3/4	14	105	35	23.0	17.2	17	23	5	24.4	1	0099902	0161500
3/4	14	105	35	23.0	17.2	17	23	5	24.4	Set of 2	0210352 <sup>1)</sup>	—
1"	11.5	115	43	28.6	21.4	21	29	5	29.4	1	0099834	0161517
1.1/4	11.5	125	43	33.3	25.0	24	38	5	27.7	1	0099858	—
1.1/2	11.5	135	43	38.1	28.6	25	44	7	28.9	1	0099841	—
2"	11.5	145	43	47.6	35.7	29	56	7	26.6	1	0099896	—

<sup>1)</sup> Sets (No.7) include: 1pc. semi-bottoming + 1 pc. semi-bottoming (truncated)

# PIPE TAPS

## General Purpose / Work-Rite, NPT

**6541** Straight Flute. Medium hook for multi-material tapping.  
Generally used for pipe fittings and couplings in most ferrous and non-ferrous materials.  
The nominal size of a pipe tap is that of the pipe fitting to be tapped and not the actual size of the tap. NPT threads require the use of a 'sealant' such as teflon tape or pipe compound to ensure a tight joint.



6541

NPT

ANSI  
B94.9

Normal



1/8 - 2"

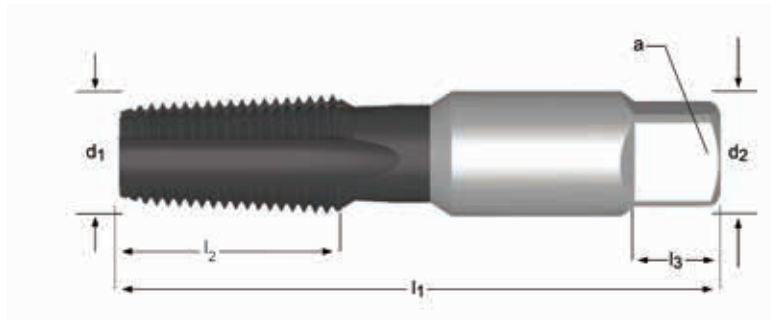
NPT	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	6541
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	8110601
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	8110602
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	8110603
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	8110604
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	8110605
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	8110606
1.1/4	11.5	4"	1.3/4	1.3130	0.9840	15/16	5	1	8110607
1.1/2	11.5	4.1/4	1.3/4	1.5000	1.1250	1	7	1	8110608
2"	11.5	4.1/2	1.3/4	1.8750	1.4060	1.1/8	7	1	8110609



## Low Rake for Cast Iron, NPT

**1544**

Straight Flute. Low rake heavy-duty for cast iron and heat treated alloy steels. Nitride surface treatment reduces wear and chip welding. Manufactured with a cutting geometry specifically for gray cast irons producing broken chips. The design makes these taps also appropriate for non-metallics, cast brass and other brass materials producing broken, powdery chips.



1544

**NPT**

ANSI  
**B94.9**

Normal



**HSS**



1/16 - 1.1/4

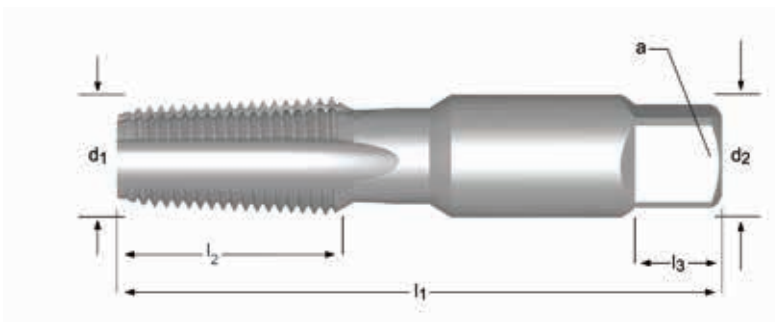
NPT	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	<b>1544</b>
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1011760
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1011761
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1011762
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1011763
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1011764
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1011765
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1011766
1.1/4	11.5	4"	1.3/4	1.3130	0.9840	15/16	5	1	1011767

# PIPE TAPS

## High Hook, NPT

**1545** Designed with a high hook and deep flutes to handle the tough curly chips of free cutting materials such as low carbon and leaded steels, boiler plate, aluminum and die castings.

**1545A** Identical to the 1545 series but with steam oxide surface treatment to prevent galling and chipping.



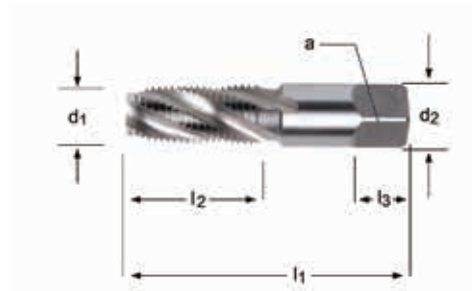
1545	1545A
1/18 - 1"	1/16 - 3/4

NPT	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	1545	1545A
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	—	1052869
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1012879	—
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1012870	1052870
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1012871	1052871
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1012872	1052872
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1012873	1052873
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1012874	1052874
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1012875	—

## Spiral Flute, 30°, NPT

**1548**

Designed with a medium hook. Most effective when used in applications that produce, long, stringy chips. The spiral flute design effectively draws the chips from the hole being tapped.



1548

NPT

ANSI

Normal



HSS



1/16 - 1"

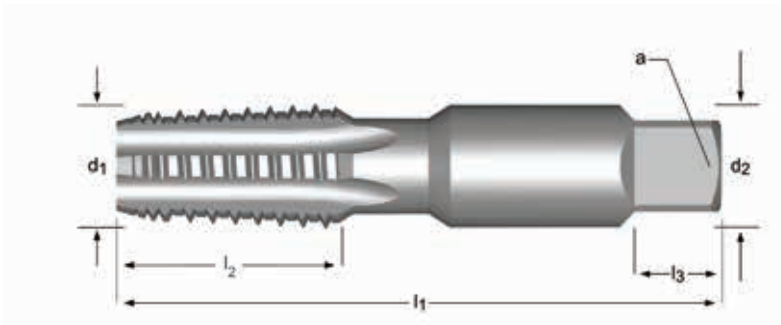
		$l_1$	$l_2$	$d_2$	$\square$	$l_3$	# of	Pack	1548
NPT	TPI	Inch	Inch	$\varnothing$ Inch	a Inch	Inch	Flutes	Qty	
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1010920
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1010924
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1010922
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1010926
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1010928
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1010930
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010932
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1010934

# PIPE TAPS

## Interrupted Thread, NPT

**1568**

Interrupted thread design for chip evacuation. Removal of every other thread allows more coolant deeper into the hole. Helps to eliminate torn threads and re-cutting of chips. Ideal for use in soft, ductile materials or those producing long, continuous chips.



1568

NPT

ANSI

Normal



HSS

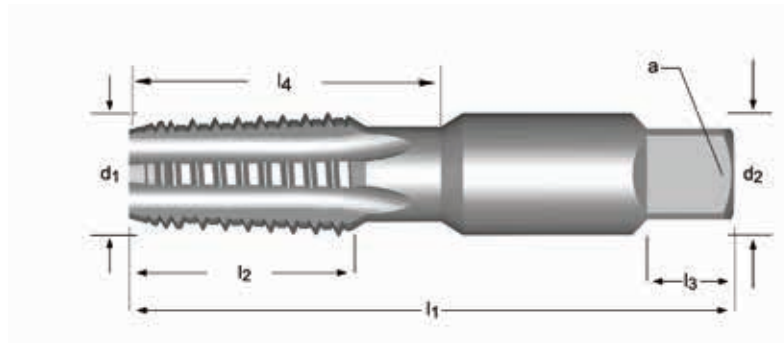


1/8 - 1.1/2

NPT	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	1568
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	5	1	1010560
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	5	1	1010551
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	5	1	1010552
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	5	1	1010553
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	5	1	1010554
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010555
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1010556
1.1/4	11.5	4"	1.3/4	1.3130	0.9840	15/16	5	1	1010557
1.1/2	11.5	4.1/4	1.3/4	1.5000	1.1250	1"	7	1	1010558

## Interrupted Thread, NPT

**E711** Interrupted thread design for chip evacuation. Removal of every other thread allows more coolant deeper into the hole. Helps to eliminate torn threads and re-cutting of chips. Ideal for use in soft, ductile materials or those producing long, continuous chips.



**E711**

**NPT**

**ANSI B94.9**

Normal

**HSS**

1/8 - 1.1/2

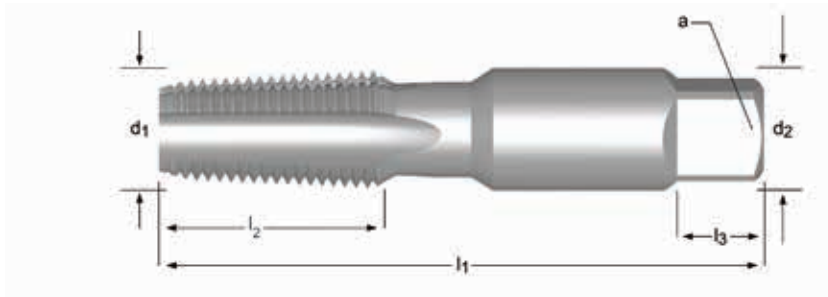
NPT	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	Pack Qty	E711
1/8	27	10.29	70	19	309	11.1	8.3	10	5	1	0099957
1/4	18	13.72	75	27	44.6	14.3	10.7	11	5	1	0099940
3/8	18	17.15	80	27	46.5	17.8	13.5	13	5	1	0099971
1/2	14	21.33	100	35	57.7	17.5	13.1	16	5	1	0099933
3/4	14	26.67	105	35	59.4	23.0	17.2	17	5	1	0099964
1"	11.5	33.40	115	43	72.4	28.6	21.4	21	5	1	0099926
1.1/2	11.5	48.26	135	43	71.9	38.1	28.6	25	7	1	0124079

# PIPE TAPS

## Dryseal, NPTF, Medium Hook

**1543** Similar in design to the 1541 series but manufactured to Dryseal American National Standard Taper Pipe Thread (NPTF) specifications. Used where a leak proof pressure tight joint is required without the use of a sealing compound.

**TN1543** TiN coated option increases surface hardness and improves tool life.

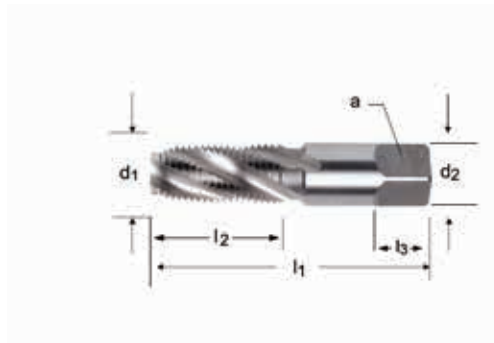


1543(NPTF)	TN1543
1/16 - 1"	1/8 - 3/4

NPTF	TPI	$l_1$ Inch	$l_1$ mm	$l_2$ Inch	$l_2$ mm	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	1543(NPTF)	TN1543
1/16	27	2.1/8		11/16		0.3130	0.2340	3/8	4	1	1010529	—
1/8	27		2.1/8		3/4	0.4380	0.3280	3/8	4	1	—	1060530
1/8	27	2.1/8		3/4		0.3130	0.2340	3/8	4	1	1010539	—
1/8	27	2.1/8		3/4		0.4380	0.3280	3/8	4	1	1010530	—
1/4	18		2.7/16		1.1/16	0.5630	0.4210	7/16	4	1	—	1060531
1/4	18	2.7/16		1.1/16		0.5630	0.4210	7/16	4	1	1010531	—
3/8	18		2.9/16		1.1/16	0.7000	0.5310	1/2	4	1	—	1060532
3/8	18	2.9/16		1.1/16		0.7000	0.5310	1/2	4	1	1010532	—
1/2	14		3.1/8		1.3/8	0.6880	0.5150	5/8	4	1	—	1060533
1/2	14	3.1/8		1.3/8		0.6880	0.5150	5/8	4	1	1010533	—
3/4	14		3.1/4		1.3/8	0.9060	0.6790	11/16	5	1	—	1060534
3/4	14	3.1/4		1.3/8		0.9060	0.6790	11/16	5	1	1010534	—
1"	11.5	3.3/4		1.3/4		1.1250	0.8430	13/16	5	1	1010535	—

## Spiral Flute, Dryseal, NPTF

**1549** Spiral Flute 30°. Medium hook for evacuation of long, stringy chips. Similar in design to the 1548 series but manufactured to Dryseal American National Standard Taper Pipe Thread (NPTF) specifications. Used where a leak proof pressure tight joint is required without the use of a sealing compound.



1549

NPTF

ANSI

Normal



HSS



1/16 - 3/4

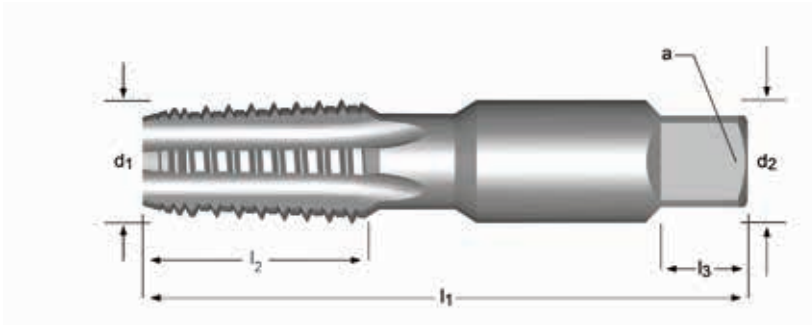
NPTF		$l_1$	$l_2$	$d_2$	$\square$	$l_3$	# of Flutes	Pack Qty	1549
TPI	Inch	Inch	Inch	Ø Inch	a Inch	Inch			
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1010921
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1010925
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1010923
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1010927
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1010929
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1010931
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010933

# PIPE TAPS

## Interrupted Thread, Dryseal, NPTF

**1567** Interrupted thread design for chip evacuation. Removal of every other thread allows more coolant deeper into the hole. Helps to eliminate torn threads and re-cutting of chips.

Similar in design to the 1568 series but manufactured to Dryseal American National Standard Taper Pipe Thread (NPTF) specifications. Used where a leak proof pressure tight joint is required without the use of a sealing compound.



1567

NPTF

ANSI

Normal



HSS



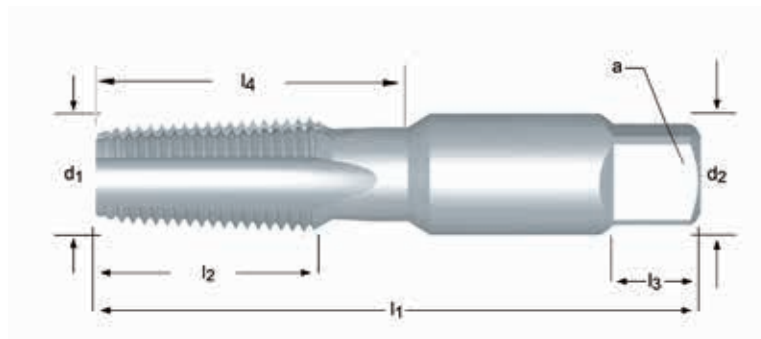
1/8 - 1"

NPTF	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ $\emptyset$ Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Pack Qty	1567
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	5	1	1010570
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	5	1	1010561
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	5	1	1010562
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	5	1	1010563
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	5	1	1010564
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010565
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1010566



## General Purpose, Medium Hook, Dryseal, NPTF

**E712** Medium hook for multi-material tapping. Similar in design to the E710 series but manufactured to Dryseal American National Standard Taper Pipe Thread (NPTF) specifications. Used where a leak proof pressure tight joint is required without the use of a sealing compound.



**E712**

**NPTF**

**ANSI B94.9**

Normal

**HSS**

1/16 - 1.1/4

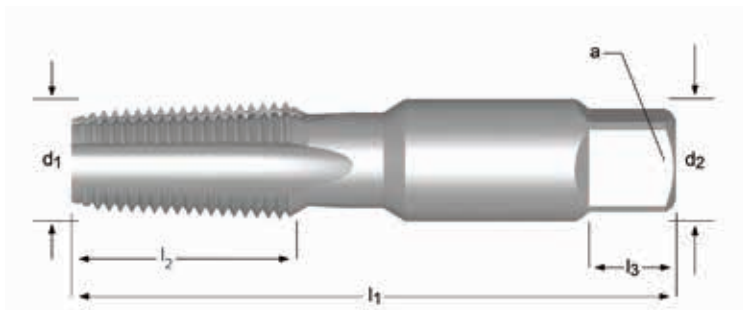
NPTF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes		Pack Qty	E712
1/16	27	7.94	65	17	11.7	8.1	6.0	8	4	6.20	1	0100004
1/8	27	10.29	70	19	11.9	11.1	8.3	10	4	8.40	1	0100035
1/4	18	13.72	75	27	17.6	14.3	10.7	11	4	10.90	1	0100028
3/8	18	17.15	80	27	19.5	17.8	13.5	13	4	14.25	1	0100059
1/2	14	21.34	100	35	22.7	17.5	13.1	16	4	17.75	1	0100011
3/4	14	26.67	105	35	24.4	23.0	17.2	17	5	23.00	1	0100042
1"	11.5	33.40	115	43	29.4	28.6	21.4	21	5	29.00	1	0099988
1.1/4	11.5	42.16	125	43	27.7	33.4	24.9	23	5	37.75	1	0099995

# PIPE TAPS

## Straight Pipe Taps, NPS & NPSF

**1542** NPSM (Mechanical) - Suitable for tapping holes for low pressure work, and then assemble with either taper threaded or straight threaded pipe or fitting and secure a tight joint with lubricant or sealer.

**1592** NPSF (Dryseal) - Similar in design to the 1542 series but manufactured to Dryseal American National Standard Pipe Thread NPSF specifications. Intended for low pressure work where a sealer is not used such as fuel and oil lines. When assembling with a dryseal taper-threaded part there will not be any clearance between the crest and roof of the threads.

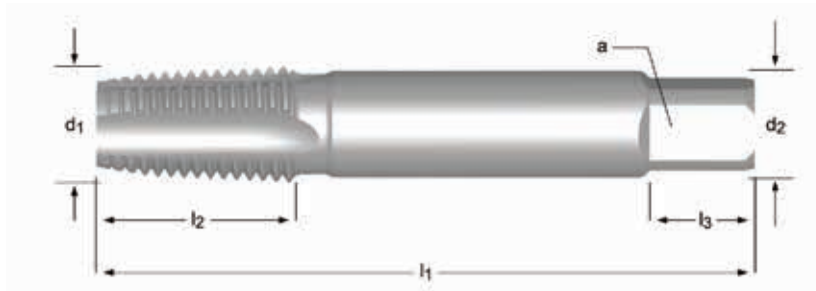


1542	1592
<b>NPSM</b>	<b>NPSF</b>
ANSI	ANSI
Normal	Normal
<b>HSS</b>	<b>HSS</b>
1/8 - 1"	1/8 - 3/4"

Nominal d <sub>1</sub>	TPI	l <sub>1</sub>		d <sub>2</sub> Ø Inch /	a Inch	l <sub>3</sub> Inch	# of Flutes	Pack Qty	1542	1592
		Inch	Inch							
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1010587	1010592
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1010581	1010588
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1010582	1010589
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1010583	1010590
1/2	14	3.1/8	1.3/8	0.6880	0.5150	5/8	4	1	1010584	1010591
3/4	14	3.1/4	1.3/8	0.9060	0.6790	11/16	5	1	1010585	1011070
1"	11.5	3.3/4	1.3/4	1.1250	0.8430	13/16	5	1	1010586	—

## Taper Pipe Taps, British Standard

**E550** Similar to the E710 but manufactured to British Standard Taper Pipe Thread specification (BSPT).




**E550**

Rc

ISO 2284

Normal

HSS



1/8 - 2"

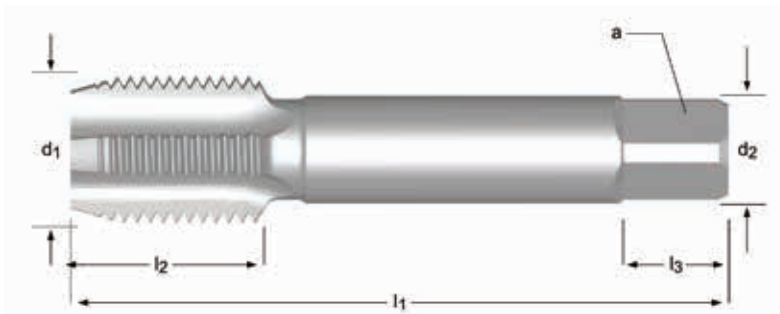
Rc	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes	↔	Pack Qty	E550
1/8	28	9.728	59	15	8.0	6.3	9	3	8.4	1	0099490
1/8	28	9.728	59	15	8.0	6.3	9	3	8.4	Set of 2	0159408 <sup>1)</sup>
1/4	19	13.157	67	19	10.0	8.0	11	3	11.2	1	0099483
1/4	19	13.157	67	19	10.0	8.0	11	3	11.2	Set of 2	0159422 <sup>1)</sup>
3/8	19	16.662	75	21	12.5	10.0	13	3	14.75	1	0099520
3/8	19	16.662	75	21	12.5	10.0	13	3	14.75	Set of 2	0159446 <sup>1)</sup>
1/2	14	20.955	87	26	16.0	12.5	16	5	18.25	1	0099476
1/2	14	20.955	87	26	16.0	12.5	16	5	18.25	Set of 2	0159460 <sup>1)</sup>
3/4	14	26.441	96	28	20.0	16.0	20	5	23.75	1	0099513
3/4	14	26.441	96	28	20.0	16.0	20	5	23.75	Set of 2	0159484 <sup>1)</sup>
1"	11	33.249	109	33	25.0	20.0	24	5	30	1	0099445
1.1/4	11	41.910	119	36	31.5	25.0	28	5	38.5	1	0099469
1.1/2	11	47.803	125	37	35.5	28.0	31	7	44.5	1	0099452
2"	11	59.614	140	41	40.0	31.5	34	7	56	1	0099506

**Note: ISO shank and square dimensions will necessitate metric holders**

<sup>1)</sup> Sets (No.7) include: 1pc. semi-bottoming + 1 pc. semi-bottoming (truncated)

## Straight Pipe Taps, British Standard

**E547** Similar to the NPS pipe taps, but manufactured to British Standard Parallel Pipe Thread specifications (BSPP).



E547

G

ISO  
2284

Normal



HSS



1/8 - 2"

Nominal $d_1$	TPI	$l_1$ mm	$l_2$ mm	$d_2$ $\varnothing$ mm	$\square$ a mm	$l_3$ mm	# of Flutes		Pack Qty	Taper	Plug	Bottoming
1/8	28	59	15	8.0	8.0	9	4	8.8	1	0157169	0157176	0099285
1/4	19	67	19	10.0	8.0	11	4	11.8	1	0157190	0157206	0099278
3/8	19	75	21	12.5	10.0	13	4	15.25	1	0157220	0157237	0099315
1/2	14	87	26	16.0	12.5	16	4	19	1	0157251	0157268	0099261
5/8	14	91	26	18.0	14.0	18	4	21	1	0157282	0099322	0099339
3/4	14	96	28	20.0	16.0	20	4	24.5	1	0157299	0150757	0099308
7/8	14	102	29	22.4	18.0	22	4	28.25	1	0157305	0099353	0099360
1"	11	109	33	25.0	20.0	24	4	30.75	1	0157312	0157329	0099254
1.1/4	11	119	36	31.5	25.0	28	6	39.5	1	0157336	0099216	0099223
1.1/2	11	125	37	35.5	28.0	31	6	45	1	0157343	0099193	0099209
2"	11	140	41	40.0	31.5	34	6	57	1	0157367	0157374	0099292

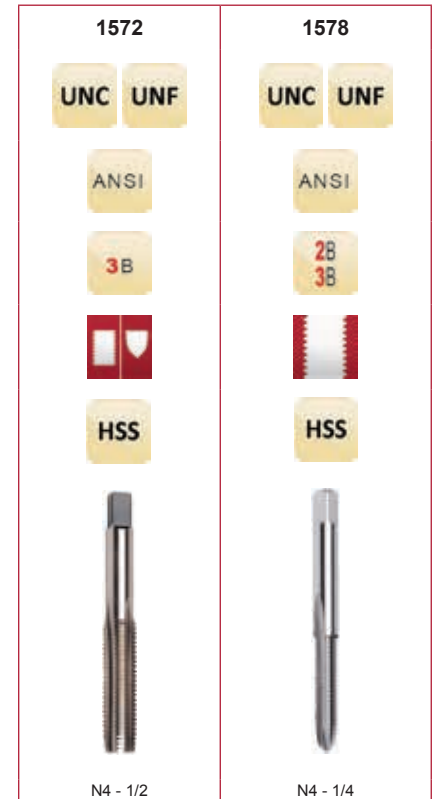
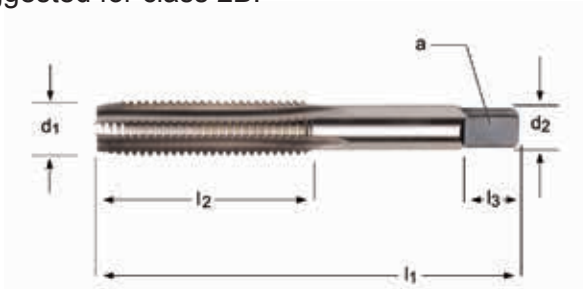
**Note:** ISO shank and square dimensions will necessitate metric holders

## Screw Thread Insert, STI

**1572** - Straight flute, hand tap

**1578** - Spiral point, machine tap

Designed for use in aluminum, magnesium, and other non-ferrous materials where taps of this type are most commonly used. Taps suitable for other materials can be furnished on request. STI taps are dimensionally oversized and utilize a larger tap drill size so that the thread they produce will accept a helical coil wire screw thread insert of the same nominal size and pitch. For a particular size and pitch the lower H-Limit number is suggested for class 2B and 3B threads, while the higher H-Limit is suggested for class 2B.



Nominal d <sub>1</sub>	TPI UNC	TPI UNF	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch /	□ a Inch	l <sub>3</sub> Inch	# of Flutes	Limits	Pack Qty	1572 - Plug	1572 Bottoming	1578 - Plug
4	40		2"	11/16	0.1410	0.1100	3/16	2	H2	1	—	—	1010491
4	40		2"	11/16	0.1410	0.1100	3/16	3	H2	1	1010419	1010421	—
6	32		2.3/8	7/8	0.1940	0.1520	1/4	2	H2	1	—	—	1010494
6	32		2.3/8	7/8	0.1940	0.1520	1/4	2	H3	1	—	—	1010495
6	32		2.3/8	7/8	0.1940	0.1520	1/4	3	H3	1	1010427	1010429	—
8	32		2.3/8	15/16	0.2200	0.1650	9/32	2	H2	1	—	—	1010498
8	32		2.3/8	15/16	0.2200	0.1650	9/32	2	H3	1	—	—	1010499
8	32		2.3/8	15/16	0.2200	0.1650	9/32	3	H3	1	1010435	1010437	—
10	24		2.1/2	1"	0.2550	0.1910	5/16	3	H2	1	1010438	1010440	—
10		32	2.1/2	1"	0.2550	0.1910	9/32	2	H2	1	—	—	1010502
10		32	2.1/2	1"	0.2550	0.1910	5/16	3	H2	1	1010442	1010444	—
10		32	2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1010443	1010445	—
1/4	20		2.23/32	1.1/8	0.3180	0.2380	5/16	2	H2	1	—	—	1010506
1/4	20		2.23/32	1.1/8	0.3180	0.2380	5/16	2	H3	1	—	—	1010507
1/4	20		2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1010451	1010453	—
1/4		28	2.23/32	1.1/8	0.3180	0.2380	5/16	2	H2	1	—	—	1010508
1/4		28	2.23/32	1.1/8	0.3180	0.2380	5/16	2	H3	1	—	—	1010509
1/4		28	2.23/32	1.1/8	0.3180	0.2380	3/8	2	H2	1	—	1010456	—
5/16	18		2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	1	1010458	—	—
3/8	16		3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	1010466	1010468	—
7/16	14		3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	1	1010474	—	—
7/16		20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	—	—	—
1/2	13		3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	1	1010482	—	—
1/2		20	3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	1	—	—	—

# SPECIAL PURPOSE TAPS

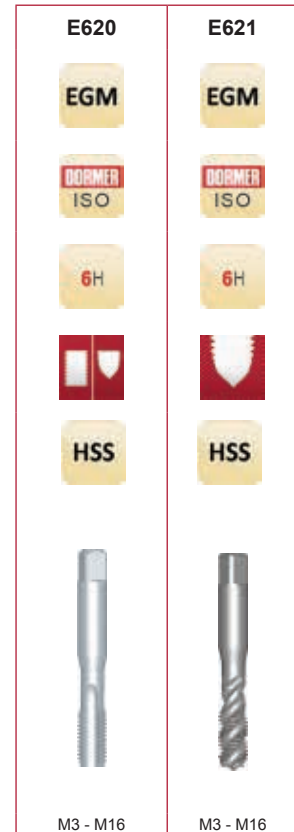
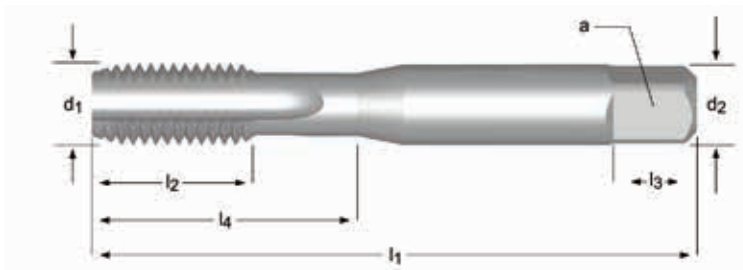


## Screw Thread Insert, STI, Semi-Bottoming

**E620** - Straight flute

**E621** - Spiral flute

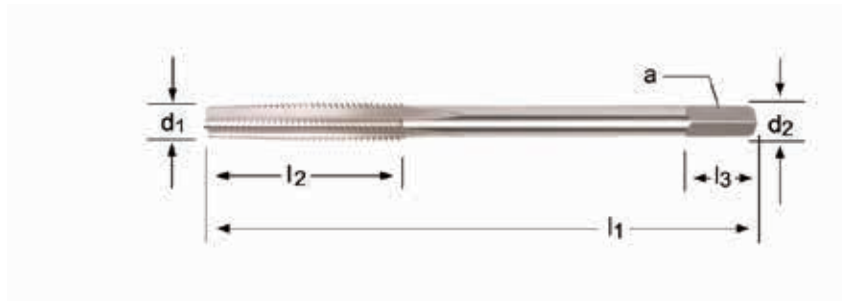
Designed for use in aluminum, magnesium, and other non-ferrous materials where taps of this type are most commonly used. Taps suitable for other materials can be furnished on request. STI taps are dimensionally oversized and utilize a larger tap drill size so that the thread they produce will accept a helical coil wire screw thread insert of the same nominal size and pitch.



Nominal d <sub>1</sub>	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> Ø mm	□ a mm	l <sub>3</sub> mm	# of Flutes		l <sub>4</sub> mm	Pack Qty	E620	E621
3	0.50	53	14	4.00	3.15	6	3	3.2	14	1	0384824	0384916
4	0.70	58	11	5.00	4.00	7	3	4.2	20	1	0384831	0384923
5	0.80	66	13	6.30	5.00	8	3	5.2	26	1	0384848	0384930
6	1.00	72	16	8.00	6.30	9	3	6.3	29	1	0384855	—
6	1.00	72	16	8.00	6.30	9	3	6.3	31	1	—	0384947
8	1.25	80	18	10.00	8.00	11	3	8.4	32	1	0384862	—
8	1.25	80	18	10.00	8.00	11	3	8.4	34	1	—	0384954
10	1.50	89	22	9.00	7.10	10	3	10.5		1	0384879	0384961
12	1.75	95	24	11.20	9.00	12	4	12.5		1	0384886	—
12	1.75	95	24	11.20	9.00	12	3	12.5		1	—	0384978
14	2.00	112	29	14.00	11.20	14	4	14.5		1	0384893	—
14	2.00	112	29	14.00	11.20	14	3	14.5		1	—	0384985
16	2.00	112	29	14.00	11.20	14	4	16.5		1	0384909	—
16	2.00	112	29	14.00	11.20	14	3	16.5		1	—	0384992

## Nut Style

**U1511** For small production runs in conventional tapping machines. They have a relatively long shank smaller than the minor diameter to permit accumulation of several nuts after tapping. Available in taper style, 7-10 thread chamfer.



U1511

UNC

ANSI

3B



HSS



1/4 - 1/2

UNC	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	U1511
1/4	20	5"	1.5/8	0.1850	0.1390	9/16	4	H3	Taper	1	1010375
5/16	18	5.1/2	1.13/16	0.2400	0.1800	5/8	4	H3	Taper	1	1010376
3/8	16	6"	2"	0.2940	0.2200	11/16	4	H3	Taper	1	1010377
1/2	13	7"	2.1/2	0.4000	0.3000	7/8	4	H3	Taper	1	1010378

# SPECIAL PURPOSE TAPS

## Pulley Style

**1519** These taps have the same major diameters and pitch diameters as standard fractional size taps, but with extended shanks for reaching locations inaccessible to regular hand taps. Although originally designed for tapping pulley holes, the long shank permits tapping other long reach applications.



1519

UNC

ANSI

3B



HSS



1/4 - 3/4

UNC	TPI	$l_1$ Inch	$l_2$ Inch	$d_2$ Ø Inch	$\square$ a Inch	$l_3$ Inch	# of Flutes	Limits	Chamfer	Pack Qty	1519
1/4	20	6"	1.000	0.2550	0.1910	5/16	4	H3	Plug	1	1010379
1/4	20	8"	1.000	0.2550	0.1910	5/16	4	H3	Plug	1	1010380
5/16	18	6"	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1010381
5/16	18	8"	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1010382
3/8	16	6"	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1010383
3/8	16	8"	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1010384
3/8	16	10"	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1010385
1/2	13	6"	1.21/32	0.5070	0.3800	9/16	4	H3	Plug	1	1010388
1/2	13	8"	1.21/32	0.5070	0.3800	9/16	4	H3	Plug	1	1010389
1/2	13	10"	1.21/32	0.5070	0.3800	9/16	4	H3	Plug	1	1010390
5/8	11	6"	1.13/16	0.6330	0.4750	11/16	4	H3	Plug	1	1010392
5/8	11	8"	1.13/16	0.6330	0.4750	11/16	4	H3	Plug	1	1010393
5/8	11	10"	1.13/16	0.6330	0.4750	11/16	4	H3	Plug	1	1010394
3/4	10	10"	2.000	0.7590	0.5690	3/4	4	H3	Plug	1	1010396



## Combination Drill & Tap

**1994** Spiral Flute 15°. Drills and taps in a single pass, reducing cycle time. Commonly used in multi-spindle operations with reversing capacity. Designed to provide 65% thread engagement and a 2B class of fit.

Bright finish improves chip flow in soft or non-ferrous materials.



1994(UNF)

UNC UNF

ANSI

2B



HSS



No.4 - 1/2

UNC	UNF	TPI	d <sub>1</sub> Ø Inch	l <sub>1</sub> Inch	l <sub>2</sub> Inch	d <sub>2</sub> Ø Inch	□ a Inch	l <sub>3</sub> Inch	l <sub>4</sub> Inch	# of Flutes	Pack Qty	1994
4		40	0.0890	1.7/8	3/8	0.1410	0.1100	3/16	1/4	2	1	1110010
5		40	0.1015	1.15/16	13/32	0.1410	0.1100	3/16	9/32	2	1	1110020
6		32	0.1110	2"	7/16	0.1410	0.1100	3/16	5/16	2	1	1110030
8		32	0.1360	2.1/8	1/2	0.1680	0.1310	1/4	3/8	2	1	1110040
10		24	0.1540	2.3/8	5/8	0.1940	0.1520	1/4	13/32	2	1	1110050
	10	32	0.1610	2.3/8	5/8	0.1940	0.1520	1/4	13/32	2	1	1110054
12		24	0.1800	2.3/8	21/32	0.2200	0.1650	9/32	15/32	2	1	1110060
	12	28	0.1850	2.3/8	21/32	0.2200	0.1650	9/32	15/32	2	1	1110064
1/4		20	0.2055	2.1/2	25/32	0.2550	0.1910	5/16	17/32	2	1	1110080
	1/4	28	0.2188	2.1/2	25/32	0.2550	0.1910	5/16	17/32	2	1	1110084
5/16		18	0.2660	2.27/32	15/16	0.3180	0.2380	3/8	11/16	2	1	1110090
	5/16	24	0.2770	2.27/32	15/16	0.3180	0.2380	3/8	11/16	2	1	1110094
3/8		16	0.3230	3.3/8	1.1/16	0.3810	0.2860	7/16	13/16	2	1	1110100
	3/8	24	0.3390	3.3/8	1.1/16	0.3810	0.2860	7/16	13/16	2	1	1110104
7/16		14	0.3770	3.3/4	1.1/4	0.3230	0.2420	13/32	1"	2	1	1110110
	7/16	20	0.3937	3.3/4	1.1/4	0.3230	0.2420	13/32	1"	2	1	1110114
1/2		13	0.4331	4.1/16	1.3/8	0.3670	0.2750	7/16	1.1/8	2	1	1110120
	1/2	20	0.4531	4.1/16	1.3/8	0.3670	0.2750	7/16	1.1/8	2	1	1110124

# SPECIAL PURPOSE TAPS

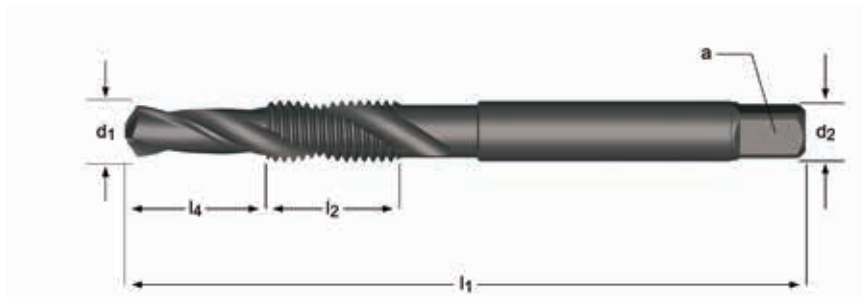


## Combination Drill & Tap

**E651** Spiral Flute 30°. Drills and taps in a single pass, reducing cycle time. Commonly used in multi-spindle operations with reversing capacity. Designed to provide 65% thread engagement and a 2B class of fit.

**E654**

Steam oxide finish reduces wear and chip welding in harder ferrous materials.



E651 / E654

UNC UNF

DORMER  
DIN

2B

HSS

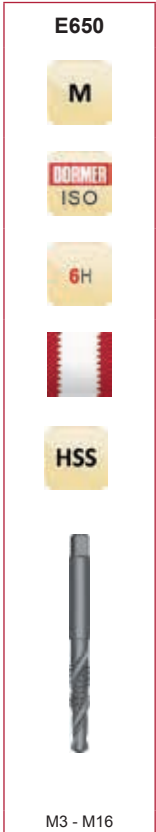
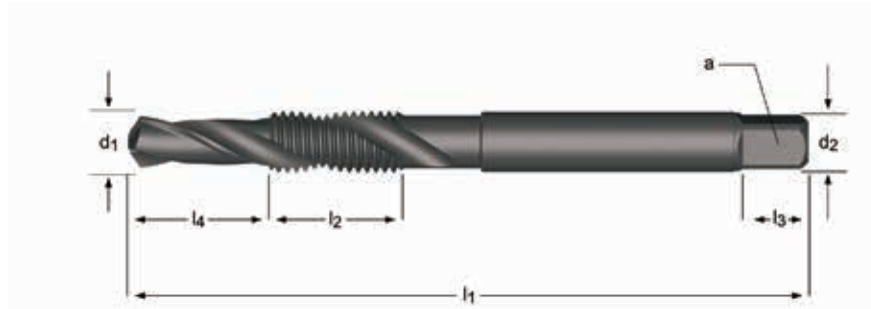
No.6 - 5/8

UNC	UNF	TPI	d <sub>1</sub> nom mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> mm	d <sub>2</sub> Ø mm	□ a mm	# of Flutes	Pack Qty	E651 / E654
6		32	2.85	56.9	12	6.0	3.50	2.90	2	1	0388907
8		32	3.50	64.0	12	8.0	4.50	3.55	2	1	0273272
	8	36	3.50	64.0	13	8.0	4.50	3.55	2	1	0339053
10		24	3.90	72.0	15	10.0	5.00	4.00	2	1	0273197
	10	32	4.10	72.0	16	10.0	5.00	4.00	2	1	0338971
12		24	4.50	77.0	15	11.0	5.60	4.50	2	1	0273210
	12	28	4.70	77.0	17	11.0	5.60	4.50	2	1	0338995
1/4		20	5.10	83.0	17	13.0	6.30	5.00	2	1	0273227
	1/4	28	5.50	83.0	19	13.0	6.30	5.00	2	1	0339008
5/16		18	6.60	94.0	21	16.0	8.00	6.30	2	1	0273241
	5/16	24	6.90	94.0	22	16.0	8.00	6.30	2	1	0339022
3/8		16	8.00	104.0	23	19.0	10.00	8.00	2	1	0273234
	3/8	24	8.50	104.0	24	19.0	10.00	8.00	2	2	0339015
7/16		14	9.40	107.0	25	22.0	8.00	6.30	2	1	0273265
	7/16	20	9.90	107.0	25	22.0	8.00	6.30	2	1	0339046
1/2		13	10.80	114.0	29	25.0	9.00	7.10	2	1	0273203
	1/2	20	11.50	114.0	29	25.0	9.00	7.10	2	1	0338988
9/16		12	12.20	124.0	29	28.0	11.20	9.00	2	1	0273289
	9/16	18	12.90	124.0	30	28.0	11.20	9.00	2	1	0339060
5/8		11	13.50	134.0	31	32.5	12.50	10.00	2	1	0273258
	5/8	18	14.50	134.0	32	32.0	12.50	10.00	2	1	0339039

## Combination Drill & Tap

**E650** Spiral Flute 30°. Drills and taps in a single pass, reducing cycle time. Commonly used in multi-spindle operations with reversing capacity. Designed to provide 65% thread engagement and a 2B class of fit.

Steam oxide finish reduces wear and chip welding in harder ferrous materials.



M3 - M16

M	P	d <sub>1</sub> Ø	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	d <sub>2</sub> Ø	□ a	l <sub>3</sub>	# of Flutes	Pack Qty	E650
3	0.50	2.5	56	10	6	3.15	2.5	5.0	2	1	0167861
4	0.70	3.3	65	12	8	4.0	3.15	6.0	2	1	0127551
5	0.80	4.2	69	15	10	5.0	4.00	7.0	2	1	0127568
6	1.00	5.0	84	18	12	6.3	5.00	8.0	2	1	0127575
8	1.25	6.8	96	21	16	8.0	6.30	9.0	2	1	0127582
10	1.50	8.5	108	22	20	10.0	8.00	11.0	2	1	0127513
12	1.75	10.2	113	29	24	9.0	7.10	10.0	2	1	0127520
14	2.00	12.0	123	30	28	11.2	9.00	12.0	2	1	0127537
16	2.00	14.0	134	32	32	12.5	10.00	13.0	2	1	0127544

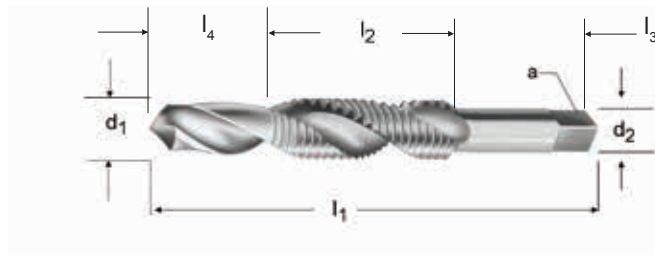
# SPECIAL PURPOSE TAPS



## Combination Drill & Tap, NPT Pipe Threads

**E653** Spiral Flute 27°. Drills and taps in a single pass, reducing cycle time. Commonly used in multi-spindle operations with reversing capacity.

Bright finish improves chip flow in soft or non-ferrous materials.



E653

NPT

ANSI

Normal



HSS



1/8 - 1"

NPT	TPI	d <sub>1</sub> nom Inch	l <sub>1</sub> Inch	l <sub>2</sub> Inch	l <sub>3</sub> Inch	l <sub>4</sub> Inch	d <sub>2</sub> Ø Inch	□ a Inch	# of Flutes	Pack Qty	E653
1/8	27	0.3346	2.7/8	3/4	3/8	3/4	0.4370	0.3280	2	1	0297285
1/4	18	0.4331	3.5/16	1.1/16	7/16	7/8	0.5620	0.4210	2	1	0297278
3/8	18	0.5709	3.1/2	1.1/16	1/2	15/16	0.7000	0.5310	2	1	0297308
1/2	14	0.7087	4.3/8	1.3/8	5/8	1.1/4	0.6870	0.5150	2	1	0297261
3/4	14	0.9055	4.9/16	1.3/8	11/16	1.5/16	0.9060	0.6790	2	1	0297292
1"	11.5	1.1417	5.3/8	1.3/4	13/16	1.5/8	1.1250	0.8430	2	1	0297247

**Tap Wrench, T-Handle**

**1215** T-Handle tap wrenches have a sliding handle and chuck. Designed for hand tapping in tight places and can also be used with any tool that can be turned by hand.



Tap Wrench #	Hand Reamer Capacity Inch	Hand Reamer Capacity mm	Hand Tap Capacity Inch	Hand Tap Capacity mm	Pack Qty	<b>1215</b>
T0	1/8 - 3/16	M3 - M5	1/16 - 5/32	M1 - M4	1	1810372
T1	3/16 - 5/16	M4 - M7	3/16 - 7/16	M4 - M10	1	1810373
T2	1/4 - 15/32	M6 - M14	1/4 - 9/16	M6 - M14	1	1810374

## Tap Wrench, Straight Handle

**3850** Straight handle tap wrenches are ideal for hand tapping. The straight handle design provides greater leverage, particularly suited for use with larger diameters. Simple to operate. Hardened steel jaws are opened and closed by simply twisting one hand which is knurled for side gripping.



3850



No.8 - No.14

Number	Hand Reamer Capacity Inch	Hand Reamer Capacity mm	Hand Tap Capacity Inch	Hand Tap Capacity mm	l <sub>1</sub> Length	Pack Qty	3850
8	1/8 - 5/16	M3 - M8	1/16 - 5/16	M1 - M8	7"	1	1810017
9	3/16 - 3/8	M5 - M9	3/16 - 1/2	M4 - M12	10.1/2"	1	1810018
10	1/4 - 9/16	M6 - M14	1/4 - 3/4	M3 - M8	15"	1	1810019
11	3/8 - 3/4	M9 - M19	3/8 - 1"	M10 - M25	20"	1	1810020
12	3/8 - 7/8	M9 - M22	3/8 - 1.1/8	M10 - M27	25.5/8"	1	1810021
14	5/8 - 1.1/2	M16 - M39	7/8 - 1.7/8	M22 - M42	40.1/2"	1	1810022

**Tap & Drill Combination Sets**

**229CSET** 18 piece tap (styles 1500 and 1528) with corresponding drills (styles R10P & R18P). Metal index.



229CSET



Set

Set	Style	Pieces per Set	UNC Tap Sizes	Tap Drill Sizes	Pack Qty	229CSET
229C	1500,1528 Taps; R10P,R15P,R18P Drills	18	6-32,8-32,10-24,10-32,1/4-20,5/16-18,3/8-16,7/16-14,1/2-13	#36,#29,#25,#21,#7,F,5/16,U,27/64	1	4111502

# LIST NUMBER INDEX - DIES



Thread Form:	<b>UNC</b>	<b>UNF</b>
Standard:	<b>ANSI</b>	<b>ANSI</b>
Tolerance:		
Chamfer:		
Tool Material:	<b>CS</b>	<b>CS</b>
Direction of Cut:		
Finish/Coating:		
Style:	<b>2010(UNC)</b>	<b>2010(UNF)</b>
Range:	No.4 - 1.1/2	No.10 - 1.1/2

Application Material Groups (AMG)			Hardness HRC	Page #	356	356
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	1.1	26	26
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	1.2	23	23
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	1.3	20	20
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	1.4	16	16
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	1.5		
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	1.6		
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	1.7		
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	1.8		
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	2.1	13	13
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	2.2	7	7
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	2.3		
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	2.4		
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	3.1	26	26
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	3.2	23	23
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	3.3	20	20
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	3.4	16	16
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	4.1		
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28	4.2		
	4.3 Titanium, alloyed	6Al4V-4Mo, 7A14V-4Mo, 4911-4967	>28<38	4.3	7	7
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	5.1	30	30
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	5.2	7	7
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	5.3	7	7
6. Copper	6.1 Copper	Commercially Pure	<100 HB	6.1	30	30
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	6.2	26	26
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	6.3	23	23
	6.4 High Strength Bronze	Ampco 18-25	<49	6.4		
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	7.1	33	33
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	7.2	49	49
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	7.3	49	49
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	7.4	33	33
8. Synthetic Materials	8.1 Thermoplastics	Ultradim, Polystrol	---	8.1	49	49
	8.2 Thermosetting plastics	Bakeliet, Pertinax	---	8.2	33	33
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	8.3	16	16
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	9.1		
10. Graphite	10.1 Standard graphite		---	10.1		



# LIST NUMBER INDEX - DIES

	UNS	NPT	UNC	UNF	UNC	UNF	M	G
	ANSI	ANSI	ANSI	ANSI	BS 1127: 1950	BS 1127: 1950	ANSI	BS 1127: 1950
					1.75XP	1.75XP		1.75XP
	CS	CS	HSS	HSS	HSS	HSS	HSS	HSS
	<b>2010(UNS)</b>	<b>2010(NPT)</b>	<b>2510(UNC)</b>	<b>2510(UNF)</b>	<b>F320</b>	<b>F330</b>	<b>2710M</b>	<b>F370</b>
	1"	1/8 - 1/2	No.5 - 7/8	No.5 - 7/8	No.4 - 1.1/4	No.4 - 1.1/2	M2 - M20	1/8 - 1.1/2
	<b>364</b>	<b>365</b>	<b>365</b>	<b>365</b>	<b>365</b>	<b>366</b>	<b>367</b>	<b>368</b>
1.1	26	26	26	26	26	26	26	26
1.2	23	23	23	23	23	23	23	23
1.3	20	20	20	20	20	20	20	20
1.4	16	16	16	16	16	16	16	16
1.5								
1.6								
1.7								
1.8								
2.1	13	13	13	13	13	13	13	13
2.2	7	7	7	7	7	7	7	7
2.3								
2.4								
3.1	26	26	26	26	26	26	26	26
3.2	23	23	23	23	23	23	23	23
3.3	20	20	20	20	20	20	20	20
3.4	16	16	16	16	16	16	16	16
4.1								
4.2								
4.3	7	7	7	7	7	7	7	7
5.1	30	30	30	30	30	30	30	30
5.2	7	7	7	7	7	7	7	7
5.3	7	7	7	7	7	7	7	7
6.1	30	30	30	30	30	30	30	30
6.2	26	26	26	26	26	26	26	26
6.3	23	23	23	23	23	23	23	23
6.4								
7.1	33	33	33	33	33	33	33	33
7.2	49	49	49	49	49	49	49	49
7.3	49	49	49	49	49	49	49	49
7.4	33	33	33	33	33	33	33	33
8.1	49	49	49	49	49	49	49	49
8.2	33	33	33	33	33	33	33	33
8.3	16	16	16	16	16	16	16	16
9.1								
10.1								

# LIST NUMBER INDEX - DIES



	<b>M</b> ISO <b>2568</b> 6g 1.75XP HSS	<b>UNC</b> ANSI	<b>UNF</b> ANSI	<b>UNS</b> ANSI	<b>NPT</b> ANSI	<b>M</b> ANSI	<b>M</b> BS 1127: 1950 6g 1.75XP HSS	<b>MF</b> BS 1127: 1950 6g 1.75XP HSS
	<b>F201</b> M3 - M20	<b>2025(UNC)</b> 1/4 - 1.1/2	<b>2025(UNF)</b> 1/4 - 1.1/2	<b>2025(UNS)</b> 11/16 - 1"	<b>2025(NPT)</b> 1/8 - 1"	<b>2325M</b> M6 - M20	<b>F302</b> M3 - M36	<b>F312</b> M8 - M24
	<b>356</b>	<b>356</b>	<b>358</b>	<b>358</b>	<b>360</b>	<b>360</b>	<b>362</b>	<b>363</b>
1.1	26	26	26	26	26	26	26	26
1.2	23	23	23	23	23	23	23	23
1.3	20	20	20	20	20	20	20	20
1.4	16	16	16	16	16	16	16	16
1.5								
1.6								
1.7								
1.8								
2.1	13	13	13	13	13	13	13	13
2.2	7	7	7	7	7	7	7	7
2.3								
2.4								
3.1	26	26	26	26	26	26	26	26
3.2	23	23	23	23	23	23	23	23
3.3	20	20	20	20	20	20	20	20
3.4	16	16	16	16	16	16	16	16
4.1								
4.2								
4.3	7	7	7	7	7	7	7	7
5.1	30	30	30	30	30	30	30	30
5.2	7	7	7	7	7	7	7	7
5.3	7	7	7	7	7	7	7	7
6.1	30	30	30	30	30	30	30	30
6.2	26	26	26	26	26	26	26	26
6.3	23	23	23	23	23	23	23	23
6.4								
7.1	33	33	33	33	33	33	33	33
7.2	49	49	49	49	49	49	49	49
7.3	49	49	49	49	49	49	49	49
7.4	33	33	33	33	33	33	33	33
8.1	49	49	49	49	49	49	49	49
8.2	33	33	33	33	33	33	33	33
8.3	16	16	16	16	16	16	16	16
9.1								
10.1								



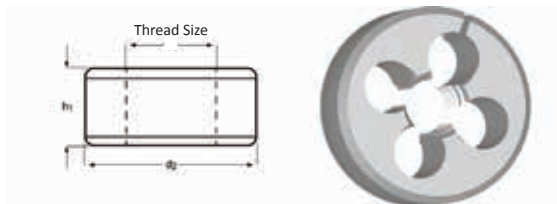
Pgs. 352-370

1301.....	369
2010.....	356
2025.....	365
2325M.....	366
2510.....	358
2710M.....	362
8007.....	369
F201 .....	364
F302 .....	367
F312 .....	368
F320 .....	360
F330 .....	360
F370 .....	363
L110.....	370

## Round Adjustable, Split Type

**2010** Round adjustable dies can be closed down by approximately 0.006" on diameter. Bright finish improves chip flow in soft or non-ferrous materials.

*Note: Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die. NPT type dies are not split.*



2010		2010(UNS)	2010(NPT)
UNC	UNF	UNS	NPT
CS	CS	CS	CS
ANSI	ANSI	ANSI	ANSI
2B	2B		
No.4 - 1/12	1"	1/8 - 1/2	

UNC	UNF	UNS	NPT	TPI	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	2010 (UNC)(UNF)	2010 (UNS)	2010 (NPT)
4				40	13/16	1/4	1	1410016	—	—
5				40	13/16	1/4	1	1410022	—	—
6				32	1"	3/8	1	1410027	—	—
6				32	13/16	1/4	1	1410026	—	—
8				32	1"	3/8	1	1410033	—	—
8				32	13/16	1/4	1	1410032	—	—
	10			32	1"	3/8	1	1410042	—	—
	10			32	13/16	1/4	1	1410041	—	—
10				24	1"	3/8	1	1410039	—	—
10				24	13/16	1/4	1	1410038	—	—
	12			28	13/16	1/4	1	1410047	—	—
12				24	13/16	1/4	1	1410044	—	—
	1/4			28	1"	3/8	1	1410069	—	—
	1/4			28	1.1/2	1/2	1	1410071	—	—
	1/4 (UNEF)			32	1"	3/8	1	1410077	—	—
1/4				20	1"	3/8	1	1410064	—	—
1/4				20	1.1/2	1/2	1	1410066	—	—
1/4				20	13/16	1/4	1	1410063	—	—
	5/16			24	1"	3/8	1	1410085	—	—
	5/16			24	1.1/2	1/2	1	1410087	—	—
	5/16			32	1"	3/8	1	1410090	—	—
5/16				18	1"	3/8	1	1410080	—	—
5/16				18	1.1/2	1/2	1	1410082	—	—
5/16				18	13/16	1/4	1	1410079	—	—
5/16				18	2"	5/8	1	1410083	—	—
	3/8			24	1"	3/8	1	1410097	—	—
	3/8			24	1.1/2	1/2	1	1410099	—	—
3/8				16	1"	3/8	1	1410093	—	—
3/8				16	1.1/2	1/2	1	1410095	—	—
3/8				16	2"	5/8	1	1410096	—	—
			1/8	27	1"	3/8	1	—	—	1410203
			1/8	27	1.1/2	1/2	1	—	—	1410204
	7/16			20	1"	3/8	1	1410105	—	—

# DIES

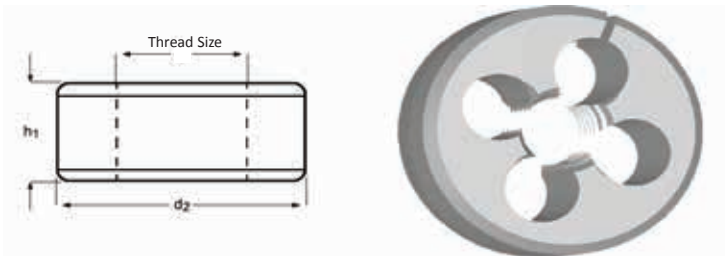
UNC	UNF	UNS	NPT	TPI	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	2010 (UNC)(UNF)	2010 (UNS)	2010 (NPT)
	7/16			20	1.1/2	1/2	1	1410107	—	—
7/16				14	1"	3/8	1	1410101	—	—
7/16				14	1.1/2	1/2	1	1410103	—	—
	1/2			20	1.1/2	1/2	1	1410114	—	—
1/2				13	1.1/2	1/2	1	1410110	—	—
1/2				13	2"	5/8	1	1410111	—	—
			1/4	18	1.1/2	1/2	1	—	—	1410205
			1/4	18	2"	5/8	1	—	—	1410206
	9/16			18	1.1/2	1/2	1	1410120	—	—
9/16				12	1.1/2	1/2	1	1410117	—	—
	5/8			18	1.1/2	1/2	1	1410126	—	—
	5/8			18	2"	5/8	1	1410127	—	—
5/8				11	1.1/2	1/2	1	1410123	—	—
5/8				11	2"	5/8	1	1410124	—	—
			3/8	18	1.1/2	1/2	1	—	—	1410207
			3/8	18	2"	5/8	1	—	—	1410208
	3/4			16	2"	5/8	1	1410133	—	—
3/4				10	2"	5/8	1	1410131	—	—
			1/2	14	2"	5/8	1	—	—	1410209
	7/8			14	2"	5/8	1	1410137	—	—
7/8				9	2"	5/8	1	1410135	—	—
		1"		14	3"	1"	1	—	1410144	—
	1"			12	3"	1"	1	1410142	—	—
1"				8	3"	1"	1	1410140	—	—
1.1/8				7	3"	1"	1	1410145	—	—
	1.1/4			12	3"	1"	1	1410148	—	—
1.1/4				7	3"	1"	1	1410147	—	—
1.3/8				6	3"	1"	1	1410149	—	—
	1.1/2			12	3"	1"	1	1410152	—	—
1/1/2				6	3"	1"	1	1410151	—	—

# DIES

## Round Adjustable, Split Type

**2510** Round adjustable dies can be closed down by approximately 0.006" on diameter. Bright finish improves chip flow in soft or non-ferrous materials.

*Note: Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die*



UNC	UNF	TPI	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	2510(UNC)	2510(UNF)
	5	44	13/16	1/4	1	—	1410154
5		40	13/16	1/4	1	1410153	—
	6	40	13/16	1/4	1	—	1410157
	8	36	13/16	1/4	1	—	1410161
8		32	1"	3/8	1	1410160	—
8		32	13/16	1/4	1	1410159	—
	10	32	1"	3/8	1	—	1410165
	10	32	13/16	1/4	1	—	1410166
10		24	1"	3/8	1	1410164	—
10		24	13/16	1/4	1	1410163	—
	12	28	13/16	1/4	1	—	1410169
12		24	13/16	1/4	1	1410167	—
	1/4	28	1"	3/8	1	—	1410175
	1/4	28	1.1/2	1/2	1	—	1410176
	1/4	28	13/16	1/4	1	—	1410174
1/4		20	1"	3/8	1	1410172	—
1/4		20	1.1/2	1/2	1	1410173	—
	5/16	24	1"	3/8	1	—	1410181
	5/16	24	1.1/2	1/2	1	—	1410182
	5/16	24	13/16	1/4	1	—	1410180
5/16		18	1"	3/8	1	1410178	—
5/16		18	1.1/2	1/2	1	1410179	—
	3/8	24	1"	3/8	1	—	1410185
	3/8	24	1.1/2	1/2	1	—	1410186
3/8		16	1"	3/8	1	1410183	—
3/8		16	1.1/2	1/2	1	1410184	—
	7/16	20	1"	3/8	1	—	1410189
	7/16	20	1.1/2	1/2	1	—	1410190
7/16		14	1"	3/8	1	1410187	—
7/16		14	1.1/2	1/2	1	1410188	—
	1/2	20	1.1/2	1/2	1	—	1410192
1/2		13	1.1/2	1/2	1	1410191	—
	9/16	18	1.1/2	1/2	1	—	1410194

# DIES

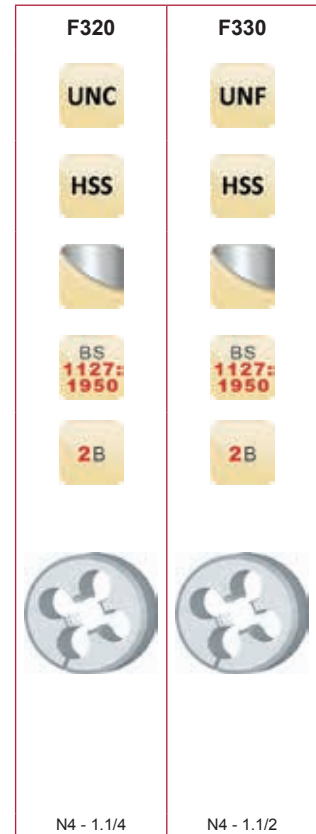
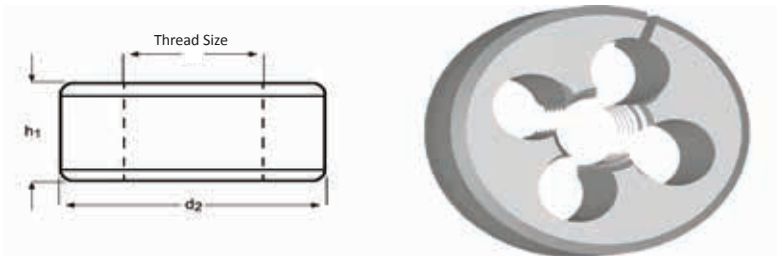
UNC	UNF	TPI	d <sub>2</sub> ∅ Inch	h <sub>1</sub> Inch	Pack Qty	2510(UNC)	2510(UNF)
9/16		12	1.1/2	1/2	1	1410193	—
	5/8	18	1.1/2	1/2	1	—	1410197
5/8		11	1.1/2	1/2	1	1410195	—
	3/4	16	2"	5/8	1	—	1410200
3/4		10	2"	5/8	1	1410199	—
	7/8	14	2"	5/8	1	—	1410202
7/8		9	2"	5/8	1	1410201	—

## Round Adjustable, Split Type

**F320** Round adjustable dies can be closed down by approximately 0.006" on diameter. Bright finish improves chip flow in soft or non-ferrous materials.

**F330**

*Note: Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die.*



UNC	UNF	TPI	d <sub>1</sub> nom mm	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	F320	F330
	4	48	2.85	13/16	1/4	1	—	0207307
4		40	2.85	13/16	1/4	1	0206614	—
	5	44	3.18	13/16	1/4	1	—	0207314
5		40	3.18	13/16	1/4	1	0206621	—
	6	40	3.51	13/16	1/4	1	—	0207338
6		32	3.51	13/16	1/4	1	0206645	—
	8	36	4.17	13/16	1/4	1	—	0207352
8		32	4.17	1"	3/8	1	0206676	—
		32	4.17	13/16	1/4	1	0206669	—
	10	32	4.83	13/16	1/4	1	—	0207376
	10	32	4.83	1"	3/8	1	—	0207383
10		24	4.83	1"	3/8	1	0206690	—
10		24	4.83	13/16	1/4	1	0206683	—
	12	28	5.49	13/16	1/4	1	—	0207390
12		24	5.49	13/16	1/4	1	0206706	—
	1/4	28	6.35	1"	3/8	1	—	0207420
	1/4	28	6.35	1.1/2	1/2	1	—	0207444
	1/4	28	6.35	13/16	1/4	1	—	0207413
1/4		20	6.35	1"	3/8	1	0206737	—
1/4		20	6.35	1.1/2	1/2	1	0206751	—
1/4		20	6.35	1.5/16	7/16	1	0206744	—
1/4		20	6.35	13/16	1/4	1	0206720	—
	5/16	24	7.94	1"	3/8	1	—	0207451
	5/16	24	7.94	1.1/2	1/2	1	—	0207475
	5/16	24	7.94	1.5/16	7/16	1	—	0207468
5/16		18	7.94	1"	3/8	1	0206768	—
5/16		18	7.94	1.1/2	1/2	1	0206782	—
	3/8	24	9.53	1"	3/8	1	—	0207482
	3/8	24	9.53	1.1/2	1/2	1	—	0207505
	3/8	24	9.53	1.5/16	7/16	1	—	0207499
3/8		16	9.53	1"	3/8	1	0206799	—
3/8		16	9.53	1.1/2	1/2	1	0206812	—
3/8		16	9.53	1.5/16	7/16	1	0206805	—

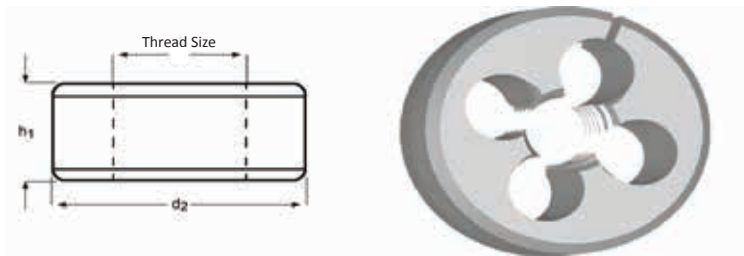


UNC	UNF	TPI	d <sub>1</sub> nom mm	d <sub>2</sub> ∅ Inch	h <sub>1</sub> Inch	Pack Qty	F320	F330
	7/16	20	11.11	1"	3/8	1	—	0207512
	7/16	20	11.11	1.1/2	1/2	1	—	0207536
	7/16	20	11.11	1.5/16	7/16	1	—	0207529
7/16		14	11.11	1.1/2	1/2	1	0206850	—
7/16		14	11.11	1.5/16	7/16	1	0206843	—
	1/2	20	12.70	1.1/2	1/2	1	—	0207550
	1/2	20	12.70	1.5/16	7/16	1	—	0207543
1/2		13	12.70	1.1/2	1/2	1	0206874	—
1/2		13	12.70	1.5/16	7/16	1	0206867	—
1/2		13	12.70	2"	5/8	1	0206881	—
	9/16	18	14.29	1.1/2	1/2	1	—	0207581
	9/16	18	14.29	1.5/16	7/16	1	—	0207574
9/16		12	14.29	1.1/2	1/2	1	0206904	—
	5/8	18	15.88	1.1/2	1/2	1	—	0207604
	5/8	18	15.88	2"	5/8	1	—	0207611
5/8		11	15.88	1.1/2	1/2	1	0206928	—
5/8		11	15.88	2"	5/8	1	0206935	—
	3/4	16	19.05	1.1/2	1/2	1	—	0207635
	3/4	16	19.05	2"	5/8	1	—	0207642
3/4		10	19.05	1.1/2	1/2	1	0206959	—
3/4		10	19.05	2"	5/8	1	0206966	—
	7/8	14	22.23	2"	5/8	1	—	0207659
7/8		9	22.23	2"	5/8	1	0206973	—
	1"	12	25.40	2"	5/8	1	—	0207666
1"		8	25.40	2"	5/8	1	0206980	—
	1.1/8	12	28.58	3"	7/8	1	—	0207673
1.1/8		7	28.58	3"	7/8	1	0206997	—
	1.1/4	12	31.75	3"	7/8	1	—	0207680
1.1/4		7	31.75	3"	7/8	1	0207000	—
	1.1/2	12	38.10	3"	7/8	1	—	0207703

## Round Adjustable, Split Type

**2710M** Round adjustable dies can be closed down by approximately 0.006" on diameter. Bright finish improves chip flow in soft or non-ferrous materials.

**Note:** Die pictured has 4 clearance holes.  
The number of clearance holes will increase or decrease depending on the size of the die



**2710M**

**M**

**HSS**

**ANSI**

**6H**

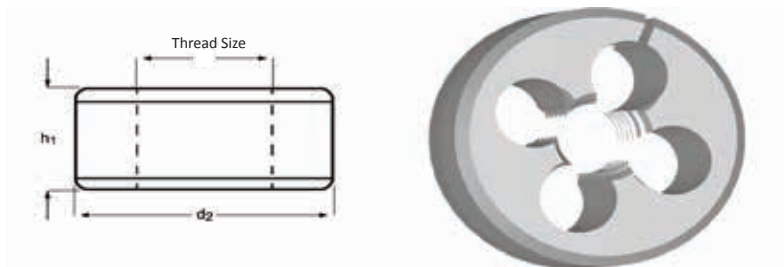
M2 - M20

M	P mm	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	2710M
2	0.40	13/16	1/4	1	1410573
2.5	0.45	13/16	1/4	1	1410575
3	0.50	13/16	1/4	1	1410577
4	0.70	13/16	1/4	1	1410579
4.5	0.75	13/16	1/4	1	1410580
5	0.80	13/16	1/4	1	1410581
6	1.00	1"	3/8	1	1410582
8	1.25	1"	3/8	1	1410584
9	1.25	1"	3/8	1	1410585
10.0	1.50	1"	3/8	1	1410586
12	1.75	1"	3/8	1	1410630
12	1.75	1.1/2	1/2	1	1410588
14	2.00	1.1/2	1/2	1	1410589
16	2.00	1.1/2	1/2	1	1410590
18	2.50	2"	5/8	1	1410591
20	2.50	2"	5/8	1	1410592

## Round Adjustable, Split Type

**F370** Round adjustable dies can be closed down by approximately 0.006" on diameter. Bright finish improves chip flow in soft or non-ferrous materials.

**Note:** Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die.



**F370**

**G**

**HSS**

**BS 1127: 1950**

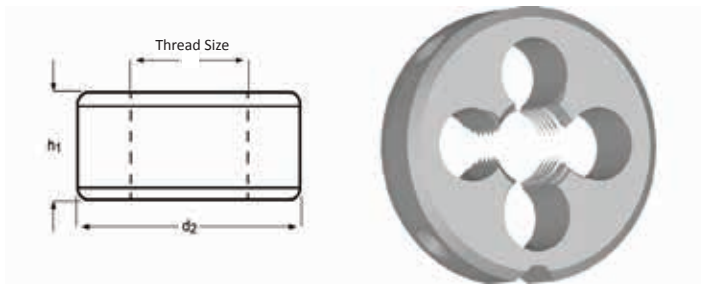
1/8 - 1.1/2

G(BSP)	TPI	d <sub>1</sub> nom mm	d <sub>2</sub> Ø Inch	h <sub>1</sub> Inch	Pack Qty	F370
1/8	28	9.73	1"	3/8	1	0209325
1/4	19	13.16	1.5/16	7/16	1	0209332
3/8	19	16.66	1.1/2	1/2	1	0209349
1/2	14	20.96	2"	5/8	1	0209356
5/8	14	22.91	2"	5/8	1	0209363
3/4	14	26.44	2"	5/8	1	0209370
7/8	14	30.20	2.1/4	11/16	1	0209387
1"	11	33.25	2.1/4	11/16	1	0209394
1.1/4	11	41.91	3"	7/8	1	0209400
1.1/2	11	47.80	4"	1"	1	0209417

## Gun Nosed Dies (Left Hand)

**F201** Left hand gun nosed dies have a chamfer length similar to semi-bottoming taps to lead the threads. This design direct chips away from the cutting area. Bright finish improves chip flow in soft or non-ferrous materials.

**Note:** Die pictured has 4 clearance holes.  
The number of clearance holes will increase or decrease depending on the size of the die



F201

M

HSS



ISO  
2568

6H



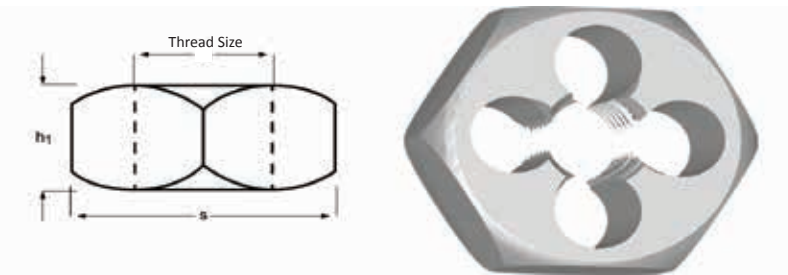
M3 - M20

M	P mm	d <sub>2</sub> Ø mm	h <sub>1</sub> mm	Pack Qty	F201
3	0.50	20	5	1	0164747
4	0.70	20	5	1	0105030
5	0.80	20	7	1	0105047
6	1.00	20	7	1	0105054
8	1.25	25	9	1	0105061
10	1.50	30	11	1	0104996
12	1.75	38	14	1	0105009
14	2.00	38	14	1	0105016
16	2.00	45	18	1	0105023
18	2.50	45	18	1	0164754
20	2.50	45	18	1	0164761

**Hexagon Rethreading Bolt Dies (Dienuts)**

**2025** Rethreading bolt dies (dienuts) are used for reclaiming or cleaning up threads by hand. They are not normally used for cutting threads from solid. Bright finish improves chip flow in soft or non-ferrous materials.

*Note: Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die*



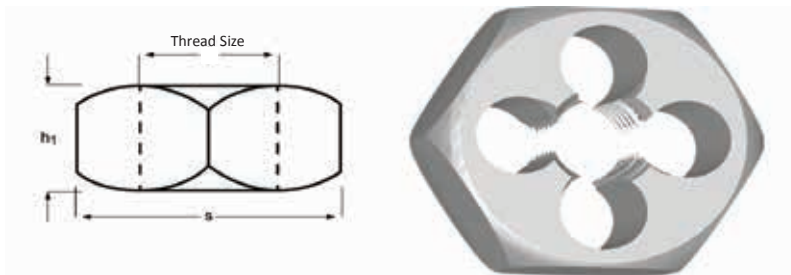
2025(UNC)	2025(UNF)	2025(UNS)	2025(NPT)
UNC	UNF	UNS	NPT
CS	CS	CS	CS
ANSI	ANSI	ANSI	ANSI
2B	2B	2B	
1/4 - 1.1/2	1/4 - 1.1/2	11/16 - 1"	1/8 - 1"

UNC	UNF	UNS	NPT	TPI	S Inch	h <sub>1</sub> Inch	Pack Qty	2025(UNC)	2025(UNF)	2025(UNS)	2025(NPT)
			1/8	27	1.1/16	3/8	1	—	—	—	1410270
	1/4			28	19/32	1/2	1	—	1410240	—	—
1/4				20	19/32	1/2	1	1410239	—	—	—
		1/4		18	1.1/4	5/8	1	—	—	—	1410271
	5/16			24	11/16	5/16	1	—	1410242	—	—
5/16				18	11/16	5/16	1	1410241	—	—	—
	3/8			24	25/32	3/8	1	—	1410244	—	—
3/8				16	25/32	3/8	1	1410243	—	—	—
		3/8		18	1.7/16	5/8	1	—	—	—	1410272
	7/16			20	7/8	7/16	1	—	1410246	—	—
7/16				14	7/8	7/16	1	1410245	—	—	—
	1/2			20	1.1/16	1/2	1	—	1410248	—	—
1/2				13	1.1/16	1/2	1	1410247	—	—	—
		1/2		14	1.5/8	3/4	1	—	—	—	1410273
	9/16			18	1.1/16	1/2	1	—	1410250	—	—
9/16				12	1.1/16	1/2	1	1410249	—	—	—
	5/8			18	1.1/4	5/8	1	—	1410252	—	—
5/8				11	1.1/4	5/8	1	1410251	—	—	—
		11/16		11	1.7/16	3/4	1	—	—	1410253	—
		11/16		16	1.7/16	3/4	1	—	—	1410254	—
	3/4			16	1.7/16	3/4	1	—	1410256	—	—
3/4				10	1.7/16	3/4	1	1410255	—	—	—
		3/4		14	2"	13/16	1	—	—	—	1410274
	7/8			14	1.5/8	7/8	1	—	1410258	—	—
7/8				9	1.5/8	7/8	1	1410257	—	—	—
	1"			14	1.13/16	1"	1	—	—	1410261	—
	1"			12	1.13/16	1"	1	—	1410260	—	—
1"				8	1.13/16	1"	1	1410259	—	—	—
		1"		11.5	2.3/8	1"	1	—	—	—	1410275
	1.1/8			12	2"	1"	1	—	1410263	—	—
1.1/8				7	2"	1"	1	1410262	—	—	—
	1.1/4			12	2.3/16	1"	1	—	1410265	—	—
1.1/4				7	2.3/16	1"	1	1410264	—	—	—
	1.3/8			12	2.3/8	1"	1	—	1410267	—	—
1.3/8				6	2.3/8	1"	1	1410266	—	—	—
	1.1/2			12	2.9/16	1"	1	—	1410269	—	—
1.1/2				6	2.9/16	1"	1	1410268	—	—	—

## Hexagon Rethreading Bolt Dies (Dienuts)

**2325M** Rethreading bolt dies (dienuts) are used for reclaiming or cleaning up threads by hand. They are not normally used for cutting threads from solid. Bright finish improves chip flow in soft or non-ferrous materials.

**Note:** Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die.



2325M

M

CS

ANSI

6H

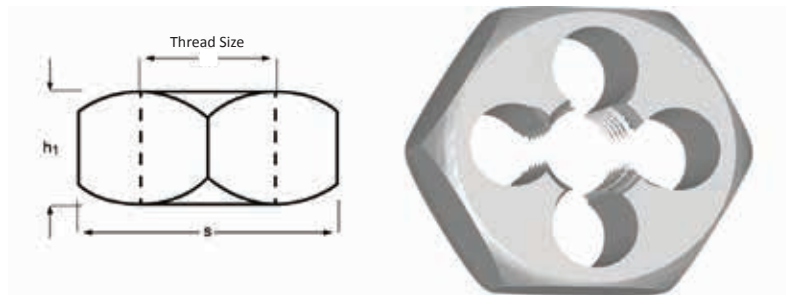
M6 - M20

M	P mm	S Inch	h <sub>1</sub> Inch	Pack Qty	2325M
6	1.00	1	3/8	1	1410609
8	1.25	1	3/8	1	1410611
9	1.25	1	3/8	1	1410612
10	1.50	1	3/8	1	1410613
12	1.75	1	3/8	1	1410615
14	2.00	1.7/16	1/2	1	1410616
16	2.00	1.7/16	1/2	1	1410618
18	1.50	1.7/16	1/2	1	1410620
18	2.50	1.7/16	1/2	1	1410619
20	2.50	1.13/16	3/4	1	1410621

## Hexagon Rethreading Bolt Dies (Dienuts)

**F302** Rethreading bolt dies (dienuts) are used for reclaiming or cleaning up threads by hand. They are not normally used for cutting threads from solid. Bright finish improves chip flow in soft or non-ferrous materials.

*Note: Die pictured has 4 clearance holes. The number of clearance holes will increase or decrease depending on the size of the die.*



**F302**

**M**

**HSS**

**BS 1127: 1950**

**6H**

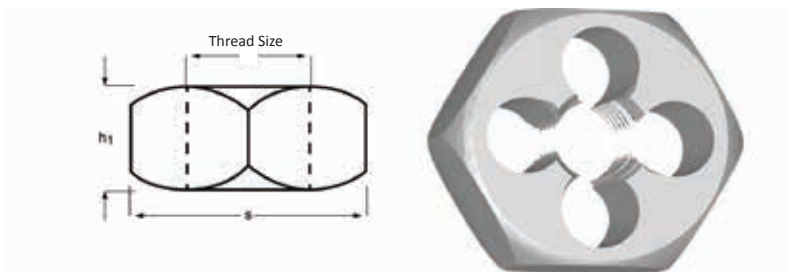
M3 - M36

M	P mm	S decimal Inch	h <sub>1</sub> Inch	Pack Qty	F302
3	0.50	0.7100	1/4	1	0105627
4	0.70	0.7100	1/4	1	0105672
5	0.80	0.7100	1/4	1	0105719
6	1.00	0.7100	1/4	1	0105733
7	1.00	0.8200	5/16	1	0105740
8	1.25	0.8200	5/16	1	0105757
10	1.50	0.9200	3/8	1	0105528
11	1.50	1.0100	7/16	1	0105535
12	1.75	1.1000	1/2	1	0105542
14	2.00	1.3000	5/8	1	0105559
16	2.00	1.3000	5/8	1	0105566
18	2.50	1.4800	11/16	1	0105573
20	2.50	1.4800	11/16	1	0105580
22	2.50	1.6700	13/16	1	0105597
24	3.00	2.0500	15/16	1	0105603
27	3.00	2.2200	1.1/16	1	0105610
30	3.50	2.2200	1.1/16	1	0105634
33	3.50	2.5800	1.1/8	1	0105641
36	4.00	2.7600	1.1/4	1	0105658

## Hexagon Rethreading Bolt Dies (Dienuts)

**F312** Rethreading bolt dies (dienuts) are used for reclaiming or cleaning up threads by hand. They are not normally used for cutting threads from solid. Bright finish improves chip flow in soft or non-ferrous materials.

*Note: Die pictured has 4 clearance holes.  
The number of clearance holes will increase or decrease depending on the size of the die*



F312

MF

HSS



BS  
1127:  
1950

6H



M8 - M24

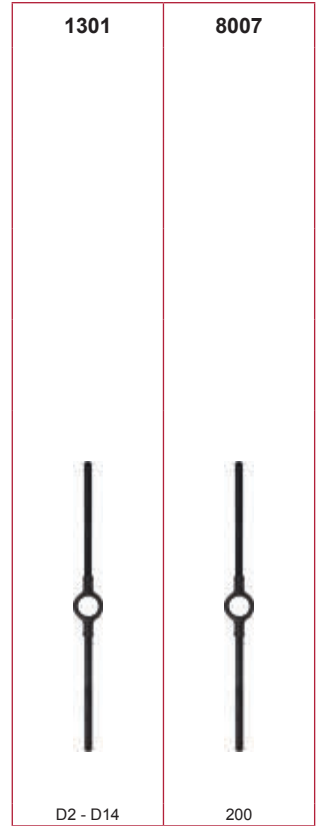
MF	P mm	S decimal Inch	h <sub>1</sub> Inch	Pack Qty	F312
8	0.75	0.8200	5/16	1	0206331
8	1.00	0.8200	5/16	1	0206348
10	1.00	0.9200	3/8	1	0206379
10	1.25	0.9200	3/8	1	0206386
12	1.00	1.0100	7/16	1	0206393
12	1.25	1.0100	7/16	1	0206409
12	1.50	1.0100	7/16	1	0206416
14	1.50	1.3000	5/8	1	0206430
16	1.50	1.3000	5/8	1	0206454
18	1.50	1.4800	11/16	1	0206461
20	1.50	1.4800	11/16	1	0206485
22	1.50	1.6700	13/16	1	0206508
24	1.50	2.0500	15/16	1	0206522
24	2.00	2.0500	15/16	1	0206539



**Die Stocks, Straight Handle**

**1301**    Designed for use with round adjustable split dies. The die is held in place by two opposed cone point screws in the stock which locate in two indents in the die. When this is effected, the split in the die lines up opposite a third pointed set screw which can be run in to spread the die slightly for minute adjustment.

**8007**



Die Stock #	$l_1$ Inch	Die O.D.	Pack Qty	1301	8007
D2	6.3/8	13/16	1	1810042	—
D3	9"	1"	1	1810043	—
D6	14"	1.1/2	1	1810096	—
200	14.3/4	2"	1	—	1810053
D14	40.3/4	3"	1	1810034	—

## Die Stocks, Straight Handle

**L110** Designed for use with Dormer gun nosed dies. The die is held in place by two opposed cone point screws in the stock which locate in two indents in the die. When this is effected, the split in the die lines up opposite a third pointed set screw which can be run in to spread the die slightly for minute adjustment.



L110










16.00 - 4"

Nr.	Die Size Ø x H	Pack Qty	L110
1"	16 x 5	1	0111604
2a	20 x 5	1	0111611
2b	20 x 7	1	0111628
3	25 x 9	1	0111635
4"	30 x 11	1	0111642
5	38 x 14	1	0111666
5f	38 x 10	1	0111659
6	45 x 18	1	0111680
6f	45 x 14	1	0111673
7	55 x 22	1	0111703
7f	55 x 16	1	0111697
8	65 x 25	1	0111727
8f	65 x 18	1	0111710
9	75 x 30	1	0111741
9f	75 x 20	1	0111734
10	90 x 36	1	0111765
10f	90 x 22	1	0111758
	13/16 x 1/4	1	0218013
	1 x 3/8	1	0218020
	1.5/16 x 7/16	1	0218037
	1.1/2 x 1/2	1	0218044
	2 x 5/8	1	0218051
	2.1/4 x 11/16	1	0218068
	3 x 7/8	1	0218075
	4 x 1	1	0218082



# Visual Index - End Mills

# of Flutes	Type of Cut	Depth/Width of Cut	Alpha Code	Feed Per Tooth (Ft) Dia Inches										
				1/8	5/32	3/16	1/4	5/16	13/32	1/2	9/16	5/8	11/16	3/4
>4		↑ 1,5 ↔ 0,05	A				0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002
			B				0.002	0.002	0.002	0.003	0.003	0.004	0.004	0.004
			C				0.003	0.003	0.004	0.004	0.005	0.005	0.006	0.007
3-4		↑ 1,5 ↔ 0,1	A	0.001	0.001	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.004	0.005
			B	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.006	0.007
			C	0.001	0.002	0.002	0.003	0.004	0.004	0.005	0.006	0.006	0.007	0.008
3-4		↑ 1 ↔ 0,5	A	0.000	0.000	0.000	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002
			B	0.003	0.000	0.001	0.001	0.001	0.002	0.002	0.002	0.003	0.003	0.004
			C	0.000	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005
2-3		↑ 0,5 ↔ 1	A	0.000	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003
			B	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004
			C	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005	0.005
3-4		↑ 0,5 ↔ 1 ↑ 1 ↔ 0,5	B				0.001	0.002	0.003	0.003	0.003	0.004	0.004	0.004
2 & 4		↑ 0,1 - 0,5mm ↔ 0,1 - 0,5mm	A											
			BC	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.003	0.003	0.003	0.004
4		↑ 0,01 - 0,1 ↔ ≤ 1	A											
			BC				0.002	0.002	0.002	0.003		0.003		

## How To Use This Chart to Find Cutting Feed Rate (IPR):

1. Find your Alpha Code on the AMG Chart (example: 279U : U is the Alpha Code).
2. Find the closest diameter for your cutting application on the chart.
3. Select the type of cut and # of flutes to find your Ft Range.

For HSS Feed Rate Chart see page 561

Application Material Groups (AMG)			Hardness HRC	ISO
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	S 1
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28	S 2
	4.3 Titanium, alloyed	6Al4V-4Mo, 7A14V-4Mo, 4911-4967	>28<38	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	N 3
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	N 4
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultramid, Polystrol	---	O
	8.2 Thermosetting plastics	Bakelint, Pertinax	---	O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	H
10. Graphite	10.1 Standard graphite		---	O

# Visual Index - End Mills

Tool Material:	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	
Application:																	
Type:	W	W	W	W	W	N	N	N	N								
Number of Flutes:	Z 2	Z 2	Z 2	Z 3	Z 3	Z 6-8	Z 4	Z 4	Z 4	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	
Cut Length:																	
Helix:	$\lambda$ 42°	$\lambda$ 30°	$\lambda$ 37°	$\lambda$ 45°	$\lambda$ 45°	$\lambda$ 45°	$\lambda$ °	$\lambda$ °	$\lambda$ °	$\lambda$ 30°	$\lambda$ 30°	$\lambda$ 30°	$\lambda$ 30°	$\lambda$ 30°	$\lambda$ 30°	$\lambda$ 30°	
Shank:																	
Finish/Coating:	TiCN	TiCN	TiCN	TiCN	TiCN	AlTiN	AlTiN	AlTiN	AlTiN			TiAlN				TiAlN	
Tolerance:										Normal	Normal	Normal	Normal	Normal	Normal	Normal	
Direction:																	
Style:	S400HA	S401HA	S402HA	S403HA	S404HA	S405HA	S406HA	S406HB	S407HA	E4302	E3302	E3302V	E3302M	E5302	E6302	E6302V	
Range:	1/16 - 3/4	5/32 - 3/4	1/4 - 1"	1/8 - 1"	1/2 - 1"	1/4 - 3/4	1/8 - 1"	3/8 - 1"	1/8 - 1"	1/8 - 1/2	1/16 - 5/8	1/16 - 5/8	2.00 - 25.00	1/8 - 1/2	1/8 - 1/2	1/8 - 1/2	
Page #	378	379	380	381	382	383	384	385	386	386	388	388	389	390	391	391	
370								✓	✓	✓	289B	289B	400B	289B	269B	249B	361B
1.2								✓	✓	✓	223B	223B	298B	223B	212B	200B	269B
1.3								✓	✓	✓	223B	223B	298B	223B	212B	200B	269B
1.4								✓	✓	✓	180B	180B	259B	180B	171B	161B	239B
1.5								✓	✓	✓	161B	161B	230B	161B	152B	144B	200B
1.6								✓	✓	✓	148B	148B	200B	148B	140B	131B	180B
1.7								✓	✓	✓							
1.8								✓	✓	✓							
2.1								✓	✓	✓	200A	200A	325A	200A	190A	180A	298A
2.2								✓	✓	✓	141A	141A	223A	141A	125A	108A	180A
2.3								✓	✓	✓	108A	108A	174A	108A	103A	98A	171A
2.4								✓	✓	✓	89A	89A	131A	89A	78A	66A	131A
3.1									✓	✓	374B	374B	551B	374B	336A	298B	499B
3.2									✓	✓	318B	318B	525B	318B	284B	249B	400B
3.3									✓	✓	318B	318B	525B	318B	284B	249B	400B
3.4								✓	✓	✓	249B	249B	374B	249B	225B	200B	341B
4.1									✓	✓			230B				200B
4.2									✓	✓			200B				180B
4.3									✓	✓			190B				174B
5.1									✓	✓			230B				200B
5.2									✓	✓			161A				141A
5.3									✓	✓			98A				85A
6.1	✓	✓	✓	✓	✓						649C	649C		649C	617C	584C	
6.2	✓	✓	✓	✓	✓						499C	499C		499C	474C	449C	
6.3	✓	✓	✓	✓	✓						499C	499C		499C	474C	449C	
6.4	✓	✓	✓	✓	✓						125B	125B		125B	117B	108B	
7.1	✓	✓	✓	✓	✓						1499C	1499C		1499C	1424C	1348C	
7.2	✓	✓	✓	✓	✓						1499C	1499C		1499C	1424C	1348C	
7.3	✓	✓	✓	✓	✓						649C	649C		649C	617C	584C	
7.4	✓	✓	✓	✓	✓						400B	400B		400B	380B	361B	
8.1	✓	✓	✓	✓	✓												
8.2	✓	✓	✓	✓	✓												
8.3	✓	✓	✓	✓	✓												
9.1																	
10.1																	

✓ See technical section for running parameters on these products

# Visual Index - End Mills

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	
	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	Z 3	Z 3	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	
	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	
	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	
	<b>EB3302</b>	<b>EB3302V</b>	<b>EB3302M</b>	<b>EB3302MV</b>	<b>EB5302</b>	<b>EB6302</b>	<b>EB6302V</b>	<b>E3303</b>	<b>E3303V</b>	<b>E4304</b>	<b>E3304</b>	<b>E3304V</b>	<b>E3304M</b>	<b>E3304MV</b>	<b>E5304</b>	<b>E5304V</b>	<b>E6304</b>
	1/16 - 1/2	1/16 - 1/2	2.00 - 20.00	2.00 - 12.00	1/8 - 5/8	1/8 - 1/2	1/8 - 1/2	1/16 - 1/2	1/16 - 1/2	1/8 - 1/2	1/16 - 1"	1/16 - 1"	2.00 - 25.00	2.00 - 20.00	1/8 - 3/4	1/8 - 3/4	1/8 - 1"
	<b>392</b>	<b>392</b>	<b>393</b>	<b>393</b>	<b>394</b>	<b>395</b>	<b>395</b>	<b>396</b>	<b>396</b>	<b>397</b>	<b>398</b>	<b>398</b>	<b>399</b>	<b>399</b>	<b>400</b>	<b>400</b>	<b>401</b>
379	289B	400B	289B	400B	269B	249B	361B	289B	400B	361B	361B	499B	361B	499B	343B	474B	325B
1.2	223B	298B	223B	298B	212B	200B	269B	223B	298B	325B	325B	449B	325B	449B	312B	425B	298B
1.3	223B	298B	223B	298B	212B	200B	269B	223B	298B	325B	325B	449B	325B	449B	312B	425B	298B
1.4	180B	259B	180B	259B	170B	161B	239B	180B	259B	298B	298B	423B	298B	423B	287B	406B	276B
1.5	161B	230B	161B	230B	152B	144B	200B	161B	230B	249B	249B	400B	249B	400B	238B	380B	226B
1.6	148B	200B	148B	200B	140B	131B	180B	148B	200B	230B	230B	328B	230B	328B	205B	313B	180B
1.7																	
1.8																	
2.1	200A	325A	200A	325A	190A	180A	298A	200A	325A	239A	239A	351A	239A	351A	220A	338A	200A
2.2	141A	223A	141A	223A	125A	108A	180A	141A	223A	171A	171A	276A	171A	276A	156A	251A	141A
2.3	108A	174A	108A	174A	103A	98A	171A	108A	174A	131A	131A	200A	131A	200A	123A	182A	115A
2.4	89A	131A	89A	131A	78A	82A	89A			105A	105A	164A	105A	164A	97A	140A	89A
3.1	374B	551B	374B	551B	336A	298B	499B	374B	551B	449B	449B	699B	449B	699B	405B	650B	361B
3.2	318B	525B	318B	525B	284B	249B	400B	318B	525B	377B	377B	649B	377B	649B	338B	578B	298B
3.3	318B	525B	318B	525B	284B	249B	400B	318B	525B	377B	377B	649B	377B	649B	338B	578B	298B
3.4	249B	374B	249B	374B	225B	200B	341B	249B	374B	279B	279B	430B	279B	430B	254B	415B	230B
4.1		230B		230B			200B		230B			259B		259B		245B	
4.2		200B		200B			180B		200B			230B		230B		220B	
4.3		190B		190B			174B		190B			200B		200B		190B	
5.1		230B		230B		148B	200B		230B			266B		266B		251B	
5.2		161A		161A			141A		161A			200A		200A		190A	
5.3		98A		98A			85A		98A			131A		131A		123A	
6.1	649C		649C		617C	584C		649C		679C	679C		679C		646C		613C
6.2	499C		499C		474C	449C		499C		574C	574C		574C		546C		518C
6.3	499C		499C		474C	449C		499C		574C	574C		574C		546C		518C
6.4	125B		125B		117B	108B		125B		144B	144B		144B		138B		131B
7.1	1499C		1499C		1424C	1348C		1499C		1601C	1601C		1601C		1525C		1450C
7.2	1499C		1499C		1424C	1348C		1499C		1601C	1601C		1601C		1525C		1450C
7.3	649C		649C		617C	584C		649C		708C	708C		708C		674C		640C
7.4	400B		400B		380B	361B		400B		479B	479B		479B		455B		430B
8.1																	
8.2																	
8.3																	
9.1																	
10.1																	

# Visual Index - End Mills

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HSS-E PM	HSS	HSS	HSS	HSS-E	HSS-E PM	HSS	HSS
										N					N		
	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2
	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30°	λ30° γ12°	λ30°	λ30°	λ30°	λ30°	λ30° γ12°	λ30°	λ38°
	ATN	ATN	ATN	ATN	ATN	ATN	ATN	ATN	ATN	OKR 1035E					OKR 1035E		
	Normal	Normal	Normal	Normal	Normal			Normal	Normal	e8	+0.03 -0.00	+0.03 -0.00	+0.001 -0.015	+0.03 -0.00	e8	+0.03 -0.00	+0.03 -0.00
	E6304V	EB3304	EB3304V	EB3304M	EB3304MV	EB5304	EB5304V	EB6304	EB6304V	C110	923	920	920K	963	C123	905	980
	1/8 - 1"	1/16 - 3/4	1/16 - 3/4	2.00 - 12.00	2.00 - 12.00	1/4 - 5/8	1/4 - 5/8	1/8 - 5/8	1/8 - 5/8	1.00 - 50.00	1/8 - 3/4	1/8 - 1.1/2	1/8 - 1"	1/8 - 1"	1/16 - 40.00	1/8 - 3/4	1/4 - 1"
	401	402	402	403	403	404	404	405	405	406	408	409	410	411	412	414	415
1.1	449B	361B	499B	361B	499B	343B	450B	325B	400B	197A	98A	98A	98A	164A	180A	112S	164A
1.2	400B	325B	449B	325B	449B	312B	412B	298B	374B	164A	89A	89A	89A	131A	148A	89S	131A
1.3	400B	325B	449B	325B	449B	312B	412B	298B	374B	131B	75B	75B	75B	115B	131B	79T	115B
1.4	390B	298B	423B	298B	423B	287B	387B	276B	351B	115B				98B	115B		
1.5	361B	249B	400B	249B	400B	238B	363B	226B	325B								
1.6	298B	230B	328B	230B	328B	205B	288B	180B	249B								
1.7																	
1.8																	
2.1	325A	239A	351A	239A	351A	220A	288A	200A	226A	98F				75F	82F		75F
2.2	226A	171A	276A	171A	276A	156A	233A	141A	190A								62F
2.3	164A	131A	200A	131A	200A	123A	176A	115A	151A								
2.4	115A	98A	148A	98A	148A		135A		121A								
3.1	600B	449B	699B	449B	699B	405B	500B	361B	499B	115A	82A	82A	82A	92A	98A	89S	
3.2	508B	377B	649B	377B	649B	338B	540N	298B	430B	98A	66A	66A	66A	75A	82A	72S	
3.3	508B	377B	649B	377B	649B	338B	540B	298B	430B	164B	82B	82B	82B	131B	148B	89T	
3.4	400B	279B	430B	279B	430B	255B	384B	230B	338B	98B				82B	98B		
4.1	230B		259B		259B		230B		200B	115D	59D	59D	59D	92D	98D	62V	92D
4.2	210B		230B		230B		210B		190B	82D	49D	49D	49D	75D	82D	49V	
4.3	180B		200B		200B		180B										
5.1	236B		266B		266B		238B		210B	197D	98D	98D	98D	157D	164D	108V	157D
5.2	180A		200A		200A		176A			49C	20C	20C	20C	43C	49C	20U	
5.3	115A		131A		131A												
6.1		679C		679C		646C		613C	699C	279C	180C	180C	180C	410C	262C	200U	410C
6.2		574C		574C		602C		518C	571C	279C	197C	197C	197C	410C	262C	223U	
6.3		574C		574C		546C		518C	571C	279C	197C	197C	197C	410C	262C	223U	
6.4		144B		144B		137B		131B	180B								
7.1		1601C		1601C		1526C		1450C	1650C	722E	197E	197E	197E	984E	656E	243X	984E
7.2		1601C		1601C		1526C		1450C	1650C	722E	180E	180E	180E	984E	656E	194X	984E
7.3		708C		708C		674C		640C	708C	279E	115E	115E	115E	295E	262E	144X	295E
7.4		479B		479B		455B		430B	410B								
8.1										295C	197C	197C	197C	410C	262C	200U	410C
8.2																	
8.3																	
9.1																	
10.1																	

# Visual Index - End Mills

	HSS	HSS	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS	HSS	HSS-E PM	HSS-E PM	HSS	HSS	HSS-E
	Z 2	Z 3	Z 3	Z 4-8	Z 4-8	Z 4-8	Z 4-8	Z 4-8	Z 4-8	Z 4	Z 4	Z 4-8	Z 4-8	Z 4	Z 4-8	Z 4-8
	$\lambda 38^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$ Y12°	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$ Y12°	$\lambda 30^\circ$ Y12°	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$
	+0.03 +0.00	+0.03 +0.00	e8	+0.05 +0.00	+0.05 +0.00	+0.05 +0.00	+0.05 +0.00	+0.05 +0.00	+0.05 +0.00	Normal	+0.03 +0.00	k10	k10		+0.03 +0.00	+0.03 +0.00
	<b>981</b>	<b>930</b>	<b>C346</b>	<b>9002</b>	<b>TC9002</b>	<b>9003</b>	<b>TC9003</b>	<b>9009</b>	<b>9008</b>	<b>948</b>	<b>945</b>	<b>C247</b>	<b>C273</b>	<b>883</b>	<b>940</b>	<b>960</b>
	1/4 - 3/4	1/8 - 1"	3.00 - 20.00	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 1"	1/4 - 3/4	1/8 - 3/4	1/8 - 1"	2.00 - 50.00	2.00 - 40.00	1/16 - 1/2	1/8 - 1"	1/8 - 1"
	<b>416</b>	<b>417</b>	<b>418</b>	<b>419</b>	<b>419</b>	<b>420</b>	<b>420</b>	<b>421</b>	<b>422</b>	<b>423</b>	<b>424</b>	<b>425</b>	<b>427</b>	<b>429</b>	<b>430</b>	<b>431</b>
1.1	148A		148A	164G	197G	164G	197G	148G	148G	115S	164S	180S	164S	66P	115S	164S
1.2	118A	131A	115A	131G	184G	131G	184G	118G	118G	92S	131S	148S	164S	66P	92S	131S
1.3	102B	115B	98B	115H	161H	115H	161H	102H	102H	79T	115T	131T	115T	52P	79T	115T
1.4		98B	82B	98H	138H	98H	138H	89H	89H	69T	98T	115T	98T	46P	69T	98T
1.5		66C												33P		
1.6														26P		
1.7																
1.8																
2.1	66F		66F	75L	105L	75L	105L	66L	66L	52Y	75Y	82Y	33Y	43P	52Y	75Y
2.2	56F	62F												30P		
2.3														20R		
2.4														16R		
3.1			82A	92G	128G	92G	128G	82G	82G	92S	92S	98S	82S	59R	92S	92S
3.2		75A	66A	75G	105G	75G	105G	66G	66G	75S	75S	82S	66S	49R	75S	75S
3.3		131B	115B	131H	184H	131H	184H	118H	118H	92T	131T	148T	131T	52R	92T	131T
3.4		82B	66B	82H	128H	82H	128H	72H	72H	56T	82T	82T	82T	33R	56T	82T
4.1	82D	92D	82D	92J	128J	92J	128J	82J	82J	62V	92V	98V	82V	52N	62V	92V
4.2		75D	66D	75J	105J	75J	105J	66J	66J	52V	75V	82V	66V	36O	52V	75V
4.3		33D												20O		
5.1	141D		148D	157J	220J	157J	220J	141J	141J	108V	157V	164V	148V	66P	108V	157V
5.2		43C	33C	43I	59I	43I	59I	36I	36I	20U	43U	49U	33U	13O	20U	43U
5.3		20D												7M		
6.1	367C		230C	410I	574I	410I	574I	367I	367I	203U	410U	262U	230U	131P	203U	410U
6.2		410C	230C	410I	574I	410I	574I	367I	367I	223U	410U	262U	230U	148P	223U	410U
6.3		410C	230C	410I	574I	410I	574I	367I	367I	223U	410U	262U	230U	148P	223U	410U
6.4		49C												16M		
7.1	886E		590E								984X	656X	590X	180R		984X
7.2	886E		590E	984K	1378K	984K	1378K	886K	886K	197X	984X	656X	590X	134R	197X	984X
7.3	266E	295E		295K	413K	295K	413K	266K	266K	148X	295X	262X	230X	85R	148X	295X
7.4		197A												56R		
8.1	367C		230C	410I	574I	410I	574I	367I	367I	203U	410U	262U	230U		203U	410U
8.2		410C														
8.3																
9.1																
10.1														56R		



# List Number Index - End Mills



Pgs. 371-431

883.....	429	E3304 .....	398	EB6304V .....	405
905.....	414	E3304M .....	399	S400HA .....	378
920.....	409	E3304MV .....	399	S401HA .....	379
923.....	408	E3304V .....	398	S402HA .....	380
930.....	417	E4302 .....	386	S403HA .....	381
940.....	430	E4304 .....	397	S404HA .....	382
945.....	424	E5302 .....	390	S405HA .....	383
948.....	423	E5304 .....	400	S406HA .....	384
960.....	431	E5304V .....	400	S406HB .....	385
963.....	411	E6302 .....	391	S407HA .....	386
980.....	415	E6302V .....	391	TC9002.....	419
981.....	416	E6304 .....	401	TC9003.....	420
9002.....	419	E6304V .....	401		
9003.....	420	EB3302.....	392		
9008.....	422	EB3302M.....	393		
9009.....	421	EB3302MV ..	393		
920K .....	410	EB3302V .....	392		
C110 .....	406	EB3304.....	402		
C123 .....	412	EB3304M.....	403		
C247 .....	425	EB3304MV ..	403		
C273 .....	427	EB3304V .....	402		
C346 .....	418	EB5302.....	394		
E3302 .....	388	EB5304.....	404		
E3302M .....	389	EB5304V .....	404		
E3302V .....	388	EB6302.....	395		
E3303 .....	396	EB6302V .....	395		
E3303V .....	396	EB6304.....	405		

# Solid Carbide 2-Flute End Mill



## Regular Length, Center Cutting, Square End, 42° Helix

### S400HA

TiCN coating increases surface hardness, and abrasion resistance while resisting edge buildup. The unique combination of a higher rake angle and deeper flutes provides excellent chip evacuation at higher metal removal rates in Aluminum and Non-Ferrous applications.



Cutting Diameter Tolerance = + 0 / - 0.0012"  
Shank Diameter Tolerance = + 0 / - 0.0003"

S400HA

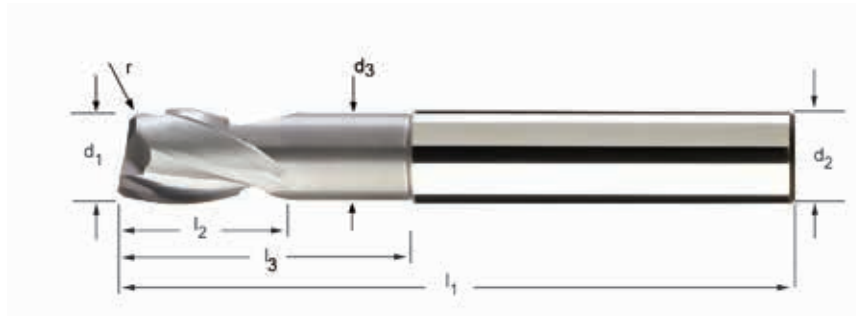


1/16 - 3/4

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	S400HA
1/16	0.0625	1/8	1/8	1.1/2	2	1	46612209
3/32	0.0938	1/8	1/4	1.1/2	2	1	46612260
1/8	0.1250	1/4	5/16	1.3/4	2	1	46612261
3/16	0.1875	1/4	7/16	2"	2	1	46612262
1/4	0.2500	3/8	3/4	2.1/2	2	1	46612263
5/16	0.3125	3/8	13/16	2.1/2	2	1	46612264
3/8	0.3750	3/8	1"	2.1/2	2	1	46612265
1/2	0.5000	1/2	1"	3"	2	1	46612266
1/2	0.5000	1/2	2"	4"	2	1	46612267
5/8	0.6250	5/8	1.1/4	3.1/2	2	1	46612268
3/4	0.7500	3/4	1.1/2	4"	2	1	46612269
3/4	0.7500	3/4	3"	5.1/2	2	1	46612270

## Regular Length, Center Cutting, Corner Radius, 30° Helix, Necked

**S401HA** TiCN coating increases surface hardness, and abrasion resistance while resisting edge buildup. Provides excellent chip evacuation in Aluminum and Non-Ferrous applications. Excellent cutting qualities in Copper and free machining Stainless Steel applications.



Cutting Diameter Tolerance = + 0 / - 0.0012"  
 Shank Diameter Tolerance = + 0 / - 0.0003"

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	r ± 0.0010	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	l <sub>3</sub> Inch	d <sub>3</sub> decimal Inch	Pack Qty	S401HA
5/32	0.1563	0.012	1/4	3/16	2"	2	3/8	0.140	1	46612271
1/4	0.2500	0.020	1/4	5/16	2.3/8	2	3/4	0.226	1	46612272
5/16	0.3125	0.024	5/16	3/8	2.3/4	2	1.1/8	0.282	1	46612273
3/8	0.3750	0.031	3/8	1/2	3.1/8	2	1.1/2	0.336	1	46612274
1/2	0.5000	0.040	1/2	9/16	3.1/2	2	1.1/2	0.460	1	46612275
5/8	0.6250	0.051	5/8	3/4	4"	2	1.3/4	0.566	1	46612276
3/4	0.7500	0.063	3/4	1"	4"	2	1.3/4	0.670	1	46612277

S401HA

HM



W



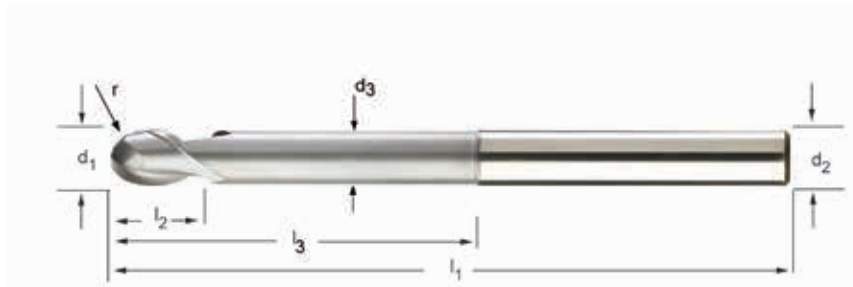
5/32 - 3/4

# Solid Carbide 2-Flute End Mill



## Long Reach Ball Nose, 37° Helix, Necked

**S402HA** TiCN coating increases surface hardness, and abrasion resistance while resisting edge buildup. Provides excellent chip evacuation in Aluminum and Non-Ferrous applications. Suitable for step-milling applications.



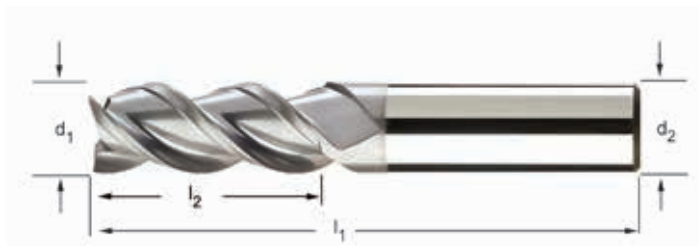
Cutting Diameter Tolerance = + 0 / - 0.0012"  
Shank Diameter Tolerance = + 0 / - 0.0003"



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	r ± 0.0010	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	l <sub>3</sub> Inch	d <sub>3</sub> decimal Inch	Pack Qty	S402HA
1/4	0.2500	1/8	1/4	3/8	4"	2	2.1/4	0.220	1	46612278
3/8	0.3750	3/16	3/8	1/2	4"	2	2.1/4	0.345	1	46612279
1/2	0.5000	1/4	1/2	5/8	5"	2	2.1/4	0.470	1	46612280
1/2	0.5000	1/4	1/2	5/8	6"	2	3.1/4	0.470	1	46612284
1/2	0.5000	1/4	1/2	5/8	6"	2	4"	0.470	1	46612285
5/8	0.6250	5/16	5/8	3/4	5"	2	2.1/4	0.585	1	46612281
5/8	0.6250	5/16	5/8	3/4	6"	2	3.1/4	0.585	1	46612286
5/8	0.6250	5/16	5/8	3/4	7"	2	4.1/4	0.585	1	46612287
3/4	0.7500	3/8	3/4	1"	5"	2	2.1/4	0.710	1	46612282
3/4	0.7500	3/8	3/4	1"	6"	2	3.1/4	0.710	1	46612288
3/4	0.7500	3/8	3/4	1"	7"	2	4.1/4	0.710	1	46612289
1"	1.0000	1/2	1"	1.1/8	5"	2	2.1/4	0.960	1	46612283
1"	1.0000	1/2	1"	1.1/8	6"	2	3.1/4	0.960	1	46612290
1"	1.0000	1/2	1"	1.1/8	7"	2	4.1/4	0.960	1	46612291

## Regular Length, Center Cutting, Square End, 45° Helix

**S403HA** TiCN coating increases surface hardness, and abrasion resistance while resisting edge buildup. The unique combination a 3-Flute design and 45° high helix allows for harmonic balance at high speed for high velocity milling in Aluminum and Non-Ferrous applications.



Cutting Diameter Tolerance = + 0 / - 0.0005"  
 Shank Diameter Tolerance = + 0 / - 0.0003"

**S403HA**

HM

W

Z  
3

1/8 - 1"

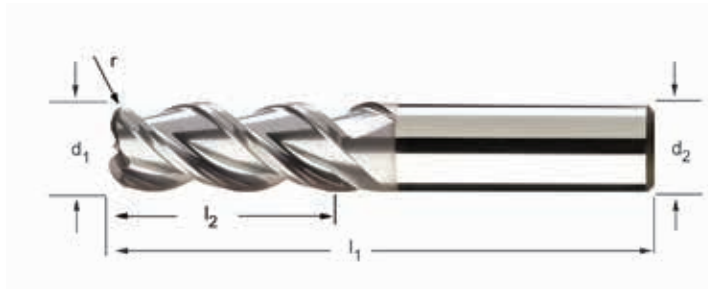
$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	S403HA
1/8	0.1250	1/8	3/8	1.1/2	3	1	46612292
3/16	0.1875	3/16	9/16	2"	3	1	46612293
1/4	0.2500	1/4	5/8	2.1/2	3	1	46612294
5/16	0.3125	5/16	5/8	2.1/2	3	1	46612295
3/8	0.3750	3/8	1"	2.1/2	3	1	46612296
7/16	0.4375	7/16	1.1/4	2.3/4	3	1	46612297
1/2	0.5000	1/2	1.1/4	3"	3	1	46612298
5/8	0.6250	5/8	1.5/8	3.1/2	3	1	46612299
3/4	0.7500	3/4	1.5/8	4"	3	1	46612300
1"	1.0000	1"	2"	5"	3	1	46612301

# Solid Carbide 3-Flute End Mill



## Regular Length, Center Cutting, Square End, 45° Helix

**S404HA** TiCN coating increases surface hardness, and abrasion resistance while resisting edge buildup. The unique combination a 3-Flute design with corner radii and 45° helix allows for harmonic balance at high speed for high velocity milling in Aluminum and Non-Ferrous applications.



Cutting Diameter Tolerance = + 0 / - 0.0005"  
Shank Diameter Tolerance = + 0 / - 0.0003"

**S404HA**

HM

W

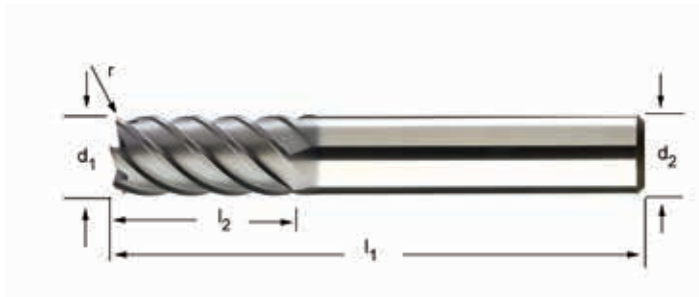
Z  
3

1/2 - 1"

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	r ± 0.0010	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	S404HA
1/2	0.5000	0.060	1/2	1.1/4	3"	3	1	46612302
1/2	0.5000	0.120	1/2	1.1/4	3"	3	1	46612306
5/8	0.6250	0.060	5/8	1.5/8	3.1/2	3	1	46612303
5/8	0.6250	0.120	5/8	1.5/8	3.1/2	3	1	46612307
3/4	0.7500	0.060	3/4	1.5/8	4"	3	1	46612304
3/4	0.7500	0.120	3/4	1.5/8	4"	3	1	46612308
1"	1.0000	0.060	1"	2"	5"	3	1	46612305
1"	1.0000	0.120	1"	2"	5"	3	1	46612309

## Long Length, Center Cutting, Corner Radius, 45° Helix

**S405HA** AlTiN coating increases surface hardness, and improves tool life allowing higher metal removal rates. This 6-8 Flute Finisher with corner radius design and 45° high helix for high speed cutting and finish milling of high hardened materials while providing superior workpiece finishes.



Cutting Diameter Tolerance = + 0 / - 0.0012"

Shank Diameter Tolerance = + 0 / - 0.0003"

S405HA

HM



N



1/4 - 3/4

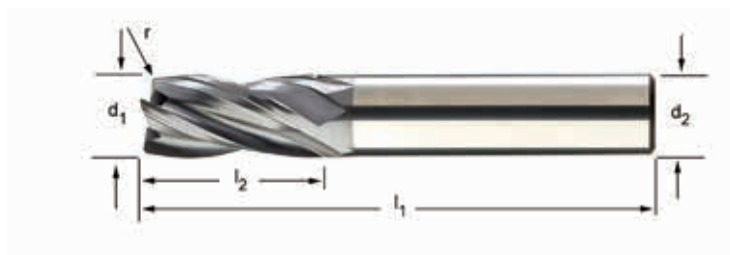
d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	r Inch	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	S405HA
1/4	0.2500	0.020	1/4	1/2	2.1/4	6	1	46660543
5/16	0.3125	0.020	5/16	3/4	2.1/2	6	1	46660544
3/8	0.3750	0.020	3/8	7/8	2.7/8	6	1	46660545
3/8	0.3750	0.030	3/8	7/8	2.7/8	6	1	46660546
1/2	0.5000	0.020	1/2	1"	3.1/4	6	1	46660547
1/2	0.5000	0.030	1/2	1"	3.1/4	6	1	46660548
5/8	0.6250	0.030	5/8	1.1/4	3.5/8	6	1	46660549
5/8	0.6250	0.060	5/8	1.1/4	3.5/8	6	1	46660550
3/4	0.7500	0.030	3/4	1.1/2	4.1/8	8	1	46660551
3/4	0.7500	0.060	3/4	1.1/2	4.1/8	8	1	46660552
3/4	0.7500	0.090	3/4	1.1/2	4.1/8	8	1	46660553

# Solid Carbide 4-Flute End Mill



## Regular Length, Center Cutting, Corner Radius, Unequal Helix

**S406HA** AlTiN coating increases surface hardness, and improves tool life allowing higher metal removal rates. These unequal helix Inco cutters with corner radii are designed for higher speeds and deeper cuts. Provides superior workpiece finishes by eliminating vibrations and harmonics. Excellent for most materials under 40 HRC



S406HA



1/8 - 1"

Cutting Diameter Tolerance = + 0 / - 0.0012"

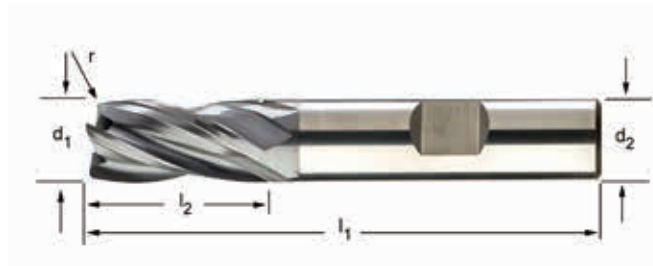
Shank Diameter Tolerance = + 0 / - 0.0003"

$d_1$ Ø Inch	$d_1$ decimal Inch	$r$ ± 0.0012	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	S406HA
1/8	0.1250	0.015	1/8	3/8	1.1/2	4	1	46612328
3/16	0.1875	0.015	3/16	7/16	2"	4	1	46612329
1/4	0.2500	0.020	1/4	1/2	2.1/2	4	1	46612330
5/16	0.3125	0.020	5/16	13/16	2.1/2	4	1	46612331
3/8	0.3750	0.020	3/8	7/8	2.1/2	4	1	46612332
7/16	0.4375	0.020	7/16	1"	2.3/4	4	1	46612333
1/2	0.5000	0.030	1/2	1"	3"	4	1	46612334
9/16	0.5625	0.030	9/16	1.1/8	3.1/2	4	1	46612335
5/8	0.6250	0.040	5/8	1.1/4	3.1/2	4	1	46612336
3/4	0.7500	0.040	3/4	1.1/2	4"	4	1	46612337
1"	1.0000	0.040	1"	1.1/2	4"	4	1	46612338



## Regular Length, Center Cutting, Corner Radius, Unequal Helix

**S406HB** AlTiN coating increases surface hardness, and improves tool life allowing higher metal removal rates. These unequal helix Inox cutters with corner radii are designed for higher speeds and deeper cuts. Provides superior workpiece finishes by eliminating vibrations and harmonics. Excellent for most materials under 40 HRC. Weldon flat on shank.



Cutting Diameter Tolerance = + 0 / - 0.0012"  
 Shank Diameter Tolerance = + 0 / - 0.0003"

$d_1$ Ø Inch	$d_1$ decimal Inch	$r$ ± 0.0012	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	S406HB
3/8	0.3750	0.020	3/8	7/8	2.1/2	4	1	46612339
7/16	0.4375	0.020	7/16	1"	2.3/4	4	1	46612340
1/2	0.5000	0.030	1/2	1"	3"	4	1	46612341
9/16	0.5625	0.030	9/16	1.1/8	3.1/2	4	1	46612342
5/8	0.6250	0.040	5/8	1.1/4	3.1/2	4	1	46612343
3/4	0.7500	0.040	3/4	1.1/2	4"	4	1	46612344
1"	1.0000	0.040	1"	1.1/2	4"	4	1	46612345

S406HB

HM



N



3/8 - 1"

# Solid Carbide 4-Flute End Mill



## Regular Length, Center Cutting, Corner Radius, Unequal Helix

**S407HA** AlTiN coating increases surface hardness, and improves tool life allowing higher metal removal rates. These unequal helix Steel cutters with corner radii are designed for higher speeds and deeper cuts. Provides superior workpiece finishes by eliminating vibrations and harmonics. Excellent for most materials under 40 HRC



Cutting Diameter Tolerance = + 0 / - 0.0012"  
Shank Diameter Tolerance = + 0 / - 0.0003"

**S407HA**

HM

N

Z  
4

1/8 - 1"

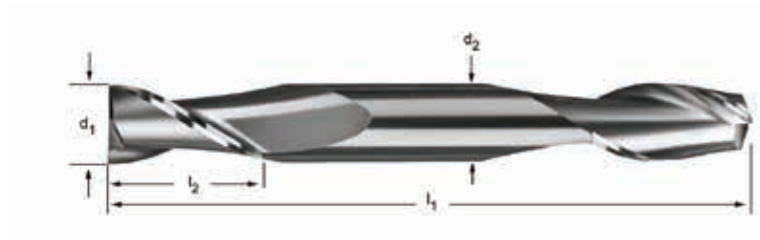
d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	r ± 0.0012	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	S407HA
1/8	0.1250	0.010	1/8	3/8	1.1/2	4	1	46612317
3/16	0.1875	0.010	3/16	7/16	2"	4	1	46612318
1/4	0.2500	0.015	1/4	1/2	2.1/2	4	1	46612319
5/16	0.3125	0.015	5/16	13/16	2.1/2	4	1	46612320
3/8	0.3750	0.015	3/8	7/8	2.1/2	4	1	46612321
7/16	0.4375	0.015	7/16	1"	2.3/4	4	1	46612322
1/2	0.5000	0.025	1/2	1"	3"	4	1	46612323
9/16	0.5625	0.025	9/16	1.1/8	3.1/2	4	1	46612324
5/8	0.6250	0.035	5/8	1.1/4	3.1/2	4	1	46612325
3/4	0.7500	0.035	3/4	1.1/2	4"	4	1	46612326
1"	1.0000	0.035	1"	1.1/2	4"	4	1	46612327



# Solid Carbide 2 Flute End Mill

## Regular Length, Square End, Double End, 30° Helix

**E4302** Double end provides two cutting ends in one tool. Bright finish improves chip flow in soft and non-ferrous materials



**E4302**

HM

Z  
2

1/8 - 1/2

$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	<b>E4302</b>
1/8	0.1250	3/8	3/8	3"	2	1	002200
5/32	0.1562	3/8	7/16	3"	2	1	002201
3/16	0.1875	3/8	1/2	3"	2	1	002202
1/4	0.2500	3/8	5/8	3"	2	1	002204
5/16	0.3125	3/8	3/4	3.1/2	2	1	002206
3/8	0.3750	3/8	3/4	3.1/2	2	1	002208
1/2	0.5000	1/2	1"	4"	2	1	002210

# Solid Carbide 2 Flute End Mill



## Regular Length, Square End, 30° Helix

**E3302** Bright finish improves chip flow in soft and non-ferrous materials.

**E3302V** ALTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	E3302	E3302V
1/16	0.0625	1/8	1/4	1.1/2	2	1	001000	002850
5/64	0.0781	1/8	1/4	1.1/2	2	1	001001	002851
3/32	0.0938	1/8	3/8	1.1/2	2	1	001002	002852
1/8	0.1250	1/8	1/2	1.1/2	2	1	001004	002854
9/64	0.1406	3/16	9/16	2"	2	1	001005	—
5/32	0.1562	3/16	9/16	2"	2	1	001006	002856
11/64	0.1719	3/16	9/16	2"	2	1	001007	—
3/16	0.1875	3/16	5/8	2"	2	1	001008	002858
7/32	0.2188	1/4	5/8	2.1/2	2	1	001010	002860
1/4	0.2500	1/4	3/4	2.1/2	2	1	001012	002862
5/16	0.3125	5/16	7/8	2.1/2	2	1	001016	002863
3/8	0.3750	3/8	7/8	2.1/2	2	1	001017	002864
7/16	0.4375	7/16	1"	2.1/2	2	1	001018	002865
1/2	0.5000	1/2	1"	3"	2	1	001019	002866
9/16	0.5625	9/16	1.1/4	3.1/2	2	1	001020	002867
5/8	0.6250	5/8	1.1/4	3.1/2	2	1	001021	002868
3/4	0.7500	3/4	1.1/2	4"	2	1	001023	—
1"	1.0000	1"	1.1/2	4"	2	1	001025	—



# Solid Carbide 2 Flute End Mill

## Regular Length, Square End, 30° Helix

**E3302M** Bright finish improves chip flow in soft and non-ferrous materials.



E3302M

HM



Z  
2



2.00 - 25.00

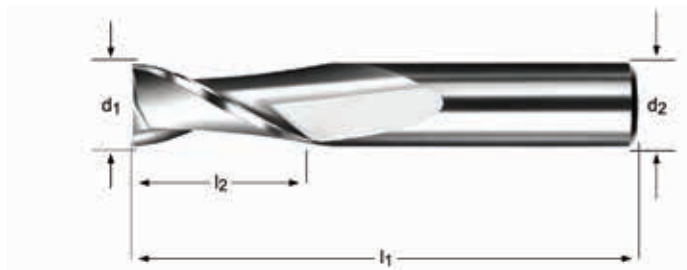
d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	d <sub>2</sub> Ø mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	Pack Qty	E3302M
2.00	0.0787	3.0	6.0	38.0	2	1	001028
2.50	0.0984	3.0	7.0	38.0	2	1	001029
3.00	0.1181	3.0	12.0	38.0	2	1	001030
4.00	0.1575	4.0	14.0	50.0	2	1	001032
4.50	0.1772	5.0	14.0	50.0	2	1	001033
5.00	0.1969	5.0	16.0	50.0	2	1	001034
6.00	0.2362	6.0	19.0	63.0	2	1	001035
7.00	0.2756	8.0	19.0	63.0	2	1	001036
8.00	0.3150	8.0	20.0	63.0	2	1	001037
9.00	0.3543	10.0	22.0	70.0	2	1	001038
10.00	0.3937	10.0	22.0	70.0	2	1	001039
11.00	0.4331	11.0	25.0	70.0	2	1	001040
12.00	0.4724	12.0	25.0	75.0	2	1	001041
14.00	0.5512	14.0	30.0	88.0	2	1	001043
16.00	0.6299	16.0	32.0	88.0	2	1	001044
20.00	0.7874	20.0	38.0	100.0	2	1	001046
25.00	0.9843	25.0	38.0	100.0	2	1	001047

# Solid Carbide 2 Flute End Mill



## Long Length, Square End, 30° Helix

**E5302** Bright finish improves chip flow in soft and non-ferrous materials.



E5302

HM



1/8 - 1/2

$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	E5302
1/8	0.1250	1/8	3/4	2"	2	1	000000
3/16	0.1875	3/16	3/4	2.1/2	2	1	000001
1/4	0.2500	1/4	1.1/8	3"	2	1	000002
3/8	0.3750	3/8	1.1/8	3"	2	1	000004
1/2	0.5000	1/2	2"	4"	2	1	000006

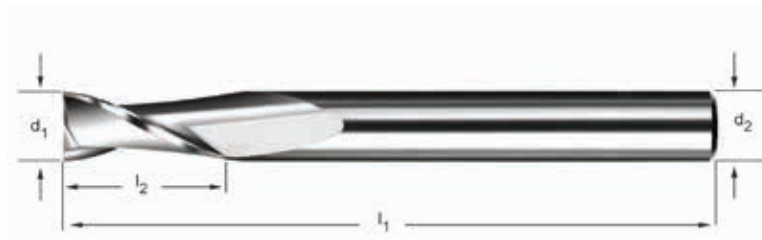


# Solid Carbide 2 Flute End Mill

## Extra Long Length, Square End, 30° Helix

**E6302** Bright finish improves chip flow in soft and non-ferrous materials.

**E6302V** ALTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	<b>E6302</b>	<b>E6302V</b>
1/8	0.1250	1/8	1"	3"	2	1	004800	003130
3/16	0.1875	3/16	1.1/8	3"	2	1	004801	003131
1/4	0.2500	1/4	1.1/2	4"	2	1	004802	003132
5/16	0.3125	5/16	1.5/8	4"	2	1	004803	—
3/8	0.3750	3/8	1.3/4	4"	2	1	004804	003134
1/2	0.5000	1/2	3"	6"	2	1	004806	003136

# Solid Carbide 2 Flute End Mill



## Regular Length, Ball Nose, 30° Helix

**EB3302** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB3302V** Ball nose for cutting internal part radius. ALTiN coating increases surface hardness, improves chip flow and tool life, allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB3302	EB3302V
1/16	0.0625	1/8	1/4	1.1/2	2	1	001200	002630
3/32	0.0938	1/8	3/8	1.1/2	2	1	001202	—
1/8	0.1250	1/8	1/2	1.1/2	2	1	001204	002634
5/32	0.1562	3/16	9/16	2"	2	1	001206	—
3/16	0.1875	3/16	5/8	2"	2	1	001208	002638
7/32	0.2188	1/4	5/8	2.1/2	2	1	001210	002640
1/4	0.2500	1/4	3/4	2.1/2	2	1	001212	002642
5/16	0.3125	5/16	7/8	2.1/2	2	1	001216	002643
3/8	0.3750	3/8	7/8	2.1/2	2	1	001217	002644
1/2	0.5000	1/2	1"	3"	2	1	001219	002646



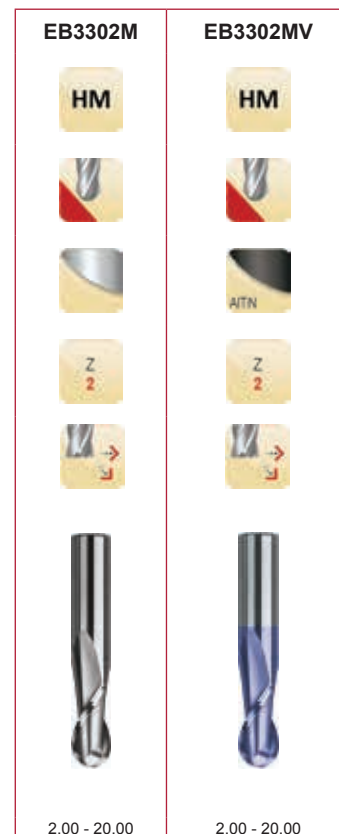
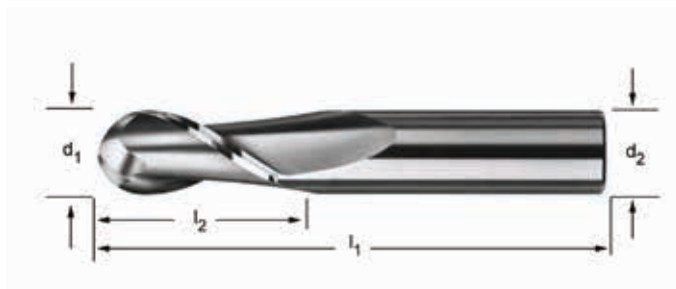


# Solid Carbide 2 Flute End Mill

## Regular Length, Ball Nose, 30° Helix

**EB3302M** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB3302MV** Ball nose for cutting internal part radius. ALTiN coating increases surface hardness, improves chip flow and tool life, allowing higher metal removal rates.



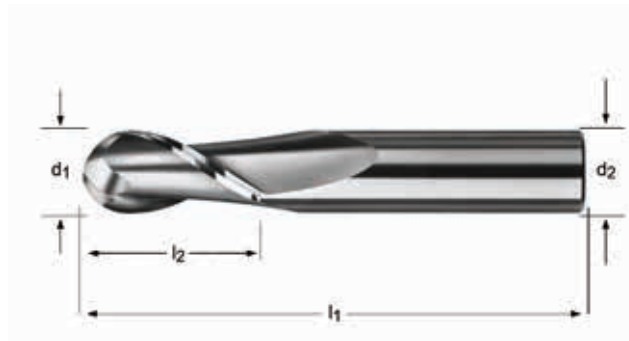
$d_1$ Ø mm	$d_1$ decimal Inch	$d_2$ Ø mm	$l_2$ mm	$l_1$ mm	# of Flutes	Pack Qty	EB3302M	EB3302MV
2.00	0.0787	3.0	6.0	38.0	2	1	001228	—
2.50	0.0984	3.0	6.0	38.0	2	1	001229	—
3.00	0.1181	3.0	12.0	38.0	2	1	001230	004402
4.00	0.1575	4.0	14.0	50.0	2	1	001232	004404
5.00	0.1969	5.0	16.0	50.0	2	1	001234	004406
6.00	0.2362	6.0	19.0	63.0	2	1	001235	004407
7.00	0.2756	8.0	19.0	63.0	2	1	001236	004408
8.00	0.3150	8.0	19.0	63.0	2	1	001237	004409
9.00	0.3543	10.0	22.0	70.0	2	1	001238	004410
10.00	0.3937	10.0	22.0	70.0	2	1	001239	004411
12.00	0.4724	12.0	25.0	75.0	2	1	001241	004413
16.00	0.6299	16.0	32.0	88.0	2	1	001243	—
20.00	0.7874	20.0	38.0	100.0	2	1	001245	—

# Solid Carbide 2 Flute End Mill



## Long Length, Ball Nose, 30° Helix

**EB5302** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.



EB5302

HM



1/8 - 5/8

$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB5302
1/8	0.1250	1/8	3/4	2"	2	1	000040
3/16	0.1875	3/16	3/4	2.1/2	2	1	000041
1/4	0.2500	1/4	1.1/8	3"	2	1	000042
5/16	0.3125	5/16	1.1/8	3"	2	1	000043
3/8	0.3750	3/8	1.1/8	3"	2	1	000044
1/2	0.5000	1/2	2"	4"	2	1	000046
5/8	0.6250	5/8	2.1/4	5"	2	1	000047



# Solid Carbide 2 Flute End Mill

## Extra Long Length, Ball Nose, 30° Helix

**EB6302** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB6302V** Ball nose for cutting internal part radius. ALTiN coating increases surface hardness, improves chip flow and tool life, allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB6302	EB6302V
1/8	0.1250	1/8	1"	3"	2	1	005400	003700
3/16	0.1875	3/16	1.1/8	3"	2	1	005401	003701
1/4	0.2500	1/4	1.1/2	4"	2	1	005402	003702
5/16	0.3125	5/16	1.5/8	4"	2	1	005403	003703
3/8	0.3750	3/8	1.3/4	4"	2	1	005404	003704
1/2	0.5000	1/2	3"	6"	2	1	005406	003706

# Solid Carbide 3 Flute End Mill



## Regular Length, Square End, 30° Helix

**E3303** 3-flute design for less chatter. Bright finish improves chip flow in soft or non-ferrous materials.

**E3303V** 3-flute design for less chatter. ALTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



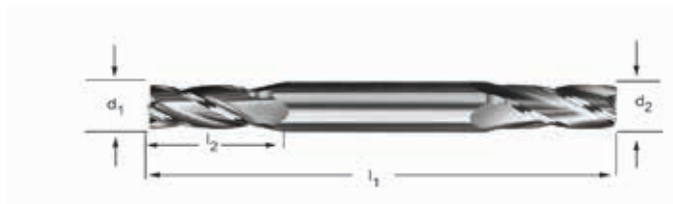
$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	<b>E3303</b>	<b>E3303V</b>
1/16	0.0625	1/8	1/4	1.1/2	3	1	001050	002920
3/32	0.0938	1/8	3/8	1.1/2	3	1	001052	002921
1/8	0.1250	1/8	1/2	1.1/2	3	1	001054	002922
5/32	0.1562	3/16	9/16	2"	3	1	001056	002923
3/16	0.1875	3/16	5/8	2"	3	1	001058	002924
1/4	0.2500	1/4	3/4	2.1/2	3	1	001062	002926
5/16	0.3125	5/16	7/8	2.1/2	3	1	001066	002927
3/8	0.3750	3/8	7/8	2.1/2	3	1	001067	002928
1/2	0.5000	1/2	1"	3"	3	1	001069	002930



# Solid Carbide 4 Flute End Mill

## Square End, Double End , 30° Helix

**E4304 Regular Length.** Double end provides two cutting ends in one tool. Bright finish improves chip flow in soft and non-ferrous materials.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	E4304
1/8	0.1250	3/8	3/8	3"	4	1	002250
5/32	0.1562	3/8	7/16	3"	4	1	002251
3/16	0.1875	3/8	1/2	3"	4	1	002252
1/4	0.2500	3/8	5/8	3"	4	1	002254
5/16	0.3125	3/8	3/4	3.1/2	4	1	002256
3/8	0.3750	3/8	3/4	3.1/2	4	1	002258
1/2	0.5000	1/2	1"	4"	4	1	002260

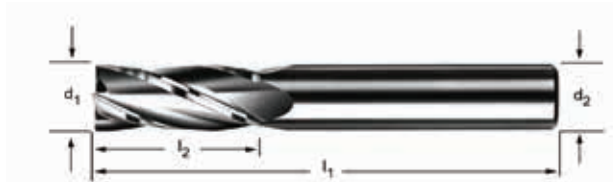
# Solid Carbide 4 Flute End Mill



## Regular Length, Square End , 30° Helix

**E3304** Bright finish improves chip flow in soft or non-ferrous materials.

**E3304V** ALTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	E3304	E3304V
1/16	0.0625	1/8	1/4	1.1/2	4	1	001100	002690
5/64	0.0781	1/8	1/4	1.1/2	4	1	001101	002691
3/32	0.0938	1/8	3/8	1.1/2	4	1	001102	002692
7/64	0.1094	1/8	3/8	1.1/2	4	1	001103	002693
1/8	0.1250	1/8	1/2	1.1/2	4	1	001104	002694
9/64	0.1406	3/16	9/16	2"	4	1	001105	002695
5/32	0.1562	3/16	9/16	2"	4	1	001106	002696
11/64	0.1719	3/16	9/16	2"	4	1	001107	002697
3/16	0.1875	3/16	5/8	2"	4	1	001108	002698
13/64	0.2031	1/4	5/8	2.1/2	4	1	001109	002699
7/32	0.2188	1/4	5/8	2.1/2	4	1	001110	002700
1/4	0.2500	1/4	3/4	2.1/2	4	1	001112	002702
5/16	0.3125	5/16	7/8	2.1/2	4	1	001116	002703
3/8	0.3750	3/8	7/8	2.1/2	4	1	001117	002704
7/16	0.4375	7/16	1"	2.1/2	4	1	001118	002705
1/2	0.5000	1/2	1"	3"	4	1	001119	002706
9/16	0.5625	9/16	1.1/4	3.1/2	4	1	001120	002707
5/8	0.6250	5/8	1.1/4	3.1/2	4	1	001121	002708
11/16	0.6875	3/4	1.1/2	4"	4	1	001122	002709
3/4	0.7500	3/4	1.1/2	4"	4	1	001123	002710
7/8	0.8750	7/8	1.1/2	4"	4	1	001124	002711
1"	1.0000	1"	1.1/2	4"	4	1	001125	002712

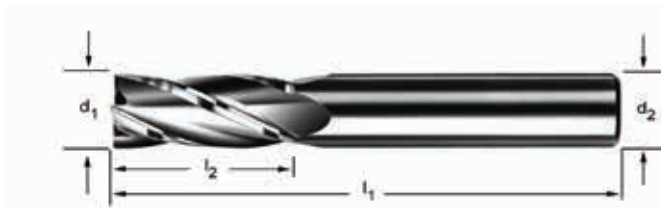


# Solid Carbide 4 Flute End Mill

## Regular Length, Square End , 30° Helix

**E3304M** Bright finish improves chip flow in soft or non-ferrous materials.

**E3304MV** AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



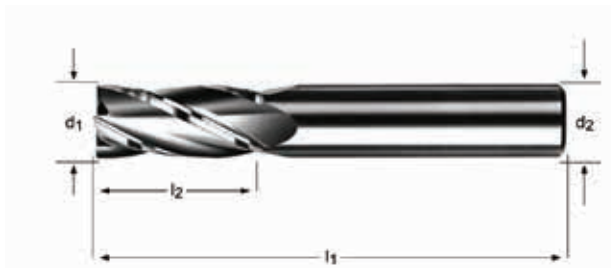
d <sub>1</sub> Ø mm	d <sub>1</sub> decimal Inch	d <sub>2</sub> Ø mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	Pack Qty	E3304M	E3304MV
2.00	0.0787	3.0	6.0	38.0	4	1	001128	004325
2.50	0.0984	3.0	7.0	38.0	4	1	001129	004326
3.00	0.1181	3.0	12.0	38.0	4	1	001130	004327
3.50	0.1378	4.0	12.0	50.0	4	1	001131	004328
4.00	0.1575	4.0	14.0	50.0	4	1	001132	004329
4.50	0.1772	5.0	14.0	50.0	4	1	001133	004330
5.00	0.1969	5.0	16.0	50.0	4	1	001134	004331
6.00	0.2362	6.0	19.0	63.0	4	1	001135	004332
7.00	0.2756	8.0	19.0	63.0	4	1	001136	004333
8.00	0.3150	8.0	19.0	63.0	4	1	001137	004334
9.00	0.3543	10.0	22.0	70.0	4	1	001138	004335
10.00	0.3937	10.0	22.0	70.0	4	1	001139	004336
11.00	0.4331	11.0	25.0	70.0	4	1	001140	004337
12.00	0.4724	12.0	25.0	75.0	4	1	001141	004338
14.00	0.5512	14.0	30.0	88.0	4	1	001143	004339
16.00	0.6299	16.0	32.0	88.0	4	1	001144	004340
18.00	0.7087	18.0	36.0	100.0	4	1	001145	004341
20.00	0.7874	20.0	38.0	100.0	4	1	001146	004342
25.00	0.9843	25.0	38.0	100.0	4	1	001147	—

# Solid Carbide 4 Flute End Mill



## Long Length, Square End , 30° Helix

- E5304** Bright finish improves chip flow in soft or non-ferrous materials.
- E5304V** AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	E5304	E5304V
1/8	0.1250	1/8	3/4	2"	4	1	000020	000030
3/16	0.1875	3/16	3/4	2.1/2	4	1	000021	000031
1/4	0.2500	1/4	1.1/8	3"	4	1	000022	000032
5/16	0.3125	5/16	1.1/8	3"	4	1	000023	000033
3/8	0.3750	3/8	1.1/8	3"	4	1	000024	000034
7/16	0.4375	7/16	2"	4"	4	1	000025	000035
1/2	0.5000	1/2	2"	4"	4	1	000026	000036
5/8	0.6250	5/8	2.1/4	5"	4	1	000027	000037
3/4	0.7500	3/4	2.1/4	5"	4	1	000028	000038



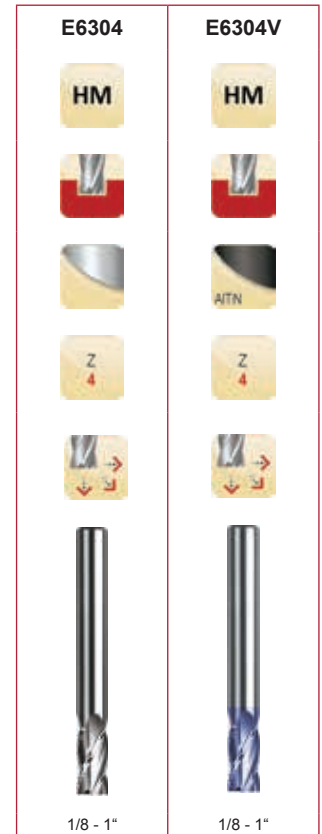


# Solid Carbide 4 Flute End Mill

## Extra Long Length, Square End , 30° Helix

**E6304** Bright finish improves chip flow in soft or non-ferrous materials.

**E6304V** AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	E6304	E6304V
1/8	0.1250	1/8	1"	3"	4	1	004900	003165
3/16	0.1875	3/16	1.1/8	3"	4	1	004901	003166
1/4	0.2500	1/4	1.1/2	4"	4	1	004902	003167
5/16	0.3125	5/16	1.5/8	4"	4	1	004903	003168
3/8	0.3750	3/8	1.3/4	4"	4	1	004904	003169
7/16	0.4375	7/16	3"	6"	4	1	004905	003170
1/2	0.5000	1/2	3"	6"	4	1	004906	003171
5/8	0.6250	5/8	3"	6"	4	1	004907	003172
3/4	0.7500	3/4	3"	6"	4	1	004908	003173
1"	1.0000	1"	3"	6"	4	1	004909	003174

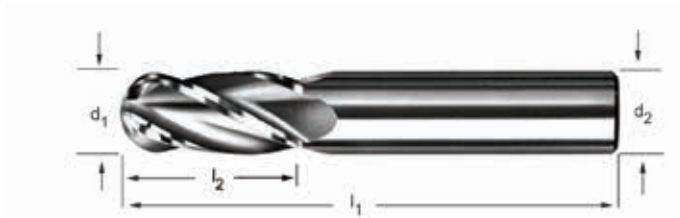
# Solid Carbide 4 Flute End Mill



## Regular Length, Ball Nose , 30° Helix

**EB3304** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB3304V** Ball nose for cutting internal part radius. AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB3304	EB3304V
1/16	0.0625	1/8	1/4	1.1/2	4	1	001300	003070
3/32	0.0938	1/8	3/8	1.1/2	4	1	001302	003072
1/8	0.1250	1/8	1/2	1.1/2	4	1	001304	003074
5/32	0.1562	3/16	9/16	2"	4	1	001306	003076
3/16	0.1875	3/16	5/8	2"	4	1	001308	003078
1/4	0.2500	1/4	3/4	2.1/2	4	1	001312	003082
5/16	0.3125	5/16	7/8	2.1/2	4	1	001316	003083
3/8	0.3750	3/8	7/8	2.1/2	4	1	001317	003084
7/16	0.4375	7/16	1"	2.1/2	4	1	001318	003085
1/2	0.5000	1/2	1"	3"	4	1	001319	003086
5/8	0.6250	5/8	1.1/4	3.1/2	4	1	001321	003088
3/4	0.7500	3/4	1.1/2	4"	4	1	001323	003090

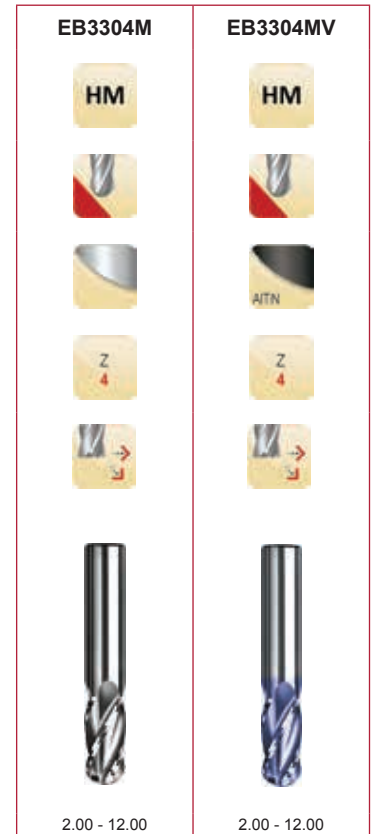
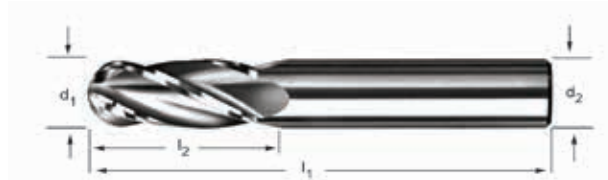


# Solid Carbide 4 Flute End Mill

## Regular Length, Ball Nose, 30° Helix

**EB3304M** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB3304MV** Ball nose for cutting internal part radius. AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø mm	$d_1$ decimal Inch	$d_2$ Ø mm	$l_2$ mm	$l_1$ mm	# of Flutes	Pack Qty	EB3304M	EB3304MV
2.00	0.0787	3.0	6.0	38.0	4	1	001344	004750
3.00	0.1181	3.0	12.0	38.0	4	1	001342	004752
4.00	0.1575	4.0	14.0	50.0	4	1	001340	004754
4.50	0.1772	5.0	14.0	50.0	4	1	001339	—
5.00	0.1969	5.0	16.0	50.0	4	1	001338	004756
6.00	0.2362	6.0	19.0	63.0	4	1	001337	004757
8.00	0.3150	8.0	19.0	63.0	4	1	001335	004759
10.00	0.3937	10.0	22.0	70.0	4	1	001333	004761
12.00	0.4724	12.0	25.0	75.0	4	1	001331	004763

# Solid Carbide 4 Flute End Mill



## Long Length, Ball Nose, 30° Helix

**EB5304** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB5304V** Ball nose for cutting internal part radius. AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB5304	EB5304V
1/4	0.2500	1/4	1.1/8	3"	4	1	000062	000072
3/8	0.3750	3/8	1.1/8	3"	4	1	000064	000074
1/2	0.5000	1/2	2"	4"	4	1	000066	000076
5/8	0.6250	5/8	2.1/4	5"	4	1	000067	000077

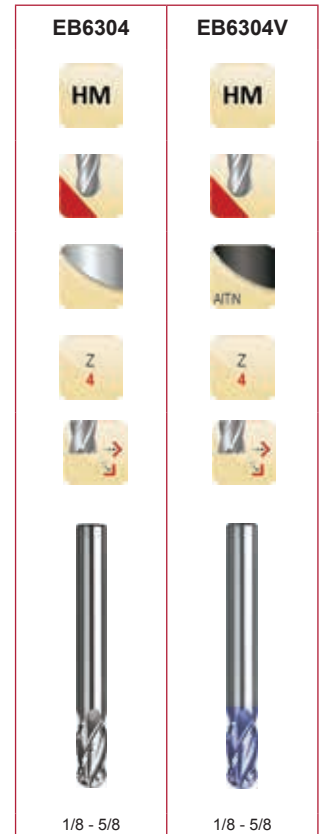


# Solid Carbide 4 Flute End Mill

## Extra Long Length, Ball Nose, 30° Helix

**EB6304** Ball nose for cutting internal part radius. Bright finish improves chip flow in soft or non-ferrous materials.

**EB6304V** Ball nose for cutting internal part radius. AlTiN coating increases surface hardness, improves chip flow and tool life allowing higher metal removal rates.



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	EB6304	EB6304V
1/8	0.1250	1/8	1"	3"	4	1	005700	003745
3/16	0.1875	3/16	1.1/8	3"	4	1	005701	003746
1/4	0.2500	1/4	1.1/2	4"	4	1	005702	003747
5/16	0.3125	5/16	1.5/8	4"	4	1	005703	003748
3/8	0.3750	3/8	1.3/4	4"	4	1	005704	003749
1/2	0.5000	1/2	3"	6"	4	1	005706	003751
5/8	0.6250	5/8	3"	6"	4	1	005707	003752

# HSS-PM 2 Flute End Mill



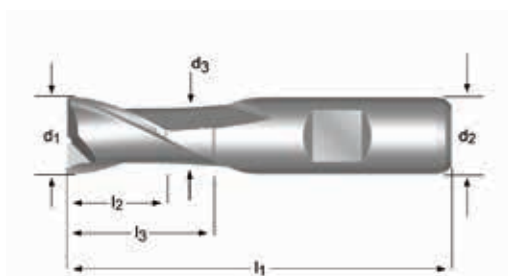
## Stub Length, Square End, Weldon Shank, 30° Helix

**C110** Powdered Metal. P9 slotting tolerance.

C110



1.00 - 50.00



$d_1$ Ø Inch	$d_1$ Ø mm	$d_2$ Ø <sub>h<sub>s</sub></sub> mm	$l_2$ mm	$l_1$ mm	# of Flutes	$l_3$ mm	$d_3$ Ø mm	Pack Qty	C110
	1.00	6	2.5	47	2	-	-	1	0353165
	1.50	6	3	47	2	-	-	1	0353172
1/16	1.59	6	3	47	2	-	-	1	0639795
	1.80	6	4	48	2	-	-	1	0353189
	2.00	6	4	48	2	-	-	1	0353301
3/32	2.38	6	5	49	2	-	-	1	0639801
	2.50	6	5	49	2	-	-	1	0353318
	2.80	6	5	49	2	-	-	1	0353325
	3.00	6	5	49	2	-	-	1	0353370
1/8	3.18	6	6	50	2	-	-	1	0639818
	3.50	6	6	50	2	-	-	1	0353387
	3.80	6	7	51	2	-	-	1	0353394
	4.00	6	7	51	2	-	-	1	0353424
	4.50	6	7	51	2	-	-	1	0353431
3/16	4.76	6	8	52	2	-	-	1	0639825
	4.80	6	8	52	2	-	-	1	0353448 <sup>1)2)</sup>
	5.00	6	8	52	2	-	-	1	0353455
	5.50	6	8	52	2	-	-	1	0353462
	5.75	6	8	52	2	-	-	1	0353479 <sup>1)2)</sup>
	6.00	6	8	52	2	-	-	1	0353486
1/4	6.35	10	10	60	2	-	-	1	0639832
	6.50	10	10	60	2	-	-	1	0353493
	6.75	10	10	60	2	-	-	1	0629031
	7.00	10	10	60	2	-	-	1	0353509
	7.50	10	10	60	2	-	-	1	0353516
	7.75	10	11	61	2	-	-	1	0573495 <sup>1)2)</sup>
5/16	7.94	10	11	61	2	-	-	1	0639849
	8.00	10	11	61	2	-	-	1	0353523
	8.50	10	11	61	2	-	-	1	0353530
	9.00	10	11	61	2	-	-	1	0353547

<sup>1)</sup> Diameter tolerance h10

<sup>2)</sup> Slot not in P9 tolerance

<sup>3)</sup> Available in HSCo only

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	l <sub>3</sub> mm	d <sub>3</sub> Ø mm	Pack Qty	C110
	9.50	10	11	61	2	-	-	1	0353554
3/8	9.52	10	13	63	2	22.5	9.5	1	0639856
	9.70	10	13	63	2	22.5	9.5	1	0573501 <sup>1)2)</sup>
	10.00	10	13	63	2	22.5	9.5	1	0353196
13/32	10.32	12	13	70	2	-	-	1	0639863
	10.50	12	13	70	2	-	-	1	0353202
	11.00	12	13	70	2	-	-	1	0353219
7/16	11.11	12	13	70	2	-	-	1	0639870
	11.50	12	13	70	2	-	-	1	0573433
	11.70	12	16	73	2	27.5	11.5	1	0573440 <sup>1)2)</sup>
1/2	12.00	12	16	73	2	27.5	11.5	1	0353226
	12.50	12	16	73	2	27.5	11.5	1	0573457
	12.70	12	16	73	2	27.5	11.5	1	0639887
17/32	13.00	12	16	73	2	27.5	11.5	1	0353233
	13.49	12	16	73	2	27.5	11.5	1	0639894
	13.70	12	16	73	2	27.5	11.5	1	0573464 <sup>1)2)</sup>
9/16	14.00	12	16	73	2	27.5	11.5	1	0353240
	14.29	12	16	73	2	27.5	11.5	1	0639900
	15.00	12	16	73	2	27.5	11.5	1	0353257
5/8	15.70	16	19	79	2	30.5	15.5	1	0573471 <sup>1)2)</sup>
	15.88	16	19	79	2	30.5	15.5	1	0639917
	16.00	16	19	79	2	30.5	15.5	1	0353264
11/16	17.00	16	19	79	2	30.5	15.5	1	0353271
	17.46	16	19	79	2	30.5	15.5	1	0639924
	17.70	16	19	79	2	30.5	15.5	1	0628942
3/4	18.00	16	19	79	2	30.5	15.5	1	0353288
	19.00	16	19	79	2	30.5	15.5	1	0353295
	19.05	20	22	88	2	37.5	18.5	1	0639931
7/8	19.70	20	22	88	2	37.5	19.5	1	0628959
	20.00	20	22	88	2	37.5	19.5	1	0353332
	21.70	20	22	88	2	37.5	19.5	1	0628966
1"	22.00	20	22	88	2	37.5	19.5	1	0353349
	22.22	20	22	88	2	37.5	19.5	1	0639948
	24.00	25	26	102	2	45.5	23.5	1	0573488
1.1/8	24.70	25	26	102	2	45.5	24.5	1	0628973
	25.00	25	26	102	2	45.5	24.5	1	0353356
	25.40	25	26	102	2	45.5	24.5	1	0621929
1.1/4	26.00	25	26	102	2	45.5	24.5	1	0628980
	28.00	25	26	102	2	45.5	24.5	1	0353363
	28.58	25	26	102	2	45.5	24.5	1	0639962
1.1/2	30.00	25	26	102	2	45.5	24.5	1	0353400
	31.75	32	32	112	2	51.5	31.5	1	0639979
	32.00	32	32	112	2	51.5	31.5	1	0353417
1.3/4	35.00	32	32	112	2	51.5	31.5	1	0639986 <sup>1)3)</sup>
	36.00	32	32	112	2	51.5	31.5	1	0628997 <sup>1)3)</sup>
	40.00	40	38	130	2	59.5	39.0	1	0629000 <sup>1)3)</sup>
1.5"	45.00	40	38	130	2	59.5	38.0	1	0629017 <sup>1)3)</sup>
	50.00	50	45	147	2	66.5	48.0	1	0629024 <sup>1)3)</sup>

<sup>1)</sup> Diameter tolerance h10

<sup>2)</sup> Slot not in P9 tolerance

<sup>3)</sup> Available in HSCo only

# HSS 2 Flute End Mill

## Regular Length, Square End, Weldon Shank, 30° Helix

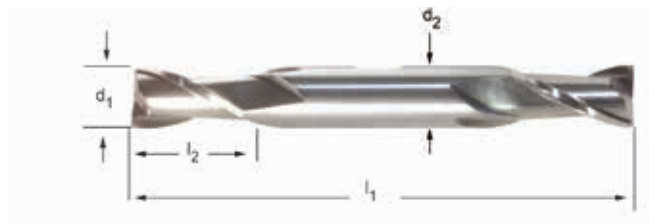
**923** Double end provides two cutting ends in one tool. Bright finish improves chip flow in soft or non-ferrous materials.

923

HSS



1/8 - 3/4

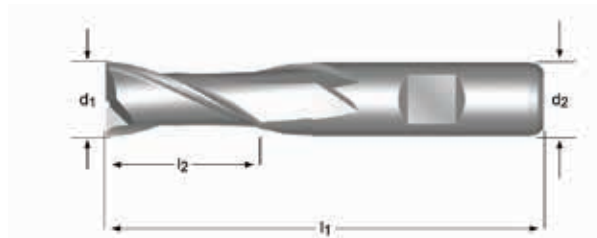


$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	923
1/8	0.1250	3/8	3.1/16	3/8	2	1	5110364
5/32	0.1562	7/16	3.1/8	3/8	2	1	5110365
3/16	0.1875	7/16	3.1/4	3/8	2	1	5110366
1/4	0.2500	1/2	3.3/8	3/8	2	1	5110368
9/32	0.2812	9/16	3.3/8	3/8	2	1	5110369
5/16	0.3125	9/16	3.1/2	3/8	2	1	5110370
3/8	0.3750	9/16	3.1/2	3/8	2	1	5110372
13/32	0.4062	13/16	4.1/8	1/2	2	1	5110373
7/16	0.4375	13/16	4.1/8	1/2	2	1	5110374
1/2	0.5000	13/16	4.1/8	1/2	2	1	5110376
5/8	0.6250	1.1/8	5"	5/8	2	1	5110378
3/4	0.7500	1.5/16	5.5/8	3/4	2	1	5110380



## Regular Length, Square End, Weldon Shank, 30° Helix

**920** Bright finish improves chip flow in soft or non-ferrous materials.



d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	# of Flutes	Pack Qty	920
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110302
3/16	0.1875	7/16	2.3/8	3/8	2	1	5110303
1/4	0.2500	1/2	2.7/16	3/8	2	1	5110304
5/16	0.3125	9/16	2.1/2	3/8	2	1	5110305
3/8	0.3750	9/16	2.1/2	3/8	2	1	5110306
7/16	0.4375	13/16	2.11/16	3/8	2	1	5110307
1/2	0.5000	13/16	2.11/16	3/8	2	1	5110308
1/2	0.5000	1"	3.1/4	1/2	2	1	5110309
9/16	0.5625	1.1/8	3.3/8	1/2	2	1	5110310
5/8	0.6250	1.1/8	3.3/8	1/2	2	1	5110311
5/8	0.6250	1.5/16	3.3/4	5/8	2	1	5110314
11/16	0.6875	1.5/16	3.5/8	1/2	2	1	5110312
11/16	0.6875	1.5/16	3.3/4	5/8	2	1	5110315
3/4	0.7500	1.5/16	3.5/8	1/2	2	1	5110313
3/4	0.7500	1.5/16	3.3/4	5/8	2	1	5110316
3/4	0.7500	1.5/16	3.7/8	3/4	2	1	5110708
13/16	0.8125	1.1/2	4"	5/8	2	1	5110317
7/8	0.8750	1.1/2	4"	5/8	2	1	5110318
7/8	0.8750	1.1/2	4.1/8	3/4	2	1	5110709
7/8	0.8750	1.1/2	4.1/8	7/8	2	1	5110321
15/16	0.9375	1.1/2	4"	5/8	2	1	5110319
1"	1.0000	1.1/2	4"	5/8	2	1	5110320
1"	1.0000	1.1/2	4.1/8	3/4	2	1	5110710
1"	1.0000	1.1/2	4.1/8	7/8	2	1	5110323
1"	1.0000	1.5/8	4.1/2	1"	2	1	5110326
1.1/8	1.1250	1.5/8	4.1/4	3/4	2	1	5111714
1.1/8	1.1250	1.5/8	4.1/2	1"	2	1	5110327
1.1/4	1.2500	1.5/8	4.1/2	1"	2	1	5110328
1.1/4	1.2500	1.5/8	4.1/2	1.1/4	2	1	5110331
1.1/2	1.5000	1.5/8	4.1/4	3/4	2	1	5111717
1.1/2	1.5000	1.5/8	4.1/2	1"	2	1	5110330
1.1/2	1.5000	1.5/8	4.1/2	1.1/4	2	1	5110332

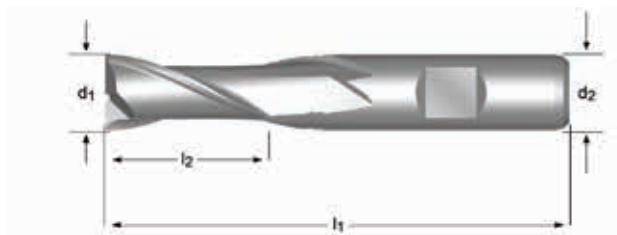
# HSS 2 Flute End Mill



## Regular Length, Square End, Keyway, Weldon Shank, 30° Helix

**920K**

Keyway cutter, close tolerance (+0.0000"/-0.0015").  
Bright finish improves chip flow in soft or non-ferrous materials.



920K

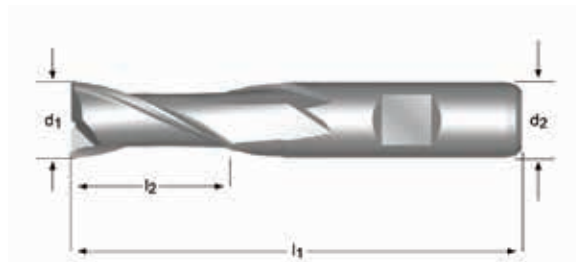


1/8 - 1"

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	# of Flutes	Pack Qty	920K
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110715
3/16	0.1875	7/16	2.3/8	3/8	2	1	5110716
1/4	0.2500	1/2	2.7/16	3/8	2	1	5110717
5/16	0.3125	9/16	2.1/2	3/8	2	1	5110718
3/8	0.3750	9/16	2.1/2	3/8	2	1	5110719
1/2	0.5000	1"	3.1/4	1/2	2	1	5110720
5/8	0.6250	1.5/16	3.3/4	5/8	2	1	5110721
3/4	0.7500	1.5/16	3.7/8	3/4	2	1	5110722
7/8	0.8750	1.1/2	4.1/8	7/8	2	1	5110723
1"	1.0000	1.5/8	4.1/2	1"	2	1	5110724

## Regular Length, Square End, Weldon Shank, 30° Helix

**963** Bright finish improves chip flow in soft or non-ferrous materials.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	963
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110633
3/16	0.1875	7/16	2.3/8	3/8	2	1	5110634
1/4	0.2500	1/2	2.7/16	3/8	2	1	5110635
5/16	0.3125	9/16	2.1/2	3/8	2	1	5110636
3/8	0.3750	9/16	2.1/2	3/8	2	1	5110637
1/2	0.5000	1"	3.1/4	1/2	2	1	5110638
5/8	0.6250	1.5/16	3.3/4	5/8	2	1	5110639
3/4	0.7500	1.5/16	3.7/8	3/4	2	1	5110640
1"	1.0000	1.5/8	4.1/2	1"	2	1	5110641

# HSS-PM 2 Flute End Mill



## Regular Length, Square End, Weldon Shank, 30° Helix

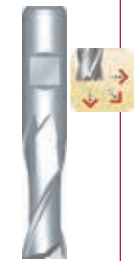
**C123** Powdered Metal. P9 slotting tolerance.

HSS-E  
PM

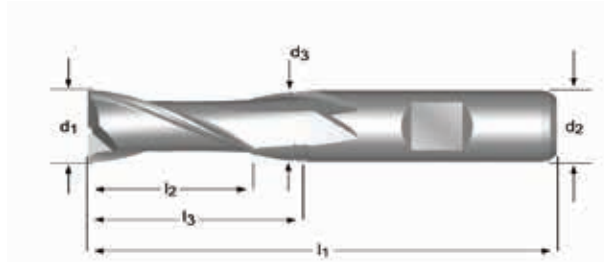
P9



Z  
2



1/16 - 40.00



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	l <sub>3</sub> mm	d <sub>3</sub> Ø mm	Pack Qty	C123
1/16	1.59	6	7	51	2	—	—	1	0640012 <sup>1)</sup>
	2.00	6	7	51	2	—	—	1	0353646
	2.50	6	8	52	2	—	—	1	0353653
	3.00	6	8	52	2	—	—	1	0353714
1/8	3.18	6	10	54	2	—	—	1	0640029 <sup>1)</sup>
	3.50	6	10	54	2	—	—	1	0353721
5/32	3.97	6	11	55	2	—	—	1	0640036 <sup>1)</sup>
	4.00	6	11	55	2	—	—	1	0353769
	4.50	6	11	55	2	—	—	1	0353776
3/16	4.76	6	13	57	2	—	—	1	0640043 <sup>1)</sup>
	5.00	6	13	57	2	—	—	1	0353790
	5.50	6	13	57	2	—	—	1	0353806
	6.00	6	13	57	2	—	—	1	0353813
1/4	6.35	10	16	66	2	—	—	1	0640050 <sup>1)</sup>
	6.50	10	16	66	2	—	—	1	0353820
	7.00	10	16	66	2	—	—	1	0353837
	7.50	10	16	66	2	—	—	1	0353844
5/16	7.94	10	19	69	2	—	—	1	0640067 <sup>1)</sup>
	8.00	10	19	69	2	—	—	1	0353851
	8.50	10	19	69	2	—	—	1	0353868
	9.00	10	19	69	2	—	—	1	0353875
	9.50	10	19	69	2	—	—	1	0353882
3/8	9.52	10	22	72	2	31.5	9.5	1	0640074 <sup>1)</sup>
	10.00	10	22	72	2	31.5	9.5	1	0353561
	11.00	12	22	79	2	—	—	1	0353578
	12.00	12	26	83	2	37.5	11.5	1	0353585
1/2	12.70	12	26	83	2	37.5	11.5	1	0640081 <sup>1)</sup>
	13.00	12	26	83	2	37.5	11.5	1	0353592
	14.00	12	26	83	2	37.5	11.5	1	0353608
9/16	14.29	12	26	83	2	37.5	11.5	1	0640098 <sup>1)</sup>

<sup>1)</sup> Diameter tolerance -.0005 inches / -.0013 inches

<sup>2)</sup> Diameter tolerance -.0005 inches / -.0015 inches

<sup>3)</sup> Available in HSCo only

# HSS-PM 2 Flute End Mill

$d_1$ Ø Inch	$d_1$ Ø mm	$d_2$ Ø <sub>h<sub>6</sub></sub> mm	$l_2$ mm	$l_1$ mm	# of Flutes	$l_3$ mm	$d_3$ Ø mm	Pack Qty	C123
	15.00	12	26	83	2	37.5	11.5	1	0353615
5/8	15.88	16	32	92	2	43.5	15.5	1	0640104 <sup>1)</sup>
	16.00	16	32	92	2	43.5	15.5	1	0353622
3/4	18.00	16	32	92	2	43.5	15.5	1	0353639
	19.05	20	38	104	2	53.5	18.5	1	0640111 <sup>2)</sup>
	20.00	20	38	104	2	53.5	19.5	1	0353660
1"	22.00	20	38	104	2	53.5	19.5	1	0353677
	25.00	25	45	121	2	64.5	24.5	1	0353691
	25.40	25	45	121	2	64.5	24.5	1	0640128
	30.00	25	45	121	2	64.5	24.5	1	0353738
	32.00	32	53	133	2	72.5	31.5	1	0353745
	36.00	32	53	133	2	72.5	31.5	1	0353752 <sup>3)</sup>
	40.00	40	63	155	2	84.5	39.0	1	0353783 <sup>3)</sup>

<sup>1)</sup> Diameter tolerance -.0005 inches / -.0013 inches

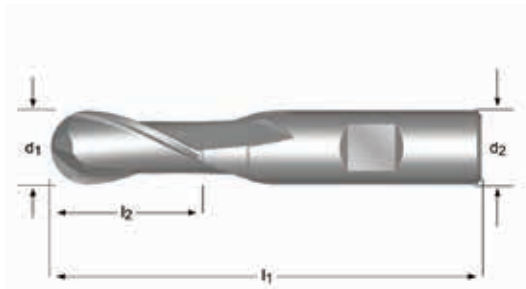
<sup>2)</sup> Diameter tolerance -.0005 inches / -.0015 inches

<sup>3)</sup> Available in HSCo only

# HSS 2 Flute End Mill

## Regular Length, Ball Nose, Weldon Shank, 30° Helix

**905** Ball nose for cutting internal radius. Bright finish improves chip flow in soft or non-ferrous materials.



**905**

**HSS**




**Z  
2**



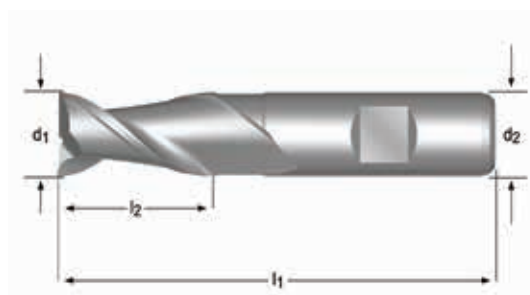

1/8 - 3/4

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ mm	$d_2$ Ø Inch	# of Flutes	Pack Qty	<b>905</b>
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110390
3/16	0.1875	1/2	2.3/8	3/8	2	1	5110391
1/4	0.2500	5/8	2.7/16	3/8	2	1	5110392
5/16	0.3125	3/4	2.1/2	3/8	2	1	5110393
3/8	0.3750	3/4	2.1/2	3/8	2	1	5110394
7/16	0.4375	1"	3.1/4	1/2	2	1	5110395
1/2	0.5000	1"	3.1/4	1/2	2	1	5110396
9/16	0.5625	1.1/8	3.3/8	1/2	2	1	5110700
5/8	0.6250	1.1/8	3.3/8	1/2	2	1	5110701
3/4	0.7500	1.5/16	3.5/8	1/2	2	1	5110702

# HSS 2 Flute End Mill

## Regular Length, Square End, Weldon Shank, 37° Helix

**980** High Helix design for aluminum and other non-ferrous materials.



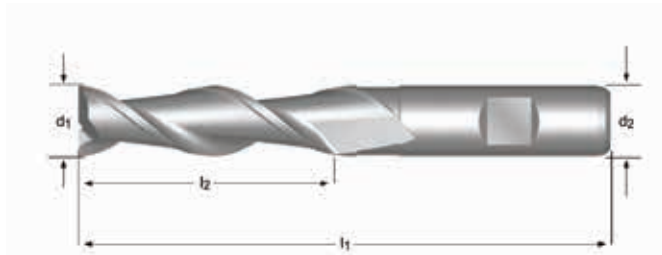
$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	<b>980</b>
1/4	0.2500	5/8	2.7/16	3/8	2	1	5110602
5/16	0.3125	3/4	2.1/2	3/8	2	1	5110603
3/8	0.3750	3/4	2.1/2	3/8	2	1	5110604
1/2	0.5000	1.1/4	3.1/4	1/2	2	1	5110606
3/4	0.7500	1.5/8	3.7/8	3/4	2	1	5110608
1"	1.0000	2"	4.1/2	1"	2	1	5110609

# HSS 2 Flute End Mill



## Long Length, Square End, Weldon Shank, 37° Helix

**981** High Helix design for aluminum and other non-ferrous materials.



**981**

**HSS**




**Z  
2**



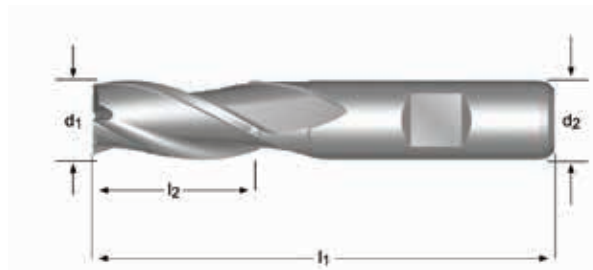

1/4 - 3/4

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	<b>981</b>
1/4	0.2500	1.1/4	3.1/16	3/8	2	1	5110613
5/16	0.3125	1.3/8	3.1/8	3/8	2	1	5110614
3/8	0.3750	1.1/2	3.1/4	3/8	2	1	5110615
1/2	0.5000	2"	4"	1/2	2	1	5110617
3/4	0.7500	3"	5.1/4	3/4	2	1	5110619



## Regular Length, Square End, Weldon Shank, 30° Helix

**930** 3-flute design for less chatter. Bright finish improves chip flow in soft or non-ferrous materials.



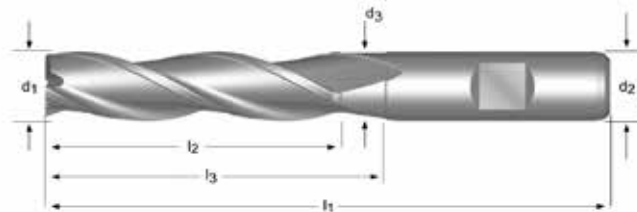
$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	<b>930</b>
1/8	0.1250	3/8	2.5/16	3/8	3	1	5110221
3/16	0.1875	1/2	2.3/8	3/8	3	1	5110222
1/4	0.2500	5/8	2.7/16	3/8	3	1	5110223
5/16	0.3125	3/4	2.1/2	3/8	3	1	5110224
3/8	0.3750	3/4	2.1/2	3/8	3	1	5110225
7/16	0.4375	1"	2.11/16	3/8	3	1	5110226
1/2	0.5000	1.1/4	3.1/4	1/2	3	1	5110228
9/16	0.5625	1.3/8	3.3/8	1/2	3	1	5110229
5/8	0.6250	1.5/8	3.3/4	5/8	3	1	5110232
3/4	0.7500	1.5/8	3.3/4	5/8	3	1	5110233
3/4	0.7500	1.5/8	3.7/8	3/4	3	1	5110696
1"	1.0000	1.7/8	4"	5/8	3	1	5110235
1"	1.0000	2"	4.1/2	1"	3	1	5110237

# Cobalt 3 Flute End Mill



## Long Length, Square End, Weldon Shank, 30° Helix

**C346** P9 slotting tolerance. 3 flute design provides less chatter.



C346



3.00 - 20.00

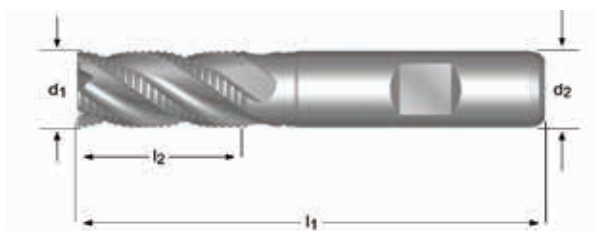
d <sub>1</sub> Ø mm	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	l <sub>3</sub> mm	d <sub>3</sub> Ø mm	Pack Qty	C346
3.00	6	12	56	3	-	-	1	0122297
4.00	6	19	63	3	-	-	1	0122303
5.00	6	24	68	3	-	-	1	0122310
6.00	6	24	68	3	-	-	1	0122327
7.00	10	30	80	3	-	-	1	0126325
8.00	10	38	88	3	-	-	1	0126332
9.00	10	38	88	3	-	-	1	0126349
10.00	10	45	95	3	-	-	1	0126233
11.00	12	45	102	3	-	-	1	0126240
12.00	12	53	110	3	-	-	1	0126257
13.00	12	53	110	3	64.5	11.5	1	0126264
14.00	12	53	110	3	64.5	11.5	1	0126271
15.00	12	53	110	3	64.5	11.5	1	0126288
16.00	16	63	123	3	74.5	15.5	1	0126295
18.00	16	63	123	3	74.5	15.5	1	0126301
20.00	20	75	141	3	90.5	19.5	1	0126318

# Cobalt 4 Flute End Mill

## Regular Length, Square End, Roughing, Weldon Shank, 30° Helix

**9002** Roughing, Fine Profile, provides a stronger edge and runs longer than conventional coarse profile roughers. Bright finish.

**TC9002** TiCN coating lowers the coefficient of friction and improves wear resistance on the end mill.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	9002	TC9002
1/4	0.2500	5/8	2.7/16	3/8	4	1	5210014	5270014
5/16	0.3125	3/4	2.1/2	3/8	4	1	5210015	5270015
3/8	0.3750	3/4	2.1/2	3/8	4	1	5210016	5270016
7/16	0.4375	1.1/4	3.1/4	1/2	4	1	5210017	5270017
1/2	0.5000	1.1/4	3.1/4	1/2	4	1	5210018	5270018
9/16	0.5625	1.3/8	3.3/8	1/2	4	1	5210019	—
5/8	0.6250	1.5/8	3.3/4	5/8	4	1	5210020	5270020
3/4	0.7500	1.5/8	3.7/8	3/4	4	1	5210021	5270021
7/8	0.8750	1.7/8	4.1/8	3/4	5	1	5210022	—
1"	1.0000	2"	4.1/2	1"	5	1	5210023	5270023

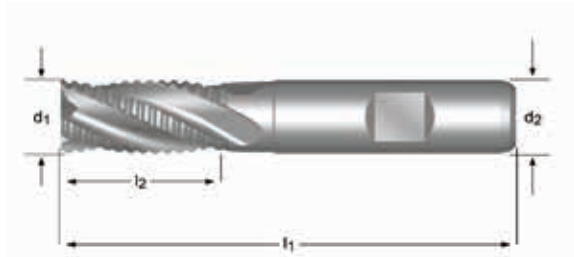
# Cobalt Multi-Flute End Mill



## Regular Length, Square End, Roughing, Weldon Shank, 30° Helix

**9003** Roughing, Coarse Profile, for maximum metal removal in one pass. Bright finish.

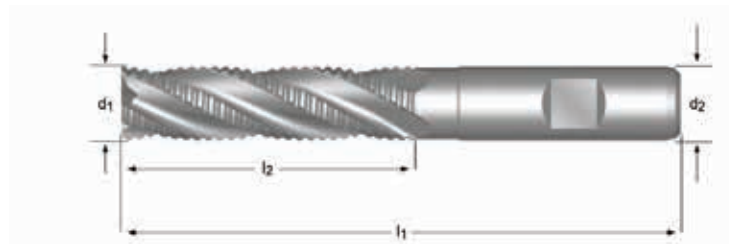
**TC9003** TiCN coating lowers the coefficient of friction and improves wear resistance on the end mill.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	9003	TC9003
1/4	0.2500	5/8	2.7/16	3/8	4	1	5210028	5270028
5/16	0.3125	3/4	2.1/2	3/8	4	1	5210029	5270029
3/8	0.3750	3/4	2.1/2	3/8	4	1	5210030	5270030
7/16	0.4375	1.1/4	3.1/4	1/2	4	1	5210031	5270031
1/2	0.5000	1.1/4	3.1/4	1/2	4	1	5210032	5270032
9/16	0.5625	1.3/8	3.3/8	1/2	4	1	5210033	—
5/8	0.6250	1.5/8	3.3/4	5/8	4	1	5210034	5270034
3/4	0.7500	1.5/8	3.7/8	3/4	4	1	5210035	5270035
7/8	0.8750	1.7/8	4.1/8	3/4	5	1	5210036	5270036
1"	1.0000	2"	4.1/2	1"	5	1	5210037	5270037

## Long Length, Square End, Roughing, Weldon Shank, 30° Helix

**9009** Roughing, Coarse Profile, for maximum metal removal in one pass. Bright finish.



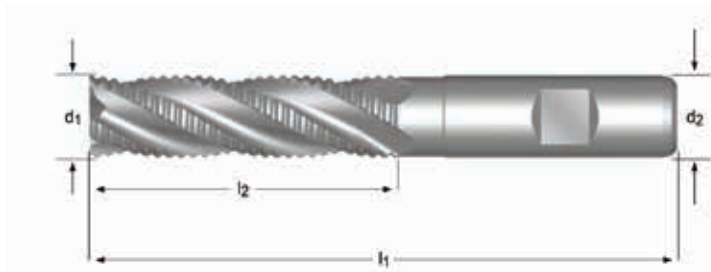
$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	9009
1/4	0.2500	1.1/4	3.1/8	3/8	4	1	5210089
3/8	0.3750	1.1/2	3.1/4	3/8	4	1	5210090
1/2	0.5000	2"	4"	1/2	4	1	5210091
5/8	0.6250	2.1/2	4.5/8	5/8	4	1	5210092
3/4	0.7500	3"	5.1/4	3/4	4	1	5210093
7/8	0.8750	3.1/2	5.3/4	3/4	6	1	5210094
1"	1.0000	4"	6.1/2	1"	5	1	5210095

# Cobalt 4 Flute End Mill



## Long Length, Square End, Roughing, Weldon Shank, 30° Helix

**9008** Roughing, Fine Profile, provides a stronger edge and runs longer than conventional coarse profile roughers. Bright finish.



9008

HSS-E



Z  
4-8



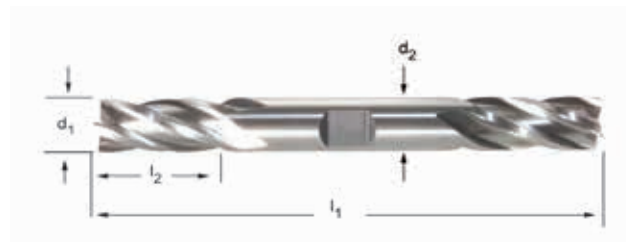
1/4 - 3/4

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	9008
1/4	0.2500	1.1/4	3.1/8	3/8	4	1	5210078
3/8	0.3750	1.1/2	3.1/4	3/8	4	1	5210079
1/2	0.5000	2"	4"	1/2	4	1	5210080
3/4	0.7500	3"	5.1/4	3/4	4	1	5210082

# HSS 4 Flute End Mill

## Regular Length, Square End, Weldon Shank, 30° Helix

**948** Double end provides two cutting ends in one tool. Bright finish improves chip flow in soft or non-ferrous materials.



948

HSS



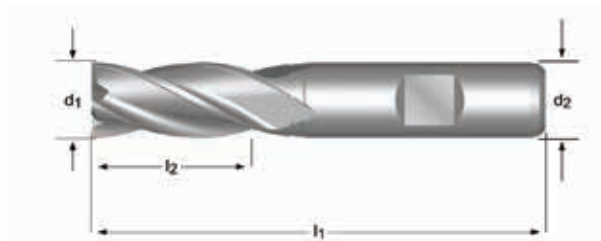
1/8 - 3/4

d <sub>1</sub> Ø Inch	d <sub>1</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	# of Flutes	Pack Qty	948
1/8	0.1250	3/8	3.1/16	3/8	4	1	5110162
3/16	0.1875	1/2	3.1/4	3/8	4	1	5110163
1/4	0.2500	5/8	3.3/8	3/8	4	1	5110164
5/16	0.3125	3/4	3.1/2	3/8	4	1	5110165
3/8	0.3750	3/4	3.1/2	3/8	4	1	5110166
1/2	0.5000	1"	4.1/8	1/2	4	1	5110167
5/8	0.6250	1.3/8	5"	5/8	4	1	5110168
3/4	0.7500	1.5/8	5.5/8	3/4	4	1	5110169

# HSS 4 Flute End Mill

## Regular Length, Square End, Weldon Shank, 30° Helix

**945** Bright finish improves chip flow in soft or non-ferrous materials.

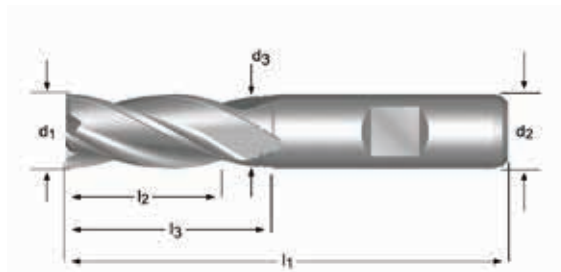


$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	945
1/8	0.1250	3/8	2.5/16	3/8	4	1	5110071
3/16	0.1875	1/2	2.3/8	3/8	4	1	5110072
1/4	0.2500	5/8	2.7/16	3/8	4	1	5110073
5/16	0.3125	3/4	2.1/2	3/8	4	1	5110074
3/8	0.3750	3/4	2.1/2	3/8	4	1	5110075
1/2	0.5000	1.1/4	3.1/4	1/2	4	1	5110076
5/8	0.6250	1.5/8	3.3/4	5/8	4	1	5110077
11/16	0.6875	1.5/8	3.3/4	5/8	4	1	5110078
3/4	0.7500	1.5/8	3.7/8	3/4	4	1	5110079
7/8	0.8750	1.7/8	4.1/8	7/8	4	1	5110080
1"	1.0000	2"	4.1/2	1"	4	1	5110081



## Regular Length, Square End, Weldon Shank, 30° Helix

**C247** Powdered Metal. Bright finish improves chip flow in soft or non-ferrous materials.



**C247**

**HSS-E PM**

**N**

**Z 4-8**

2.00 - 50.00

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	l <sub>3</sub> mm	d <sub>3</sub> Ø mm	Pack Qty	<b>C247</b>
	2.00	6	7	51	4	—	—	1	0354667
	2.50	6	8	52	4	—	—	1	0354674
	3.00	6	8	52	4	—	—	1	0354728
1/8	3.18	6	10	54	4	—	—	1	0640142 <sup>1)</sup>
	3.50	6	10	54	4	—	—	1	0354735
	4.00	6	11	55	4	—	—	1	0354766
	4.50	6	11	55	4	—	—	1	0354773
3/16	4.76	6	13	57	4	—	—	1	0640159 <sup>1)</sup>
	5.00	6	13	57	4	—	—	1	0354780
	5.50	6	13	57	4	—	—	1	0354797
	6.00	6	13	57	4	—	—	1	0354803
1/4	6.35	10	16	66	4	—	—	1	0640166 <sup>1)</sup>
	6.50	10	16	66	4	—	—	1	0354810
	7.00	10	16	66	4	—	—	1	0354827
	7.50	10	16	66	4	—	—	1	0354834
5/16	7.94	10	19	69	4	—	—	1	0640173 <sup>1)</sup>
	8.00	10	19	69	4	—	—	1	0354841
	8.50	10	19	69	4	—	—	1	0354858
	9.00	10	19	69	4	—	—	1	0354865
	9.50	10	19	69	4	—	—	1	0354872
3/8	9.52	10	22	72	4	31.5	9.5	1	0640180 <sup>1)</sup>
	10.00	10	22	72	4	31.5	9.5	1	0354582
	11.00	12	22	79	4	—	—	1	0354599
	12.00	12	26	83	4	37.5	11.5	1	0354605
1/2	12.70	12	26	83	4	37.5	11.5	1	0640197 <sup>1)</sup>
	13.00	12	26	83	4	37.5	11.5	1	0354612
	14.00	12	26	83	4	37.5	11.5	1	0354629
9/16	14.29	12	26	83	4	37.5	11.5	1	0640203 <sup>1)</sup>
	15.00	12	26	83	4	37.5	11.5	1	0354636
5/8	15.88	16	32	92	4	43.5	15.5	1	0640210 <sup>1)</sup>

<sup>1)</sup> Diameter tolerance +.0025 inches / -.0005 inches

<sup>2)</sup> Not center Cutting

<sup>3)</sup> Available in HSCo only

# HSS-PM 4 Flute End Mill



$d_1$ Ø Inch	$d_1$ Ø mm	$d_2$ Ø <sub>h<sub>6</sub></sub> mm	$l_2$ mm	$l_1$ mm	# of Flutes	$l_3$ mm	$d_3$ Ø mm	Pack Qty	C247
	16.00	16	32	92	4	43.5	15.5	1	0354643
	17.00	16	32	92	4	43.5	15.5	1	0609316
	18.00	16	32	92	4	43.5	15.5	1	0354650
	19.00	16	32	92	4	43.5	15.5	1	0609323
3/4	19.05	20	38	104	4	53.5	18.5	1	0640227 <sup>1)</sup>
	20.00	20	38	104	4	53.5	19.5	1	0354681
	21.00	20	38	104	4	53.5	19.5	1	0609330
	22.00	20	38	104	5	53.5	19.5	1	0354698
7/8	22.22	20	38	104	5	53.5	19.5	1	0640234 <sup>1)</sup>
	23.00	20	38	104	5	53.5	19.5	1	0609347
	24.00	25	45	121	5	64.5	23.5	1	0609354
	25.00	25	45	121	5	64.5	24.5	1	0354704
1"	25.40	25	45	121	5	64.5	24.5	1	0640241 <sup>1)</sup>
	26.00	25	45	121	6	64.5	24.5	1	0609361
	28.00	25	45	121	6	64.5	24.5	1	0354711
	30.00	25	45	121	6	64.5	24.5	1	0354742
	32.00	32	53	133	6	72.5	31.5	1	0354759
	36.00	32	53	133	6	72.5	31.5	1	0609378 <sup>2)3)</sup>
	40.00	40	63	155	6	84.5	39.0	1	0609385 <sup>2)3)</sup>
	50.00	50	75	177	8	96.5	48.0	1	0640258 <sup>2)3)</sup>

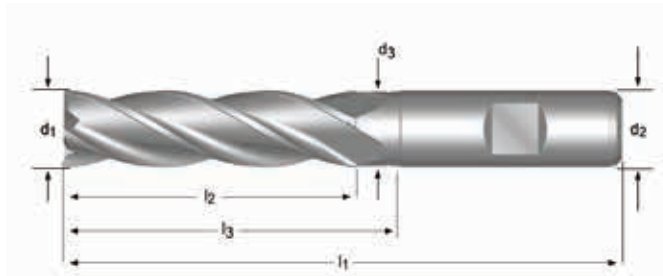
<sup>1)</sup> Diameter tolerance +.0025 inches / -.0005 inches

<sup>2)</sup> Not center Cutting

<sup>3)</sup> Available in HSCo only

## Long Length, Square End, Weldon Shank

**C273** Powdered Metal. Bright finish improves chip flow in soft or non-ferrous materials.



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	d <sub>2</sub> Øh <sub>6</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	# of Flutes	l <sub>3</sub> mm	d <sub>3</sub> Ø mm	Pack Qty	C273
	2.00	6	10	54	4	—	—	1	0354964
	2.50	6	12	56	4	—	—	1	0354971
	3.00	6	12	56	4	—	—	1	0355022
1/8	3.18	6	15	59	4	—	—	1	0640265 <sup>1)</sup>
	3.50	6	15	59	4	—	—	1	0355039
	4.00	6	19	63	4	—	—	1	0355060
	4.50	6	19	63	4	—	—	1	0355077
3/16	4.76	6	24	68	4	—	—	1	0640272 <sup>1)</sup>
	5.00	6	24	68	4	—	—	1	0355084
	5.50	6	24	68	4	—	—	1	0355091
	6.00	6	24	68	4	—	—	1	0355107
1/4	6.35	10	30	80	4	—	—	1	0640289 <sup>1)</sup>
	7.00	10	30	80	4	—	—	1	0355114
	8.00	10	38	88	4	—	—	1	0355121
	9.00	10	38	88	4	—	—	1	0355138
3/8	9.52	10	45	95	4	54.5	9.5	1	0640296 <sup>1)</sup>
	10.00	10	45	95	4	54.5	9.5	1	0354889
	11.00	12	45	102	4	—	—	1	0354896
	12.00	12	53	110	4	64.5	11.5	1	0354902
1/2	12.70	12	53	110	4	64.5	11.5	1	0640302 <sup>1)</sup>
	13.00	12	53	110	4	64.5	11.5	1	0354919
	14.00	12	53	110	4	64.5	11.5	1	0354926
	15.00	12	53	110	4	64.5	11.5	1	0354933
5/8	15.88	16	63	123	4	74.5	15.5	1	0640319 <sup>1)</sup>
	16.00	16	63	123	4	74.5	15.5	1	0354940
	18.00	16	63	123	4	74.5	15.5	1	0354957
3/4	19.05	20	75	141	4	90.5	18.5	1	0640326 <sup>1)</sup>
	20.00	20	75	141	4	90.5	19.5	1	0354988
	22.00	20	75	141	5	90.5	19.5	1	0354995
	25.00	25	90	166	5	109.5	24.5	1	0355008

<sup>1)</sup> Diameter tolerance +.0025 inches / -.0005 inches

<sup>2)</sup> Available in HSCo only

<sup>3)</sup> Not Center Cutting

# HSS-PM 4 Flute End Mill



$d_1$ Ø Inch	$d_1$ Ø mm	$d_2$ Ø <sub>h<sub>6</sub></sub> mm	$l_2$ mm	$l_1$ mm	# of Flutes	$l_3$ mm	$d_3$ Ø mm	Pack Qty	C273
1"	25.40	25	90	166	5	109.5	24.5	1	0640340 <sup>1)</sup>
	28.00	25	90	166	6	109.5	24.5	1	0355015
	30.00	25	90	166	6	109.5	24.5	1	0355046
	32.00	32	106	186	6	125.5	31.5	1	0355053
	40.00	40	125	217	6	146.5	39.0	1	0609309 <sup>2)3)</sup>

<sup>1)</sup> Diameter tolerance +.0025 inches / -.0005 inches

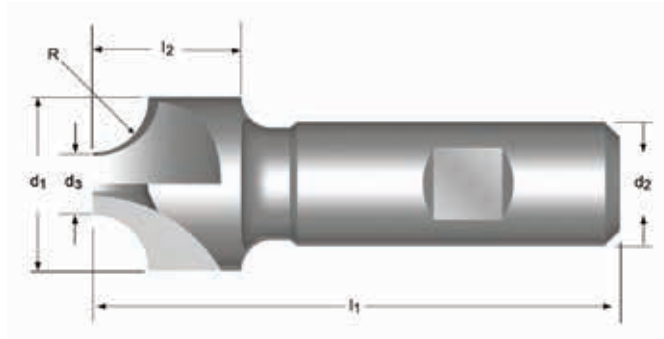
<sup>2)</sup> Available in HSCo only

<sup>3)</sup> Not Center Cutting

# HSS 4 Flute End Mill

## Regular Length, Inverse Radius, Corner Rounding, Weldon Shank

**883** Corner rounding for cutting external radius on part. Bright finish improves chip flow in soft or non-ferrous materials.

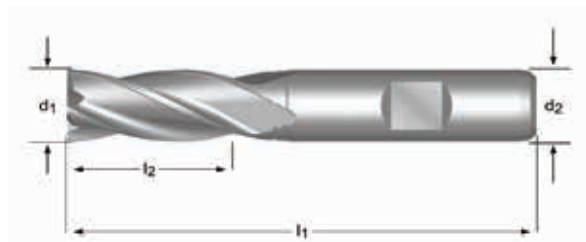


r	d <sub>1</sub> Ø	d <sub>2</sub> Ø	d <sub>3</sub> Ø	l <sub>2</sub>	l <sub>1</sub>	# of Flutes	Pack Qty	883
Inch	Inch	Inch	Inch	Inch	Inch			
1/16	7/16	3/8	1/4	13/16	2.1/2	4	1	5110686
3/32	1/2	3/8	1/4	13/16	2.1/2	4	1	5110687
1/8	5/8	1/2	1/4	1.1/16	3"	4	1	5110688
5/32	3/4	1/2	5/16	1"	3"	4	1	5110689
3/16	7/8	3/4	3/8	7/8	3.1/8	4	1	5110690
1/4	1"	3/4	3/8	1"	3.1/4	4	1	5110691
5/16	1.1/8	7/8	3/8	1.5/16	3.1/2	4	1	5110692
3/8	1.1/4	7/8	3/8	1.1/2	3.3/4	4	1	5110693
7/16	1.3/8	1"	3/8	1.9/16	4"	4	1	5110694
1/2	1.1/2	1"	3/8	1.5/8	4.1/8	4	1	5110695

# HSS Multi Flute End Mill

## Regular Length, Square End, Weldon Shank, 30° Helix

**940** Multi-flute finishing. Bright finish improves chip flow in soft or non-ferrous materials.

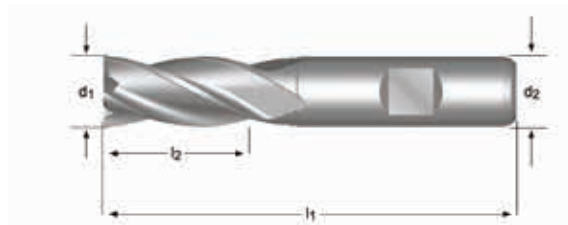


$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	940
1/8	0.1250	3/8	2.5/16	3/8	4	1	5110001
3/16	0.1875	1/2	2.3/8	3/8	4	1	5110002
1/4	0.2500	5/8	2.7/16	3/8	4	1	5110003
5/16	0.3125	3/4	2.1/2	3/8	4	1	5110004
3/8	0.3750	3/4	2.1/2	3/8	4	1	5110005
7/16	0.4375	1"	2.11/16	3/8	4	1	5110006
1/2	0.5000	1"	2.11/16	3/8	4	1	5110007
1/2	0.5000	1.1/4	3.1/4	1/2	4	1	5110008
9/16	0.5625	1.3/8	3.3/8	1/2	4	1	5110009
5/8	0.6250	1.3/8	3.3/8	1/2	4	1	5110010
5/8	0.6250	1.5/8	3.3/4	5/8	4	1	5110013
11/16	0.6875	1.5/8	3.5/8	1/2	4	1	5110011
11/16	0.6875	1.5/8	3.3/4	5/8	4	1	5110014
3/4	0.7500	1.5/8	3.5/8	1/2	4	1	5110012
3/4	0.7500	1.5/8	3.3/4	5/8	4	1	5110015
3/4	0.7500	1.5/8	3.7/8	3/4	4	1	5110711
13/16	0.8125	1.7/8	4"	5/8	6	1	5110016
7/8	0.8750	1.7/8	4"	5/8	6	1	5110017
7/8	0.8750	1.7/8	4.1/8	3/4	4	1	5110712
7/8	0.8750	1.7/8	4.1/8	7/8	4	1	5110020
1"	1.0000	1.7/8	4"	5/8	6	1	5110019
1"	1.0000	1.7/8	4.1/8	3/4	4	1	5110713
1"	1.0000	1.7/8	4.1/8	7/8	4	1	5110022
1"	1.0000	2"	4.1/2	1"	4	1	5110025

# Cobalt 4-Flute End Mill

## Regular Length, Square End, Weldon Shank, 30° Helix

**960** Multi-flute finishing for high strength heat resistant materials, stainless and alloy steel, super alloys, and titanium alloys.



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pack Qty	960
1/8	0.1250	3/8	2.5/16	3/8	4	1	5110660
3/16	0.1875	1/2	2.3/8	3/8	4	1	5110661
1/4	0.2500	5/8	2.7/16	3/8	4	1	5110662
5/16	0.3125	3/4	2.1/2	3/8	4	1	5110663
3/8	0.3750	3/4	2.1/2	3/8	4	1	5110664
1/2	0.5000	1.1/4	3.1/4	1/2	4	1	5110665
5/8	0.6250	1.5/8	3.3/4	5/8	4	1	5110666
3/4	0.7500	1.5/8	3.7/8	3/4	4	1	5110667
1"	1.0000	2"	4.1/2	1"	4	1	5110669

# Visual Index - Reamers

## Feed Rate Chart - Reamers

Alpha Code	Reamers - Feed in Inches per Revolution										Ø Diameter		
	1/16	5/64	1/8	3/16	5/16	25/64	1/2	5/8	25/32	1"	1-13/16	1-1/2	2"
A	0.002	0.002	0.003	0.004	0.006	0.007	0.007	0.009	0.010	0.011	0.013	0.015	0.017
B	0.002	0.003	0.004	0.006	0.007	0.008	0.009	0.011	0.012	0.014	0.016	0.020	0.022
C	0.003	0.003	0.005	0.007	0.009	0.010	0.011	0.013	0.015	0.017	0.019	0.024	0.027
D	0.031	0.004	0.006	0.008	0.011	0.013	0.014	0.016	0.019	0.021	0.024	0.029	0.033
E	0.004	0.006	0.007	0.010	0.014	0.015	0.017	0.020	0.021	0.025	0.030	0.036	0.043
F	0.006	0.007	0.010	0.014	0.017	0.020	0.022	0.025	0.028	0.031	0.037	0.047	0.059

Application Material Groups (AMG)		Hardness HRC	ISO	
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	S 1
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28	S 2
	4.3 Titanium, alloyed	6Al4V-4Mo, 7A14V-4Mo, 4911-4967	>28<38	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	N 3
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	N 4
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultramid, Polystrol	---	O
	8.2 Thermosetting plastics	Bakelitt, Pertinax	---	O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	H
10. Graphite	10.1 Standard graphite		---	O



# Visual Index - Reamers

Tool Material:	HM	HM	HM	HM	HM	HSS-E	HSS	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	
Finish/Coating:															
Standard:	DIN 8050	DIN 8093	DIN 8051	DIN 8094	DIN 8093	DIN 212	ANSI	ANSI	ANSI	BS 328	DIN 212	ANSI	ANSI	ANSI	
Direction of Cut:															
Shank:															
Flute Style:	A	B	A	B	B	B				B	E				
Tolerance:	H7	H7	H7	H7	± 0.005 ± 0.004 ± 0.005	± 0.005 ± 0.004 ± 0.005	USCTI	USCTI	USCTI	H7	H7			USCTI	USCTI
Taper Gradient:													1:48		
Style:	B441	B400	B442	B411	B481	B170	4533	4531	4535	B901	B157	B122	4588	4536	
Range:	10.00 - 20.00	1.00 - 20.00	10.00 - 20.00	5.00 - 30.00	0.98 - 12.05	0.98 - 12.00	N60 - 1.1/2	3/8 - 1.3/4"	1/16 - 1"	1.50 - 1/2	2.00 - 20.00	3/8 - 1.1/16	7/0 - 10	1/4 - 1"	
Page #	436	437	438	439	440	442	445	449	450	451	452	453	454	455	
1.1	59B	59B	59B	59B	59B	82C	82C	82C	82C	59C	82C	59C	59C	82C	
1.2	59B	59B	59B	59B	59B	66C	66C	66C	66C	46C	66C	46C	46C	66C	
1.3	46B	46B	46B	46B	46B	52C	52C	52C	52C	36C	52C	36C	36C	52C	
1.4	46B	46B	46B	46B	46B	49B	49B	49B	49B	33B	49B	33B	33B	49B	
1.5	33C	33C	33C	33C	33C	30B	30B	30B	30B	16B	30B	16B	16B	30B	
1.6	33C	33C	33C	33C	33C	16A	16A	16A	16A	13A	16A	13A	13A	16A	
1.7															
1.8															
2.1						36C	36C	36C	36C	26C	36C	26C	26C	36C	
2.2						20B	20B	20B	20B		20B	16B	16B	20B	
2.3						26B	26B	26B	26B		26B	20B	20B	26B	
2.4							20B	20B	20B					20B	
3.1	56D	56D	56D	56D	56D	52E	52E	52E	52E	46E		46E	46E	52E	
3.2	56D	56D	56D	56D	56D	49D	49D	49D	49D	36D		36D	36D	49D	
3.3	56D	56D	56D	56D	56D	43C	43C	43C	43C	33C		33C	33C	43C	
3.4	46D	46D	46D	46D	46D	36C	36C	36C	36C	30C		30C	30C	36C	
4.1	46C	46C	46C	46C	46C	49C	49C	49C	49C	36C	49C	36C	36C	49C	
4.2	46C	46C	46C	46C	46C	30B	30B	30B	30B	16B	30B	16B	16B	30B	
4.3	33B	33B	33B	33B	33B	16B	16B	16B	16B	13B	16B	13B	13B	16B	
5.1	33C	33C	33C	33C	33C	26D	26D	26D	26D	16D	26D	16D	16D	26D	
5.2	33B	33B	33B	33B	33B	16C	16C	16C	16C	10C	16C			16C	
5.3	33B	33B	33B	33B	33B	10C	10C	10C	10C	7C	10C			10C	
6.1	125E	125E	125E	125E	125E	82D	82D	82D	82D	59D	82D	59D	59D	82D	
6.2	125E	125E	125E	125E	125E	92E	92E	92E	92E	66E	92E	66E	66E	92E	
6.3	125E	125E	125E	125E	125E	82D	82D	82D	82D	59D		59D	59D	82D	
6.4	125D	125D	125D	125D	125D	46D	46D	46D	46D	36D		36D	36D	46D	
7.1	197D	197D	197D	197D	197D					75F	92F	75F	75F		
7.2	197D	197D	197D	197D	197D					59F	82F	59F	59F		
7.3	82D	82D	82D	82D	82D						66E	49E	49E		
7.4	82D	82D	82D	82D	82D						52D	46D	46D		
8.1	82C	82C	82C	82C	82C						98B				
8.2	43C	43C	43C	43C	43C					69B		69B	69B		
8.3															
9.1											10A				
10.1															

# Visual Index - Reamers

	HSS	HSS	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
	ANSI	ANSI	BS 328	DIN 311	ANSI	ANSI	ANSI	ISO 738	ANSI	ANSI	ANSI	DIN 206	BS 328	
			B									B	A	
	USCTI	USCTI	H7	k11	USCTI	USCTI	USCTI		USCTI	USCTI	USCTI	H7		
									1:48	1:48			1:48	
	4537	4532	B101	B121	4579	T400	4500	B334	B335	4587	4591	4600	B100	B301
	5/16 - 1"	3/8 - 1.3/4	3.00 - 2"	10.00 - 30.00	7/16 - 1.1/16	1/2 - 1.5/8	1/8 - 1"	N000	Blades N16 Nuts	N0 - N10	N0 - N10	1/8 - 1"	1.50 - 50.00	1/16 - 1/2
	455	456	457	459	460	461	462	463	464	465	466	467	468	470
1.1	82C	82C	59C	59C	59C	75E	82C	59C		59C	59C	59C	59C	59C
1.2	66C	66C	46C	46C	46C	46F	66C	46C		46C	46C	46C	46C	46C
1.3	52C	52C	36C	36C	36C	49F	52C	36C		36C	36C	36C	36C	36C
1.4	49B	49B	33B	33B	33B	49D	49B	33B		33B	33B	33B	33B	33B
1.5	30B	30B	16B	16B	16B	36D	30B	16B		16B	16B	16B	16B	16B
1.6	16A	16A	13A	13A	13A		16A	13A		13A	13A	13A	13A	13A
1.7														
1.8														
2.1	36C	36C	26C		26C	66F	36C	26F		26C	26C	26C	26F	26C
2.2	20B	20B			16B	39D	20B			16B	16B	16B		16B
2.3	26B	26B			20B	39D	26B			20B	20B	20B		20B
2.4		20B					20B					20B		
3.1	52E	52E	46E	46E	46E	108E	52E	46E		46E	46E	46E	46E	46E
3.2	49D	49D	36D	36D	36D	59H	49D	36D		36D	36D	36D	36D	36D
3.3	43C	43C	33C	33C	33C	59F	43C	33C		33C	33C	33C	33C	33C
3.4	36C	36C	30C	30C	30C		36C	30C		30C	30C	30C	30C	30C
4.1	49C	49C	36C	36C	36C	69F	49C	36C		36C	36C	36C	36C	36C
4.2	30B	30B	16B		16B	36D	30B	16B		16B	16B	16B	16B	16B
4.3	16B	16B	13B		13B		16B	13B		13B	13B	13B	13B	13B
5.1	26D	26D	16D		16D	49D	26D	16D		16D	16D	16D	16D	16D
5.2	16C	16C	10C				16C	10C					10C	
5.3	10C	10C	7C				10C	7C					7C	
6.1	82D	82D	59D		59D		82D	59D		59D	59D	59D	59D	59D
6.2	92E	92E	66E		66E		92E	66E		66E	66E	66E	66E	66E
6.3	82D	82D	59D		59D		82D	59D		59D	59D	59D	59D	59D
6.4	46D	46D	36D		36D		46D	36D		36D	36D	36D	36D	36D
7.1			75F		75F			75F		75F	75F	75F	75F	75F
7.2			59F		59F			59F		59F	59F	59F	59F	59F
7.3					49E					49E	49E	49E	49E	49E
7.4					46D					46D	46D	46D	46D	46D
8.1														
8.2			69B	69B	69B			69B		69B	69B	69B	69B	69B
8.3														
9.1														
10.1														

# List Number Index - Reamers



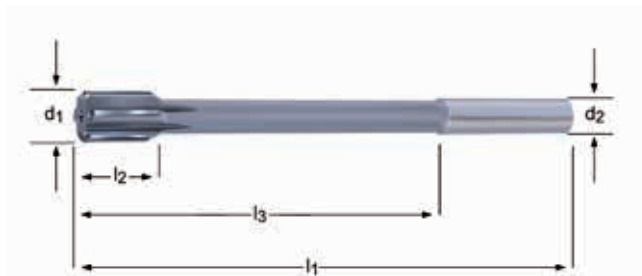
Pgs. 432 - 470

4500.....	462	B301.....	470
4531.....	449	B334.....	463
4532.....	456	B335.....	464
4533.....	445	B400.....	437
4535.....	450	B411.....	439
4536.....	455	B441.....	436
4537.....	455	B442.....	438
4579.....	460	B481.....	440
4587.....	465	B901.....	451
4588.....	454	T400.....	461
4591.....	466		
4600.....	467		
B100.....	468		
B101.....	457		
B121.....	459		
B122.....	453		
B157.....	452		
B170.....	442		

## Machine Reamer, Straight Shank, Brazed Carbide Tipped

**B441** Extremely unequal flute spacing. Straight flute. For machine reaming of abrasive, hard ferrous, and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2  
5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2



B441

HM



DIN 8050



10.00 - 20.00

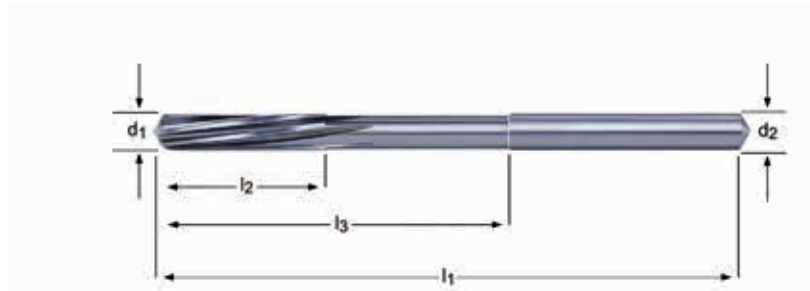
$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	$d_2$ Ø $h_9$ mm	Pack Qty	B441
10.0	133	19	87	6	10	1	0421086
11.0	142	19	96	6	10	1	0421093
12.0	151	19	105	6	10	1	0421109
13.0	151	19	105	6	10	1	0426302
14.0	160	19	110	6	12.5	1	0421116
15.0	162	19	112	6	12.5	1	0421123
16.0	170	22	120	6	12.5	1	0421130
17.0	175	22	123	6	14	1	0421147
18.0	182	22	130	6	14	1	0421154
19.0	189	22	131	6	16	1	0421161
20.0	195	22	137	6	16	1	0421178

## Machine Reamer, Straight Shank

### B400

Extremely unequal flute spacing with left hand slow spiral, right hand cut. For machine reaming of abrasive, hard ferrous, and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2  
5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2

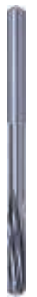


B400

HM



DIN 8093



1.00 - 20.00

$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	$d_2$ Ø $h_9$ mm	Pack Qty	B400
1.0	34	6	15	3	1.0	1	0052983 <sup>1)</sup>
1.2	38	8	16.5	3	1.2	1	0052990 <sup>1)</sup>
1.4	40	8	18	3	1.4	1	0053003 <sup>1)</sup>
1.5	40	8	18	3	1.5	1	0053010 <sup>1)</sup>
1.6	49	11	26	3	1.6	1	0053027 <sup>1)</sup>
1.8	49	11	25	4	1.8	1	0053034 <sup>1)</sup>
2.0	49	11	24	4	2.0	1	0053041 <sup>1)</sup>
2.2	57	15	30	4	2.2	1	0053058 <sup>1)</sup>
2.5	57	15	28	4	2.5	1	0053065 <sup>1)</sup>
2.8	61	15	32	4	2.8	1	0053072 <sup>1)</sup>
3.0	61	15	30	6	3.0	1	0144152 <sup>1)</sup>
3.2	70	18	33	6	3.2	1	0144169 <sup>1)</sup>
3.5	70	18	33	6	3.5	1	0144176 <sup>1)</sup>
4.0	75	19	44	6	4.0	1	0144183 <sup>1)</sup>
4.5	80	21	46	6	4.5	1	0144190 <sup>1)</sup>
5.0	86	23	53	6	5.0	1	0144206 <sup>1)</sup>
5.5	93	26	56	6	5.6	1	0144213 <sup>1)</sup>
6.0	93	26	56	6	5.6	1	0144220 <sup>1)</sup>
6.5	101	28	63	6	6.3	1	0144237 <sup>2)</sup>
7.0	109	31	69	6	7.1	1	0144244 <sup>2)</sup>
8.0	117	33	75	6	8.0	1	0144251 <sup>2)</sup>
9.0	125	36	81	6	9.0	1	0144268 <sup>2)</sup>
10.0	133	38	87	6	10.0	1	0144275 <sup>2)</sup>
12.0	151	44	105	6	10.0	1	0144282 <sup>2)</sup>
14.0	160	47	110	8	12.5	1	0144299 <sup>2)</sup>
16.0	170	52	120	8	12.5	1	0144305 <sup>2)</sup>
18.0	182	56	130	6	14.0	1	0144312 <sup>3)</sup>
20.0	195	60	137	6	16.0	1	0144329 <sup>3)</sup>

<sup>1)</sup> Solid Carbide

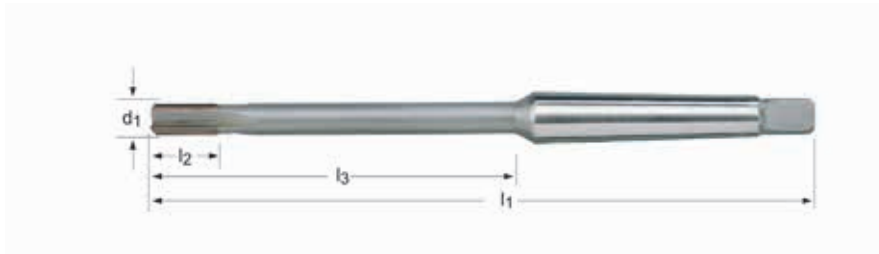
<sup>2)</sup> Carbide Head

<sup>3)</sup> Carbide Tipped

## Machine Reamer, Taper Shank, Braze Carbide Tipped

**B442** Extremely unequal flute spacing with straight flute. For machine reaming of abrasive, hard ferrous, and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2  
5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2



B442



10.00 - 20.00

$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	MTS	Pack Qty	B442
10.0	168	19	102.5	6	1	1	0421185
12.0	182	19	116.5	6	1	1	0421192
14.0	189	19	123.5	6	1	1	0421208
15.0	204	19	124	6	2	1	0421215
16.0	210	22	130	6	2	1	0421222
17.0	214	22	134	6	2	1	0421239
18.0	219	22	139	6	2	1	0421246
19.0	223	22	143	6	2	1	0426319
20.0	228	22	148	6	2	1	0421253

## Machine Reamer, Taper Shank

**B411** Extremely unequal spacing with left hand spiral, and right hand cut. For machine reaming of abrasive, hard ferrous, and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2  
5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2



B411

HM



DIN 8094



5.00 - 30.00

$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	MTS	Pack Qty	B411
5.0	133	23	67.5	6	1	1	0053195 <sup>1)</sup>
6.0	138	26	72.5	6	1	1	0053201 <sup>1)</sup>
7.0	150	31	84.5	6	1	1	0053218 <sup>1)</sup>
8.0	156	33	90.5	6	1	1	0053225 <sup>1)</sup>
9.0	162	36	96.5	6	1	1	0053232 <sup>1)</sup>
10.0	168	38	102.5	6	1	1	0053126 <sup>1)</sup>
12.0	182	44	116.5	6	1	1	0053140 <sup>1)</sup>
14.0	189	47	123.5	8	1	1	0053164 <sup>1)</sup>
15.0	204	50	124	8	2	1	0053171 <sup>1)</sup>
16.0	210	52	130	8	2	1	0053188 <sup>1)</sup>
17.0	214	54	134	6	2	1	0144336 <sup>2)</sup>
18.0	219	56	139	6	2	1	0144343 <sup>2)</sup>
19.0	223	58	143	6	2	1	0144350 <sup>2)</sup>
20.0	228	60	148	6	2	1	0144367 <sup>2)</sup>
22.0	237	64	157	6	2	1	0144374 <sup>2)</sup>
24.0	268	68	169	8	3	1	0144381 <sup>2)</sup>
25.0	268	68	169	8	3	1	0144398 <sup>2)</sup>
26.0	273	70	174	8	3	1	0144404 <sup>2)</sup>
30.0	281	73	182	8	3	1	0144411 <sup>2)</sup>

<sup>1)</sup> Carbide Head  
<sup>2)</sup> Carbide Tipped

# APPLICATION CARBIDE REAMER



## High Precision, Straight Shank

**B481** High Precision NC Centesimal Reamers are offered in 0.01mm increments. Extremely unequal flute spacing with left hand slow spiral, right hand cut. For machining reaming of abrasive, hard ferrous, and non-ferrous materials. Ideal for hydraulic and heat shrink tool holding systems.

1.1 1.2 1.3 1.4 1.5 1.6 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2  
5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2



B481



0.98 - 12.05

d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	# of Flutes	d <sub>2</sub> Øh <sub>6</sub> mm	Pack Qty	B481
0.98	49.5	6	21.5	3	4	1	0421567
0.99	49.5	6	21.5	3	4	1	0421574
1.00	49.5	6	21.5	3	4	1	0421581
1.01	49.5	6	21.5	3	4	1	0421598
1.02	49.5	6	21.5	3	4	1	0421604
1.03	49.5	9	21.5	3	4	1	0421611
1.48	49	9	21	3	4	1	0421628
1.49	49	9	21	3	4	1	0421635
1.50	49	9	21	3	4	1	0421642
1.51	49	9	21	3	4	1	0421659
1.52	49	9	21	3	4	1	0421666
1.53	49	9	21	3	4	1	0421673
1.98	49	12	21	4	4	1	0421680
1.99	49	12	21	4	4	1	0421697
2.00	49	12	21	4	4	1	0421857
2.01	49	12	21	4	4	1	0421864
2.02	49	12	21	4	4	1	0421871
2.03	49	12	21	4	4	1	0421888
2.48	59	16	31	4	4	1	0421895
2.49	59	16	31	4	4	1	0421901
2.50	59	16	31	4	4	1	0421918
2.51	59	16	31	4	4	1	0421925
2.52	59	16	31	4	4	1	0421932
2.53	59	16	31	4	4	1	0421949
2.97	62.5	17	35	6	4	1	0421956
2.98	62.5	17	35	6	4	1	0421963
2.99	62.5	17	35	6	4	1	0421970
3.00	62.5	17	35	6	4	1	0421987
3.01	62.5	17	35	6	4	1	0421994
3.02	62.5	17	35	6	4	1	0422007
3.03	62.5	17	35	6	4	1	0422014
3.97	75	19	47	6	4	1	0422021
3.98	75	19	47	6	4	1	0422038



$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	$d_2$ Ø $h_6$ mm	Pack Qty	B481
3.99	75	19	47	6	4	1	0422045
4.00	75	19	47	6	4	1	0422052
4.01	75	19	47	6	4	1	0422069
4.02	75	19	47	6	4	1	0422076
4.03	75	19	47	6	4	1	0422083
4.97	86	23	50	6	6	1	0422090
4.98	86	23	50	6	6	1	0422106
4.99	86	23	50	6	6	1	0422113
5.00	86	23	50	6	6	1	0422120
5.01	86	23	50	6	6	1	0422137
5.02	86	23	50	6	6	1	0422144
5.03	86	23	50	6	6	1	0422151
5.97	93	26	57	6	6	1	0422168
5.98	93	26	57	6	6	1	0422175
5.99	93	26	57	6	6	1	0422182
6.00	93	26	57	6	6	1	0422199
6.01	93	26	57	6	6	1	0422205
6.02	93	26	57	6	6	1	0422212
6.03	93	26	57	6	6	1	0422229
7.97	117	33	81	6	8	1	0422236
7.98	117	33	81	6	8	1	0422243
7.99	117	33	81	6	8	1	0422250
8.00	117	33	81	6	8	1	0422267
8.01	117	33	81	6	8	1	0422274
8.02	117	33	81	6	8	1	0422281
8.03	117	33	81	6	8	1	0422298
8.04	117	33	81	6	8	1	0422304
9.97	133	38	93	6	10	1	0422311
9.98	133	38	93	6	10	1	0422328
9.99	133	38	93	6	10	1	0422335
10.00	133	38	93	6	10	1	0421703
10.01	133	38	93	6	10	1	0421710
10.02	133	38	93	6	10	1	0421727
10.03	133	38	93	6	10	1	0421734
10.04	133	38	93	6	10	1	0421741
10.05	133	38	93	6	10	1	0421758
11.97	151	44	106	6	12	1	0421765
11.98	151	44	106	6	12	1	0421772
11.99	151	44	106	6	12	1	0421789
12.00	151	44	106	6	12	1	0421796
12.01	151	44	106	6	12	1	0421802
12.02	151	44	106	6	12	1	0421819
12.03	151	44	106	6	12	1	0421826
12.04	151	44	106	6	12	1	0421833
12.05	151	44	106	6	12	1	0421840

## High Precision, Straight Shank

**B170** Centesimal Reamer by 0.01mm increments. Left hand slow spiral, right hand cut. For machine reaming of abrasive, hard ferrous, and non-ferrous materials.

1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2  
4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4



B170

HSS-E



DIN 212



0.98 - 12.00

$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	$d_2$ Ø $h_3$ mm	Pack Qty	B170
0.98	34	5.5	15	3	1.0	1	0127957
0.99	34	5.5	15	3	1.0	1	0127964
1.00	34	5.5	15	3	1.0	1	0127971
1.01	34	5.5	15	3	1.0	1	0127988
1.02	34	5.5	15	3	1.0	1	0127995
1.03	34	5.5	15	3	1.0	1	0128008
1.04	34	5.5	15	3	1.0	1	0128015
1.05	34	5.5	15	3	1.0	1	0128022
1.49	40	8.0	18	3	1.5	1	0128459
1.50	40	8.0	18	3	1.5	1	0128466
1.51	43	9.0	20	3	1.6	1	0050392
1.52	43	9.0	20	3	1.6	1	0128473
1.98	49	11.0	24	4	2.0	1	0128916
1.99	49	11.0	24	4	2.0	1	0128923
2.00	49	11.0	24	4	2.0	1	0130896
2.01	49	11.0	24	4	2.0	1	0130902
2.02	49	11.0	24	4	2.0	1	0130919
2.03	49	11.0	24	4	2.0	1	0130926
2.04	49	11.0	24	4	2.0	1	0130933
2.05	49	11.0	24	4	2.0	1	0130940
2.49	57	14.0	28	4	2.5	1	0131367
2.50	57	14.0	28	4	2.5	1	0131374
2.51	57	14.0	28	4	2.5	1	0131381
2.52	57	14.0	28	4	2.5	1	0131398
2.98	61	15.0	32	6	3.0	1	0131848
2.99	61	15.0	32	6	3.0	1	0131855
3.00	61	15.0	32	6	3.0	1	0131862
3.01	65	16.0	35	6	3.2	1	0050491
3.02	65	16.0	35	6	3.2	1	0131879
3.03	65	16.0	35	6	3.2	1	0131886
3.04	65	16.0	35	6	3.2	1	0131893
3.05	65	16.0	35	6	3.2	1	0131909
3.49	70	18.0	40	6	3.5	1	0132302

$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	$d_2$ Ø $h_3$ mm	Pack Qty	B170
3.50	70	18.0	40	6	3.5	1	0132319
3.51	70	18.0	40	6	3.5	1	0132326
3.52	70	18.0	40	6	3.5	1	0132333
3.98	75	19.0	43	6	4.0	1	0132784
3.99	75	19.0	43	6	4.0	1	0132791
4.00	75	19.0	43	6	4.0	1	0132807
4.01	75	19.0	43	6	4.0	1	0132814
4.02	75	19.0	43	6	4.0	1	0132821
4.03	75	19.0	43	6	4.0	1	0132838
4.04	75	19.0	43	6	4.0	1	0132845
4.05	75	19.0	43	6	4.0	1	0132852
4.49	80	21.0	47	6	4.5	1	0133286
4.50	80	21.0	47	6	4.5	1	0133293
4.51	80	21.0	47	6	4.5	1	0133309
4.52	80	21.0	47	6	4.5	1	0133316
4.98	86	23.0	52	6	5.0	1	0133767
4.99	86	23.0	52	6	5.0	1	0133774
5.00	86	23.0	52	6	5.0	1	0133781
5.01	86	23.0	52	6	5.0	1	0133798
5.02	86	23.0	52	6	5.0	1	0133804
5.03	86	23.0	52	6	5.0	1	0133811
5.04	86	23.0	52	6	5.0	1	0133828
5.05	86	23.0	52	6	5.0	1	0133835
5.49	93	26.0	57	6	5.6	1	0134269
5.50	93	26.0	57	6	5.6	1	0134276
5.51	93	26.0	57	6	5.6	1	0134283
5.52	93	26.0	57	6	5.6	1	0134290
5.98	93	26.0	57	6	5.6	1	0134757
5.99	93	26.0	57	6	5.6	1	0134764
6.00	93	26.0	57	6	5.6	1	0134771
6.01	101	28.0	63	6	6.3	1	0134788
6.02	101	28.0	63	6	6.3	1	0134795
6.03	101	28.0	63	6	6.3	1	0134801
6.04	101	28.0	63	6	6.3	1	0134818
6.05	101	28.0	63	6	6.3	1	0134825
6.49	101	28.0	63	6	6.3	1	0135242
6.50	101	28.0	63	6	6.3	1	0135259
6.51	101	28.0	63	6	6.3	1	0135303
6.52	101	28.0	63	6	6.3	1	0135310
6.98	109	31.0	69	6	7.1	1	0135761
6.99	109	31.0	69	6	7.1	1	0135778
7.00	109	31.0	69	6	7.1	1	0135785
7.01	109	31.0	69	6	7.1	1	0135792
7.02	109	31.0	69	6	7.1	1	0135808
7.03	109	31.0	69	6	7.1	1	0135815
7.04	109	31.0	69	6	7.1	1	0135822
7.05	109	31.0	69	6	7.1	1	0135839
7.49	109	31.0	69	6	7.1	1	0136270
7.50	109	31.0	69	6	7.1	1	0136287
7.51	117	33.0	75	6	8.0	1	0136294
7.52	117	33.0	75	6	8.0	1	0136300
7.98	117	33.0	75	6	8.0	1	0136751
7.99	117	33.0	75	6	8.0	1	0136768
8.00	117	33.0	75	6	8.0	1	0136959
8.01	117	33.0	75	6	8.0	1	0136775
8.02	117	33.0	75	6	8.0	1	0136782
8.03	117	33.0	75	6	8.0	1	0136799
8.04	117	33.0	75	6	8.0	1	0136805
8.05	117	33.0	75	6	8.0	1	0136812
8.49	117	33.0	75	6	8.0	1	0137260
8.50	117	33.0	75	6	8.0	1	0137277
8.51	125	36.0	81	6	9.0	1	0050590
8.52	125	36.0	81	6	9.0	1	0137284
8.98	125	36.0	81	6	9.0	1	0137734
8.99	125	36.0	81	6	9.0	1	0137741
9.00	125	36.0	81	6	9.0	1	0137758

# APPLICATION COBALT REAMER

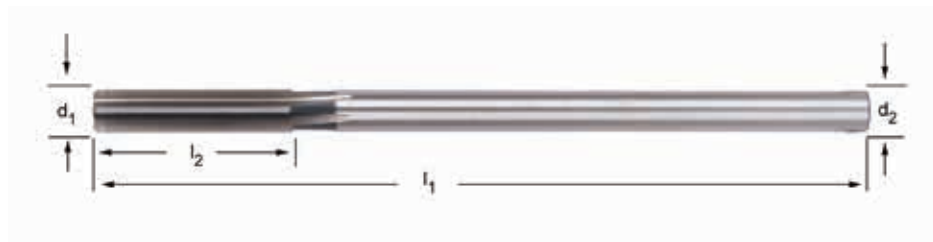


$d_1$ Ø	$l_1$	$l_2$	$l_3$	# of Flutes	$d_2$ Øh <sub>9</sub> mm	Pack Qty	B170
mm	mm	mm	mm		mm		
9.01	125	36.0	81	6	9.0	1	0137765
9.02	125	36.0	81	6	9.0	1	0137772
9.03	125	36.0	81	6	9.0	1	0137789
9.04	125	36.0	81	6	9.0	1	0137796
9.05	125	36.0	81	6	9.0	1	0137802
9.49	125	36.0	81	6	9.0	1	0138236
9.50	125	36.0	81	6	9.0	1	0138243
9.51	133	38.0	87	6	10.0	1	0138250
9.52	133	38.0	87	6	10.0	1	0138267
9.98	133	38.0	87	6	10.0	1	0138717
9.99	133	38.0	87	6	10.0	1	0138724
10.00	133	38.0	87	6	10.0	1	0128930
10.01	133	38.0	87	6	10.0	1	0128947
10.02	133	38.0	87	6	10.0	1	0128954
10.03	133	38.0	87	6	10.0	1	0128961
10.04	133	38.0	87	6	10.0	1	0128978
10.05	133	38.0	87	6	10.0	1	0128985
10.49	133	38.0	87	6	10.0	1	0129463
10.51	133	38.0	87	6	10.0	1	0129470
10.52	133	38.0	87	6	10.0	1	0129487
10.98	142	41.0	96	6	10.0	1	0129883
10.99	142	41.0	96	6	10.0	1	0129890
11.00	142	41.0	96	6	10.0	1	0129906
11.01	142	41.0	96	6	10.0	1	0129913
11.02	142	41.0	96	6	10.0	1	0129920
11.03	142	41.0	96	6	10.0	1	0129937
11.04	142	41.0	96	6	10.0	1	0129944
11.05	142	41.0	96	6	10.0	1	0129951
11.49	142	41.0	96	6	10.0	1	0130384
11.50	142	41.0	96	6	10.0	1	0130391
11.51	142	41.0	96	6	10.0	1	0130407
11.52	142	41.0	96	6	10.0	1	0130414
11.98	151	44.0	105	6	10.0	1	0130865
11.99	151	44.0	105	6	10.0	1	0130872
12.00	151	44.0	105	6	10.0	1	0130889

## Chucking Reamer, Straight Shank

**4533** Straight Flute, Right Hand Cut. Chucking reamers have shorter and deeper flutes than hand reamers and are specifically designed for accurate machine reaming in most materials and equipment including screw machines, turret lathes, drill presses, and machining centers. Recommended for most general purpose reaming.

Produced per ASME B94.2-1995 Standards.



4533

HSS



ANSI



N60 - 1.1/2

d <sub>1</sub> Ø "Nr./letter	d <sub>1</sub> decimal Inch	d <sub>2</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4533
N60	0.0400	0.0390	1/2	2.1/2	4	1	5010173
N59	0.0410	0.0390	1/2	2.1/2	4	1	5010175
N58	0.0420	0.0390	1/2	2.1/2	4	1	5010177
N57	0.0430	0.0390	1/2	2.1/2	4	1	5010179
N56	0.0465	0.0455	1/2	2.1/2	4	1	5010186
3/64	0.0469	0.0455	1/2	2.1/2	4	1	5010187
N55	0.0520	0.0510	1/2	2.1/2	4	1	5010198
N54	0.0550	0.0510	1/2	2.1/2	4	1	5010204
N53	0.0595	0.0585	1/2	2.1/2	4	1	5010213
1/16	0.0625	0.0585	1/2	2.1/2	4	1	5010219
N52	0.0635	0.0585	1/2	2.1/2	4	1	5010221
N51	0.0670	0.0660	3/4	3"	4	1	5010228
N50	0.0700	0.0660	3/4	3"	4	1	5010234
N49	0.0730	0.0660	3/4	3"	4	1	5010240
N48	0.0760	0.0720	3/4	3"	4	1	5010246
5/64	0.0781	0.0720	3/4	3"	4	1	5010251
N47	0.0785	0.0720	3/4	3"	4	1	5010252
N46	0.0810	0.0771	3/4	3"	4	1	5010257
N45	0.0820	0.0771	3/4	3"	4	1	5010259
N44	0.0860	0.0810	3/4	3"	4	1	5010267
N43	0.0890	0.0810	3/4	3"	4	1	5010273
N42	0.0935	0.0880	3/4	3"	4	1	5010282
3/32	0.0938	0.0880	3/4	3"	4	1	5010283
N41	0.0960	0.0928	7/8	3.1/2	4	1	5010288
N40	0.0980	0.0928	7/8	3.1/2	4	1	5010292
N39	0.0995	0.0928	7/8	3.1/2	4	1	5010295
N38	0.1015	0.0950	7/8	3.1/2	4	1	5010299
N37	0.1040	0.0950	7/8	3.1/2	4	1	5010304
N36	0.1065	0.1030	7/8	3.1/2	4	1	5010309
7/64	0.1094	0.1030	7/8	3.1/2	4	1	5010316
N35	0.1100	0.1030	7/8	3.1/2	4	1	5010318
N34	0.1110	0.1055	7/8	3.1/2	4	1	5010320
N33	0.1130	0.1055	7/8	3.1/2	4	1	5010324

# HSS REAMER



d <sub>1</sub> Ø "/Nr./letter	d <sub>1</sub> decimal Inch	d <sub>2</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4533
N32	0.1160	0.1120	7/8	3.1/2	4	1	5010330
N31	0.1200	0.1120	7/8	3.1/2	4	1	5010338
	0.1230	0.1120	7/8	3.1/2	4	1	5010344
	0.1240	0.1190	7/8	3.1/2	4	1	5010346
	0.1247	0.1190	7/8	3.1/2	4	1	5010349
1/8	0.1250	0.1190	7/8	3.1/2	4	1	5010350
	0.1260	0.1190	7/8	3.1/2	4	1	5010354
N30	0.1285	0.1190	7/8	3.1/2	4	1	5010359
N29	0.1360	0.1275	1"	4"	4	1	5010374
N28	0.1405	0.1350	1"	4"	4	1	5010383
9/64	0.1410	0.1350	1"	4"	4	1	5010384
N27	0.1440	0.1350	1"	4"	4	1	5010391
N26	0.1470	0.1430	1"	4"	4	1	5010397
N25	0.1495	0.1430	1"	4"	4	1	5010402
N24	0.1520	0.1460	1"	4"	4	1	5010407
N23	0.1540	0.1460	1"	4"	4	1	5010411
5/32	0.1562	0.1510	1"	4"	6	1	5010416
N22	0.1570	0.1510	1"	4"	6	1	5010418
N21	0.1590	0.1530	1.1/8	4.1/2	6	1	5010422
N20	0.1610	0.1530	1.1/8	4.1/2	6	1	5010426
N19	0.1660	0.1595	1.1/8	4.1/2	6	1	5010436
N18	0.1695	0.1595	1.1/8	4.1/2	6	1	5010443
11/64	0.1719	0.1645	1.1/8	4.1/2	6	1	5010448
N17	0.1730	0.1645	1.1/8	4.1/2	6	1	5010451
N16	0.1770	0.1700	1.1/8	4.1/2	6	1	5010459
N15	0.1800	0.1755	1.1/8	4.1/2	6	1	5010465
N14	0.1820	0.1755	1.1/8	4.1/2	6	1	5010469
N13	0.1850	0.1800	1.1/8	4.1/2	6	1	5010475
	0.1855	0.1800	1.1/8	4.1/2	6	1	5010476
	0.1865	0.1800	1.1/8	4.1/2	6	1	5010478
	0.1870	0.1800	1.1/8	4.1/2	6	1	5010479
3/16	0.1875	0.1800	1.1/8	4.1/2	6	1	5010480
	0.1885	0.1800	1.1/8	4.1/2	6	1	5010482
N12	0.1890	0.1800	1.1/8	4.1/2	6	1	5010483
N11	0.1910	0.1860	1.1/4	5"	6	1	5010487
N10	0.1935	0.1860	1.1/4	5"	6	1	5010492
N9	0.1960	0.1895	1.1/4	5"	6	1	5010498
N8	0.1990	0.1895	1.1/4	5"	6	1	5010504
N7	0.2010	0.1945	1.1/4	5"	6	1	5010508
13/64	0.2031	0.1945	1.1/4	5"	6	1	5010513
N6	0.2040	0.1945	1.1/4	5"	6	1	5010515
N5	0.2055	0.2016	1.1/4	5"	6	1	5010518
N4	0.2090	0.2016	1.1/4	5"	6	1	5010525
N3	0.2130	0.2075	1.1/4	5"	6	1	5010533
7/32	0.2188	0.2075	1.1/4	5"	6	1	5010545
N2	0.2210	0.2173	1.1/2	6"	6	1	5010550
N1	0.2280	0.2173	1.1/2	6"	6	1	5010564
A	0.2340	0.2265	1.1/2	6"	6	1	5010576
15/64	0.2344	0.2265	1.1/2	6"	6	1	5010577
B	0.2380	0.2329	1.1/2	6"	6	1	5010585
C	0.2420	0.2329	1.1/2	6"	6	1	5010593
D	0.2460	0.2329	1.1/2	6"	6	1	5010602
	0.2480	0.2329	1.1/2	6"	6	1	5010606
	0.2490	0.2400	1.1/2	6"	6	1	5010608
	0.2495	0.2400	1.1/2	6"	6	1	5010609
1/4	0.2500	0.2400	1.1/2	6"	6	1	5010610
E	0.2500	0.2400	1.1/2	6"	6	1	5011202
	0.2510	0.2400	1.1/2	6"	6	1	5010612
F	0.2570	0.2485	1.1/2	6"	6	1	5010619
G	0.2610	0.2485	1.1/2	6"	6	1	5010622
17/64	0.2656	0.2485	1.1/2	6"	6	1	5010623
H	0.2660	0.2485	1.1/2	6"	6	1	5010624
I	0.2720	0.2485	1.1/2	6"	6	1	5010626
J	0.2770	0.2485	1.1/2	6"	6	1	5010627
K	0.2810	0.2485	1.1/2	6"	6	1	5010628
9/32	0.2812	0.2485	1.1/2	6"	6	1	5010629

# HSS REAMER

d <sub>1</sub> Ø "Nr./letter	d <sub>1</sub> decimal Inch	d <sub>2</sub> decimal Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4533
L	0.2900	0.2792	1.1/2	6"	6	1	5010630
M	0.2950	0.2792	1.1/2	6"	6	1	5010631
19/64	0.2969	0.2792	1.1/2	6"	6	1	5010632
N	0.3020	0.2792	1.1/2	6"	6	1	5010633
	0.3105	0.2792	1.1/2	6"	6	1	5010636
	0.3115	0.2792	1.1/2	6"	6	1	5010638
	0.3120	0.2792	1.1/2	6"	6	1	5010639
5/16	0.3125	0.2792	1.1/2	6"	6	1	5010640
	0.3135	0.2792	1.1/2	6"	6	1	5010642
O	0.3160	0.2792	1.1/2	6"	6	1	5010645
P	0.3230	0.2792	1.1/2	6"	6	1	5010647
21/64	0.3281	0.2792	1.1/2	6"	6	1	5010648
Q	0.3320	0.2792	1.1/2	6"	6	1	5010649
R	0.3390	0.2792	1.1/2	6"	6	1	5010650
11/32	0.3438	0.2792	1.1/2	6"	6	1	5010651
S	0.3480	0.3100	1.3/4	7"	6	1	5010652
T	0.3580	0.3100	1.3/4	7"	6	1	5010653
23/64	0.3594	0.3100	1.3/4	7"	6	1	5010654
U	0.3680	0.3100	1.3/4	7"	6	1	5010655
	0.3730	0.3100	1.3/4	7"	6	1	5010658
	0.3740	0.3100	1.3/4	7"	6	1	5010659
	0.3745	0.3100	1.3/4	7"	6	1	5010660
3/8	0.3750	0.3100	1.3/4	7"	6	1	5010661
	0.3760	0.3100	1.3/4	7"	6	1	5010662
V	0.3770	0.3100	1.3/4	7"	6	1	5010663
W	0.3860	0.3100	1.3/4	7"	6	1	5010665
25/64	0.3906	0.3100	1.3/4	7"	6	1	5010666
X	0.3970	0.3100	1.3/4	7"	6	1	5010667
Y	0.4040	0.3100	1.3/4	7"	6	1	5010668
13/32	0.4062	0.3100	1.3/4	7"	6	1	5010670
Z	0.4130	0.3730	1.3/4	7"	6	1	5010671
27/64	0.4219	0.3730	1.3/4	7"	6	1	5010672
	0.4355	0.3730	1.3/4	7"	6	1	5010673
	0.4365	0.3730	1.3/4	7"	6	1	5010674
	0.4370	0.3730	1.3/4	7"	6	1	5010675
7/16	0.4375	0.3730	1.3/4	7"	6	1	5010676
	0.4385	0.3730	1.3/4	7"	6	1	5010677
29/64	0.4531	0.3730	1.3/4	7"	6	1	5010678
15/32	0.4688	0.3730	1.3/4	7"	6	1	5010679
31/64	0.4844	0.4355	2"	8"	6	1	5010680
	0.4980	0.4355	2"	8"	6	1	5010681
	0.4990	0.4355	2"	8"	6	1	5010682
	0.4995	0.4355	2"	8"	6	1	5010683
1/2	0.5000	0.4355	2"	8"	6	1	5010684
	0.5010	0.4355	2"	8"	6	1	5010685
33/64	0.5156	0.4355	2"	8"	6	1	5010690
17/32	0.5312	0.4355	2"	8"	6	1	5010691
35/64	0.5469	0.4355	2"	8"	8	1	5010692
9/16	0.5625	0.4355	2"	8"	8	1	5010693
37/64	0.5781	0.4355	2"	8"	8	1	5010694
19/32	0.5938	0.4355	2"	8"	8	1	5010695
39/64	0.6094	0.5620	2.1/4	9"	8	1	5010696
5/8	0.6250	0.5620	2.1/4	9"	8	1	5010698
41/64	0.6406	0.5620	2.1/4	9"	8	1	5010700
21/32	0.6562	0.5620	2.1/4	9"	8	1	5010701
43/64	0.6719	0.5620	2.1/4	9"	8	1	5010702
11/16	0.6875	0.5620	2.1/4	9"	8	1	5010703
45/64	0.7031	0.5620	2.1/4	9"	8	1	5010704
23/32	0.7188	0.5620	2.1/4	9"	8	1	5010705
47/64	0.7344	0.6245	2.1/2	9.1/2	8	1	5010706
3/4	0.7500	0.6245	2.1/2	9.1/2	8	1	5010708
49/64	0.7656	0.6245	2.1/2	9.1/2	8	1	5010710
25/32	0.7812	0.6245	2.1/2	9.1/2	8	1	5010711
51/64	0.7969	0.6245	2.1/2	9.1/2	8	1	5010712
13/16	0.8125	0.6245	2.1/2	9.1/2	8	1	5010713
53/64	0.8281	0.6245	2.1/2	9.1/2	8	1	5010714

# HSS REAMER



$d_1$ Ø "/Nr./letter	$d_1$ decimal Inch	$d_2$ decimal Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4533
27/32	0.8438	0.6245	2.1/2	9.1/2	8	1	5010715
55/64	0.8594	0.7495	2.5/8	10"	8	1	5010716
7/8	0.8750	0.7495	2.5/8	10"	8	1	5010717
57/64	0.8906	0.7495	2.5/8	10"	8	1	5010718
29/32	0.9062	0.7495	2.5/8	10"	8	1	5010719
59/64	0.9219	0.7495	2.5/8	10"	8	1	5010720
15/16	0.9375	0.7495	2.5/8	10"	8	1	5010721
61/64	0.9531	0.7495	2.5/8	10"	8	1	5010722
31/32	0.9688	0.7495	2.5/8	10"	8	1	5010723
63/64	0.9844	0.8745	2.3/4	10.1/2	8	1	5010724
1"	1.0000	0.8745	2.3/4	10.1/2	8	1	5010725
1.1/16	1.0625	0.8745	2.3/4	10.1/2	8	1	5010726
1.1/8	1.1250	0.8745	2.7/8	11"	8	1	5010727
1.3/16	1.1875	0.9995	2.7/8	11"	8	1	5010728
1.1/4	1.2500	0.9995	3"	11.1/2	8	1	5010729
1.3/8	1.3750	0.9995	3.1/4	12"	8	1	5010731
1.1/2	1.5000	1.2495	3.1/2	12.1/2	8	1	5010733



## Chucking Reamer, Expansion, Straight Shank

**4531** Straight Flute, Right Hand Cut. Expansion Chucking Reamers are an economical general purpose high production tool. The expansion feature permits the reamer to be resharpened many times while still retaining the original size. Recommended for abrasive materials. As the diameter wears down, the reamers can be expanded many times by tightening the end adjusting screw and regrinding to it's original size.

Produced per ASME B94.2-1995 Standards.



4531

HSS



ANSI



3/8 - 1.3/4"

$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4531
3/8	0.3750	5/16	3/4	7"	6	1	5011204
7/16	0.4375	3/8	7/8	7"	6	1	5010778
1/2	0.5000	7/16	1"	8"	6	1	5010780
9/16	0.5625	7/16	1.1/8	8"	6	1	5010782
5/8	0.6250	9/16	1.1/4	9"	6	1	5010784
3/4	0.7500	5/8	1.3/8	9.1/2	6	1	5010788
7/8	0.8750	3/4	1.1/2	10"	6	1	5010792
1"	1.0000	7/8	1.1/8	10.1/2	8	1	5010796
1.1/4	1.2500	1"	1.7/8	11.1/2	8	1	5010804
1.7/16	1.4375	1.1/4	2"	12"	10	1	5010807
1.3/4	1.7500	1.1/4	2.3/8	13.1/2	10	1	5010812

## Chucking Reamer, Straight Shank

### 4535

Slow Right Hand Spiral Flute, Right Hand Cut. Cuts with a smoother, chatter free action than straight flute reamers. Recommended for more difficult to ream materials, better surface finish requirements, applications with an interruption, and to aid in chip evacuation in blind holes.

Designed for accurate machine reaming using all types of equipment and incorporating all other design features of the straight flute style.

Produced per ASME B94.2-1995 standards.

4535



1/16 - 1"



$d_1$ Ø Inch	$d_1$ decimal Inch	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4535
1/16	0.0625	0.0585	1/2	2.1/2	4	1	5010054
5/64	0.0781	0.0720	3/4	3"	4	1	5010055
3/32	0.0938	0.0880	3/4	3"	4	1	5010056
7/64	0.1094	0.1030	7/8	3.1/2	4	1	5010057
1/8	0.1250	0.1190	7/8	3.1/2	4	1	5010058
5/32	0.1562	0.1510	1"	4"	6	1	5010060
11/64	0.1719	0.1645	1.1/8	4.1/2	6	1	5010061
3/16	0.1875	0.1800	1.1/8	4.1/2	6	1	5010062
13/64	0.2031	0.1945	1.1/4	5"	6	1	5010063
7/32	0.2188	0.2075	1.1/4	5"	6	1	5010064
1/4	0.2500	0.2400	1.1/2	6"	6	1	5010066
17/64	0.2656	0.2485	1.1/2	6"	6	1	5010067
9/32	0.2812	0.2485	1.1/2	6"	6	1	5010068
5/16	0.3125	0.2792	1.1/2	6"	6	1	5010070
11/32	0.3438	0.2792	1.1/2	6"	6	1	5010072
3/8	0.3750	0.3100	1.3/4	7"	6	1	5010074
25/64	0.3906	0.3100	1.3/4	7"	6	1	5010075
13/32	0.4062	0.3100	1.3/4	7"	6	1	5010076
7/16	0.4375	0.3730	1.3/4	7"	6	1	5010078
31/64	0.4844	0.4355	2"	8"	6	1	5010081
1/2	0.5000	0.4355	2"	8"	6	1	5010082
17/32	0.5312	0.4355	2"	8"	6	1	5010083
9/16	0.5625	0.4355	2"	8"	8	1	5010084
5/8	0.6250	0.5620	2.1/4	9"	8	1	5010086
11/16	0.6875	0.5620	2.1/4	9"	8	1	5010088
3/4	0.7500	0.6245	2.1/2	9.1/2	8	1	5010090
7/8	0.8750	0.7495	2.5/8	10"	8	1	5010094
1"	1.0000	0.8745	2.3/4	10.1/2	8	1	5010098

## Machine Reamer, Straight Shank

**B901** Left Hand Slow Spiral, Right Hand Cut. Steam Oxide in flutes reduces wear and chip welding in soft ferrous materials.



**B901**

**HSS-E**



**BS 328**



1.50mm - 1/2

$d_1$ Ø Inch	$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	# of Flutes	Pack Qty	<b>B901</b>
	1.50	44	21	4	1	0180808
1/16	1.59	44	21	4	1	0180815
	2.00	50	25	4	1	0180822
3/32	2.38	58	29	4	1	0180839
	2.50	58	29	4	1	0180846
	3.00	62	31	4	1	0180853
1/8	3.18	66	33	4	1	0180860
	3.50	71	35	4	1	0180877
5/32	3.97	76	38	6	1	0180891
	4.00	76	38	6	1	0180907
	4.50	81	41	6	1	0180921
3/16	4.76	87	44	6	1	0180938
	5.00	87	44	6	1	0180945
13/64	5.16	87	44	6	1	0180952
	5.50	93	47	6	1	0180969
7/32	5.56	93	47	6	1	0180976
15/64	5.95	93	47	6	1	0180983
	6.00	93	47	6	1	0180990
1/4	6.35	100	50	6	1	0181003
	7.00	107	54	6	1	0181010
9/32	7.14	107	54	6	1	0181027
5/16	7.94	115	58	6	1	0181034
	8.00	115	58	6	1	0181041
	9.00	124	62	6	1	0181065
3/8	9.52	133	66	6	1	0181072
	10.00	133	66	6	1	0181089
	11.00	142	71	6	1	0181102
7/16	11.11	142	71	6	1	0181119
	12.00	152	76	6	1	0181126
1/2	12.70	152	76	6	1	0181133

## Machine Reamer, Straight Shank

**B157** Left Hand Fast Sprial, Right Hand Cut.  
Designed for Stainless Steel, Titanium, and  
Nickel Alloy applications.

B157

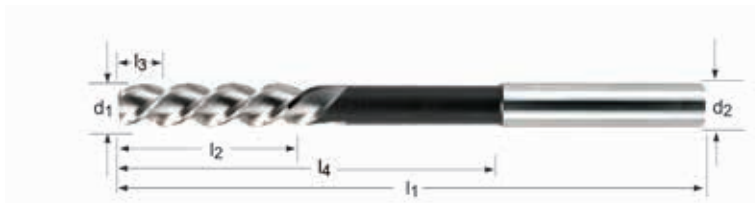
HSS-E



DIN  
212



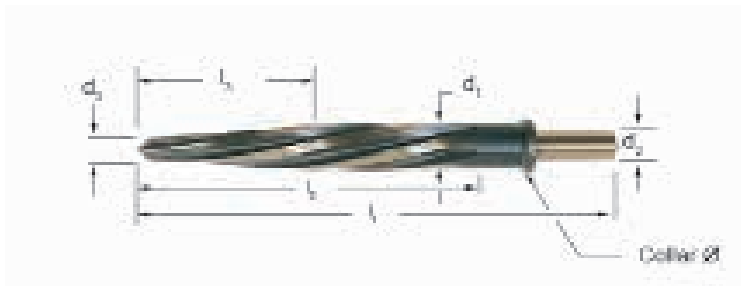
2.00 - 20.00



d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	l <sub>4</sub> mm	# of Flutes	d <sub>2</sub> Øh <sub>9</sub> mm	Pack Qty	B157
2.0	49	11	3.5	24	3	2.0	1	0049648
3.0	61	15	4.0	32	3	3.0	1	0122198
4.0	75	19	4.0	43	3	4.0	1	0049679
5.0	86	23	4.5	52	3	5.0	1	0049693
6.0	93	26	6.0	57	3	5.6	1	0049716
7.0	109	31	7.0	69	3	7.1	1	0049730
8.0	117	33	9.0	75	3	8.0	1	0049747
9.0	125	36	9.5	81	3	9.0	1	0049754
10.0	133	38	10.0	87	3	10.0	1	0049617
11.0	142	41	10.5	96	3	10.0	1	0049624
12.0	151	44	11.0	105	3	10.0	1	0049631
13.0	151	44	11.5	105	3	10.0	1	0140352
14.0	160	47	12.0	110	3	12.5	1	0140369
15.0	162	50	12.5	112	3	12.5	1	0140376
16.0	170	52	13.0	120	3	12.5	1	0140383
17.0	175	54	13.5	123	3	14.0	1	0140390
18.0	182	56	14.0	130	3	14.0	1	0140406
19.0	189	58	14.5	131	3	16.0	1	0140413
20.0	195	60	15.0	137	3	16.0	1	0140420

## Car Reamer (Alignment Reamer), Reduced Shank

**B122** Left Hand Helical Flute, Right Hand Cut. 1/2" Reduced Shank with Tri-Flats. Combination Bronze and Steam Oxide in flutes reduces wear and chip welding in harder ferrous materials. Used to align or enlarge holes.



Note: Collar diameter =  $d_1 + 1/8"$   
 Collar thickness =  $3/16"$   
 Shank Length =  $1.1/2"$

**B122**

HSS

ST Bronze

ANSI

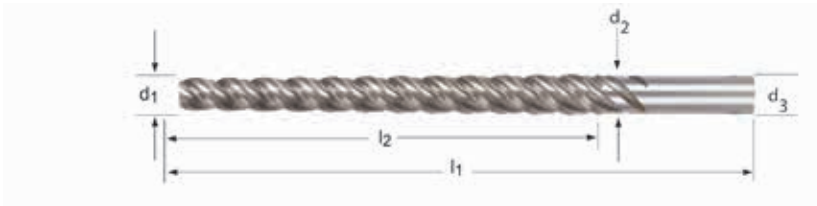
3/8 - 1.1/16

$d_1$ Ø Inch	$d_1$ decimal Inch	$l_1$ Inch	$l_2$ Inch	$l_3$ Inch	# of Flutes	$d_2$ Ø Inch	$d_3$ Ø Inch	Pack Qty	<b>B122</b>
3/8	0.3750	5.1/4	3.1/16	2	5	3/8	7/32	1	0426296
1/2	0.5000	5.5/16	3.3/4	2.5/8	5	1/2	1/4	1	0252376
9/16	0.5625	6.9/16	4.5/16	3.3/16	5	1/2	5/16	1	0252437
5/8	0.6250	6.9/16	4.5/16	3.3/16	5	1/2	3/8	1	0252413
11/16	0.6875	7	4.13/16	3.9/16	5	1/2	7/16	1	0252369
3/4	0.7500	7	4.13/16	3.9/16	5	1/2	1/2	1	0252406
13/16	0.8125	7.1/4	5.1/8	3.7/8	5	1/2	9/16	1	0252383
7/8	0.8750	7.1/4	5.1/8	3.7/8	5	1/2	5/8	1	0252420
15/16	0.9375	7.1/4	5.1/8	3.7/8	5	1/2	11/16	1	0252390
1"	1.0000	7.1/4	5.1/8	3.7/8	5	1/2	3/4	1	0252345
1.1/16	1.0625	7.1/4	5.1/4	3.7/8	5	1/2	13/16	1	0252352

# HSS REAMER

## Machine Reamer, Taper Pin Type, Straight Shank

**4588** Left hand high spiral. Right hand cut taper pin (1/4" per foot). Designed to convert a straight hole into a tapered hole into which standard taper pins (ASA B5.20-1958) will fit. Ideal geometry for the machine reaming of pin holes on a production basis. Helical construction prevents chips from packing in flutes and reduces breakage.



4588

HSS



ANSI



1:48



7/0 - 10

nom Ø	d <sub>1</sub> Ø Inch	d <sub>2</sub> Ø Inch	d <sub>3</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4588
7/0	0.0497	0.0666	5/64	13/16	1.13/16	2	1	5011157
6/0	0.0611	0.0810	3/32	15/16	1.15/16	2	1	5011158
5/0	0.0719	0.0966	7/64	1.3/16	2.3/16	2	1	5011159
4/0	0.0869	0.1142	1/8	1.5/16	2.5/16	2	1	5011160
3/0	0.1029	0.1300	9/64	1.5/16	5.5/16	2	1	5011161
2/0	0.1137	0.1462	5/32	1.9/16	2.9/16	3	1	5011162
1	0.1447	0.1798	3/16	1.11/16	2.15/16	3	1	5011164
2	0.1600	0.2010	13/64	1.15/16	3.3/16	3	1	5011165
3	0.1813	0.2294	15/64	2.5/16	3.11/16	3	1	5011166
4	0.2071	0.2600	17/64	2.9/16	4.1/16	3	1	5011167
5	0.2410	0.2994	5/16	2.13/16	4.5/16	3	1	5011168
6	0.2773	0.3540	23/64	3.11/16	5.7/16	3	1	5011169
7	0.3297	0.4220	13/32	4.7/16	6.5/16	3	1	5011170
8	0.3971	0.5050	7/16	5.3/16	7.3/16	3	1	5011171
9	0.4800	0.6066	9/16	6.1/16	8.5/16	4	1	5011172
10	0.5799	0.7216	5/8	6.13/16	9.5/16	4	1	5011173

Note: Nom Ø is the Taper Pin number  
Per American Standard Taper Pin Specification ( ASA B5.20-1958)

## Chucking Reamer, Taper Shank

**4536** Straight flute, right hand cut. Chucking reamers have shorter and deeper flutes than hand reamers and are specifically designed for accurate machine reaming in most materials and equipment.

**4537** Right hand spiral flute, right hand cut. Cuts with a smoother action than a straight flute reamer. Recommended for more difficult to ream materials, better surface finish requirements, applications with an interruption, and to aid in chip removal in blind holes.

Produced per ASME B94.2-1995 standards.



$d_1$ Ø Inch	$d_1$ decimal Inch	MTS	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4536	4537
1/4	0.2500	1	1.1/2	6"	6	1	5010734	—
9/32	0.2813	1	1.1/2	6"	6	1	5010735	—
5/16	0.3125	1	1.1/2	6"	6	1	5010736	5010142
11/32	0.3437	1	1.1/2	6"	6	1	5010737	—
3/8	0.3750	1	1.3/4	7"	6	1	5010738	5010144
13/32	0.4062	1	1.3/4	7"	6	1	5010739	—
7/16	0.4375	1	1.3/4	7"	6	1	5010740	—
1/2	0.5000	1	2"	8"	6	1	5010742	5010148
9/16	0.5625	1	2"	8"	8	1	5010744	—
5/8	0.6250	2	2.1/4	9"	8	1	5010746	5010152
11/16	0.6875	2	2.1/4	9"	8	1	5010748	—
3/4	0.7500	2	2.1/2	9.1/2	8	1	5010750	5010156
13/16	0.8125	2	2.1/2	9.1/2	8	1	5010752	5010158
7/8	0.8750	2	2.5/8	10"	8	1	5010754	5010160
15/16	0.9375	3	2.5/8	10"	8	1	5010756	—
1"	1.0000	3	2.3/4	10.1/2	8	1	5010758	5010164

# HSS REAMER

## Chucking Reamer, Expansion, Taper Shank

**4532**

Straight flute, right hand cut.

Expansion Chucking Reamers are an economical general purpose high production tool. The expansion feature permits the reamer to be resharpened many times while still retaining the original size.

Recommended for abrasive materials. As the diameter wears down, the reamers can be expanded many times by tightening the end adjusting screw and regrinding to it's original size.

Produced per ASME B94.2-1995 standards.



4532

HSS



ANSI



3/8 - 1.3/4"

$d_1$ Ø Inch	$d_1$ decimal Inch	MTS	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4532
3/8	0.3750	1	3/4	7"	6	1	5011206
1/2	0.5000	1	1"	8"	6	1	5010822
5/8	0.6250	2	1.1/4	9"	6	1	5010826
11/16	0.6875	2	1.1/4	9"	6	1	5010828
3/4	0.7500	2	1.3/8	9.1/2	6	1	5010830
7/8	0.8750	2	1.1/2	10"	6	1	5010834
1"	1.0000	3	1.5/8	10.1/2	8	1	5010838
1.1/8	1.1250	3	1.3/4	11"	8	1	5010842
1.1/4	1.2500	4	1.7/8	11.1/2	8	1	5010846
1.3/8	1.3750	4	2"	12"	8	1	5010848
1.1/2	1.5000	4	2.1/8	12.1/2	10	1	5010850
1.5/8	1.6250	4	2.1/4	13"	10	1	5010852
1.3/4	1.7500	5	2.3/8	13.1/2	10	1	5010854



## Machine Reamer, Taper Shank

**B101** Left hand slow spiral, right hand. Steam oxide in flutes reduces wear chip welding harder ferrous materials.



B101

HSS-E



BS 328



3.00mm - 2"

Note: All sizes have 1mm x 45 chamfer (lead).  
Cutting diameters are produced to H7 tolerance

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	# of Flutes	MTS	Pack Qty	B101
	3.00	112	33	4	1	1	0181560
1/8	3.18	112	33	4	1	1	0181140
	3.50	115	35	6	1	1	0181577
	4.00	117	38	6	1	1	0181584
3/16	4.50	120	41	6	1	1	0181591
	4.76	124	44	6	1	1	0181164
	5.00	124	44	6	1	1	0181607
	5.50	127	47	6	1	1	0181614
	6.00	127	47	6	1	1	0181621
1/4	6.35	130	50	6	1	1	0181188
	6.50	130	50	6	1	1	0181638
	7.00	134	54	6	1	1	0181645
5/16	7.94	138	58	6	1	1	0181201
	8.00	138	58	6	1	1	0181669
	8.50	138	58	6	1	1	0181676
	9.00	142	62	6	1	1	0181683
	9.50	142	62	6	1	1	0181690
3/8	9.52	146	66	6	1	1	0181225
	10.00	146	66	6	1	1	0181706
	10.50	146	66	6	1	1	0181713
	11.00	151	71	6	1	1	0181720
7/16	11.11	151	71	6	1	1	0181249
	12.00	156	76	6	1	1	0181744
	12.50	156	76	6	1	1	0181751
1/2	12.70	156	76	6	1	1	0181263
	13.00	156	76	6	1	1	0181768
	13.50	161	81	6	1	1	0181775
	14.00	161	81	8	1	1	0181782
	14.29	181	81	8	2	1	0181287
9/16	14.50	181	81	8	2	1	0181799
	15.00	181	81	8	2	1	0181805
	15.50	187	87	8	2	1	0181812
	15.88	187	87	8	2	1	0181300

# HSS REAMER



d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	# of Flutes	MTS	Pack Qty	B101
	16.00	187	87	8	2	1	0181829
	16.50	187	87	8	2	1	0181836
	17.00	187	87	8	2	1	0181843
	18.00	193	93	8	2	1	0181850
	19.00	193	93	8	2	1	0181867
3/4	19.05	200	100	8	2	1	0181348
	20.00	200	100	8	2	1	0181874
13/16	20.64	200	100	8	2	1	0181362
	21.00	200	100	8	2	1	0181881
	22.00	207	107	8	2	1	0181898
7/8	22.22	207	107	8	2	1	0181386
	23.00	207	107	8	2	1	0181904
	24.00	242	115	8	3	1	0181911
	25.00	242	115	10	3	1	0181928
1"	25.40	242	115	10	3	1	0181423
	26.00	242	115	10	3	1	0181935
	27.00	251	124	10	3	1	0181942
	28.00	251	124	10	3	1	0181959
1.1/8	28.58	251	124	10	3	1	0181447
	29.00	251	124	10	3	1	0181966
	30.00	251	124	10	3	1	0181973
	31.00	260	133	10	3	1	0181980
1.1/4	31.75	260	133	10	3	1	0181461
	32.00	293	133	10	4	1	0181997
	34.00	302	142	10	4	1	0182017
1.3/8	34.93	302	142	10	4	1	0181485
	35.00	302	142	10	4	1	0182024
	36.00	302	142	10	4	1	0182031
	37.00	302	142	10	4	1	0182048
	38.00	312	152	10	4	1	0182055
1.1/2	38.10	312	152	10	4	1	0181508
	39.00	312	152	10	4	1	0182062
	40.00	312	152	10	4	1	0182079
	41.00	312	152	10	4	1	0182086
	42.00	312	152	10	4	1	0182093
	43.00	323	163	10	4	1	0182109
	44.00	323	163	10	4	1	0182116
1.3/4	44.45	323	163	10	4	1	0181522
	45.00	323	163	12	4	1	0182123
	46.00	323	163	12	4	1	0182130
	47.00	323	163	12	4	1	0182147
	48.00	334	174	12	4	1	0182154
	50.00	334	174	12	4	1	0182178
2"	50.80	334	174	12	4	1	0181546

## Bridge Reamer, Taper Shank

**B121** Left hand fast spiral, right hand cut tapered bridge reamer. Used in structural iron and steel applications for badly misaligned holes. The  $l_3$  length has a 1:10 starting taper.



B121

HSS



DIN 311



10.00 - 30.00

$d_1$ Ø	$l_1$	$l_2$	$l_3$	# of Flutes	MTS	Pack Qty	B121
10.0	171	95	30	4	1	1	0049020
11.0	176	100	33	4	1	1	0049037
12.0	199	105	39	4	2	1	0049044
13.0	199	105	39	4	2	1	0049051
14.0	209	115	42	4	2	1	0049068
15.0	219	125	45	4	2	1	0049075
16.0	229	135	48	4	2	1	0049082
17.0	251	135	51	4	3	1	0049099
18.0	261	145	58	4	3	1	0049105
19.0	261	145	58	4	3	1	0049112
20.0	271	155	62	4	3	1	0049129
21.0	271	155	62	4	3	1	0049136
22.0	281	165	66	4	3	1	0049143
23.0	281	165	66	4	3	1	0049150
24.0	296	180	72	4	3	1	0049167
25.0	296	180	72	4	3	1	0049174
26.0	296	180	72	4	3	1	0049181
30.0	311	195	78	5	3	1	0049211

# HSS REAMER

## Bridge Reamer, Taper Shank

**4579** Left hand slow spiral, right hand cut tapered bridge reamer. Used in structural iron and steel applications for badly misaligned holes.

Produced per ASME B94.2-1995 standards.



4579

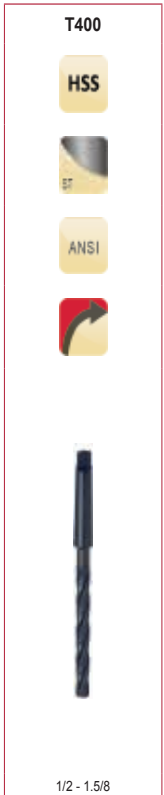


7/16 - 1.1/16

nom Ø	$d_1$ Ø (min)	$d_2$ Ø (max)	MTS	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4579
7/16	1/4	7/16	2	4.3/8	8.1/4	4	1	5011055
1/2	9/32	1/2	2	5.1/8	9"	4	1	5011056
9/16	11/32	9/16	2	5.1/8	9"	4	1	5011057
5/8	3/8	5/8	2	6.1/8	10"	4	1	5011058
11/16	25/64	11/16	3	7.1/8	11.3/4	4	1	5011059
3/4	7/16	3/4	3	7.3/8	12"	4	1	5011060
13/16	1/2	13/16	3	7.3/8	12"	4	1	5011061
7/8	9/16	7/8	3	7.3/8	12"	4	1	5011062
15/16	5/8	15/16	3	7.3/8	12"	4	1	5011063
1"	11/16	1"	3	7.3/8	12"	4	1	5011064
1.1/16	3/4	1.1/16	3	7.3/8	12"	4	1	5011065

## Taper Shank - 4-Flute

**T400** Core drill with taper shank for enlarging pre-drilled or cast holes in a wide range of materials.



$d_1$ Ø	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	MTS	Pack Qty	T400
1/2	0.5000	4.3/8	8.1/4	2	1	024532
17/32	0.5312	4.5/8	8.1/2	2	1	024534
9/16	0.5625	4.7/8	8.3/4	2	1	024536
5/8	0.6250	4.7/8	8.3/4	2	1	024540
21/32	0.6562	5.1/8	9"	2	1	024542
3/4	0.7500	5.7/8	9.3/4	2	1	024548
25/32	0.7812	6"	9.7/8	2	1	024550
7/8	0.8750	6.1/8	10.3/4	3	1	024556
1"	1.0000	6.3/8	11"	3	1	024600
1.1/32	1.0312	6.1/2	11.1/8	3	1	024602
1.1/16	1.0625	6.5/8	11.1/4	3	1	024604
1.1/8	1.1250	7.1/8	12.3/4	4	1	024608
1.5/32	1.1562	7.1/4	12.7/8	4	1	024610
1.1/4	1.2500	7.7/8	13.1/2	4	1	024616
1.5/16	1.3125	8.5/8	14.1/4	4	1	024620
1.11/32	1.3438	8.3/4	14.3/8	4	1	024622
1.3/8	1.3750	8.7/8	14.1/2	4	1	024624
1.1/2	1.5000	9.3/8	15"	4	1	024632
1.9/16	1.5625	9.5/8	16.5/8	5	1	024636
1.5/8	1.6250	10"	17"	5	1	024640

# HSS REAMER

## Hand Reamer, Square Drive

**4500** Straight flute hand reamer with square drive, right hand cut. Widely used by hand for the final sizing of drilled holes. The square on the shank allows it to be held in either a tap wrench or a vise depending on whether it is the reamer or the part that is rotating. A long starting taper allows for ease of entry and accurate alignment. The straight flute style is recommended for most general purpose hand reaming applications.

4500

HSS



ANSI



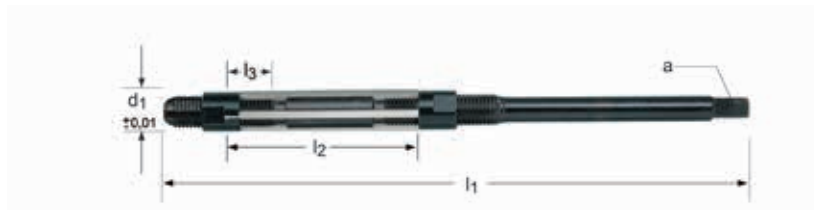
1/8 - 1"



$d_1$ Ø Inch	$d_1$ decimal Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4500
1/8	0.1250	1.1/2	3"	4	1	5010928
3/16	0.1875	1.3/4	3.1/2	6	1	5010930
1/4	0.2500	2"	4"	6	1	5010932
5/16	0.3125	2.1/4	4.1/2	6	1	5010934
3/8	0.3750	2.1/2	5"	6	1	5010936
7/16	0.4375	2.3/4	5.1/2	6	1	5010938
1/2	0.5000	3"	6"	6	1	5010940
9/16	0.5625	3.1/4	6.1/2	8	1	5010942
5/8	0.6250	3.1/2	7"	8	1	5010944
3/4	0.7500	4.3/16	8.3/8	8	1	5010948
7/8	0.8750	4.7/8	9.3/4	8	1	5010950
1"	1.0000	5.7/16	10.7/8	8	1	5010952

## Adjustable Hand Reamer, Replaceable Blade Type

**B334** For light duty sizing of uninterrupted holes.



B334

HSS



N000 - N16

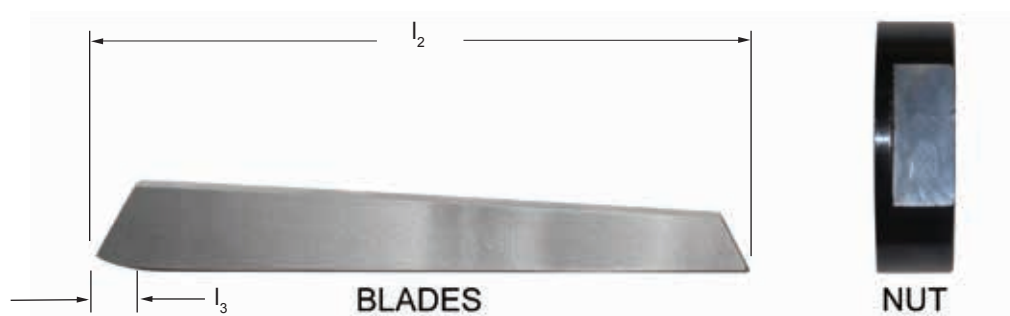
Nr.	d min-max mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	# of Flutes	∇ a mm	Pack Qty	B334
000	6.4 - 7.2	110	32	7	4	3.0	1	0052174
00	7.2 - 8.0	110	32	7	4	3.4	1	0052167
0	8.0 - 9.0	115	34	9	5	3.8	1	0052150
1	9.0 - 10.0	115	34	9	5	4.3	1	0052181
2	10.0 - 11.0	115	34	9	5	4.9	1	0052228
3	11.0 - 12.0	125	35	9	5	4.9	1	0052235
4	12.0 - 13.5	135	41	9	5	6.2	1	0052242
5	13.5 - 15.5	146	50	12	5	7.0	1	0052259
6	15.5 - 18.0	166	60	12	5	8.0	1	0052266
7	18.0 - 21.0	178	65	15	5	9.0	1	0052273
8	21.0 - 24.0	195	76	15	5	11.0	1	0052280
9	24.0 - 27.5	218	82	18	5	12.0	1	0052297
10	27.5 - 31.5	245	86	18	5	14.5	1	0052198
11	31.5 - 37.0	280	98	18	6	18.0	1	0052204
12	37.0 - 45.0	325	108	20	6	20.0	1	0052211
13	45.0 - 55.0	370	118	20	6	26.0	1	0140819
14	55.0 - 67.0	400	125	20	6	32.0	1	0140826
15	67.0 - 80.0	435	140	23	8	39.0	1	0140833
16	80.0 - 95.0	475	155	23	8	49.0	1	0140840

# HSS REAMER



## Adjustable Hand Reamer, Replaceable Blade Type

**B335** Replace blades & nuts for use with B334



B335



N000 BLADES -  
N16 NUTS

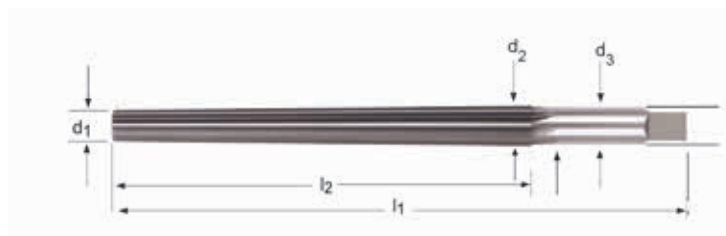
Nr.	$l_2$ mm	$l_3$ mm	Nuts Pack Qty	B335 Nuts	Blades Pack Qty	B335 Blades
000	32	7	1	0144640	4	0052327
00	32	7	1	0144633	4	0052310
0	34	9	1	0144626	5	0052303
1	34	9	1	0144657	5	0052334
2	34	9	1	0144664	5	0052372
3	35	9	1	0144671	5	0052389
4	41	9	1	0144688	5	0052396
5	50	12	1	0144695	5	0052402
6	60	12	1	0144701	5	0052419
7	65	15	1	0144718	5	0052426
8	76	15	1	0144725	5	0052433
9	82	18	1	0144732	5	0052440
10	86	18	1	0144749	5	0052341
11	98	18	1	0144756	6	0052358
12	108	20	1	0144763	6	0052365
13	118	20	1	0144770	6	0144589
14	125	20	1	0144787	6	0144596
15	140	23	1	0144794	8	0144602
16	155	23	1	0144800	8	0144619



## Hand Reamer, Taper Pin Type, Square Drive

**4587** Straight flute taper pin (1/4" per foot), right hand cut. Designed to convert a straight hole into a tapered hole into which standard taper pins (ASA B5.20-1958) will fit. The square on the shank is suitable for holding a tap wrench or vise, depending on whether the reamer or part is rotating, making them ideal for hand use. Recommended for most materials.

Produced per ASME B94.2-1995 standards.



4587

HSS

ANSI

1:48

N0 - N10

nom Ø	$d_1$ Ø Inch	$d_2$ Ø Inch	$d_3$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	4587
0	0.1287	0.1638	11/64	1.11/16	2.15/16	6	1	5011129
1	0.1447	0.1798	3/16	1.11/16	2.15/16	6	1	5011130
2	0.1600	0.2010	13/64	1.15/16	3.3/16	6	1	5011131
3	0.1813	0.2294	15/64	2.5/16	3.11/16	6	1	5011132
4	0.2071	0.2600	17/64	2.9/16	4.1/16	6	1	5011133
5	0.2410	0.2994	5/16	2.13/16	4.5/16	6	1	5011134
6	0.2773	0.3540	23/64	3.11/16	5.7/16	6	1	5011135
7	0.3297	0.4220	13/32	4.7/16	6.5/16	6	1	5011136
8	0.3971	0.5050	7/16	5.3/16	7.3/16	6	1	5011137
9	0.4800	0.6066	9/16	6.1/16	8.5/16	8	1	5011138
10	0.5799	0.7216	5/8	6.13/16	9.5/16	8	1	5011139

Note: Nom Ø is the Taper Pin number  
Per American Standard Taper Pin Specification ( ASA B5.20-1958)

# HSS REAMER

## Hand Reamer, Taper Pin, Square Drive

**4591** Left hand slow spiral flute, right hand cut taper pin (1/4" per foot) hand reamer with square drive.  
 Designed to convert a straight hole into a tapered hole into which standard taper pins (ASA B5.20-1958) will fit. The square on the shank is suitable for holding a tap wrench or vise, depending on whether the reamer or part is rotating, making them ideal for hand use.  
 Recommended for most materials.

Produced per ASME B94.2-1995 standards.



4591

HSS



ANSI



1:48



N0 - N10

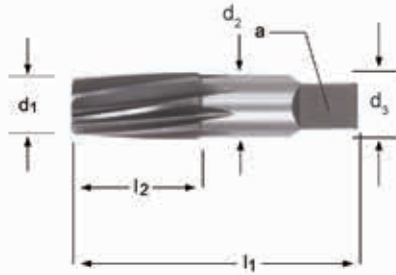
nom Ø	d <sub>1</sub> Ø Inch	d <sub>2</sub> Ø Inch	d <sub>3</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4591
0	0.1287	0.1638	11/64	1.11/16	2.15/16	6	1	5011146
1	0.1447	0.1798	3/16	1.11/16	2.15/16	6	1	5011147
2	0.1600	0.2010	13/64	1.15/16	3.3/16	6	1	5011148
3	0.1813	0.2294	15/64	2.5/16	3.11/16	6	1	5011149
4	0.2071	0.2600	17/64	2.9/16	4.1/16	6	1	5011150
5	0.2410	0.2994	5/16	2.13/16	4.5/16	6	1	5011151
6	0.2773	0.3540	23/64	3.11/16	5.7/16	6	1	5011152
7	0.3297	0.4220	13/32	4.7/16	6.5/16	6	1	5011153
8	0.3971	0.5050	7/16	5.3/16	7.3/16	6	1	5011154
9	0.4800	0.6066	9/16	6.1/16	8.5/16	8	1	5011155
10	0.5799	0.7216	5/8	6.13/16	9.5/16	8	1	5011156

Note: Nom Ø is the Taper Pin number  
 Per American Standard Taper Pin Specification ( ASA B5.20-1958)

## Hand Reamer, Taper Pipe Type, Square Drive

**4600** Left hand spiral flute, right hand cut taper (3/4" per foot) taper pipe reamer. Intended for reaming holes to be tapped with American Standard taper pipe taps. Generally used by hand with a tap wrench.

Produced per ASME B94.2-1995 standards.



4600

HSS



ANSI



1/8 - 1"

nom Ø	d <sub>1</sub> Ø Inch	d <sub>2</sub> Ø Inch	d <sub>3</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	□ a mm	# of Flutes	Pack Qty	4600
1/8	0.3160	0.3620	0.4375	3/4	2.1/8	0.3280	6	1	1810007
1/4	0.4060	0.4720	0.5625	1.1/16	2.7/16	0.4210	6	1	1810008
3/8	0.5400	0.6060	0.7000	1.1/16	2.9/16	0.5310	8	1	1810009
1/2	0.6650	0.7510	0.6875	1.3/8	3.1/8	0.5150	8	1	1810010
3/4	0.8760	0.9620	0.9063	1.3/8	3.1/4	0.6790	10	1	1810011
1"	1.1030	1.2120	1.1250	1.3/4	3.3/4	0.8430	10	1	1810012

Note: Nom Ø (column 1) is the NPT pipe thread size.  
This is not the tool diameter.

## Hand Reamer, Square Drive

### B100

Left hand spiral flute, right hand cut.

Widely used by hand for the final sizing of drilled holes. The square on the shank allows it to be held in either a tap wrench or a vise depending on whether it is the reamer or the part that is rotating. A long starting taper allows for ease of entry and accurate alignment.



Produced per DIN206 Form B.

Cutting diameters are produced to H7 tolerance.

Shank diameters (same as cutting diameters) but produced to e9 tolerance.

B100



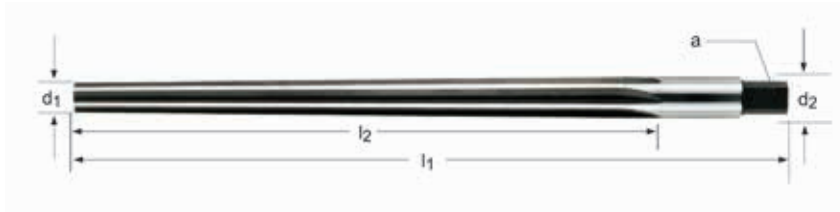
1.50 - 50.00

$d_1$ Ø Inch	$d_1$ Ø mm	$l_1$ mm	$l_2$ mm	$l_3$ mm	# of Flutes	□ a mm	Pack Qty	B100
	1.50	41	20	5	3	1.12	1	0179987
1/16	1.59	41	20	5	3	1.12	1	0179598
	1.60	44	21	5	3	1.25	1	0179994
5/64	1.98	47	23	6	4	1.40	1	0179604
	2.00	50	25	6	4	1.60	1	0048610
3/32	2.38	54	27	7	4	1.80	1	0179611
	2.50	58	29	7	4	2.10	1	0048634
7/64	2.78	62	31	8	6	2.10	1	0179628
	3.00	62	31	8	6	2.40	1	0048719
1/8	3.18	66	33	8	6	2.40	1	0179635
	3.20	66	33	8	6	2.40	1	0048726
	3.50	71	35	9	6	2.70	1	0048733
9/64	3.57	71	35	9	6	2.70	1	0179642
5/32	3.97	76	38	10	6	3.00	1	0179659
	4.00	76	38	10	6	3.00	1	0048801
11/64	4.37	81	41	10	6	3.40	1	0179666
	4.50	81	41	10	6	3.40	1	0048818
3/16	4.76	87	44	11	6	3.80	1	0179673
	5.00	87	44	11	6	3.80	1	0048887
13/64	5.16	87	44	11	6	3.80	1	0179680
	5.50	93	47	12	6	4.30	1	0048894
7/32	5.56	93	47	12	6	4.30	1	0179697
15/64	5.95	93	47	12	6	4.90	1	0179703
	6.00	93	47	12	6	4.90	1	0048917
1/4	6.35	100	50	13	6	4.90	1	0179710
	6.50	100	50	13	6	4.90	1	0140314
17/64	6.75	107	54	14	6	5.50	1	0179727
	7.00	107	54	14	6	5.50	1	0048924
9/32	7.14	107	54	14	6	6.20	1	0179734
	7.50	107	54	14	6	6.20	1	0140321
19/64	7.54	115	58	15	6	6.20	1	0179741
5/16	7.94	115	58	15	6	6.20	1	0179758
	8.00	115	58	15	6	6.20	1	0048931

d <sub>1</sub> Ø Inch	d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	# of Flutes	□ a mm	Pack Qty	B100
21/64	8.33	115	58	15	6	7.00	1	0179765
	8.50	115	58	15	6	7.00	1	0140338
11/32	8.73	124	62	16	6	7.00	1	0179772
	9.00	124	62	16	6	7.00	1	0048948
23/64	9.13	124	62	16	6	8.00	1	0179789
	9.50	124	62	16	6	8.00	1	0140345
3/8	9.52	124	62	17	6	8.00	1	0179796
25/64	9.92	133	66	17	6	8.00	1	0179802
	10.00	133	66	17	6	8.00	1	0048511
13/32	10.32	133	66	17	6	8.00	1	0179819
	10.50	133	66	17	6	8.00	1	0180006
7/16	11.00	142	71	18	6	9.00	1	0048528
	11.11	142	71	18	6	9.00	1	0179826
	11.50	142	71	18	6	9.00	1	0180013
	12.00	152	76	19	6	9.00	1	0048535
	12.50	152	76	19	6	10.00	1	0180020
1/2	12.70	152	76	19	6	10.00	1	0179840
	13.00	152	76	19	6	10.00	1	0048542
17/32	13.49	163	81	20	8	11.00	1	0179857
	13.50	163	81	20	8	11.00	1	0180037
	14.00	163	81	20	8	11.00	1	0048559
9/16	14.29	163	81	20	8	11.00	1	0179864
	14.50	163	81	20	8	11.00	1	0180044
	15.00	163	81	20	8	12.00	1	0048566
19/32	15.08	163	81	22	8	12.00	1	0179871
5/8	15.88	175	87	22	8	12.00	1	0179888
	16.00	175	87	22	8	12.00	1	0048573
	17.00	175	87	22	8	13.00	1	0048580
11/16	17.46	188	93	23	8	14.50	1	0179895
	18.00	188	93	23	8	14.50	1	0048597
	19.00	188	93	23	8	14.50	1	0048603
3/4	19.05	188	93	25	8	14.50	1	0179901
	20.00	201	100	25	8	16.00	1	0048658
13/16	20.64	201	100	25	8	16.00	1	0179925
	21.00	201	100	25	8	16.00	1	0180051
	22.00	215	107	27	8	18.00	1	0048665
7/8	22.22	215	107	27	8	18.00	1	0179949
	23.00	215	107	27	8	18.00	1	0180068
	24.00	231	115	29	8	18.00	1	0048672
	25.00	231	115	29	8	20.00	1	0048689
1"	25.40	231	115	29	8	20.00	1	0179970
	26.00	231	115	29	8	20.00	1	0048696
	27.00	247	124	31	10	22.00	1	0180075
	28.00	247	124	31	10	22.00	1	0048702
	29.00	247	124	31	10	22.00	1	0180082
	30.00	247	124	31	10	24.00	1	0048740
	31.00	265	133	33	10	24.00	1	0180099
	32.00	265	133	33	10	24.00	1	0048757
	33.00	265	133	33	10	26.00	1	0180105
	34.00	284	142	36	10	26.00	1	0048764
	35.00	284	142	36	10	29.00	1	0048771
	36.00	284	142	36	10	29.00	1	0048788
	37.00	284	142	36	10	29.00	1	0180112
	38.00	305	152	38	10	29.00	1	0048795
	39.00	305	152	38	10	32.00	1	0180129
40.00	305	152	38	10	32.00	1	0048825	
45.00	326	163	41	12	35.00	1	0048856	
50.00	347	174	44	12	39.00	1	0048900	

## Hand Reamer, Taper Pin Type, Square Drive

**B301** Straight flute taper pin (1/4" per foot), straight shank reamer. Designed to convert a straight hole into a tapered hole into which standard taper pins will fit. The square on the shank is suitable for holding a tap wrench or vise, depending on whether the reamer or part is rotating, making them ideal for hand use. Recommended for most materials.



1/16 - 1/2

nom Ø	d <sub>1</sub> Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	# of Flutes	☐ a mm	d <sub>2</sub> Ø mm	Pack Qty	B301
1/16	1.10	51	25	4	1.2	1.63	1	0182277 <sup>1)</sup>
5/64	1.50	51	25	4	1.6	2.03	1	0182284 <sup>1)</sup>
3/32	1.75	57	32	4	2.0	2.41	1	0182291 <sup>1)</sup>
7/64	2.03	64	38	4	2.2	2.82	1	0182307 <sup>1)</sup>
1/8	2.30	70	44	4	2.5	3.23	1	0182314 <sup>1)</sup>
9/64	2.64	73	48	4	2.8	3.63	1	0182321 <sup>1)</sup>
5/32	2.95	76	51	4	3.1	4.01	1	0182338 <sup>1)</sup>
11/64	3.23	89	57	4	3.6	4.42	1	0182345 <sup>1)</sup>
3/16	3.50	102	70	4	4.0	4.95	1	0182352 <sup>1)</sup>
7/32	4.13	102	70	6	4.5	5.59	1	0182369 <sup>1)</sup>
1/4	4.64	117	86	6	5.0	6.43	1	0182376 <sup>2)</sup>
9/32	5.23	143	105	6	5.6	7.42	1	0182383 <sup>2)</sup>
5/16	5.84	143	105	6	6.3	8.03	1	0182390 <sup>2)</sup>
11/32	6.43	152	114	6	7.1	8.81	1	0182406 <sup>2)</sup>
3/8	7.03	165	127	6	8.0	9.68	1	0182413 <sup>2)</sup>
13/32	7.42	191	146	6	8.0	10.46	1	0182420 <sup>2)</sup>
7/16	8.21	191	146	6	9.0	11.25	1	0182437 <sup>2)</sup>
1/2	9.41	210	165	6	10.0	12.85	1	0182444 <sup>2)</sup>

<sup>1)</sup> Limit of tolerance +0.0030

<sup>2)</sup> Limit of tolerance +0.0050

# Visual Index - Countersinks & Counterbores



# Visual Index - Countersinks & Counterbores

Alpha Code	Countersinks, Counterbores - Feed in Inches per Revolution										Ø Diameter
	1/4	5/16	5/64	5/8	25/32	1"	1-1/4	1-1/2	2-3/8	3"	
A	0.001	0.002	0.002	0.002	0.003	0.004	0.004	0.005	0.006	0.006	
B	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.006	0.007	0.008	
C	0.002	0.002	0.003	0.004	0.005	0.006	0.006	0.007	0.008	0.009	
D	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.009	0.010	0.011	
E	0.003	0.004	0.005	0.006	0.007	0.008	0.010	0.011	0.012	0.013	
F	0.004	0.004	0.005	0.006	0.007	0.008	0.010	0.011	0.013	0.014	
G	0.004	0.005	0.006	0.007	0.008	0.009	0.011	0.013	0.014	0.016	
H	0.005	0.006	0.007	0.008	0.009	0.010	0.012	0.014	0.016	0.018	

Application Material Groups (AMG)			Hardness HRC	ISO
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	S 1
	4.2 Titanium, alloyed	6Al4V, 6Al4V-2Sn, Monel, Monel K	<28	S 2
	4.3 Titanium, alloyed	6Al4V-4Mo, 7Al4V-4Mo, 4911-4967	>28<38	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	N 3
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	N 4
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultrad, Polystrol	---	O
	8.2 Thermosetting plastics	Bakelit, Pertinax	---	O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	H
10. Graphite	10.1 Standard graphite		---	O



# Visual Index - Countersinks & Counterbores

Tool Material:	HM	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	HSS	HSS	HSS-E	HSS
Finish/Coating:						TN				TAN		ATCN	TAN
Standard:	DIN 335C	ANSI	ANSI	ANSI	DIN 334C	DIN 334C	DIN 335C	DORAM	DIN 335C	DIN 335C	DIN 335C	DIN 335C	DIN 335C
Direction of Cut:													
Application:													
Shank:													
Countersink Angle:	90°	60°	60°	60°	60°	60°	82°	90°	90°	90°	90°	90°	100°
		↓	↓	↓									
		90°	100°	82°									
Style:	G400	4603	4608	4602	G135	G335	G154	G149	G136	G560	G142	G570	G171
Range:	6.30 - 31.00	1/4 - 1.1/2	1/4 - 1"	1/2 - 1"	6.30 - 25.00	6.30 - 25.00	6.30 - 25.00	5.00 - 50.00	4.30 - 31.00	6.30 - 31.00	4.80 - 31.00	6.30 - 31.00	6.30 - 25.00
Page #	476	477	478	479	480	480	481	482	483	483	484	485	486
1.1	98F	98F	98F	98F	98F	164E	98F	98D	98F	164E	98F	148E	164E
1.2	82E	82E	82E	82E	82E	131E	82E	82D	82E	131E	82E	118E	131E
1.3	66D	66D	66D	66D	66D	98D	66D	66C	66D	98D	66D	89D	98D
1.4	49D	49D	49D	49D	49D	66D	49D	49B	49D	66D	49D	72D	66D
1.5	33B	33B	33B	33B	33B	49B	33B	33A	33B	49B	33B	56B	49B
1.6	20A	20A	20A	20A	20A	33B	20A	20A	20A	33B		39B	33B
1.7													
1.8													
2.1	26C	26C	26C	26C	26C		26C	26B	26C		26C	56C	
2.2	20B	20B	20B	20B	20B		20B	20A	20B		20B	39B	
2.3	13A	13A	13A	13A	13A		13A		13A		13A	49A	
2.4												33A	
3.1	82F	82F	82F	82F	82F	148F	82F	82D	82F	148F		131C	148F
3.2	49D	49D	49D	49D	49D	115D	49D	49C	49D	115D		105C	115D
3.3	39C	39C	39C	39C	39C	98C	39C	39A	39C	98C		89C	98C
3.4	26C	26C	26C	26C	26C	98C	26C	26A	26C	98C		79C	98C
4.1	39C	39C	39C	39C	39C	66C	39C	39B	39C	66C	39C		66C
4.2	33A	33A	33A	33A	33A	49A	33A	33A	33A	49A	33A		49A
4.3	26A	26A	26A	26A	26A	33A	26A	26A	26A	33A			33A
5.1	39C	39C	39C	39C	39C	66C	39C	39B	39C	66C	39C		66C
5.2	20B	20B	20B	20B	20B	33B	20B	20A	20B	33B	20B	20A	33B
5.3	13A	13A	13A	13A	13A	20A	13A	13A	13A	20A		13A	20A
6.1	82D	82D	82D	82D	82D	131D	82D	82B	82D	131D	82D	131D	131D
6.2	66F	66F	66F	66F	66F	98F	66F	66C	66F	98F	66F	98F	98F
6.3	82F	82F	82F	82F	82F	131F	82F	82C	82F	131F	82F	131F	131F
6.4	33D	33D	33D	33D	33D	49D	33D	33B	33D	49D		49D	49D
7.1	98G	98G	98G	98G	98G	164G	98G	98D	98G	164G	98G	148G	164G
7.2	82F	82F	82F	82F	82F	131F	82F	82C	82F	131F	82F	118F	131F
7.3	66F	66F	66F	66F	66F	98F	66F	66C	66F	98F	66F	89F	98F
7.4	33F	33F	33F	33F	33F	49F	33F	33C	33F	49F	33F	43F	49F
8.1	98G	98G	98G	98G	98G	164G	98G	98D	98G	164G	98G	164G	164G
8.2	66G	66G	66G	66G	66G	98G	66G	66D	66G	98G	66G	98G	98G
8.3													
9.1													
10.1													

# Visual Index - Countersinks & Counterbores

	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
		DIN 335A	DIN 334D	DIN 335D	DIN 335D	DIN 335C	ANSI	ANSI	ANSI	ANSI	ANSI
	G600	G132	G137	G138	G338	G236	4702	4706	4705	4703	4704
	6.30 - 25.00	8.00 - 20.00	16.00 - 80.00	25.00 - 80.00	25.00 - 63.00	Set	1/4 - 2"	1/4 - 1"	1/4 - 1"	1/4 - 2.1/2	3/32 - 2"
	487	488	489	490	490	491	492	493	493	495	496
1.1	72F		98F	98F	164F		82C	82C	82C	82C	
1.2	56E		82E	82E	131E		66C	66C	66C	66C	
1.3	49D	66E	66D	66D	98D		52C	52C	52C	52C	
1.4	39D	49D	49D	49D	66D		49B	49B	49B	49B	
1.5	26B	33D	33B	33B	49B		30B	30B	30B	30B	
1.6	20A	20B	20A	20A	33A		16A	16A	16A	16A	
1.7											
1.8											
2.1	26C		26C	26C			36C	36C	36C	36C	
2.2	20B		20B	20B			20B	20B	20B	20B	
2.3	13A	13B	13A	13A			26B	26B	26B	26B	
2.4											
3.1	82F		82F	82F	148F		52E	52E	52E	52E	
3.2	49D		49D	49D	115D		49D	49D	49D	49D	
3.3	39C		39C	39C	98C		43C	43C	43C	43C	
3.4		26D	26C	26C	98C		36C	36C	36C	36C	
4.1			39C	39C	66C		49C	49C	49C	49C	
4.2		26A	33A	33A	49A		30B	30B	30B	30B	
4.3		26A	26A	26A	33A		16B	16B	16B	16B	
5.1			39C	39C	66C		26D	26D	26D	26D	
5.2		20C	20B	20B	33B		16C	16C	16C	16C	
5.3		13B	13A	13A	20A		10C	10C	10C	10C	
6.1	82D		82D	82D	131D		82D	82D	82D	82D	
6.2	66F		66F	66F	98F		92E	92E	92E	92E	
6.3	82F		82F	82F	131F		82D	82D	82D	82D	
6.4	33D	33F	33D	33D	49D		46D	46D	46D	46D	
7.1	98G		98G	98G	164G						
7.2	82F		82F	82F	131F						
7.3	66F		66F	66F	98F						
7.4	33F		33F	33F	49F						
8.1			98G	98G	164G						
8.2			66G	66G	98G						
8.3		16G									
9.1											
10.1											

# List Number Index - Countersinks/Counterbores



Pgs. 471-497

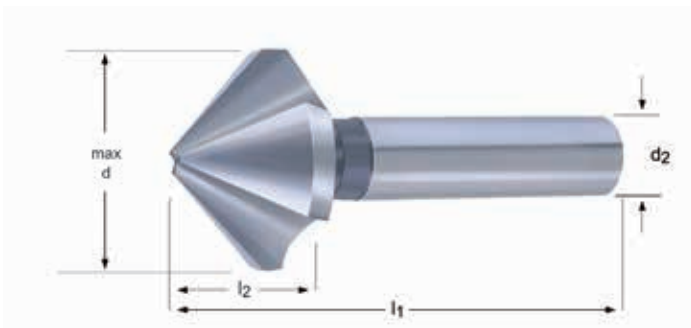
4602.....	479
4603.....	477
4608.....	478
4702.....	492
4703.....	495
4704.....	496
4705.....	493
4706.....	493
G132.....	488
G135.....	480
G136.....	483
G137.....	489
G138.....	490
G142.....	484
G149.....	482
G154.....	481
G171.....	486
G236.....	491
G335.....	480
G338.....	490
G400.....	476
G560.....	483
G570.....	485
G600.....	487

# MULTI-APPLICATION CARBIDE COUNTERSINK

## Solid Carbide, Straight Shank, 3-Flute

**G400** 90° Countersink with Straight Shank. Recommended for abrasive, hard ferrous, and non-ferrous materials.

1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	3.1	3.2	3.3	3.4	4.1	4.2
4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	



G400

HM



DIN 335C



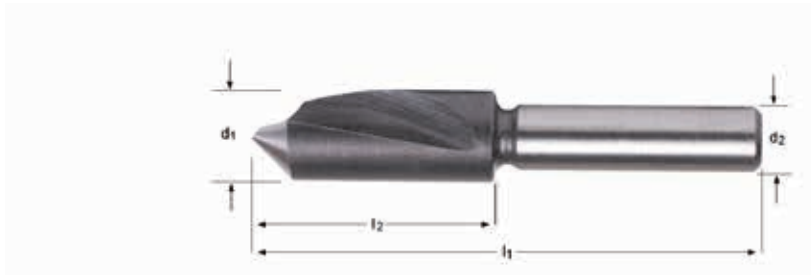
6.30 - 31.00

max d mm	min d mm	$l_2$ mm	$l_1$ mm	$d_2$ $\varnothing h_6$ mm	# of Flutes	Pack Qty	G400
6.3 (1/4)	1.5	5.0	45	5	3	1	0128787
8.3 (5/16)	2.0	6.0	50	6	3	1	0128794
10.4 (3/8)	2.5	7.1	50	6	3	1	0128725
12.4 (1/2)	2.8	8.0	56	8	3	1	0128732
16.5 (5/8)	3.2	10.0	60	10	3	1	0128749
20.5 (3/4)	3.5	12.5	63	10	3	1	0128756
25.0 (1")	3.8	15.0	67	10	3	1	0128763
31.0 (1.1/4)	4.2	18.0	71	12	3	1	0128770

## Countersink, Straight Shank, Single-Flute

**4603** Available in 60°, 82°, or 90° angles. Engineered for machine use and light portable work. Single flute construction and low controlled relief assure the user of chatterless operation.

Best results obtained using high speeds and low feed. Recommended that the predrilled hole be at least 10% of the countersink diameter.



4603

HSS



ANSI



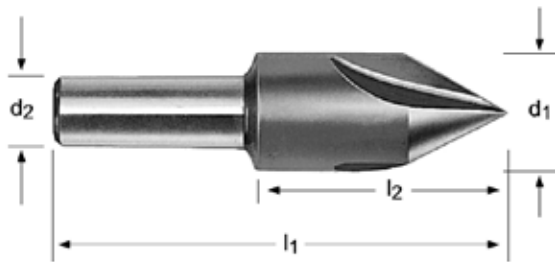
1/4 - 1.1/2

d <sub>1</sub> Ø Inch	angle	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4603
1/4	82°	3/16	11/16	1.7/16	1	1	4710797
1/4	90°	3/16	11/16	1.7/16	1	1	4710805
3/8	60°	1/4	7/8	1.3/4	1	1	4710790
3/8	82°	1/4	25/32	1.21/32	1	1	4710798
3/8	90°	1/4	3/4	1.5/8	1	1	4710806
1/2	60°	1/4	1"	2"	1	1	4710791
1/2	82°	1/4	27/32	1.27/32	1	1	4710799
1/2	90°	1/4	13/32	1.13/16	1	1	4710807
5/8	82°	3/8	1.3/32	2.3/32	1	1	4710800
5/8	90°	3/8	1"	2"	1	1	4710808
3/4	60°	3/8	1.13/32	2.21/32	1	1	4710793
3/4	82°	3/8	1.5/32	2.13/32	1	1	4710801
3/4	90°	3/8	1.1/16	2.5/16	1	1	4710809
1"	60°	1/2	1.9/16	3.1/8	1	1	4710794
1"	82°	1/2	1.1/4	2.13/16	1	1	4710802
1"	90°	1/2	1.1/4	2.13/16	1	1	4710810
1.1/4	60°	1/2	1.3/4	3.3/4	1	1	4710795
1.1/4	82°	1/2	1.1/2	3.1/2	1	1	4710803
1.1/4	90°	1/2	1.9/16	3.9/16	1	1	4710811
1.1/2	60°	1/2	2.5/16	4.1/4	1	1	4710796
1.1/2	82°	1/2	1.15/16	3.7/8	1	1	4710804
1.1/2	90°	1/2	1.13/16	3.3/4	1	1	4710812

# HSS COUNTERSINK

## Straight Shank, 3-Flute

**4608** Center Reamer/Countersink, Available in 60°, 82°, 90°, or 100° angles. Widely used to countersink screw heads and rivet heads, and countersink holes for lathe centers. The odd number of flutes eliminates chatter in most applications while providing better accuracy than a single-flute countersink.



4608

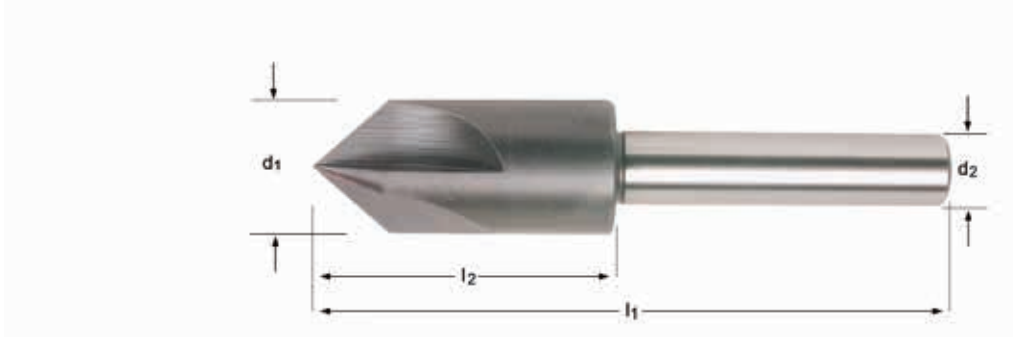


1/4 - 1"

d <sub>1</sub> Ø Inch	Angle	d <sub>2</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	# of Flutes	Pack Qty	4608
1/4	60°	3/16	3/4	1.1/2	3	1	5011093
1/4	82°	3/16	3/4	1.1/2	3	1	5011098
1/4	90°	3/16	3/4	1.1/2	3	1	5011103
1/4	100°	3/16	3/4	1.1/2	3	1	5011108
3/8	60°	1/4	7/8	1.3/4	3	1	5011094
3/8	82°	1/4	7/8	1.3/4	3	1	5011099
3/8	90°	1/4	7/8	1.3/4	3	1	5011104
3/8	100°	1/4	7/8	1.3/4	3	1	5011109
1/2	60°	3/8	1"	2"	3	1	5011095
1/2	82°	3/8	1"	2"	3	1	5011100
1/2	90°	3/8	1"	2"	3	1	5011105
1/2	100°	3/8	1"	2"	3	1	5011110
5/8	60°	3/8	1"	2.1/4	3	1	5011096
5/8	82°	3/8	1"	2.1/4	3	1	5011101
5/8	90°	3/8	1"	2.1/4	3	1	5011106
5/8	100°	3/8	1"	2.1/4	3	1	5011111
3/4	60°	1/2	1.1/4	2.5/8	3	1	5011097
3/4	82°	1/2	1.1/4	2.5/8	3	1	5011102
3/4	90°	1/2	1.1/4	2.5/8	3	1	5011107
3/4	100°	1/2	1.1/4	2.5/8	3	1	5011112
1"	60°	1/2	1"	3"	3	1	46262132
1"	82°	1/2	1"	3"	3	1	46262133
1"	90°	1/2	1"	3"	3	1	46262134
1"	100°	1/2	1"	3"	3	1	46262135

## Countersink, Straight Shank, 4-Flute

**4602** Countersink with angles of 60° for centers or 82° for flat head screws. Bright finish improves chip flow in soft ferrous or non-ferrous materials.



4602

HSS

ANSI

1/2 - 1"

$d_1$ Ø Inch	angle	$d_2$ Ø Inch	$l_2$ Inch	$l_1$ Inch	# of Flutes	Pack Qty	<b>4602</b>
1/2	60°	1/2	1.5/8	3.7/8	4	1	4710588
1/2	82°	1/2	1.5/8	3.7/8	4	1	4710593
5/8	60°	1/2	1.3/4	4"	4	1	4710589
5/8	82°	1/2	1.3/4	4"	4	1	4710594
3/4	60°	1/2	1.7/8	4.1/8	4	1	4710590
3/4	82°	1/2	1.7/8	4.1/8	4	1	4710595
7/8	60°	1/2	2"	4.1/4	4	1	4710591
7/8	82°	1/2	2"	4.1/4	4	1	4710596
1"	60°	1/2	2.1/8	4.3/8	4	1	4710592
1"	82°	1/2	2.1/8	4.3/8	4	1	4710597

# HSS COUNTERSINK

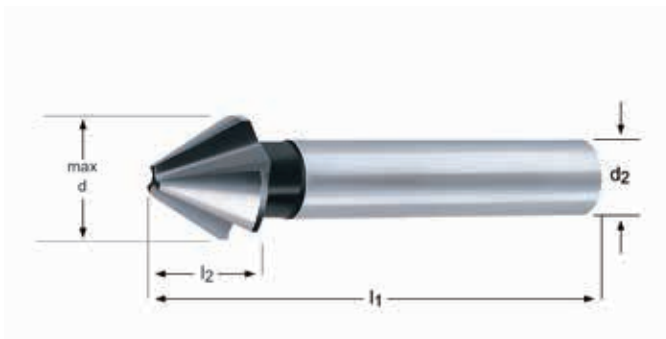


## Straight Shank, 3-Flute

60° countersink with straight shank for multiple materials.

**G135** Bright finish improves chip flow in soft ferrous or non-ferrous materials.

**G335** TiN coated for improved wear resistance.



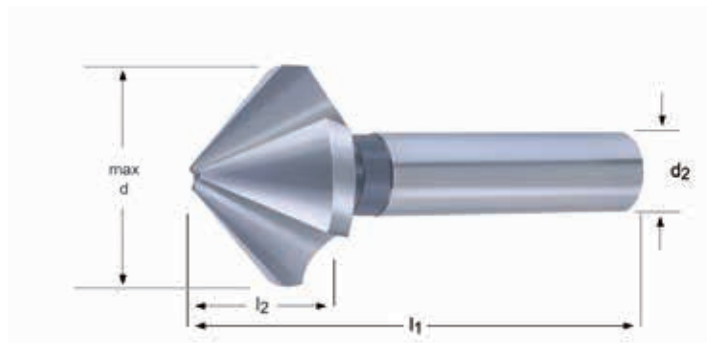
G135	G335
6.30 - 25.00	6.30 - 25.00

max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G135	G335
6.3 (1/4)	1.6	6.8	45	5	3	1	0108482	0149546
8.0 (5/16)	2.0	8.5	50	6	3	1	0108499	0149553
10.0 (3/8)	2.5	7.6	50	6	3	1	0144817	0149560
12.5 (1/2)	3.2	11.7	56	8	3	1	0108444	0149577
16.0 (5/8)	4.0	14.5	63	10	3	1	0108451	0149584
20.0 (3/4)	5.0	17.5	67	10	3	1	0108468	0149591
25.0 (1")	6.3	20.5	71	10	3	1	0108475	0149607



## Straight Shank, 3-Flute

**G154** 82° countersink for multiple materials. Bright finish improves chip flow in soft ferrous or non-ferrous materials.



G154

HSS



DIN 335C



6.30 - 25.00

max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G154
6.3 (1/4)	1.5	5.5	45	5	3	1	0149348
8.3 (5/16)	2.0	6.5	50	6	3	1	0149355
10.4 (3/8)	2.5	7.6	50	6	3	1	0149362
12.4 (1/2)	2.8	8.5	56	8	3	1	0149379
16.5 (5/8)	3.2	10.5	60	10	3	1	0149386
20.5 (3/4)	3.5	13.0	63	10	3	1	0149393
25.0 (1")	3.8	15.5	67	10	3	1	0149409

## Straight Shank, Single Flute

**G149** 90° Countersink, single flute, for multiple materials. Bright finish improves chip flow in soft ferrous or non-ferrous materials.



G149

HSS-E



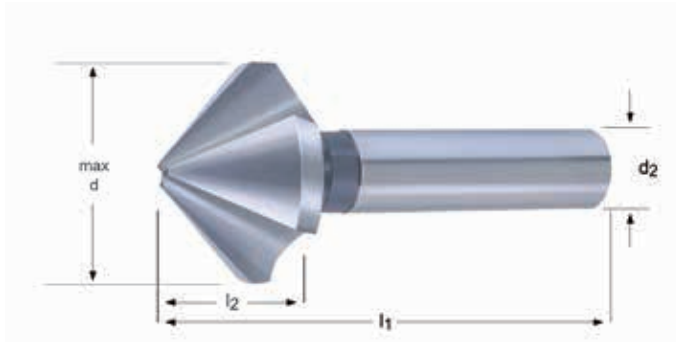
5.00 - 50.00

max d mm	min d mm	$l_2$ mm	$l_1$ mm	$d_2$ Ø mm	$d_1$ Ø mm	# of Flutes	Pack Qty	G149
5	2	19.0	45	6	10	1	1	0109106
10	5	23.0	48	8	14	1	1	0109038
15	10	34.0	65	10	21	1	1	0109045
20	15	43.0	84	12	28	1	1	0109052
25	20	48.0	102	15	35	1	1	0109069
30	25	61.0	115	15	44	1	1	0109076
35	30	65.0	127	15	48	1	1	0109083
40	35	66.0	136	15	53	1	1	0109090
50	40	85.0	166	20	60	1	1	0109113

## Straight Shank, 3-Flute

**G136** 90° Countersink with straight shank for multiple materials. Bright finish improves chip flow in soft ferrous or non-ferrous materials.

**G560** 90° Countersink with straight shank for multiple materials. TiAlN coating increases surface hardness, improves chip flow, and increases tool life.



G136	G560
4.30 - 31.00	6.30 - 31.00

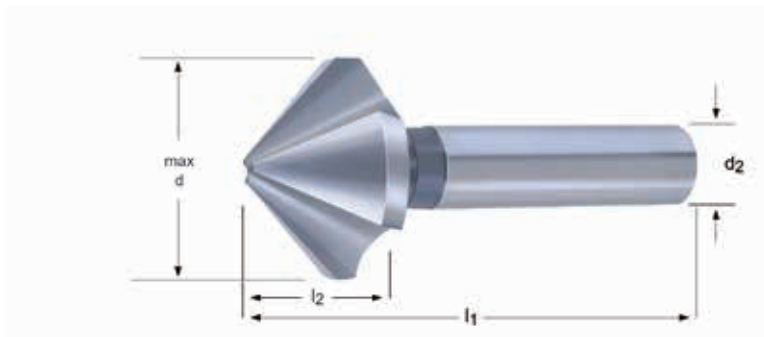
max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G136	G560
4.3	1.3	4.0	40	4	3	1	0108659	—
5.0	1.5	4.5	40	4	3	1	0108666	—
5.3	1.5	4.5	40	4	3	1	0108673	—
5.8	1.5	5.0	45	5	3	1	0108680	—
6.0	1.5	5.0	45	5	3	1	0108697	—
6.3	1.5	5.5	45	5	3	1	0108703	0109694
7.0	1.8	5.5	50	6	3	1	0108710	—
7.3	1.8	6.1	50	6	3	1	0108727	—
8.0	2.0	6.1	50	6	3	1	0108734	0127711
8.3	2.0	6.5	50	6	3	1	0108741	0127728
9.4	2.2	7.2	50	6	3	1	0108758	—
10.0	2.5	7.6	50	6	3	1	0108505	0109632
10.4	2.5	7.6	50	6	3	1	0108512	0109649
11.5	2.8	8.0	56	8	3	1	0108529	—
12.4	2.8	8.5	56	8	3	1	0108536	0109656
13.4	2.9	9.0	56	8	3	1	0108543	—
15.0	3.2	9.5	60	10	3	1	0108550	—
16.5	3.2	10.5	60	10	3	1	0108567	0109663
19.0	3.5	11.7	63	10	3	1	0108574	—
20.5	3.5	13.0	63	10	3	1	0108581	0109670
23.0	3.8	13.7	67	10	3	1	0108598	—
25.0	3.8	15.5	67	10	3	1	0108604	0109687
26.0	3.8	15.5	67	10	3	1	0108611	—
28.0	4.0	16.5	71	12	3	1	0108628	—
30.0	4.2	18.5	71	12	3	1	0108635	—
31.0	4.2	18.5	71	12	3	1	0108642	0127735

# HSS COUNTERSINK



## Straight Shank, 3-Flute

**G142** 90° Countersink with extra radial relief for soft or gummy materials. Bright finish improves chip flow in these materials.



G142

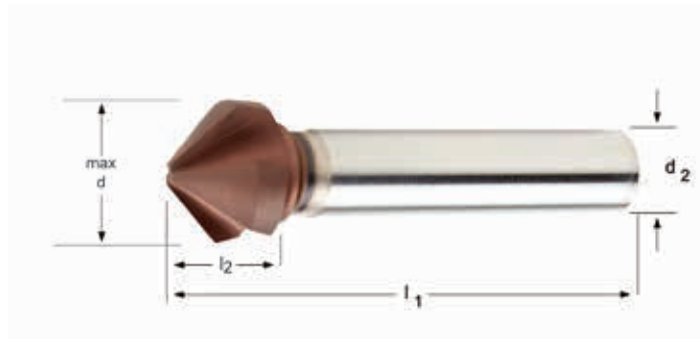


4.80 - 31.00

max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G142
4.8	1.3	4.5	40	4	3	1	0168059
5.0	1.5	4.5	40	4	3	1	0168066
6.0	1.5	5.0	45	5	3	1	0168073
6.3	1.5	5.5	45	5	3	1	0149270
7.0	1.8	5.5	50	6	3	1	0168080
7.3	1.8	6.1	50	6	3	1	0168097
8.0	2.0	6.1	50	6	3	1	0168103
8.3	2.0	6.5	50	6	3	1	0150658
10.0	2.5	7.6	50	6	3	1	0168110
10.4	2.5	7.6	50	6	3	1	0149287
11.5	2.8	8.0	56	8	3	1	0168127
12.4	2.8	8.5	56	8	3	1	0149294
15.0	3.2	9.5	60	10	3	1	0168134
16.5	3.2	10.5	60	10	3	1	0149300
19.0	3.5	11.7	63	10	3	1	0168141
20.5	3.5	13.0	63	10	3	1	0149317
23.0	3.8	13.7	67	10	3	1	0168158
25.0	3.8	15.5	67	10	3	1	0149324
31.0	4.2	18.5	71	12	3	1	0149331

## Straight Shank, 3-Flute

**G570** 90° Countersink with AlTiCN coating designed primarily for Alloy Steels and Stainless Steels. Special PVD coating increases surface hardness and temperature resistance while maintaining a high level of toughness even in dry cutting conditions.



G570

HSS-E



DIN 335C



6.30 - 31.00

max d mm	min d mm	$l_1$ mm	$l_1$ mm	$d_2$ $\varnothing h_9$ mm	# of Flutes	Pack Qty	G570
6.3	1.5	6.5	45	5	3	1	46381760
8.3	2.0	8.2	50	6	3	1	46381761
10.4	2.5	9.7	50	6	3	1	46381762
12.4	2.8	10.6	56	8	3	1	46381763
16.5	3.2	13.9	60	10	3	1	46381764
20.5	3.5	17.1	63	10	3	1	46381765
25.0	3.8	21.4	67	10	3	1	46381766
31.0	4.2	24.4	71	12	3	1	46381767

# HSS COUNTERSINK



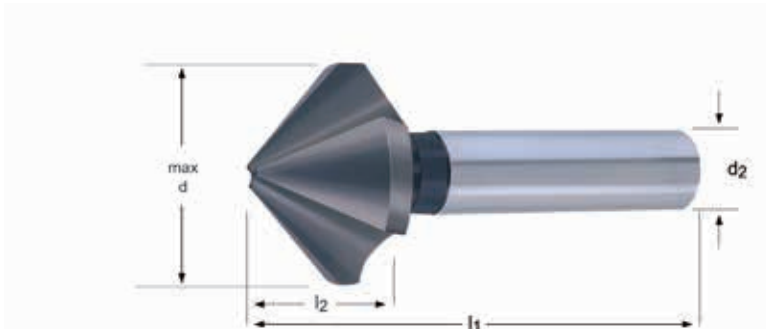
## Straight Shank, 3-Flute

**G171** 100° Countersink with straight shank design for cast iron, soft steels & aluminum. TiAIN coating increases surface hardness and improves tool life at higher speeds.

G171



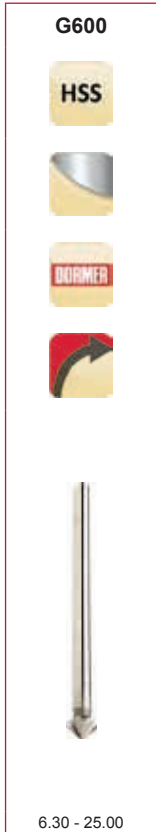
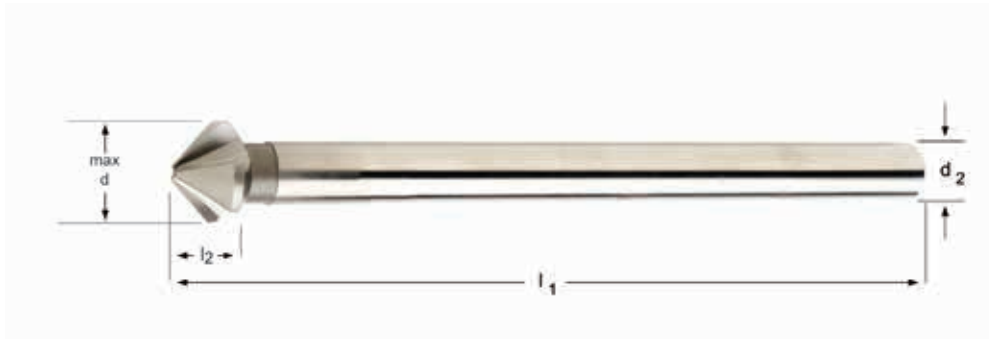
6.30 - 25.00



max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G171
6.3	1.5	4.5	44.0	5.0	3	1	0372609
8.3	2.0	5.5	49.0	6.0	3	1	0372616
10.4	2.5	6.6	49.0	6.0	3	1	0372555
12.4	2.8	7.0	53.0	6.0	3	1	0372562
16.5	3.2	9.0	56.0	6.0	3	1	0372579
20.5	3.5	11.0	61.0	10.0	3	1	0372586
25.0	3.8	13.5	65.0	10.0	3	1	0372593

## Straight Shank, 3-Flute

**G600** 90° Countersink with straight shank for long reach applications. Multi-material type excellent for soft to medium steels. Bright finish improves chip flow in softer materials.

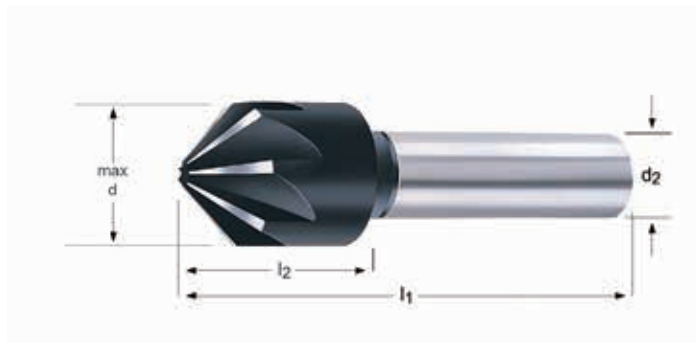


6.30 - 25.00

max d mm	min d mm	$l_2$ mm	$l_1$ mm	$d_2$ $\varnothing h_9$ mm	# of Flutes	Pack Qty	<b>G600</b>
6.3	1.3	6.4	154	5	3	1	46381768
8.3	1.8	8.3	155	6	3	1	46381769
10.4	2.2	9.7	157	6	3	1	46381770
12.4	2.5	10.6	158	8	3	1	46381771
15.0	2.8	12.6	159	10	3	1	46381772
16.5	2.8	13.9	161	10	3	1	46381773
20.5	3.0	17.1	164	10	3	1	46381774
25.0	3.2	21.4	168	10	3	1	46381775

## Straight Shank, Multi-Flute

**G132** 90° Multi-flute countersink for better stability in harder materials. More flutes to share the load when cutting at slower speeds.



**G132**

**HSS**

**DIN 335A**

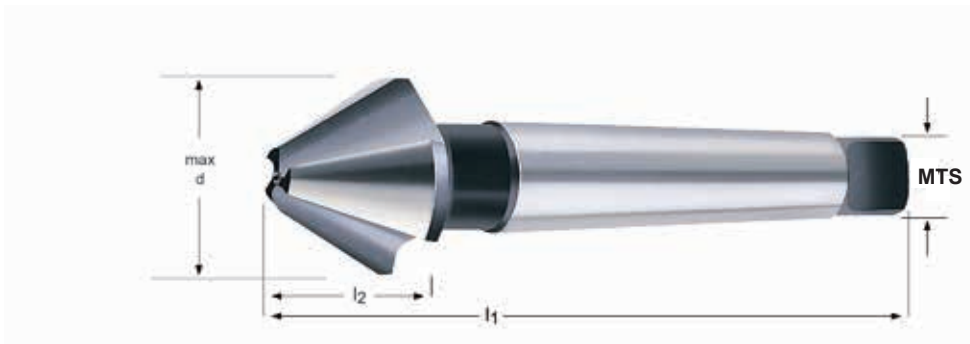
8.00 - 20.00

max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	d <sub>2</sub> Øh <sub>9</sub> mm	# of Flutes	Pack Qty	G132
8.0	-	0.0	48	8	5	1	0108291
12.5	2.0	15.5	48	8	5	1	0108260
16.0	3.2	19.5	56	10	7	1	0108277
20.0	5.0	23.0	60	10	7	1	0108284



## Taper Shank, 3-Flute

**G137** 60° Countersink with MorseTaper Shank for multiple materials. Bright finish improves chip flow in soft ferrous and non-ferrous materials.



**G137**

**HSS**

**DIN 334D**

16.00 - 80.00

max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	MTS	# of Flutes	Pack Qty	G137
16.0 (5/8)	4.0	14.5	90	1	3	1	0108765
20.0 (3/4)	5.0	17.5	106	2	3	1	0108772
25.0 (1")	6.3	20.0	112	2	3	1	0108789
31.5 (1.1/4)	10.0	23.0	118	2	3	1	0108796
40.0 (1.1/2)	12.5	28.5	150	3	3	1	0108802
50.0 (2")	16.0	36.0	160	3	3	1	0108819
63.0 (2.1/2)	20.0	43.0	190	4	3	1	0108826
80.0 (3")	25.0	54.0	200	4	3	1	0108833

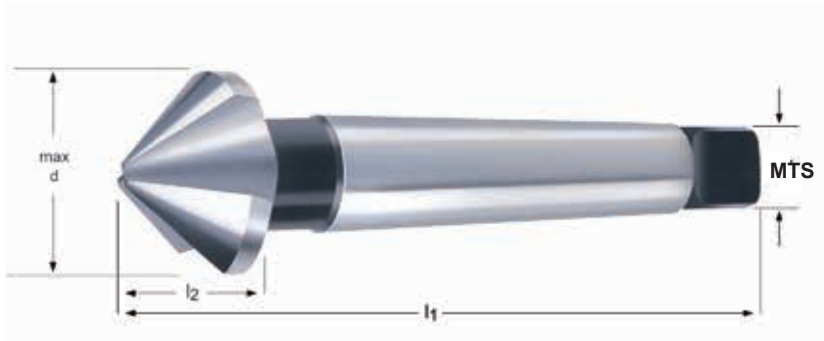
# HSS COUNTERSINK



## Taper Shank, 3-Flute

**G138** 90° Countersink with Morse Taper Shank for multiple materials. Excellent for steel, titanium & nickle alloys. Bright finish improves chip flow in soft ferrous and non-ferrous materials.

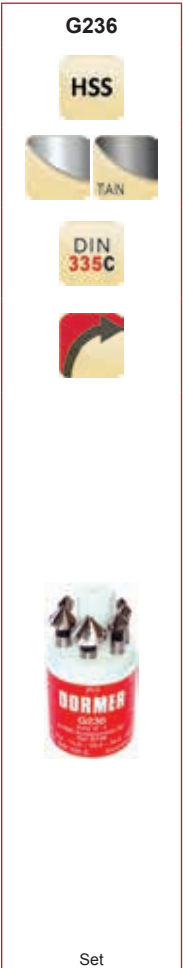
**G338** 90° Countersink with Morse Taper Shank for multiple materials. TiN coating increases surface hardness and improves chip flow in steel, cast iron and aluminum alloys.



max d mm	min d mm	l <sub>2</sub> mm	l <sub>1</sub> mm	MTS	# of Flutes	Pack Qty	G138	G338
25.0	3.8	15.5	106	2	3	1	0108895	0109502
30.0	4.2	18.5	112	2	3	1	0108925	—
31.0	4.2	20.0	112	2	3	1	0108932	0109519
34.0	4.5	19.5	118	2	3	1	0108949	—
37.0	4.8	21.7	118	2	3	1	0108956	0109526
40.0	10.0	20.5	140	3	3	1	0108963	0109533
50.0	14.0	24.1	150	3	3	1	0108970	0109540
63.0	16.0	28.5	180	4	3	1	0108987	0109557
80.0	22.0	36.0	190	4	3	1	0108994	—

## Straight Shank, 3-Flute

**G236** 90° Countersink sets in 4 or 6 pcs. Sets 1&2 in bright finish improves chip flow in soft ferrous & non-ferrous materials. Set 3 in TiAlN coating increases surface hardness and improves tool life.



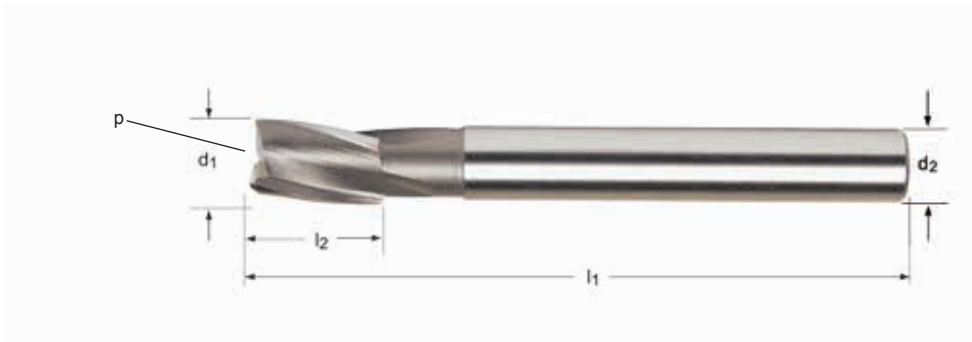
Set	Styles in set	Pieces per Set	Diameters in set	Pack Qty	G236
1	G136	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm	1	0217887
2	G136	4	6.30 mm, 10.40 mm, 16.50 mm, 20.50 mm	1	0344750
3	G560	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm	1	46521338

# HSS COUNTERBORE

## Counterbore Body - Interchangeable Pilot Type

**4702** Short Length

Used to enlarge the end of a preformed hole when a flat bottom is required. The counterbore is an end cutting tool which utilizes an interchangeable pilot to align the enlarged hole being machined with the preformed hole. The 3 and 5 flute counterbore reduces chatter and improves finish.



**4702**

**HSS**

**ANSI**

1/4 - 2"

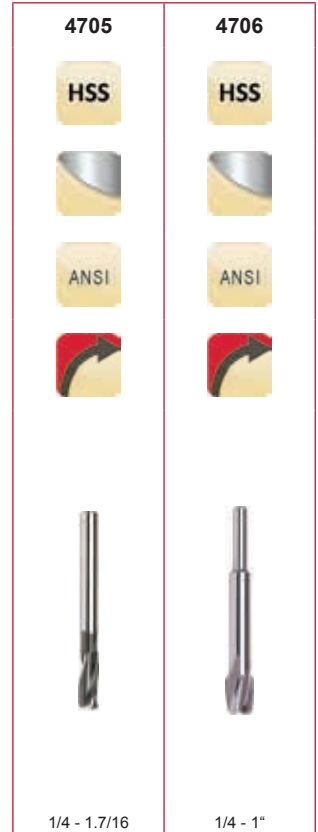
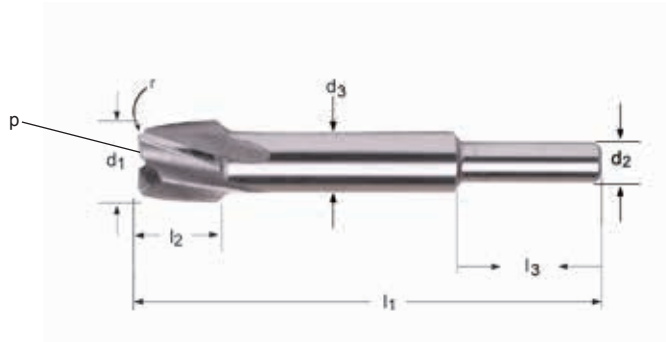
$d_1$ Ø Inch	$l_2$ Inch	$l_1$ Inch	$d_2$ Ø Inch	# of Flutes	Pilot (p) Mounting Ø Inch	Pilot Ø min	Pilot Ø max	Pack Qty	<b>4702</b>
1/4	3/4	3.13/16	15/64	3	3/32	1/8	3/16	1	6210031
9/32	3/4	3.13/16	17/64	3	3/32	1/8	7/32	1	6210032
5/16	3/4	3.13/16	19/64	3	3/32	1/8	1/4	1	6210033
11/32	3/4	3.13/16	5/16	3	3/32	1/8	9/32	1	6210034
3/8	1"	4.1/16	5/16	3	5/32	3/16	5/16	1	6210035
13/32	1"	4.1/16	3/8	3	5/32	3/16	11/32	1	6210036
7/16	1"	4.1/16	3/8	3	5/32	3/16	3/8	1	6210037
15/32	1.1/4	4.5/16	7/16	3	3/16	3/16	13/32	1	6210038
1/2	1.1/4	4.5/16	7/16	3	3/16	3/16	7/16	1	6210039
9/16	1.1/4	4.5/16	1/2	3	3/16	3/16	1/2	1	6210041
19/32	1.1/4	5.1/8	1/2	3	3/16	3/16	17/32	1	6210042
5/8	1.1/4	5.1/8	1/2	3	3/16	3/16	9/16	1	6210043
11/16	1.1/4	5.1/8	1/2	3	3/16	3/16	5/8	1	6210045
3/4	1.1/2	5.3/8	1/2	3	1/4	5/16	11/16	1	6210047
25/32	1.1/2	5.3/8	5/8	3	1/4	5/16	23/32	1	6210048
13/16	1.1/2	5.3/8	5/8	3	1/4	5/16	3/4	1	6210049
27/32	1.1/2	5.3/8	3/4	3	1/4	5/16	25/32	1	6210050
7/8	1.1/2	5.3/8	3/4	3	1/4	5/16	13/16	1	6210051
1"	1.3/4	6.3/8	3/4	3	5/16	3/8	15/16	1	6210055
2"	2.1/2	8.3/8	1.1/2	5	1/2	9/16	1.15/16	1	6210065

## Counterbore Body, Aircraft Series - Interchangeable Pilot Type

**4705** Long Series, 3-flute

**4706** Short Series (Aircraft) 4-flute with corner radius

Used for the facing of bosses, and counterboring recesses for spring pockets and screw heads. Supplied with corner radius to produce the fillets necessary for this type of work. Designed for pneumatic or electric drills.



d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	l <sub>3</sub> Inch	d <sub>3</sub> Ø Inch	# of Flutes	Pilot (p) Mounting Ø Inch	Pilot Ø min	Pilot Ø max	Pack Qty	4705	4706
1/4	1/2	2.3/8	1/4	1.1/8	15/64	4	3/32	1/8	3/16	1	—	6210137 <sup>1)</sup>
1/4	3/4	3.13/16	15/64	3.1/16	15/64	3	3/32	1/8	3/16	1	6210107	—
5/16	1/2	2.3/8	1/4	7/8	17/64	4	3/32	1/8	1/4	1	—	6210139 <sup>1)</sup>
5/16	3/4	3.13/16	19/64	3.1/16	19/64	3	3/32	1/8	1/4	1	6210109	—
11/32	1/2	2.3/8	1/4	7/8	19/64	4	3/32	1/8	9/32	1	—	6210140 <sup>1)</sup>
3/8	1/2	2.3/8	1/4	7/8	5/16	4	3/32	3/16	5/16	1	—	6210141 <sup>2)</sup>
3/8	3/4	3.13/16	5/16	3.1/16	5/16	3	3/32	3/16	5/16	1	6210111	—
13/32	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	11/32	1	—	6210142 <sup>2)</sup>
7/16	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	3/8	1	—	6210143 <sup>2)</sup>
7/16	3/4	3.13/16	3/8	3.1/16	3/8	3	1/8	3/16	3/8	1	6210113	—
15/32	1/2	2.13/16	1/4	7/8	5/16	4	1/8	1/4	13/32	1	—	6210144 <sup>2)</sup>
1/2	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	7/16	1	—	6210145 <sup>2)</sup>
1/2	3/4	3.13/16	7/16	3.1/16	7/16	3	1/8	1/4	7/16	1	6210115	—
17/32	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	15/32	1	—	6210146 <sup>2)</sup>
17/32	3/4	5.3/8	1/2	4.5/8	1/2	3	1/8	1/4	15/32	1	6210116	—
9/16	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	1/2	1	—	6210147 <sup>2)</sup>
9/16	3/4	5.3/8	1/2	4.5/8	1/2	3	1/8	1/4	1/2	1	6210117	—
19/32	3/4	5.3/8	1/2	4.3/16	9/16	3	1/8	1/4	17/32	1	6210118	—
5/8	3/4	5.3/8	1/2	4.3/16	9/16	3	1/8	1/4	9/16	1	6210119	—
11/16	1/2	2.13/16	1/4	7/8	1/2	4	1/8	1/4	5/8	1	—	6210151 <sup>3)</sup>
21/32	1.1/4	5.3/8	1/2	3.5/8	9/16	3	3/16	1/4	19/32	1	6210120	—
11/16	1.1/4	5.3/8	1/2	3.5/8	5/8	3	3/16	1/4	5/8	1	6210121	—
3/4	1.1/4	5.3/8	1/2	3.5/8	11/16	3	3/16	5/16	11/16	1	6210123	—

<sup>1)</sup>1/32 Corner Radius  
<sup>2)</sup> 3/64 Corner Radius  
<sup>3)</sup> 0.0550" Corner Radius

# HSS COUNTERBORE



d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	d <sub>2</sub> Ø Inch	l <sub>3</sub> Inch	d <sub>3</sub> Ø Inch	# of Flutes	Pilot Mounting Ø Inch	Pilot Ø min	Pilot Ø max	Pack Qty	4705	4706
3/4	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	11/16	1	—	6210153 <sup>3)</sup>
25/32	1.1/4	5.3/8	1/2	3.5/8	11/16	3	3/16	5/16	23/32	1	6210124	—
13/16	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	5/16	3/4	1	6210125	—
13/16	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	3/4	1	—	6210155 <sup>3)</sup>
7/8	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	5/16	13/16	1	6210126	—
7/8	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	13/16	1	—	6210157 <sup>3)</sup>
15/16	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	5/16	7/8	1	6210127	—
1"	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	3/8	15/16	1	6210128	—
1"	1/2	2.13/16	1/4	7/8	1/2	4	3/16	3/8	15/16	1	—	6210161 <sup>3)</sup>

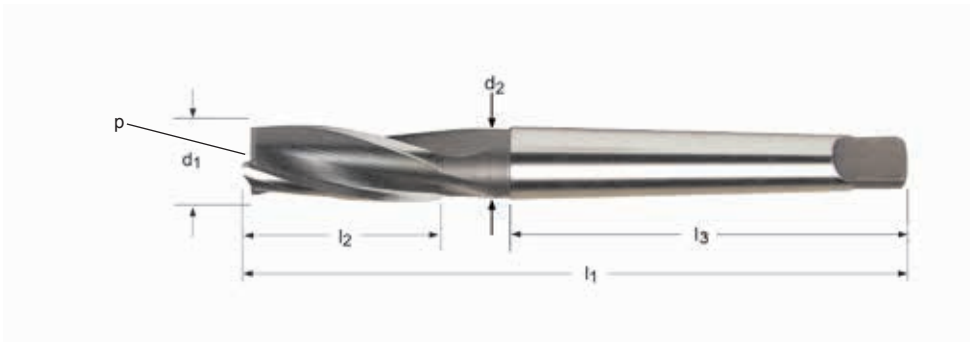
<sup>1)</sup>1/32 Corner Radius

<sup>2)</sup>3/64 Corner Radius

<sup>3)</sup>0.0550" Corner Radius

## Counterbore Body, Taper Shank, Short Series - Interchangeable Pilot Type

**4703** Short counterbore body, with taper shank for use with detachable pilots which align counterbore to existing drilled hole. 3 & 5 Flute designs for less chatter.



4703

HSS

ANSI

1/4 - 2.1/2

d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	MTS	d <sub>2</sub> Neck Dia. Inch	l <sub>3</sub> Shank Length Inch	# of Flutes	pilot (p) mounting Ø Inch	pilot Ø min	pilot Ø max	Pack Qty	4703
5/16	3/4	3.13/16	1	19/64	2.9/16	3	3/32	1/8	1/4	1	6210068 *
1/2	1.1/4	4.5/16	1	29/64	2.9/16	3	3/16	1/4	7/16	1	6210074
9/16	1.1/4	4.5/16	1	29/64	2.9/16	3	3/16	1/4	1/2	1	6210076 *
11/16	1.1/4	5.1/8	2	5/8	3.1/8	3	3/16	1/4	5/8	1	6210080
3/4	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	11/16	1	6210082
13/16	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	3/4	1	6210084
7/8	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	13/16	1	6210085
15/16	1.1/2	6.1/8	2	7/8	3.7/8	3	1/4	5/16	7/8	1	6210086
1"	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	15/16	1	6210087
1.1/16	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1"	1	6210088
1.1/8	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/16	1	6210089
1.3/16	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/8	1	6210090
1.1/4	2"	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.3/16	1	6210091
1.5/16	2"	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.1/4	1	6210092 *
1.3/8	2"	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.5/16	1	6210093
1.1/2	2"	7.7/8	4	1.3/16	4.7/8	5	3/8	7/16	1.7/16	1	6210094
1.5/8	2.1/4	8.1/8	4	1.3/8	4.7/8	5	7/16	1/2	1.9/16	1	6210095
1.3/4	2.1/4	8.1/8	4	1.3/8	4.7/8	5	7/16	1/2	1.11/16	1	6210096 *
2"	2.1/2	8.3/8	4	1.1/2	4.7/8	5	1/2	9/16	1.5/16	1	6210098
2.1/8	2.1/2	9.7/8	5	1.3/4	6.1/8	5	1/2	9/16	2.1/16	1	6210099
2.1/4	2.1/2	9.7/8	5	1.3/4	6.1/8	5	1/2	9/16	2.3/16	1	6210100 *

\* Starred items are outgoing products and are available only while supplies last.

# HSS COUNTERBORE

## Counterbore Pilot, Detachable

**4704** Interchangeable detachable pilots for use with counterbore bodies. Pilot shank diameters must match counterbore body "pilot diameter" for proper match.

4704

HSS



ANSI



3/32 - 2"



pilot Ø Inch	d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	4704
1/8	3/32	1/8	1.1/4	1	3210114
5/32	3/32	3/16	1.5/16	1	3210115
3/16	3/32	3/16	1.5/16	1	3210116
7/32	3/32	1/4	1.3/8	1	3210117
1/4	3/32	1/4	1.3/8	1	3210118
1/8	1/8	1/8	1.7/16	1	3210249
5/32	1/8	3/16	1.1/2	1	3210251
3/16	1/8	3/16	1.1/2	1	3210255
7/32	1/8	1/4	1.9/16	1	3210258
1/4	1/8	1/4	1.9/16	1	3210259
9/32	1/8	5/16	1.5/8	1	3210261
5/16	1/8	5/16	1.5/8	1	3210262
3/8	1/8	3/8	1.11/16	1	3210263
7/16	1/8	7/16	1.3/4	1	3210264
1/2	1/8	1/2	1.13/16	1	3210265
3/16	5/32	3/16	1.9/16	1	3210119
7/32	5/32	1/4	1.5/8	1	3210120
1/4	5/32	1/4	1.5/8	1	3210121
9/32	5/32	5/16	1.11/16	1	3210122
5/16	5/32	5/16	1.11/16	1	3210123
3/8	5/32	3/8	1.3/4	1	3210124
3/16	3/16	1/4	1.7/8	1	3210281
7/32	3/16	1/4	1.7/8	1	3210284
1/4	3/16	1/4	1.7/8	1	3210125
9/32	3/16	5/16	1.15/16	1	3210287
5/16	3/16	5/16	1.15/16	1	3210126
11/32	3/16	3/8	2"	1	3210444
3/8	3/16	3/8	2"	1	3210127
13/32	3/16	7/16	2.1/16	1	3210445
7/16	3/16	7/16	2.1/16	1	3210128
15/32	3/16	1/2	2.1/8	1	3210446
1/2	3/16	1/2	2.1/8	1	3210129
9/16	3/16	9/16	2.3/16	1	3210130
5/8	3/16	9/16	2.3/16	1	3210131
13/16	3/16	13/16	2.7/16	1	3210296



# HSS COUNTERBORE

pilot Ø Inch	d <sub>1</sub> Ø Inch	l <sub>2</sub> Inch	l <sub>1</sub> Inch	Pack Qty	4704
7/8	3/16	7/8	2.1/2	1	3210297
1/4	1/4	1/4	1.11/16	1	3210300
9/32	1/4	5/16	1.3/4	1	3210302
5/16	1/4	5/16	1.3/4	1	3210132
3/8	1/4	3/8	1.13/16	1	3210133
7/16	1/4	7/16	1.7/8	1	3210134
1/2	1/4	1/2	1.15/16	1	3210135
17/32	1/4	9/16	2"	1	3210447
9/16	1/4	9/16	2"	1	3210136
5/8	1/4	5/8	2.1/16	1	3210137
11/16	1/4	11/16	2.1/8	1	3210138
3/4	1/4	3/4	2.3/16	1	3210139
13/16	1/4	7/8	2.5/16	1	3210140
1"	1/4	1"	2.7/16	1	3210314
3/8	5/16	3/8	2"	1	3210142
7/16	5/16	7/16	2.1/16	1	3210143
1/2	5/16	1/2	2.1/8	1	3210144
9/16	5/16	9/16	2.3/16	1	3210145
5/8	5/16	5/8	2.1/4	1	3210146
11/16	5/16	11/16	2.5/16	1	3210147
3/4	5/16	3/4	2.3/8	1	3210148
13/16	5/16	7/8	2.1/2	1	3210149
15/16	5/16	1"	2.5/8	1	3210151
1"	5/16	1"	2.5/8	1	3210152
7/16	3/8	7/16	2.5/16	1	3210155
1/2	3/8	1/2	2.3/8	1	3210156
9/16	3/8	9/16	2.7/16	1	3210157
5/8	3/8	5/8	2.1/2	1	3210158
11/16	3/8	11/16	2.9/16	1	3210159
3/4	3/8	3/4	2.5/8	1	3210160
13/16	3/8	7/8	2.3/4	1	3210161
7/8	3/8	7/8	2.3/4	1	3210162
15/16	3/8	1"	2.5/8	1	3210163
9/16	7/16	5/8	2.7/8	1	3210173
11/16	7/16	3/4	3"	1	3210175
3/4	7/16	3/4	3"	1	3210176
13/16	7/16	7/8	3.1/8	1	3210177
7/8	7/16	7/8	3.1/8	1	3210178
15/16	7/16	1"	3.1/4	1	3210179
1"	7/16	1"	3.1/4	1	3210180
9/16	1/2	5/8	3.1/8	1	3210195
1"	1/2	1"	3.1/2	1	3210202
1.1/2	1/2	1.1/2	4"	1	3210210

# List Number Index - Miscellaneous

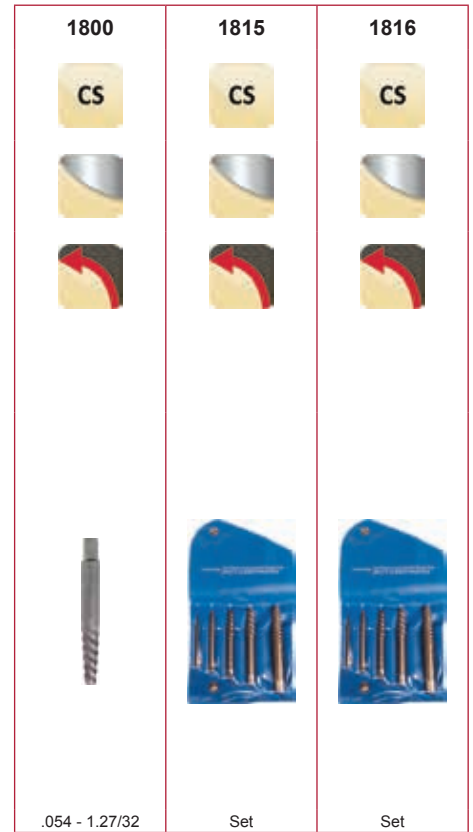


Pgs. 498-502

411.....	501
430.....	501
K520.....	502
K521.....	502
1800.....	499
1815.....	499
1816.....	499
1900.....	500

**SCREW EXTRACTOR**

- 1800** Screw Extractor
- 1815** Screw Extractor Set, 5 piece
- 1816** Screw Extractor Set, 6 piece



Nr.	d <sub>1</sub> Ø Inch	Sizes in Set	d <sub>2</sub> Ø Inch	Pieces per Set	l <sub>1</sub> Inch	Capacity For		Pack Qty	1800	1815set	1816set
						Screws & Bolts	Pipe Sizes				
801	0.0540		5/32		2"	3/16 - 1/4		12	3210001	—	—
802	0.0860		3/16		2.3/8	1/4 - 5/16		12	3210002	—	—
803	1/8		1/4		2.3/4	5/16 - 7/16		12	3210003	—	—
804	11/64		5/16		3"	7/16 - 9/16		6	3210004	—	—
805	1/4		7/16		3.3/8	9/16 - 3/4	1/8 - 1/4	6	3210005	—	—
806	3/8		5/8		3.3/4	3/4 - 1"	3/8	1	3210006	—	—
807	31/64		3/4		4.1/8	1 - 1.3/8	1/2	1	3210007	—	—
808	47/64		1"		4.3/8	1.3/8 - 1.3/4	3/4	1	3210008	—	—
809	31/32		1.1/4		4.5/8	1.3/4 - 2.1/8	1	1	3210009	—	—
810	1.7/32		1.17/32		5"	2.1/8 - 2.1/2	1.1/4	1	3210010	—	—
811	1.15/32		1.27/32		5.5/8	2.1/2 - 3	1.1/2	1	3210011	—	—
812	1.27/32		2.9/32		6.1/4	3 - 3.1/2	2	1	3210012	—	—
1815		801 - 805		5		3/16 - 3/4	1/8 - 1/4	1	—	3210013	—
1816		801 - 806		6		3/16 - 1	1/8 - 3/8	1	—	—	3210014

## DRILLING & TAPPING FLUID

**1900 Drilling & Tapping Fluid** - A heavy oil for drilling & tapping all ferrous and non-ferrous materials. Increases productivity and extends tool life. Environmentally safe.

**Wax Stick** - Multi-purpose wax that sticks to the tool and effectively removes heat while adding lubrication. Withstands tremendous pressure. Can be used in lieu of drilling/tapping fluids and cutting oils.

**Foam** - Heavy duty aerosol foam coats the tools as it foams on contact. Will not contaminate existing coolant.

**Light Tapping Fluid** - A light viscosity heavy duty drilling & tapping fluid for reducing torque. Ideal for use with a re-circulation system. Can be added to existing cutting oils to increase lubricity. Will not contaminate existing coolant as it will float to the surface for easy skimming.

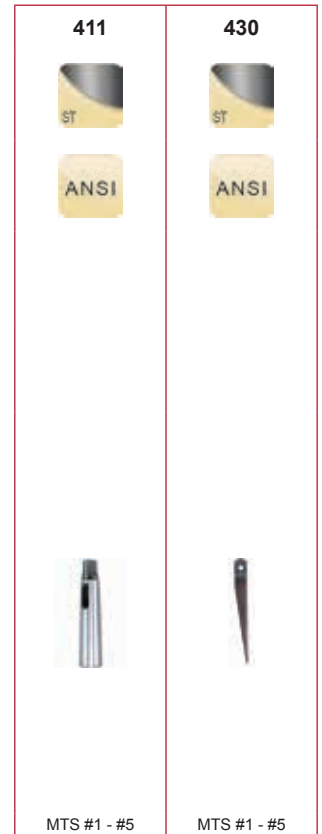


Sizes	Style	Description	Pack Qty	1900
1/2 oz	Trial Size	Drilling & Tapping Fluid	1	1910512
4 oz	Squirt Bottle	Drilling & Tapping Fluid	24	1910501
16 oz	Squirt Bottle	Drilling & Tapping Fluid	12	1930502
1 gal	Bottle	Drilling & Tapping Fluid	4	1930503
5 gal	Dispenser	Drilling & Tapping Fluid	1	1910506
5 gal	Pail	Drilling & Tapping Fluid	1	1910504
55 gal	Drum	Drilling & Tapping Fluid	1	1910505
1 lb	Stick	Wax	24	1950501
20 oz	Aerosal Can	Foam	12	1910509
1 gal	Bottle	Light Drilling & Tapping Fluid	4	1910503
16 oz	Squirt Bottle	Light Drilling & Tapping Fluid	12	1910502
16 oz	Squirt Bottle	Light Tapping Fluid (single)	1	46437347
16 oz	Squirt Bottle	Drilling & Tapping Fluid (single)	1	46437348
20 oz	Aerosal Can	Foam (single)	1	46437349
1 lb	Stick	Wax (single)	1	46437430

**SLEEVES & KEYS**

**411** Taper shank (internal and external) adapters. Heat treated and externally ground. Steam oxide surface finish prevents corrosion.

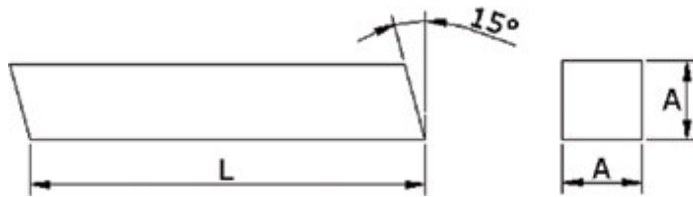
**430** Drill Drift. Dropped forged steel keys used for removing taper shank tools from adapting sleeves and machine spindles.



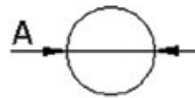
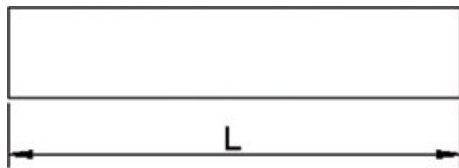
430	411	411		Pack	411	430
MTS #	Inside Taper	Outside Taper	Length	Qty		
1			4.1/2	1	—	3210338
2			5.1/2	1	—	3210339
3			7	1	—	3210340
4			8	1	—	3210341
5			9.7/8	1	—	3210342
	1	2	3.1/2	1	3210046	—
	1	3	3.15/16	1	3210047	—
	1	4	4.13/16	1	3210048	—
	2	3	4.3/8	1	3210050	—
	2	4	4.13/16	1	3210051	—
	3	4	5.5/16	1	3210053	—
	3	5	6.1/16	1	3210054	—
	4	5	6.1/2	1	3210055	—
	5	6	8.1/2	1	3210057	—

## TOOL BIT BLANKS

**K520** Cobalt ground blank with 15° beveled ends



**K521** Cobalt round blank



Sizes	Overall Length	K520
4	100	0160732
5	160	0160749
6	100	0110478
6	160	0110485
6	200	0110492
8	100	0110546
8	160	0110553
8	200	0110560
10	100	0110171
10	160	0110195
10	200	0110201
12	100	0110225
12	160	0110249
12	200	0110256
14	160	0110294
14	200	0110300
16	100	0110317
16	160	0110324
16	200	0110331
20	160	0110379
20	200	0110386
25	200	0110409
3/16	2.1/2	0254721
1/4	2.1/2	0254684
1/4	4"	0197943
5/16	2.1/2	0254790
5/16	3"	0254806
5/16	4"	0197950
3/8	3"	0254769
3/8	4"	0197967
3/8	6"	0254776
7/16	3.1/2	0340691
1/2	4"	0197974
1/2	6"	0197981
5/8	4.1/2	0197998
5/8	6"	0254820

Sizes	Overall Length	K521
4	100	0110799
6	160	0110805
8	100	0164884
8	200	0110843
10	100	0110850
10	200	0110881
12	100	0110904
12	160	0110911
12	200	0110607
14	200	0110638
15	100	0110645
16	160	0110669
18	160	0164914
1/4	4"	0110720
1/2	6"	0110782

Material



Carbide



High Speed Steel



High Speed Cobalt



High Speed Powder Metallurgy Steel



High Speed Cobalt Powder Metallurgy Steel



High Speed Steel and Carbide



Chromium Steel

Coating



Bright



Steam Tempered



Nitride



Nitride/ Steam Tempered



Bronze



Titanium Aluminium Nitride



Titanium Carbo-Nitride



Titanium Nitride



Bright/ Steam Tempered



Bright/ Titanium Nitride



Steam Tempered/ Bronze



Titanium Aluminium Nitride - Top



Titanium Nitride - Top



Ti-phon (TiAlCrSiN)



Purple / Bronze (Dual oxide surface treatment)



Alcrona Top (AlCrN - Top)



Aluminium Titanium Carbo-Nitride



Aluminium Titanium Nitride

## Common Icons

### Direction



Right hand rotation



Left hand rotation

### Depth



## Drilling icons

### Point Angle



### Countersink °



60° Countersink



82° Countersink



90° Countersink

### Form



Normal Helix



Quick Helix



Continuously Thinned Web

### Coolant



Internal Coolant



## Drilling icons

### Shank



Straight Shank



Morse taper shank



DIN 6535 HA  
(cylindrical)



DIN 6535 HE



Reduced shank



Threaded Hex Shank

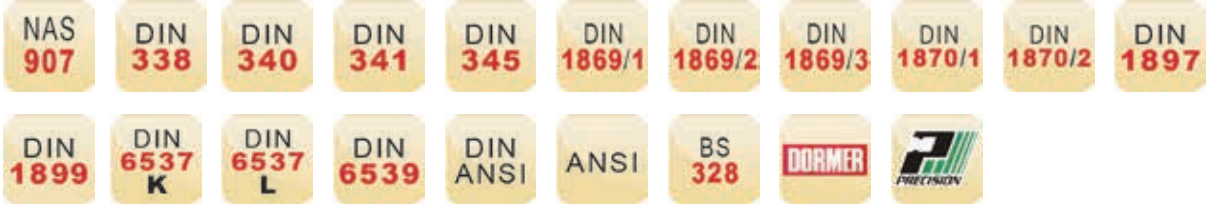


DIN 6535 HB / HE



DIN 6535 HB  
(Weldon Shank)

### Manufacturing Standards



## Reaming - Countersink Icons

### Taper Gradient



Imperial  
Standard  
Taper



Metric  
Standard  
Taper

### Tolerance



Industry standard  
hole tolerance



Specific  
Reamer  
Tolerance



ISO Tolerance  
for shafts

### Application



Countersink



Counterbore

### Countersink<sup>0</sup>



### Shank



Straight



Morse taper

### Manufacturing Standards



## Threading icons

### Thread form



Metric coarse



Metric fine



Unified Coarse



Unified Fine



Unified Special



British standard pipe fastening - G series



National taper pipe



National taper pipe dryseal



National straight pipe dryseal



National straight pipe mechanical



ISO Metric Coarse to DIN8140-2



British standard pipe taper - Rc Series

### Flute Geometry



Straight Flute



Spiral Point



Fluteless - thread forming



15° Helix



17° Helix



27° Helix



30° Helix



40° Helix



45° Helix



50° Helix



52° Helix



Straight Flute (hand tap)

### Hole Type



Through hole



Blind hole



Through or blind hole

## Threading icons

### Chamfer



Plug chamfer



Semi-bottoming



Full-bottoming



Semi-bottoming



Plug



Taper

### Tolerance



Common Class of fit



Multiple Classes of fit



Closer class of fit for accuracy



Common metric class of fit



Class of fit outside Std. for high strength or abrasive materials



Normal

### Standards



## Milling icons

Type



For steels with low to high resistance



For soft and malleable materials

Application



Slotting P9 tolerance



Slotting



Finishing (side cutting)



Roughing



Ball nose



Corner radius inside



Corner rounding outside

Direction



Slotting, ramping, plunging



Slotting, ramping



Finishing (side cutting)

Cut Length



Extra short



Short



Medium



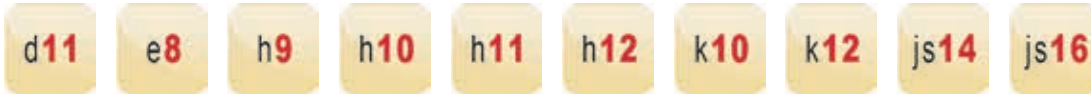
Long



Extra long

## Milling icons

Diameter tolerance



Industry standard shaft tolerances

Helix Angle



Unequal Helix

# of teeth or flutes



Shank



Straight Shank



Weldon Shank



# Technical Section - General

## TOOL MATERIALS

### High Speed Steel

**HSS** A medium-alloyed high speed steel that has good machinability and good performance. HSS exhibits hardness, toughness and wear resistance characteristics that make it attractive in a wide range of applications, for example in drills and taps.

### Cobalt High Speed Steel

**HSS-E** This high speed steel contains cobalt for increased hot hardness. The composition of HSCo is a good combination of toughness and hardness. It has good machinability and good wear resistance, which makes it usable for drills, taps, milling cutters and reamers.

### Non Cobalt Powder Metallurgy Steel

**HSS PM** Has a finer and more consistent grain structure than HSCo resulting in a tougher product. Tool life and wear resistance is normally higher than HSCo and this grade has superior edge strength and rigidity. Mainly used for milling cutters and taps.

### Sintered Cobalt High Speed Steel

**HSS-E PM** HSCo-XP is a Cobalt high speed steel which has been produced using powder metallurgy technology. High speed steel produced by this method exhibits superior toughness and grindability. Taps and milling cutters find particular advantage when manufactured from XP grade steel.

### Chromium Steel

**CS** Chromium steel is a tool steel in which the principal alloying element is Chromium. It is used only for the manufacture of taps and dies. This steel has lower hot hardness properties in comparison with high speed steels. Suited for hand tap applications.

	Grade	Hardness (HV10)	C %	W %	Mo %	Cr %	V %	Co %	Tool Material
<b>HSS</b>	M2	810-850	0.9	6.4	5.0	4.2	1.8	-	HSS
<b>HSS-E</b>	M35	830-870	0.93	6.4	5.0	4.2	1.8	4.8	HSCO
	M42	870-960	1.08	1.5	9.4	3.9	1.2	8.0	
<b>HSS PM</b>	-	830-870	0.9	6.25	5.0	4.2	1.9	-	HSS Powder Metal
<b>HSS-E PM</b>	ASP 2017	860-900	0.8	3.0	3.0	4.0	1.0	8.0	HSCO Powder Metal
	ASP 2030	870-910	1.28	6.4	5.0	4.2	3.1	8.5	
	ASP 2052	870-910	1.6	10.5	2.0	4.8	5.0	8.0	
<b>CS</b>	-	775-825	1.03	-	-	1.5	-	-	Chromium Steel

# Technical Section - General

## CARBIDE MATERIALS

### Carbide Materials (or Hard Materials)

**HM**

A sintered powder metallurgy steel, consisting of a metallic carbide composite with binder metal. The most central raw material is tungsten carbide (WC). Tungsten carbide contributes to the hardness of the material. Tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) complements WC and adjusts the properties to what is desired. These three materials are called cubic carbides. Cobalt (Co) acts as a binder and keeps the material together.

Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.

Properties	HSS materials	Carbide materials	K10/30F (often used for solid tools)
Hardness (HV30)	800-950	1300-1800	1600
Density (g/cm <sup>3</sup> )	8.0-9.0	7.2-15	14.45
Compressive strength (N/mm <sup>2</sup> )	3000-4000	3000-8000	6250
Flexural strength, (bending) (N/mm <sup>2</sup> )	2500-4000	1000-4700	4300
Heat resistance (°C)	550	1000	900
E-module (KN/mm <sup>2</sup> )	260-300	460-630	580
Grain size (µm)	-	0.2-10	0.8

The combination of hard particle (WC) and binder metal (Co) give the following changes in characteristics.

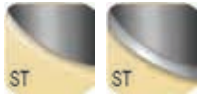
Characteristic	Higher WC content give	Higher Co content give
Hardness	Higher hardness	Lower hardness
Compressive strength (CS)	Higher CS	Lower CS
Bending strength (BS)	Lower BS	Higher BS

Grain size also influences the material properties. Small grain sizes means higher hardness and coarse grains give more toughness.



# Technical Section - General

## SURFACE TREATMENTS



### Steam Tempering

Steam tempering gives a strongly adhering blue oxide surface that acts to retain cutting fluid and prevent chip to tool welding, thereby counteracting the formation of a built-up edge. Steam tempering can be applied to any bright tool but is most effective on drills and taps.



### Bronze Finish

The bronze finish is a thin oxide layer formed on the tool surface and it is applied principally to Cobalt and Vanadium high speed steels.



### Nitriding (FeN)

Nitriding is a process that is used to increase the hardness and wear resistance of the surface of a tool. It is particularly suitable for taps that are used on abrasive materials such as cast iron, bakelite, etc. Nitriding is used on twist drills when it is desirable to increase the strength and wear resistance of the cylindrical lands.

## SURFACE COATINGS



### Titanium Nitride Coating (TiN)

Titanium Nitride is a gold colored ceramic coating applied by physical vapour deposition (PVD). High hardness combined with low friction properties ensures considerably longer tool life, or alternatively, better cutting performance from tools which have not been coated. TiN coating is used mainly for drills and taps.



### Titanium Carbon Nitride Coating (TiCN)

Titanium Carbon Nitride is a ceramic coating applied by PVD coating technology. TiCN is harder than TiN and has a lower coefficient of friction. Its hardness and toughness in combination with good wear resistance ensures that it finds its principal application in the field of milling to enhance the performance of milling cutters.



### Titanium Aluminum Nitride Coating (TiAlN)

Titanium Aluminium Nitride is a multi layer ceramic coating applied by PVD coating technology, which exhibits high toughness and oxidation stability. These properties make it ideal for higher speeds and feeds, whilst at the same time improving tool life TiAlN is suitable for drilling and tapping. It is recommended to use TiAlN when machining dry.

# Technical Section - General



## Chromium Nitride Coating (CrN)

CrN is an excellent coating for aluminum alloys, copper alloys and low alloyed steel materials. CrN can also be used as an alternative on Titanium and Nickel alloys. This coating has a low tendency for built-up edges.



## Alcrona Top (AlCrN Top)

Alcrona Top is an aluminum chromium nitride coating mostly used for milling cutters. The coatings hot hardness and high oxidation resistance are two unique properties. When machining applications involving heavy mechanical and thermal stresses, these properties translate into supreme wear resistance.



## Hardlube (TiAlN/WC/C)

Super B is a Titanium Aluminum Nitride + Tungsten Carbide + Carbon Coating used for wet and minimal lubrication machining in drilling, milling and tapping applications. Very effective for cast iron, hardened steels and heat resistant super alloys.

## SURFACE TREATMENT / COATING PROPERTIES

Surface Treatments	Color	Coating material	Hardness (HV)	Thick-ness (µm)	Coating structure	Frict. coeff. against steel	Max. appl. temp. (°C)
ST	Dark grey	Fe 304	400	Max. 5	Conversion into the surface	–	550
Bronze	Bronze	Fe 304	400	Max. 5	Conversion into the surface	–	550
N	Grey	FeN	1300	20	Diffusion zone	–	550
TiN	Gold	TiN	2300	1-4	Mono-layer	0.4	600
TiCN	Blue grey	TiCN	3000	1-4	Multi-layer gradient	0.4	500
TiAlN	Black grey	TiAlN	3300	3	Nano structured	0.3-0.35	900
CrN	Silver grey	CrN	1750	3-4	Mono-layer	0.5	700
Alcrona Top	Blue grey	AlCrN Top	3200		Mono-layer	0.35	1100
Super B	Black	TiAlN+ WC/C	3000	2-6	Multi-layer lamellar	0.2	800

# Technical Section - General

## DECIMAL EQUIVALENTS

Size	Decimal Equivalent	Size	Decimal Equivalent	Size	Decimal Equivalent	Size	Decimal Equivalent	Size	Decimal Equivalent	Size	Decimal Equivalent
80	.0135	<b>1/16</b>	<b>.0625</b>	3.3 mm	.1299	5.4 mm	.2126	O	.3160	13.50 mm	.5315
0.35 mm	.0138	1.6 mm	.0630	3.4 mm	.1339	3	.2130	8.1 mm	.3189	<b>35/64</b>	<b>.5469</b>
79	.0145	52	.0635	29	.1360	5.5 mm	.2165	8.2 mm	.3228	14.00 mm	.5512
<b>1/64</b>	<b>.0156</b>	1.65 mm	.0650	3.5 mm	.1378	<b>7/32</b>	<b>.2188</b>	P	.3230	<b>9/16</b>	<b>.5625</b>
.4 mm	.0157	1.7 mm	.0669	28	.1405	5.6 mm	.2205	8.25 mm	.3248	14.50 mm	.5709
78	.0160	51	.0670	<b>9/64</b>	<b>.1406</b>	2	.2210	8.3 mm	.3268	<b>37/64</b>	<b>.5781</b>
.45 mm	.0177	1.75 mm	.0689	3.6 mm	.1417	5.7 mm	.2244	<b>21/64</b>	<b>.3281</b>	15.00 mm	.5906
77	.0180	50	.0700	27	.1440	5.75 mm	.2264	8.4 mm	.3307	<b>19/32</b>	<b>.5938</b>
.5 mm	.0197	1.8 mm	.0709	3.7 mm	.1457	1	.2280	8.4 mm	.3320	<b>39/64</b>	<b>.6094</b>
76	.0200	1.85 mm	.0728	26	.1470	5.8 mm	.2283	8.5 mm	.3346	15.50 mm	.6102
75	.0210	49	.0730	3.75 mm	.1476	5.9 mm	.2323	8.6 mm	.3386	<b>5/8</b>	<b>.6250</b>
.55 mm	.0217	1.9 mm	.0748	25	.1495	A	.2340	R	.3390	16.00 mm	.6299
74	.0225	48	.0760	3.8 mm	.1496	<b>15/64</b>	<b>.2344</b>	8.7 mm	.3425	<b>41/64</b>	<b>.6406</b>
.6 mm	.0236	1.95 mm	.0768	24	.1520	6 mm	.2362	<b>11/32</b>	<b>.3438</b>	16.50 mm	.6496
73	.0240	<b>5/64</b>	<b>.0781</b>	3.9 mm	.1535	B	.2380	8.75 mm	.3445	<b>21/32</b>	<b>.6562</b>
72	.0250	47	.0785	23	.1540	6.1 mm	.2402	8.8 mm	.3465	17.00 mm	.6693
.65 mm	.0256	2 mm	.0787	<b>5/32</b>	<b>.1562</b>	C	.2420	S	.3480	<b>43/64</b>	<b>.6719</b>
71	.0260	2.05 mm	.0807	22	.1570	6.2 mm	.2441	8.90 mm	.3504	<b>11/16</b>	<b>.6875</b>
.7 mm	.0276	46	.0810	4 mm	.1575	D	.2460	9.00 mm	.3543	17.50 mm	.6890
70	.0280	45	.0820	21	.1590	6.25 mm	.2461	T	.3580	<b>45/64</b>	<b>.7031</b>
69	.0292	2.1 mm	.0827	20	.1610	6.3 mm	.2480	9.10 mm	.3583	18.00 mm	.7087
.75 mm	.0295	2.15 mm	.0846	4.1 mm	.1614	E	.2500	<b>23/64</b>	<b>.3594</b>	<b>23/32</b>	<b>.7188</b>
68	.0310	44	.0860	4.2 mm	.1654	<b>1/4</b>	<b>.2500</b>	9.20 mm	.3622	18.50 mm	.7283
<b>1/32</b>	<b>.0312</b>	2.2 mm	.0866	19	.1660	6.4 mm	.2520	9.25 mm	.3642	<b>47/64</b>	<b>.7344</b>
.8 mm	.0315	2.25 mm	.0886	4.25 mm	.1673	6.5 mm	.2559	9.30 mm	.3661	19.00 mm	.7480
67	.0320	43	.0890	4.3 mm	.1693	F	.2570	U	.3680	<b>3/4</b>	<b>.7500</b>
66	.0330	2.3 mm	.0906	18	.1695	6.6 mm	.2598	9.40 mm	.3701	<b>49/64</b>	<b>.7656</b>
.85 mm	.0335	2.35 mm	.0925	<b>11/64</b>	<b>.1719</b>	G	.2610	9.50 mm	.3740	19.50 mm	.7677
65	.0350	42	.0935	17	.1730	6.7 mm	.2638	<b>3/8</b>	<b>.3750</b>	<b>25/32</b>	<b>.7812</b>
.9 mm	.0354	<b>3/32</b>	<b>.0938</b>	4.4 mm	.1732	<b>17/64</b>	<b>.2656</b>	V	.3770	20.00 mm	.7874
64	.0360	2.4 mm	.0945	16	.1770	6.75 mm	.2657	9.60 mm	.3780	<b>51/64</b>	<b>.7969</b>
63	.0370	41	.0960	4.5 mm	.1772	H	.2660	9.70 mm	.3819	20.50 mm	.8071
.95 mm	.0374	2.45 mm	.0965	15	.1800	6.8 mm	.2677	9.75 mm	.3839	<b>13/16</b>	<b>.8125</b>
62	.0380	40	.0980	4.6 mm	.1811	6.9 mm	.2717	9.80 mm	.3858	21.00 mm	.8268
61	.0390	2.5 mm	.0984	14	.1820	I	.2720	W	.3860	<b>53/64</b>	<b>.8281</b>
1 mm	.0394	39	.0995	13	.1850	7 mm	.2756	9.90 mm	.3898	<b>27/32</b>	<b>.8438</b>
60	.0400	38	.1015	4.7 mm	.1850	J	.2770	<b>25/64</b>	<b>.3906</b>	21.50 mm	.8465
59	.0410	2.60 mm	.1024	4.75 mm	.1870	7.1 mm	.2795	10.00 mm	.3937	<b>55/64</b>	<b>.8594</b>
1.05 mm	.0413	37	.1040	<b>3/16</b>	<b>.1875</b>	K	.2810	X	.3970	22.00 mm	.8661
58	.0420	2.7 mm	.1063	4.8 mm	.1890	<b>9/32</b>	<b>.2812</b>	Y	.4040	<b>7/8</b>	<b>.8750</b>
57	.0430	36	.1065	12	.1890	7.2 mm	.2835	<b>13/32</b>	<b>.4062</b>	22.50 mm	.8858
1.1 mm	.0433	2.75 mm	.1083	11	.1910	7.25 mm	.2854	Z	.4130	<b>57/64</b>	<b>.8906</b>
1.15 mm	.0453	<b>7/64</b>	<b>.1094</b>	4.9 mm	.1929	7.3 mm	.2874	10.50 mm	.4134	23.00 mm	.9055
56	.0465	35	.1100	10	.1935	L	.2900	<b>27/64</b>	<b>.4219</b>	<b>29/32</b>	<b>.9062</b>
<b>3/64</b>	<b>.0469</b>	2.8 mm	.1102	9	.1960	7.4 mm	.2913	11.00 mm	.4331	<b>59/64</b>	<b>.9219</b>
1.2 mm	.0472	34	.1110	5 mm	.1969	M	.2950	<b>7/16</b>	<b>.4375</b>	23.50 mm	.9252
1.25 mm	.0492	33	.1130	8	.1990	7.5 mm	.2953	11.50 mm	.4528	<b>15/16</b>	<b>.9375</b>
1.3 mm	.0512	2.9 mm	.1142	5.1 mm	.2008	<b>19/64</b>	<b>.2969</b>	<b>29/64</b>	<b>.4531</b>	24.00 mm	.9449
55	.0520	32	.1160	7	.2010	7.6 mm	.2992	<b>15/32</b>	<b>.4688</b>	<b>61/64</b>	<b>.9531</b>
1.35 mm	.0531	3 mm	.1181	<b>13/64</b>	<b>.2031</b>	N	.3020	12.00 mm	.4724	24.50 mm	.9646
54	.0550	31	.1200	6	.2040	7.7 mm	.3031	<b>31/64</b>	<b>.4844</b>	<b>31/32</b>	<b>.9688</b>
1.4 mm	.0551	3.1 mm	.1220	5.2 mm	.2047	7.75 mm	.3051	12.50 mm	.4921	25.00 mm	.9843
1.45 mm	.0571	<b>1/8</b>	<b>.1250</b>	5	.2055	7.8 mm	.3071	<b>1/2</b>	<b>.5000</b>	<b>63/64</b>	<b>.9844</b>
1.5 mm	.0591	3.2 mm	.1260	5.25 mm	.2067	7.9 mm	.3110	13.00 mm	.5118	<b>1.0000</b>	<b>1.0000</b>
53	.0595	3.25 mm	.1280	5.3 mm	.2087	<b>5/16</b>	<b>.3125</b>	<b>33/64</b>	<b>.5156</b>		
1.55 mm	.0610	30	.1285	4	.2090	8 mm	.3150	<b>17/32</b>	<b>.5312</b>		

# Technical Section - General

## HARDNESS CONVERSION TABLE

Rockwell Hardness			Brinell	Tensile Strength
C	B	A	Hardness	(Lbs./Sq.In.)
70	—	86.5	780	—
69	—	86.0	762	—
68	—	85.5	745	—
67	—	85.0	728	—
66	—	84.5	712	—
65	—	84.0	697	—
64	—	83.5	682	—
63	—	83.0	668	—
62	—	82.5	653	—
61	—	82.0	640	—
60	—	81.0	627	314,000
59	—	80.5	614	307,000
58	—	80.0	601	299,000
57	—	79.5	578	291,000
56	—	79.0	567	284,000
55	—	78.5	555	277,000
54	—	78.0	545	270,000
53	—	77.5	534	263,000
52	—	77.0	514	256,000
51	—	76.5	505	250,000
50	—	76.0	495	243,000
49	—	75.5	477	236,000
48	—	75.0	469	230,000
47	—	74.0	461	223,000
46	115	73.5	444	217,000
45	115	73.0	429	211,000
44	114	72.5	415	205,000
43	114	72.0	408	200,000
42	113	71.5	401	195,000
41	112	71.0	388	188,000
40	112	70.5	375	182,000
39	111	70.0	369	176,000

Rockwell Hardness			Brinell	Tensile Strength
C	B	A	Hardness	(Lbs./Sq.In.)
38	110	69.5	363	171,000
37	110	69.0	352	167,000
36	109	68.5	341	162,000
35	109	68.0	331	158,000
34	108	67.5	321	153,000
33	108	67.0	311	148,000
32	107	66.5	302	144,000
31	106	66.0	293	140,000
30	105	65.5	285	136,000
29	104	65.0	277	133,000
28	104	64.5	269	131,000
27	103	64.0	265	130,000
26	103	63.5	262	128,000
25	102	63.0	255	125,000
24	102	62.5	248	122,000
23	101	62.0	241	119,000
22	100	61.5	235	116,000
21	99	61.0	229	113,000
20	98	60.0	223	110,000
19	97	59.5	220	108,000
18	97	59.0	217	107,000
17	96	58.0	212	104,000
16	96	57.5	207	101,000
15	95	57.0	202	99,000
14	94	56.5	200	98,000
13	93	56.0	197	97,000
12	92	55.5	192	95,000
11	92	55.0	189	94,000
10	91	54.0	187	93,000
9	90	53.5	183	91,000
8	89	53.0	179	89,000
7	88	52.5	174	87,000

## LUBRICANTS

Lubricants or coolants are used on cutting tools to reduce friction or to reduce heat.

Type of Lubricant	Description	Advantages	Disadvantages
Emulsion	Emulsions or water-soluble cutting oils give lubrication properties combined with good cooling property. The oil concentrate in emulsion contains additives that give different properties like lubricators, preservatives and EP additives to improve bearing strength.	Reduces heat. Flushes away chips.	Disposal cost. Environment
Minimal lubrication	Minimal lubrication is a small amount of oil distributed with compressed air to lubricate the cutting or forming process.	Low cost. Good	Bad chip removal. Requires good set up of nozzle positioning
Oil	Cutting oils have good lubrication properties but do not provide such good cooling as water-based cutting fluids.	Good	High cost. Environment.
Dry / compressed air	Compressed air directed to the cutting process.	Clean process. Remove Chips. Low cost.	Works in a limited no. of applications.

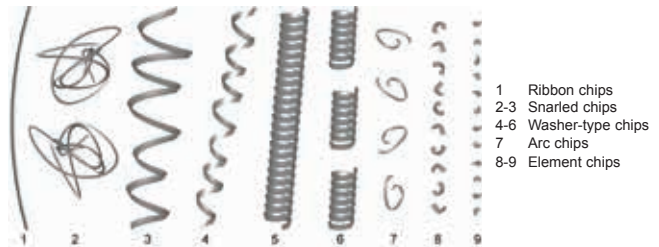


## TYPES OF CHIPS

Chip formation is mostly caused by plastic deformation. This process, due to the friction generated during machining, generates heat. Heat has the positive effect of increasing the plasticity of the workpiece material, but the negative effect of increasing the wear on the tool. When workpiece material reaches its breakage point, then the chip is generated. Its form and development depend on different factors, such as:

- Chemical-physical compatibility between tool and workpiece materials
- Cutting operation
- Cutting conditions (speed, feed, material removal rate)
- Tool geometry
- Friction coefficient (with or without coating)
- Lubrication

Depending on different combinations of the above mentioned factors, the chips can turn out in many different ways (see figure below).



- 1 Ribbon chips
- 2-3 Snarled chips
- 4-6 Washer-type chips
- 7 Arc chips
- 8-9 Element chips

Chips that are shaped as small "6's & 9's" are desirable in most machining applications. This will allow for the best possible chip evacuation from the deepest cavities. Tool life is also increased dramatically when chips are kept small and manageable. When the heat generated from cutting is kept in the chip instead of the tool, wear is kept to a minimum.

# Technical Section - General

## INDUSTRY STANDARD TOLERANCES FOR SHAFTS & HOLES

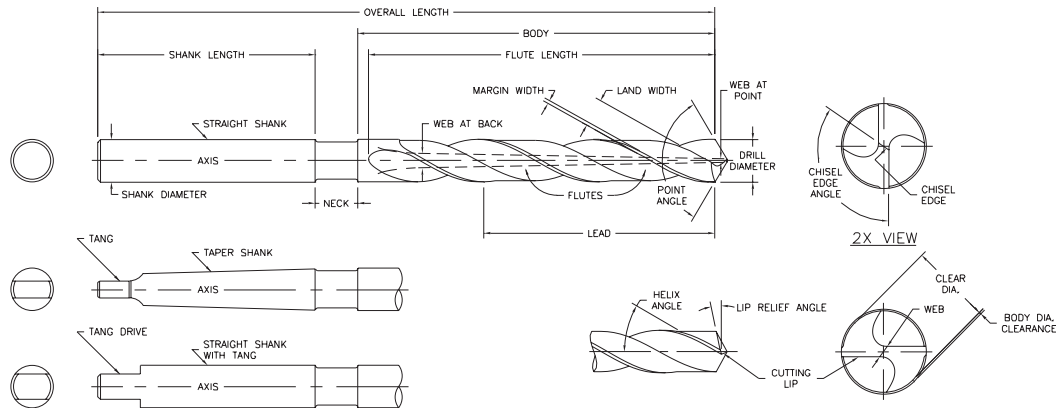
Tolerance values are shown in Microns ( $\mu\text{m}$ )

Formula for Microns ...1  $\mu\text{m}$  = 0.001 mm / 0.000039

Tolerance	Diameter (mm)							
	> 1 ≤ 3	> 3 ≤ 6	> 6 ≤ 10	> 10 ≤ 18	> 18 ≤ 30	> 30 ≤ 50	> 50 ≤ 80	> 80 ≤ 120
	Diameter (inch)							
	> 0.039 ≤ 0.118	> 0.118 ≤ 0.236	> 0.236 ≤ 0.394	> 0.394 ≤ 0.709	> 0.709 ≤ 1.181	> 1.181 ≤ 1.968	> 1.968 ≤ 3.149	> 3.149 ≤ 4.724
	Tolerance values ( $\mu\text{m}$ )							
e8	-14 / -28	-20 / -38	-25 / -47	-32 / -59	-40 / -73	-50 / -89	-60 / -106	-72 / -126
f6	-6 / -12	-10 / -18	-13 / -22	-16 / -27	-20 / -33	-25 / -41	-30 / -49	-36 / -58
f7	-6 / -16	-10 / -22	-13 / -28	-16 / -34	-20 / -41	-25 / -50	-30 / -60	-36 / -71
h6	0 / -6	0 / -8	0 / -9	0 / -11	0 / -13	0 / -16	0 / -19	0 / -22
h7	0 / -10	0 / -12	0 / -15	0 / -18	0 / -21	0 / -25	0 / -30	0 / -35
h8	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33	0 / -39	0 / -46	0 / -54
h9	0 / -25	0 / -30	0 / -36	0 / -43	0 / -52	0 / -62	0 / -74	0 / -87
h10	0 / -40	0 / -48	0 / -58	0 / -70	0 / -84	0 / -100	0 / -120	0 / -140
h11	0 / -60	0 / -75	0 / -90	0 / -110	0 / -130	0 / -160	0 / -190	0 / -220
h12	0 / -100	0 / -120	0 / -150	0 / -180	0 / -210	0 / -250	0 / -300	0 / -350
k10	+40 / 0	+48 / 0	+58 / 0	+70 / 0	+84 / 0	+100 / 0	+120 / 0	+140 / 0
k12	+100 / 0	+120 / 0	+150 / 0	+180 / 0	+210 / 0	+250 / 0	+300 / 0	+350 / 0
m7	+2 / +12	+4 / +16	+6 / +21	+7 / +25	+8 / +29	+9 / +34	+11 / +41	+13 / +48
js14	+/- 125	+/- 150	+/- 180	+/- 215	+/- 260	+/- 310	+/- 370	+/- 435
js16	+/- 300	+/- 375	+/- 450	+/- 550	+/- 650	+/- 800	+/- 950	+/- 1100
H7	+10 / 0	+12 / 0	+15 / 0	+18 / 0	+21 / 0	+25 / 0	+30 / 0	+35 / 0
H8	+14 / 0	+18 / 0	+22 / 0	+27 / 0	+33 / 0	+39 / 0	+46 / 0	+54 / 0
H9	+25 / 0	+30 / 0	+36 / 0	+43 / 0	+52 / 0	+62 / 0	+74 / 0	+87 / 0
H12	+100 / 0	+120 / 0	+150 / 0	+180 / 0	+210 / 0	+250 / 0	+300 / 0	+350 / 0
P9	-6 / -31	-12 / -42	-15 / -51	-18 / -61	-22 / -74	-26 / -86	-32 / -106	-37 / -124
S7	-13 / -22	-15 / -27	-17 / -32	-21 / -39	-27 / -48	-34 / -59	-42 / -72	-58 / -93

# Technical Section - Drilling

## DRILL NOMENCLATURE



**Axis**—The imaginary straight line which forms the longitudinal center line of a drill.

**Backtaper**—A slight decrease in diameter from front to back in the body of a drill.

**Body**—The portion of a drill extending from the shank or neck to the outer corners of the cutting lips.

**Body Clearance Diameter**—The portion of the land that has been cut away so it will not bind against the walls of the hole.

**Chisel-Edge**—The edge at the end of the web that connects the cutting lips.

**Chisel-Edge Angle**—The included angle between the chisel-edge and cutting lip, as viewed from the end of a drill.

**Clearance Diameter**—The diameter over the cut away portion of the drill lands.

**Drill**—A rotary end cutting tool having one or more cutting lips, and having one or more helical or straight flutes for the passage of chips and the admission of a cutting fluid.

**Drill Diameter**—The diameter over the margins of a drill measured at the point.

**Flute Length**—The length from the outer corners of the cutting lips to the extreme back of the flutes. Includes the sweep of the tool used to generate the flutes and therefore does not indicate the usable length of flutes.

**Flutes**—Helical or straight grooves cut or formed in the body of a drill to provide cutting lips, permit removal of chips, and allow cutting fluid to reach the cutting lips.

**Helix Angle**—The angle formed by the leading edge of the land with a plane containing the axis of a drill.

**Land**—The peripheral portion of the body between adjacent flutes.

**Land Width**—The distance between the leading edge and heel of the land; measured at a right angle to the leading edge.

**Lead**—The axial advance of a leading edge of the land in one turn around the circumference.

**Lip Relief Angle**—The axial relief angle at the outer corner of the lip; measured by projection to a plane tangent to the periphery at the outer corner of the lip.

**Lips**—The cutting edges of a two flute drill extending from the chisel-edge to the periphery.

**Margin**—The cylindrical portion of the land, which is not cut away, to provide clearance.

**Neck**—The section of reduced diameter between the body and the shank of a drill.

**Overall Length**—The length from the extreme end of the shank to the outer corners of the cutting lip. It does not include the conical shank end often used on straight shank drills, nor the conical cutting point used on both straight and taper shank drills.

**Point**—The cutting end of a drill, made up of the ends of the lands and the web. In form, it resembles a cone, but departs from a true cone to furnish clearance behind the cutting lips.

**Conventional**—Conventional Points with 118° included point angles are the most commonly used because they provide satisfactory results in a wide variety of materials. A

possible limitation is that the straight chisel edge contributes to walking at the drill point, often making it necessary to spot the hole for improved accuracy.

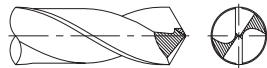


# Technical Section - Drilling

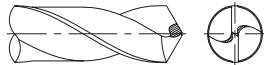
(CONTINUED FROM PRIOR PAGE)

## DRILL NOMENCLATURE

**Split** — Split-Points (commonly called Crankshaft Points) were originally developed for use on drills designed for deep oil holes in automotive crankshafts. Since its inception, the split-point has gained widespread use and is applied to both 118° and 135° included point angles. Its main advantages are the ability to reduce thrust and eliminate walking at the drill point. This is a distinct advantage when the drill is used in a portable drill or in drilling applications where bushings cannot be used. The split-point also has two positive rake cutting edges extending to the center of the drill, which can assist as a chipbreaker to produce small chips which can readily be ejected.



**Notched** — Notched Points were developed for drilling tough alloys. Commonly incorporated on heavy web drills, which allow the point to withstand the higher thrust loads required in drilling these materials. As with the split-point, the Notched Point contains two additional positive rake cutting edges extending toward the center of the drill. These secondary cutting lips, which extend no further than half the original cutting lip, can assist in chip control and reduce the torque required in drilling tough materials. Notched Points can be incorporated on both 118° and 135° included point angles, making them suitable for drilling a wide variety of materials.



**Point Angle**—The included angle between the cutting lips projected upon a plane parallel to the drill axis and parallel to the two cutting lips.

**Relative Lip Height**—The difference in indicator reading between the cutting lips of a drill. Measured at a right angle to the cutting lip at a specific distance from the axis of the tool.

**Shank**—The part of a drill by which it is held and driven.

**Tang**—The flattened end of a taper shank, intended to fit into a driving slot in a socket.

**Tang Drive**—Two opposite parallel driving flats on the extreme end of a straight shank.

**Taper Shank**—Drills having conical shanks suitable for direct fitting in machine spindles, driving sleeves, or sockets. Tapered shanks generally have a tang.

**Web**—The central portion of the body that joins the lands. The extreme end of the web forms the chisel-edge on a two flute drill.

**Web Thickness**—The thickness of the web at the point, unless another specific location is indicated.

## DRILLING TERMINOLOGY/ OPERATING FORMULAS

**Speed** — The speed of a drill is determined by the rate at which the outer periphery of the tool rotates in relation to material being cut. In general, the SFM at which a drill will operate is within a range based upon the workpiece material, its condition, hardness, and depth of hole. The deeper the hole, the greater tendency there is for more heat to be generated, due to length of drill engagement, as well as chip compaction. Thus, speed reduction is often recommended to minimize the amount of heat being generated. By increasing the SFM, fewer holes will result. Therefore, it is usually advisable to start the drilling process at a slower SFM and then increase to the maximum.

**Feed** — Feed rates for drilling are governed by the drill diameter machinability of materials and depth of hole. Small drills, harder materials, and deeper holes require additional considerations in selecting the proper feed rates.

The following terms and formulas can be used to determine the appropriate operating parameters.

Terms	Formulas
<b>IPM</b> = Inches Per Minute	$IPR \times RPM = \mathbf{IPM}$
<b>IPR</b> = Inches Per Revolution	$\frac{IPM}{RPM} = \mathbf{IPR}$
<b>RPM</b> = Revolutions Per Minute	$\frac{SFM \times 3.82}{D} = \mathbf{RPM}$
<b>SFM</b> = Surface Feet Per Minute	$D \times RPM \times .26 = \mathbf{SFM}$
<b>D</b> = Drill Diameter	

**Note:** For element and tolerance information, see specific technical sections on Solid Carbide or High Speed Steel.

# Technical Section - Drilling

## OPTIMIZING THE DRILLING OPERATION / TROUBLESHOOTING

### Drill Selection

Use the shortest drill the application will permit in order to achieve maximum tool rigidity.

### HOLDERS

Tool holders and collets must provide good concentricity between the drill and the machine spindle. Use a positive back stop to prevent the tool from backing up into the holder. Never collet the tool over the flutes or over-tighten the holder. Static runout in the tool assembly must be accurately checked and maintained.

### Workpiece

A secure and rigid workpiece to minimize deflection is needed, particularly on through-hole applications.

### Coolants

Coolants are recommended when drilling mild steel and high temperature alloys. The purpose of the coolant media is to direct the chips away from the cutting tool and workpiece. Excessive coolant pressure and/or too much volume can negatively affect performance. When using coolant fed drills, the coolant pressure that is required should be higher than normal. Suggested pressure for coolant fed drills is minimally 150 PSI. As the diameter of the drill is reduced, the higher the pressure. This is to assist the chip in evacuating from a more confined area.

## DRILLING TROUBLESHOOTING GUIDE

Problem	Solution
<b>Wear on Outer Corners</b>	<ul style="list-style-type: none"> <li>• Reduce cutting speed</li> <li>• Increase feed (IPR)</li> <li>• Improve direction of coolant flow</li> <li>• Increase coolant pressure</li> <li>• Add corner break</li> </ul>
<b>Chipping of Chisel Edge</b>	<ul style="list-style-type: none"> <li>• Check accuracy of drill runout</li> <li>• Check workpiece clamping accuracy and movement</li> <li>• Check point centrality and lip height</li> <li>• Increase feed rate</li> </ul>
<b>Chipping of Cutting Lips</b>	<ul style="list-style-type: none"> <li>• Check accuracy of drill runout</li> <li>• Check workpiece clamping accuracy and movement</li> <li>• Reduce speed</li> <li>• Reduce point clearance</li> <li>• Increase hone</li> </ul>
<b>Cracking of Lands</b>	<ul style="list-style-type: none"> <li>• Check movement of workpiece</li> <li>• Increase back taper</li> <li>• Check accuracy of drill runout</li> <li>• Chip packing; increase flute form opening or peck drill (HSS or HSCO only)</li> <li>• Slow down helix, horizontal drilling</li> <li>• Increase feed</li> <li>• When spot drilling, reduce feed</li> <li>• Improve direction of coolant flow</li> <li>• Increase coolant pressure</li> </ul>
<b>Oversize Hole</b>	<ul style="list-style-type: none"> <li>• Increase speed, reduce feed</li> <li>• Check workpiece clamping accuracy and movement</li> <li>• Check accuracy of drill runout</li> <li>• Chip packing, increase flute form opening or peck drill (HSS or HSCO only)</li> <li>• Check point centrality and lip height</li> </ul>
<b>Undersize Hole</b>	<ul style="list-style-type: none"> <li>• Improve direction of coolant flow</li> <li>• Reduce cutting speed, increase feed</li> <li>• Check drill diameter</li> </ul>
<b>Hole Not Round</b>	<ul style="list-style-type: none"> <li>• Check accuracy of drill runout</li> <li>• Check workpiece clamping accuracy and movement</li> <li>• Check point centrality and lip height</li> <li>• Chip packing, increase flute form opening or peck drill (HSS or HSCO only)</li> </ul>
<b>Drill Breakage</b>	<ul style="list-style-type: none"> <li>• Chip packing, increase flute form opening or peck drill (HSS or HSCO only)</li> <li>• Check workpiece clamping accuracy and movement</li> <li>• Check accuracy of drill runout</li> <li>• Reduce feed rate, increase feed rate</li> <li>• Improve direction of coolant flow</li> <li>• Increase coolant pressure</li> </ul>



# Technical Section - Drilling

## HOLE SIZE / ACHIEVABLE HOLE TOLERANCES

As geometric, substrate and coating configurations become more advanced, the ability of a drill to produce a more accurate hole size increases. In general, a standard geometry tool will achieve a hole size to H12. However as the configuration of the drill becomes more complex the achievable hole size, under favorable conditions, can be as good as H8.

To offer a better insight, listed below are the product types and their achievable hole tolerances:

HSS General Purpose drills – H12

HSS / HSCo Parabolic Flute Deep Hole Drills (PFX) – H10

HSS / HSCo High performance TiN/ TiALN coated (ADX) – H9

Solid Carbide High Performance TiN / TiALN coated (CDX) – H8

### NOMINAL HOLE DIAMETER (MM)

∅ (mm)	H8	H9	H10	H12
≤ 3	0 / +0.014	0 / +0.025	0 / +0.040	0 / +0.100
> 3 ≤ 6	0 / +0.018	0 / +0.030	0 / +0.048	0 / +0.120
> 6 ≤ 10	0 / +0.022	0 / +0.036	0 / +0.058	0 / +0.150
> 10 ≤ 18	0 / +0.027	0 / +0.043	0 / +0.070	0 / +0.180
> 18 ≤ 30	0 / +0.033	0 / +0.052	0 / +0.084	0 / +0.210

### NOMINAL HOLE DIAMETER (INCHES)

∅ (inch)	H8	H9	H10	H12
≤ .1181	0 / +0.0006	0 / +0.0010	0 / +0.0016	0 / +0.0040
>.1181≤.2362	0 / +0.0007	0 / +0.0012	0 / +0.0019	0 / +0.0048
>.2362 ≤.3937	0 / +0.0009	0 / +0.0015	0 / +0.0023	0 / +0.0059
>.3937≤.7087	0 / +0.0011	0 / +0.0017	0 / +0.0028	0 / +0.0071
>.7087≤1.1811	0 / +0.0013	0 / +0.0021	0 / +0.0033	0 / +0.0083

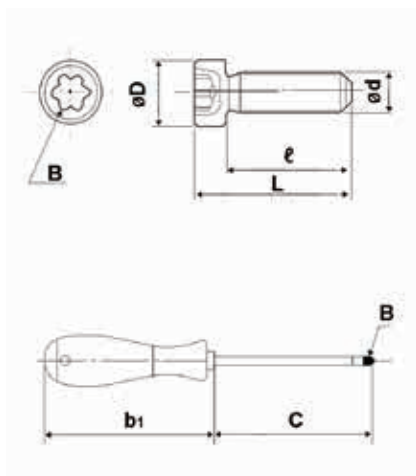
In view of the ability of some drills to produce a much tighter hole tolerance, due consideration should be given to drilled holes which are subject to secondary operations, eg. tapping, reaming. The diameter of the drill will need to be increased from what is recommended to account for the fact that the hole size produced will be smaller.

# Technical Section - Drilling - Hydra

## Torque Table

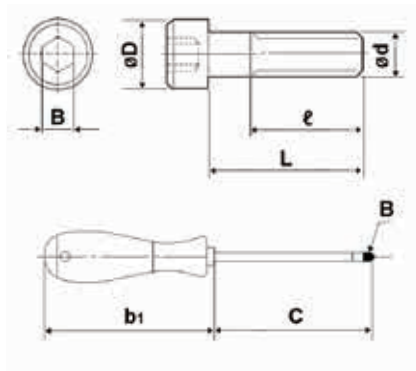
					TORQUE VALUES Nm (metric System)	TORQUE VALUES in/lbs (inch System)
H860	H861	H853 3xD	H855 5xD	H858 8xD		
H860N1	H861N1	12.0mm-15.0mm 31/64"-39/64"	12.0mm-15.0mm 31/64"-39/64"	14.0mm-15.0mm	0.75-0.99	6.6-8.8
H860N2	H861N2	16.0mm-18.0mm 41/64"-23/32"	16.0mm-18.0mm 41/64"-23/32"	16.0mm-18.0mm	0.93-1.24	8.2-11.0
H860N3	H861N3	19.0mm-21.0mm 49/64"-27/32"	19.0mm-21.0mm 49/64"-27/32"	19.0mm-21.0mm	1.84-2.44	16.3-21.6
H860N4	H861N3	22.0mm-24.0mm 57/64"-31/32"	22.0mm-24.0mm 57/64"-31/32"	22.0mm-24.0mm	2.73-3.72	24.2-32.9
H860N5	H861N4	25.0mm-27.0mm 1.1/64"-1.3/32"	25.0mm-27.0mm 1.1/64"-1.3/32"	25.0mm-27.0mm	4.14-5.52	36.6-48.8
H860N6	H861N5	28.0mm-33.5mm 1.1/8"-1.3/16"	28.0mm-33.5mm 1.1/8"-1.3/16"	28.0mm-33.5mm	4.97-6.63	44.0-58.7
H860N7	H861N6	35.0mm-42.5mm	35.0mm-42.5mm	35.0mm-42.5mm	7.20	63.7

## Screws and screw-drivers data



e-code	d	Pitch	L (mm)	l (mm)	D (mm)	B
H860N1	M2.2	0.45	7.5	5.7	3.5	8IP
H860N2	M2.5	0.45	9.0	7.0	4.1	10IP
H860N3	M3.0	0.50	10.5	8.0	4.9	15IP
H860N4	M3.5	0.60	11.5	8.8	5.5	15IP
H860N5	M4.0	0.70	12.5	9.5	6.0	20IP
H860N6	M4.5	0.75	14.3	10.8	6.8	25IP

code	B	C	b1
H861N1	8IP	60	104
H861N2	10IP	80	111
H861N3	15IP	80	111
H861N4	20IP	100	118
H861N5	25IP	100	118



e-code	d	Pitch	L (mm)	l (mm)	D (mm)	B
H860N7	M5.0	0.8	15	FULL	8.5	4

e-code	B	C	b1
H861N6	4	75	111

# Technical Section - Drilling - Hydra

## Drilling Hints & Tips with the Hydra Drill

### COOLANTS

For maximum chip evacuation and tool performance, coolant use is recommended.

Emulsion coolant concentration of 6 – 8% is recommended for most applications, at a coolant pressure of 20 bar or higher. For high strength steel, stainless steels and tougher drilling applications, use a higher concentration of 10-12%. In these applications, particularly in stainless steels, it is recommended to use the maximum coolant pressure on the machine.

The Hydra-drill coolant holes provide improved web strength and reduce heat at the cutting edges for increased productivity and longer tool life.

### HOLDERS

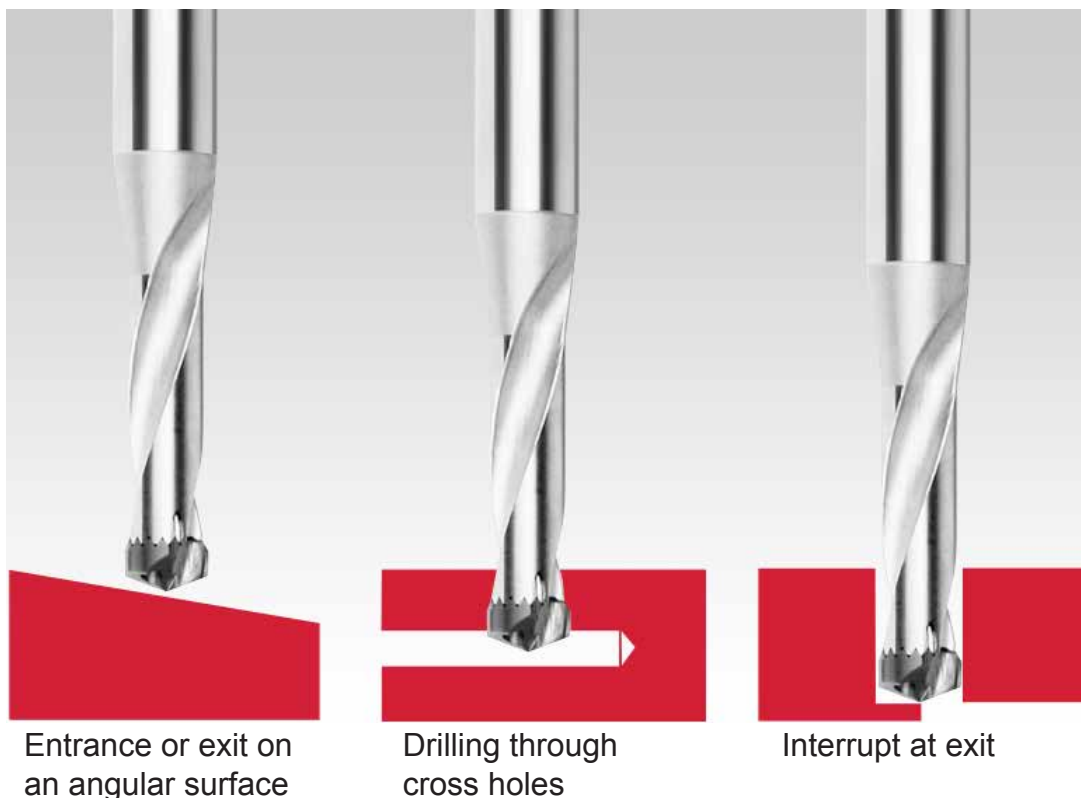
Always use tool holders and collets that provide good concentricity between the drill and the machine spindle. Use a positive stop to prevent the tool from backing up into the holder. Radial runout in the tool assembly must be accurately checked and maintained.

### WORKPIECE

A secure and rigid workpiece will minimise deflection, and allow for better accuracy and true position of the hole.

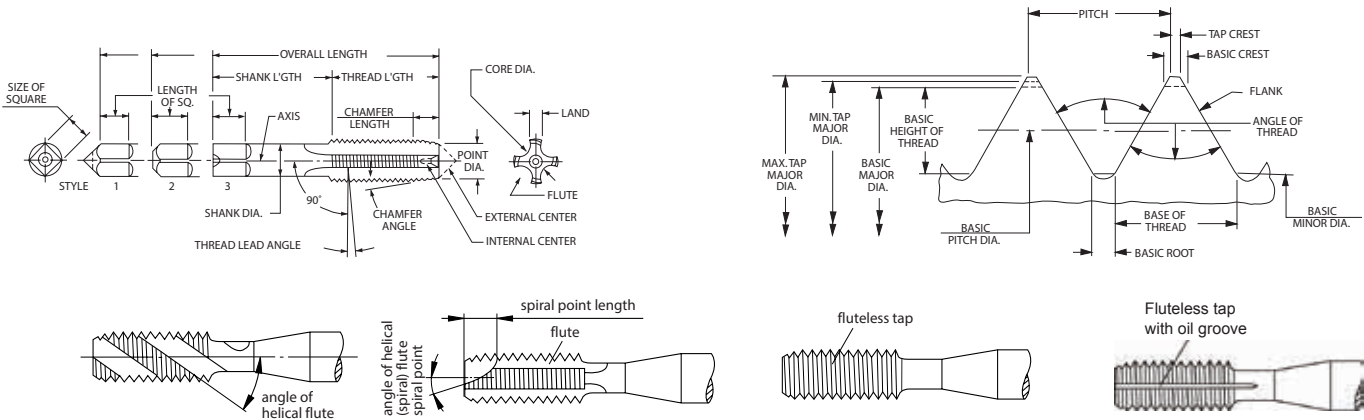
### FEEDS

It is important not to underfeed the drill which will cause it to dwell and dull. This is particularly true in work hardening materials. Feed rates should be high enough for proper chip formation.



In these drilling scenarios, reducing feed rate to 1/3 (33%) is generally recommended. Drilling into an entry angle of more than 10° is NOT recommended – surface should be milled flat first.

# Technical Section - Threading



**Allowance:** The minimum clearance or maximum interference which is intended between mating parts.

**Angle of Thread:** The angle included between the flanks of a thread measured in an axial plane.

**Back Taper:** A slight taper on the threaded portion of the tap making the pitch diameter near the shank smaller than that at the chamfer.

**Basic:** The theoretical or nominal standard size from which all variations are made.

**Chamfer:** The tapered and relieved cutting teeth at the front end of the threaded section. Common types of chamfer are taper, 8 to 10 pitches long, plug, 3 to 5 pitches and bottoming, 1 to 2 pitches.

**Crest:** The top surface joining the two sides or flanks of a thread.

**Cutting Face:** The leading side of the land.

**Flute:** The longitudinal channels formed on a tap to create cutting edges on the thread profile.

**Heel:** The following side of the land.

**Height of Thread:** In profile, distance between crest and bottom section of thread measured normal to the axis.

**Hook Face:** A concave cutting face of the land. This may be varied for different materials and conditions.

**Interrupted Thread:** Alternate teeth are removed in the thread helix on a tap; usually restricted to those having an odd number of flutes.

**Land:** One of the threaded sections between the flutes of a tap.

**Lead of Thread:** The distance a screw thread advances axially in one turn.

**Major Diameter:** The largest diameter of the screw or nut on a straight screw thread.

**Minor Diameter:** The smallest diameter of the screw or nut on a straight screw thread.

**Neck:** The reduced diameter, on some taps, between the threaded portion and the shank.

**Pitch:** The distance from a point on one thread to a corresponding point on the next thread, measured parallel to the axis.

**Pitch Diameter:** On a straight screw thread, the diameter of an imaginary cylinder where the width of the thread and the width of the space between threads is equal.

**Point Diameter:** The diameter at the leading end of the chamfered portion.

**Radial:** The straight face of a land, the plane of which passes through the axis of the tap.

**Rate:** The angle of the cutting face of the land in relation to an axial plane intersecting the cutting face at the major diameter.

**Relief:** The removal of metal behind the cutting edge to provide clearance between the part being threaded and a portion of the threaded land. Also, see back taper.

**CHAMFER RELIEF:** The gradual decrease in land height from cutting edge to heel on the chamfered portion of the tap land to provide radial clearance for the cutting edge.

**CON-ECCENTRIC RELIEF:** Radial relief in the thread form starting at the back of a concentric margin.

**ECCENTRIC THREAD RELIEF:** Radial relief in the thread form starting at the cutting edge and continuing to the heel.

**Root:** The bottom surface joining the flanks of two adjacent threads.

**Side or flank of thread:** The surface of the thread which connects the crest with the root.

**Shank:** The portion of the tap by which it is held and driven.

**Spiral Point:** An oblique cutting edge ground into the lands to provide a shear cutting action on the first few threads.

**Square:** The squared end of the tap shank.

**Thread:** The helical formed tooth of the tap which produces the thread in a tapped hole.

**Thread Lead Angle:** The angle made by the helix of the thread at the pitch diameter, with a plane perpendicular to the axis.

**Threads Per Inch:** The number of threads in one inch of length.

**Thread:**





**SINGLE:** A thread in which lead is equal to pitch.





**DOUBLE:** A thread in which lead is equal to twice the pitch.

**TRIPLE:** A thread in which lead is equal to triple the pitch.

# Technical Section - Threading

## TAP GEOMETRIES & APPLICATIONS

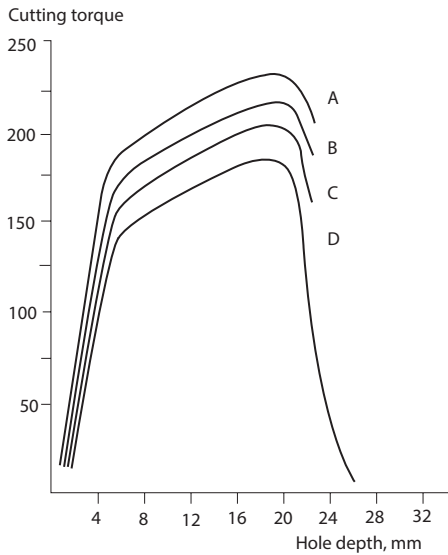
Description	Chips
<p><b>Taps with straight flutes</b></p> <p>Straight flutes are the most commonly used type of tap. Suitable for use on most materials, mainly short chipping steel and cast iron, they form the basis of the program.</p>	
<p><b>Taps with interrupted thread</b></p> <p>The interrupted thread ensures less friction and therefore less resistance, which is particularly important when threading material which is resilient and difficult to machine (e.g. aluminium, bronze). It is also easier for lubricant to penetrate to the cutting edges, thus helping to minimize the torque generated</p>	
<p><b>Spiral point taps</b></p> <p>The tap has a straight fairly shallow flute and is often referred to as a gun nose or spiral point tap. The gun nose or spiral point is designed to drive the chips forward. The relatively shallow flutes ensure that the sectional strength is maximised. They also act to allow lubricant to reach the cutting edges. This type of tap is recommended for threading through holes.</p>	
<p><b>Nut taps</b></p> <p>These taps are generally used to thread nuts but can be used also on deep through holes. They have a shank diameter smaller than the nominal and a longer overall length, because their function is to accumulate nuts.</p> <p>They are used on special machines designed to thread huge amounts of nuts. They can work in steel and stainless steel.</p> <p>The first serial tap has a very long chamfer, in order to spread the cutting load on almost two thirds of the thread length.</p>	

Description	Chips
<p><b>Taps with flutes only on the chamfer lead</b></p> <p>The cutting part of the tap is formed by gun nosing in the same manner as for a spiral point tap, the function being to drive the chips forward ahead of the cutting edges. This design is extremely rigid which facilitates good machining results. However, the short length of the gun nosing limits its application to a depth of hole less than about <math>1.5 \times \varnothing</math>.</p>	
<p><b>Taps with spiral flutes</b></p> <p>Taps with spiral flutes are intended primarily for threading in blind holes. The helical flute transports the chips back away from the cutting edges and out of the hole, thus avoiding packing of chips in the flutes or at the bottom of the hole. In this way, danger of breaking the tap or damaging the thread is minimised.</p>	
<p><b>Cold forming taps</b></p> <p>Cold forming taps differ from cutting taps in that the thread is produced by plastic deformation of the component material rather than by the traditional cutting action. This means that no chips are produced by their action. The application range is materials with good formability. Tensile strength (<math>R_m</math>) should not exceed <math>1200 \text{ N/mm}^2</math> and the elongation factor (<math>A_5</math>) should not be less than 10%.</p> <p>Cold forming taps without flutes are suitable for normal machining and are especially suitable when vertically tapping blind holes. They are also available with through coolant.</p>	
<p><b>Through coolant taps</b></p> <p>The performance of taps with through coolant holes is higher than the same taps used with external lubrication. These kinds of taps allow better evacuation of the chip, which is transported away from the cutting area itself. Wear on the cutting edge is reduced, since the cooling effect on the cutting zone is higher than the heat generation.</p> <p>Lubrication can be oil, emulsion or air pressurised with oil mist. Working pressure not less than 15 bar is required, but good results can be obtained with minimal lubrication.</p>	

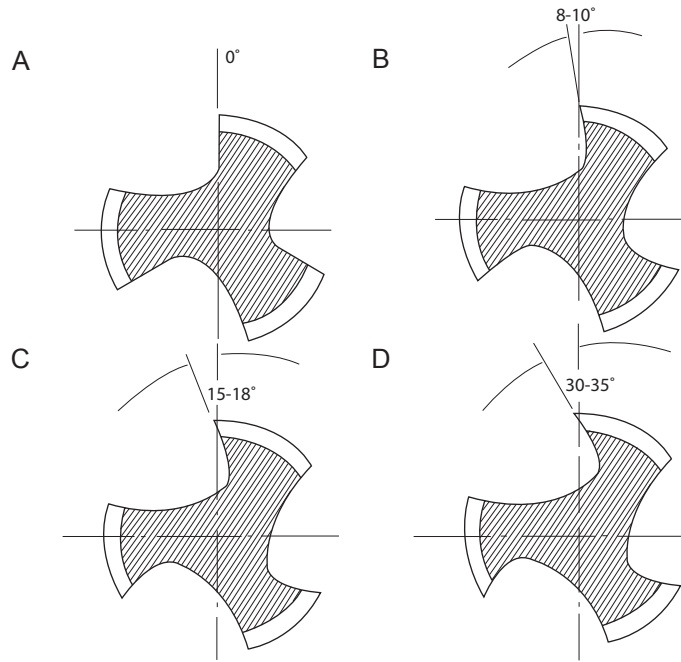
# Technical Section - Threading

## TAPPING TECHNICAL DATA

### Rake Angles

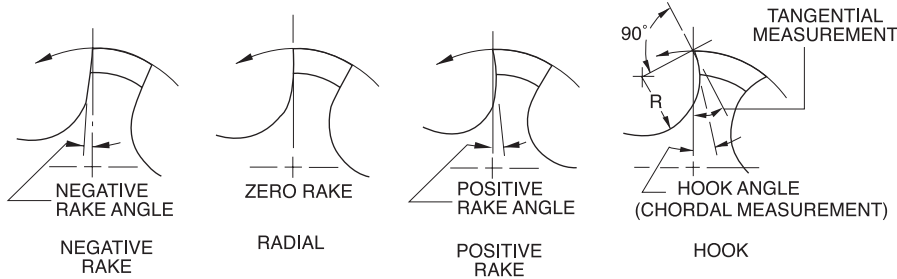


Threading tap M10 used with various rake angles in steel (low carbon steel)

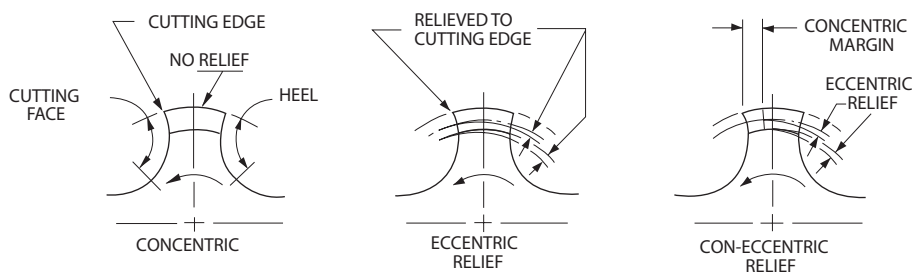


The rake angle has a primary influence on cutting forces and consequently the cutting torque and surface finish of the thread. Test results made with different rake angles are shown in the above diagram, illustrating how cutting torque

decreases with a larger rake angle. There is, however, a limit. A large rake angle means lower strength of the cutting edge.



### Relief Angles

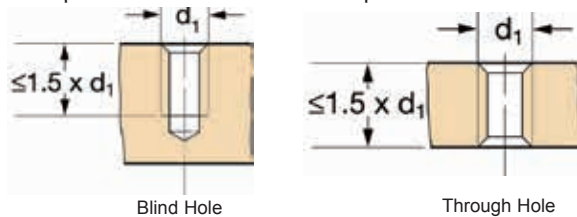


# Technical Section - Threading

## CUTTING CHAMFERS

The cutting part of a tap is the teeth of the chamfer on the leading end of the tap. The rest of the thread length is the cylindrical guiding part, which is slightly back-tapered for clearance. A decision on the best type of chamfer form has to be carefully made as both the tap life and quality of thread are greatly affected.

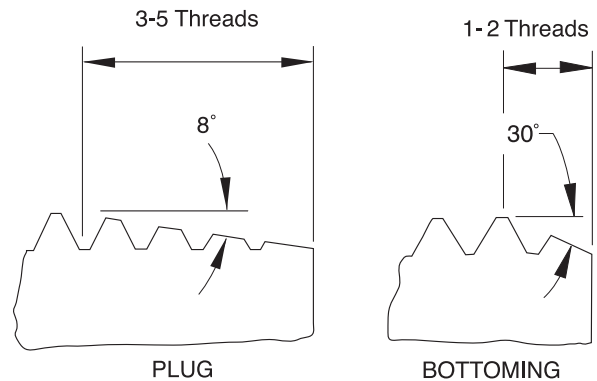
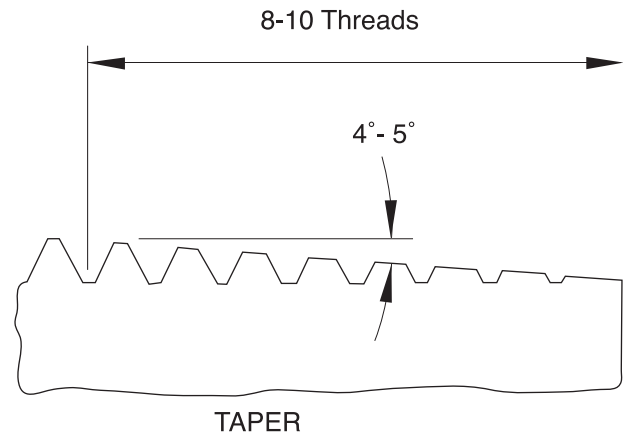
Generally, the form and length of chamfer depend on the type of hole to be tapped. Though holes do not normally cause difficulties whereas the tapping of blind holes can create certain problems associated with chip evacuation.



The length of the chamfer is determined by careful consideration of the following factors:

- The number of chamfer cutting teeth cannot be kept too low so as to avoid overloading, premature dulling and oversized or rough threads.
- A chamfer lead that is too long, however, increases the torque and the danger of breakage.

Commonly used chamfers are taper, plug and bottoming. Eight to ten cutting teeth per land are produced by a taper chamfer. A plug chamfer produces three to five cutting teeth per land and a bottoming chamfer one to two cutting teeth per land. The recommended radial relief behind the cutting edge of the chamfer portion is .004" to .005" relief per 1/16 of land width.



### Tapping Speeds

Correct tapping speeds are very important in obtaining efficient tapping results. There are many factors which affect tapping speeds, some of which are listed below:

#### Material Factors:

- Thermo-conductivity of the material and wall thickness as it affects heat dispersion.
- Variations in carbon content of steel.
- Hard spots in material.
- Depth of hole to be tapped.
- Percentage of full thread to be tapped.

#### Tap Factors:

- Major diameters, pitch and lead.
- Style of tap.
- Width of lands.
- Amount of hook or rake.
- Length of chamfer. Bottoming taps normally require slower speeds than plug chamfered taps

#### Mechanical Factors:

- Type of tapping machine and holder; Speeds for small diameter taps are often governed by the limitation of the machine.
- Condition of tapping machine and spindle.
- Type of fixture.
- Vertical or horizontal tapping (faster speeds for vertical tapping).
- Method of feeding the tap.
- Cutting fluid used and method of application.

The optimum speed for tapping is the highest speed that conditions permit, consistent with economic tool life.

Proper tapping speeds are determined best by experiment. In the table below the speeds shown should be used as a guide only, and the suggested surface feet per minute adjusted upward or downward until the best results are obtained.


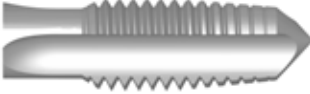






$$\text{RPM} = \frac{3.82 \times \text{SFM}}{D}$$

$$\text{SFM} = .26 \times \text{RPM} \times D$$

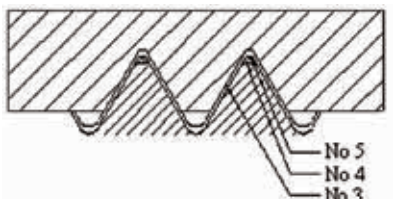
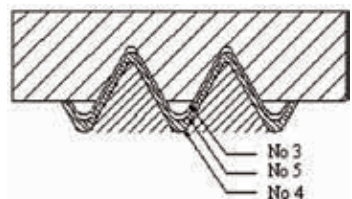
# Technical Section - Threading

## CHAMFER LENGTHS AND SERIAL TAPS

The first group (No. 1, No. 2, No. 3) includes taps with complete thread profile and the difference is in the chamfer length. The second group (No. 4, No. 5) includes taps with incomplete thread profile. They have lower pitch and outer diameter, compared to the complete standard, and longer chamfer. After using them, a finishing tap No. 3, must be used.

No. 1 =		6-8 x P	
No. 2 =		4-6 x P	
No. 3 =		2-3 x P	
No. 4 =		6-8 x P	
No. 5 =		3,5-5 x P	

 <p style="text-align: center;"><math>\varnothing \leq M10</math></p>	 <p style="text-align: center;"><math>\varnothing \geq M12</math></p>
--	---

<b>ISO</b>	<b>Set code number</b>	<b>Including tap number</b>
	No. 6	No. 1 + No. 2 + No. 3
	No. 7	No. 2 + No. 3
	No. 8	No. 4 + No. 5 + No. 3
<b>DIN</b>	<b>Set code number</b>	<b>Including tap number</b>
	No. 8	No.3 (form C) + No.4 (form A) + No.5 (form B)
<b>ANSI</b>	<b>Set code number</b>	<b>Including tap number</b>
	Hand Tap (No. 6)	Taper(No.1) + Plug(No.2) + Bottoming(No.3)



# Technical Section - Threading

## TAPPING TECHNICAL DATA

### The Relationship Between H-Limit and Class of Fit

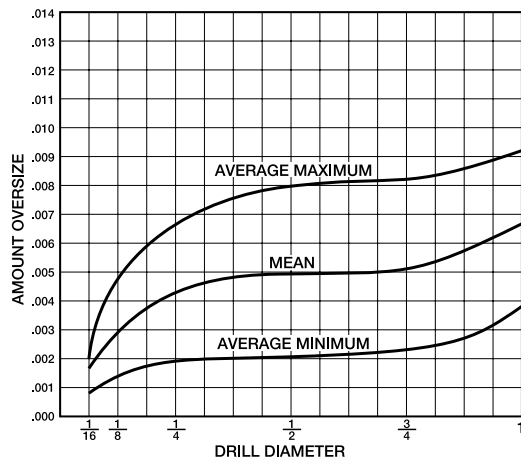
H-limits are used to properly size a tap for the threaded hole to be produced. They are selected based upon the tolerance required for the part. These tolerances are defined by the symbols class 1B, 2B, or 3B. Class 1B has the broadest tolerance and is generally applied to DIY (Do It Yourself) type nuts and bolts. Class 2B is the most common and is used for general fasteners and threaded parts. Class 3B is the tightest tolerance and used for close fit and high strength fastening applications, primarily in the automotive and aerospace industry.

Once the class of thread and part tolerance has been defined, an H-limit is selected to produce a thread that is within the minimum and maximum limits for that class of fit. These limits are the same as the Go and No Go thread plug gage dimensions. The goal is to select a tap with an H-limit that is near the middle of the part tolerance. For instance, if the total tolerance was .005", the tap should be approximately .0025" larger than the minimum limit of the part and .0025" smaller than the maximum. However, to handle the widest variety of tapping conditions, the "40% rule" is commonly used. Using this rule, the tap is placed at 40% of the part tolerance. For example, if the part tolerance is .005", multiplying .005" by 0.40 equals .002". Thus, the tap would be .002" larger than the minimum limit of the part or Go thread gage.

With the position of the tap in relationship to the part tolerance established, the selection of an H-limit number, such as H3, H4, H5, etc. is possible. H-limits are a sequence of size "steps" in .0005" increments beginning at the minimum size limit of the part, starting with H1. In other words, an H1 limit is one .0005" increment larger than the minimum limit of Go gage, an H2 is two .0005" increments (or .001) larger than the minimum limit, an H3 is three .0005" increments (or .0015") and so on. In the example above, a tap that is .002" larger than minimum limit, is four .0005" increments larger, or an H4. This would be the tap H-limit recommendation for this tolerance.

If after selecting the proper H-limit, an oversize or undersized thread exists, or if shrinkage due to heat treating or plating will occur, larger or smaller H-limits may be required to adjust to the condition.

### Probable Oversize Values For Drilled Holes



Drills will normally cut a hole larger in diameter than the drill itself. The amount depends upon the rigidity of the equipment, stiffness of the drill, accuracy of the point, the material being drilled, and many other contributing factors. However, averaging all factors, the chart below shows what might be expected with standard drills without guide bushings in steel or cast iron using good drilling practices and reasonable care in the resharpening of the drills.

Drills as received from our factory will usually drill hole sizes between the minimum and mean lines. Reconditioned drills, however, may produce hole sizes between the minimum and maximum lines depending upon drill wear, margin pick-up, and accuracy of resharpening.

#### PROBABLE OVERSIZE DIAMETERS IN DRILLING

Drill Dia., Inch	Amount Oversize, Inch		
	Average Max	Mean	Average Min.
1/16	.002	.0015	.001
1/8	.0045	.003	.001
1/4	.0065	.004	.002

Drill Dia., Inch	Amount Oversize, Inch		
	Average Max	Mean	Average Min.
1/2	.008	.005	.002
3/4	.008	.005	.003
1	.004	.009	.007

# Technical Section - Threading

## PITCH DIAMETER LIMITS

### Fractional and Machine Screw

All standard Ground Thread Taps will be marked with the letter G to designate Ground Thread. The letter G will be followed by the letter H to designate above basic (L below basic) and a numeral to designate the pitch diameter limits.

Example: G H3 indicates a Ground Thread Tap with pitch diameter limits .0010 to .0015 over basic

Pitch diameter limits for Taps to 1" diameter inclusive:

- L1 = Basic to Basic minus .0005
- H1 = Basic to Basic plus .0005
- H2 = Basic plus .0005 to Basic plus .0010
- H3 = Basic plus .0010 to Basic plus .0015
- H4 = Basic plus .0015 to Basic plus .0020
- H5 = Basic plus .0020 to Basic plus .0025
- H6 = Basic plus .0025 to Basic plus .0030

### Metric I.S.O

Where the tap pitch diameter is over or under basic thread pitch diameter by even multiples of .00052", the tap will be marked with the letter "D" or "DU" respectively, followed by a limit number. The limit number is determined as follows:

D Limit No. = Amt. Tap PD High Limit Is Over Basic PD  
.00052"

DU Limit No. = Amt. Tap PD Low Limit Is Under Basic PD  
.00052"

Examples:

M1.6 x .035 - for D3 limit, max. tap PD = basic plus .0015"  
Tap PD tolerance = minus .0006"

### Specials

Special taps are to be marked with the nominal diameter and number of threads per inch and form of thread as specified by the purchaser on his order or blue print provided such specifications are reasonably correct.

Special Ground Thread taps made to the pitch diameter limits shown will also be marked with the corresponding limit number.

When taps are specified to be a certain amount oversize or undersized, it is standard practice to add or subtract this amount from the basic pitch diameter of the nominal size tap. This dimension then becomes the new minimum pitch diameter for the special tap to which Standard Tolerance for the nominal size is added.

Pitch Diameter limits for Taps over 1" diameter to 1-1/2" diameter inclusive:

H4 = Basic plus .0010 to Basic plus .0020

Pitch Diameter limit numbers for taps not shown above or those over 1-1/2" diameter.

For taps with H or L limit numbers not shown above or over 1-1/2" diameter for example H12 or L10, the H or L limit number divided by 2 indicates in thousandths of an inch the amount the maximum tap pitch diameter is over basic in the H series or the amount the minimum tap pitch diameter is under basic on the L series.

M12 x 1.75-for D6 limit, max. tap PD = basic plus .0030"  
Tap PD tolerance = minus .0012"

M39 x 4-for D10 limit, max. tap PD = basic plus .0050"  
Tap PD tolerance = minus .0020"

M6 x 1-for DU 4 limit, min. tap PD = basic minus .0020"  
Tap PD tolerance = plus .0010"

Metric taps will be marked with a capital M followed by the nominal size in millimeters and the pitch in millimeters separated by the sign "x." For example, M1.6 x 0.35; M6 x 1; M10 x 1.5.

Undersize or oversize taps will be marked with the nominal size and pitch, followed by the amount the minimum pitch diameter is over or under basic. For example, 1/2-13+.010".

Whenever possible, in the case of oversize, undersize, or other special taps, orders should specify the minimum and maximum tap pitch diameter desired.

Left hand taps will be marked "Left Hand" or "LH."

# Technical Section - Threading

The limits and tolerances of external threads for unified screws are designated by the letter "A", which results in class 1A, class 2A, and class 3A screws. The nut (internal thread) limits and tolerances are designated by the letter "B" resulting in class 1B, class 2B, and class 3B.

**Tolerances:** The tolerance of the tapped hole in the unified series is always 1.3 times the tolerance of the screw for the same class of fit. In the American National Standard, pitch diameter tolerances on both the nut and the screw were equal with the nut above basic and the screw below basic.

**Class 1A and 1B:** This class of fit is intended to cover the manufacture of threaded parts where quick and easy assembly is necessary or desired and an allowance is provided to permit ready assembly.

**Class 2A and 2B:** This class of fit is intended to cover screws, bolts and nuts, but it is also suitable for a variety of other applications. An allowance is provided to minimize galling and seizure in assembling and use. It will also accommodate limited amount of plating, coating or finish.

**Class 3A and 3B:** This class of fit is provided for those applications where closeness of fit, accuracy of lead and angle of thread is important. No allowance is provided and these threads are obtained consistently only by use of high quality production equipment and checked by a very efficient system of gaging and inspection.

Unified and American standard threads have substantially the same thread form. Threads of both standards are mechanically interchangeable. The main difference between the two standards are: Variation of tolerance with size, differences in amounts of pitch diameter tolerance for external and internal threads, and differences in thread designations.

**Caution:** Select the proper percent of thread for the material to be tapped.

**Remember:** As the drilled hole becomes smaller the amount of chips to be removed becomes so great that the friction generated may require as much power as does the actual cutting.

## Technical Section - Threading

**TABLE OVER TAP TOLERANCE VS TOLERANCE ON INTERNAL THREAD (NUT)**

Tolerance class, Tap			Tolerance, Internal thread (Nut)					Application
ISO	DIN	ANSI BS						
ISO 1	4 H	3 B	4 H	5 H				Fit without allowance
ISO 2	6 H	2 B	4 G	5 G	6 H			Normal fit
ISO 3	6 G	1 B			6 G	7 H	8 H	Fit with large allowance
-	7 G	-				7 G	8 G	Loose fit for following treatment or coating

Thread tolerances for taps are collected in standard reference DIN 13.

Normal tolerance is ISO 2 (6H) on taps, which generates an average quality fit between screw and nut. Lower tolerance (ISO 1) generates a fine fit without a gap on the flanks between screw and nut. Higher tolerance (ISO 3) generates a rough fit, with large gap. It is used in the case of a nut which will later be coated or if a loose fit is preferred.

Between tolerances 6H (ISO2) and 6G (ISO3), as well as between 6G and 7G, the tap manufacturer produces taps with tolerance 6HX and 6GX. "X" means the tolerance is outside standard and it is used for taps working high strength material or abrasive material such as cast iron. These materials do not cause oversize problems, so higher tolerance can be used in order to increase tool life. The width of the tolerance is equal between, for example, 6H and 6HX.

Forming taps are usually produced with a 6HX or 6GX tolerance.

The tolerance icon for BSW and BSF is medium. This refers to BS 84 "medium fit".

Pipe threads with the tolerance icon "Normal" refer to the following standards:

- G threads to ISO 228-1. One class for internal thread (tap), and class A and B for external thread (die).
- R, Rc and R threads to ISO 7-1.
- NPT and NPSM to ANSI B1.20.1.
- NPTF and NPSF to ANSI B1.20.3.
- PG to DIN 40 430.

# Technical Section - Threading

## SELF-LOCKING THREAD FORM

### Concept

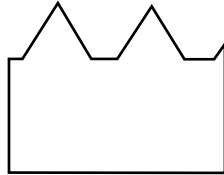
**Designed to produce threads for self-locking operations and put a lock on fastener costs.**

This is not to be confused as just another range of taps for a specific application. It is a thread form. Utilizing the latest generation CNC equipment this thread form can be produced on straight flute, spiral flute, spiral point, roll form and even the range of Applix high performance taps.

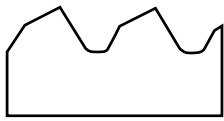
Although this is a made-to-order program, quantities of up to 48 pieces of any style would be delivered in no greater than 10 working days.

The relatively small quantities being produced and the additional thread grinding required does mean that taps featuring this thread form can be marginally more expensive than conventionally ground taps. Depending on the size, quantity, and/or the type of tool being compared, the additional cost will vary. However, before making a pure price decision we recommend a review of the added benefits of the concepts featured in this catalog and how they help in offsetting costs in other areas.

### Self-Locking Threads and How They Work



Standard Thread Form



Self-Locking Thread Form

Taps ground to the adjacent self-locking thread form produce a highly efficient female thread form with a 30° inclined wedge that provides optimum locking contact with the crests of the male threads of a standard bolt or screw. The thread form produced is ideal for a wide variety of applications where vibration resistance is a must. Clamping forces are evenly distributed along the entire length of thread engagement providing a capability to resist the forces created by vibration that can loosen ordinary threaded fasteners. The end result is a standard male fastener locked firmly in place without having to resort to the use of costly adhesives, locking devices or inserts.

On the smaller diameters, <8-32 but including 8-36, because of their size, the taps are ground with a modified ramp form.



### Key Features and Benefits

#### Improves Holding Power

A 30° wedge lock on the female thread creates a continuous spiral contact along the entire thread length for improved holding power versus standard thread forms.

#### Clamp Load More Evenly Distributed

Clamp load forces are spread evenly across all threads versus conventional 60° thread forms that

put the clamping force on the first few threads only with the other threads receiving limited or no contact at all.

#### Reduces Fastener Costs

Utilizing this thread form converts standard male fasteners into highly efficient self-locking ones and may eliminate the necessity for costly locking fasteners, chemical bonds, nylon plugs or other devices to maintain tightness.

#### Faster Assembly Operations

The larger tap drill size creates greater clearance with the male fastener than conventionally produced threads. In assembling fasteners produced with this thread form it is clearly noticeable that the fasteners turn more freely irrespective of whether by hand or utilizing assembly machinery. Assembly costs are lower and assembly related rejects are additionally reduced.

#### Holding Power that Lasts and Lasts

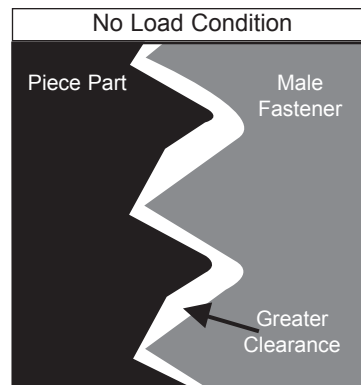
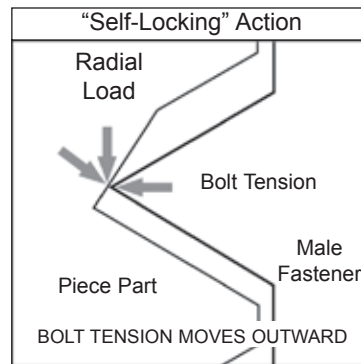
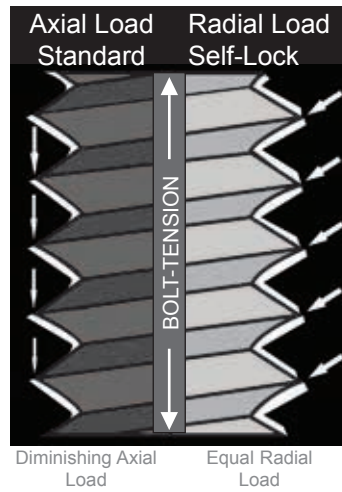
There is no loss of locking power in those applications requiring frequent loosening and tightening of the male fastener. This eliminates time intensive disassembly and assembly procedures. Conventional locking fasteners would be either destroyed or their locking power severely diminished.

#### Threading Solution for Soft Materials

The optimum load distribution provided by this thread form eliminates thread stripping that is typical with thread forms that concentrate clamping load on fewer threads. Ideal for aluminum and other lightweight, soft materials in applications where stripping is frequent.

#### Environmentally Friendly

Because the threads produced permit the male fastener to be locked in place by simply tightening, there is no necessity for bonding materials or chemical agents which eliminates the need for using potentially environmentally harmful products plus saving valuable time and cost.



# Technical Section - Threading

## SELF-LOCKING THREAD FORM

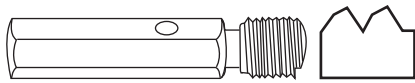
### Gaging for Self-Locking Threads

### How to Order

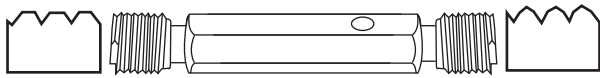
An essential element in high quality thread production is an accurate gaging capability. To facilitate the latter Precision offers a complete gaging system for self-locking threads, which consists of the following:

#### **LARGER DIAMETERS**

Go-Pitch Diameter and Ramp Gage



Hi-Pitch Diameter and Ramp Gage



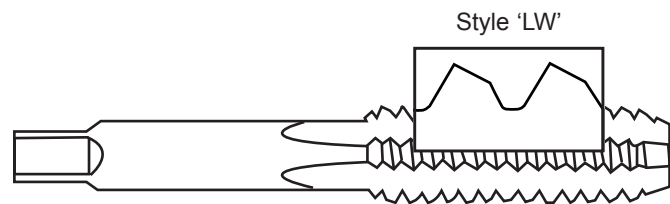
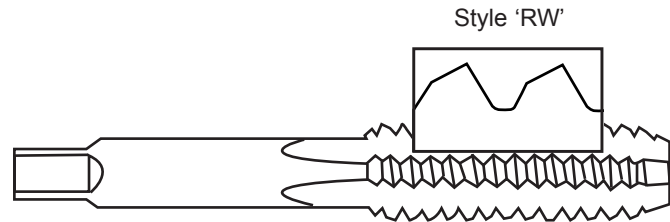
#### **SMALLER DIAMETERS**

Go-Pitch Diameter and Ramp Gage      Hi-Limit Gage



Precision certifies all new gages for self-locking threads to insure their functional accuracy. A certificate of compliance can be provided for a nominal charge. It is highly recommended that they be returned on a periodic basis for recertification.

When placing your inquiry for a self-locking tap, simply advise the type of gage(s) you require and one consistent with whatever size is ordered will be quoted and supplied.



Unless otherwise specified, the taps will be provided featuring a ramp angle in the direction detailed and referred to as style "RW."

When tapping is to be effected from the opposite end of a through hole, the style "LW" must be special ordered. This style features the ramp angle in the opposite direction as detailed, and is generally used in the production of nuts.

There is no requirement to specify an H or D limit. Basically, one size fits all because contact is not made on the thread flanks but on the wedge ramp.

To place an order call or fax Customer Service at:  
TEL: 1-800-877-3745 • FAX: 1-815-459-2804

Simply identify the following:

- The List No. or description of the standard tap.
- The size, number of flutes and chamfer requirements.
- The ramp style (RW or LW).

Should a gage be required, simply indicate the type when placing the order.

# Technical Section - Threading

## TAP DRILL SIZES FOR UNIVERSAL AND M-PROFILE SCREW THREADS

Tap Size	Tap Drill Size	Decimal Equiv. of Tap Drill (inches)	Theoretical Percent of Thread	Probable Mean Oversize (inches)	Probable Hole Size (inches)	Probable % of Thread (inches)	Tap Size	Tap Drill Size	Decimal Equiv. of Tap Drill (inches)	Theoretical Percent of Thread	Probable Mean Oversize (inches)	Probable Hole Size (inches)	Probable % of Thread (inches)
0-80	56	.0465	83	.0015	.0480	74	8-36	29	.1360	78	.0029	.1389	70
—	3/64	.0469	81	.0015	.0484	71	—	3.5mm	.1378	72	.0029	.1407	65
—	1.20mm	.0472	79	.0015	.0487	69	10-24	27	.1440	85	.0032	.1472	79
—	1.25mm	.0492	67	.0015	.0507	57	—	3.70mm	.1457	82	.0032	.1489	76
1-64	54	.0550	89	.0015	.0565	81	—	26	.1470	79	.0032	.1502	74
—	1.45mm	.0571	78	.0015	.0586	71	—	25	.1495	75	.0032	.1527	69
—	53	.0595	67	.0015	.0610	59	—	24	.1520	70	.0032	.1552	64
1-72	1.5mm	.0591	77	.0015	.0606	68	10-32	5/32	.1563	83	.0032	.1595	75
—	53	.0595	75	.0015	.0610	67	—	22	.1570	81	.0032	.1602	73
—	1.55mm	.0610	67	.0015	.0606	68	—	21	.1590	76	.0032	.1622	68
2-56	51	.0670	82	.0017	.0687	74	12-24	11/64	.1719	82	.0035	.1754	75
—	1.75mm	.0689	73	.0017	.0706	66	—	17	.1730	79	.0035	.1765	73
—	50	.0700	69	.0017	.0717	62	—	16	.1770	72	.0035	.1805	66
—	1.80mm	.0709	65	.0017	.0726	58	12-28	16	.1770	84	.0035	.1805	77
2-64	50	.0700	79	.0017	.0717	70	—	15	.1800	78	.0035	.1835	70
—	1.80mm	.0709	74	.0017	.0726	66	—	4.60mm	.1811	75	.0035	.1846	67
—	49	.0730	64	.0017	.0747	56	—	14	.1820	73	.0035	.1855	66
3-48	48	.0760	85	.0019	.0779	78	1/4-20	9	.1960	83	.0038	.1998	77
—	5/64	.0781	77	.0019	.0800	70	—	8	.1990	79	.0038	.2028	73
—	47	.0785	76	.0019	.0804	69	—	7	.2010	75	.0038	.2048	70
—	2.00mm	.0787	75	.0019	.0806	68	—	13/64	.2031	72	.0038	.2069	66
—	46	.0810	67	.0019	.0829	60	1/4-28	5.40mm	.2126	81	.0038	.2164	72
—	45	.0820	63	.0019	.0839	56	—	3	.2130	80	.0038	.2168	72
3-56	46	.0810	78	.0019	.0829	69	—	F	.2570	77	.0038	.2608	72
—	45	.0820	73	.0019	.0839	65	—	6.60mm	.2598	73	.0038	.2636	68
—	2.10mm	.0827	70	.0019	.0846	62	—	G	.2610	71	.0041	.2651	66
—	2.15mm	.0846	62	.0019	.0865	54	5/16-18	H	.2660	86	.0041	.2701	78
4-40	44	.0860	80	.0020	.0880	74	—	6.80mm	.2677	83	.0041	.2718	75
—	2.20mm	.0866	78	.0020	.0886	72	—	I	.2720	75	.0041	.2761	67
—	43	.0890	71	.0020	.0910	65	3/8-16	7.80mm	.3071	84	.0044	.3115	78
—	2.30mm	.0906	66	.0020	.0926	60	—	7.90mm	.3110	79	.0044	.3154	73
4-48	2.35mm	.0925	72	.0020	.0926	62	—	5/16	.3125	77	.0044	.3169	72
—	42	.0935	68	.0020	.0955	71	—	O	.3160	73	.0044	.3204	68
—	3/32	.0938	68	.0020	.0958	60	3/8-24	21/64	.3281	87	.0044	.3325	79
—	2.40mm	.0945	65	.0020	.0965	57	—	8.40mm	.3307	82	.0044	.3351	74
5-40	40	.0980	83	.0023	.1003	76	—	Q	.3320	79	.0044	.3364	71
—	39	.0995	79	.0023	.1018	71	—	8.50mm	.3346	75	.0044	.3390	67
—	38	.1015	72	.0023	.1038	65	7/16-14	T	.3580	86	.0046	.3626	81
—	2.60mm	.1024	70	.0023	.1047	63	—	23/64	.3594	84	.0046	.3640	79
5-44	38	.1015	79	.0023	.1038	72	—	9.20mm	.3622	81	.0046	.3668	76
—	2.60mm	.1024	77	.0023	.1047	69	—	9.30mm	.3661	77	.0046	.3707	72
—	37	.1040	71	.0023	.1063	63	—	U	.3680	75	.0046	.3726	70
6-32	37	.1040	84	.0023	.1063	78	—	9.40mm	.3701	73	.0046	.3747	68
—	36	.1065	78	.0023	.1088	72	7/16-20	W	.3860	79	.0046	.3906	72
—	7/64	.1094	70	.0026	.1120	64	—	25/64	.3906	72	.0046	.3952	65
—	35	.1100	69	.0026	.1126	63	—	10.50mm	.4134	87	.0047	.4181	82
—	34	.1100	67	.0026	.1136	60	—	27/64	.4219	78	.0047	.4266	73
6-40	34	.1110	83	.0026	.1136	75	1/2-13	10.50mm	.4134	87	.0047	.4181	82
—	33	.1130	77	.0026	.1156	69	—	29/64	.4531	72	.0047	.4578	65
—	2.90mm	.1142	73	.0026	.1168	65							
—	32	.1160	68	.0026	.1186	60							
8-32	3.40mm	.1339	74	.0029	.1368	67							
—	29	.1360	69	.0029	.1389	62							

## TAP DRILL SIZES FOR METRIC M-PROFILE SCREW THREADS

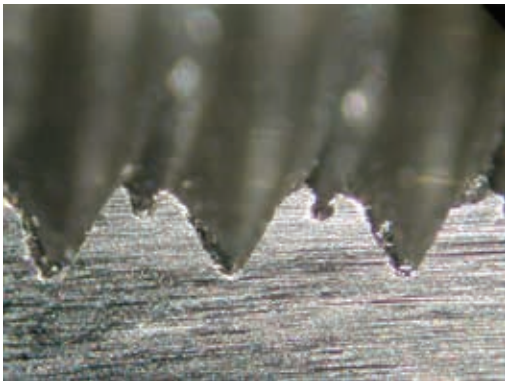
Metric of Tap	Tap Drill	Decimal Equiv. of Tap Drill	Theoretical Percent of Thread	Probable Mean Oversize	Probable Hole Size	Probable Percent Thread	Metric of Tap	Tap Drill	Decimal Equiv. of Tap Drill	Theoretical Percent of Thread	Probable Mean Oversize	Probable Hole Size	Probable Percent Thread
M1.6 x 0.35	1.20mm	.0472	88	.0014	.0486	80	M5 x 0.8	4.2mm	.1654	77	.0032	.1686	69
—	1.25mm	.0492	77	.0014	.0506	69	—	19	.1660	75	.0032	.1692	68
M2 x 0.4	1/16	.0625	79	.0015	.0640	72	M6 x 1	10	.1935	84	.0038	.1973	76
—	1.60mm	.0630	77	.0017	.0647	69	—	9	.1960	79	.0038	.1998	71
—	52	.0635	74	.0017	.0652	66	—	5mm	.1969	77	.0038	.2006	70
M2.5 x 0.45	2.05mm	.0807	77	.0019	.0826	69	—	8	.1990	73	.0038	.2028	65
—	46	.0810	76	.0019	.0829	67	M7 x 1	A	.2340	81	.0038	.2378	74
—	45	.0820	71	.0019	.0839	63	—	6mm	.2362	77	.0038	.2400	70
M3 x 0.5	40	.0980	79	.0023	.1003	70	—	B	.2380	74	.0038	.2418	66
—	2.5mm	.0984	77	.0023	.1007	68	M8 x 1.25	6.7mm	.2638	80	.0041	.2679	74
—	39	.0995	73	.0023	.1018	64	—	17/64	.2656	77	.0041	.2697	71
M3.5 x 0.6	33	.1130	81	.0026	.1156	72	—	H	.2660	77	.0041	.2701	70
—	2.9mm	.1142	77	.0026	.1168	68	—	6.8mm	.2677	74	.0041	.2718	68
—	32	.1160	71	.0026	.1186	63	M10 x 1.5	8.4mm	.3307	82	.0044	.3344	3351
M4 x 0.7	3.2mm	.1260	88	.0029	.1289	80	—	Q	.3320	80	.0044	.3364	75
—	30	.1285	81	.0029	.1314	73	—	8.5mm	.3346	77	.0044	.3390	71
—	3.3mm	.1299	77	.0029	.1328	69	M12 x 1.5	10.4mm	.4094	81	.0047	.4141	4141
M4.5 x 0.75	3.7mm	.1457	82	.0032	.1489	74	—	Z	.4130	77	.0047	.4177	71
—	26	.1470	79	.0032	.1502	70	M12 x 1.75	10.20mm	.4016	79	.0047	.4063	4063
—	25	.1495	72	.0032	.1527	64	—	Y	.4040	76	.0047	.4087	71
							—	13/32	.4062	74	.0047	.4109	69

**Note:** "Probable Hole Size" columns listed above apply to HSS/HSCo Drills ONLY. When using Solid Carbide Drills as Tap-Drills you must ADD the average Oversize amount per diameter to the size listed in these "Probable Hole Size" columns.

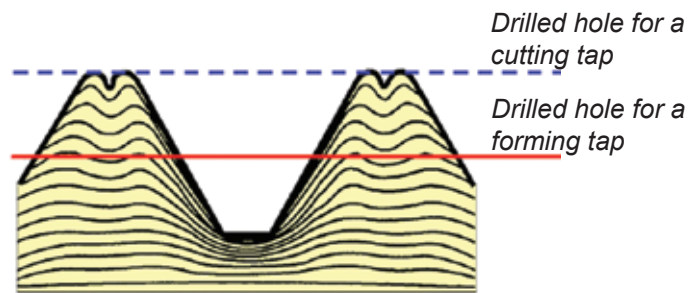
# Technical Section - Threading

## FLOW OF MATERIAL WHEN FORMING A THREAD

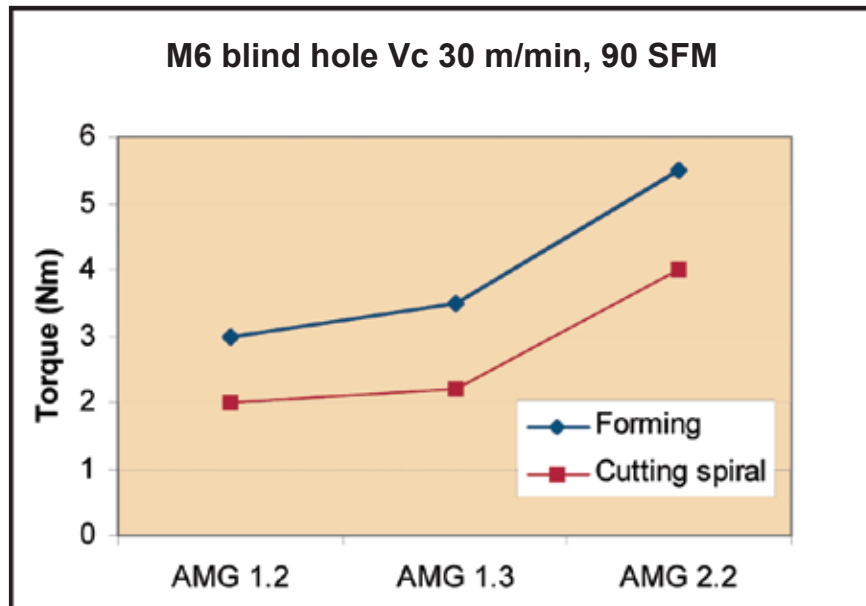
The tapping hole size depends upon the material being drilled, the cutting conditions selected and the condition of the equipment being used. If material is pushed up at the thread entry by the tap and/or the life of the tap is too short, select a slightly larger drill diameter. If on the other hand the profile of the thread formed is insufficient, then select a slightly smaller drill diameter.



Section of thread obtained by forming tap on steel C45



Cold forming taps require more power on the spindle, compared to a cutting tap of the same size, since it generates higher torque.



Torque comparison between forming and cutting taps in different material groups.



# Technical Section - Threading

**Note:** Recommended thread percentage for various (Inch standard) tap sizes is shown in the “60% Thread “ columns below. This is also the average percentage that is desirable for metric sizes. Use the “Probable Percent of Thread” column in the “Metric Sizes” tables below.

## TAP DRILL SIZES FOR FORMING TAPS

### Machine Screw Sizes

Tap Size	75% Thread		70% Thread		65% Thread		60% Thread		55% Thread		50% Thread	
	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size
0-80	0.0536	1.35mm	0.0540	1.35mm	0.0545	—	0.0549	54	0.0554	54	0.0558	1.0mm
1-64	0.0650	1.65mm	0.0655	1.65mm	0.0661	—	0.0666	—	0.0672	51	0.0677	51
1-72	0.0659	1.65mm	0.0663	—	0.0669	1.7mm	0.0673	51	0.0679	51	0.0683	—
2-56	0.0769	1.95mm	0.0774	1.95mm	0.0781	23498	0.0787	47	0.0794	2.0mm	0.0799	—
2-64	0.0780	5/64	0.0785	47	0.0791	2.0mm	0.0796	2.0mm	0.0802	—	0.0807	2.05mm
3-48	0.0884	2.25mm	0.0890	43	0.0898	43	0.0905	2.3mm	0.0913	2.3mm	0.0919	—
3-56	0.0899	43	0.0904	—	0.0911	2.3mm	0.0917	2.3mm	0.0924	2.35mm	0.0929	2.35mm
4-40	0.0993	2.5mm	0.1000	39	0.1010	39	0.1018	38	0.1028	2.6mm	0.1035	2.6mm
4-48	0.1014	38	0.1020	38	0.1028	2.6mm	0.1035	2.6mm	0.1043	37	0.1049	37
5-40	0.1123	34	0.1130	33	0.1140	33	0.1148	2.9mm	0.1158	32	0.1165	32
5-44	0.1134	33	0.1141	2.9mm	0.1150	2.9mm	0.1157	—	0.1166	32	0.1173	32
6-32	0.1221	3.1mm	0.1230	3.1mm	0.1243	—	0.1252	40916	0.1264	3.2mm	0.1274	—
6-40	0.1253	1/8	0.1260	3.2mm	0.1270	3.2mm	0.1278	3.25mm	0.1288	30	0.1295	30
8-32	0.1481	3.75mm	0.1490	—	0.1503	25	0.1512	3.8mm	0.1524	24	0.1534	3.9mm
8-36	0.1498	25	0.1507	3.8mm	0.1518	24	0.1526	24	0.1537	3.9mm	0.1546	23
10-24	0.1688	—	0.1700	18	0.1717	23682	0.1729	23682	0.1746	—	0.1758	—
10-32	0.1741	17	0.1750	—	0.1763	—	0.1772	16	0.1784	4.5mm	0.1794	—
12-24	0.1948	10	0.1960	9	0.1977	5.0mm	0.1989	8	0.2006	5.1mm	0.2018	7
12-28	0.1978	5.0mm	0.1989	8	0.2003	8	0.2014	7	0.2028	—	0.2039	13/64

### Fractional Sizes

Tap Size	75% Thread		70% Thread		65% Thread		60% Thread		55% Thread		50% Thread	
	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size	Theor. Hole Size	Nearest Drill Size
1/4-20	.2245	5.7mm	.2260	—	.2280	1	.2295	1	.2315	—	.2330	5.9mm
1/4-28	.2318	—	.2329	5.9mm	.2343	A	.2354	15/64	.2368	6.0mm	.2379	B
5/16-18	0.2842	7.2mm	.2861	7.25mm	.2879	7.3mm	.2898	L	.2917	7.4mm	.2936	—
5/16-24	0.2912	7.4mm	.2927	—	.2941	M	.2955	7.5mm	.2969	19/64	.2983	7.6mm
3/8-16	.3431	11/32	.3452	8.75mm	.3474	S	.3495	8.9mm	.3516	—	.3537	9.0mm
3/8-24	.3537	9.0mm	.3552	9.0mm	.3566	—	.3580	T	.3594	23/64	.3608	—
7/16-14	.4011	—	.4035	Y	.4059	13/32	.4084	—	.4108	—	.4132	Z
7/16-20	0.4120	Z	.4137	10.5mm	.4154	—	.4171	—	.4188	—	.4205	—
1/2-13	.4608	—	.4634	—	.4660	—	.4686	15/32	.4712	12mm	.4738	12mm
1/2-20	.4745	—	.4762	—	.4779	—	.4796	—	.4813	—	.4830	31/64

### Metric Sizes

Metric Tap Size	Tap Drill Size	Decimal Equiv. of Tap Drill (inches)	Theoretical Percentage of thread %	Probable Mean Oversize (inches)	Probable Hole Size (inches)	Probable Percent of Thread %	Metric Tap Size	Tap Drill Size	Decimal Equiv. of Tap Drill (inches)	Theoretical Percentage of thread %	Probable Mean Oversize (inches)	Probable Hole Size (inches)	Probable Percent of Thread %
M3 x 0.5	36	0.1065	86	.0026	.1091	67	M8 x 1.25	7.4mm	0.2910	71	.0042	.2952	59
—	2.7mm	0.1062	88	.0026	.1088	70	—	L	0.2900	75	.0042	.2942	62
M4 x 0.7	27	0.1440	72	.0032	.1472	54	—	7.3mm	.2874	82	.0042	.2916	70
—	3.6mm	.1417	84	.0032	.1449	67	M10 x 1.5	U	0.3680	64	.0046	.3726	53
—	9/64	.1406	90	.0032	.1438	73	—	9.3mm	0.3660	69	.0046	.3706	58
M5 x 0.8	14	0.1820	69	.0035	.1855	53	—	9.2mm	0.3620	78	.0046	.3666	67
—	4.6mm	.1811	74	.0035	.1846	57	—	23/64	.3594	85	.0046	.3640	74
—	15	.1800	79	.0035	.1835	62	M12 x 1.5	11.3mm	.4449	70	.0047	.4496	57
—	16	0.1770	92	.0035	.1805	76	—	7/16	.4375	86	.0047	.4422	75
M6 x 1	7/32	.2188	65	.0038	.2226	51	M12 x 1.75	7/16	.4375	75	.0047	.4422	65
—	5.4mm	.2126	88	.0038	.2164	74	—	11mm	.4331	84	.0047	.4378	73

\*Probable percent of full thread produced in tapped hole using standard drill sizes.

# Technical Section - Threading

## TAP PROJECTION AND HOLE SIZE FOR PIPE TAPS

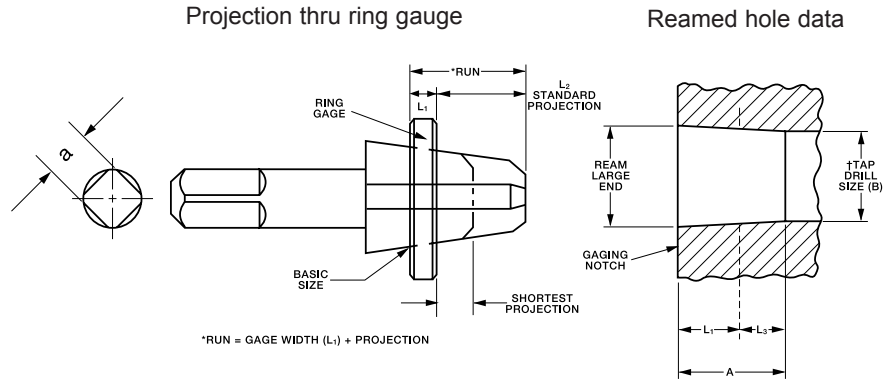
Nominal Size	Tap Thread Limits		Taper Per Ft. Limits		Projection				Ream Dia. Large End	Gage Width		A	Tap Drill Size B	Tap Drill Size BB
	L <sub>2</sub>	L <sub>2</sub> Tolerance	Min.	Max.	NPT & NPTF		SAE - Short			L <sub>1</sub>	L <sub>3</sub>			
1/16 - 27	0.3120	±1/16	23/32	25/32	.250	0.3750	.222	.259	.2515	0.1600	.1111	.2711	15/64	C
1/8 - 27	0.3120	±1/16	23/32	25/32	.250	.375	.222	.259	.3440	0.1615	.1111	.2726	21/64	Q
1/4 - 18	0.4590	±1/16	23/32	25/32	.397	0.5210	.333	.389	.4472	0.2278	.1667	.3945	27/64	7/16
3/8 - 18	0.4540	±1/16	23/32	25/32	.392	.516	.333	0.3890	.5826	0.2400	.1667	.4067	9/16	9/16
1/2 - 14	0.5790	±1/16	23/32	25/32	.517	.641	.429	0.5000	.7213	0.3200	.2143	.5343	11/16	45/64
3/4 - 14	0.5650	±1/16	23/32	25/32	.503	0.6270	.429	.500	.9317	0.3390	.2143	.5533	57/64	29/32
1 - 11-1/2	0.6780	±3/32	23/32	25/32	.584	.772	—	—	1.1691	0.4000	.2609	.6609	1-1/8	1-9/64
1-1/4 - 11-1/2	0.6860	±3/32	23/32	25/32	.592	0.7800	—	—	1.5138	0.4200	.2609	.6809	1-15/32	1-31/64
1-1/2 - 11-1/2	0.6990	±3/32	23/32	25/32	.606	0.7920	—	—	1.7528	0.4200	.2609	.6809	1-45/64	1-23/32
2 - 11-1/2	0.6670	±3/32	23/32	25/32	.574	.760	—	—	2.2267	0.4360	.2609	.6909	2-11/64	2-3/16

### TOLERANCES

Ground Thread = A maximum lead deviation of plus or minus .0005" within any two threads no further apart than 1" is permitted.

Threads per inch	Angle Tolerance
	Half Angle
8	Ground Thread
	25' Plus or Minus
11-1/2 to 27 inclusive	30' Plus or minus

\*Distance small end of tap projects through L<sub>1</sub> Taper Thread Ring Gage.  
 \*\*Recommended sizes given permit direct tapping without reaming the hole, but only give a full thread for approx. L<sub>1</sub> distance.  
 \*\*\*TAP DRILL SIZE (B) is size for use with a taper reamer. The tap drill size for use without a taper reamer is shown in column BB



## RECOMMENDED MINOR DIAMETERS AND TAP DRILLS FOR STI SPIRAL POINT AND HAND TAPS

Nominal Diameter	T.R.I.		Aluminum				Plastic - Steel - Magnesium			
	UNC	UNF	Diameter of Tapped Holes		Recommended Minor/ Drill Size		Diameter of Tapped Holes		Recommended Minor/ Drill Size	
			Min.	Max.	Tap Drill Size	Dec Eq.	Min.	Max.	Tap Drill Size	Dec Eq.
4	40	—	.1160	.1210	31	.1200	.1190	.1240	31	.1200
6	32	—	.1440	.1500	26	.1470	.1480	.1540	25	.1495
8	32	—	.1700	.1760	17	.1730	.1740	.1800	16	.1770
10	24	—	.1990	.2050	13/64	.2031	.2030	.2090	5	.2055
10	—	32	.1960	.2020	7	.2010	.2000	.2060	13/64	.2031
1/4	20	—	.2610	.2670	H	.2660	.2650	.2710	H	.2660
1/4	—	28	.2570	.2640	G	.2610	.2610	.2680	6.7MM	.2638
5/16	18	—	.3280	.3340	Q	.3320	.3310	.3370	Q	.3320
5/16	—	24	.3230	.3300	21/64	.3281	.3270	.3340	21/64	.3281
3/8	16	—	.3900	.3980	X	.3970	.3960	.4020	X	.3970
3/8	—	24	.3850	.3920	25/64	.3906	.3890	.3960	25/64	.3906
7/16	14	—	.4530	.4630	29/64	.4531	.4610	.4710	29/64	.4531
7/16	—	20	.4500	.4580	29/64	.4531	.4530	.4610	29/64	.4531
1/2	13	—	.5150	.5250	33/64	.5156	.5230	.5330	17/64	.5312
1/2	—	20	.5130	.5220	33/64	.5156	.5150	.5240	17/64	.5312

# Technical Section - Threading

## TAP SIZE RECOMMENDATIONS FOR CLASSES 2B AND 3B

### Machine Screw Sizes

Size	Threads Per Inch		Recommended Tap for Class of Thread		Pitch Diameter Limits for Class of Thread		
	NC	NF	Class 2B	Class 3B	Min. All Classes (Basic)	Max Class 2B	Max Class 3B
0	—	80	H2	H1	.0519	.0542	.0536
1	64	—	H2	H1	.0629	.0655	.0648
1	—	72	H2	H1	.0640	.0665	.0659
2	56	—	H2	H1	.0744	.0772	.0765
2	—	64	H2	H1	.0759	.0786	.0779
3	48	—	H2	H1	.0855	.0885	.0877
3	—	56	H2	H1	.0874	.0902	.0895
4	40	—	H2	H2	.0958	.0991	.0982
4	—	48	H2	H1	.0985	.1016	.1008
5	40	—	H2	H2	.1088	.1121	.1113
5	—	44	H2	H1	.1102	.1134	.1126
6	32	—	H3	H2	.1177	.1214	.1204
6	—	40	H2	H2	.1218	.1252	.1243
8	32	—	H3	H2	.1437	.1475	.1465
8	—	36	H2	H2	.1460	.1496	.1487
10	24	—	H3	H3	.1629	.1672	.1661
10	—	32	H3	H2	.1697	.1736	.1726
12	24	—	H3	H3	.1889	.1933	.1922
12	—	28	H3	H3	.1928	.1970	.1959

### Fractional Sizes

Size	Threads Per Inch		Recommended Tap For Class of Thread		Pitch Diameter Limits For Class of Thread		
	NC	NF	Class 2B	Class 3B	Min. All Classes (Basic)	Max Class 2B	Max Class 3B
1/4	20	—	H5	H3	.2175	.2223	.2211
1/4	—	28	*H4	H3	.2268	.2311	.2300
5/16	18	—	H5	H3	.2764	.2817	.2803
5/16	—	24	*H4	H3	.2854	.2902	.2890
3/8	16	—	H5	H3	.3344	.3401	.3387
3/8	—	24	*H4	H3	.3479	.3528	.3516
7/16	14	—	H5	H3	.3911	.3972	.3957
7/16	—	20	H5	H3	.4050	.4104	.4091
1/2	13	—	H5	H3	.4500	.4565	.4548
1/2	—	20	H5	H3	.4675	.4731	.4717
9/16	12	—	H5	H3	.5084	.5152	.5135
9/16	—	18	H5	H3	.5264	.5323	.5308
5/8	11	—	H5	H3	.5660	.5732	.5714
5/8	—	18	H5	H3	.5889	.5949	.5934
3/4	10	—	H5	H5	.6850	.6927	.6907
3/4	—	16	H5	H3	.7094	.7159	.7143
7/8	9	—	H6	H4	.8028	.8110	.8089
7/8	—	14	H6	H4	.8286	.8356	.8339
1	8	—	H6	H4	.9188	.9276	.9254
1	—	12	H6	H4	.9459	.9535	.9516

\* Note: In cast iron applications we recommend style 1600 (H5 limit) for class 2B fit.

### Metric Sizes for Class 6H

Thread Size		Internal Thread-Class 6H (Inches)				Recommended Tap		
Nominal Dia. (mm)	Pitch (mm)	Minor Dia.		Pitch Dia.		Major Dia.	Tap Size	Limit Number
		Min.	Max.	Min.	Max.			
1.6	0.35	.0481	.0520	.0541	.0574	.0630	M1.6 x 0.35	D-3
2	0.4	.0617	.0661	.0686	.0720	.0788	M2 x 0.4	D-3
2.5	0.45	.0793	.0841	.0870	.0906	.0985	M2.5 x 0.45	D-3
3	0.5	.0969	.1023	.1054	.1092	.1182	M3 x 0.5	D-3
3.5	0.6	.1123	.1185	.1225	.1268	.1378	M3.5 x 0.6	D-4
4	0.7	.1277	.1347	.1396	.1442	.1575	M4 x 0.7	D-4
4.5	0.75	.1452	.1526	.1580	.1626	.1772	M4.5 x 0.75	D-4
5	0.8	.1628	.1706	.1764	.1812	.1969	M5 x 0.8	D-4
6	1.0	.1936	.2028	.2107	.2165	.2363	M6 x 1	D-5
7	1.0	.2330	.2422	.2500	.2559	.2756	M7 x 1	D-5
8	1.25	.2617	.2721	.2830	.2892	.3150	M8 x 1.25	D-5
10	1.5	.3298	.3415	.3554	.3624	.3937	M10 x 1.5	D-6
12	1.75	.3979	.4110	.4277	.4355	.4725	M12 x 1.75	D-6
14	2.0	.4660	.4807	.5001	.5083	.5512	M14 x 2	D-7
16	2.0	.5447	.5594	.5788	.5871	.6300	M16 x 2	D-7
20	2.5	.6809	.6985	.7235	.7322	.7875	M20 x 2.5	D-7
24	3.0	.8171	.8366	.8682	.8785	.9449	M24 x 3	D-8
30	3.5	1.0320	1.0539	1.0917	1.1026	1.1812	M30 x 3.5	D-9
36	4.0	1.2469	1.2704	1.3151	1.3268	1.4174	M36 x 4	D-9

### Forming Type Taps Machine Screw and Fractional Sizes

Tap Size	Basic	Tap Recommendations For Class 2B Fit		Tap Recommendations For Class 3B Fit		Oversize Forming Taps		Tap Size UNC-NF	Basic P.D.	Tap Recommendations For Class 2B Fit		Tap Recommendations For Class 3B Fit		Oversize Forming Taps	
		Styles	Max. PD. Thread	Styles	Max. PD. Thread	Styles	Max. PD. Thread			Styles	Max. PD. Thread	Styles	Max. PD. Thread	Styles	Max. PD. Thread
0-80	.0519	—	—	H-2	.0536	—	—	10-24	.1629	H-6	.1672	H-4	.1661	—	—
1-64	.0629	—	—	H-2	.0648	—	—	10-32	.1697	H-6	.1736	H-4	.1762	—	—
1-72	.0640	—	—	H-2	.0659	—	—	12-24	.1889	H-6	.1933	H-4	.1922	—	—
2-56	.0744	H-3	.0772	H-2	.0765	—	—	12-2 8	.1928	H-6	.1970	H-4	.1959	—	—
2-64	.0759	H-3	.0786	H-2	.0779	—	—	1/4-20	.2175	H-6	.2223	H-4	.2211	H-8	.2215
3-48	.0855	H-3	.0885	H-2	.0877	—	—	1/4-28	.2268	H-6	.2311	H-4	.2300	H-8	.2308
3-56	.0874	H-3	.0902	H-2	.0895	—	—	5/16-18	.2764	H-7	.2817	H-5	.2803	H-9	.2809
4-40	.0958	H-5	.0991	H-3	.0982	—	—	5/16-24	.2854	H-7	.2902	H-5	.2890	H-9	.2899
4-48	.0985	H-5	.1016	H-3	.1008	—	—	3/8-16	.3344	H-7	.3401	H-5	.3387	H-9	.3389
5-40	.1088	H-5	.1121	H-3	.1113	—	—	3/8-24	.3479	H-7	.3528	H-5	.3516	H-9	.3524
5-44	.1102	H-5	.1134	H-3	.1126	—	—	7/16-14	.3911	H-8	.3972	H-5	.3957	—	—
6-32	.1177	H-5	.1214	H-3	.1204	—	—	7/16-20	.4050	H-8	.4104	H-5	.4091	—	—
6-40	.1218	H-5	.1252	H-3	.1243	—	—	1/2-13	.4500	H-8	.4565	H-5	.4548	H-10	.4550
8-32	.1437	H-5	.1475	H-3	.1465	—	—	1/2-20	.4675	H-8	.4731	H-5	.4717	H-10	.4725
8-36	.1460	H-5	.1496	H-3	.1487	—	—								

# Technical Section - Threading

## UNIFIED SCREW THREAD LIMITS

### Diameter - Pitch Combinations for Class of Fit

Nominal Size Threads Per Inch and Series Designation	Class	Internal				Major Diameter Min.
		Minor Diameter		Pitch Diameter		
		Min.	Max.	Min.	Max.	
0-80 UNF	2B	.0465	.0514	.0519	.0542	.0600
—	3B	.0465	.0514	.0519	.0536	.0600
1-64 UNC	2B	.0561	.0623	.0629	.0655	.0730
—	3B	.0561	.0623	.0629	.0648	.0730
1-72 UNF	2B	.0580	.0635	.0640	.0665	.0730
—	3B	.0580	.0635	.0640	.0659	.0730
2-56 UNC	2B	.0667	.0737	.0744	.0772	.0860
—	3B	.0667	.0737	.0744	.0765	.0860
2-64 UNF	2B	.0691	.0753	.0759	.0786	.0860
—	3B	.0691	.0753	.0759	.0779	.0860
3-48 UNC	2B	.0764	.0845	.0855	.0885	.0990
—	3B	.0764	.0845	.0855	.0877	.0990
3-56 UNF	2B	.0797	.0865	.0874	.0902	.0990
—	3B	.0797	.0865	.0874	.0895	.0990
4-40 UNC	2B	.0849	.0939	.0958	.0991	.1120
—	3B	.0849	.0939	.0958	.0982	.1120
4-48 UNF	2B	.0894	.0968	.0985	.1016	.1120
—	3B	.0894	.0968	.0985	.1008	.1120
5-40 UNC	2B	.0979	.1062	.1088	.1121	.1250

Nominal Size Threads Per Inch and Series Designation	Class	Internal				Major Diameter Min.
		Minor Diameter		Pitch Diameter		
		Min.	Max.	Min.	Max.	
—	3B	.0979	.1062	.1088	.1113	.1250
5-44 UNF	2B	.1004	.1079	.1102	.1134	.1250
—	3B	.1004	.1079	.1102	.1126	.1250
6-32 UNC	2B	.1040	.1140	.1177	.1214	.1380
—	3B	.1040	.1140	.1177	.1204	.1380
6-40 UNF	2B	.1110	.1190	.1218	.1252	.1380
—	3B	.1110	.1186	.1218	.1243	.1380
8-32 UNC	2B	.1300	.1390	.1437	.1475	.1640
—	3B	.1300	.1389	.1437	.1465	.1640
8-36 UNF	2B	.1340	.1420	.1460	.1496	.1640
—	3B	.1340	.1416	.1460	.1487	.1640
10-24 UNC	2B	.1450	.1560	.1629	.1672	.1900
—	3B	.1450	.1555	.1629	.1661	.1900
10-32 UNF	2B	.1560	.1640	.1697	.1736	.1900
—	3B	.1560	.1641	.1697	.1726	.1900
12-24 UNC	2B	.1710	.1810	.1889	.1933	.2160
—	3B	.1710	.1807	.1889	.1922	.2160
12-28 UNF	2B	.1770	.1860	.1928	.1970	.2160
—	3B	.1770	.1857	.1928	.1959	.2160

### Fractional Sizes

Nominal Size Threads Per Inch and Series Designation	Class	Internal				Major Diameter Min.
		Minor Diameter		Pitch Diameter		
		Min.	Max.	Min.	Max.	
1/4-20 UNC	1B	.1960	.2070	.2175	.2248	.2500
—	2B	.1960	.2070	.2175	.2224	.2500
—	3B	.1960	.2067	.2175	.2211	.2500
1/4-28 UNF	1B	.2110	.2200	.2268	.2333	.2500
—	2B	.2110	.2200	.2268	.2311	.2500
—	3B	.2110	.2190	.2268	.2300	.2500
5/16-18 UNC	1B	.2520	.2650	.2764	.2843	.3125
—	2B	.2520	.2650	.2764	.2817	.3125
—	3B	.2520	.2630	.2764	.2803	.3125
5/16-24 UNF	1B	.2670	.2770	.2854	.2925	.3125
—	2B	.2670	.2770	.2854	.2902	.3125
—	3B	.2670	.2754	.2854	.2890	.3125
3/8-16 UNC	1B	.3070	.3210	.3344	.3429	.3750
—	2B	.3070	.3210	.3344	.3401	.3750
—	3B	.3070	.3182	.3344	.3387	.3750

Nominal Size Threads Per Inch and Series Designation	Class	Internal				Major Diameter Min.
		Minor Diameter		Pitch Diameter		
		Min.	Max.	Min.	Max.	
3/8-24 UNF	1B	.3300	.3400	.3479	.3553	.3750
—	2B	.3300	.3400	.3479	.3528	.3750
—	3B	.3300	.3372	.3479	.3516	.3750
7/16-14 UNC	1B	.3600	.3760	.3911	.4003	.4375
—	2B	.3600	.3760	.3911	.3972	.4375
—	3B	.3600	.3717	.3911	.3957	.4375
7/16-20 UNF	1B	.3830	.3950	.4050	.4131	.4375
—	2B	.3830	.3950	.4050	.4104	.4375
—	3B	.3830	.3916	.4050	.4091	.4375
1/2-13 UNC	1B	.4170	.4340	.4500	.4597	.5000
—	2B	.4170	.4340	.4500	.4565	.5000
—	3B	.4170	.4284	.4500	.4548	.5000
1/2-20 UNF	1B	.4460	.4570	.4675	.4759	.5000
—	2B	.4460	.4570	.4675	.4731	.5000
—	3B	.4460	.4537	.4675	.4717	.5000

### Metric Sizes (ANSA B1.13M-1983) All dimensions are in millimeters.

Basic Thread Description	Tol. Class	Minor Diameter		Pitch Diameter			Major Diameter Min.	
		Min.	Max.	Min.	Max.	Tol.	Min.	Max.
M1.6 x 0.35	6H	1.221	1.321	1.373	1.458	.085	1.600	1.736
M2 x 0.4	6H	1.567	1.679	1.740	1.830	.090	2.000	2.148
M2.5 x 0.45	6H	2.013	2.138	2.208	2.303	.095	2.500	2.660
M3 x 0.5	6H	2.459	2.599	2.675	2.775	.100	3.000	3.172
M3.5 x 0.6	6H	2.850	3.010	3.110	3.222	.112	3.500	3.699
M4 x 0.7	6H	3.242	3.422	3.545	3.663	.118	4.000	4.219
M5 x 0.8	6H	4.134	4.334	4.480	4.605	.125	5.000	5.240
M6 x 1	6H	4.917	5.153	5.350	5.500	.150	6.000	6.294
M8 x 1.25	6H	6.647	6.912	7.188	7.348	.160	8.000	8.340

Basic Thread Description	Tol. Class	Minor Diameter		Pitch Diameter			Major Diameter Min.	
		Min.	Max.	Min.	Max.	Tol.	Min.	Max.
M8 x 1	6H	6.917	7.153	7.350	7.500	.150	8.000	8.294
M10 x 1.5	6H	8.376	8.676	9.026	9.206	.180	10.000	10.396
M10 x 1.25	6H	8.647	8.912	9.188	9.348	.160	10.000	10.340
M10 x 0.75	6H	9.188	9.378	9.513	9.645	.132	10.000	10.240
M12 x 1.75	6H	10.106	10.441	10.863	11.063	.200	12.000	12.453
M12 x 1.5	6H	10.376	10.676	11.026	11.216	.190	12.000	12.406
M12 x 1.25	6H	10.647	10.912	11.188	11.368	.180	12.000	12.360
M12 x 1	6H	10.917	11.153	11.350	11.510	.160	12.000	12.304

\*Internal Thread Minor Diameter Tolerances. Internal thread minor diameter tolerances are based on a length of engagement equal to the nominal diameter. For general applications these tolerances are suitable for lengths of engagement up to 1-1/2 diameters. However, some thread applications have lengths of engagement which are greater than 1-1/2 diameters or less than the nominal diameter. For such applications it may be advantageous to increase or decrease the tolerance, respectively.

# Technical Section - Threading

## TAPPING SPEEDS

### Conventional Table (Surface Feet Per Minute to Revolutions Per Minute)

Tap Sizes UNC/ UNF	Pipe	Surface Feet Per Minute																	
		5'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	150'
		Revolutions Per Minute																	
0	—	318	637	955	1273	1592	1910	2546	3183	3820	4456	5093	5729	6366	7003	7639	8276	8913	9549
1	—	273	546	819	1046	1308	1570	2093	2617	3140	3663	4186	4710	5233	5756	6279	6805	7326	7849
2	—	212	424	637	888	1110	1333	1777	2221	2665	3109	3554	3999	4442	4886	5330	5774	6218	6662
3	—	191	382	573	772	964	1157	1543	1929	2315	2701	3086	3472	3858	4244	4629	5015	5401	5787
4	—	174	347	521	682	853	1023	1364	1705	2046	2387	2728	3069	3411	3751	4092	4434	4775	5116
5	—	147	294	441	611	764	917	1222	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	4584
6	—	136	273	409	553	691	829	1106	1382	1659	1935	2212	2488	2766	3042	3318	3595	3871	4148
8	—	119	239	358	466	583	699	932	1165	1398	1631	1864	2097	2330	2563	2796	3029	3262	3495
10	—	101	201	302	402	502	603	804	1005	1205	1406	1607	1808	2009	2210	2411	2612	2813	3014
12	—	87	174	260	354	442	531	707	884	1061	1238	1415	1592	1769	1945	2122	2300	2476	2653
1/4	—	76	153	229	306	382	458	611	764	917	1070	1222	1375	1528	1681	1833	1986	2139	2292
5/16	—	62	123	185	245	306	367	489	611	733	856	978	1100	1222	1345	1467	1589	1711	1833
3/8	—	50	101	151	204	255	305	407	509	611	713	815	917	1019	1120	1222	1324	1426	1528
7/16	1/8	43	87	130	175	219	262	349	437	524	611	698	786	873	960	1048	1135	1222	1310
1/2	—	38	76	115	153	191	229	305	382	458	535	611	688	764	840	917	993	1070	1146
9/16	1/4	34	68	102	137	172	206	274	342	410	478	547	616	683	752	820	888	952	1020
5/8	—	32	64	96	122	153	183	244	306	367	428	489	550	611	672	733	794	856	917
11/16	3/8	28	55	83	111	138	167	222	278	333	389	444	500	556	611	667	722	778	833
3/4	—	25	51	76	102	128	153	203	255	305	357	407	458	509	560	611	662	713	764
7/8	1/2	22	43	65	87	109	131	175	218	262	306	350	392	437	480	524	568	611	655
1	—	19	38	57	76	96	115	153	191	230	268	305	344	382	420	458	497	535	573
1-1/8	3/4	17	34	51	68	84	102	136	170	204	238	272	306	340	373	407	441	475	509
1-1/4	—	15	31	46	61	76	92	122	153	183	214	244	275	305	336	367	397	428	458
1-3/8	1	14	28	42	56	69	83	111	139	167	194	222	250	278	306	333	361	389	417
1-1/2	—	13	25	38	51	63	76	102	127	153	178	204	229	255	280	305	331	356	382
1-5/8	—	12	23	35	47	59	71	94	118	141	165	188	212	235	259	282	306	329	353
1-3/4	—	11	22	33	44	55	65	87	109	131	153	175	196	218	240	262	284	306	327
1-7/8	—	10	20	30	41	51	61	81	102	122	143	163	183	204	224	244	265	285	306
2	—	9	19	29	38	48	57	76	96	115	134	153	172	191	210	229	248	267	287

## Metric Sizes

Tap Sizes Metric	Surface Feet Per Minute																	
	5'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	150'
		Revolutions Per Minute																
M 1	490	979	1469	1959	2449	2938	3918	4897	5877	6856	7836	8815	9795	10774	11754	12733	13713	14692
M 2	242	484	725	967	1209	1451	1934	2418	2901	3385	3868	4352	4835	5319	5803	6286	6770	7253
M 3	162	324	486	647	809	971	1295	1619	1942	2266	2590	2914	3237	3561	3885	4208	4532	4856
M 3.5	138	277	415	554	692	830	1107	1384	1661	1938	2214	2491	2768	3045	3322	3599	3875	4152
M 4	122	243	365	487	608	730	973	1217	1460	1703	1946	2190	2433	2676	2920	3163	3406	3650
M 5	97	194	291	388	485	582	776	970	1163	1357	1551	1745	1939	2133	2327	2521	2715	2909
M 6	81	162	243	324	405	486	647	809	971	1133	1295	1457	1619	1781	1942	2104	2266	2428
M 7	69	138	208	277	346	415	554	692	830	969	1107	1246	1384	1522	1661	1799	1938	2076
M 8	61	121	182	243	303	364	485	606	728	849	970	1091	1213	1334	1455	1577	1698	1819
M 10	48	97	145	194	242	291	388	485	582	679	776	873	970	1067	1163	1260	1357	1454
M 12	40	81	121	162	202	243	324	405	486	567	647	728	809	890	971	1052	1133	1214
M 14	35	69	104	139	173	208	277	347	416	485	555	624	693	763	832	901	971	1040
M 16	30	61	91	121	152	182	243	303	364	424	485	546	606	667	728	788	849	910
M 18	27	54	81	108	135	162	216	269	323	377	431	485	539	593	647	700	754	808
M 20	24	49	73	97	121	146	194	243	291	340	388	437	485	534	582	631	680	728
M 22	22	44	66	88	110	132	176	221	265	309	353	397	441	485	529	573	618	662
M 24	20	40	61	81	101	121	162	202	243	283	323	364	404	445	485	526	566	606
M 27	18	36	54	72	90	108	144	180	216	252	287	323	359	395	431	467	503	539
M 30	16	32	49	65	81	97	129	162	194	226	259	291	323	356	388	420	453	485

# Technical Section - Threading

## TYPICAL TAPPING PROBLEMS

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
<b>DIMENSIONAL ACCURACY</b>		
<b>Oversize Pitch Diameter</b>		
	<b>Incorrect Tap</b>	<ol style="list-style-type: none"> <li>1. Use correct H limit</li> <li>2. Use longer chamfered taps</li> <li>3. Consider less free cutting NR style</li> </ol>
	<b>Chip packing</b>	<ol style="list-style-type: none"> <li>1. Use spiral pointed or spiral fluted taps</li> <li>2. Reduce number of flutes to create extra chip space</li> <li>3. Use larger drill size</li> <li>4. In blind hole applications, allow deeper holes where applicable or shorten the thread length of the parts</li> <li>5. Use recommended lubricant</li> </ol>
	<b>Galling</b>	<ol style="list-style-type: none"> <li>1. Apply surface treatment such as steam oxide, TiN, TiCN or CrN</li> <li>2. Use recommended lubricant</li> <li>3. Reduce tapping speed</li> <li>4. Use correct tap for the material being tapped</li> </ol>
	<b>Operating Conditions</b>	<ol style="list-style-type: none"> <li>1. Ensure correct tapping speeds to avoid torn threads</li> <li>2. Check alignment of tap and drilled hole</li> <li>3. Use lead screw tapper</li> <li>4. Use tapping machine with adequate horsepower</li> <li>5. Check misalignment of tap and drilled hole due to loose spindle or worn holder</li> </ol>
	<b>Tool Condition</b>	<ol style="list-style-type: none"> <li>1. Check accuracy of chamfer lead grinding</li> <li>2. Ensure correct cutting angles</li> <li>3. Land widths too narrow</li> <li>4. Check burrs from regrinding not present</li> </ol>
<b>Oversize Internal Diameter</b>		
	<b>Hole Size</b>	<ol style="list-style-type: none"> <li>1. Use smaller drill size</li> <li>2. Avoid tapered hole</li> <li>3. Use taps with correct chamfer</li> </ol>
	<b>Galling</b>	See solutions prescribed under Oversize Pitch Diameter
<b>Undersized Pitch Diameter</b>		
	<b>Incorrect Tap</b>	<ol style="list-style-type: none"> <li>1. Use oversize taps <ul style="list-style-type: none"> <li>» For cutting materials such as copper alloy, aluminum alloy and cast iron</li> <li>» For cutting tubing which will have "spring back" action after tapping</li> </ul> </li> <li>2. Use taps with correct chamfer angle</li> <li>3. Use taps with higher cutting angle</li> </ol>
	<b>Damaged Thread</b>	Use proper reversing speed to avoid damaging tapped thread on the existing hole
	<b>Leftover Chips</b>	<ol style="list-style-type: none"> <li>1. Improve operating conditions to eliminate leftover chips in the hole</li> <li>2. Remove left over chips prior to gage checking</li> </ol>
<b>Undersized Internal Diameter</b>		
	<b>Hole Size</b>	Use larger drill size
<b>SURFACE FINISH</b>		
<b>Torn or Rough Threads</b>		
	<b>Dull Tap</b>	Resharpen
	<b>Chamfer too short</b>	Increase chamfer length
	<b>Incorrect rake angle</b>	Use correct rake angle suitable for material tapped
	<b>Galling</b>	<ol style="list-style-type: none"> <li>1. Use thread relieved taps</li> <li>2. Reduce land width</li> <li>3. Apply surface treatment such as steam oxide, TiN, or chrome</li> <li>4. Use recommended lubricant</li> <li>5. Reduce tapping speed</li> <li>6. Use larger drill size</li> <li>7. Check alignment between tap and hole</li> </ol>

# Technical Section - Threading

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
	Chip Packing	<ol style="list-style-type: none"> <li>1. Use spiral pointed or spiral fluted taps</li> <li>2. Use larger drill size</li> </ol>
<b>Chattering on Tapped Thread</b>		
	Too Positive	<ol style="list-style-type: none"> <li>1. Use lower rake angle</li> <li>2. Reduce amount of thread relief - consider NR style</li> <li>3. Use taps with wider land</li> </ol>
	Tool Condition	Use taps with wider land
<b>TOOL LIFE</b>		
<b>Breakage</b>		
	Incorrect Tap Selection	<ol style="list-style-type: none"> <li>1. Tapping too deep. Avoid chip packing in the flutes or bottom of the hole. Use spiral pointed, spiral fluted or cold forming tap.</li> <li>2. Use correct surface treatment such as steam oxide, TiN, TiCN or CrN</li> </ol>
	Excessive Tapping Torque	<ol style="list-style-type: none"> <li>1. Hole too small - use correct size drill</li> <li>2. Shorten thread length</li> <li>3. Increase rake angle</li> <li>4. Use a tap with more thread relief and reduced land width</li> <li>5. Use spiral pointed or spiral fluted taps</li> </ol>
	Operating Conditions	<ol style="list-style-type: none"> <li>1. Reduce tapping speed</li> <li>2. Avoid misalignment between tap and the hole and tapered hole</li> <li>3. Use floating type of tapping holder</li> <li>4. Use tapping holder with torque adjustment</li> <li>5. Avoid hitting bottom of the hole</li> </ol>
	Tool Condition	<ol style="list-style-type: none"> <li>1. Use taps with wider land width</li> <li>2. Remove all worn sections when regrinding the flutes</li> <li>3. Regrind tool more frequently</li> </ol>
<b>Chipping</b>		
	Incorrect Tap Selection	<ol style="list-style-type: none"> <li>1. Use tap with lower rake angle</li> <li>2. Consider different tool steel</li> <li>3. Reduce hardness of the tap</li> <li>4. Increase chamfer length</li> <li>5. Avoid chip packing in the flutes or in the bottom of the hole by using spiral fluted or spiral pointed taps</li> </ol>
	Operating Conditions	<ol style="list-style-type: none"> <li>1. Reduce tapping speed</li> <li>2. Avoid misalignment between tap and hole</li> <li>3. Avoid sudden reverse in blind hole tapping</li> <li>4. Avoid galling</li> <li>5. Use larger drill size</li> <li>6. Ensure adequate lubricant</li> <li>7. Check for hard spots in the workpiece</li> </ol>
<b>Excessive Wear</b>		
	Incorrect Tap Selection	<ol style="list-style-type: none"> <li>1. Consider specially designed taps</li> <li>2. Change to an Applix style of tap made from PM material</li> <li>3. Apply special surface treatment such as steam oxide, TiN, TiCN or CrN</li> <li>4. Increase chamfer length</li> </ol>
	Operating Conditions	<ol style="list-style-type: none"> <li>1. Reduce tapping speed</li> <li>2. Apply adequate lubrication</li> <li>3. Avoid work hardening the material being tapped</li> <li>4. Use larger drill size</li> </ol>
	Tool Condition	<ol style="list-style-type: none"> <li>1. Ensure correct rake angle</li> <li>2. Minimize heat in grinding process to avoid de-tempering</li> </ol>

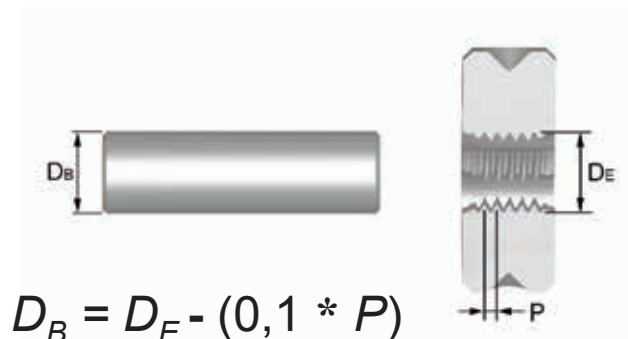
# Technical Section - Threading

## TECHNICAL TIPS ON THREADING WITH DIES

1. Before starting the die or die nut, chamfer the end of the bar at an angle of 45 degrees to eliminate sudden loading of the leading edges. Ensure the die or die nut is presented to the bolt squarely.
2. Make use of the large tolerances associated with the major diameter of the bolt, by reducing the diameter of the bar (see below). This will reduce the cutting force to a minimum.
3. Use the gun nose type of die, as this ensures the chips are directed away from the cutting area.
4. Ensure a good supply of the correct lubricant is aimed at the cutting area.
5. When adjusting split dies, avoid opening out as this will cause rubbing. Split dies may be closed down by approximately 0.15mm, by turning the adjustment screws equally. Pressure on one side of the die only may cause breakage.
6. Generally speaking, die nuts are used for reclaiming or cleaning out existing threads by hand. They tend to be of a more robust construction and should only be used in exceptional circumstances to cut a thread from solid.

## PRE-MACHINING DIMENSIONS

The diameter of the bolt blank must be smaller than the max. external diameter of the screw thread.





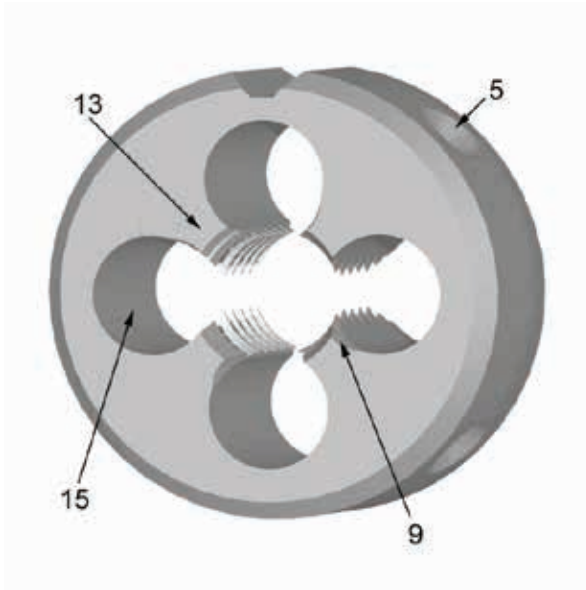
# Technical Section - Threading

## TROUBLE SHOOTING WHEN THREADING WITH DIES

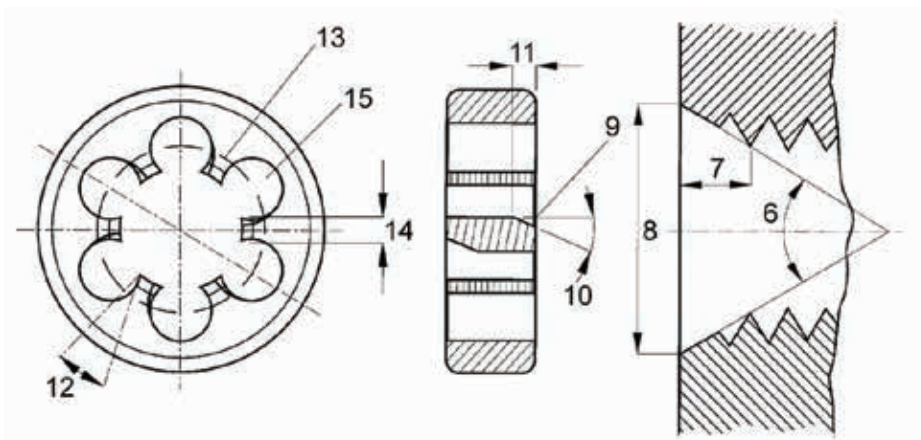
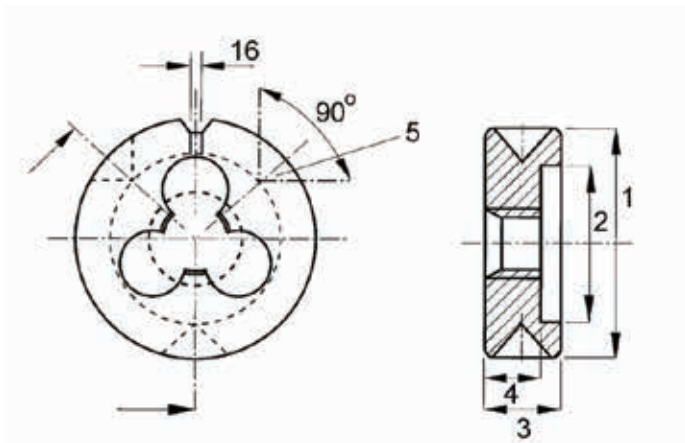
<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
<b>Oversize / Undersize</b>		
	Misalignment	Correct alignment, ensure cleanliness
	Incorrect axial feed rate	Ensure axial feed rate is controlled accurately
<b>Poor finish</b>		
	Incorrect rake angle for the material	Try alternative dies or special die
	Incorrect/lack of lubricant	See lubricants section
	Incorrect speed	Follow recommendations in Catalog
	Bar diameter too large	Reduce to appropriate size
	Bar end not chamfered	Ensure bar end is chamfered
<b>Chipping / Breakage</b>		
	Wrong type of die	Follow recommendations in Catalog
	Speed too high	Follow recommendations in Catalog
	Bar diameter too large	Reduce to appropriate size
	Bar end not chamfered	Ensure bar end is chamfered
	Misalignment	Correct alignment, ensure cleanliness
<b>Rapid wear</b>		
	Incorrect/lack of lubricant	See lubricants section
	Speed too high	Follow recommendations in Catalog
<b>Built up edge</b>		
	Incorrect/lack of lubricant	See section lubricants
	Bar diameter too large	Reduce to appropriate size
	Speed too low	Follow recommendations in Catalog

# Technical Section - Threading

## DIE DEFINITIONS / NOMENCLATURE

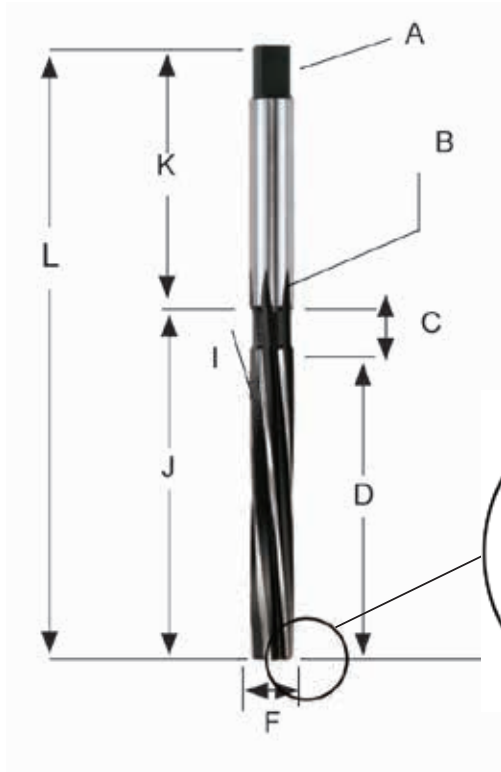


- 1 Outside Diameter
- 2 Recess Diameter
- 3 Thickness
- 4 Thread Length
- 5 Conical Hole for Fixing Screw
- 6 Chamfer Angle
- 7 Chamfer Length
- 8 Chamfer Diameter
- 9 Gun-nose
- 10 Spiral Angle
- 11 Spiral Length
- 12 Rake Angle
- 13 Land
- 14 Width of Land
- 15 Clearance Hole
- 16 Split of Adjustment

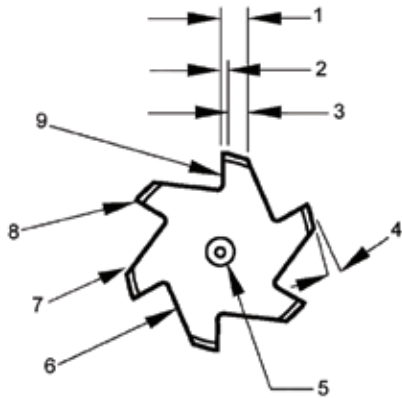
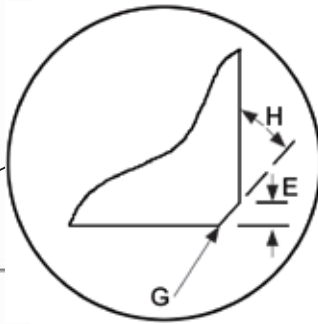


# Technical Section - Reaming

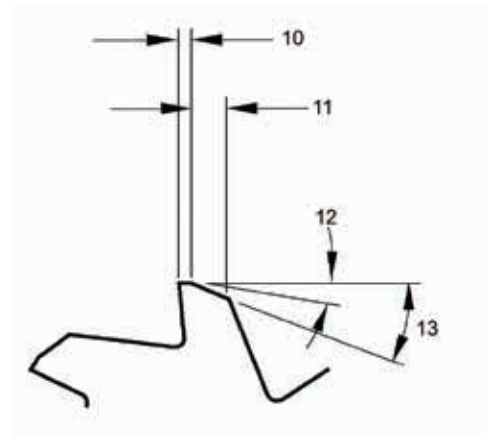
## REAMER DEFINITIONS / NOMENCLATURE



- A Tang
- B Recess
- C Recess Length
- D Cut Length
- E Bevel Lead Length
- F Diameter
- G Bevel Lead
- H Bevel Lead Angle
- I Helix Angle
- J Body Length
- K Shank Length
- L Overall Length



- 1 Width of Land
- 2 Circular Land
- 3 Clearance
- 4 Clearance Angle
- 5 Centre Hole
- 6 Flute
- 7 Heel
- 8 Cutting Edge
- 9 Face



- 10 Width of Primary Clearance
- 11 Width of Secondary Clearance
- 12 Primary Clearance Angle
- 13 Secondary Clearance Angle

# Technical Section - Reaming

## TECHNICAL TIPS ON REAMING

To obtain the best results when using reamers it is essential to make them 'work'. It is a common fault to prepare holes for reaming with too little stock left in. If insufficient stock is left in the hole before reaming, then the reamer will rub, quickly show wear and will result in loss of diameter. It is equally important for performance not to leave too much stock in the hole. (See Stock Removal on next page).

1. Select the optimum type of reamer and the optimum speeds and feeds for the application. Ensure that pre-drilled holes are the correct diameter.
2. The workpiece must be held rigid and the machine spindle should have no play.
3. The chuck in which a straight shank reamer is held must be good quality. If the reamer slips in the chuck and the feed is automatic, breakage of the reamer may occur.
4. When driving a Morse Taper Shank reamer into a socket, sleeve or machine spindle, always use a soft faced hammer. Make sure there is a good fit between the reamer shank and the sleeve or socket otherwise misalignment will occur and the reamer may cut oversize.
5. Keep tool overhang from machine spindle to a minimum.
6. Use recommended lubricants to enhance the life of the reamer and ensure the fluid reaches the cutting edges. As reaming is not a heavy cutting operation, soluble oil 40:1 dilution is normally satisfactory. Air blasting may be used with grey cast iron, if dry machining.
7. Do not allow the flutes of a reamer to become blocked with chips.
8. Before the reamer is reground, check concentricity between centers. In most instances only the bevel lead will need regrinding.
9. Keep reamers sharp. Frequent regrinding is good economy, but it is important to understand that reamers cut only on the bevel and taper leads and not on the lands. Consequently only these leads need regrinding. Accuracy of regrinding is important to hole quality and tool life.

## HAND / MACHINE REAMERS

Although both hand and machine reamers offer the same capability regarding finished hole size, the use of each must be considered according to application. A hand reamer, for reasons of alignment, has a long taper lead, whereas a machine reamer has only a 45 degree bevel lead. A machine reamer cuts only on the bevel lead, a hand reamer cuts on the bevel lead and also on the taper lead.

# Technical Section - Reaming

## APPLICATIONS

The results obtained in reaming are to a great extent dependent upon the condition of the drilled hole. If deep scores or form deviations are inherent in the hole, reaming is probably not going to rectify these inaccuracies or produce a finish within tolerance requirements. A reamer can also be mounted in a floating holder with enough clearance to permit the reamer to move freely along the existing hole.

## Suggested Stock Removal

Material ≥	Core-Drilled Hole Diameter (inches)					
	5/32	> 5/32 – 3/8	> 3/8 – 5/8	> 5/8 – 1	> 1 – 1-1/2	> 1-1/2 – 2-1/2
Steel*						
Hard cast-iron	.004	.004 – .008	.006 – .010	.008 – .014	.010 – .018	.016 – .025
Soft cast-iron						
Light alloys*	.005	.005 – .012	.008 – .016	.010 – .020	.016 – .024	.024 – .031
Copper, soft						
Copper, alloys						
Plastics (Duro plastics)	.007	.007 – .012	.010 – .016	.013 – .020	.016 – .024	.020 – .031

\* For soft materials and quick spiral machine reamers add 50% of allowance.

## Table of Speeds and Feeds

Type of Material	Speed Range (sfm)		Type of Feed
	HSS	Carbide	
Magnesium	200 – 400	500 – 1000	M-H
Aluminum	150 – 300	500 – 1000	M-H
Brass and Bronze – Free Mach. – Tough	125 – 200	250 – 400	M
	75 – 125	150 – 250	M
Copper and Hard Bronze	50 – 75	100 – 150	L
Cast Iron – Soft (Ferritic) – Medium (Pearlitic) – Hard (Mart. or Acicular)	50 – 100	150 – 250	H
	25 – 50	75 – 150	L-M
	15 – 25	50 – 75	L
Steel – Under 200 BHN – 200 - 300 BHN – 300 - 400 BHN – 400 - 500 BHN – 500 - BHN Plus	55 – 80	200 – 300	M-H
	30 – 55	125 – 200	M
	20 – 30	50 – 125	L
	10 – 20	35 – 50	L
	—	15 – 35	L
Stainless – Free Mach. and 400 Ann. – 300 Series – P.H. and H.T. 400 series	40 – 60	150 – 250	M
	20 – 30	80 – 120	M
	15 – 25	60 – 100	L-M
High Temp Alloy – Nickel Base – Cobalt Base	10 – 20	40 – 70	L
	10 – 15	30 – 45	L
Titanium – Pure – Alloys	35 – 50	50 – 100	M
	10 – 20	35 – 50	L-M

Diameter Range	Feed (ipr) for Diameter Range		
	Light (L)	Medium (M)	Heavy (H)
≥ 1/16"	.0002" – .001"	.0005" – .002"	.001" – .003"
> 1/16" – 1/8"	.001" – .002"	.002" – .004"	.003" – .006"
> 1/8" – 1/4"	.002" – .004"	.004" – .006"	.006" – .010"
> 1/4" – 1/2"	.004" – .006"	.006" – .010"	.010" – .015"
> 1/2" – 1"	.006" – .010"	.010" – .020"	.015" – .030"
> 1"	.010" – .020"	.020" – .040"	.030" – .050"

# Technical Section - Reaming

## APPLICATION REAMERS

As with most cutting tools, the substrate and geometric configuration of reamers differs, dependent on the material they are intended to cut. As such, care should be taken to ensure that the correct choice of reamer is made.

CNC reamers are manufactured with a shank tolerance of h6. This enables the reamer to be used in hydraulic and heat shrink tool holding systems, offering enhanced accuracy and concentricity.

## ADJUSTABLE REAMERS

Several types of adjustable reamers are available, all offering varying degrees of diameter adjustment. It is an important aspect of adjustable reamers to follow this set procedure:

- Adjust the reamer to the required diameter.
- Check the reamer between centers for concentricity and lip height variation.
- If required, grind the reamer to eliminate any eccentricity or lip height variation.
- Re-check the diameter.

## STOCK REMOVAL

The recommended stock removal in reaming is dependent on the application material and the surface finish of the pre-drilled hole. General guidelines for stock removal are shown in the following tables:

Size of reamed hole (mm)	When pre-drilled	When pre-core-drilled	Size of reamed hole (inches)	When pre-drilled	When Pre-core-drilled
Below 4	0.1	0.1	Below 3/16	0.004	0.004
Over 4 to 11	0.2	0.15	3/16 to 1/2	0.008	0.006
Over 11 to 3	0.3	0.2	1/2 to 1. 1/2	0.010	0.008
Over 39 to 50	0.4	0.3	1. 1/2 to 2	0.016	0.010

## SELECTION OF REAMER TYPES

Reaming is a recognized method of producing dimensionally accurate holes of fine surface finish. Dormer offers a range of reamers for producing holes to H7 tolerance.

Reamers are classified into various types:

- Solid - available in two shank types, Straight (cylindrical) and Morse Taper.
- Shell - for use on arbors.
- Expanding - with adjustable HSS blades and used for light work.

# Technical Section - Reaming

## Applications - Reamer Selection

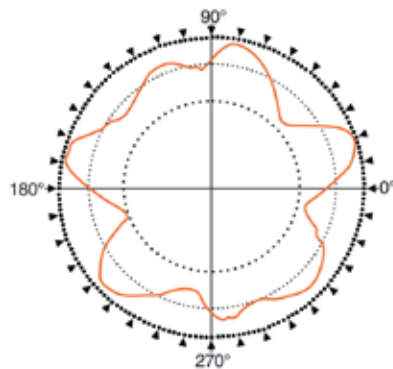
The most common types of reamers have a left-hand spiral because the main applications involve through holes requiring chips to be pushed forward. For blind holes, reamers with straight flutes or right hand spirals are recommended.

The most efficient reaming conditions depend on the application, material, quality of hole required, stock removal, lubrication and other factors. A general guide to surface speeds and feeds for machine reamers is shown in the reamer AMG and feed charts (see Dormer catalogue or Product Selector) and stock removal tables.

Extremely unequal spacing on reamers means that the divide is not the same for each tooth. As there are no two teeth diametrically opposite each other, the reamer produces a hole with a roundness variance of between 1 and 2  $\mu\text{m}$ . This compared with a variance of up to 10 $\mu\text{m}$  with unequal spacing.

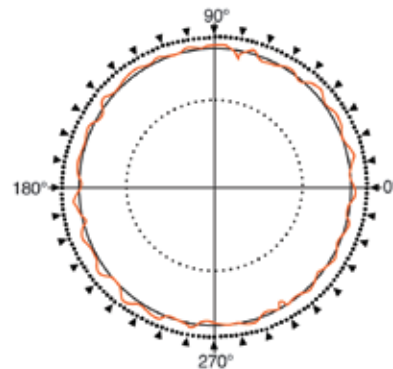
### CARBIDE REAMERS - COMPARISON SPACING / EU SPACING

unequal spacing  
roundness error up to 10  $\mu\text{m}$



Results of roundness

extremely unequal spacing  
roundness error up to 1 - 2  $\mu\text{m}$



Results of roundness

# Technical Section - Reaming

## TROUBLE SHOOTING WHEN REAMING

<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
<b>Broken or twisted tangs</b>		
	Incorrect fit between shank and socket	Ensure the shank and the socket are clean and free from damage
<b>Rapid Tool Wear</b>		
	Insufficient stock to remove	Increase the amount of stock to be removed
<b>Oversize Hole</b>		
	Excessive lip height variation	Regrind to correct specification
	Displacement in the machine spindle	Repair and rectify spindle displacement
	Defects on the tool holder	Replace tool holder
	Tool shank is damaged	Replace or regrind the shank
	Ovality of the tool	Replace or regrind the tool
	Asymmetric bevel lead angle	Regrind to correct specification
	Too high feed or cutting speed	Adjust cutting conditions in accordance with Catalog or Product Selector
<b>Undersize hole</b>		
	Insufficient stock to remove	Increase the amount of stock to be removed
	Too much heat generated while reaming. The hole widens and shrinks.	Increase coolant flow
	The tool diameter is worn and is undersize.	Regrind to correct specification.
	Too low feed or cutting speed	Adjust cutting conditions in accordance with the Dormer Product Selector.
	Pre-drilled hole is too small	Decrease the amount of stock to be removed.
<b>Oval and conical holes</b>		
	Displacement in the machine spindle	Repair and rectify spindle displacement
	Misalignment between tool and hole	Use a bridge reamer
	Asymmetric bevel lead angle	Regrind to correct specification
<b>Bad Hole finish</b>		
	Excessive stock to remove	Decrease the amount of stock to be removed
	Worn out tool	Regrind to specification
	Too small cutting rake angle	Regrind to specification
	Too diluted emulsion or cutting oil	Increase % concentration
	Feed and/or speed too low	Adjust cutting conditions in accordance with Catalog/ Product Selector
	Cutting speed too high	Adjust cutting conditions in accordance with Catalog/ Product Selector
<b>The tool clamps and breaks</b>		
	Worn out tool	Regrind to correct specification
	Back taper of the tool is too small	Check and replace / modify the tool
	The width of the land is too wide	Check and replace / modify the tool
	Workpiece material tend to squeeze	Use an adjustable reamer to compensate for the displacement
	Pre-drilled hole is too small	Decrease the amount of stock to be removed
	Heterogeneous material with hard inclusions	Use solid carbide reamer



# Technical Section - Counterboring and Countersinking

## GENERAL HINTS ON COUNTERBORING AND COUNTERSINKING

### COUNTERBORING

The counterbore is an end cutting tool which is used to enlarge a preformed hole when a flat bottom is required or to spotface when a machine finish is required. It may have a fixed pilot (solid pattern) Fig.1 or be designed Fig.2 for an interchangeable pilot Fig. 3.



Fig.1



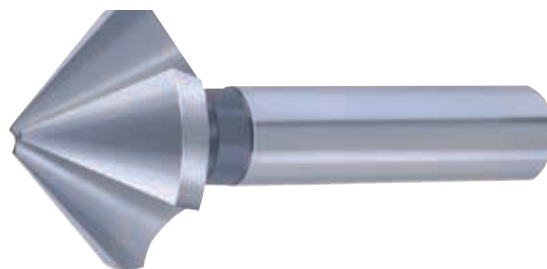
Fig.2



Fig. 3

### COUNTERSINKING

The countersink is a conical cutting tool, usually made with angular relief, having one or more flutes with specific size angle cutting edges. It is used for chamfering and countersinking holes. The countersink may have a straight shank, tapered shank, bit stock shank or special shank requiring a special holder, for holding in a power or hand operated machine.



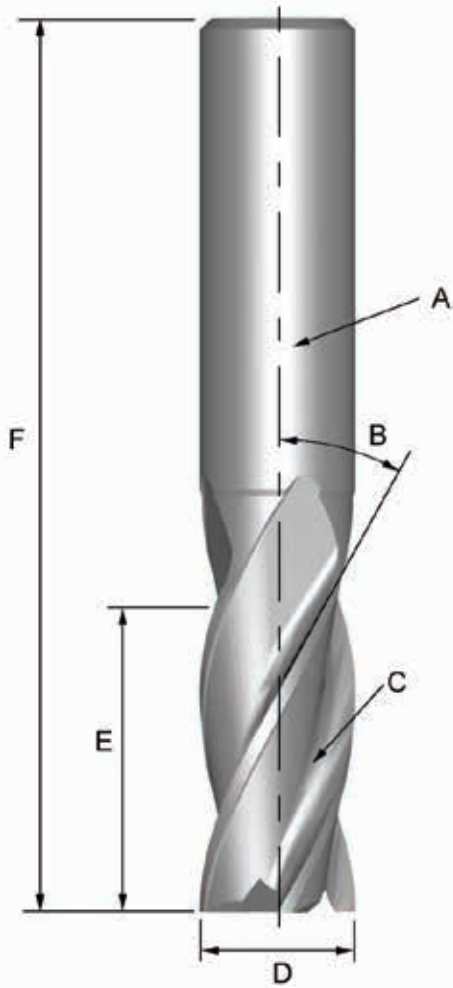
# Technical Section - Counterboring and Countersinking

## TROUBLE SHOOTING WHEN COUNTERBORING

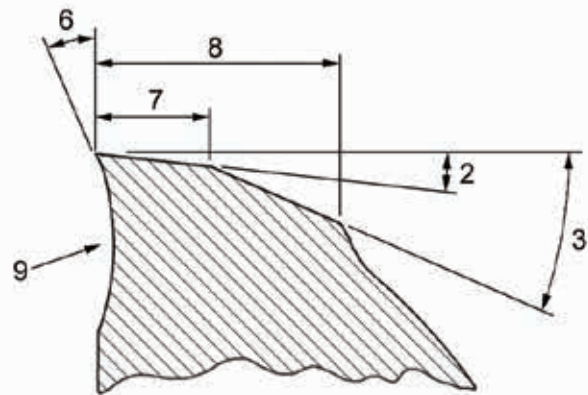
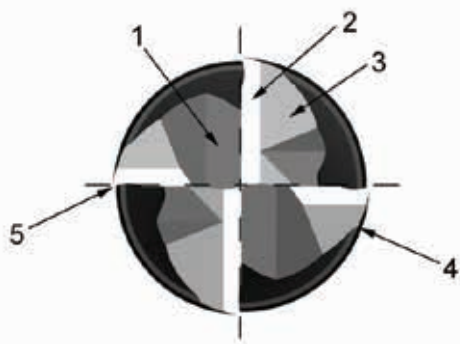
<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
<b>Excessive Cutting Edge Wear</b>		
	Incorrect feeds & speeds	Increase feed - especially when machining ductile or free machining materials. Also try reducing speed
	Rough cutting edge	Lightly hone cutting edge with fine grit diamond hone
	Insufficient coolant	Increase coolant flow - review type of coolant
<b>Chipping</b>		
	Poor chip removal	Use tool with larger flute space - larger diameter or fewer flutes
	Recutting work hardened chips	Increase coolant flow
	Vibration	Increase rigidity of set-up, especially worn tool holders
<b>Short Tool Life</b>		
	Excessive cratering	Increase speed or decrease feed
	Abrasive material	Decrease speed and increase feed Increase coolant flow
	Hard materials	Reduce speed - rigidity very important
	Insufficient chip room	Use larger diameter tool
	Delayed resharpening	Prompt resharpening to original geometry will increase tool life
<b>Glazed Finish</b>		
	Feed too light	Increase feed
	Dull cutting edge	Resharpen tool to original geometry
	Insufficient clearance	Resharpen tool with more clearance
<b>Rough Finish</b>		
	Dull cutting edge	Resharpen to original tool geometry
	Wrong feeds & speeds	Increase speed - also try reducing feed
<b>Chattering</b>		
	Insufficient machine horsepower	Use tool with fewer flutes as correct feeds & speeds must be maintained
	Vibration	Resharpen tool with more clearance

# Technical Section - Milling

## NOMENCLATURE



- A Shank
- B Helix Angle
- C Flute
- D Outside Diameter
- E Cutting Length
- F Overall Length



- 1 Gash
- 2 Primary Relief Angle
- 3 Secondary Relief Angle
- 4 Heel
- 5 Cutting Edge

- 6 Rake Angle
- 7 Width of Primary Relief Land
- 8 Width of Secondary Relief Land
- 9 Undercut Face

# Technical Section - Milling

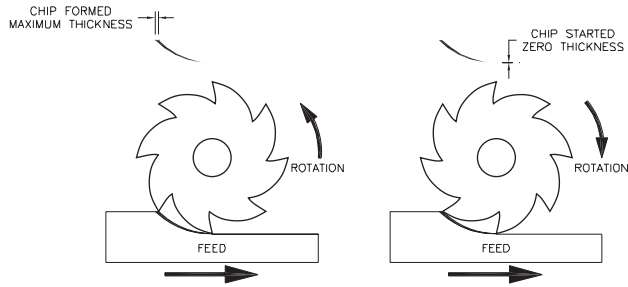
## MILLING EFFECTIVELY

### Types Of Cuts

#### Climb Milling Versus Conventional Milling

##### CLIMB MILLING

##### CONVENTIONAL MILLING



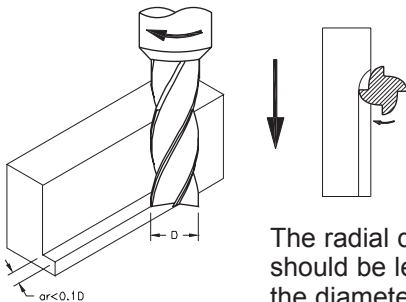
In conventional milling, the cutter revolves opposite to the direction of table feed. Therefore the width of the chip starts at zero and increases to a maximum at the end of the cut. This can lead to accelerated tool wear under some conditions. Conventional milling may be advantageous when milling hot rolled steel, surface hardened and steels with a surface scale.

In climb milling, the cutter revolves in the same direction as the table feed. The tooth meets the work at the top of the cut, producing the thickest part of the chip first. In horizontal applications the resultant force created by climb milling can act as a clamping force, acting towards the machine table.

It is important to make sure that the machine tool has no leadscrew backlash. Normally climb milling improves product surface finish and increases tool life.

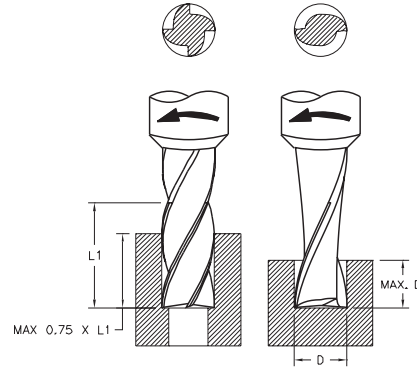
**Peripheral Milling** The milling of a surface which is parallel to the end mill axis.

#### Peripheral (Cylindrical, Slab) Milling



The radial depth of cut should be less than 0.1 of the diameter of the mill:  
 $a_r < 0.1 D$ .

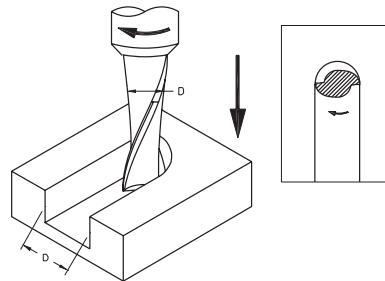
**Plunge Milling** The direct movement between the workpiece and the center line of the end mill when the end mill sinks directly into the workpiece.



In order to be able to "drill," i.e. mill with axial feed, an end mill must have an end face cutting edge that goes all the way to the center. An example of such a solid drilling operation is keyway milling in the middle of a shaft.

In boring, the depth of a hole may be up to 75% of the cutting edge length. In solid drilling, however, it should not exceed 0.5-1 D.

#### Slot Milling



003-00-A

The radial depth of cut is equal to the diameter of the mill:  $a_r = D$ .

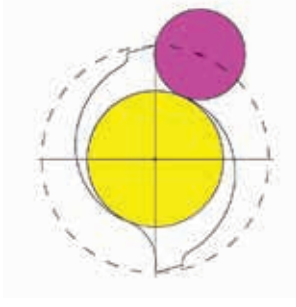
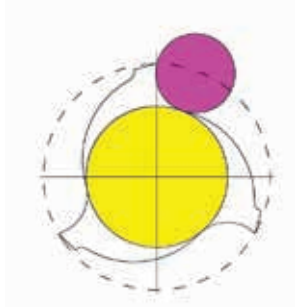
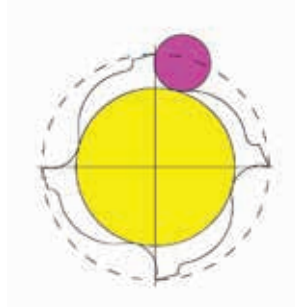
All slotting applications are a combination of conventional and climb milling. Refer to adjacent section.

# Technical Section - Milling

## FEATURES OF THE END MILL - CHOOSING THE NUMBER OF FLUTES

Number of flutes should be determined by:

- Milled material
- Dimension of workpiece
- Milling conditions

	2 Flutes	3 Flutes	4 Flutes (or multi-flutes)
			
Flexural strength	Low	←—————→ High	
Chip space	Big	←—————→ Small	
	<ul style="list-style-type: none"> <li>• Large chip space.</li> <li>• Easy chip ejection.</li> <li>• Good for slot milling.</li> <li>• Good for heavy duty milling.</li> <li>• Less rigidity due to small section area.</li> <li>• Lower quality surface finish</li> </ul>	<ul style="list-style-type: none"> <li>• Chip space almost as large as for 2 flutes.</li> <li>• Larger section area - higher rigidity than 2 flutes</li> <li>• Improved surface finish</li> </ul>	<ul style="list-style-type: none"> <li>• Highest rigidity.</li> <li>• Largest section area – small chip space.</li> <li>• Gives best surface finish.</li> <li>• Recommended for profiling, side milling and shallow slotting.</li> </ul>

## FEATURES OF THE END MILL – HELIX ANGLE

Increasing the number of flutes makes the load on the single tooth more homogeneous and consequently, this allows for a better finish. But with a high helix angle, the load (FV) along the cutter axis is increased too. A high FV can give:

- Load problems on the bearings
- Cutter movement along the spindle axis. To avoid this problem it is necessary to use Weldon or screwed shanks.



# Technical Section - Milling

## DIRECTION OF USE OF THE CUTTER

We can split the range of the cutters in relationship to the possible working directions to the workpiece surface. There are three different types:

3 Directions	2 Directions	1 Direction
		

Please note that the axial direction is possible only with center cutting end mills.

## MRR (MATERIAL REMOVAL RATE) Q

We can calculate material removal rate  $Q$  as the volume of material removed divided by the time taken to cut. The volume removed is the initial volume of the workpiece minus the final volume. The cutting time is the time needed for the tool to move through the length of the workpiece. This parameter strongly influences the finishing grade of the workpiece.

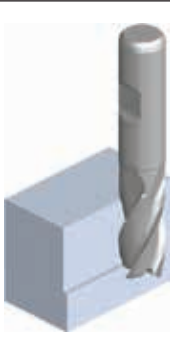




$$Q = \frac{a_p * a_e * v_f}{1000}$$

$Q = \text{MRR (cm}^3/\text{min)}$      $a_e = \text{radial depth (mm)}$

$a_p = \text{axial depth (mm)}$      $v_f = \text{feed rate (mm/min)}$

## APPLICATIONS

The MRR and the applications are strongly related. For each different application we have a different MRR that increases with the engagement section of the cutter on the workpiece. The recent Dormer Catalogue was produced with simple icons that show the different applications.

Side Milling	Face Milling	Slot Milling	Plunge Milling	Ramping
				
The radial depth of cut should be less than 0.25 of the diameter of the end mill.	The radial depth of cut should be no more than 0.9 of the diameter, axial depth of cut less than 0.1 of the diameter.	Machining of a slot for keyways. The radial depth of cut is equal to the diameter on the end mill.	It is possible to drill the workpiece with an end mill only with the cutting centre. In this operation the feed has to be halved.	Both axial and radial entering into the workpiece.

# Technical Section - Milling

## MILLING EFFECTIVELY

### End Mill Selection

Utilize the shortest possible tool available for the application with the largest diameter permissible and the shortest flute length as depth of cut allows. Extra length end mills have excessive overhang, thus a reduction in feed up to 25% may be required. Stub length end mills, due to their short overall and flute length, have more rigidity, thus an increase in feed rates of up to 25% may be required.

### Speeds

Solid Carbide end mills must be run at higher speeds than High Speed Steel end mills. Many times, lighter cuts at higher speeds can improve the finish of the workpiece.

When the application is a slotting cut, the speed should be reduced by approximately 20%. Speeds should be decreased when milling hard or tough materials or when taking heavy cuts. Speeds should be increased when milling softer materials or when taking lighter cuts. Speeds should also be increased for finishing cuts.

### Coolants

Coolants are recommended when milling mild steel and high temperature alloys. The purpose of the coolant media is to direct the chips away from the cutting tool and workpiece. This prevents damage to the cutting edges due to recutting the chips. When machining titanium, coolant flow must be heavy and directed at the area of cut to prevent overheating and assist in chip removal.

## Milling Terminology/Operating Formulas

The following terms and formulas can be used to determine the appropriate operating parameters.

Terms	Formulas
<b>SFM</b> = Surface Feet Per Minute	$D \times \text{RPM} \times .26 = \text{SFM}$
<b>RPM</b> = Revolutions Per Minute	$\frac{\text{SFM} \times 3.82}{D} = \text{RPM}$
<b>F</b> = Feed in Inches Per Minute	$\text{Ft} \times \text{T} \times \text{RPM} = \text{F}$
<b>Ft</b> = Feed Per Tooth	$\frac{\text{F}}{\text{T} \times \text{RPM}} = \text{Ft}$
<b>D</b> = Cutting Diameter	
<b>T</b> = Number of Teeth	

# Technical Section - Milling

## TABLE OF CUTTING SPEEDS

### Conversion Table (Surface Feet Per Minute to Revolutions Per Minute)

DIA. In Inches	Surface Feet Per Minute																DIA. In Inches	
	15'	20'	25'	30'	35'	40'	45'	50'	60'	70'	80'	90'	100'	110'	120'	130'		140'
	Revolutions Per Minute																	
1/64	3667	4890	6112	7334	8559	9779	11002	12224	14669	17114	19558	22003	24448	26893	29338	31782	34227	1/64
1/32	1834	2445	3056	3667	4278	4890	5501	6112	7334	8557	9779	11002	12224	13446	14669	15891	17114	1/32
3/64	1222	1630	2037	2445	2852	3260	3667	4075	4890	5705	6519	7334	8149	8964	9779	10594	11409	3/64
1/16	917	1222	1528	1833	2139	2445	2750	3056	3667	4278	4889	5500	6112	6723	7333	7945	8556	1/16
3/32	611	815	1019	1222	1426	1630	1834	2037	2445	2852	3260	3667	4075	4482	4890	5297	5705	3/32
1/8	458	611	764	917	1070	1222	1375	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	1/8
5/32	367	489	611	733	856	978	1100	1222	1467	1711	1956	2200	2445	2689	2934	3178	3423	5/32
3/16	306	407	509	611	713	815	917	1019	1222	1426	1620	1833	2037	2241	2445	2648	2852	3/16
1/4	229	306	382	458	535	611	688	764	917	1070	1222	1375	1528	1681	1833	1986	2139	1/4
5/16	183	244	306	367	428	489	550	611	733	856	978	1100	1222	1345	1467	1589	1711	5/16
3/8	153	204	255	306	357	407	458	509	611	713	815	917	1019	1120	1222	1324	1426	3/8
7/16	131	175	218	262	306	349	393	437	524	611	698	786	873	960	1048	1135	1222	7/16
1/2	115	153	191	229	267	306	344	382	458	535	611	688	764	840	917	993	1070	1/2
5/8	92	122	153	183	214	244	275	306	367	428	489	550	611	672	733	794	856	5/8
3/4	76	102	127	153	178	204	229	255	306	357	407	458	509	560	611	662	713	3/4
7/8	66	87	109	131	153	175	196	218	262	306	349	393	473	480	524	568	611	7/8
1	57	76	96	115	134	153	172	191	229	267	306	344	382	420	458	479	535	1
1-1/8	51	68	85	102	119	136	153	170	204	238	272	306	340	373	407	441	475	1-1/8
1-1/4	46	61	76	92	107	122	138	153	183	214	244	275	306	336	367	397	428	1-1/4
1-3/8	42	56	70	83	97	111	125	139	167	194	222	250	278	306	333	361	389	1-3/8
1-1/2	38	51	64	76	89	102	115	127	153	178	204	229	255	280	309	331	357	1-1/2
1-5/8	35	47	59	71	82	94	106	118	141	165	188	212	235	259	282	306	329	1-5/8
1-3/4	33	44	55	66	76	87	98	109	131	153	175	196	218	240	262	284	306	1-3/4
1-7/8	31	41	51	61	71	82	92	102	122	143	163	183	204	224	244	265	285	1-7/8
2	29	38	48	57	67	76	86	96	115	134	153	172	191	210	229	248	267	2
2-1/4	26	34	42	51	59	68	76	85	102	119	136	153	170	187	204	221	238	2-1/4
2-1/2	23	31	38	46	54	61	69	76	92	107	122	138	153	168	183	199	214	2-1/2
2-3/4	21	28	35	42	49	56	62	70	83	97	111	125	139	153	167	181	194	2-3/4
3	19	26	32	38	45	51	57	64	76	89	102	115	127	140	153	166	178	3
3-1/4	18	24	29	35	41	47	53	59	71	82	94	106	118	129	141	153	165	3-1/4
3-1/2	16	22	27	33	38	44	49	55	66	76	87	98	109	120	131	142	153	3-1/2
3-3/4	15	20	26	31	36	41	46	51	61	71	81	92	102	112	122	132	143	3-3/4
4	14	19	24	29	33	38	43	48	57	67	76	86	96	105	115	124	134	4
4-1/2	13	17	21	26	30	34	38	42	51	59	68	76	85	93	102	110	119	4-1/2
5	12	15	19	23	27	31	34	38	46	54	61	69	76	84	92	99	107	5
5-1/2	10	14	17	21	24	28	31	35	42	49	56	63	70	76	83	90	97	5-1/2
6	10	13	16	19	22	26	29	32	38	45	51	57	64	70	76	83	89	6
6-1/2	9	12	15	18	21	24	26	29	35	41	47	53	59	65	71	76	82	6-1/2
7	8	11	14	16	19	22	25	27	33	38	44	49	55	60	66	71	76	7
7-1/2	8	10	13	15	18	20	23	26	31	36	41	46	51	56	61	66	71	7-1/2
8	7	10	12	14	17	19	22	24	29	33	38	43	48	53	57	62	67	8
8-1/2	7	9	11	14	16	18	20	23	27	32	36	40	45	49	54	58	63	8-1/2
9	6	9	11	13	15	17	19	21	26	30	34	38	42	47	51	55	59	9
9-1/2	6	8	10	12	14	16	18	20	24	28	32	36	40	44	48	52	56	9-1/2
10	6	8	10	12	13	15	17	19	23	27	31	34	38	42	46	50	54	10
11	5	7	9	10	12	14	16	17	21	24	28	31	35	38	42	45	49	11
12	5	6	8	10	11	13	14	16	19	22	26	29	32	35	38	41	45	12
	15'	20'	25'	30'	35'	40'	45'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	



# Technical Section - Milling

## CUTTING DATA

### S400HA SLOTING

Materials:	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/16	15,600	29.44	255	0.0019
3/32	15,600	35.98	383	0.0039
1/8	15,600	42.52	511	0.0027
3/16	15,600	61.42	766	0.0039
1/4	15,600	70.87	1022	0.0045
5/16	12,000	85.05	983	0.0071
3/8	12,000	103.93	1179	0.0087
1/2	12,000	127.56	1572	0.0106
5/8	9,600	118.12	1572	0.0123
3/4	6,000	89.76	1179	0.0150

**Axial DOC (maximum) = 0.5 x D**

**Using Table Above...**

For AMG 6.1 & 6.4 — Use RPM & SFM x 0.3

For AMG 8.1 - 8.3 — Use RPM & SFM x 0.3

### S400HA SIDE CUTTING

Materials	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/16	12,000	40.01	197	0.0033
3/32	12,000	48.35	295	0.0040
1/8	12,000	56.69	393	0.0047
3/16	12,000	80.32	590	0.0067
1/4	12,000	94.49	786	0.0079
5/16	9,600	108.66	786	0.0113
3/8	9,600	127.56	943	0.0133
1/2	9,600	160.56	1258	0.0167
5/8	7,200	146.52	1179	0.0204
3/4	4,800	113.39	943	0.0236

**Axial DOC (maximum) = 1.0 x D**

**Radial DOC (maximum) = 0.25 x D (up to ø 3/8)**

**Radial DOC (maximum) = 0.5 x D (ø 1/2 - ø 3/4)**

### S401HA SLOTING

Materials:	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
5/32	12,400	36.4	508	0.0029
1/4	12,400	45.4	812	0.0037
5/16	9,920	54.5	812	0.0055
3/8	9,920	66.6	975	0.0067
1/2	9,920	81.8	1300	0.0082
5/8	7,440	75.7	1218	0.0102
3/4	4,960	60.6	975	0.0122

**Axial DOC (maximum) = 0.5 x D**

**Using Table Above...**

For AMG 8.1 - 8.3 — Use RPM & SFM x 0.3

### S401HA SIDE CUTTING

Materials	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
5/32	12,400	42.4	508	0.0034
1/4	12,400	60.6	812	0.0049
5/16	9,920	69.6	812	0.0070
3/8	9,920	81.8	975	0.0082
1/2	9,920	103	1300	0.0104
5/8	7,440	93.9	1218	0.0126
3/4	4,960	75.7	975	0.0153

**Axial DOC (maximum) = 1.0 x D**

**Radial DOC (maximum) = 0.25 x D (up to ø 3/8)**

**Radial DOC (maximum) = 0.5 x D (ø 1/2 - ø 3/4)**

Materials:	AMG 6.1 - 6.4 Copper Alloys			
"D" Tool Dia.	RPM	IPM	SFM	IPR
5/32	3,720	9.1	152	0.0024
1/4	3,720	11.5	244	0.0031
5/16	2,852	13.6	234	0.0048
3/8	2,852	16.6	280	0.0058
1/2	2,852	20.5	374	0.0072
5/8	2,232	19.1	365	0.0086
3/4	1,426	15.2	280	0.0107

**Axial DOC (maximum) = 0.5 x D**

Materials	AMG 6.1 - 6.4 Copper Alloys			
"D" Tool Dia.	RPM	IPM	SFM	IPR
5/32	3,720	10.6	152	0.0028
1/4	3,720	15.2	244	0.0041
5/16	2,852	17.6	234	0.0062
3/8	2,852	20.6	280	0.0072
1/2	2,852	25.8	374	0.0090
5/8	2,232	23.6	365	0.0106
3/4	1,426	19.1	280	0.0134

**Axial DOC (maximum) = 1.0 x D**

**Radial DOC (maximum) = 0.25 x D (up to ø 3/8)**

**Radial DOC (maximum) = 0.5 x D (ø 1/2 - ø 3/4)**

RPM = Revolutions per Minute

IPM = Inches per Minute

SFM = Surface Feet per Minute

IPR = Inches per Revolution

DOC = Depth of Cut

FT (Feet per Tooth) = IPR / # of Teeth

# Technical Section - Milling

## CUTTING DATA

### S402HA

#### PROFILING

Materials:	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/4	14,500	71.65	950	0.0049
5/16	11,200	81.9	917	0.0073
3/8	11,200	96.2	1100	0.0086
1/2	11,200	122.85	1467	0.0110
5/8	8,800	110.5	1441	0.0126
3/4	5,600	104	1100	0.0186
<b>Using Table Above...</b>				
For AMG 6.1 & 6.4 — Use RPM & SFM x 0.3				
For AMG 8.1 - 8.3 — Use RPM & SFM x 0.3				

Axial Depth of Cut (DOC) recommendation = 0.2 x D  
 Radial Depth of Cut (DOC) recommendation = 0.5 x D  
 Note: Reduce the Feed in "Long Length" options by 50%

### S403HA & S404HA

#### SLOTING

Materials:	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	15,600	43	511	0.0028
3/16	15,600	61.4	766	0.0039
1/4	15,600	73.7	1022	0.0047
5/16	12,000	86	983	0.0072
3/8	12,000	104.4	1179	0.0087
7/16	12,000	116.65	1376	0.0097
1/2	12,000	128.9	1572	0.0107
5/8	9,600	116.65	1572	0.0122
3/4	6,000	92.15	1179	0.0154
1"	6,000	98.3	1572	0.0164
<b>Axial DOC (maximum) = 0.5 x D</b>				
<b>Using Table Above...</b>				
For AMG 6.1 & 6.4 — Use RPM & SFM x 0.3				
For AMG 8.1 - 8.3 — Use RPM & SFM x 0.3				

### S403HA & S404HA

#### SIDE CUTTING

Materials	AMG 7.1 - 7.4 Aluminum & Non-Ferrous Metals			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	12,000	55.25	393	0.0046
3/16	12,000	79.8	590	0.0067
1/4	12,000	92.2	786	0.0077
5/16	9,600	110.55	786	0.0115
3/8	9,600	129	943	0.0134
7/16	9,600	144.4	1100	0.0150
1/2	9,600	159.8	1258	0.0166
5/8	7,200	147.4	1179	0.0205
3/4	4,800	113.6	943	0.0237
1"	4,800	116.65	1258	0.0243
<b>Axial DOC (maximum) = 1.0 x D</b>				
<b>Radial DOC (maximum) = 0.25 x D (up to ø 3/8)</b>				
<b>Radial DOC (maximum) = 0.5 x D (ø 1/2 - ø 1")</b>				

### S405HA

#### HIGH SPEED CUTTING (FINISHING)

Materials:	AMG 1.3-1.6 Carbon Steels, Alloy Steels			
	AMG 3.4 Cast Iron (up to 50 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/4	16,800	240	1100	0.0143
5/16	12,600	240	1032	0.0190
3/8	10,000	235	983	0.0235
1/2	8,400	200	1100	0.0238
5/8	6,300	150	1032	0.0238
3/4	5,000	120	983	0.0240
<b>Axial DOC (maximum) = 1.5 x D</b>				
<b>Radial DOC (maximum) = 0.05 x D</b>				

Materials:	AMG 1.7 - 1.8 Alloy Steels & Tool Steels (from 50 HRC up to 60 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/4	8,400	120	550	0.0143
5/16	6,300	120	516	0.0190
3/8	5,000	120	491	0.0240
1/2	4,200	100	550	0.0238
5/8	3,150	75	516	0.0238
3/4	2,500	58	491	0.0232
<b>Axial DOC (maximum) = 1.5 x D</b>				
<b>Radial DOC (maximum) = 0.05 x D</b>				

Materials:	AMG 1.8 Hardened Steels (from 60 HRC up to 65 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/4	4,200	58	275	0.0138
5/16	3,200	58	262	0.0181
3/8	2,500	58	246	0.0232
1/2	2,100	50	275	0.0238
5/8	1,600	37	262	0.0231
3/4	1,260	30	248	0.0238
<b>Axial DOC (maximum) = 1.5 x D</b>				
<b>Radial DOC (maximum) = 0.05 x D</b>				

RPM = Revolutions per Minute  
 IPM = Inches per Minute  
 SFM = Surface Feet per Minute  
 IPR = Inches per Revolution  
 DOC = Depth of Cut  
 FT (Feet per Tooth) = IPR / # of Teeth

# Technical Section - Milling

## S406HA & S406HB

### SLOTTING & SIDE CUTTING

Materials:	AMG 1.1-1.5 Carbon Steels, Alloy Steels, and Cast Iron (under 40 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	12,735	10.2	417	0.0008
3/16	8,490	10.9	417	0.0013
1/4	6,370	11.5	417	0.0018
5/16	5,100	13	418	0.0025
3/8	4,245	18.4	417	0.0043
7/16	4,010	24.5	460	0.0061
1/2	3,500	25.9	459	0.0074
9/16	3,110	26	458	0.0084
5/8	2,800	26.1	459	0.0093
3/4	2,340	24	460	0.0103
1"	1,755	17.4	460	0.0099

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

### SLOTTING & SIDE CUTTING

Materials:	AMG 2.2-2.4 Stainless Steels (300 Series)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	9,625	7.3	315	0.0008
3/16	6,385	8.3	314	0.0013
1/4	4,810	9.6	315	0.0020
5/16	3,850	10.7	315	0.0028
3/8	3,210	15.4	315	0.0048
7/16	2,750	20.9	315	0.0076
1/2	2,400	21	314	0.0088
9/16	2,140	21.2	315	0.0099
5/8	1,925	21.2	315	0.0110
3/4	1,600	19.4	314	0.0121
1"	1,200	14.7	314	0.0123

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

### SLOTTING & SIDE CUTTING

Materials:	AMG 2.1-2.3 Stainless Steels (400 Series)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	13,475	7.6	441	0.0006
3/16	12,000	8.4	590	0.0007
1/4	6,815	9.6	446	0.0014
5/16	5,390	10.7	441	0.0020
3/8	4,490	15.4	441	0.0034
7/16	3,850	20.9	441	0.0054
1/2	3,370	21	441	0.0062
9/16	2,990	21.2	441	0.0071
5/8	2,700	21.2	442	0.0079
3/4	2,250	19.4	442	0.0086
1"	1,685	15.1	441	0.0090

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

### SLOTTING & SIDE CUTTING

Materials:	AMG 4.1-4.3 Titanium			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	8,320	7.6	272	0.0009
3/16	5,550	8.4	273	0.0015
1/4	4,160	9.6	272	0.0023
5/16	3,330	10.7	273	0.0032
3/8	2,770	15.4	272	0.0056
7/16	2,380	20.7	273	0.0087
1/2	2,080	21	272	0.0101
9/16	1,850	21.2	273	0.0115
5/8	1,660	21.2	272	0.0128
3/4	1,390	19.4	273	0.0140
1"	1,040	15.1	272	0.0145

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

### SLOTTING & SIDE CUTTING

Materials:	AMG 5.1-5.3 Nickel Alloys, Inconel, Hastelloy			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	2,565	2.1	84	0.0008
3/16	1,685	1.8	83	0.0011
1/4	1,285	2.5	84	0.0019
5/16	1,025	2.8	84	0.0027
3/8	855	4.1	84	0.0048
7/16	735	5.5	84	0.0075
1/2	640	5.6	84	0.0088
9/16	570	5.7	84	0.0100
5/8	510	5.6	84	0.0110
3/4	425	5.2	84	0.0122
1"	315	4.3	83	0.0137

**Axial DOC (maximum) = 0.5 x D (Slotting)**  
**Axial DOC (maximum) = 1.0 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.35 x D (Side Cutting)**

RPM = Revolutions per Minute  
 IPM = Inches per Minute  
 SFM = Surface Feet per Minute  
 IPR = Inches per Revolution  
 DOC = Depth of Cut  
 FT (Feet per Tooth) = IPR / # of Teeth

# Technical Section - Milling

## CUTTING DATA

### S407HA

#### SLOTTING & SIDE CUTTING

Materials:	AMG 1.1-1.4 Alloy Steels			
	AMG 3.1-3.3 Cast Iron (up to 30 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	12,735	10.2	417	0.0008
3/16	8,490	10.9	417	0.0013
1/4	6,370	11.5	417	0.0018
5/16	5,100	13	418	0.0025
3/8	4,245	18.4	417	0.0043
7/16	4,010	24.5	460	0.0061
1/2	3,500	25.9	459	0.0074
9/16	3,110	26	458	0.0084
5/8	2,800	26.1	459	0.0093
3/4	2,340	24	460	0.0103
1"	1,755	17.4	460	0.0099

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

#### SLOTTING & SIDE CUTTING

Materials:	AMG 1.4-1.6 Alloy Steels			
	AMG 3.2-3.4 Cast Iron (from 30 HRC to 40 HRC)			
"D" Tool Dia.	RPM	IPM	SFM	IPR
1/8	8,910	7.1	292	0.0008
3/16	5,940	7.6	292	0.0013
1/4	4,460	8.1	292	0.0018
5/16	3,560	9.1	291	0.0026
3/8	2,970	12.7	292	0.0043
7/16	2,800	17	321	0.0061
1/2	2,460	18	322	0.0073
9/16	2,180	18.1	321	0.0083
5/8	1,960	18.3	321	0.0093
3/4	1,640	16.7	322	0.0102
1"	1,230	12.2	322	0.0099

**Axial DOC (maximum) = 1 x D (Slotting)**  
**Axial DOC (maximum) = 1.5 x D (Side Cutting)**  
**Radial DOC (maximum) = 0.5 x D (Side Cutting)**

# Technical Section - Milling

## MILLING TROUBLESHOOTING GUIDE

<i>Problem</i>	<i>Solution</i>	
<b>Chipping of the Cutting Edge</b>	<ul style="list-style-type: none"> <li>• Apply hone .0005" to .001"</li> <li>• Try air blow or coolant</li> <li>• Reduce depth of cut</li> <li>• Check amount of wear on collet</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce feed per tooth</li> <li>• If wet cutting, change to dry cutting</li> <li>• Check tool runout</li> <li>• Improve the stability of the work-holding</li> </ul>
<b>Extreme Flank Wear</b>	<ul style="list-style-type: none"> <li>• Use coated end mill</li> <li>• If conventional milling, change to climb</li> <li>• If using water soluble cutting fluid, change to non-water soluble cutting fluid</li> </ul>	<ul style="list-style-type: none"> <li>• Increase helix angle</li> <li>• If conventional milling, change to climb</li> </ul>
<b>Vibration / Chattering</b>	<ul style="list-style-type: none"> <li>• Use larger diameter end mill</li> <li>• Increase feed per tooth</li> <li>• Increase helix angle</li> <li>• Reduce length of flutes or overhang</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce cutting speed</li> <li>• Check or change the holder</li> <li>• Increase number of flutes</li> <li>• Tighten chuck or use stronger chuck</li> </ul>
<b>Deflection</b>	<ul style="list-style-type: none"> <li>• Reduce depth of cut</li> <li>• Increase feed per tooth</li> <li>• Increase helix angle</li> <li>• If using water soluble cutting fluid, change to non-water soluble cutting fluid</li> </ul>	<ul style="list-style-type: none"> <li>• Use larger diameter end mill</li> <li>• Reduce length of flutes or overhang</li> <li>• If using 2-flute type, change to 4-flute type</li> <li>• If climb milling, change to conventional milling</li> </ul>
<b>Poor Surface Finish</b>	<ul style="list-style-type: none"> <li>• Reduce end mill runout</li> <li>• Increase cutting speed</li> <li>• Reduce feed per tooth</li> <li>• Use small hone .0003" to .0006"</li> <li>• Increase helix angle</li> </ul>	<ul style="list-style-type: none"> <li>• Increase number of flutes</li> <li>• Increase volume of air or cutting fluid</li> <li>• Reduce depth of cut</li> <li>• If dry cutting, change to wet cutting</li> </ul>
<b>Waviness</b>	<ul style="list-style-type: none"> <li>• Reduce helix angle</li> <li>• Check end mill runout</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce depth of cut</li> <li>• Check or change the holder</li> </ul>
<b>End Mill Fracturing</b>	<ul style="list-style-type: none"> <li>• Reduce depth of cut</li> <li>• Reduce feed per tooth</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce length of flutes or overhang</li> <li>• If chip jamming occurs, reduce the number of flutes</li> </ul>
<b>Poor Chip Disposal</b>	<ul style="list-style-type: none"> <li>• Use air blow</li> <li>• Reduce depth of cut</li> <li>• Reduce feed per tooth</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce the number of flutes</li> <li>• Increase volume of air or cutting fluid</li> <li>• Increase cutting speed</li> </ul>
<b>Burring Workpiece Chipping</b>	<ul style="list-style-type: none"> <li>• Reduce helix angle</li> <li>• Reduce feed per tooth</li> </ul>	<ul style="list-style-type: none"> <li>• Reduce depth of cut</li> </ul>
<b>Chip Welding</b>	<ul style="list-style-type: none"> <li>• Use coolant</li> <li>• Use coated end mill</li> </ul>	<ul style="list-style-type: none"> <li>• Increase volume of cutting fluid</li> <li>• Increase helix angle</li> </ul>



# Technical Section - General

## APPLICATION MATERIAL GROUP (AMG) CHART WITH MATERIAL EXAMPLES

Application Material Groups (AMG)			Hardness HRC
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28
	4.3 Titanium, alloyed	6Al4V-4Mo, 7A14V-4Mo, 4911-4967	>28<38
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38
6. Copper	6.1 Copper	Commercially Pure	<100 HB
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB
	6.4 High Strength Bronze	Ampco 18-25	<49
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB
8. Synthetic Materials	8.1 Thermoplastics	Ultramid, Polystrol	---
	8.2 Thermosetting plastics	Bakelit, Pertinax	---
	8.3 Reinforced plastic materials	CFK, GFKAFK	---
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54
10. Graphite	10.1 Standard graphite		---

# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
<b>209</b>	115I	98I	82F	66F	39E	30D			49E	30G	33C		98I	79E	66E	46E	75F
<b>0860</b>	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
<b>1290</b>	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
<b>1511</b>	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
<b>1813</b>	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
<b>209CO</b>	115J	98H	89G	75F	56E	33D			79E	36G	56C		115J	92G	72E	56E	92G
<b>2A</b>	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
<b>2AB</b>	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
<b>2ACO</b>	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
<b>4ASM</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>4ASMCO</b>	125K	108H	98G	89G	59F	36E			72F	36H	49D		112K	98F	72F	56F	98G
<b>500-12</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>500-6</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>501-12</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>501-6</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>502-12</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>502-6</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>5ATL</b>	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
<b>5ATS</b>	115I	98I	82F	66F	39E	30D			49E	30G	33C		98I	79E	66E	46E	75F
<b>76HA</b>	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
<b>A002</b>	154J	131J	115F	98F	59F	33E			66F	39G	52C		131J	98E	92E	85E	75F
<b>A012</b>	154J	131J	115F	98F	59F	33E			66F	39G	52C		131J	98E	92E	85E	75F
<b>A022</b>	115K	105K	82I	75H	52G	33E			49G	26I	30E		105K	82I	66G	52G	82I
<b>A100</b>	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
<b>A101</b>	35H	30H	25F	20F	13E	9D			15E	8G	9C		30H	24F	20E	14E	23E
<b>A108</b>	115I	98I	82G	66F	43E	30D			49E	30G	33D		98H	79F	66E	46E	82G
<b>A125</b>	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
<b>A160</b>	197E	197E	180D	164D	131C	121A			131B	115C	115A		164C	131A	115A	98A	115A
<b>A170</b>	115H	98H	82F	66E	43D	30C			49D	23F	23B		89H	72E	62D	39D	56E
<b>A217</b>	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
<b>A218</b>	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
<b>A221</b>	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
<b>A225</b>	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
<b>A243</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>A244</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>A245</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>A345</b>	79G	72G	56E	49D	20C	16B			39C	13E	26A		72G	59D	43C	30C	49D
<b>A350</b>	89I	82I	66G	52F	33E	20D			43E	13G	26C		85I	66F	59E	36E	52F
<b>A510</b>	187M	154M	131K	98H	69F	36D			92G	46I	62G		138K	105J	92J	82F	105G
<b>A520</b>	187M	154M	131K	105I	69G	36E			98I	52I	66G		157M	121K	98J	85F	112I
<b>A530</b>	154I	131I	98F	89F	66E	33D			79E	43G	66C		118I	92E	89E	72E	105F
<b>A553</b>	279L	230L	197L	148H	92F	49D			131G	62I	89G		230K	164J	148J	138F	148G
<b>A554</b>	279L	230L	197L	148H	92F	49D			131G	62I	89G		230K	164J	148J	138F	148G
<b>A720</b>	115A	98A	89A	75A	56A	33A			72A	33A	49A		98A	79A	66A	46A	75A
<b>A900</b>	125H	108H	85H	85H	69E	52E			49E	23E	30C		79J	62J	62J	46I	72E
<b>A901</b>	197J	164J	144I	144I	108G	85G			56E	30E	36C		190I	154I	112J	92I	115G
<b>A920</b>	131J	112J	105I	105I	75E	62E			49F	23F	30D		112L	85L	85L	62J	98G
<b>A921</b>	197M	171M	174J	174J	125G	98G			56F	30F	36D		174L	138L	138L	118J	157I
<b>A940</b>	125F	108F	72G	72G	56C	39C			49C	23E	30B			52I	52I	39H	59E
<b>A941</b>	174G	151G	118G	118G	75D	56D			56C	30E	36B		118I	98I	98I	79H	82F
<b>A951</b>	89G	72G	62E	49D	26C	20B			39C	20E	39A		72G	52D	43C	30C	59D
<b>A952</b>	89G	72G	62E	49D	26C	20B			39C	20E	39A		72G	52D	43C	30C	59D
<b>A976</b>	102C	85C	72C	72C	39A	33A			39B	23C	26A			75C	52C	36A	49C
<b>A977</b>	102B	85B	72B	72B	39A	33A			39B	23B	26A			75B	52B	36A	49B
<b>A978</b>	102A	85A	72A	72A	39A	33A			39A	23A	26A			75A	52A	36A	49A
<b>ATR41</b>			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
<b>CO500-12</b>						20B			95H	56F	56D	30D	161H	85H	85F	56D	
<b>CO500-6</b>						20B			95H	56F	56D	30D	161H	85H	85F	56D	
<b>CO501-12</b>						20B			95H	56F	56D	30D	161H	85H	85F	56D	
<b>CO501-6</b>						20B			95H	56F	56D	30D	161H	85H	85F	56D	
<b>D33F</b>	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
<b>D33L</b>	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
<b>D33M</b>	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
<b>D33W</b>	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
<b>D444</b>	197E	197E	180D	164D	131C	121A			131B	115C	115A		164C	131A	115A	98A	115A
<b>DC</b>	279S	246S	246S	230S	148S	148S	98S	98S					246T	246T	180T	180T	
<b>DS-90</b>	279S	246S	246S	230S	148S	148S	98S	98S	174S	148S			246T	246T	180T	180T	148T



# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
209	43D	23B	33G	23E	13A	108F	115I	115H	52F	85J	98I	92H	75H	98K	92J	46H	10B	
0860	30B	16A	16E	13C	10A	79D	108G	72F	52D	79H	72G	72F	66E	98H	85F	33D	10A	
1290	30B	16A	16E	13C	10A	79D	108G	72F	52D	79H	72G	72F	66E	98H	85F	33D	10A	
1511	30B	16A	16E	13C	10A	79D	108G	72F	52D	79H	72G	72F	66E	98H	85F	33D	10A	
1813	30B	16A	16E	13C	10A	79D	108G	72F	52D	79H	72G	72F	66E	98H	85F	33D	10A	
209CO	66D	36C	49G	23E	20B	125L	131J	89H	69F	108J	98I	98H	89F	115K	92J	66H	16C	
2A	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B	
2AB	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B	
2ACO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C	
4ASM	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
4ASMCO	59F	33C	49H	30F	20C	125I	131K	89J	52I	115K	108J	102I	98G	115M	92K	56I	20C	
500-12	39D	20B	33G	20E	10A			89H	52G				79F				10B	
500-6	39D	20B	33G	20E	10A			89H	52G				79F				10B	
501-12	39D	20B	33G	20E	10A			89H	52G				79F				10B	
501-6	39D	20B	33G	20E	10A			89H	52G				79F				10B	
502-12	39D	20B	33G	20E	10A			89H	52G				79F				10B	
502-6	39D	20B	33G	20E	10A			89H	52G				79F				10B	
5ATL	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A	
5ATS	43D	23B	33G	23E	13A	108F	115I	115H	52F	85J	98I	92H	75H	98K	92J	46H	10B	
76HA	43D	23B	33G	16E	13A	115G	108I	89H	52G	108J	98I	89H	72H	98J	92H	46F	10B	
A002	43D	23B	43G	23E	10A	164G	108I	128H	98G	134K	125J	108I	108I	98I	164H	115F	10B	
A012	43D	23B	43G	23E	10A	164G	108I	128H	98G	134K	125J	108I	108I	98I	164H	115F	10B	
A022	46F	26C	43H	26F	13B	118H	125K	89I	52I	131F	105K	105J	82J	98K	115I	56G	13C	
A100	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B	
A101	12D	6B	10G	6E	3A	33G	35I	27H	16G	33J	30I	27H	24F	30J	28H	14F	3B	
A108	52E	23B	39G	23G	20E	108G	115I	102H	52G	108J	98I	89H	79F	98J	92H	46F	10B	
A125	30B	16A	16E	13C	10A	79D	108G	72F	52D	79H	72G	72F	66E	98H	85F	33D	10A	
A160	115A	82A	98A	82A	66A	180D	230G	197C	164C	164I	148H	131G	115F		197E		30C	
A170	30C	16A	26F	13D	10A	115F	108H	89G	52F	108I	98H	89G	72G	98I	92G	46E	10A	
A217	43D	23B	33G	16E	13A	115G	108I	89H	52G	108J	98I	89H	72H	98J	92H	46F	10B	
A218	43D	23B	33G	16E	13A	115G	108I	89H	52G	108J	98I	89H	72H	98J	92H	46F	10B	
A221	43D	23B	33G	16E	13A	115G	108I	89H	52G	108J	98I	89H	72H	98J	92H	46F	10B	
A225	43D	23B	33G	16E	13A	115G	108I	89H	52G	108J	98I	89H	72H	98J	92H	46F	10B	
A243	39D	20B	33G	20E	10A			89H	52G				79F				10B	
A244	39D	20B	33G	20E	10A			89H	52G				79F				10B	
A245	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
A345	30B	16A	26E	13C	10A	89D	108G	89F	52D	108H	89G	89F	79F	98J	98H	33F	10A	
A350	30D	16B	26G	13E	10A	108F	115I	115H	52F	108J	82I	89H	82H	115L	85J	39H	10B	
A510	66H	13B	56I	30E	20E	131D	164I	148I	66F	164G	164M	102I	108I	213G	164G	115F		
A520	66G	13B	56I	36G	23E	131E	164I	148K	66F	180I	164M	121K	115I	213G	164G	115F		
A530	59D	43B	43G	20E	10A	197G	180I	131G	115E	180I	148I	115G	92G	164J	164H	115F	10B	
A553	98E	26C	82I	49E	33G	230G	279I	262I	115G	230H	328M	180I	180J	295G				
A554	98E	26C	82I	49E	33G	230G	279I	262I	115G	230H	328M	180I	180J	295G				
A720	56A	26A	33A	23A	13A	115A	131A	115A	89A	115A	98A	89A	89A	157A	82A			
A900	49E	20C	46G	23G	20C	213G	174I	112H	98G	197J	148N	131N	92I	180I	131G			
A901	79G	33E	72I	36I	33E			184I	157I				157I					
A920	59G	33C	49I	30G	20E	213H	216J	131J	102G	246L	148N	131N	118J	180J	131H			
A921	95I	52E	79L	46I	33G			233J	164I				157J					
A940	43C	20C				213F	230F	112G	98G	174H	148N	131N	98G	180H	131F			
A941	59D	26D						157H	138H				138H					
A951	33B	20A	23E	16C	10A	72D	108G	72F	52D	98H	89G	79F	72F	98J	98H	33F	10A	
A952	33B	20A	23E	16C	10A	72D	108G	72F	52D	98H	89G	79F	72F	98J	98H	33F	10A	
A976	36A	16A						98D	89D				89D					
A977	36A	16A						98C	89C				89C					
A978	36A	16A						98B	89B				89B					
ATR41	39D	20B	33G	20E	10A			89H	52G				79F				10B	
CO500-12		20D		20B	16B													
CO500-6		20D		20B	16B													
CO501-12		20D		20B	16B													
CO501-6		20D		20B	16B													
D33F							820V	820V		656V	656V	367V	197V	197X	328V			
D33L							820V	820V		656V	656V	367V	197V	197X	328V			
D33M							820V	820V		656V	656V	367V	197V	197X	328V			
D33W							820V	820V		656V	656V	367V	197V	197X	328V			
D444	115A	82A	98A	82A	66A	180D	230G	197C	164C	164I	148H	131G	115F		197E		30C	
DC							820V	820V		656V	656V	367V	197V	197X	328V			
DS-90	115T	82S	148T	98S	66S	902V	820V	820V	230T	656V	656V	367V	197V	197X	328V			

# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
HX10	115H	69H	75I	69H	56F				105I	59H	56F		171L	89I	95H	59F	95H
HX15	115H	69H	75I	69H	56F				105I	59H	56F		171L	89I	95H	59F	95H
HX18	115H	69H	75I	69H	56F				105I	59H	56F		171L	89I	95H	59F	95H
L10	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
M40CO	125K	108H	98G	89G	59F	36E			72F	36H	49D		112K	98F	72F	56F	98G
M41CO	125K	108H	98G	89G	59F	36E			72F	36H	49D		112K	98F	72F	56F	98G
M42CO	125K	108H	98G	89G	59F	36E			72F	36H	49D		112K	98F	72F	56F	98G
M51CO	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
M52CO	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
QC0860P	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		
QC1290P	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		
QC21G	115F	69F	75H	69F	56D				105H	59F	59D		171H	89H	95F	59D	
QC21GM	115F	69F	75H	69F	56D				105H	59F	59D		171H	89H	95F	59D	
QC21P	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
QC21PM	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
QC41G	115F	69F	75H	69F	56D				105H	59F	59D		171H	89H	95F	59D	
QC41P	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
QC91G	115F	69F	75H	69F	56D				105H	59F	59D		171H	89H	95F	59D	
QC91GM	115F	69F	75H	69F	56D				105H	59F	59D		171H	89H	95F	59D	
QC91P	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
QC91PM	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
R10	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R10A	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R10B	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R10CO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R10H	108I	92I											82F	66D	52C	33C	49C
R10P	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R15	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R15A	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R15B	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R15CO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R15P	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R18	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R18A	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R18B	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R18CO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R18H	108I	92I											82F	66D	52C	33C	49C
R18P	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
R40	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R40C	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R41	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R41C	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R42	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R42C	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
R453	443V	394V	361V	328V	262V	213U	98U	82U	246V	115V	98U		394W	394W	262V	262V	180V
R454	410V	361V	295V	262V	197V	164U	98U	82U	148U	131T	115T	115T	295W	295W	230V	230V	164U
R457	443W	394W	361W	328W	262W	213U	98U	82U	246V	115V	98U		394W	394W	262V	262V	180V
R458	410W	361W	295W	262V	197V	164U	98U	82U	148U	131T	115T	115T	295W	295W	230V	230V	164U
R459	443V	394V	361U	328U	262U	180T			246V	115V	98U		394W	394W	262V	262V	
R51	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
R510	328W	295W	295W	262W	180V	148V	115T	98S	164V				295X	295X	213W	213W	148V
R51FS																	
R52	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
R520	328X	295X	295X	262X	180X	148W	115U	98T	164W				295Y	295Y	213X	213X	197W
R55	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
R56	115H	98H	82F	66E	43D	30C			49D	23F	23B		89H	72E	62D	39D	56E
R56CO	115H	98H	82F	66E	43D	30C			49D	23F	23B		89H	72E	62D	39D	56E
R57	115H	98H	82F	66E	43D	30C			49D	23F	23B		89H	72E	62D	39D	56E
R58	98F	59F	66H	59F	46D				89H	49F	49D		151H	79H	79F		89H
R88CO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R89CO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
R950 3x			328W	279W	279W	230U						115T			289V	289V	
R950 5x			328V	279V	279V	213U						115S			279V	279V	
R950 8x			295U	246U	246U	197T						98S			262U	262U	
R960 3x	361W	328W							197V	164T	131T		394V	380V			148T
R960 5x	361V	328V							164V	164S	131S		374V	354V			148T
R960 8x	328U	295U							148U	131S	115S		348U	328U			115S
S209	115I	98I	82F	66F	39E	30D			49E	30G	33C		98I	79E	66E	46E	75F

# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1	
HX10	75H		59H																
HX15	75H		59H																
HX18	75H		59H																
L10	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
M40CO	59F	33C	49H	30F	20C	125I	131K	89J	52I	115K	108J	102I	98G	115M	92K	56I	20C		
M41CO	59F	33C	49H	30F	20C	125I	131K	89J	52I	115K	108J	102I	98G	115M	92K	56I	20C		
M42CO	59F	33C	49H	30F	20C	125I	131K	89J	52I	115K	108J	102I	98G	115M	92K	56I	20C		
M51CO	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A		
M52CO	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A		
QC0860P			49F			79H 75H				348H 325H 276H				151D 125D					
QC1290P			49F			79H 75H				348H 325H 276H				151D 125D					
QC21G			59H			98I 89H 89H				400H 351H 315H									
QC21GM			59H			98I 89H 89H				400H 351H 315H									
QC21P	49F		49F			89I 79H 79H				351H 325H 276H									
QC21PM	49F		49F			89I 79H 79H				351H 325H 276H									
QC41G			59H			98I 89H 89H													
QC41P	49F		49F			89I 79H 79H				351H 325H 276H									
QC91G			59H			98I 89H 89H				400H 351H 315H									
QC91GM			59H			98I 89H 89H				400H 351H 315H									
QC91P	49F		49F			89I 79H 79H				351H 325H 276H									
QC91PM	49F		49F			89I 79H 79H				351H 325H 276H									
R10	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R10A	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R10B	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R10CO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R10H			23E			115H 118G				148J 115J 98G 95G				138J 131I 66G					
R10P	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R15	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R15A	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R15B	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R15CO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R15P	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R18	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R18A	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R18B	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R18CO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R18H			23E			115H 118G				148J 115J 98G 95G				138J 131I 66G					
R18P	39D	20B	33G	20E	10A	108G	115I	89H	52G	108J	98I	89H	79F	98J	92H	46F	10B		
R40	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R40C	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R41	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R41C	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R42	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R42C	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C		
R453	148V	131U					410W	722W	722W	328V	820W	820W	656V	492V					
R454	131U	115T					328V	656V	656V	262U	738W	738W	590V	394V					
R457	148V	131U					410W	722W	722W	328V	820W	820W	656V	492V					
R458	131U	115T					328V	656V	656V	262U	738W	738W	590V	394V					
R459						410V	722V	722V	328U	935W	935W	623V	312V						
R51	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A		
R510			164V							738Y 738Y 492X 213X				246X 377V					
R51FS						89I				348H 325H 276H									
R52	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A		
R520	148V	115U	164W							738Z 738Z 492Y 213Y				246Z 377V					
R55	30C	13A	26F	13D	10A	98E	105H	89G	52E	105I	89H	89G	82E	115I	85G	39E	10A		
R56	30C	16A	26F	13D	10A	115F	108H	89G	52F	108I	98H	89G	72G	98I	92G	46E	10A		
R56CO	30C	16A	26F	13D	10A	115F	108H	89G	52F	108I	98H	89G	72G	98I	92G	46E	10A		
R57	30C	16A	26F	13D	10A	115F	108H	89G	52F	108I	98H	89G	72G	98I	92G	46E	10A		
R58	49F		49F	23F	13B	108F	115H	115H	52F	85I	98H	92H	75H	98I	92I	46H	10B		
R88CO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R89CO	66D	36C	49G	23E	20B	125H	131F	89H	69F	108J	98I	98H	89F				20C		
R950 3x																			
R950 5x																			
R950 8x																			
R960 3x	115T	98S	115T	98S	82S														
R960 5x	115T	98S	115T	98S	82S														
R960 8x	98S	82S	98S	82S	66S														
S209	43D	23B	33G	23E	13A	108F	115I	115H	52F	85J	98I	92H	75H	98K	92J	46H	10B		

# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
<b>SPL-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPL-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPLG-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPLG-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPR-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPR-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPRG-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPRG-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPS-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPS-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPSG-120</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>SPSG-90</b>	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
<b>TS10</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>TS18</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>TS41</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>TS51</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
<b>TS52</b>	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G

### Calculations: (inch)

$$\begin{aligned} \text{RPM} &= \text{SFM}/D \times 3.82 \\ \text{SFM} &= \text{RPM} \times D \times .262 \\ \text{IPM} &= \text{IPR} \times \text{RPM} \\ \text{IPR} &= \text{IPM} \div \text{RPM} \\ \text{Inch} &= \text{mm} \times .0394 \end{aligned}$$

### Terms:

$$\begin{aligned} D &= \text{Drill Diameter} \\ \text{RPM} &= \text{Revolutions Per Minute} \\ \text{SFM} &= \text{Surface Feet per Minute} \\ \text{IPM} &= \text{Inches Per Minute} \\ \text{IPR} &= \text{Inches Per Revolution} \end{aligned}$$

# APPLICATION MATERIAL GROUPS - DRILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see page 573. For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
SPL-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPL-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPLG-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPLG-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPR-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPR-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPRG-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPRG-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPS-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPS-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPSG-120	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
SPSG-90	39B	23A	43D	26C	13A	89D	108E	89D	52D	108E	98E	98D	82D	98F	115E	56D	39A	
TS10	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
TS18	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
TS41	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
TS51	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	
TS52	52E	26C	43H	26F	13B	118H	125J	89I	52H	108K	98J	98I	82I	98K	115I	56G	13C	

### Feed Rate Chart - Drills

How To Use This Chart to Find Cutting Feed Rate (IPR):

1. Find your Alpha Code on the AMG Chart (example: 279 U : U is the Alpha Code)
2. Find the closest diameter for your cutting application on the chart to find your IPR

Alpha Code	Feed in Inches per Revolution (IPR) ± 25%										Ø Diameter					
	1mm/ 1/32"	2mm/ 3/32"	3mm/ 1/8"	4mm/ 5/32"	5mm/ 3/16"	6mm/ 1/4"	8mm/ 5/16"	10mm/ 3/8"	12mm/ 1/2"	15mm/ 9/16"	16mm/ 5/8"	20mm/ 3/4"	25mm/ 1"	30mm/ 1.1/8"	40mm/ 1.5/8"	50mm/ 2"
A	0.0004	0.0009	0.0011	0.0013	0.0014	0.0017	0.0021	0.0024	0.0027	0.0032	0.0034	0.0043	0.0049	0.0053	0.0061	0.0069
B	0.0006	0.0011	0.0015	0.0016	0.0018	0.0021	0.0026	0.0031	0.0035	0.0041	0.0043	0.0053	0.0060	0.0065	0.0074	0.0082
C	0.0006	0.0013	0.0017	0.0020	0.0022	0.0025	0.0031	0.0039	0.0043	0.0049	0.0051	0.0063	0.0071	0.0077	0.0087	0.0094
D	0.0006	0.0015	0.0021	0.0024	0.0027	0.0031	0.0039	0.0047	0.0051	0.0059	0.0061	0.0074	0.0083	0.0090	0.0100	0.0108
E	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068	0.0071	0.0085	0.0094	0.0102	0.0112	0.0122
F	0.0007	0.0020	0.0029	0.0033	0.0037	0.0043	0.0054	0.0065	0.0070	0.0080	0.0083	0.0098	0.0108	0.0116	0.0126	0.0135
G	0.0007	0.0022	0.0033	0.0038	0.0043	0.0050	0.0063	0.0075	0.0081	0.0091	0.0094	0.0110	0.0122	0.0130	0.0140	0.0148
H	0.0008	0.0026	0.0040	0.0046	0.0051	0.0059	0.0075	0.0090	0.0096	0.0107	0.0110	0.0126	0.0140	0.0148	0.0157	0.0165
I	0.0008	0.0030	0.0047	0.0053	0.0059	0.0068	0.0087	0.0104	0.0110	0.0122	0.0126	0.0142	0.0157	0.0165	0.0173	0.0181
J	0.0009	0.0033	0.0053	0.0060	0.0067	0.0078	0.0098	0.0117	0.0124	0.0137	0.0142	0.0159	0.0175	0.0183	0.0191	0.0198
K	0.0010	0.0036	0.0059	0.0067	0.0075	0.0087	0.0110	0.0130	0.0138	0.0153	0.0157	0.0177	0.0193	0.0201	0.0209	0.0215
L	0.0011	0.0040	0.0065	0.0073	0.0082	0.0094	0.0120	0.0142	0.0152	0.0165	0.0169	0.0191	0.0207	0.0215	0.0224	0.0231
M	0.0012	0.0043	0.0071	0.0080	0.0089	0.0102	0.0130	0.0154	0.0165	0.0177	0.0181	0.0205	0.0220	0.0228	0.0238	0.0248
N	0.0013	0.0047	0.0077	0.0086	0.0095	0.0110	0.0140	0.0165	0.0179	0.0189	0.0193	0.0219	0.0234	0.0242	0.0253	0.0265
S	0.0003	0.0006	0.0008	0.0010	0.0012	0.0015	0.0020	0.0031	0.0039	0.0048	0.0051	0.0059	0.0070	0.0070	0.0090	
T	0.0006	0.0011	0.0016	0.0020	0.0024	0.0028	0.0035	0.0043	0.0051	0.0063	0.0067	0.0075	0.0080	0.0090	0.0100	
U	0.0010	0.0019	0.0028	0.0031	0.0035	0.0042	0.0055	0.0067	0.0079	0.0088	0.0091	0.0094	0.0110	0.0120	0.0140	
V	0.0015	0.0027	0.0039	0.0045	0.0051	0.0060	0.0079	0.0098	0.0110	0.0122	0.0126	0.0134	0.0160	0.0170	0.0200	
W	0.0019	0.0035	0.0051	0.0059	0.0067	0.0079	0.0102	0.0130	0.0150	0.0165	0.0169	0.0177	0.0190	0.0190	0.0200	
X	0.0022	0.0041	0.0059	0.0071	0.0083	0.0098	0.0130	0.0165	0.0189	0.0210	0.0217	0.0228				
Y	0.0027	0.0049	0.0071	0.0087	0.0102	0.0125	0.0169	0.0217	0.0276	0.0276	0.0276	0.0291				
Z	0.0037	0.0068	0.0098	0.0128	0.0157	0.0210	0.0315	0.0394	0.0433	0.0463	0.0472	0.0472				

# APPLICATION MATERIAL GROUPS - TAPS

## SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
1500	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1500A	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1500L	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1500OV	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1505	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1508	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1519	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1528	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1534	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1534NE	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1534NR	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1541	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1542	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1543	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1544													65	40	40	25	
1545	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1545A	60	45	30	30	20	10			25	15	15						20
1548	60	50	35	35					25	20	20						20
1549	60	50	35	35					25	20	20						20
1567	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1568	45	35	25	15	10				25	15	15						20
1572	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1578	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1580	120	100	60	60	40				50	30	40						40
1582	60	50	35	35					25	20	20						20
1585	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1585A	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1585NR	65	60	40	40	25	15			20	13	10		50	30	30	20	20
1585OV	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1586	60	50	35	35					26	20	20						20
1587																	
1588																	
1590	70	60	40	40	30				30	26	20						20
1591	70	60	40	40	30				30	26	20						20
1592	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1593	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1595	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1599													65	40	40	25	
1599SB													65	40	40	25	
1600													65	40	40	25	
1629AP					45	25						30	90	70	65	35	
1630AP					45	25						30	90	70	65	35	
1634	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1641	150	125	90	90					70	60	50						60
1659AP					45	25						30	90	70	65	35	
1660AP					45	25						30	90	70	65	35	
1671	150	125	90	90					70	60	50						60
1672AP	110	90	55	55	45				50	40	40						35
1673AP	110	90	55	55	45				50	40	40						35
1674	120	100	65	65	50				60	40	45						40
1675	120	100	65	65	50				60	40	45						40
1676AP	100	80	50	50	40				45	30	35						30
1677AP	100	80	50	50	40				45	30	35						30
1678	110	90	55	55	45				50	40	40						35
1679	110	90	55	55	45				50	40	40						35
1681AP	150	125	90	90					70	50	60						60
1687AP	150	125	90	90					70	50	60						60
1691AP	165	135	100	100					80	70	60						70
1697AP	165	135	100	100					80	70	60						70
1700M	60	45	30	30	20	10			25	15	15		50	30	30	15	20
1785M	65	60	40	40	25	15			30	20	20		50	30	30	20	20
1785NR	66	59	46	33	16	10			20	13	10		46	26	26	16	

# APPLICATION MATERIAL GROUPS - TAPS

## SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
1500	15		20	10		25	80	60	10	50	100	75	20	25	15			
1500A	15		20	10		25	80	60	10	50	100	75	20	25	15			
1500L	15		20	10		25	80	60	10	50	100	75	20	25	15			
1500OV	15		20	10		25	80	60	10	50	100	75	20	25	15			
1505	15		20	10		25	80	60	10	50	100	75	20	25	15			
1508	15		20	10		25	80	60	10	50	100	75	20	25	15			
1519	15		20	10		25	80	60	10	50	100	75	20	25	15			
1528	15		20	10		25	80	60	10	50	100	75	20	25	15			
1534	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1534NE	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1534NR	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1541	15		20	10		25	80	60	10	50	100	75	20	25	15			
1542	15		20	10		25	80	60	10	50	100	75	20	25	15			
1543	15		20	10		25	80	60	10	50	100	75	20	25	15			
1544									15									
1545	15		20	10		25	80	60	10	50	100	75	20	25	15			
1545A	15		20	10		25	80	60	10	50	100	75	20	25	15			
1548	15	5	20	15														
1549	15	5	20	15														
1567	15		20	10		25	80	60	10	50	100	75	20	25	15			
1568	10		20	10		30	50	50		50	75	50		25	15			
1572	15		20	10		25	80	60	10	50	100	75	20	25	15			
1578	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1580	30		40			50	150	120		100	200	125						
1582	15	5	20	15														
1585	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1585A	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1585NR	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1585OV	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1586	15	5	20	15														
1587						30	80	60		50	60	60						
1588						30	80	60		50	60	60						
1590	15	5			10													
1591	15	5			10													
1592	15		20	10		25	80	60	10	50	100	75	20	25	15			
1593	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1595	15		20	10		25	80	60	10	50	100	75	20	25	15			
1599									15									
1599SB									15									
1600									15									
1629AP		10			15				25									
1630AP		10			15				25									
1634	16	7	26	10		30	89	69	10	49	98	66	20	98	26			
1641			45			55	180	130		180	200	230						
1659AP		10			15				25									
1660AP		10			15				25									
1671			45			55	180	130		180	200	230						
1672AP	25		35	20		45	120	100		85	100	85	30					
1673AP	25		35	20		45	120	100		85	100	85	30					
1674	30		40	25		50	125	110		95	120	95	40					
1675	30		40	25		50	125	110		95	120	95	40					
1676AP	20		30	15		40	100	90		80	95	80	30					
1677AP	20		30	15		40	100	90		80	95	80	30					
1678	25		35	20		45	120	100		85	100	85	30					
1679	25		35	20		45	120	100		85	100	85	30					
1681AP			45			55	180	130		180	200	230						
1687AP			45			55	180	130		180	200	230						
1691AP			55			70	200	160		200	240	260						
1697AP			55			70	200	160		200	240	260						
1700M	15		20	10		25	80	60	10	50	100	75	20	25	15			
1785M	15	5	25	10		30	90	70	10	70	100	75	20	90	25			
1785NR		10	33	13		33		49		33	82	43	33	66				

# APPLICATION MATERIAL GROUPS - TAPS

## SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
1788(M)																	
1985	75	69	49	49	30	16			36	20							20
1994	82	72	59	49										26			
3300	98	79	49	49	30				39	30							30
3306E	98	79	49	49	30				39	30							30
6541	16	16	23	20	13								23	16	23	16	
E000	82	72	59	52	33	16							49	26	49	26	33
E000TIN	131	131	105	89	43	36			26	23	16		72	23	16		49
E001	82	72	59	52	33	16			23	20	13		49	26	49	26	
E002	82	72	59	52	33												33
E003	82	72	59	52	33				23	20	13						
E005	82	72	59	52	33	16							49	26	49	26	33
E006	82	72	59	52	33	16			26	23	16		49	26	49	26	
E007	82	72	59	52	33												33
E008	82	72	59	52	33				23	20	13						
E011	82	72	59	52	33	16			23	20	13		49	26	49	26	
E013	82	72	59	52	33				23	20	13						
E016	82	72	59	52	33	16			26	23	16		49	26	49	26	
E018	82	72	59	52	33				23	20	13						
E021	82	72	59	52	33	16			23	20	13		49	26	49	26	
E023	82	72	59	52	33				23	20	13						
E025	82	72	59	52	33	16							49	26	49	26	33
E026	82	72	59	52	33	16			26	23	16		49	26	49	26	
E027	82	72	59	52	33												33
E028	82	72	59	52	33				23	20	13						
E031	82	72	59	52	33	16			23	20	13		49	26	49	26	
E033	82	72	59	52	33	16			23	20	13						
E035	82	72	59	52	33	16							49	26	49	26	33
E036	82	72	59	52	33	16			26	23	16		49	26	49	26	
E037	82	72	59	52	33	16											33
E038	82	72	59	52	33	16			23	20	13						
E041	82	72	59	52	33	16			23	20	13		49	26	49	26	
E043	82	72	59	52	33	16			23	20	13						
E052	82	72	59	52	33												
E061	72	66	52	39	23	13							39	23	33	16	
E071	72	66	52	39	23	13							39	23	33	16	
E201													49	26	49	26	
E252													49	26	49	26	
E500	23	20	16	13	10								39	23	33	16	
E501	23	20	16	13	10								39	23	33	16	
E504	46	39	33	26	20								59	39	72	39	
E513	23	20	16	13	10								39	23	33	16	
E547	23	20	16	13	10								39	23	33	16	
E550	72	66	52	39	23	13			23	16	23		39	23	33	16	
E620	23	20	16	13	10								39	23	33	16	
E621		59	46	33	16				20	13	10						
E650	82	72	59	49										26			
E651	82	72	59	49										26			
E653	82	72	59	49										26			
E654	82	72	59	49										26			
E710	13	13	20	16	10								20	13	20	13	
E711	13	13	20	16	10								20	13	20	13	
E712	13	13	20	16	10								20	13	20	13	
E721	13	13	20	16	10								20	13	20	13	
EP006H	82	72	59	52	33	16							49	26	49	26	33
EP016H	82	72	59	52	33	16			23	20	13		49	26	49	26	
EP10	82	72	59	52	33	16							49	26	49	26	33
EP11	82	72	59	52	33	16			23	20	13		49	26	49	26	
EP20	82	72	59	52	33	16							49	26	49	26	33
EP21	82	72	59	52	33	16			23	20	13		49	26	49	26	
EP30	82	72	59	52	33	16							49	26	49	26	33
EP31	82	72	59	52	33	16			23	20	13		49	26	49	26	
EP40	82	72	59	52	33	16							49	26	49	26	33



# APPLICATION MATERIAL GROUPS - TAPS

## SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
1788(M)						30	79	79		49	66	66						
1985	16	7	30	16	10													
1994							98	66		59	115			98				
3300	26		30			39	121	98		79	161	98						
3306E	26		30			39	121	98		79	161	98						
6541							39					39	26	16				
E000	16		39	16		39	98	66		52	115	66	49	98				
E000TIN	23		59	26		59	148	115				98	72		148			
E001																		
E002	16		39	16						52	115	66	49					
E003																		
E005	16		39	16		39	98	66		52	115	66	49	98				
E006																		
E007	16		39	16						52	115	66	49					
E008																		
E011																		
E013																		
E016																		
E018																		
E021																		
E023																		
E025	16		39	16		39	98	66		52	115	66	49	98				
E026																		
E027	16		39	16		39	98	66		52	115	66	49	98				
E028																		
E031																		
E033																		
E035	16		39	16		39	98	66		52	115	66	49	98				
E036																		
E037	16		39	16						52	115	66	49	98				
E038																		
E041																		
E043																		
E052						39	98	66		52	115	66	49					
E061						39	98	66				66	49		39	23		
E071						39	98	66				66	49		39	23		
E201							66		16				49			33		
E252							66		16				49			33		
E500						13	33	23	7		39	23	16		16	10		
E501						13	33	23	7		39	23	16		16	10		
E504							66	46	13		79	46	33		33	20		
E513						13	33	23	7		39	23	16		16	10		
E547						13	33	23	7		39	23	16		16	10		
E550						39	98	66	13		115	66	49		39	23		
E620						13	33	23	7		39	23	16		16	10		
E621			13							33	82	43	33					
E650							98	66		59	115			98				
E651							98	66		59	115			98				
E653							98	66		59	115			98				
E654							98	66		59	115			98				
E710							36					36	23	13				
E711							36					36	23	13				
E712							36					36	23	13				
E721							36					36	23	13				
EP006H	16		39	16		39	98	66		52	115	66	49	98				
EP016H																		
EP10	16		39	16		39	98	66		52	115	66	49	98				
EP11																		
EP20	16		39	16		39	98	66		52	115	66	49	98				
EP21																		
EP30	16		39	16		39	98	66		52	115	66	49	98				
EP31																		
EP40	16		39	16		39	98	66		52	115	66	49	98				

## APPLICATION MATERIAL GROUPS - TAPS SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
EP41	82	72	59	52	33	16			23	20	13		49	26	49	26	
EX006H	82	72	59	52	33				23	20	13						33
EX016H	82	72	59	52	33				23	20	13						
EX10	82	72	59	52	33												33
EX11	82	72	59	52	33				23	20	13						
EX20	82	72	59	52	33												33
EX21	82	72	59	52	33				23	20	13						
EX30	82	72	59	52	33												33
EX31	82	72	59	52	33				23	20	13						
EX40	82	72	59	52	33												33
EX41	82	72	59	52	33				23	20	13						
TN1500	59	46	30	30	20	10			26	26	16		49	30	30	16	20
TN1534	79	75	49	49	30	20			39	26	26		49	30	30	20	
TN1541	16	16	23	20	13								23	16	23	16	
TN1543	16	16	23	20	13								23	16	23	16	
TN1585	79	75	49	49	30	20			39	26	26		49	30	30	20	
TN1785	79	75	49	49	30	20			39	26	26		49	30	30	20	
U1511	39	33	26	20	16								46	26	39		

## APPLICATION MATERIAL GROUPS - DIES SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
2010	26	23	20	16					13	7			26	23	20	16	
2025	26	23	20	16					13	7			26	23	20	16	
2325M	26	23	20	16					13	7			26	23	20	16	
2510	26	23	20	16					13	7			26	23	20	16	
2710M	26	23	20	16					13	7			26	23	20	16	
F201	26	23	20	16					13	7			26	23	20	16	
F302	26	23	20	16					13	7			26	23	20	16	
F312	26	23	20	16					13	7			26	23	20	16	
F320	26	23	20	16					13	7			26	23	20	16	
F330	26	23	20	16					13	7			26	23	20	16	
F370	26	23	20	16					13	7			26	23	20	16	

## APPLICATION MATERIAL GROUPS - TAPS SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
EP41																		
EX006H	16		39	16						52	115	66	49					
EX016H																		
EX10	16		39	16						52	115	66	49					
EX11																		
EX20	16		39	16						52	115	66	49					
EX21																		
EX30	16		39	16						52	115	66	49					
EX31																		
EX40	16		39	16						52	115	66	49	98				
EX41																		
TN1500	16		20	10		26	79	59	10	49	98	75	20	30	16			
TN1534			30	13		39	115	89	13	66	125	79	26	121	30			
TN1541							39					39	26	16				
TN1543							39					39	26	16				
TN1585			30	13		39	115	89	13	66	125	79	26	121	30			
TN1785			30	13		39	115	89	13	66	125	79	26	121	30			
U1511							52	39			66	39			26			

## APPLICATION MATERIAL GROUPS - DIES SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
2010	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
2025	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
2325M	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
2510	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
2710M	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F201	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F302	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F312	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F320	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F330	7		30	7	7	30	26	23		33	49	49	33	49	33	16		
F370	7		30	7	7	30	26	23		33	49	49	33	49	33	16		

# APPLICATION MATERIAL GROUPS - END MILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see pages 582 & 583. For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
883	66P	66P	52P	46P	33P	26P			43P	30P	20R	16R	59R	49R	52R	33R	52N
905	112S	89S	79T										89S	72S	89T		62V
920	98A	89A	75B										82A	66A	82B		59D
923	98A	89A	75B										82A	66A	82B		59D
930		131A	115B	98B	66C					62F				75A	131B	82B	92D
940	115S	92S	79T	69T					52Y				92S	75S	92T	56T	62V
945	164S	131S	115T	98T					75Y				92S	75S	131T	82T	92V
948	115S	92S	79T	69T					52Y				92S	75S	92T	56T	62V
960	164S	131S	115T	98T					75Y				92S	75S	131T	82T	92V
963	164A	131A	115B	98B					75F				92A	75A	131B	82B	92D
980	164A	131A	115B						75F	62F							92D
981	148A	118A	102B						66F	56F							82D
9002	164G	131G	115H	98H					75L				92G	75G	131H	82H	92J
9003	164G	131G	115H	98H					75L				92G	75G	131H	82H	92J
9008	148G	118G	102H	89H					66L				82G	66G	118H	72H	82J
9009	148G	118G	102H	89H					66L				82G	66G	118H	72H	82J
920K	98A	89A	75B										82A	66A	82B		59D
C110	197A	164A	131B	115B					98F				115A	98A	164B	98B	115D
C123	180A	148A	131B	115B					82F				98A	82A	148B	98B	98D
C247	180S	148S	131T	115T					82Y				98S	82S	148T	82T	98V
C273	164S	164S	115T	98T					33Y				82S	66S	131T	82T	82V
C346	148A	115A	98B	82B					66F				82A	66A	115B	66B	82D
E3302	289B	223B	223B	180B	161B	148B			200A	141A	108A	89A	374B	318B	318B	249B	
E3302M	289B	223B	223B	180B	161B	148B			200A	141A	108A	89A	374B	318B	318B	249B	
E3302V	400B	298B	298B	259B	230B	200B			325A	223A	174A	131A	551B	525B	525B	374B	230B
E3303	289B	223B	223B	180B	161B	148B			200A	141A	108A		374B	318B	318B	249B	
E3303V	400B	298B	298B	259B	230B	200B			325A	223A	174A		551B	525B	525B	374B	230B
E3304	361B	325B	325B	298B	249B	230B			239A	171A	131A	105A	449B	377B	377B	279B	
E3304M	361B	325B	325B	298B	249B	230B			239A	171A	131A	105A	449B	377B	377B	279B	
E3304MV	499B	449B	449B	423B	400B	328B			351A	276A	200A	164A	699B	649B	649B	430B	259B
E3304V	499B	449B	449B	423B	400B	328B			351A	276A	200A	164A	699B	649B	649B	430B	259B
E4302	289B	223B	223B	180B	161B	148B			200A	141A	108A	89A	374B	318B	318B	249B	
E4304	361B	325B	325B	298B	249B	230B			239A	171A	131A	105A	449B	377B	377B	279B	
E5302	269B	212B	212B	171B	152B	140B			190A	125A	103A	78A	336B	284B	284B	225B	
E5304	343B	312B	312B	287B	238B	205B			220A	156A	123A	97A	405B	338B	338B	254B	
E5304V	474B	425B	425B	406B	380B	313B			338A	251A	182A	140A	650B	578B	578B	415B	245B
E6302	249B	200B	200B	161B	144B	131B			180A	108A	98A	66A	298B	249B	249B	200B	
E6302V	361B	269B	269B	239B	200B	180B			298A	180A	171A	131A	499B	400B	400B	341B	200B
E6304	325B	298B	298B	276B	226B	180B			200A	141A	115A	89A	361B	298B	298B	230B	
E6304V	449B	400B	400B	390B	361B	298B			325A	226A	164A	115A	600B	508B	508B	400B	230B
EB3302	289B	223B	223B	180B	161B	148B			200A	141A	108A	89A	374B	318B	318B	249B	
EB3302M	289B	223B	223B	180B	161B	148B			200A	141A	108A	89A	374B	318B	318B	249B	
EB3302MV	400B	298B	298B	259B	230B	200B			325A	223A	174A	131A	551B	525B	525B	374B	230B
EB3302V	400B	298B	298B	259B	230B	200B			325A	223A	174A	131A	551B	525B	525B	374B	230B
EB3304	361B	325B	325B	298B	249B	230B			239A	171A	131A	98A	449B	377B	377B	279B	
EB3304M	361B	325B	325B	298B	249B	230B			239A	171A	131A	98A	449B	377B	377B	279B	
EB3304MV	499B	449B	449B	423B	400B	328B			351A	276A	200A	148A	699B	649B	649B	430B	259B
EB3304V	499B	449B	449B	423B	400B	328B			351A	276A	200A	148A	699B	649B	649B	430B	259B
EB5302	269B	212B	212B	171B	152B	140B			190A	125A	103A	78A	336B	284B	284B	225B	
EB5304	343B	312B	312B	287B	238B	205B			220A	156A	123A		405B	338B	338B	255B	
EB5304V	450B	412B	412B	387B	363B	288B			288A	233A	176A	135A	500B	540B	540B	384B	230B
EB6302	249B	200B	200B	161B	144B	131B			180A	108A	98A	82A	298B	249B	249B	200B	
EB6302V	361B	269B	269B	239B	200B	180B			298A	180A	171A	89A	499B	400B	400B	341B	200B
EB6304	325B	298B	298B	276B	226B	180B			200A	141A	115A		361B	298B	298B	230B	
EB6304V	400B	374B	374B	351B	325B	249B			226A	190A	151A	121A	499B	430B	430B	338B	200B
TC9002	197G	184G	161H	138H					105L				128G	105G	184H	128H	128J
TC9003	197G	184G	161H	138H					105L				128G	105G	184H	128H	128J

# APPLICATION MATERIAL GROUPS - END MILLS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see pages 582 & 583. For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
883	36P 200		66P 130	7M		131P 148P	148P 16M			180R 134R	85R 56R							56R
905	49V		108V 20U			200U 223U	223U			243X 194X	144X			200U				
920	49D		98D 20C			180C 197C	197C			197E 180E	115E			197C				
923	49D		98D 20C			180C 197C	197C			197E 180E	115E			197C				
930	75D 33D		43C 20D			410C 410C	49C			295E 197A				410C				
940	52V		108V 20U			203U 223U	223U			197X 148X				203U				
945	75V		157V 43U			410U 410U	410U			984X 984X	295X			410U				
948	52V		108V 20U			203U 223U	223U			197X 148X				203U				
960	75V		157V 43U			410U 410U	410U			984X 984X	295X			410U				
963	75D		157D 43C			410C 410C	410C			984E 984E	295E			410C				
980			157D			410C				984E 984E	295E			410C				
981			141D			367C				886E 886E	266E			367C				
9002	75J		157J 43I			410I 410I	410I			984K 295K				410I				
9003	75J		157J 43I			410I 410I	410I			984K 295K				410I				
9008	66J		141J 36I			367I 367I	367I			886K 266K				367I				
9009	66J		141J 36I			367I 367I	367I			886K 266K				367I				
920K	49D		98D 20C			180C 197C	197C			197E 180E	115E			197C				
C110	82D		197D 49C			279C 279C	279C			722E 722E	279E			295C				
C123	82D		164D 49C			262C 262C	262C			656E 656E	262E			262C				
C247	82V		164V 49U			262U 262U	262U			656X 656X	262X			262U				
C273	66V		148V 33U			230U 230U	230U			590X 590X	230X			230U				
C346	66D		148D 33C			230C 230C	230C			590E 590E				230C				
E3302						649C 499C	499C 125B			1499C 1499C	649C 400B							
E3302M						649C 499C	499C 125B			1499C 1499C	649C 400B							
E3302V	200B 190B		230B 161A 98A															
E3303						649C 499C	499C 125B			1499C 1499C	649C 400B							
E3303V	200B 190B		230B 161A 98A															
E3304						679C 574C	574C 144B			1601C 1601C	708C 479B							
E3304M						679C 574C	574C 144B			1601C 1601C	708C 479B							
E3304MV	230B 200B		266B 200A 131A															
E3304V	230B 200B		266B 200A 131A															
E4302						649C 499C	499C 125B			1499C 1499C	649C 400B							
E4304						679C 574C	574C 144B			1601C 1601C	708C 479B							
E5302						617C 474C	474C 117B			1424C 1424C	617C 380B							
E5304						646C 546C	546C 138B			1525C 1525C	674C 455B							
E5304V	220B 190B		251B 190A 123A															
E6302						584C 449C	449C 108B			1348C 1348C	584C 361B							
E6302V	180B 174B		200B 141A 85A															
E6304						613C 518C	518C 131B			1450C 1450C	640C 430B							
E6304V	210B 180B		236B 180A 115A															
EB3302						649C 499C	499C 125B			1499C 1499C	649C 400B							
EB3302M						649C 499C	499C 125B			1499C 1499C	649C 400B							
EB3302MV	200B 190B		230B 161A 98A															
EB3302V	200B 190B		230B 161A 98A															
EB3304						679C 574C	574C 144B			1601C 1601C	708C 479B							
EB3304M						679C 574C	574C 144B			1601C 1601C	708C 479B							
EB3304MV	230B 200B		266B 200A 131A															
EB3304V	230B 200B		266B 200A 131A															
EB5302						617C 474C	474C 117B			1424C 1424C	617C 380B							
EB5304						646C 546C	546C 137B			1526C 1526C	674C 455B							
EB5304V	210B 180B		238B 176A															
EB6302			148B			584C 449C	449C 108B			1348C 1348C	584C 361B							
EB6302V	180B 174B		200B 141A 85A															
EB6304						613C 518C	518C 131B			1450C 1450C	640C 430B							
EB6304V	190B		210B			699C 571C	571C 180B			1650C 1650C	708C 410B							
TC9002	105J		220J 59I			574I 574I	574I			1378K 413K				574I				
TC9003	105J		220J 59I			574I 574I	574I			1378K 413K				574I				

# APPLICATION MATERIAL GROUPS - END MILLS

## SURFACE FEET PER MINUTE (SFM)








\*Feed rate chart - see pages 582 & 583. For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
S400HA																	
S401HA																	
S402HA																	
S403HA																	
S404HA																	
S405HA			*	*	*	*	*	*									
S406HA	*	*	*	*	*				*	*	*	*					*
S406HB	*	*	*	*	*				*	*	*	*					*
S407HA	*	*	*	*	*	*							*	*	*	*	

## Feed Rate Chart - Solid Carbide End Mills

### How To Use This Chart to Find Cutting Feed Rate (IPR):

1. Find your Alpha Code on the AMG Chart (example: 279 U : U is the Alpha Code).
2. Find the closest diameter for your cutting application on the chart.
3. Select the type of cut and # Flutes to find your Ft Range.

# of Flutes	Type of Cut	Depth/Width of Cut	Alpha Code	Feed Per Tooth (Ft) Dia Inches												
				1/8	5/32	3/16	1/4	5/16	13/32	1/2	9/16	5/8	11/16	3/4		
>4		↓ 1,5 ↔ 0,05	A				0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002		
			B				0.002	0.002	0.002	0.003	0.003	0.004	0.004	0.004		
			C				0.003	0.003	0.004	0.004	0.005	0.005	0.006	0.007		
3-4		↓ 1,5 ↔ 0,1	A	0.001	0.001	0.002	0.002	0.002	0.002	0.003	0.003	0.004	0.004	0.005		
			B	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.006	0.007		
			C	0.001	0.002	0.002	0.003	0.004	0.005	0.006	0.006	0.007	0.008	0.009		
3-4		↓ 1 ↔ 0,5	A	0.000	0.000	0.000	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002		
			B	0.003	0.000	0.001	0.001	0.001	0.002	0.002	0.002	0.003	0.003	0.004		
			C	0.000	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005		
2-3		↓ 0,5 ↔ 1	A	0.000	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003		
			B	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004		
			C	0.001	0.001	0.001	0.002	0.002	0.003	0.003	0.004	0.004	0.005	0.005		
3-4		↓ 0,5 ↔ 1 ↓ 1 ↔ 0,5	B				0.001	0.002	0.003	0.003	0.003	0.004	0.004	0.004		
2 & 4		↓ 0,1 - 0,5mm ↔ 0,1 - 0,5mm	A													
			BC	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003	0.003			
4		↓ 0,01 - 0,1 ↔ ≤ 1	A													
			BC				0.002	0.002	0.002	0.003			0.003			
							0.002	0.002	0.003	0.003			0.004			

# APPLICATION MATERIAL GROUPS - END MILLS

## SURFACE FEET PER MINUTE (SFM)





\*Feed rate chart - see pages 582 & 583. For material examples, see page 567.

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
S400HA						*	*	*	*	*	*	*	*	*	*	*		
S401HA						*	*	*	*	*	*	*	*	*	*	*		
S402HA						*	*	*	*	*	*	*	*	*	*	*		
S403HA						*	*	*	*	*	*	*	*	*	*	*		
S404HA						*	*	*	*	*	*	*	*	*	*	*		
S405HA																		
S406HA	*	*	*	*	*													
S406HB	*	*	*	*	*													
S407HA																		

### Feed Rate Chart - HSS End Mills

#### How To Use This Chart to Find Cutting Feed Rate (IPR):

1. Find your Alpha Code on the AMG Chart (example: 279 U : U is the Alpha Code).
2. Find the closest diameter for your cutting application on the chart.
3. Select the type of cut and # Flutes to find your Ft Range.

		Feed per Tooth (Ft) Dia Inches																
Type of Cut	Alpha Code	0.078	1/8	5/32	3/16	1/4	5/16	13/32	1/2	9/16	5/8	11/16	3/4	7/8	1"	1.1/4	1.1/2	
	A	0.0003	0.0005	0.0007	0.0009	0.0011	0.0017	0.0024	0.0028	0.0033	0.0038	0.0038	0.0038	0.0039	0.0041	0.0042	0.0043	
	B	0.0003	0.0005	0.0006	0.0009	0.0010	0.0015	0.0021	0.0026	0.0030	0.0034	0.0034	0.0034	0.0035	0.0037	0.0037	0.0038	
	C	0.0003	0.0004	0.0006	0.0007	0.0009	0.0014	0.0019	0.0023	0.0027	0.0031	0.0031	0.0031	0.0031	0.0033	0.0034	0.0034	
	↓ 0,5D	D	0.0003	0.0004	0.0006	0.0008	0.0009	0.0015	0.0020	0.0024	0.0028	0.0032	0.0032	0.0032	0.0033	0.0035	0.0038	0.0040
	↔ D	E	0.0005	0.0007	0.0009	0.0014	0.0017	0.0025	0.0034	0.0041	0.0048	0.0055	0.0056	0.0066	0.0060	0.0066	0.0069	
		F	0.0004	0.0005	0.0007	0.0008	0.0010	0.0013	0.0016	0.0020	0.0022	0.0025	0.0028	0.0031	0.0031	0.0033	0.0033	0.0033
	G					0.0010	0.0013	0.0014	0.0017	0.0020	0.0022	0.0025	0.0028	0.0028	0.0021	0.0021	0.0022	
	H					0.0009	0.0012	0.0013	0.0015	0.0018	0.0020	0.0023	0.0026	0.0026	0.0019	0.0019	0.0020	
	I					0.0008	0.0011	0.0011	0.0014	0.0016	0.0018	0.0020	0.0023	0.0023	0.0017	0.0017	0.0018	
	↓ D	J					0.0009	0.0012	0.0013	0.0015	0.0018	0.0020	0.0023	0.0026	0.0026	0.0019	0.0019	0.0020
	↔ 0,8D	K					0.0014	0.0019	0.0026	0.0031	0.0036	0.0059	0.0035	0.0039	0.0038	0.0043	0.0043	0.0046
		L					0.0004	0.0005	0.0007	0.0008	0.0010	0.0011	0.0012	0.0013	0.0013	0.0013	0.0015	0.0017
	M	0.0003	0.0005	0.0007	0.0009	0.0012	0.0016	0.0022	0.0027	0.0031	0.0036	0.0041	0.0045	0.0035	0.0041	0.0038	0.0042	
	N	0.0003	0.0004	0.0006	0.0008	0.0011	0.0015	0.0020	0.0024	0.0028	0.0032	0.0037	0.0041	0.0024	0.0037	0.0034	0.0038	
	O	0.0002	0.0004	0.0006	0.0007	0.0010	0.0013	0.0018	0.0022	0.0026	0.0029	0.0033	0.0036	0.0029	0.0033	0.0031	0.0034	
	↓ 1,5D	P	0.0003	0.0004	0.0006	0.0008	0.0011	0.0014	0.0019	0.0023	0.0027	0.0031	0.0015	0.0039	0.0031	0.0035	0.0033	0.0036
	↔ 0,25D	Q	0.0004	0.0006	0.0008	0.0010	0.0015	0.0019	0.0026	0.0031	0.0036	0.0041	0.0035	0.0039	0.0039	0.0044	0.0050	0.0055
		R	0.0005	0.0006	0.0008	0.0010	0.0011	0.0015	0.0019	0.0022	0.0026	0.0029	0.0033	0.0036	0.0036	0.0036	0.0041	0.0043
	S	0.0004	0.0006	0.0009	0.0011	0.0015	0.0020	0.0028	0.0034	0.0039	0.0045	0.0051	0.0056	0.0044	0.0051	0.0048	0.0052	
	T	0.0004	0.0006	0.0008	0.0010	0.0014	0.0018	0.0025	0.0030	0.0035	0.0051	0.0046	0.0051	0.0040	0.0046	0.0043	0.0047	
	↓ 1,5D	U	0.0003	0.0005	0.0007	0.0009	0.0013	0.0016	0.0023	0.0028	0.0032	0.0036	0.0041	0.0046	0.0036	0.0041	0.0039	0.0043
	↔ 0,1D	V	0.0004	0.0005	0.0008	0.0010	0.0013	0.0017	0.0024	0.0029	0.0034	0.0039	0.0043	0.0048	0.0038	0.0043	0.0041	0.0045
		X	0.0005	0.0007	0.0010	0.0013	0.0018	0.0023	0.0032	0.0039	0.0045	0.0052	0.0044	0.0049	0.0048	0.0055	0.0062	0.0068
		Y	0.0006	0.0008	0.0010	0.0012	0.0014	0.0019	0.0023	0.0028	0.0024	0.0036	0.0041	0.0045	0.0045	0.0045	0.0051	0.0054

#### Easy Calculations: (inch)

$$\text{RPM} = \text{SFM}/D \times 3.82 \quad \text{F} = \text{Ft} \times \text{T} \times \text{RPM}$$

$$\text{RPM} = [(m/\text{min.}) \times 1000] \div (3.14 \times D)$$

Terms: RPM = Revolutions Per Minute    F = Feed Inches Per Minute  
 Ft = Feed Per Tooth    T = Number of Teeth    D = Cutting Dia.  
 SFM = Surface Feet per Minute

# APPLICATION MATERIAL GROUPS - REAMERS

## SURFACE FEET PER MINUTE (SFM)

For material examples, see page 567.

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
4500	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4531	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4532	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4533	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4535	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4536	82C	66C	52C	49B	30B	16A			36C	20B	26B	20B	52E	49D	43C	36C	49C
4537	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
4579	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
4587	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
4588	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
4591	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
4600	59C	46C	36C	33B	16B	13A			26C	16B	20B	20B	46E	36D	33C	30C	36C
B100	59C	46C	36C	33B	16B	13A			26F				46E	36D	33C	30C	36C
B101	59C	46C	36C	33B	16B	13A			26C				46E	36D	33C	30C	36C
B121	59C	46C	36C	33B	16B	13A							46E	36D	33C	30C	36C
B122	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
B157	82C	66C	52C	49B	30B	16A			36C	20B	26B						49C
B170	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
B301	59C	46C	36C	33B	16B	13A			26C	16B	20B		46E	36D	33C	30C	36C
B334	59C	46C	36C	33B	16B	13A			26F				46E	36D	33C	30C	36C
B400	59B	59B	46B	46B	33C	33C							56D	56D	56D	46D	46C
B411	59B	59B	46B	46B	33C	33C							56D	56D	56D	46D	46C
B441	59B	59B	46B	46B	33C	33C							56D	56D	56D	46D	46C
B442	59B	59B	46B	46B	33C	33C							56D	56D	56D	46D	46C
B481	59B	59B	46B	46B	33C	33C							56D	56D	56D	46D	46C
B901	59C	46C	36C	33B	16B	13A			26C				46E	36D	33C	30C	36C
T400	75F	46F	49F	49D	36D				66F	39D	39D		108E	59H	59F		69F

# APPLICATION MATERIAL GROUPS - COUNTERSINKS

Feed rate chart see page 584. **SURFACE FEET PER MINUTE (SFM)**

	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1
4602	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
4603	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
4608	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
4702	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
4703	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
4705	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
4706	82C	66C	52C	49B	30B	16A			36C	20B	26B		52E	49D	43C	36C	49C
G171	164E	131E	98D	66D	49B	33B							148F	115D	98C	98C	66C
G132			66E	49D	33D	20B					13B						26D
G135	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G136	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G137	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G138	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G142	98F	82E	66D	49D					26C	20B	13A						39C
G149	98D	82D	66C	49B	33A	20A			26B	20A			82D	49C	39A	26A	39B
G154	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G335	164E	131E	98D	66D	49B	33B							148F	115D	98C	98C	66C
G338	164F	131E	98D	66D	49B	33A							148F	115D	98C	98C	66C
G400	98F	82E	66D	49D	33B	20A			26C	20B	13A		82F	49D	39C	26C	39C
G560	164E	131E	98D	66D	49B	33B							148F	115D	98C	98C	66C
G570	148E	118E	89D	72D	56B	39B			56C	39B	49A	33A	131C	105C	89C	79C	
G600	72F	56E	49D	39D	26B	20A			26C	20B	13A		82F	49D	39C		

## Feed Rate Chart - Reamers

Alpha Code	Reamers - Feed in Inches per Revolution													
	Ø Diameter													
	1/16	5/64	1/8	3/16	5/16	25/64	1/2	5/8	25/32	1"	1-13/16	1-1/2	2"	
A	0.002	0.002	0.003	0.004	0.006	0.007	0.007	0.009	0.010	0.011	0.013	0.015	0.017	
B	0.002	0.003	0.004	0.006	0.007	0.008	0.009	0.011	0.012	0.014	0.016	0.020	0.022	
C	0.003	0.003	0.005	0.007	0.009	0.010	0.011	0.013	0.015	0.017	0.019	0.024	0.027	
D	0.031	0.004	0.006	0.008	0.011	0.013	0.014	0.016	0.019	0.021	0.024	0.029	0.033	
E	0.004	0.006	0.007	0.010	0.014	0.015	0.017	0.020	0.021	0.025	0.030	0.036	0.043	
F	0.006	0.007	0.010	0.014	0.017	0.020	0.022	0.025	0.028	0.031	0.037	0.047	0.059	



# APPLICATION MATERIAL GROUPS - REAMERS

## SURFACE FEET PER MINUTE (SFM)

\*Feed rate chart - see pages 584. For material examples, see page 567

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
4500	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4531	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4532	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4533	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4535	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4536	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4537	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4579	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
4587	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
4588	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
4591	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
4600	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
B100	16B	13B	16D	10C	7C	59D	66E	59D	36D	75F	59F				69B			
B101	16B	13B	16D	10C	7C	59D	66E	59D	36D	75F	59F				69B			
B121															69B			
B122	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
B157	30B	16B	26D	16C	10C	82D	92E			92F	82F	66E	52D	98B			10A	
B170	30B	16B	26D	16C	10C	82D	92E	82D	46D									
B301	16B	13B	16D			59D	66E	59D	36D	75F	59F	49E	46D		69B			
B334	16B	13B	16D	10C	7C	59D	66E	59D	36D	75F	59F				69B			
B400	46C	33B	33C	33B	33B	125E	125E	125E	125D	197D	197D	82D	82D	82C	43C			
B411	46C	33B	33C	33B	33B	125E	125E	125E	125D	197D	197D	82D	82D	82C	43C			
B441	46C	33B	33C	33B	33B	125E	125E	125E	125D	197D	197D	82D	82D	82C	43C			
B442	46C	33B	33C	33B	33B	125E	125E	125E	125D	197D	197D	82D	82D	82C	43C			
B481	46C	33B	33C	33B	33B	125E	125E	125E	125D	197D	197D	82D	82D	82C	43C			
B901	16B	13B	16D	10C	7C	59D	66E	59D	36D	75F	59F				69B			
T400	36D		49D															

# APPLICATION MATERIAL GROUPS - COUNTERSINKS

Material examples page 585. **SURFACE FEET PER MINUTE (SFM)**

	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	10.1
4602	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
4603	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
4608	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4702	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4703	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4705	30B	16B	26D	16C	10C	82D	92E	82D	46D									
4706	30B	16B	26D	16C	10C	82D	92E	82D	46D									
G171	49A	33A	66C	33B	20A	131D	98F	131F	49D	164G	131F	98F	49F	164G	98G			
G132	26A	26A		20C	13B				33F							16G		
G135	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G136	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G137	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G138	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G142	33A		39C	20B		82D	66F	82F		98G	82F	66F	33F	98G	66G			
G149	33A	26A	39B	20A	13A	82B	66C	82C	33B	98D	82C	66C	33C	98D	66D			
G154	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G335	49A	33A	66C	33B	20A	131D	98F	131F	49D	164G	131F	98F	49F	164G	98G			
G338	49A	33A	66C	33B	20A	131D	98F	131F	49D	164G	131F	98F	49F	164G	98G			
G400	33A	26A	39C	20B	13A	82D	66F	82F	33D	98G	82F	66F	33F	98G	66G			
G560	49A	33A	66C	33B	20A	131D	98F	131F	49D	164G	131F	98F	49F	164G	98G			
G570				20A	13A	131D	98F	131F	49D	148G	118F	89F	43F					
G600						82D	66F	82F	33D	98G	82F	66F	33F					

## Feed Rate Chart - Countersinks, Counterbores

Alpha Code	Countersinks, Counterbores - Feed in Inches per Revolution										Ø Diameter
	1/4	5/16	5/64	5/8	25/32	1"	1-1/4	1-1/2	2-3/8	3"	
A	0.001	0.002	0.002	0.002	0.003	0.004	0.004	0.005	0.006	0.006	
B	0.002	0.002	0.002	0.003	0.004	0.005	0.006	0.006	0.007	0.008	
C	0.002	0.002	0.003	0.004	0.005	0.006	0.006	0.007	0.008	0.009	
D	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.009	0.010	0.011	
E	0.003	0.004	0.005	0.006	0.007	0.008	0.010	0.011	0.012	0.013	
F	0.004	0.004	0.005	0.006	0.007	0.008	0.010	0.011	0.013	0.014	
G	0.004	0.005	0.006	0.007	0.008	0.009	0.011	0.013	0.014	0.016	
H	0.005	0.006	0.007	0.008	0.009	0.010	0.012	0.014	0.016	0.018	

# EDP NUMBER INDEX - 00000 - 001344

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
000000	E53021/8	390	0000403	A1001.4	82	001022	E330211/16	388	001144	E3304M16.0	399
000001	E53023/16	390	0000410	A1001.45	82	001023	E33023/4	388	001145	E3304M18.0	399
000002	E53021/4	390	0000427	A1001.5	82	001025	E33021	388	001146	E3304M20.0	399
000004	E53023/8	390	0000434	A1001.55	82	0001028	A10013.75	82	001147	E3304M25.0	399
000006	E53021/2	390	0000441	A1001.6	82	001028	E3302M2.0	389	0001158	A10015.5	82
000009	E53021	390	0000458	A1001.65	82	001029	E3302M2.5	389	0001165	A10015.75	82
000020	E53041/8	400	0000465	A1001.7	82	001030	E3302M3.0	389	0001172	A10015/32	82
000021	A100.2	82	0000472	A1001.75	82	001031	E3302M3.5	389	0001189	A10015/64	82
000021	E53043/16	400	0000489	A1001.8	82	001032	E3302M4.0	389	0001196	A10016.0	82
000022	E53041/4	400	0000496	A1001.85	82	001033	E3302M4.5	389	001200	EB33021/16	392
000023	E53045/16	400	0000502	A1001.9	82	001034	E3302M5.0	389	001201	EB33025/64	392
000024	E53043/8	400	0000519	A1001.95	82	0001035	A10013.8	82	0001202	A10016.5	82
000025	E53047/16	400	0000526	A10010.0	82	001035	E3302M6.0	389	001202	EB33023/32	392
000026	E53041/2	400	0000533	A10010.1	82	001036	E3302M7.0	389	001203	EB33027/64	392
000027	E53045/8	400	0000540	A10010.2	82	001037	E3302M8.0	389	001204	EB33021/8	392
000028	E53043/4	400	0000557	A10010.25	82	001038	E3302M9.0	389	001206	EB33025/32	392
000030	E5304V1/8	400	0000564	A10010.3	82	001039	E3302M10.0	389	001208	EB33023/16	392
000031	E5304V3/16	400	0000571	A10010.4	82	001040	E3302M11.0	389	001210	EB33027/32	392
000032	E5304V1/4	400	0000588	A10010.5	82	001041	E3302M12.0	389	001211	EB330215/64	392
000033	E5304V5/16	400	0000595	A10010.6	82	0001042	A10013.9	82	001212	EB33021/4	392
000034	E5304V3/8	400	0000601	A10010.7	82	001043	E3302M14.0	389	001216	EB33025/16	392
000035	E5304V7/16	400	0000618	A10010.75	82	001044	E3302M16.0	389	001217	EB33023/8	392
000036	E5304V1/2	400	0000625	A10010.8	82	001046	E3302M20.0	389	0001219	A1001/64	82
000037	E5304V5/8	400	0000632	A10010.9	82	001047	E3302M25.0	389	001219	EB33021/2	392
000038	A100.25	82	0000649	A10011.0	82	001050	E33031/16	396	001222	EB330211/16	392
000038	E5304V3/4	400	0000656	A10011.1	82	001052	E33033/32	396	0001226	A10017.0	82
000039	E5304V1	400	0000663	A10011.2	82	001054	E33031/8	396	001228	EB3302M2.0	393
000040	EB53021/8	394	0000670	A10011.25	82	001056	E33035/32	396	001229	EB3302M2.5	393
000041	EB53023/16	394	0000687	A10011.3	82	001058	E33033/16	396	001230	EB3302M3.0	393
000042	EB53021/4	394	0000694	A10011.4	82	0001059	A1001/32	82	001232	EB3302M4.0	393
000043	EB53025/16	394	0000700	A10011.5	82	001062	E33031/4	396	0001233	A10017.5	82
000044	EB53023/8	394	0000717	A10011.6	82	0001066	A10013/32	82	001234	EB3302M5.0	393
000045	A100.3	82	0000724	A10011.7	82	001066	E33035/16	396	001235	EB3302M6.0	393
000046	EB53021/2	394	0000731	A10011.75	82	001067	E33033/8	396	001236	EB3302M7.0	393
000047	EB53025/8	394	0000748	A10011.8	82	001069	E33031/2	396	001237	EB3302M8.0	393
000052	A100.32	82	0000755	A10011.9	82	0001073	A10013/64	82	001238	EB3302M9.0	393
000061	EB53043/16	404	0000762	A10011/16	82	0001080	A1001/4	82	001239	EB3302M10.0	393
000062	EB53041/4	404	0000779	A10011/32	82	0001097	A10014.0	82	0001240	A10017/32	82
000063	EB53045/16	404	0000786	A1001/16	82	001100	E33041/16	398	001241	EB3302M12.0	393
000064	EB53043/8	404	0000793	A1001/64	82	001101	E33045/64	398	001243	EB3302M16.0	393
000066	EB53041/2	404	0000809	A1001/2	82	001102	E33043/32	398	001244	EB3302M18.0	393
000067	EB53045/8	404	0000816	A10012.0	82	0001103	A10014.25	82	001245	EB3302M20.0	393
000069	A100.35	82	0000823	A10012.1	82	001103	E33047/64	398	0001257	A10017/64	82
000072	EB5304V1/4	404	0000830	A10012.2	82	001104	E33041/8	398	0001264	A1001/8	82
000074	EB5304V3/8	404	0000847	A10012.25	82	001105	E33049/64	398	0001271	A10018.0	82
000076	A100.38	82	0000854	A10012.3	82	001106	E33045/32	398	0001288	A10018.5	82
000076	EB5304V1/2	404	0000861	A10012.4	82	001107	E330411/64	398	0001295	A10019.0	82
000077	EB5304V5/8	404	0000878	A10012.5	82	001108	E33043/16	398	001300	EB33041/16	402
000083	A100.4	82	0000885	A10012.6	82	001109	E330413/64	398	0001301	A10019.5	82
000090	A100.42	82	0000892	A10012.7	82	0001110	A10014.5	82	001301	EB33045/64	402
000106	A100.45	82	0000908	A10012.75	82	001110	E33047/32	398	001302	EB33043/32	402
000113	A100.48	82	0000915	A10012.8	82	001112	E33041/4	398	001304	EB33041/8	402
000120	A100.5	82	0000922	A10012.9	82	001116	E33045/16	398	001305	EB33049/64	402
000137	A100.52	82	0000939	A10013.0	82	001117	E33043/8	398	001306	EB33045/32	402
000144	A100.55	82	0000946	A10013.1	82	001118	E33047/16	398	001307	EB330411/64	402
000151	A100.58	82	0000953	A10013.2	82	001119	E33041/2	398	001308	EB33043/16	402
000168	A100.6	82	0000960	A10013.25	82	001120	E33049/16	398	001310	EB33047/32	402
000175	A100.62	82	0000977	A10013.3	82	001121	E33045/8	398	001311	EB330415/64	402
000182	A100.65	82	0000984	A10013.4	82	001122	E330411/16	398	001312	EB33041/4	402
000199	A100.68	82	0000991	A10013.5	82	001123	E33043/4	398	001316	EB33045/16	402
000205	A100.7	82	001000	E33021/16	388	001124	E33047/8	398	001317	EB33043/8	402
000212	A100.72	82	001001	E33025/64	388	001125	E33041	398	0001318	A10019/32	82
000229	A100.75	82	001002	E33023/32	388	0001127	A10014.75	82	001318	EB33047/16	402
000236	A100.78	82	0001004	A10013.6	82	001128	E3304M2.0	399	001319	EB33041/2	402
000243	A100.8	82	001004	E33021/8	388	001129	E3304M2.5	399	001320	EB33049/16	402
000250	A100.82	82	001005	E33029/64	388	001130	E3304M3.0	399	001321	EB33045/8	402
000267	A100.85	82	001006	E33025/32	388	001131	E3304M3.5	399	001323	EB33043/4	402
000274	A100.88	82	001007	E330211/64	388	001132	E3304M4.0	399	0001325	A10019/64	82
000281	A100.9	82	001008	E33023/16	388	001133	E3304M4.5	399	001330	EB3304M14.0	403
000298	A100.92	82	001009	E330213/64	388	0001134	A10015.0	82	001331	EB3304M12.0	403
000304	A100.95	82	001010	E33027/32	388	001134	E3304M5.0	399	0001332	A1002.0	82
000311	A100.98	82	0001011	A10013.7	82	001135	E3304M6.0	399	001333	EB3304M10.0	403
000328	A1001.0	82	001011	E330215/64	388	001136	E3304M7.0	399	001335	EB3304M8.0	403
000335	A1001.05	82	001012	E33021/4	388	001137	E3304M8.0	399	1336	EB3304M7.0	403
000342	A1001.1	82	001016	E33025/16	388	001138	E3304M9.0	399	001337	EB3304M6.0	403
000359	A1001.15	82	001017	E33023/8	388	001139	E3304M10.0	399	001338	EB3304M5.0	403
000366	A1001.2	82	001018	E33027/16	388	001140	E3304M11.0	399	001339	EB3304M4.5	403
000373	A1001.25	82	001019	E33021/2	388	0001141	A10015.25	82	001340	EB3304M4.0	403
000380	A1001.3	82	001020	E33029/16	388	001141	E3304M12.0	399	001342	EB3304M3.0	403
000397	A1001.35	82	001021	E33025/8	388	001143	E3304M14.0	399	001344	EB3304M2.0	403

# EDP NUMBER INDEX - 0001349 - 003500

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0001349	A1002.05	82	0002131	A1006.1	82	0002674	A1011.1	90	0002988	A1014.8	90
0001356	A1002.1	82	0002148	A1006.2	82	0002681	A1011.2	90	0002995	A1015.0	90
0001363	A1002.15	82	0002155	A1006.25	82	0002690	E3304V1/16	398	0003008	A1015.1	90
0001370	A1002.2	82	0002162	A1006.3	82	0002691	E3304V5/64	398	0003015	A1015.2	90
0001387	A1002.25	82	0002179	A1006.4	82	0002692	E3304V3/32	398	0003022	A1015.5	90
0001394	A1002.3	82	0002186	A1006.5	82	0002693	E3304V7/64	398	0003039	A1016.0	90
0001400	A1002.35	82	0002193	A1006.6	82	0002694	E3304V1/8	398	0003046	A1016.5	90
0001417	A1002.4	82	0002200	E43021/8	386	0002695	E3304V9/64	398	0003053	A1017.0	90
0001424	A1002.45	82	0002201	E43025/32	386	0002696	E3304V5/32	398	0003060	A1017.5	90
0001431	A1002.5	82	0002202	E43023/16	386	0002697	E3304V11/64	398	003070	EB3304V1/16	402
0001448	A1002.55	82	0002204	E43021/4	386	0002698	A1011.25	90	003072	EB3304V3/32	402
0001455	A1002.6	82	0002206	E43025/16	386	0002698	E3304V3/16	398	003074	EB3304V1/8	402
0001462	A1002.65	82	0002208	E43023/8	386	0002699	E3304V13/64	398	003076	EB3304V5/32	402
0001479	A1002.7	82	0002209	A1006.7	82	0002700	E3304V7/32	398	0003077	A1018.0	90
0001486	A1002.75	82	0002210	E43021/2	386	0002702	E3304V1/4	398	003077	EB3304V11/64	402
0001493	A1002.8	82	0002216	A1006.75	82	0002703	E3304V5/16	398	003078	EB3304V3/16	402
0001509	A1002.85	82	0002223	A1006.8	82	0002704	A1011.3	90	003082	EB3304V1/4	402
0001516	A1002.9	82	0002230	A1006.9	82	0002704	E3304V3/8	398	003083	EB3304V5/16	402
0001523	A1002.95	82	0002247	A1007.0	82	0002705	E3304V7/16	398	003084	A1018.5	90
0001530	A10020.0	82	0002250	E43041/8	397	0002706	E3304V1/2	398	003084	EB3304V3/8	402
0001547	A10021/32	82	0002251	E43045/32	397	0002707	E3304V9/16	398	003085	EB3304V7/16	402
0001554	A10021/64	82	0002252	E43043/16	397	0002708	E3304V5/8	398	003086	EB3304V1/2	402
0001561	A10023/64	82	0002254	A1007.1	82	0002709	E3304V11/16	398	003088	EB3304V5/8	402
0001578	A10025/64	82	0002254	E43041/4	397	0002710	E3304V3/4	398	003090	EB3304V3/4	402
0001585	A10027/64	82	0002256	E43045/16	397	0002711	A1011.4	90	0003091	A1019.0	90
0001592	A10029/64	82	0002258	E43043/8	397	0002711	E3304V7/8	398	003092	EB3304V1	402
0001608	A1003.0	82	0002260	E43041/2	397	0002712	E3304V1	398	003130	E6302V1/8	391
0001615	A1003.1	82	0002261	A1007.2	82	0002728	A1011.5	90	003131	E6302V3/16	391
0001622	A1003.15	82	0002278	A1007.25	82	0002735	A1011.6	90	003132	E6302V1/4	391
0001639	A1003.2	82	0002285	A1007.3	82	0002742	A1011.7	90	003134	E6302V3/8	391
0001646	A1003.25	82	0002292	A1007.4	82	0002759	A1011.75	90	003136	E6302V1/2	391
0001653	A1003.3	82	0002308	A1007.5	82	0002766	A1011.8	90	003165	E6304V1/8	401
0001660	A1003.4	82	0002315	A1007.6	82	0002773	A1011.9	90	003166	E6304V3/16	401
0001677	A1003.5	82	0002322	A1007.7	82	0002780	A10110.0	90	003167	E6304V1/4	401
0001684	A1003.6	82	0002339	A1007.75	82	0002797	A10112.0	90	003168	E6304V5/16	401
0001691	A1003.7	82	0002346	A1007.8	82	0002803	A1012.0	90	003169	E6304V3/8	401
0001707	A1003.75	82	0002353	A1007.9	82	0002810	A1012.1	90	003170	E6304V7/16	401
0001714	A1003.8	82	0002360	A1007/16	82	0002827	A1012.2	90	003171	E6304V1/2	401
0001721	A1003.9	82	0002377	A1007/32	82	0002834	A1012.3	90	003172	E6304V5/8	401
0001738	A1003/16	82	0002384	A1007/64	82	0002841	A1012.4	90	003173	E6304V3/4	401
0001745	A10031/64	82	0002391	A1008.0	82	0002850	E3302V1/16	388	003174	E6304V1	401
0001752	A1003/32	82	0002407	A1008.1	82	0002851	E3302V5/64	388	003251	DCN0	195
0001769	A10033/64	82	0002414	A1008.2	82	0002852	E3302V3/32	388	003252	DCN1	195
0001776	A10035/64	82	0002421	A1008.25	82	0002854	E3302V1/8	388	003253	DCN2	195
0001783	A1003/64	82	0002438	A1008.3	82	0002856	E3302V5/32	388	003254	DCN3	195
0001790	A10037/64	82	0002445	A1008.4	82	0002857	E3302V11/64	388	003255	DCN4	195
0001806	A1003/8	82	0002452	A1008.5	82	0002858	A1012.5	90	003256	DCN5	195
0001813	A10039/64	82	0002469	A1008.6	82	0002858	E3302V3/16	388	003257	DCN6	195
0001820	A1004.0	82	0002476	A1008.7	82	0002859	E3302V13/64	388	003332	DS901/8	191
0001837	A1004.1	82	0002483	A1008.75	82	0002860	E3302V7/32	388	003334	DS903/16	191
0001844	A1004.2	82	0002490	A1008.8	82	0002862	E3302V1/4	388	003336	DS901/4	191
0001851	A1004.25	82	0002506	A1008.9	82	0002863	E3302V5/16	388	003338	DS905/16	191
0001868	A1004.3	82	0002513	A1009.0	82	0002864	E3302V3/8	388	003340	DS903/8	191
0001875	A1004.4	82	0002520	A1009.1	82	0002865	A1012.6	90	003342	DS901/2	191
0001882	A1004.5	82	0002537	A1009.2	82	0002865	E3302V7/16	388	003470	D33M.8	190
0001899	A1004.6	82	0002544	A1009.25	82	0002866	E3302V1/2	388	003471	D33M.9	190
0001905	A1004.7	82	0002551	A1009.3	82	0002867	E3302V9/16	388	003472	D33M1.0	190
0001912	A1004.75	82	0002568	A1009.4	82	0002868	E3302V5/8	388	003473	D33M1.5	190
0001929	A1004.8	82	0002575	A1009.5	82	0002872	A1012.7	90	003474	D33M2.0	190
0001936	A1004.9	82	0002582	A1009.6	82	0002889	A1012.8	90	003475	D33M2.05	190
0001943	A10041/64	82	0002599	A1009.7	82	0002896	A1012.9	90	003476	D33M2.5	190
0001950	A10043/64	82	0002605	A1009.75	82	0002902	A1013.0	90	003477	D33M3.0	190
0001967	A1005.0	82	0002612	A1009.8	82	0002919	A1013.2	90	003478	D33M3.5	190
0001974	A1005.1	82	0002629	A1009.9	82	0002920	E3303V1/16	396	003479	D33M4.5	190
0001981	A1005.2	82	0002630	EB3302V1/16	392	0002921	E3303V3/32	396	003480	D33M5.5	190
0001998	A1005.25	82	0002634	EB3302V1/8	392	0002922	E3303V1/8	396	003481	D33M6.0	190
0002001	A1005.3	82	0002636	A1009/16	82	0002923	E3303V5/32	396	003482	D33M6.5	190
0002018	A1005.4	82	0002636	EB3302V5/32	392	0002924	E3303V3/16	396	003483	D33M7.0	190
0002025	A1005.5	82	0002638	EB3302V3/16	392	0002926	A1013.3	90	003484	D33M7.5	190
0002032	A1005.6	82	0002640	EB3302V7/32	392	0002926	E3303V1/4	396	003485	D33M8.0	190
0002049	A1005.7	82	0002642	EB3302V1/4	392	0002927	E3303V5/16	396	003486	D33M8.5	190
0002056	A1005.75	82	0002643	A1009/32	82	0002928	E3303V3/8	396	003487	D33M9.0	190
0002063	A1005.8	82	0002643	EB3302V5/16	392	0002929	E3303V7/16	396	003488	D33M9.5	190
0002070	A1005.9	82	0002644	EB3302V3/8	392	0002930	E3303V1/2	396	003489	D33M10.5	190
0002087	A1005/16	82	0002645	EB3302V7/16	392	0002933	A1013.5	90	003490	D33M10.75	190
0002094	A1005/32	82	0002646	EB3302V1/2	392	0002940	A1013.8	90	003491	D33M11.0	190
0002100	A1005/64	82	0002650	A1009/64	82	0002957	A1014.0	90	003492	D33M11.5	190
0002117	A1005/8	82	0002651	EB3302V7/8	392	0002964	A1014.2	90	003493	D33M12.0	190
0002124	A1006.0	82	0002667	A1011.0	90	0002971	A1014.5	90	003500	D33WN68	187

# EDP NUMBER INDEX - 003501 - 0008690

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
003501	D33F1/32	187	003580	D33WN1	187	004402	EB3302MV3.0	393	0007822	A10813/32	101
003502	D33WN67	187	003581	D33LA	187	004403	EB3302MV3.5	393	0007839	A10813/64	101
003503	D33WN66	187	003582	D33F15/64	187	004404	EB3302MV4.0	393	0007846	A1081/4	101
003504	D33WN65	187	003583	D33LB	187	004406	EB3302MV5.0	393	0007853	A10814.0	101
003505	D33WN64	187	003584	D33LC	187	004407	EB3302MV6.0	393	0007860	A10814.5	101
003506	D33WN63	187	003585	D33LD	187	004408	EB3302MV7.0	393	0007877	A10815.0	101
003507	D33WN62	187	003586	D33F1/4	187	004409	EB3302MV8.0	393	0007884	A10815.25	101
003508	D33WN61	187	003587	D33LF	187	004410	EB3302MV9.0	393	0007891	A10815.5	101
003509	D33WN60	187	003588	D33LG	187	004411	EB3302MV10.0	393	0007907	A10815/32	101
003510	D33WN59	187	003589	D33F17/64	187	004413	EB3302MV12.0	393	0007921	A10816.0	101
003511	D33WN58	187	003590	D33LH	187	4416	EB3302MV18.0	393	0007945	A1081/8	101
003512	D33WN57	187	003591	D33LI	187	004750	EB3304MV2.0	403	0007969	A1082.0	101
003513	D33WN56	187	003592	D33LJ	187	004752	EB3304MV3.0	403	0007976	A1082.1	101
003514	D33F3/64	187	003593	D33LK	187	004754	EB3304MV4.0	403	0007983	A1082.2	101
003515	D33WN55	187	003594	D33F9/32	187	004756	EB3304MV5.0	403	0007990	A1082.3	101
003516	D33WN54	187	003595	D33LL	187	004757	EB3304MV6.0	403	0008003	A1082.4	101
003517	D33WN53	187	003596	D33LM	187	004759	EB3304MV8.0	403	0008010	A1082.5	101
003518	D33F1/16	187	003597	D33F19/64	187	004761	EB3304MV10.0	403	0008027	A1082.6	101
003519	D33WN52	187	003598	D33LN	187	004763	EB3304MV12.0	403	0008034	A1082.7	101
003520	D33WN51	187	003599	D33F5/16	187	004800	E6302/18	391	0008041	A1082.8	101
003521	D33WN50	187	003600	D33LO	187	004801	E63023/16	391	0008058	A1082.9	101
003522	D33WN49	187	003601	D33LP	187	004802	E6302/14	391	0008119	A1083.0	101
003523	D33WN48	187	003602	D33F21/64	187	004803	E63025/16	391	0008126	A1083.1	101
003524	D33F5/64	187	003603	D33LQ	187	004804	E63023/8	391	0008133	A1083.2	101
003525	D33WN47	187	003604	D33LR	187	004805	E63027/16	391	0008140	A1083.3	101
003526	D33WN46	187	003605	D33F11/32	187	004806	E6302/12	391	0008157	A1083.4	101
003527	D33WN45	187	003606	D33LS	187	004808	E63023/4	391	0008164	A1083.5	101
003528	D33WN44	187	003607	D33LT	187	004900	E6304/18	401	0008171	A1083.6	101
003529	D33WN43	187	003608	D33F23/64	187	004901	E63043/16	401	0008188	A1083.7	101
003530	D33WN42	187	003609	D33LU	187	004902	E6304/14	401	0008195	A1083.8	101
003531	D33F3/32	187	003610	D33F3/8	187	004903	E63045/16	401	0008201	A1083.9	101
003532	D33WN41	187	003611	D33LV	187	004904	E63043/8	401	0008218	A1083/16	101
003533	D33WN40	187	003612	D33LW	187	004905	E63047/16	401	0008232	A1083/32	101
003534	D33WN39	187	003613	D33F25/64	187	004906	E6304/12	401	0008249	A1083/8	101
003535	D33WN38	187	003614	D33LX	187	004907	E63045/8	401	0008256	A1084.0	101
003536	D33WN37	187	003615	D33LY	187	004908	E63043/4	401	0008263	A1084.1	101
003537	D33WN36	187	003616	D33F13/32	187	004909	E63041	391	0008270	A1084.2	101
003538	D33F7/64	187	003617	D33LZ	187	005400	EB63021/8	405	0008287	A1084.3	101
003539	D33WN35	187	003618	D33F27/64	187	005401	EB63023/16	395	0008294	A1084.4	101
003540	D33WN34	187	003619	D33F7/16	187	005402	EB63021/4	395	0008300	A1084.5	101
003541	D33WN33	187	003620	D33F29/64	187	005403	EB63025/16	395	0008317	A1084.6	101
003542	D33WN32	187	003621	D33F15/32	187	005404	EB63023/8	395	0008324	A1084.7	101
003543	D33WN31	187	003622	D33F31/64	187	005406	EB63021/2	395	0008331	A1084.8	101
003544	D33F1/8	187	003623	D33F1/2	187	005700	EB63041/8	405	0008348	A1084.9	101
003545	D33WN30	187	003624	D33M3.3	190	005701	EB63043/16	405	0008355	A1085.0	101
003546	D33WN29	187	003626	D33M4.0	190	005702	EB63041/4	405	0008362	A1085.1	101
003547	D33WN28	187	003630	D33M5.0	190	005703	EB63045/16	405	0008379	A1085.2	101
003548	D33F9/64	187	003631	D33M10.0	190	005704	EB63043/8	405	0008386	A1085.3	101
003549	D33WN27	187	003700	EB6302V1/8	395	005705	EB63047/16	405	0008393	A1085.4	101
003550	D33WN26	187	003701	EB6302V3/16	395	005706	EB63041/2	405	0008409	A1085.5	101
003551	D33WN25	187	003702	EB6302V1/4	395	005707	EB63045/8	405	0008416	A1085.6	101
003552	D33WN24	187	003703	EB6302V5/16	395	0007549	A1081.0	101	0008423	A1085.7	101
003553	D33WN23	187	003704	EB6302V3/8	395	0007556	A1081.1	101	0008430	A1085.8	101
003554	D33F5/32	187	003706	EB6302V1/2	395	0007563	A1081.2	101	0008447	A1085.9	101
003555	D33WN22	187	003745	EB6304V1/8	405	0007570	A1081.3	101	0008454	A1085/16	101
003556	D33WN21	187	003746	EB6304V3/16	405	0007587	A1081.4	101	0008461	A1085/32	101
003557	D33WN20	187	003747	EB6304V1/4	405	0007594	A1081.5	101	0008478	A1085/64	101
003558	D33WN19	187	003748	EB6304V5/16	405	0007600	A1081.6	101	0008485	A1086.0	101
003559	D33WN18	187	003749	EB6304V3/8	405	0007617	A1081.7	101	0008492	A1086.1	101
003560	D33F11/64	187	003751	EB6304V1/2	405	0007624	A1081.8	101	0008508	A1086.2	101
003561	D33WN17	187	003752	EB6304V5/8	405	0007631	A1081.9	101	0008515	A1086.3	101
003562	D33WN16	187	004325	E3304MV2.0	399	0007648	A10810.0	101	0008522	A1086.4	101
003563	D33WN15	187	004326	E3304MV2.5	399	0007655	A10810.2	101	0008539	A1086.5	101
003564	D33WN14	187	004327	E3304MV3.0	399	0007662	A10810.5	101	0008546	A1086.6	101
003565	D33WN13	187	004328	E3304MV3.5	399	0007679	A10810.8	101	0008553	A1086.7	101
003566	D33F3/16	187	004329	E3304MV4.0	399	0007686	A10811.0	101	0008560	A1086.8	101
003567	D33WN12	187	004330	E3304MV4.5	399	0007693	A10811.5	101	0008577	A1086.9	101
003568	D33WN11	187	004331	E3304MV5.0	399	0007709	A10811.8	101	0008584	A1087.0	101
003569	D33WN10	187	004332	E3304MV6.0	399	0007716	A10811/32	101	0008591	A1087.1	101
003570	D33WN9	187	004333	E3304MV7.0	399	0007723	A1081/16	101	0008607	A1087.2	101
003571	D33WN8	187	004334	E3304MV8.0	399	0007730	A10811/64	101	0008614	A1087.3	101
003572	D33WN7	187	004335	E3304MV9.0	399	0007747	A1081/2	101	0008621	A1087.4	101
003573	D33F13/64	187	004336	E3304MV10.0	399	0007754	A10812.0	101	0008638	A1087.5	101
003574	D33WN6	187	004337	E3304MV11.0	399	0007761	A10812.2	101	0008645	A1087.6	101
003575	D33WN5	187	004338	E3304MV12.0	399	0007778	A10812.5	101	0008652	A1087.7	101
003576	D33WN4	187	004339	E3304MV14.0	399	0007785	A10812.8	101	0008669	A1087.8	101
003577	D33WN3	187	004340	E3304MV16.0	399	0007792	A10812.9	101	0008676	A1087.9	101
003578	D33F7/32	187	004341	E3304MV18.0	399	0007808	A10813.0	101	0008683	A1087/16	101
003579	D33WN2	187	004342	E3304MV20.0	399	0007815	A10813.5	101	0008690	A1087/32	101

# EDP NUMBER INDEX - 0008706 - 014970

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0008706	A1087/64	101	010116	R10A1/4	95	010334	R10CO17/32	110	010634	R10P17/32	74
0008713	A1088.0	101	010117	R10A17/64	95	010335	R10CO35/64	110	010635	R10P35/64	74
0008720	A1088.1	101	010118	R10A9/32	95	010336	R10CO9/16	110	010636	R10P9/16	74
0008737	A1088.2	101	010119	R10A19/64	95	010337	R10CO37/64	110	010637	R10P37/64	74
0008744	A1088.3	101	010120	R10A5/16	95	010338	R10CO19/32	110	010638	R10P19/32	74
0008751	A1088.4	101	010121	R10A21/64	95	010339	R10CO39/64	110	010639	R10P39/64	74
0008768	A1088.5	101	010122	R10A11/32	95	010340	R10CO5/8	110	010640	R10P5/8	74
0008775	A1088.6	101	010123	R10A23/64	95	010341	R10CO41/64	110	010641	R10P41/64	74
0008782	A1088.7	101	010124	R10A3/8	95	010342	R10CO21/32	110	010642	R10P21/32	74
0008799	A1088.8	101	010125	R10A25/64	95	010343	R10CO43/64	110	010643	R10P43/64	74
0008805	A1088.9	101	010126	R10A13/32	95	010344	R10CO11/16	110	010644	R10P11/16	74
0008812	A1089.0	101	010127	R10A27/64	95	0010396	E0212-56	256	010902	L101/32	89
0008829	A1089.1	101	010128	R10A7/16	95	0010419	E0215-40	256	010903	L103/64	89
0008836	A1089.2	101	010129	R10A29/64	95	0010440	E0232-56	270	010904	L101/16	89
0008843	A1089.3	101	010130	R10A15/32	95	0010471	E0235-40	270	010905	L105/64	89
0008850	A1089.4	101	010131	R10A31/64	95	010502	R10H1/32	101	010906	L103/32	89
0008867	A1089.5	101	010132	R10A1/2	95	010503	R10H3/64	101	010907	L107/64	89
0008874	A1089.6	101	010204	R10B1/16	98	010504	R10H1/16	101	010908	L101/8	89
0008881	A1089.7	101	010205	R10B5/64	98	010505	R10H5/64	101	010909	L109/64	89
0008898	A1089.8	101	010206	R10B3/32	98	010506	R10H3/32	101	010910	L105/32	89
0008904	A1089.9	101	010207	R10B7/64	98	010507	R10H7/64	101	010911	L1011/64	89
0008911	A1089/32	101	010208	R10B1/8	98	010508	R10H1/8	101	010912	L103/16	89
0008928	A1089/64	101	010209	R10B9/64	98	010509	R10H9/64	101	010913	L1013/64	89
010001	R101/64	74	010210	R10B5/32	98	010510	R10H5/32	101	010914	L107/32	89
010002	R101/32	74	010211	R10B11/64	98	010511	R10H11/64	101	010915	L1015/64	89
010003	R103/64	74	010212	R10B3/16	98	010512	R10H3/16	101	010916	L101/4	89
010004	R101/16	74	010213	R10B13/64	98	010513	R10H13/64	101	010917	L1017/64	89
010005	R105/64	74	010214	R10B7/32	98	010514	R10H7/32	101	010918	L109/32	89
010006	R103/32	74	010215	R10B15/64	98	010515	R10H15/64	101	010919	L1019/64	89
010007	R107/64	74	010216	R10B1/4	98	010516	R10H1/4	101	010920	L105/16	89
010008	R101/8	74	010217	R10B17/64	98	010517	R10H17/64	101	010921	L1021/64	89
010009	R109/64	74	010218	R10B9/32	98	010518	R10H9/32	101	010922	L1011/32	89
010010	R105/32	74	010219	R10B19/64	98	010519	R10H19/64	101	010923	L1023/64	89
010011	R1011/64	74	010220	R10B5/16	98	010520	R10H5/16	101	010924	L103/8	89
010012	R103/16	74	010221	R10B21/64	98	010521	R10H21/64	101	010925	L1025/64	89
010013	R1013/64	74	010222	R10B11/32	98	010522	R10H11/32	101	010926	L1013/32	89
010014	R107/32	74	010223	R10B23/64	98	010523	R10H23/64	101	010927	L1027/64	89
010015	R1015/64	74	010224	R10B3/8	98	010524	R10H3/8	101	010928	L107/16	89
010016	R101/4	74	010225	R10B25/64	98	010525	R10H25/64	101	010929	L1029/64	89
010017	R1017/64	74	010226	R10B13/32	98	010526	R10H13/32	101	010930	L1015/32	89
010018	R109/32	74	010227	R10B27/64	98	010527	R10H27/64	101	010931	L1031/64	89
010019	R1019/64	74	010228	R10B7/16	98	010528	R10H7/16	101	010932	L101/2	89
010020	R105/16	74	010229	R10B29/64	98	010529	R10H29/64	101	013115	QC21PM1.5	109
010021	R1021/64	74	010230	R10B15/32	98	010530	R10H15/32	101	013120	QC21PM2.0	109
010022	R1011/32	74	010231	R10B31/64	98	010531	R10H31/64	101	013125	QC21PM2.5	109
010023	R1023/64	74	010232	R10B1/2	98	010532	R10H1/2	101	013130	QC21PM3.0	109
010024	R103/8	74	010301	R10CO1/64	110	010601	R10P1/64	74	013135	QC21PM3.5	109
010025	R1025/64	74	010302	R10CO1/32	110	010602	R10P1/32	74	013140	QC21PM4.0	109
010026	R1013/32	74	010303	R10CO3/64	110	010603	R10P3/64	74	013145	QC21PM4.5	109
010027	R1027/64	74	010304	R10CO1/16	110	010604	R10P1/16	74	013150	QC21PM5.0	109
010028	R107/16	74	010305	R10CO5/64	110	010605	R10P5/64	74	013152	QC21PM5.2	109
010029	R1029/64	74	010306	R10CO3/32	110	010606	R10P3/32	74	013155	QC21PM5.5	109
010030	R1015/32	74	010307	R10CO7/64	110	010607	R10P7/64	74	013156	QC21PM5.6	109
010031	R1031/64	74	010308	R10CO1/8	110	010608	R10P1/8	74	013160	QC21PM6.0	109
010032	R101/2	74	010309	R10CO9/64	110	010609	R10P9/64	74	013165	QC21PM6.5	109
010033	R1033/64	74	010310	R10CO5/32	110	010610	R10P5/32	74	013168	QC21PM6.8	109
010034	R1017/32	74	010311	R10CO11/64	110	010611	R10P11/64	74	013170	QC21PM7.0	109
010035	R1035/64	74	010312	R10CO3/16	110	010612	R10P3/16	74	013175	QC21PM7.5	109
010036	R109/16	74	010313	R10CO13/64	110	010613	R10P13/64	74	013180	QC21PM8.0	109
010037	R1037/64	74	010314	R10CO7/32	110	010614	R10P7/32	74	013182	QC21PM8.2	109
010038	R1019/32	74	010315	R10CO15/64	110	010615	R10P15/64	74	013185	QC21PM8.5	109
010039	R1039/64	74	010316	R10CO1/4	110	010616	R10P1/4	74	013186	QC21PM8.6	109
010040	R105/8	74	010317	R10CO17/64	110	010617	R10P17/64	74	013190	QC21PM9.0	109
010041	R1041/64	74	010318	R10CO9/32	110	010618	R10P9/32	74	013195	QC21PM9.5	109
010042	R1021/32	74	010319	R10CO19/64	110	010619	R10P19/64	74	014900	QC21PM10.0	109
010043	R1043/64	74	010320	R10CO5/16	110	010620	R10P5/16	74	014905	QC21PM10.5	109
010044	R1011/16	74	010321	R10CO21/64	110	010621	R10P21/64	74	014910	QC21PM11.0	109
010104	R10A1/16	95	010322	R10CO11/32	110	010622	R10P11/32	74	014915	QC21PM11.5	109
010105	R10A5/64	95	010323	R10CO23/64	110	010623	R10P23/64	74	014920	QC21PM12.0	109
010106	R10A3/32	95	010324	R10CO3/8	110	010624	R10P3/8	74	014925	QC21PM12.5	109
010107	R10A7/64	95	010325	R10CO25/64	110	010625	R10P25/64	74	014930	QC21PM13.0	109
010108	R10A1/8	95	010326	R10CO13/32	110	010626	R10P13/32	74	014935	QC21PM13.5	109
010109	R10A9/64	95	010327	R10CO27/64	110	010627	R10P27/64	74	014940	QC21PM14.0	109
010110	R10A5/32	95	010328	R10CO7/16	110	010628	R10P7/16	74	014945	QC21PM14.5	109
010111	R10A11/64	95	010329	R10CO29/64	110	010629	R10P29/64	74	014950	QC21PM15.0	109
010112	R10A3/16	95	010330	R10CO15/32	110	010630	R10P15/32	74	014955	QC21PM15.5	109
010113	R10A13/64	95	010331	R10CO31/64	110	010631	R10P31/64	74	014960	QC21PM16.0	109
010114	R10A7/32	95	010332	R10CO1/2	110	010632	R10P1/2	74	014965	QC21PM16.5	109
010115	R10A15/64	95	010333	R10CO33/64	110	010633	R10P33/64	74	014970	QC21PM17.0	109

# EDP NUMBER INDEX - 014975 - 016252

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
014975	QC21PM17.5	109	015301	R15COA	110	015831	QC21P31/64	106	016075	2A7.5	82
015001	R15A	74	015302	R15COB	110	015832	QC21P1/2	106	016076	2A7.6	82
015002	R15B	74	015303	R15COC	110	015833	QC21P33/64	106	016078	2A7.8	82
015003	R15C	74	015304	R15COD	110	015834	QC21P17/32	106	016079	2A7.9	82
015004	R15D	74	015305	R15COE	110	015835	QC21P35/64	106	016080	2A8.0	82
015005	R15E	74	015306	R15COF	110	015836	QC21P9/16	106	016081	2A8.1	82
015006	R15F	74	015307	R15COG	110	015837	QC21P37/64	106	016082	2A8.2	82
015007	R15G	74	015308	R15COH	110	015838	QC21P19/32	106	016084	2A8.4	82
015008	R15H	74	015309	R15COI	110	015839	QC21P39/64	106	016085	2A8.5	82
015009	R15I	74	015310	R15COJ	110	015840	QC21P5/8	106	016086	2A8.6	82
015010	R15J	74	015311	R15COK	110	015841	QC21P41/64	106	016087	2A8.7	82
015011	R15K	74	015312	R15COL	110	015842	QC21P21/32	106	016088	2A8.8	82
015012	R15L	74	015313	R15COM	110	015843	QC21P43/64	106	016089	2A8.9	82
015013	R15M	74	015314	R15CON	110	015844	QC21P11/16	106	016090	2A9.0	82
015014	R15N	74	015315	R15COO	110	016002	2A.2	82	016093	2A9.3	82
015015	R15O	74	015316	R15COP	110	016003	2A.3	82	016094	2A9.4	82
015016	R15P	74	015317	R15COQ	110	016004	2A.4	82	016095	2A9.5	82
015017	R15Q	74	015318	R15COR	110	016005	2A.5	82	016096	2A9.6	82
015018	R15R	74	015319	R15COS	110	016006	2A.6	82	016097	2A9.7	82
015019	R15S	74	015320	R15COT	110	016007	2A.7	82	016098	2A9.8	82
015020	R15T	74	015321	R15COU	110	016008	2A.8	82	016099	2A9.9	82
015021	R15U	74	015322	R15COV	110	016009	2A.9	82	016100	2A10.0	82
015022	R15V	74	015323	R15COW	110	016010	2A1.00	82	016102	2A10.2	82
015023	R15W	74	015324	R15COX	110	016011	2A1.1	82	016103	2A10.3	82
015024	R15X	74	015325	R15COY	110	016012	2A1.2	82	016105	2A10.5	82
015025	R15Y	74	015326	R15COZ	110	016013	2A1.3	82	016106	2A10.6	82
015026	R15Z	74	015601	R15PA	74	016014	2A1.4	82	016108	2A10.8	82
015101	R15AA	95	015602	R15PB	74	016015	2A1.5	82	016109	2A10.9	82
015102	R15AB	95	015603	R15PC	74	016016	2A1.6	82	016110	2A11.0	82
015103	R15AC	95	015604	R15PD	74	016017	2A1.7	82	016112	2A11.2	82
015104	R15AD	95	015605	R15PE	74	016018	2A1.8	82	016113	2A11.3	82
015105	R15AE	95	015606	R15PF	74	016019	2A1.9	82	016114	2A11.4	82
015106	R15AF	95	015607	R15PG	74	016020	2A2.0	82	016115	2A11.5	82
015107	R15AG	95	015608	R15PH	74	016021	2A2.1	82	016117	2A11.7	82
015108	R15AH	95	015609	R15PI	74	016022	2A2.2	82	016118	2A11.8	82
015109	R15AI	95	015610	R15PJ	74	016023	2A2.3	82	016120	2A12.0	82
015110	R15AJ	95	015611	R15PK	74	016024	2A2.4	82	016121	2A12.1	82
015111	R15AK	95	015612	R15PL	74	016025	2A2.5	82	016122	2A12.2	82
015112	R15AL	95	015613	R15PM	74	016026	2A2.6	82	016125	2A12.5	82
015113	R15AM	95	015614	R15PN	74	016027	2A2.7	82	016127	2A12.7	82
015114	R15AN	95	015615	R15PO	74	016029	2A2.9	82	016128	2A12.8	82
015115	R15AO	95	015616	R15PP	74	016030	2A3.0	82	016129	2A12.9	82
015116	R15AP	95	015617	R15PQ	74	016031	2A3.1	82	016130	2A13.0	82
015117	R15AQ	95	015618	R15PR	74	016032	2A3.2	82	016135	2AB13.5	82
015118	R15AR	95	015619	R15PS	74	016033	2A3.3	82	016140	2AB14.0	82
015119	R15AS	95	015620	R15PT	74	016034	2A3.4	82	016145	2AB14.5	82
015120	R15AT	95	015621	R15PU	74	016035	2A3.5	82	016150	2AB15.0	82
015121	R15AU	95	015622	R15PV	74	016036	2A3.6	82	016155	2AB15.5	82
015122	R15AV	95	015623	R15PW	74	016037	2A3.7	82	016160	2AB16.0	82
015123	R15AW	95	015624	R15PX	74	016040	2A4.0	82	016165	2AB16.5	82
015124	R15AX	95	015625	R15PY	74	016041	2A4.1	82	016170	2AB17.0	82
015125	R15AY	95	015626	R15PZ	74	016042	2A4.2	82	016175	2AB17.5	82
015126	R15AZ	95	015804	QC21P1/16	106	016043	2A4.3	82	016215	2A.15	82
015201	R15BA	98	015805	QC21P5/64	106	016044	2A4.4	82	016216	2A.16	82
015202	R15BB	98	015806	QC21P3/32	106	016045	2A4.5	82	016217	2A.17	82
015203	R15BC	98	015807	QC21P7/64	106	016046	2A4.6	82	016218	2A.18	82
015204	R15BD	98	015808	QC21P1/8	106	016048	2A4.8	82	016219	2A.19	82
015205	R15BE	98	015809	QC21P9/64	106	016050	2A5.0	82	016221	2A.21	82
015206	R15BF	98	015810	QC21P5/32	106	016051	2A5.1	82	016222	2A.22	82
015207	R15BG	98	015811	QC21P11/64	106	016052	2A5.2	82	016223	2A.23	82
015208	R15BH	98	015812	QC21P3/16	106	016053	2A5.3	82	016224	2A.24	82
015209	R15BI	98	015813	QC21P13/64	106	016054	2A5.4	82	016225	2A.25	82
015210	R15BJ	98	015814	QC21P7/32	106	016055	2A5.5	82	016226	2A.26	82
015211	R15BK	98	015815	QC21P15/64	106	016056	2A5.6	82	016227	2A.27	82
015212	R15BL	98	015816	QC21P1/4	106	016057	2A5.7	82	016228	2A.28	82
015213	R15BM	98	015817	QC21P17/64	106	016058	2A5.8	82	016229	2A.29	82
015214	R15BN	98	015818	QC21P9/32	106	016060	2A6.0	82	016232	2A.32	82
015215	R15BO	98	015819	QC21P19/64	106	016061	2A6.1	82	016234	2A.34	82
015216	R15BP	98	015820	QC21P5/16	106	016062	2A6.2	82	016235	2A.35	82
015217	R15BQ	98	015821	QC21P21/64	106	016063	2A6.3	82	016236	2A.36	82
015218	R15BR	98	015822	QC21P11/32	106	016064	2A6.4	82	016238	2A.38	82
015219	R15BS	98	015823	QC21P23/64	106	016065	2A6.5	82	016242	2A.42	82
015220	R15BT	98	015824	QC21P3/8	106	016066	2A6.6	82	016244	2A.44	82
015221	R15BU	98	015825	QC21P25/64	106	016067	2A6.7	82	016245	2A.45	82
015222	R15BV	98	015826	QC21P13/32	106	016068	2A6.8	82	016246	2A.46	82
015223	R15BW	98	015827	QC21P27/64	106	016070	2A7.0	82	016248	2A.48	82
015224	R15BX	98	015828	QC21P7/16	106	016072	2A7.2	82	016250	2A.50	82
015225	R15BY	98	015829	QC21P29/64	106	016073	2A7.3	82	016251	2A.51	82
015226	R15BZ	98	015830	QC21P15/32	106	016074	2A7.4	82	016252	2A.52	82

# EDP NUMBER INDEX - 016253 - 018248

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
016253	2A.85	82	016442	2AC04.2	110	018023	R18N23	74	018122	R18AN22	95
016254	2A.95	82	016443	2AC04.3	110	018024	R18N24	74	018123	R18AN23	95
016256	2A1.15	82	016444	2AC04.4	110	018025	R18N25	74	018124	R18AN24	95
016257	2A1.25	82	016445	2AC04.5	110	018026	R18N26	74	018125	R18AN25	95
016258	2A1.35	82	016447	2AC04.7	110	018027	R18N27	74	018126	R18AN26	95
016259	2A1.45	82	016448	2AC04.8	110	018028	R18N28	74	018127	R18AN27	95
016260	2A1.55	82	016450	2AC05.0	110	018029	R18N29	74	018128	R18AN28	95
016261	2A1.65	82	016451	2AC05.1	110	018030	R18N30	74	018129	R18AN29	95
016262	2A1.75	82	016452	2AC05.2	110	018031	R18N31	74	018130	R18AN30	95
016266	2A2.15	82	016453	2AC05.3	110	018032	R18N32	74	018131	R18AN31	95
016267	2A2.25	82	016455	2AC05.5	110	018033	R18N33	74	018132	R18AN32	95
016268	2A2.35	82	016456	2AC05.6	110	018034	R18N34	74	018133	R18AN33	95
016270	2A2.75	82	016457	2AC05.7	110	018035	R18N35	74	018134	R18AN34	95
016271	2A3.25	82	016459	2AC05.9	110	018036	R18N36	74	018135	R18AN35	95
016276	2A5.75	82	016460	2AC06.0	110	018037	R18N37	74	018136	R18AN36	95
016278	2A6.75	82	016461	2AC06.1	110	018038	R18N38	74	018137	R18AN37	95
016279	2A7.25	82	016462	2AC06.2	110	018039	R18N39	74	018138	R18AN38	95
016282	2A8.25	82	016463	2AC06.3	110	018040	R18N40	74	018139	R18AN39	95
016283	2A8.75	82	016464	2AC06.4	110	018041	R18N41	74	018140	R18AN40	95
016300	2ACO10.0	110	016465	2AC06.5	110	018042	R18N42	74	018141	R18AN41	95
016302	2ACO10.2	110	016466	2AC06.6	110	018043	R18N43	74	018142	R18AN42	95
016305	2ACO10.5	110	016467	2AC06.7	110	018044	R18N44	74	018143	R18AN43	95
016308	2ACO10.8	110	016468	2AC06.8	110	018045	R18N45	74	018144	R18AN44	95
016310	2ACO11.0	110	016469	2AC06.9	110	018046	R18N46	74	018145	R18AN45	95
016312	2ACO11.2	110	016470	2AC07.0	110	018047	R18N47	74	018146	R18AN46	95
016315	2ACO11.5	110	016471	2AC07.1	110	018048	R18N48	74	018147	R18AN47	95
016318	2ACO11.8	110	016472	2AC07.2	110	018049	R18N49	74	018148	R18AN48	95
016320	2ACO12.0	110	016473	2AC07.3	110	018050	R18N50	74	018149	R18AN49	95
016322	2ACO12.2	110	016475	2AC07.5	110	018051	R18N51	74	018150	R18AN50	95
016325	2ACO12.5	110	016478	2AC07.8	110	018052	R18N52	74	018151	R18AN51	95
016330	2ACO13.0	110	016479	2AC07.9	110	018053	R18N53	74	018152	R18AN52	95
016355	2ACO1.05	110	016480	2AC08.0	110	018054	R18N54	74	018201	R18BN1	98
016356	2ACO1.15	110	016482	2AC08.2	110	018055	R18N55	74	018202	R18BN2	98
016357	2ACO1.25	110	016484	2AC08.4	110	018056	R18N56	74	018203	R18BN3	98
016358	2ACO1.35	110	016485	2AC08.5	110	018057	R18N57	74	018204	R18BN4	98
016359	2ACO1.45	110	016488	2AC08.8	110	018058	R18N58	74	018205	R18BN5	98
016360	2ACO1.55	110	016489	2AC08.9	110	018059	R18N59	74	018206	R18BN6	98
016361	2ACO1.65	110	016490	2AC09.0	110	018060	R18N60	74	018207	R18BN7	98
016362	2ACO1.75	110	016491	2AC09.1	110	018061	R18N61	74	018208	R18BN8	98
016363	2ACO1.85	110	016492	2AC09.2	110	018062	R18N62	74	018209	R18BN9	98
016364	2ACO1.95	110	016493	2AC09.3	110	018063	R18N63	74	018210	R18BN10	98
016365	2ACO2.05	110	016494	2AC09.4	110	018064	R18N64	74	018211	R18BN11	98
016368	2ACO2.35	110	016495	2AC09.5	110	018065	R18N65	74	018212	R18BN12	98
016371	2ACO3.25	110	016496	2AC09.6	110	018066	R18N66	74	018213	R18BN13	98
016372	2ACO3.75	110	016497	2AC09.7	110	018067	R18N67	74	018214	R18BN14	98
016373	2ACO4.25	110	016498	2AC09.8	110	018068	R18N68	74	018215	R18BN15	98
016375	2ACO5.25	110	017910	TS52N10	199	018069	R18N69	74	018216	R18BN16	98
016379	2ACO7.25	110	017911	TS52N11	199	018070	R18N70	74	018217	R18BN17	98
016410	2ACO1.0	110	017920	TS52N20	199	018071	R18N71	74	018218	R18BN18	98
016411	2ACO1.1	110	017921	TS52N21	199	018072	R18N72	74	018219	R18BN19	98
016412	2ACO1.2	110	017930	TS52N30	199	018073	R18N73	74	018220	R18BN20	98
016413	2ACO1.3	110	017940	TS52N40	199	018074	R18N74	74	018221	R18BN21	98
016414	2ACO1.4	110	017958	TS511/8	199	018075	R18N75	74	018222	R18BN22	98
016415	2ACO1.5	110	017960	TS515/32	199	018076	R18N76	74	018223	R18BN23	98
016416	2ACO1.6	110	017962	TS513/16	199	018077	R18N77	74	018224	R18BN24	98
016417	2ACO1.7	110	017964	TS517/32	199	018078	R18N78	74	018225	R18BN25	98
016418	2ACO1.8	110	017966	TS511/4	199	018079	R18N79	74	018226	R18BN26	98
016419	2ACO1.9	110	018001	R18N1	74	018080	R18N80	74	018227	R18BN27	98
016420	2ACO2.0	110	018002	R18N2	74	018101	R18AN1	95	018228	R18BN28	98
016421	2ACO2.1	110	018003	R18N3	74	018102	R18AN2	95	018229	R18BN29	98
016422	2ACO2.2	110	018004	R18N4	74	018103	R18AN3	95	018230	R18BN30	98
016423	2ACO2.3	110	018005	R18N5	74	018104	R18AN4	95	018231	R18BN31	98
016424	2ACO2.4	110	018006	R18N6	74	018105	R18AN5	95	018232	R18BN32	98
016425	2ACO2.5	110	018007	R18N7	74	018106	R18AN6	95	018233	R18BN33	98
016426	2ACO2.6	110	018008	R18N8	74	018107	R18AN7	95	018234	R18BN34	98
016427	2ACO2.7	110	018009	R18N9	74	018108	R18AN8	95	018235	R18BN35	98
016428	2ACO2.8	110	018010	R18N10	74	018109	R18AN9	95	018236	R18BN36	98
016429	2ACO2.9	110	018011	R18N11	74	018110	R18AN10	95	018237	R18BN37	98
016430	2ACO3.0	110	018012	R18N12	74	018111	R18AN11	95	018238	R18BN38	98
016431	2ACO3.1	110	018013	R18N13	74	018112	R18AN12	95	018239	R18BN39	98
016432	2ACO3.2	110	018014	R18N14	74	018113	R18AN13	95	018240	R18BN40	98
016433	2ACO3.3	110	018015	R18N15	74	018114	R18AN14	95	018241	R18BN41	98
016434	2ACO3.4	110	018016	R18N16	74	018115	R18AN15	95	018242	R18BN42	98
016435	2ACO3.5	110	018017	R18N17	74	018116	R18AN16	95	018243	R18BN43	98
016436	2ACO3.6	110	018018	R18N18	74	018117	R18AN17	95	018244	R18BN44	98
016437	2ACO3.7	110	018019	R18N19	74	018118	R18AN18	95	018245	R18BN45	98
016438	2ACO3.8	110	018020	R18N20	74	018119	R18AN19	95	018246	R18BN46	98
016440	2ACO4.0	110	018021	R18N21	74	018120	R18AN20	95	018247	R18BN47	98
016441	2ACO4.1	110	018022	R18N22	74	018121	R18AN21	95	018248	R18BN48	98

# EDP NUMBER INDEX - 018249 - 019430

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
018249	R18BN49	98	018376	R18CON76	110	018575	R18HN75	101	018674	R18PN74	74
018250	R18BN50	98	018377	R18CON77	110	018576	R18HN76	101	018675	R18PN75	74
018251	R18BN51	98	018378	R18CON78	110	018577	R18HN77	101	018676	R18PN76	74
018252	R18BN52	98	018379	R18CON79	110	018578	R18HN78	101	018677	R18PN77	74
018301	R18CON1	110	018380	R18CON80	110	018579	R18HN79	101	018678	R18PN78	74
018302	R18CON2	110	018501	R18HN1	101	018580	R18HN80	101	018679	R18PN79	74
018303	R18CON3	110	018502	R18HN2	101	018601	R18PN1	74	018680	R18PN80	74
018304	R18CON4	110	018503	R18HN3	101	018602	R18PN2	74	018681	R18PN81	74
018305	R18CON5	110	018504	R18HN4	101	018603	R18PN3	74	018682	R18PN82	74
018306	R18CON6	110	018505	R18HN5	101	018604	R18PN4	74	018683	R18PN83	74
018307	R18CON7	110	018506	R18HN6	101	018605	R18PN5	74	018684	R18PN84	74
018308	R18CON8	110	018507	R18HN7	101	018606	R18PN6	74	018685	R18PN85	74
018309	R18CON9	110	018508	R18HN8	101	018607	R18PN7	74	018686	R18PN86	74
018310	R18CON10	110	018509	R18HN9	101	018608	R18PN8	74	018687	R18PN87	74
018311	R18CON11	110	018510	R18HN10	101	018609	R18PN9	74	018688	R18PN88	74
018312	R18CON12	110	018511	R18HN11	101	018610	R18PN10	74	018689	R18PN89	74
018313	R18CON13	110	018512	R18HN12	101	018611	R18PN11	74	018690	R18PN90	74
018314	R18CON14	110	018513	R18HN13	101	018612	R18PN12	74	018691	R18PN91	74
018315	R18CON15	110	018514	R18HN14	101	018613	R18PN13	74	018692	R18PN92	74
018316	R18CON16	110	018515	R18HN15	101	018614	R18PN14	74	018693	R18PN93	74
018317	R18CON17	110	018516	R18HN16	101	018615	R18PN15	74	018694	R18PN94	74
018318	R18CON18	110	018517	R18HN17	101	018616	R18PN16	74	018695	R18PN95	74
018319	R18CON19	110	018518	R18HN18	101	018617	R18PN17	74	018696	R18PN96	74
018320	R18CON20	110	018519	R18HN19	101	018618	R18PN18	74	018697	R18PN97	74
018321	R18CON21	110	018520	R18HN20	101	018619	R18PN19	74	019301	QC21PA	106
018322	R18CON22	110	018521	R18HN21	101	018620	R18PN20	74	019302	QC21PB	106
018323	R18CON23	110	018522	R18HN22	101	018621	R18PN21	74	019303	QC21PC	106
018324	R18CON24	110	018523	R18HN23	101	018622	R18PN22	74	019304	QC21PD	106
018325	R18CON25	110	018524	R18HN24	101	018623	R18PN23	74	019306	QC21PF	106
018326	R18CON26	110	018525	R18HN25	101	018624	R18PN24	74	019307	QC21PG	106
018327	R18CON27	110	018526	R18HN26	101	018625	R18PN25	74	019308	QC21PH	106
018328	R18CON28	110	018527	R18HN27	101	018626	R18PN26	74	019309	QC21PI	106
018329	R18CON29	110	018528	R18HN28	101	018627	R18PN27	74	019310	QC21PJ	106
018330	R18CON30	110	018529	R18HN29	101	018628	R18PN28	74	019311	QC21PK	106
018331	R18CON31	110	018530	R18HN30	101	018629	R18PN29	74	019312	QC21PL	106
018332	R18CON32	110	018531	R18HN31	101	018630	R18PN30	74	019313	QC21PM	106
018333	R18CON33	110	018532	R18HN32	101	018631	R18PN31	74	019314	QC21PN	106
018334	R18CON34	110	018533	R18HN33	101	018632	R18PN32	74	019315	QC21PO	106
018335	R18CON35	110	018534	R18HN34	101	018633	R18PN33	74	019316	QC21PP	106
018336	R18CON36	110	018535	R18HN35	101	018634	R18PN34	74	019317	QC21PQ	106
018337	R18CON37	110	018536	R18HN36	101	018635	R18PN35	74	019318	QC21PR	106
018338	R18CON38	110	018537	R18HN37	101	018636	R18PN36	74	019319	QC21PS	106
018339	R18CON39	110	018538	R18HN38	101	018637	R18PN37	74	019320	QC21PT	106
018340	R18CON40	110	018539	R18HN39	101	018638	R18PN38	74	019321	QC21PU	106
018341	R18CON41	110	018540	R18HN40	101	018639	R18PN39	74	019322	QC21PV	106
018342	R18CON42	110	018541	R18HN41	101	018640	R18PN40	74	019323	QC21PW	106
018343	R18CON43	110	018542	R18HN42	101	018641	R18PN41	74	019324	QC21PX	106
018344	R18CON44	110	018543	R18HN43	101	018642	R18PN42	74	019325	QC21PY	106
018345	R18CON45	110	018544	R18HN44	101	018643	R18PN43	74	019326	QC21PZ	106
018346	R18CON46	110	018545	R18HN45	101	018644	R18PN44	74	019401	QC21PN1	106
018347	R18CON47	110	018546	R18HN46	101	018645	R18PN45	74	019402	QC21PN2	106
018348	R18CON48	110	018547	R18HN47	101	018646	R18PN46	74	019403	QC21PN3	106
018349	R18CON49	110	018548	R18HN48	101	018647	R18PN47	74	019404	QC21PN4	106
018350	R18CON50	110	018549	R18HN49	101	018648	R18PN48	74	019405	QC21PN5	106
018351	R18CON51	110	018550	R18HN50	101	018649	R18PN49	74	019406	QC21PN6	106
018352	R18CON52	110	018551	R18HN51	101	018650	R18PN50	74	019407	QC21PN7	106
018353	R18CON53	110	018552	R18HN52	101	018651	R18PN51	74	019408	QC21PN8	106
018354	R18CON54	110	018553	R18HN53	101	018652	R18PN52	74	019409	QC21PN9	106
018355	R18CON55	110	018554	R18HN54	101	018653	R18PN53	74	019410	QC21PN10	106
018356	R18CON56	110	018555	R18HN55	101	018654	R18PN54	74	019411	QC21PN11	106
018357	R18CON57	110	018556	R18HN56	101	018655	R18PN55	74	019412	QC21PN12	106
018358	R18CON58	110	018557	R18HN57	101	018656	R18PN56	74	019413	QC21PN13	106
018359	R18CON59	110	018558	R18HN58	101	018657	R18PN57	74	019414	QC21PN14	106
018360	R18CON60	110	018559	R18HN59	101	018658	R18PN58	74	019415	QC21PN15	106
018361	R18CON61	110	018560	R18HN60	101	018659	R18PN59	74	019416	QC21PN16	106
018362	R18CON62	110	018561	R18HN61	101	018660	R18PN60	74	019417	QC21PN17	106
018363	R18CON63	110	018562	R18HN62	101	018661	R18PN61	74	019418	QC21PN18	106
018364	R18CON64	110	018563	R18HN63	101	018662	R18PN62	74	019419	QC21PN19	106
018365	R18CON65	110	018564	R18HN64	101	018663	R18PN63	74	019420	QC21PN20	106
018366	R18CON66	110	018565	R18HN65	101	018664	R18PN64	74	019421	QC21PN21	106
018367	R18CON67	110	018566	R18HN66	101	018665	R18PN65	74	019422	QC21PN22	106
018368	R18CON68	110	018567	R18HN67	101	018666	R18PN66	74	019423	QC21PN23	106
018369	R18CON69	110	018568	R18HN68	101	018667	R18PN67	74	019424	QC21PN24	106
018370	R18CON70	110	018569	R18HN69	101	018668	R18PN68	74	019425	QC21PN25	106
018371	R18CON71	110	018570	R18HN70	101	018669	R18PN69	74	019426	QC21PN26	106
018372	R18CON72	110	018571	R18HN71	101	018670	R18PN70	74	019427	QC21PN27	106
018373	R18CON73	110	018572	R18HN72	101	018671	R18PN71	74	019428	QC21PN28	106
018374	R18CON74	110	018573	R18HN73	101	018672	R18PN72	74	019429	QC21PN29	106
018375	R18CON75	110	018574	R18HN74	101	018673	R18PN73	74	019430	QC21PN30	106



# EDP NUMBER INDEX - 019431 - 022031

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
019431	QC21PN31	106	020019	20919/64	164	020125	2091.25/64	164	021337	209CO37/64	174
019432	QC21PN32	106	020020	2095/16	164	020126	2091.13/32	164	021338	209CO19/32	174
019433	QC21PN33	106	020021	20921/64	164	020127	2091.27/64	164	021339	209CO39/64	174
019434	QC21PN34	106	020022	20911/32	164	020128	2091.7/16	164	021340	209CO5/8	174
019435	QC21PN35	106	020023	20923/64	164	0020128	A1253.0X160	149	021341	209CO41/64	174
019436	QC21PN36	106	020024	2093/8	164	020130	2091.15/32	164	021342	209CO21/32	174
019437	QC21PN37	106	020025	20925/64	164	020131	2091.31/64	164	021343	209CO43/64	174
019438	QC21PN38	106	020026	20913/32	164	020132	2091.1/2	164	021344	209CO11/16	174
019439	QC21PN39	106	020027	20927/64	164	020134	2091.17/32	164	021345	209CO45/64	174
019440	QC21PN40	106	020028	2097/16	164	0020135	A1253.0X200	149	021347	209CO47/64	174
019441	QC21PN41	106	020029	20929/64	164	020136	2091.9/16	164	021348	209CO23/32	174
019442	QC21PN42	106	0020029	A12514.0X400	149	020140	2091.5/8	164	021349	209CO49/64	174
019443	QC21PN43	106	020030	20915/32	164	0020142	A1253.0X250	149	021350	209CO3/4	174
019444	QC21PN44	106	020031	20931/64	164	020144	2091.11/16	164	021351	209CO51/64	174
019445	QC21PN45	106	020032	2091/2	164	020146	2091.23/32	164	021352	209CO25/32	174
019446	QC21PN46	106	020033	20933/64	164	020148	2091.3/4	164	021353	209CO53/64	174
019447	QC21PN47	106	020034	20917/32	164	020150	2091.25/32	164	021354	209CO13/16	174
019448	QC21PN48	106	020035	20935/64	164	020152	2091.13/16	164	021355	209CO27/32	174
019449	QC21PN49	106	020036	2099/16	164	020154	2091.27/32	164	021356	209CO7/8	174
019450	QC21PN50	106	0020036	A1252.2X160	149	020156	2091.7/8	164	021357	209CO55/64	174
019451	QC21PN51	106	020037	20937/64	164	020158	2091.29/32	164	021358	209CO57/64	174
019452	QC21PN52	106	020038	20919/32	164	0020159	A1254.5X160	149	021359	209CO29/32	174
019815	QC21GM1.5	109	020039	20939/64	164	020160	2091.15/16	164	021360	209CO15/16	174
019820	QC21GM2.0	109	020040	2095/8	164	020162	2091.31/32	164	021362	209CO59/64	174
019825	QC21GM2.5	109	020041	20941/64	164	0020166	A1254.5X200	149	021363	209CO61/64	174
019830	QC21GM3.0	109	020042	20921/32	164	0020173	A1254.5X250	149	021364	209CO31/32	174
0019832	A1251.4X160	149	020043	20943/64	164	0020180	A1254.5X315	149	021365	209CO63/64	174
019840	QC21GM4.0	109	0020043	A1252.5X125	149	0020197	A1254.0X160	149	021400	209CO1	174
0019849	A1251.5X125	149	020044	20911/16	164	20200	2092	164	021401	209CO1.1/64	174
019850	QC21GM5.0	109	020045	20945/64	164	0020203	A1254.0X200	149	021402	209CO1.1/32	174
019852	QC21GM5.2	109	020046	20923/32	164	0020210	A1254.0X250	149	021404	209CO1.1/16	174
019855	QC21GM5.5	109	020047	20947/64	164	0020227	A1254.0X315	149	021406	209CO1.3/32	174
0019856	A1251.5X160	149	020048	2093/4	164	0020234	A1255.5X200	149	021407	209CO1.7/64	174
019856	QC21GM5.6	109	020049	20949/64	164	0020241	A1255.5X250	149	021408	209CO1.1/8	174
019860	QC21GM6.0	109	020050	20925/32	164	0020258	A1255.5X315	149	021409	209CO1.9/64	174
0019863	A1251.8X160	149	0020050	A1252.5X160	149	0020265	A1255.0X160	149	021411	209CO1.11/64	174
019865	QC21GM6.5	109	020051	20951/64	164	0020272	A1255.0X200	149	021412	209CO1.3/16	174
019868	QC21GM6.8	109	020052	20913/16	164	0020289	A1255.0X250	149	021414	209CO1.7/32	174
0019870	A12510.5X250	149	020053	20953/64	164	0020296	A1255.0X315	149	021415	209CO1.15/64	174
019870	QC21GM7.0	109	020054	20927/32	164	0020302	A1255.0X400	149	021416	209CO1.1/4	174
019875	QC21GM7.5	109	020055	20955/64	164	0020319	A1256.5X200	149	021418	209CO1.9/32	174
019880	QC21GM8.0	109	020056	2097/8	164	0020326	A1256.5X250	149	021419	209CO1.19/64	174
019882	QC21GM8.2	109	020057	20957/64	164	0020333	A1256.5X315	149	021420	209CO1.5/16	174
019885	QC21GM8.5	109	020058	20929/32	164	0020340	A1256.0X200	149	021422	209CO1.11/32	174
019886	QC21GM8.6	109	020059	20959/64	164	0020357	A1256.0X250	149	021423	209CO1.23/64	174
0019887	A12510.5X315	149	020060	20915/16	164	0020364	A1256.0X315	149	021424	209CO1.3/8	174
019890	QC21GM9.0	109	020061	20961/64	164	0020371	A1256.0X400	149	021427	209CO1.27/64	174
0019894	A12510.5X400	149	020062	20931/32	164	0020388	A1257.5X200	149	021428	209CO1.7/16	174
019895	QC21GM9.5	109	020063	20963/64	164	0020395	A1257.5X250	149	021430	209CO1.15/32	174
0019900	A12510.0X250	149	0020067	A1252.0X125	149	0020401	A1257.5X315	149	021431	209CO1.31/64	174
019900	QC21GM10.0	109	0020074	A1252.0X160	149	0020418	A1257.0X200	149	021432	209CO1.1/2	174
019905	QC21GM10.5	109	0020081	A1253.3X160	149	0020425	A1257.0X250	149	022004	HX101/16	92
019910	QC21GM11.0	109	0020098	A1253.5X160	149	0020432	A1257.0X315	149	022005	HX105/64	92
019915	QC21GM11.5	109	20100	2091	164	0020449	A1258.5X250	149	022006	HX103/32	92
0019917	A12510.0X315	149	020101	2091.1/64	164	0020456	A1258.5X315	149	022007	HX107/64	92
019920	QC21GM12.0	109	020102	2091.1/32	164	0020463	A1258.0X250	149	022008	HX101/8	92
0019924	A12510.0X400	149	020103	2091.3/64	164	0020470	A1258.0X315	149	022009	HX109/64	92
019925	QC21GM12.5	109	020104	2091.1/16	164	0020487	A1258.0X400	149	022010	HX105/32	92
019930	QC21GM13.0	109	0020104	A1253.5X200	149	0020494	A1259.5X250	149	022011	HX1011/64	92
0019931	A12511.0X250	149	020105	2091.5/64	164	0020500	A1259.5X315	149	022012	HX103/16	92
0019948	A12511.0X315	149	020106	2091.3/32	164	0020517	A1259.0X250	149	022013	HX1013/64	92
0019955	A12511.0X400	149	020107	2091.7/64	164	0020524	A1259.0X315	149	022014	HX107/32	92
0019962	A12512.0X250	149	020108	2091.1/8	164	0020531	A1259.0X400	149	022015	HX1015/64	92
0019979	A12512.0X315	149	020109	2091.9/64	164	021316	209CO1/4	174	022016	HX101/4	92
0019986	A12512.0X400	149	020110	2091.5/32	164	021318	209CO9/32	174	022017	HX1017/64	92
0019993	A12513.0X315	149	020111	2091.11/64	164	021320	209CO5/16	174	022018	HX109/32	92
0020005	A12513.0X400	149	0020111	A1253.5X250	149	021322	209CO11/32	174	022019	HX1019/64	92
020008	2091/8	164	020112	2091.3/16	164	021324	209CO3/8	174	022020	HX105/16	92
020009	2099/64	164	020114	2091.7/32	164	021326	209CO13/32	174	022021	HX1021/64	92
020010	2095/32	164	020115	2091.15/64	164	021327	209CO27/64	174	022022	HX1011/32	92
020011	20911/64	164	020116	2091.1/4	164	021328	209CO7/16	174	022023	HX1023/64	92
020012	2093/16	164	020117	2091.17/64	164	021329	209CO29/64	174	022024	HX103/8	92
020012	A12514.0X315	149	020118	2091.9/32	164	021330	209CO15/32	174	022025	HX1025/64	92
020013	20913/64	164	020119	2091.19/64	164	021331	209CO31/64	174	022026	HX1013/32	92
020014	2097/32	164	020120	2091.5/16	164	021332	209CO1/2	174	022027	HX1027/64	92
020015	20915/64	164	020121	2091.21/64	164	021333	209CO33/64	174	022028	HX107/16	92
020016	2091/4	164	020122	2091.11/32	164	021334	209CO17/32	174	022029	HX1029/64	92
020017	20917/64	164	020123	2091.23/64	164	021335	209CO35/64	174	022030	HX1015/32	92
020018	2099/32	164	020124	2091.3/8	164	021336	209CO9/16	174	022031	HX1031/64	92

# EDP NUMBER INDEX - 022032 - 029043

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
022032	HX101/2	92	023032	S2091/2	164	026065	5ATS6.5	167	0028568	A100A	82
022101	HX18N1	92	023033	S20933/64	164	026068	5ATS6.8	167	0028575	A100B	82
022102	HX18N2	92	023034	S20917/32	164	026070	5ATS7.0	167	0028582	A100C	82
022103	HX18N3	92	023035	S20935/64	164	026075	5ATS7.5	167	0028599	A100D	82
022104	HX18N4	92	023036	S2099/16	164	026080	5ATS8.0	167	0028605	A100E	82
022105	HX18N5	92	023051	S20951/64	164	026085	5ATS8.5	167	0028612	A100F	82
022106	HX18N6	92	023052	S20913/16	164	026090	5ATS9.0	167	0028629	A100G	82
022107	HX18N7	92	023053	S20953/64	164	026095	5ATS9.5	167	0028636	A100H	82
022108	HX18N8	92	023054	S20927/32	164	026100	5ATS10.0	167	0028643	A100I	82
022109	HX18N9	92	023055	S20955/64	164	026102	5ATS10.2	167	0028650	A100J	82
022110	HX18N10	92	023056	S2097/8	164	026105	5ATS10.5	167	0028667	A100K	82
022111	HX18N11	92	023057	S20957/64	164	026110	5ATS11.0	167	0028674	A100L	82
022112	HX18N12	92	023058	S20929/32	164	026115	5ATS11.5	167	0028681	A100M	82
022113	HX18N13	92	023106	S2091.3/32	164	026120	5ATS12.0	167	0028698	A100N	82
022114	HX18N14	92	023107	S2091.7/64	164	026122	5ATS12.2	167	0028704	A100N1	82
022115	HX18N15	92	023108	S2091.1/8	164	026125	5ATS12.5	167	0028711	A100N10	82
022116	HX18N16	92	023109	S2091.9/64	164	026128	5ATS12.8	167	0028728	A100N11	82
022117	HX18N17	92	023110	S2091.5/32	164	026130	5ATS13.0	167	0028735	A100N12	82
022118	HX18N18	92	023111	S2091.11/64	164	026135	5ATS13.5	167	0028742	A100N13	82
022119	HX18N19	92	023112	S2091.3/16	164	026138	5ATS13.8	167	0028759	A100N14	82
022120	HX18N20	92	023113	S2091.13/64	164	026140	5ATS14.0	167	0028766	A100N15	82
022121	HX18N21	92	023114	S2091.7/32	164	026142	5ATS14.25	167	0028773	A100N16	82
022122	HX18N22	92	023115	S2091.15/64	164	026145	5ATS14.5	167	0028780	A100N17	82
022123	HX18N23	92	023116	S2091.1/4	164	026147	5ATS14.75	167	0028797	A100N18	82
022124	HX18N24	92	023133	S2091.33/64	164	026150	5ATS15.0	167	0028803	A100N19	82
022125	HX18N25	92	023134	S2091.17/32	164	026152	5ATS15.25	167	0028810	A100N2	82
022126	HX18N26	92	023135	S2091.35/64	164	026155	5ATS15.5	167	0028827	A100N20	82
022127	HX18N27	92	023136	S2091.9/16	164	026157	5ATS15.75	167	0028834	A100N21	82
022128	HX18N28	92	023137	S2091.37/64	164	026160	5ATS16.0	167	0028841	A100N22	82
022129	HX18N29	92	023138	S2091.19/32	164	026162	5ATS16.25	167	0028858	A100N23	82
022130	HX18N30	92	023139	S2091.39/64	164	026165	5ATS16.5	167	0028865	A100N24	82
022131	HX18N31	92	023140	S2091.5/8	164	026170	5ATS17.0	167	0028872	A100N25	82
022132	HX18N32	92	023141	S2091.41/64	164	026175	5ATS17.5	167	0028889	A100N26	82
022133	HX18N33	92	023142	S2091.21/32	164	026180	5ATS18.0	167	0028896	A100N27	82
022134	HX18N34	92	023144	S2091.11/16	164	026185	5ATS18.5	167	0028902	A100N28	82
022135	HX18N35	92	023145	S2091.45/64	164	026190	5ATS19.0	167	0028919	A100N29	82
022136	HX18N36	92	023147	S2091.47/64	164	026195	5ATS19.5	167	0028926	A100N3	82
022137	HX18N37	92	023148	S2091.3/4	164	026200	5ATS20.0	167	0028933	A100N30	82
022138	HX18N38	92	023150	S2091.25/32	164	026205	5ATS20.5	167	0028940	A100N31	82
022139	HX18N39	92	023152	S2091.13/16	164	026210	5ATS21.0	167	0028957	A100N32	82
022140	HX18N40	92	023156	S2091.7/8	164	026215	5ATS21.5	167	0028964	A100N33	82
022141	HX18N41	92	023160	S2091.15/16	164	026220	5ATS22.0	167	0028971	A100N34	82
022142	HX18N42	92	023162	S2091.31/32	164	026225	5ATS22.5	167	0028988	A100N35	82
022143	HX18N43	92	023200	S2092	164	026230	5ATS23.0	167	0028995	A100N36	82
022144	HX18N44	92	024532	T4001/2	461	026235	5ATS23.5	167	0029008	A100N37	82
022145	HX18N45	92	024534	T40017/32	461	026240	5ATS24.0	167	029010	2AB1.0	82
022146	HX18N46	92	024536	T4009/16	461	026245	5ATS24.5	167	029011	2AB1.1	82
022147	HX18N47	92	024540	T4005/8	461	026250	5ATS25.0	167	029012	2AB1.2	82
022148	HX18N48	92	024542	T40021/32	461	026255	5ATS25.5	167	029013	2AB1.3	82
022149	HX18N49	92	024548	T4003/4	461	026260	5ATS26.0	167	029014	2AB1.4	82
022150	HX18N50	92	024550	T40025/32	461	026265	5ATS26.5	167	029015	2AB1.5	82
022151	HX18N51	92	024556	T4007/8	461	026270	5ATS27.0	167	0029015	A100N38	82
022152	HX18N52	92	024558	T40029/32	461	026275	5ATS27.5	167	029016	2AB1.6	82
022201	HX15A	92	024600	T4001	461	026280	5ATS28.0	167	029017	2AB1.7	82
022202	HX15B	92	024602	T4001.1/32	461	026285	5ATS28.5	167	029018	2AB1.8	82
022203	HX15C	92	024604	T4001.1/16	461	026290	5ATS29.0	167	029019	2AB1.9	82
022204	HX15D	92	024608	T4001.1/8	461	026295	5ATS29.5	167	029020	2AB2.0	82
022205	HX15E	92	024610	T4001.5/32	461	026300	5ATS30.0	167	029021	2AB2.1	82
022206	HX15F	92	024616	T4001.1/4	461	026305	5ATS30.5	167	029022	2AB2.2	82
022207	HX15G	92	024620	T4001.5/16	461	026310	5ATS31.0	167	0029022	A100N39	82
022208	HX15H	92	024622	T4001.11/32	461	026315	5ATS31.5	167	029023	2AB2.3	82
022209	HX15I	92	024624	T4001.3/8	461	026320	5ATS32.0	167	029024	2AB2.4	82
022210	HX15J	92	024626	T4001.13/32	461	026325	5ATS32.5	167	029025	2AB2.5	82
022211	HX15K	92	024628	T4001.7/16	461	026330	5ATS33.0	167	029026	2AB2.6	82
022212	HX15L	92	024632	T4001.1/2	461	026340	5ATS34.0	167	029027	2AB2.7	82
022213	HX15M	92	024636	T4001.9/16	461	026350	5ATS35.0	167	029029	2AB2.9	82
022214	HX15N	92	024640	T4001.5/8	461	026360	5ATS36.0	167	029030	2AB3.0	82
022215	HX15O	92	024648	T4001.3/4	461	026365	5ATS36.5	167	029031	2AB3.1	82
022216	HX15P	92	024650	T4001.25/32	461	026370	5ATS37.0	167	029032	2AB3.2	82
022217	HX15Q	92	024654	T4001.27/32	461	026375	5ATS37.5	167	029033	2AB3.3	82
022218	HX15R	92	024656	T4001.7/8	461	026380	5ATS38.0	167	029034	2AB3.4	82
022219	HX15S	92	024658	T4001.29/32	461	026390	5ATS39.0	167	029035	2AB3.5	82
022220	HX15T	92	024662	T4001.31/32	461	026400	5ATS40.0	167	029036	2AB3.6	82
022221	HX15U	92	024708	T4002.1/8	461	026420	5ATS42.0	167	029037	2AB3.7	82
022222	HX15V	92	024716	T4002.1/4	461	026430	5ATS43.0	167	0029039	A100N4	82
022223	HX15W	92	024732	T4002.1/2	461	026440	5ATS44.0	167	029040	2AB4.0	82
022224	HX15X	92	026050	5ATS5.0	167	026450	5ATS45.0	167	029041	2AB4.1	82
022225	HX15Y	92	026055	5ATS5.5	167	026480	5ATS48.0	167	029042	2AB4.2	82
022226	HX15Z	92	026060	5ATS6.0	167	026500	5ATS50.0	167	029043	2AB4.3	82

# EDP NUMBER INDEX - 029044 - 0034033

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
029044	2AB4.4	82	0029152	A100N50	82	0029794	A1607.0	186	032950	4ASMC09.5	134
029045	2AB4.5	82	0029169	A100N51	82	0029800	A1607.5	186	032980	4ASMC09.8	134
029046	2AB4.6	82	0029176	A100N52	82	0029817	A1608.0	186	033000	4ASMC10.0	134
0029046	A100N40	82	0029183	A100N53	82	0029824	A1608.5	186	033002	4ASMC10.2	134
029048	2AB4.8	82	0029190	A100N54	82	0029831	A1609.0	186	033005	4ASMC10.5	134
029050	2AB5.0	82	0029206	A100N55	82	0029848	A1609.5	186	033110	4ASMC11.0	134
029051	2AB5.1	82	0029213	A100N56	82	0030134	A1701	176	033112	4ASMC11.2	134
029052	2AB5.2	82	0029220	A100N57	82	0030141	A17011/16	176	033115	4ASMC11.5	134
029053	2AB5.3	82	0029237	A100N58	82	0030165	A17013.0	176	033200	4ASMC12.0	134
0029053	A100N41	82	0029244	A100N59	82	0030172	A17013.5	176	0033241	A35010.0	167
029054	2AB5.4	82	0029251	A100N6	82	0030189	A17013/16	176	0033265	A35010.2	167
029055	2AB5.5	82	0029256	2AB1.15	82	0030196	A17014.0	176	0033289	A35010.5	167
029056	2AB5.6	82	029257	2AB1.25	82	0030202	A17014.5	176	0033296	A35010.7	167
029057	2AB5.7	82	029258	2AB1.35	82	0030219	A17015.0	176	0033319	A35011.0	167
029058	2AB5.8	82	029259	2AB1.45	82	0030226	A17015.5	176	0033333	A35011.5	167
029060	2AB6.0	82	029260	2AB1.55	82	0030233	A17015/16	176	0033340	A35011.75	167
0029060	A100N42	82	029262	2AB1.75	82	0030240	A17016.0	176	0033357	A35011.8	167
029061	2AB6.1	82	029264	2AB1.95	82	0030257	A17016.5	176	0033364	A35012.0	167
029062	2AB6.2	82	029268	2AB2.35	82	0030264	A17017.0	176	0033395	A35012.5	167
029063	2AB6.3	82	0029268	A100N60	82	0030271	A17017.5	176	0033401	A35013.0	167
029064	2AB6.4	82	029271	2AB3.25	82	0030288	A17045/64	176	0033418	A35013.5	167
029065	2AB6.5	82	0029275	A100N61	82	0030295	A17017/32	176	0033432	A35014.0	167
029066	2AB6.6	82	029276	2AB5.75	82	0030301	A17018.0	176	0033449	A35014.25	167
029067	2AB6.7	82	029278	2AB6.75	82	0030318	A17018.5	176	0033456	A35014.5	167
029068	2AB6.8	82	029279	2AB7.25	82	0030325	A17019.0	176	0033463	A35014.75	167
029070	2AB7.0	82	029281	2AB7.85	82	0030332	A17019.5	176	0033470	A35015.0	167
029072	2AB7.2	82	029282	2AB8.25	82	0030349	A17019/32	176	0033487	A35015.25	167
029073	2AB7.3	82	0029282	A100N62	82	0030356	A17020.0	176	0033494	A35015.5	167
029074	2AB7.4	82	029283	2AB8.75	82	0030363	A17021.0	176	0033500	A35015.75	167
029075	2AB7.5	82	0029299	A100N63	82	0030370	A17021/32	176	0033517	A35016.0	167
029076	2AB7.6	82	0029305	A100N64	82	0030387	A17022.0	176	0033524	A35016.25	167
0029077	A100N43	82	0029312	A100N65	82	0030394	A17023.0	176	0033531	A35016.5	167
029078	2AB7.8	82	0029329	A100N66	82	0030400	A17023/32	176	0033548	A35016.75	167
029079	2AB7.9	82	0029336	A100N67	82	0030417	A17024.0	176	0033555	A35017.0	167
029080	2AB8.0	82	0029343	A100N68	82	0030424	A17025.0	176	0033562	A35017.25	167
029081	2AB8.1	82	0029350	A100N69	82	0030431	A17025/32	176	0033579	A35017.5	167
029082	2AB8.2	82	0029367	A100N7	82	0030448	A17027/32	176	0033593	A35018.0	167
029084	2AB8.4	82	0029374	A100N70	82	0030455	A17031/32	176	0033616	A35018.5	167
0029084	A100N44	82	0029381	A100N71	82	0030462	A1703/4	176	0033623	A35019.0	167
029085	2AB8.5	82	0029398	A100N72	82	0030479	A17041/64	176	0033647	A35019.5	167
029086	2AB8.6	82	0029404	A100N73	82	0030486	A17051/64	176	0033654	A35019.75	167
029087	2AB8.7	82	0029411	A100N74	82	0030493	A17057/64	176	0033661	A35020.0	167
029088	2AB8.8	82	0029428	A100N75	82	0030509	A1705/8	176	0033678	A35020.25	167
029089	2AB8.9	82	0029435	A100N76	82	0030516	A1707/8	176	0033685	A35020.5	167
029090	2AB9.0	82	0029442	A100N77	82	0030523	A1709/16	176	0033692	A35021.0	167
0029091	A100N45	82	0029459	A100N78	82	0030547	A190201	205	0033708	A35021.5	167
029093	2AB9.3	82	0029466	A100N79	82	0030554	A190202	205	0033715	A35022.0	167
029094	2AB9.4	82	0029473	A100N8	82	0030561	A190203	205	0033722	A35022.5	167
029095	2AB9.5	82	0029480	A100N80	82	0030578	A190204	205	0033739	A35023.0	167
029096	2AB9.6	82	0029497	A100N9	82	0030585	A190206	205	0033746	A35023.5	167
029097	2AB9.7	82	0029503	A100O	82	0030608	A191413	205	0033753	A35024.0	167
029098	2AB9.8	82	0029510	A100P	82	0030615	A191419	205	0033760	A35024.5	167
029099	2AB9.9	82	0029527	A100Q	82	032230	4ASMC02.3	134	0033777	A35025.0	167
029100	2AB10.0	82	0029534	A100R	82	032250	4ASMC02.5	134	0033784	A35025.5	167
029102	2AB10.2	82	0029541	A100S	82	032300	4ASMC03.0	134	0033791	A35026.0	167
029103	2AB10.3	82	0029558	A100T	82	032310	4ASMC03.1	134	0033807	A35026.5	167
029105	2AB10.5	82	0029565	A100U	82	032320	4ASMC03.2	134	0033814	A35027.0	167
0029107	A100N46	82	0029572	A100V	82	032330	4ASMC03.3	134	0033821	A35027.5	167
029108	2AB10.8	82	0029589	A100W	82	032340	4ASMC03.4	134	0033838	A35028.0	167
029109	2AB10.9	82	0029596	A100X	82	032350	4ASMC03.5	134	0033845	A35029.0	167
029110	2AB11.0	82	0029602	A100Y	82	032360	4ASMC03.6	134	0033852	A35030.0	167
029112	2AB11.2	82	0029619	A100Z	82	032370	4ASMC03.7	134	0033869	A35030.5	167
029113	2AB11.3	82	0029626	A16010.0	186	032400	4ASMC04.0	134	0033876	A35031.0	167
029114	2AB11.4	82	0029633	A16010.2	186	032410	4ASMC04.1	134	0033883	A35031.5	167
0029114	A100N47	82	0029640	A16010.5	186	032420	4ASMC04.2	134	0033890	A35032.0	167
029115	2AB11.5	82	0029657	A16011.0	186	032470	4ASMC04.7	134	0033906	A35033.0	167
029117	2AB11.7	82	0029664	A16011.5	186	032480	4ASMC04.8	134	0033913	A35034.0	167
029118	2AB11.8	82	0029671	A16012.0	186	032490	4ASMC04.9	134	0033920	A35035.0	167
029120	2AB12.0	82	0029688	A16013.0	186	032500	4ASMC05.0	134	0033937	A35036.0	167
029121	2AB12.1	82	0029695	A16014.0	186	032510	4ASMC05.1	134	0033944	A35037.0	167
0029121	A100N48	82	0029701	A16015.0	186	032550	4ASMC05.5	134	0033951	A35038.0	167
029122	2AB12.2	82	0029718	A16016.0	186	032570	4ASMC05.7	134	0033968	A35039.0	167
029125	2AB12.5	82	0029725	A1604.0	186	032600	4ASMC06.0	134	0033975	A35040.0	167
029127	2AB12.7	82	0029732	A1604.5	186	032640	4ASMC06.4	134	0033982	A35041.0	167
029128	2AB12.8	82	0029749	A1605.0	186	032650	4ASMC06.5	134	0033999	A35042.0	167
029129	2AB12.9	82	0029756	A1605.5	186	032680	4ASMC06.8	134	0034002	A35043.0	167
029130	2AB13.0	82	0029763	A1606.0	186	032700	4ASMC07.0	134	0034019	A35044.0	167
0029138	A100N49	82	0029770	A1606.5	186	032800	4ASMC08.0	134	0034026	A35045.0	167
0029145	A100N5	82	0029787	A1606.8	186	032850	4ASMC08.5	134	0034033	A35046.0	167

# EDP NUMBER INDEX - 0034040 - 040032

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0034040	A35047.0	167	034625	D444N25	184	0036921	A5107.3	60	0039113	A5205.1	53
0034057	A35048.0	167	034629	D444N29	184	0036938	A5107.4	60	0039120	A5205.2	53
0034071	A3505.0	167	034630	D444N30	184	0036945	A5107.5	60	0039137	A5205.3	53
0034088	A3505.5	167	034632	D444N32	184	0036952	A5107.6	60	0039144	A5205.4	53
0034101	A35050.0	167	0036174	A51010.0	60	0036969	A5107.7	60	0039151	A5205.5	53
0034118	A3506.0	167	0036181	A51010.1	60	0036976	A5107.8	60	0039168	A5205.6	53
0034125	A3506.7	167	0036198	A51010.2	60	0036983	A5107.9	60	0039175	A5205.7	53
034135	2A13.5	82	0036204	A51010.3	60	0036990	A5108.0	60	0039182	A5205.8	53
034140	2A14.0	82	0036211	A51010.4	60	0037003	A5108.1	60	0039199	A5205.9	53
034145	2A14.5	82	0036228	A51010.5	60	0037010	A5108.2	60	0039205	A5206.0	53
0034149	A3506.8	167	0036235	A51010.6	60	0037027	A5108.3	60	0039212	A5206.1	53
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0034156	A3507.0	167	0036259	A51010.8	60	0037041	A5108.5	60	0039236	A5206.3	53
0034163	A3507.5	167	0036266	A51010.9	60	0037058	A5108.6	60	0039243	A5206.4	53
0034187	A3508.0	167	0036273	A51011.0	60	0037065	A5108.7	60	0039250	A5206.5	53
0034200	A3508.4	167	0036280	A51011.1	60	0037072	A5108.8	60	0039267	A5206.6	53
0034217	A3508.5	167	0036297	A51011.2	60	0037089	A5108.9	60	0039274	A5206.7	53
0034224	A3508.75	167	0036303	A51011.3	60	0037096	A5109.0	60	0039281	A5206.8	53
0034248	A3509.0	167	0036310	A51011.4	60	0037102	A5109.1	60	0039298	A5206.9	53
0034279	A3509.5	167	0036327	A51011.5	60	0037119	A5109.2	60	0039304	A5207.0	53
0034293	A3509.8	167	0036334	A51011.6	60	0037126	A5109.3	60	0039311	A5207.1	53
034408	D4441/8	184	0036341	A51011.7	60	0037133	A5109.4	60	0039328	A5207.2	53
034409	D4449/64	184	0036358	A51011.8	60	0037140	A5109.5	60	0039335	A5207.3	53
034410	D4445/32	184	0036365	A51011.9	60	0037157	A5109.6	60	0039342	A5207.4	53
034411	D44411/64	184	0036372	A51012.0	60	0037164	A5109.7	60	0039359	A5207.5	53
034412	D4443/16	184	0036389	A51012.1	60	0037171	A5109.8	60	0039366	A5207.6	53
034413	D44413/64	184	0036396	A51012.2	60	0037188	A5109.9	60	0039373	A5207.7	53
034414	D4447/32	184	0036402	A51012.3	60	0038598	A52010.0	53	0039380	A5207.8	53
034415	D44415/64	184	0036419	A51012.4	60	0038604	A52010.1	53	0039397	A5207.9	53
034416	D4441/4	184	0036426	A51012.5	60	0038611	A52010.2	53	0039403	A5208.0	53
034417	D44417/64	184	0036433	A51012.6	60	0038628	A52010.3	53	0039410	A5208.1	53
034418	D4449/32	184	0036440	A51012.7	60	0038635	A52010.4	53	0039427	A5208.2	53
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034420	D4445/16	184	0036464	A51012.9	60	0038659	A52010.6	53	0039441	A5208.4	53
034421	D44421/64	184	0036471	A51013.0	60	0038666	A52010.7	53	0039458	A5208.5	53
034422	D44411/32	184	0036488	A51014.0	60	0038673	A52010.8	53	0039465	A5208.6	53
034423	D44423/64	184	0036495	A5103.0	60	0038680	A52010.9	53	0039472	A5208.7	53
034424	D4443/8	184	0036501	A5103.1	60	0038697	A52011.0	53	0039489	A5208.8	53
034425	D44425/64	184	0036518	A5103.2	60	0038703	A52011.1	53	0039496	A5208.9	53
034426	D44413/32	184	0036525	A5103.3	60	0038710	A52011.2	53	0039502	A5209.0	53
034427	D44427/64	184	0036532	A5103.4	60	0038727	A52011.3	53	0039519	A5209.1	53
034428	D4447/16	184	0036549	A5103.5	60	0038734	A52011.4	53	0039526	A5209.2	53
034429	D44429/64	184	0036556	A5103.6	60	0038741	A52011.5	53	0039533	A5209.3	53
034430	D44415/32	184	0036563	A5103.7	60	0038758	A52011.6	53	0039540	A5209.4	53
034431	D44431/64	184	0036570	A5103.8	60	0038765	A52011.7	53	0039557	A5209.5	53
034432	D4441/2	184	0036587	A5103.9	60	0038772	A52011.8	53	0039564	A5209.6	53
034502	D444B	184	0036594	A5104.0	60	0038789	A52011.9	53	0039571	A5209.7	53
034503	D444C	184	0036600	A5104.1	60	0038796	A52012.0	53	0039588	A5209.8	53
034505	D444E	184	0036617	A5104.2	60	0038802	A52012.1	53	0039595	A5209.9	53
034506	D444F	184	0036624	A5104.3	60	0038819	A52012.2	53	040003	R403/64	117
034507	D444G	184	0036631	A5104.4	60	0038826	A52012.3	53	040004	R401/16	117
034508	D444H	184	0036648	A5104.5	60	0038833	A52012.4	53	040005	R405/64	117
034509	D444I	184	0036655	A5104.6	60	0038840	A52012.5	53	040006	R403/32	117
034510	D444J	184	0036662	A5104.7	60	0038857	A52012.6	53	040007	R407/64	117
034511	D444K	184	0036679	A5104.8	60	0038864	A52012.7	53	040008	R401/8	117
034512	D444L	184	0036686	A5104.9	60	0038871	A52012.8	53	040009	R409/64	117
034514	D444N	184	0036693	A5105.0	60	0038888	A52012.9	53	040010	R405/32	117
034515	D444O	184	0036709	A5105.1	60	0038895	A52013.0	53	040011	R4011/64	117
034516	D444P	184	0036716	A5105.2	60	0038901	A5203.0	53	040012	R403/16	117
034517	D444Q	184	0036723	A5105.3	60	0038918	A5203.1	53	040013	R4013/64	117
034518	D444R	184	0036730	A5105.4	60	0038925	A5203.2	53	040014	R407/32	117
034519	D444S	184	0036747	A5105.5	60	0038932	A5203.3	53	040015	R4015/64	117
034520	D444T	184	0036754	A5105.6	60	0038949	A5203.4	53	040016	R401/4	117
034521	D444U	184	0036761	A5105.7	60	0038956	A5203.5	53	040017	R4017/64	117
034526	D444Z	184	0036778	A5105.8	60	0038963	A5203.6	53	040018	R409/32	117
034601	D444N1	184	0036785	A5105.9	60	0038970	A5203.7	53	040019	R4019/64	117
034603	D444N3	184	0036792	A5106.0	60	0038987	A5203.8	53	040020	R405/16	117
034607	D444N7	184	0036808	A5106.1	60	0038994	A5203.9	53	040021	R4021/64	117
034609	D444N9	184	0036815	A5106.2	60	0039007	A5204.0	53	040022	R4011/32	117
034610	D444N10	184	0036822	A5106.3	60	0039014	A5204.1	53	040023	R4023/64	117
034611	D444N11	184	0036839	A5106.4	60	0039021	A5204.2	53	040024	R403/8	117
034613	D444N13	184	0036846	A5106.5	60	0039038	A5204.3	53	040025	R4025/64	117
034614	D444N14	184	0036853	A5106.6	60	0039045	A5204.4	53	040026	R4013/32	117
034615	D444N15	184	0036860	A5106.7	60	0039052	A5204.5	53	040027	R4027/64	117
034617	D444N17	184	0036877	A5106.8	60	0039069	A5204.6	53	040028	R407/16	117
034618	D444N18	184	0036884	A5106.9	60	0039076	A5204.7	53	040029	R4029/64	117
034619	D444N19	184	0036891	A5107.0	60	0039083	A5204.8	53	040030	R4015/32	117
034620	D444N20	184	0036907	A5107.1	60	0039090	A5204.9	53	040031	R4031/64	117
034621	D444N21	184	0036914	A5107.2	60	0039106	A5205.0	53	040032	R401/2	117

# EDP NUMBER INDEX - 040033 - 0041376

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
040033	R4033/64	117	40584	R453N11	46	0040997	A53018.5	167	0041208	A53028.0	167
040034	R4017/32	117	40591	R453N10	46	041001	R41N1	117	0041215	A53028.5	167
040035	R4035/64	117	040600	R401	117	041002	R41N2	117	0041222	A53029.0	167
040036	R409/16	117	040604	R401.1/16	117	041003	R41N3	117	0041239	A53029.5	167
040037	R4037/64	117	40607	R453N9	46	041004	R41N4	117	0041246	A53030.0	167
040038	R4019/32	117	040608	R401.1/8	117	041005	R41N5	117	0041253	A53031.0	167
040039	R4039/64	117	040612	R401.3/16	117	041006	R41N6	117	0041260	A53032.0	167
040040	R405/8	117	40614	R453N8	46	041007	R41N7	117	0041277	A5308.5	167
040041	R4041/64	117	040616	R401.1/4	117	041008	R41N8	117	0041284	A5309.0	167
040042	R4021/32	117	040620	R401.5/16	117	041009	R41N9	117	41291	R453H	46
040043	R4043/64	117	40621	R453N7	46	041010	R41N10	117	041301	M41CON1	131
040044	R4011/16	117	040624	R401.3/8	117	041011	R41N11	117	041302	M41CON2	131
040304	M40CO1/16	131	040628	R401.7/16	117	041012	R41N12	117	041303	M41CON3	131
040305	M40CO5/64	131	040632	R401.1/2	117	041013	R41N13	117	041304	M41CON4	131
040306	M40CO3/32	131	040636	R401.9/16	117	041014	R41N14	117	041305	M41CON5	131
040307	M40CO7/64	131	40638	R453N6	46	041015	R41N15	117	041306	M41CON6	131
040308	M40CO1/8	131	040640	R401.5/8	117	041016	R41N16	117	041307	M41CON7	131
040309	M40CO9/64	131	040644	R401.11/16	117	0041017	A53019.0	167	0041307	R453L	46
040310	M40CO5/32	131	40645	R453N5	46	041017	R41N17	117	0041307	R453L	46
040311	M40CO11/64	131	040648	R401.3/4	117	041018	R41N18	117	041308	M41CON8	131
040312	M40CO3/16	131	040652	R401.13/16	117	041019	R41N19	117	041309	M41CON9	131
040313	M40CO13/64	131	40652	R453N4	46	041020	R41N20	117	041310	M41CON10	131
040314	M40CO7/32	131	040656	R401.7/8	117	041021	R41N21	117	041311	M41CON11	131
040315	M40CO15/64	131	040660	R401.15/16	117	041022	R41N22	117	041312	M41CON12	131
040316	M40CO1/4	131	40669	R453N3	46	041023	R41N23	117	041313	M41CON13	131
040317	M40CO17/64	131	40676	R453N2	46	0041024	A53019.5	167	041314	M41CON14	131
040318	M40CO9/32	131	40683	R453N1	46	041024	R41N24	117	41314	R453M	46
040319	M40CO19/64	131	40690	R453A	46	041025	R41N25	117	041315	M41CON15	131
040320	M40CO5/16	131	040700	R402	117	041026	R41N26	117	041316	M41CON16	131
040321	M40CO21/64	131	40706	R453D	46	041027	R41N27	117	041317	M41CON17	131
040322	M40CO11/32	131	0040713	A53010.0	167	041028	R41N28	117	041318	M41CON18	131
040323	M40CO23/64	131	0040720	A53010.2	167	041029	R41N29	117	041319	M41CON19	131
040324	M40CO3/8	131	0040737	A53010.5	167	041030	R41N30	117	041320	M41CON20	131
040325	M40CO25/64	131	0040744	A53011.0	167	041031	R41N31	117	041321	M41CON21	131
040326	M40CO13/32	131	0040751	A53011.5	167	041032	R41N32	117	41321	R453N	46
040327	M40CO27/64	131	0040768	A53011.75	167	041033	R41N33	117	041322	M41CON22	131
040328	M40CO7/16	131	0040775	A53012.0	167	041034	R41N34	117	041323	M41CON23	131
040329	M40CO29/64	131	0040799	A53012.5	167	041035	R41N35	117	041324	M41CON24	131
040330	M40CO15/32	131	040804	R40C1/16	123	041036	R41N36	117	041325	M41CON25	131
040331	M40CO31/64	131	040805	R40C5/64	123	041037	R41N37	117	041326	M41CON26	131
040332	M40CO1/2	131	040806	R40C3/32	123	041038	R41N38	117	041327	M41CON27	131
40393	R453N30	46	040807	R40C7/64	123	041039	R41N39	117	041328	M41CON28	131
40409	R453N29	46	040808	R40C1/8	123	041040	R41N40	117	041329	M41CON29	131
40416	R453N28	46	040809	R40C9/64	123	041041	R41N41	117	041330	M41CON30	131
40423	R453N27	46	040810	R40C5/32	123	041042	R41N42	117	041331	M41CON31	131
40430	R453N26	46	040811	R40C11/64	123	041043	R41N43	117	041332	M41CON32	131
40447	R453N25	46	0040812	A53013.0	167	041044	R41N44	117	041333	M41CON33	131
40454	R453N24	46	040812	R40C3/16	123	041045	R41N45	117	041334	M41CON34	131
40461	R453N23	46	040813	R40C13/64	123	041046	R41N46	117	041335	M41CON35	131
40478	R453N22	46	040814	R40C7/32	123	041047	R41N47	117	041336	M41CON36	131
40485	R453N21	46	040815	R40C15/64	123	0041048	A53020.0	167	041337	M41CON37	131
40492	R453N20	46	040816	R40C1/4	123	041048	R41N48	117	041338	M41CON38	131
40508	R453N19	46	040817	R40C17/64	123	041049	R41N49	117	41338	R453O	46
40515	R453N18	46	040818	R40C9/32	123	041050	R41N50	117	041339	M41CON39	131
40522	R453N17	46	040819	R40C19/64	123	041051	R41N51	117	041340	M41CON40	131
40539	R453N16	46	040820	R40C5/16	123	041052	R41N52	117	041341	M41CON41	131
040545	R4045/64	117	040821	R40C21/64	123	041053	R41N53	117	041342	M41CON42	131
040546	R4023/32	117	040822	R40C11/32	123	041054	R41N54	117	041343	M41CON43	131
40546	R453N15	46	040823	R40C23/64	123	0041055	A53020.5	167	041344	M41CON44	131
040547	R4047/64	117	040824	R40C3/8	123	041055	R41N55	117	041345	M41CON45	131
040548	R403/4	117	040825	R40C25/64	123	041056	R41N56	117	41345	R453Q	46
040549	R4049/64	117	040826	R40C13/32	123	041057	R41N57	117	041346	M41CON46	131
040550	R4025/32	117	040827	R40C27/64	123	041058	R41N58	117	041347	M41CON47	131
040551	R4051/64	117	040828	R40C7/16	123	041059	R41N59	117	041348	M41CON48	131
040552	R4013/16	117	0040829	A53013.5	167	041060	R41N60	117	041349	M41CON49	131
040553	R4053/64	117	040829	R40C29/64	123	0041062	A53021.0	167	041350	M41CON50	131
40553	R453N14	46	040830	R40C15/32	123	0041079	A53021.5	167	041351	M41CON51	131
040554	R4027/32	117	040831	R40C31/64	123	0041086	A53022.0	167	041352	M41CON52	131
040555	R4055/64	117	040832	R40C1/2	123	0041093	A53022.5	167	41352	R453T	46
040556	R407/8	117	0040836	A53014.0	167	0041109	A53023.0	167	041353	M41CON53	131
040557	R4057/64	117	0040850	A53014.5	167	0041116	A53023.5	167	041354	M41CON54	131
040558	R4029/32	117	0040874	A53015.0	167	0041123	A53024.0	167	041355	M41CON55	131
040559	R4059/64	117	0040881	A53015.25	167	0041130	A53024.5	167	041356	M41CON56	131
040560	R4015/16	117	0040898	A53015.5	167	0041147	A53025.0	167	041357	M41CON57	131
40560	R453N13	46	0040911	A53016.0	167	0041154	A53025.5	167	041358	M41CON58	131
040561	R4061/64	117	0040935	A53016.5	167	0041161	A53026.0	167	041359	M41CON59	131
040562	R4031/32	117	0040942	A53017.0	167	0041178	A53026.5	167	041360	M41CON60	131
040563	R4063/64	117	0040966	A53017.5	167	0041185	A53027.0	167	0041369	R453U	46
40577	R453N12	46	0040980	A53018.0	167	0041192	A53027.5	167	0041376	R453X	46

# EDP NUMBER INDEX - 0041383 - 042812

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0041383	R453Y	46	041828	R41CN28	123	042016	R42P	117	042324	M42COX	131
0041390	R453Z	46	041829	R41CN29	123	042017	R42Q	117	042325	M42COY	131
0041406	R454N30	46	041830	R41CN30	123	042018	R42R	117	042326	M42COZ	131
0041406	R454N30	46	041831	R41CN31	123	042019	R42S	117	0042328	R458N24	40
0041413	R454N29	46	041832	R41CN32	123	042020	R42T	117	0042328	R458N24	40
0041420	R454N28	46	041833	R41CN33	123	042021	R42U	117	0042335	R458N23	40
0041437	R454N27	46	0041833	R457N30	40	0042021	R457N11	40	0042335	R458N23	40
0041444	R454N26	46	0041833	R457N30	40	0042021	R457N11	40	0042342	R458N22	40
0041451	R454N25	46	041834	R41CN34	123	042022	R42V	117	0042342	R458N22	40
0041468	R454N24	46	041835	R41CN35	123	042023	R42W	117	0042359	R458N21	40
0041475	R454N23	46	041836	R41CN36	123	042024	R42X	117	0042359	R458N21	40
0041482	R454N22	46	041837	R41CN37	123	042025	R42Y	117	0042366	R458N20	40
0041499	R454N21	46	041838	R41CN38	123	042026	R42Z	117	0042366	R458N20	40
0041505	R454N20	46	041839	R41CN39	123	042038	R457N10	40	0042373	R458N19	40
0041512	R454N19	46	041840	R41CN40	123	042038	R457N10	40	0042373	R458N19	40
0041529	R454N18	46	0041840	R457N29	40	0042045	R457N9	40	0042380	R458N18	40
0041536	R454N17	46	0041840	R457N29	40	0042052	R457N8	40	0042380	R458N18	40
0041543	R454N16	46	041841	R41CN41	123	0042052	R457N8	40	0042397	R458N17	40
0041550	R454N15	46	041842	R41CN42	123	0042069	R457N7	40	0042397	R458N17	40
0041567	R454N14	46	041843	R41CN43	123	0042069	R457N7	40	0042403	R458N16	40
0041574	R454N13	46	041844	R41CN44	123	0042076	R457N6	40	0042403	R458N16	40
0041581	R454N12	46	041845	R41CN45	123	0042076	R457N6	40	0042410	R458N15	40
0041598	R454N11	46	041846	R41CN46	123	0042083	R457N5	40	0042427	R458N14	40
0041604	R454N10	46	041847	R41CN47	123	0042090	R457N4	40	0042427	R458N14	40
0041611	R454N9	46	041848	R41CN48	123	0042106	R457N3	40	0042434	R458N13	40
0041628	R454N8	46	041849	R41CN49	123	0042106	R457N3	40	0042434	R458N13	40
0041635	R454N7	46	041850	R41CN50	123	0042113	R457N2	40	0042441	R458N12	40
0041642	R454N6	46	041851	R41CN51	123	0042120	R457N1	40	0042441	R458N12	40
0041659	R454N5	46	041852	R41CN52	123	0042120	R457N1	40	0042458	R458N11	40
0041666	R454N4	46	041853	R41CN53	123	0042137	R457A	40	0042458	R458N11	40
0041673	R454N3	46	041854	R41CN54	123	0042144	R457D	40	0042465	R458N10	40
0041680	R454N2	46	041855	R41CN55	123	0042151	R457H	40	0042465	R458N10	40
0041697	R454N1	46	041856	R41CN56	123	0042168	R457L	40	0042472	R458N9	40
041701	ATR41N1	200	041857	R41CN57	123	0042175	R457M	40	0042472	R458N9	40
041702	ATR41N2	200	0041857	R457N28	40	0042182	R457N	40	0042489	R458N8	40
041703	ATR41N3	200	041858	R41CN58	123	0042199	R457O	40	0042489	R458N8	40
0041703	R454A	46	041859	R41CN59	123	0042205	R457Q	40	0042496	R458N7	40
041704	ATR41N4	200	041860	R41CN60	123	0042212	R457T	40	0042496	R458N7	40
0041710	R454D	46	0041864	R457N27	40	0042229	R457U	40	0042502	R458N6	40
0041727	R454H	46	0041864	R457N27	40	0042229	R457U	40	0042502	R458N6	40
0041727	R454H	46	0041871	R457N26	40	0042236	R457X	40	0042519	R458N5	40
0041734	R454L	46	0041888	R457N25	40	0042243	R457Y	40	0042519	R458N5	40
0041741	R454M	46	0041888	R457N25	40	0042250	R457Z	40	0042526	R458N4	40
0041758	R454N	46	0041895	R457N24	40	0042267	R458N30	40	0042526	R458N4	40
0041765	R454O	46	0041901	R457N23	40	0042267	R458N30	40	0042533	R458N3	40
0041772	R454Q	46	0041901	R457N23	40	0042274	R458N29	40	0042533	R458N3	40
0041772	R454Q	46	0041918	R457N22	40	0042274	R458N29	40	0042540	R458N2	40
0041789	R454T	46	0041918	R457N22	40	0042281	R458N28	40	0042540	R458N2	40
0041796	R454U	46	0041925	R457N21	40	0042281	R458N28	40	0042557	R458N1	40
041801	R41CN1	123	0041925	R457N21	40	0042298	R458N27	40	0042557	R458N1	40
041802	R41CN2	123	0041932	R457N20	40	0042298	R458N27	40	0042564	R458A	40
0041802	R454X	46	0041932	R457N20	40	042301	M42COA	131	0042571	R458D	40
041803	R41CN3	123	0041949	R457N19	40	042302	M42COB	131	0042588	R458H	40
041804	R41CN4	123	0041956	R457N18	40	042303	M42COC	131	0042595	R458L	40
041805	R41CN5	123	0041956	R457N18	40	042304	M42COD	131	0042601	R458M	40
041806	R41CN6	123	0041963	R457N17	40	0042304	R458N26	40	0042618	R458N	40
041807	R41CN7	123	0041970	R457N16	40	0042304	R458N26	40	0042625	R458O	40
041808	R41CN8	123	0041970	R457N16	40	042305	M42COE	131	0042632	R458Q	40
041809	R41CN9	123	0041987	R457N15	40	042305	M42COE	131	0042632	R458Q	40
041810	R41CN10	123	0041994	R457N14	40	042307	M42COG	131	0042649	R458T	40
041811	R41CN11	123	042001	R42A	117	042308	M42COH	131	0042656	R458U	40
041812	R41CN12	123	042002	R42B	117	042309	M42COI	131	0042663	R458X	40
041813	R41CN13	123	042003	R42C	117	042310	M42COJ	131	0042670	R458Y	40
041814	R41CN14	123	042004	R42D	117	042311	M42COK	131	0042687	R458Z	40
041815	R41CN15	123	042005	R42E	117	0042311	R458N25	40	0042694	R45810.8	40
041816	R41CN16	123	042006	R42F	117	0042311	R458N25	40	0042694	R45810.8	40
041817	R41CN17	123	042007	R42G	117	042312	M42COL	131	042801	R42CA	123
041818	R41CN18	123	0042007	R457N13	40	042313	M42COM	131	042802	R42CB	123
041819	R41CN19	123	042008	R42H	117	042314	M42CON	131	042803	R42CC	123
0041819	R454Y	46	042009	R42I	117	042315	M42COO	131	042804	R42CD	123
041820	R41CN20	123	042010	R42J	117	042316	M42COP	131	042805	R42CE	123
041821	R41CN21	123	042011	R42K	117	042317	M42COQ	131	042806	R42CF	123
041822	R41CN22	123	042012	R42L	117	042318	M42COR	131	042807	R42CG	123
041823	R41CN23	123	042013	R42M	117	042319	M42COS	131	042808	R42CH	123
041824	R41CN24	123	042014	R42N	117	042320	M42COT	131	042809	R42CI	123
041825	R41CN25	123	0042014	R457N12	40	042321	M42COU	131	042810	R42CJ	123
041826	R41CN26	123	0042014	R457N12	40	042322	M42COV	131	042811	R42CK	123
0041826	R454Z	46	042015	R42O	117	042323	M42COW	131	042812	R42CL	123
041827	R41CN27	123									

# EDP NUMBER INDEX - 042813 - 0048368

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
042813	R42CM	123	0046340	A9001/16	65	046900	4ASM9.0	126	0047576	A90029/64	65
042814	R42CN	123	046350	4ASM3.5	126	0046906	A90015/64	65	0047583	A90011.8	65
042815	R42CO	123	0046357	A9001.6	65	046910	4ASM9.1	126	0047590	A90015/32	65
042816	R42CP	123	0046364	A9001.7	65	0046913	A9006.0	65	0047606	A90012.0	65
042817	R42CQ	123	046370	4ASM3.7	126	046920	4ASM9.2	126	0047620	A90031/64	65
042818	R42CR	123	0046371	A9001.8	65	0046920	A9006.1	65	0047637	A90012.5	65
042819	R42CS	123	0046388	A9001.9	65	046930	4ASM9.3	126	0047644	A9001/2	65
042820	R42CT	123	0046395	A9005/64	65	0046937	A9006.2	65	0047651	A90012.8	65
042821	R42CU	123	046400	4ASM4.0	126	0046944	A9006.3	65	0047668	A90013.0	65
042822	R42CV	123	0046401	A9002.0	65	046950	4ASM9.5	126	0047675	A90013.5	65
042823	R42CW	123	0046418	A9002.1	65	0046951	A9001/4	65	0047682	A90014.0	65
042824	R42CX	123	046420	4ASM4.2	126	0046968	A9006.4	65	0047699	A90014.5	65
042825	R42CY	123	0046425	A9002.2	65	046970	4ASM9.7	126	0047705	A90015.0	65
042826	R42CZ	123	0046432	A9002.3	65	0046975	A9006.5	65	0047712	A90015.5	65
0044988	A720.15	130	0046449	A9003/32	65	0046999	A9006.6	65	0047729	A90016.0	65
0044995	A720.18	130	046450	4ASM4.5	126	047000	4ASM10.0	126	0047736	A90017.0	65
0045008	A720.2	130	0046456	A9002.4	65	047002	4ASM10.2	126	0047743	A90017.5	65
0045015	A720.22	130	0046463	A9002.5	65	0047002	A9006.7	65	0047750	A90018.0	65
0045022	A720.25	130	0046470	A9002.6	65	047005	4ASM10.5	126	0047767	A90019.0	65
0045039	A720.28	130	0046487	A9002.7	65	047008	4ASM10.8	126	0047774	A90020.0	65
0045046	A720.3	130	0046494	A9007/64	65	0047019	A90017/64	65	0047781	A9011.5	65
0045053	A720.35	130	046500	4ASM5.0	126	0047026	A9006.8	65	0047798	A9012.0	65
0045060	A720.38	130	0046500	A9002.8	65	0047033	A9006.9	65	0047804	A9012.5	65
0045077	A720.39	130	0046517	A9002.9	65	0047057	A9007.0	65	0047811	A9012.6	65
0045084	A720.4	130	0046524	A9003.0	65	0047064	A9007.1	65	0047828	A9013.0	65
0045107	A720.45	130	0046531	A9003.1	65	0047071	A9009/32	65	0047835	A9013.1	65
0045114	A720.5	130	0046548	A9001/8	65	0047088	A9007.2	65	0047842	A9013.2	65
0045121	A720.6	130	046550	4ASM5.5	126	0047095	A9007.3	65	0047859	A9013.3	65
045610	TS18N10	199	0046555	A9003.2	65	0047101	A9007.4	65	0047866	A9013.4	65
045611	TS18N11	199	0046562	A9003.3	65	047110	4ASM11.0	126	0047873	A9013.5	65
045620	TS18N20	199	046570	4ASM5.7	126	047112	4ASM11.2	126	0047880	A9013.6	65
045621	TS18N21	199	0046579	A9003.4	65	047115	4ASM11.5	126	0047897	A9013.7	65
045630	TS18N30	199	046580	4ASM5.8	126	047118	4ASM11.8	126	0047903	A9013.8	65
045640	TS18N40	199	0046586	A9003.5	65	0047118	A9007.5	65	0047910	A9013.9	65
045708	TS101/8	199	0046593	A9009/64	65	0047125	A90019/64	65	0047927	A9014.0	65
045710	TS105/32	199	046600	4ASM6.0	126	0047132	A9007.6	65	0047934	A9014.1	65
045712	TS103/16	199	0046609	A9003.6	65	0047149	A9007.7	65	0047941	A9014.2	65
045714	TS107/32	199	0046616	A9003.7	65	0047156	A9007.8	65	0047958	A9014.3	65
045716	TS101/4	199	046620	4ASM6.2	126	0047163	A9007.9	65	0047965	A9014.4	65
045810	TS41N10	199	0046623	A9003.8	65	0047170	A9005/16	65	0047972	A9014.5	65
045811	TS41N11	199	0046630	A9003.9	65	0047187	A9008.0	65	0047989	A9014.6	65
045820	TS41N20	199	046640	4ASM6.4	126	0047194	A9008.1	65	0047996	A9014.7	65
045830	TS41N30	199	0046647	A9005/32	65	047200	4ASM12.0	126	0048009	A9014.8	65
045840	TS41N40	199	046650	4ASM6.5	126	0047200	A9008.2	65	0048016	A9014.9	65
046033	M40CO33/64	131	0046654	A9004.0	65	0047217	A9008.3	65	0048023	A9015.0	65
046034	M40CO17/32	131	046660	4ASM6.6	126	047220	4ASM12.2	126	0048030	A9015.1	65
046035	M40CO35/64	131	0046661	A9004.1	65	0047224	A90021/64	65	0048047	A9015.2	65
046036	M40CO9/16	131	0046678	A9004.2	65	0047231	A9008.4	65	0048054	A9015.3	65
046037	M40CO37/64	131	046680	4ASM6.8	126	047250	4ASM12.5	126	0048061	A9015.4	65
046038	M40CO19/32	131	0046685	A9004.3	65	0047255	A9008.5	65	0048078	A9015.5	65
046039	M40CO39/64	131	046690	4ASM6.9	126	0047262	A9008.6	65	0048085	A9015.6	65
046040	M40CO5/8	131	0046692	A90011/64	65	0047286	A9008.7	65	0048092	A9015.7	65
046041	M40CO41/64	131	046700	4ASM7.0	126	0047293	A90011/32	65	0048108	A9015.8	65
046042	M40CO21/32	131	0046708	A9004.4	65	0047309	A9008.8	65	0048115	A9015.9	65
046043	M40CO43/64	131	0046715	A9004.5	65	0047316	A9008.9	65	0048122	A9016.0	65
046044	M40CO11/16	131	046720	4ASM7.2	126	0047323	A9009.0	65	0048139	A9016.1	65
046045	M40CO45/64	131	0046722	A9004.6	65	0047330	A9009.1	65	0048146	A9016.2	65
046046	M40CO23/32	131	0046739	A9004.7	65	0047347	A90023/64	65	0048153	A9016.3	65
046047	M40CO47/64	131	0046746	A9003/16	65	0047354	A9009.2	65	0048160	A9016.4	65
046048	M40CO3/4	131	046750	4ASM7.5	126	0047361	A9009.3	65	0048177	A9016.5	65
046100	4ASM1.0	126	0046753	A9004.8	65	0047378	A9009.4	65	0048184	A9016.6	65
046125	4ASM1.25	126	0046760	A9004.9	65	0047385	A9009.5	65	0048191	A9016.7	65
046130	4ASM1.3	126	0046777	A9005.0	65	0047392	A9003/8	65	0048207	A9016.8	65
046165	4ASM1.65	126	0046784	A9005.1	65	0047408	A9009.6	65	0048214	A9016.9	65
046200	4ASM2.0	126	046800	4ASM8.0	126	0047415	A9009.7	65	0048221	A9017.0	65
046230	4ASM2.3	126	0046807	A90013/64	65	0047422	A9009.8	65	0048238	A9017.1	65
046240	4ASM2.4	126	046810	4ASM8.1	126	0047439	A9009.9	65	0048245	A9017.2	65
046250	4ASM2.5	126	0046814	A9005.2	65	0047446	A90025/64	65	0048252	A9017.3	65
0046289	A9001.0	65	0046821	A9005.3	65	0047453	A90010.0	65	0048269	A9017.4	65
0046296	A9001.1	65	0046838	A9005.4	65	0047460	A90010.2	65	0048276	A9017.5	65
046300	4ASM3.0	126	046840	4ASM8.4	126	0047477	A90010.3	65	0048283	A9017.6	65
0046302	A9001.2	65	0046845	A9005.5	65	0047484	A90013/32	65	0048290	A9017.7	65
046310	4ASM3.1	126	046850	4ASM8.5	126	0047491	A90010.4	65	0048306	A9017.8	65
0046319	A9001.3	65	0046852	A9007/32	65	0047507	A90010.5	65	0048313	A9017.9	65
046320	4ASM3.2	126	0046869	A9005.6	65	0047514	A90027/64	65	0048320	A9018.0	65
0046326	A9001.4	65	046870	4ASM8.7	126	0047521	A90010.8	65	0048337	A9018.1	65
046330	4ASM3.3	126	0046876	A9005.7	65	0047538	A90011.0	65	0048344	A9018.2	65
0046333	A9001.5	65	0046883	A9005.8	65	0047545	A9007/16	65	0048351	A9018.3	65
046340	4ASM3.4	126	0046890	A9005.9	65	0047569	A90011.5	65	0048368	A9018.4	65

# EDP NUMBER INDEX - 0048375 - 0051092

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0048375	A9018.5	65	0049280	A90111.5	65	050320	QC91GM12.0	144	050951	QC91GN51	142
0048382	A9018.6	65	0049297	A90111.8	65	0050323	A9201.4	56	050952	QC91GN52	142
0048399	A9018.7	65	0049303	A90112.0	65	050325	QC91GM12.5	144	0050958	A9203.7	56
0048405	A9018.8	65	0049594	A90112.5	65	0050347	A9201.5	56	0050965	A9203.8	56
0048412	A9018.9	65	0049600	A90112.8	65	0050392	B1701.51	442	0050972	A9203.9	56
0048429	A9019.0	65	0049617	B15710.0	452	0050491	B1703.01	442	0050989	A9205/32	56
0048436	A9019.1	65	0049624	B15711.0	452	0050590	B1708.51	442	051001	R511/64	135
0048443	A9019.2	65	0049631	B15712.0	452	0050644	A9201/16	56	051002	R511/32	135
0048450	A9019.3	65	0049648	B1572.0	452	0050668	A9201.6	56	051003	R513/64	135
0048467	A9019.4	65	0049655	A90113.0	65	0050675	A9201.7	56	051004	R511/16	135
0048474	A9019.5	65	0049662	A90113.5	65	0050682	A9201.8	56	051005	R515/64	135
0048481	A9019.6	65	0049679	B1574.0	452	0050699	A9201.9	56	051006	R513/32	135
0048498	A9019.7	65	0049686	A90114.0	65	0050705	A9205/64	56	051007	R517/64	135
0048504	A9019.8	65	0049693	B1575.0	452	0050712	A9202.0	56	051008	R511/8	135
0048511	B10010.0	468	0049709	A90114.5	65	0050729	A9202.1	56	0051009	A9204.0	56
0048528	B10011.0	468	0049716	B1576.0	452	0050743	A9202.2	56	051009	R519/64	135
0048535	B10012.0	468	0049723	A90115.0	65	0050750	A9202.3	56	051010	R515/32	135
0048542	B10013.0	468	0049730	B1577.0	452	0050767	A9203/32	56	051011	R5111/64	135
0048559	B10014.0	468	0049747	B1578.0	452	0050781	A9202.4	56	051012	R513/16	135
0048566	B10015.0	468	0049754	B1579.0	452	0050804	A9202.5	56	051013	R5113/64	135
0048573	B10016.0	468	050015	QC91PM1.5	144	0050811	A9202.6	56	051014	R517/32	135
0048580	B10017.0	468	050020	QC91PM2.0	144	0050828	A9202.7	56	051015	R5115/64	135
0048597	B10018.0	468	050025	QC91PM2.5	144	0050835	A9207/64	56	0051016	A9204.1	56
0048603	B10019.0	468	050030	QC91PM3.0	144	0050842	A9202.8	56	051016	R511/4	135
0048610	B1002.0	468	050035	QC91PM3.5	144	0050859	A9202.9	56	051017	R5117/64	135
0048627	A9019.9	65	050040	QC91PM4.0	144	0050866	A9203.0	56	051018	R519/32	135
0048634	B1002.5	468	050045	QC91PM4.5	144	0050873	A9203.1	56	051019	R5119/64	135
0048641	A90110.0	65	050050	QC91PM5.0	144	0050880	A9201/8	56	051020	R515/16	135
0048658	B10020.0	468	050052	QC91PM5.2	144	0050897	A9203.2	56	051021	R5121/64	135
0048665	B10022.0	468	050055	QC91PM5.5	144	050902	QC91GN2	142	051022	R5111/32	135
0048672	B10024.0	468	050060	QC91PM6.0	144	0050903	A9203.3	56	0051023	A9204.2	56
0048689	B10025.0	468	050065	QC91PM6.5	144	050903	QC91GN3	142	051023	R5123/64	135
0048696	B10026.0	468	050068	QC91PM6.8	144	050904	QC91GN4	142	051024	R513/8	135
0048702	B10028.0	468	050070	QC91PM7.0	144	050905	QC91GN5	142	051025	R5125/64	135
0048719	B1003.0	468	050080	QC91PM8.0	144	050906	QC91GN6	142	051026	R5113/32	135
0048726	B1003.2	468	050082	QC91PM8.2	144	050907	QC91GN7	142	051027	R5127/64	135
0048733	B1003.5	468	050085	QC91PM8.5	144	050908	QC91GN8	142	051028	R517/16	135
0048740	B10030.0	468	050086	QC91PM8.6	144	050909	QC91GN9	142	051029	R5129/64	135
0048757	B10032.0	468	050090	QC91PM9.0	144	0050910	A9203.4	56	0051030	A9204.3	56
0048764	B10034.0	468	050095	QC91PM9.5	144	050911	QC91GN11	142	051030	R5115/32	135
0048771	B10035.0	468	050100	QC91PM10.0	144	050912	QC91GN12	142	051031	R5131/64	135
0048788	B10036.0	468	050105	QC91PM10.5	144	050913	QC91GN13	142	051032	R511/2	135
0048795	B10038.0	468	050110	QC91PM11.0	144	050914	QC91GN14	142	051033	R5133/64	135
0048801	B1004.0	468	050115	QC91PM11.5	144	050915	QC91GN15	142	051034	R5117/32	135
0048818	B1004.5	468	050120	QC91PM12.0	144	050916	QC91GN16	142	051035	R5135/64	135
0048825	B10040.0	468	050125	QC91PM12.5	144	050917	QC91GN17	142	051036	R519/16	135
0048856	B10045.0	468	050130	QC91PM13.0	144	050918	QC91GN18	142	051037	R5137/64	135
0048863	A90110.2	65	0050132	A90115.5	65	050919	QC91GN19	142	051038	R5119/32	135
0048870	A90110.3	65	050135	QC91PM13.5	144	050920	QC91GN20	142	051039	R5139/64	135
0048887	B1005.0	468	050140	QC91PM14.0	144	050921	QC91GN21	142	051040	R515/8	135
0048894	B1005.5	468	050150	QC91PM15.0	144	050923	QC91GN23	142	051041	R5141/64	135
0048900	B10050.0	468	050155	QC91PM15.5	144	050924	QC91GN24	142	051042	R5121/32	135
0048917	B1006.0	468	050160	QC91PM16.0	144	050925	QC91GN25	142	051043	R5143/64	135
0048924	B1007.0	468	050165	QC91PM16.5	144	050926	QC91GN26	142	051044	R5111/16	135
0048931	B1008.0	468	0050170	A90116.0	65	0050927	A9203.5	56	051045	R5145/64	135
0048948	B1009.0	468	050170	QC91PM17.0	144	050928	QC91GN28	142	051046	R5123/32	135
0048955	A90110.4	65	050215	QC91GM1.5	144	050929	QC91GN29	142	0051047	A92011/64	56
0049013	A90110.5	65	0050217	A9201.0	56	050930	QC91GN30	142	051047	R5147/64	135
0049020	B12110.0	459	050220	QC91GM2.0	144	050931	QC91GN31	142	051048	R513/4	135
0049037	B12111.0	459	050225	QC91GM2.5	144	050932	QC91GN32	142	051049	R5149/64	135
0049044	B12112.0	459	050230	QC91GM3.0	144	0050934	A9209/64	56	051050	R5125/32	135
0049051	B12113.0	459	050235	QC91GM3.5	144	050934	QC91GN34	142	051051	R5151/64	135
0049068	B12114.0	459	050240	QC91GM4.0	144	050935	QC91GN35	142	051052	R5113/16	135
0049075	B12115.0	459	050245	QC91GM4.5	144	050936	QC91GN36	142	051053	R5153/64	135
0049082	B12116.0	459	050250	QC91GM5.0	144	050937	QC91GN37	142	0051054	A9204.4	56
0049099	B12117.0	459	050252	QC91GM5.2	144	050938	QC91GN38	142	051054	R5127/32	135
0049105	B12118.0	459	050255	QC91GM5.5	144	050939	QC91GN39	142	051055	R5155/64	135
0049112	B12119.0	459	050260	QC91GM6.0	144	050940	QC91GN40	142	051056	R517/8	135
0049129	B12120.0	459	0050262	A9201.1	56	0050941	A9203.6	56	051057	R5157/64	135
0049136	B12121.0	459	050265	QC91GM6.5	144	050941	QC91GN41	142	051058	R5129/32	135
0049143	B12122.0	459	050270	QC91GM7.0	144	050942	QC91GN42	142	051059	R5159/64	135
0049150	B12123.0	459	050280	QC91GM8.0	144	050943	QC91GN43	142	051060	R5115/16	135
0049167	B12124.0	459	050285	QC91GM8.5	144	050944	QC91GN44	142	0051061	A9204.5	56
0049174	B12125.0	459	050286	QC91GM8.6	144	050945	QC91GN45	142	051061	R5161/64	135
0049181	B12126.0	459	050290	QC91GM9.0	144	050946	QC91GN46	142	051062	R5131/32	135
0049198	A90110.8	65	050300	QC91GM10.0	144	050947	QC91GN47	142	051063	R5163/64	135
0049211	B12130.0	459	050305	QC91GM10.5	144	050948	QC91GN48	142	0051078	A9204.6	56
0049235	A90111.0	65	0050309	A9201.2	56	050949	QC91GN49	142	0051085	A9204.7	56
0049242	A90111.2	65	0050316	A9201.3	56	050950	QC91GN50	142	0051092	A9203/16	56



# EDP NUMBER INDEX - 051100 - 052313

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
051100	R511	135	051337	M51CO37/64	145	0051627	A92021/64	56	052041	R52N41	135
051101	R511.1/64	135	051338	M51CO19/32	145	0051634	A9208.4	56	052042	R52N42	135
051102	R511.1/32	135	051339	M51CO39/64	145	0051658	A9208.5	56	052043	R52N43	135
051103	R511.3/64	135	051340	M51CO5/8	145	0051665	A9208.6	56	0052044	A9201/2	56
051104	R511.1/16	135	051341	M51CO41/64	145	0051672	A9208.7	56	052044	R52N44	135
051105	R511.5/64	135	051342	M51CO21/32	145	0051689	A92011/32	56	052045	R52N45	135
051106	R511.3/32	135	051343	M51CO43/64	145	0051702	A9208.8	56	052046	R52N46	135
051107	R511.7/64	135	0051344	A9206.6	56	0051719	A9208.9	56	052047	R52N47	135
0051108	A9204.8	56	051344	M51CO11/16	145	0051726	A9209.0	56	052048	R52N48	135
051108	R511.1/8	135	051345	M51CO45/64	145	0051733	A9209.1	56	052049	R52N49	135
051109	R511.9/64	135	051346	M51CO23/32	145	0051740	A92023/64	56	052050	R52N50	135
051114	R511.7/32	135	051347	M51CO47/64	145	0051757	A9209.2	56	052051	R52N51	135
051111	R511.11/64	135	051348	M51CO3/4	145	0051764	A9209.3	56	052052	R52N52	135
051112	R511.3/16	135	051349	M51CO49/64	145	0051771	A9209.4	56	052053	R52N53	135
051113	R511.13/64	135	051350	M51CO25/32	145	0051788	A9209.5	56	052054	R52N54	135
051114	R511.7/32	135	0051351	A9206.7	56	0051795	A9203/8	56	052055	R52N55	135
0051115	A9204.9	56	051351	M51CO51/64	145	0051801	A9209.6	56	052056	R52N56	135
051115	R511.15/64	135	051352	M51CO13/16	145	0051818	A9209.7	56	052057	R52N57	135
051116	R511.1/4	135	051353	M51CO53/64	145	0051825	A9209.8	56	052058	R52N58	135
051120	R511.5/16	135	051354	M51CO27/32	145	0051832	A9209.9	56	052059	R52N59	135
0051122	A9205.0	56	051355	M51CO55/64	145	0051849	A92025/64	56	052060	R52N60	135
051124	R511.3/8	135	051356	M51CO7/8	145	0051856	A92010.0	56	052061	R52N61	135
0051128	R511.7/16	135	051357	M51CO57/64	145	0051863	A92010.2	56	052062	R52N62	135
051132	R511.1/2	135	051358	M51CO29/32	145	0051870	A92010.3	56	052063	R52N63	135
051136	R511.9/16	135	051359	M51CO59/64	145	0051887	A92013/32	56	052064	R52N64	135
0051139	A9205.1	56	051360	M51CO15/16	145	0051894	A92010.4	56	052065	R52N65	135
051140	R511.5/8	135	051361	M51CO61/64	145	0051900	A92010.5	56	052066	R52N66	135
0051146	A92013/64	56	051362	M51CO31/32	145	0051917	A92027/64	56	052067	R52N67	135
051148	R511.3/4	135	051363	M51CO63/64	145	0051924	A92010.8	56	0052068	A92013.0	56
0051153	A9205.2	56	051364	M51CO1	145	0051931	A92011.0	56	052068	R52N68	135
0051160	A9205.3	56	0051368	A92017/64	56	0051948	A9207/16	56	052069	R52N69	135
0051177	A9205.4	56	0051375	A9206.8	56	0051962	A92011.5	56	052070	R52N70	135
0051191	A9205.5	56	0051382	A9206.9	56	0051979	A92029/64	56	052071	R52N71	135
0051207	A9207/32	56	0051429	A9207.0	56	0051986	A92011.8	56	052072	R52N72	135
0051214	A9205.6	56	0051436	A9207.1	56	0051993	A92015/32	56	052073	R52N73	135
0051221	A9205.7	56	0051443	A9209/32	56	052001	R52N1	135	052074	R52N74	135
0051238	A9205.8	56	0051450	A9207.2	56	052002	R52N2	135	0052075	A92013.5	56
0051245	A9205.9	56	0051467	A9207.3	56	052003	R52N3	135	052075	R52N75	135
0051269	A92015/64	56	0051474	A9207.4	56	052004	R52N4	135	052076	R52N76	135
0051276	A9206.0	56	0051481	A9207.5	56	052005	R52N5	135	052077	R52N77	135
0051283	A9206.1	56	0051498	A92019/64	56	0052006	A92012.0	56	052078	R52N78	135
0051290	A9206.2	56	0051504	A9207.6	56	052006	R52N6	135	052079	R52N79	135
051304	M51CO1/16	145	051504	R51FS1/16	141	052007	R52N7	135	052080	R52N80	135
051305	M51CO5/64	145	051505	R51FS5/64	141	052008	R52N8	135	0052082	A92014.0	56
0051306	A9206.3	56	051506	R51FS3/32	141	052009	R52N9	135	0052099	A92014.5	56
051306	M51CO3/32	145	051507	R51FS7/64	141	052010	R52N10	135	052105	A92015.0	56
051307	M51CO7/64	145	051508	R51FS1/8	141	052011	R52N11	135	0052112	A92015.5	56
051308	M51CO1/8	145	051509	R51FS9/64	141	052012	R52N12	135	0052129	A92016.0	56
051309	M51CO9/64	145	051510	R51FS5/32	141	0052013	A92012.2	56	0052136	A92017.0	56
051310	M51CO5/32	145	0051511	A9207.7	56	052013	R52N13	135	052143	A92017.5	56
051311	M51CO11/64	145	051511	R51FS11/64	141	052014	R52N14	135	0052150	B3340	463
051312	M51CO3/16	145	051512	R51FS3/16	141	052015	R52N15	135	0052167	B3340	463
0051313	A9201/4	56	051513	R51FS13/64	141	052016	R52N16	135	0052174	B334000	463
051313	M51CO13/64	145	051514	R51FS7/32	141	052017	R52N17	135	0052181	B3341	463
051314	M51CO7/32	145	051515	R51FS15/64	141	052018	R52N18	135	0052198	B33410	463
051315	M51CO15/64	145	051516	R51FS1/4	141	052019	R52N19	135	0052204	B33411	463
051316	M51CO1/4	145	051517	R51FS17/64	141	0052020	A92031/64	56	0052211	B33412	463
051317	M51CO17/64	145	051518	R51FS9/32	141	052020	R52N20	135	0052228	B3342	463
051318	M51CO9/32	145	051519	R51FS19/64	141	052021	R52N21	135	0052235	B3343	463
051319	M51CO19/64	145	051520	R51FS5/16	141	052022	R52N22	135	0052242	B3344	463
0051320	A9206.4	56	051521	R51FS21/64	141	052023	R52N23	135	0052259	B3345	463
051320	M51CO5/16	145	051522	R51FS11/32	141	052024	R52N24	135	0052266	B3346	463
051321	M51CO21/64	145	051523	R51FS23/64	141	052025	R52N25	135	0052273	B3347	463
051322	M51CO11/32	145	051524	R51FS3/8	141	052026	R52N26	135	0052280	B3348	463
051323	M51CO23/64	145	051525	R51FS25/64	141	052027	R52N27	135	0052297	B3349	463
051324	M51CO3/8	145	051526	R51FS13/32	141	052028	R52N28	135	052301	M52CON1	145
051325	M51CO25/64	145	051527	R51FS27/64	141	052029	R52N29	135	052302	M52CON2	145
051326	M51CO13/32	145	0051528	A9207.8	56	052030	R52N30	135	0052303	B3350BLADES	464
051327	M51CO27/64	145	051528	R51FS7/16	141	052031	R52N31	135	052303	M52CON3	145
051328	M51CO7/16	145	051529	R51FS29/64	141	052032	R52N32	135	052304	M52CON4	145
051329	M51CO29/64	145	051530	R51FS15/32	141	052033	R52N33	135	052305	M52CON5	145
051330	M51CO15/32	145	051531	R51FS31/64	141	052034	R52N34	135	052307	M52CON7	145
051331	M51CO31/64	145	051532	R51FS1/2	141	052035	R52N35	135	052308	M52CON8	145
051332	M51CO1/2	145	0051535	A9207.9	56	052036	R52N36	135	052309	M52CON9	145
051333	M51CO33/64	145	0051542	A9205/16	56	0052037	A92012.5	56	0052310	B33500BLADES	464
051334	M51CO17/32	145	0051566	A9208.0	56	052037	R52N37	135	052310	M52CON10	145
051335	M51CO35/64	145	0051580	A9208.1	56	052038	R52N38	135	052311	M52CON11	145
051336	M51CO9/16	145	0051603	A9208.2	56	052039	R52N39	135	052312	M52CON12	145
0051337	A9206.5	56	0051610	A9208.3	56	052040	R52N40	135	052313	M52CON13	145

# EDP NUMBER INDEX - 052314 - 0055625

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
052314	M52CON14	145	0052747	A9215.4	56	0053423	A92110.3	56	053746	CO501-6N46	162
052315	M52CON15	145	0052754	A9215.5	56	0053430	A92110.4	56	053747	CO501-6N47	162
052316	M52CON16	145	0052761	A9215.6	56	0053447	A92110.5	56	053748	CO501-6N48	162
052317	M52CON17	145	0052778	A9215.7	56	0053454	A92110.8	56	053749	CO501-6N49	162
052318	M52CON18	145	0052785	A9215.8	56	0053461	A92111.0	56	053750	CO501-6N50	162
052319	M52CON19	145	0052792	A9215.9	56	0053478	A92111.2	56	0053751	A9401.4	68
052320	M52CON20	145	052802	CO501-12N2	162	0053485	A92111.5	56	053751	CO501-6N51	162
052321	M52CON21	145	0052808	A9216.0	56	0053492	A92111.8	56	053752	CO501-6N52	162
052322	M52CON22	145	052810	CO501-12N10	162	0053508	A92112.0	56	0053768	A9401.5	68
052324	M52CON24	145	052811	CO501-12N11	162	0053522	A92112.5	56	0053775	A9401/16	68
052325	M52CON25	145	0052815	A9216.1	56	0053546	A92113.0	56	0054253	A9401.6	68
052326	M52CON26	145	052816	CO501-12N16	162	0053553	A92113.5	56	0054260	A9401.7	68
0052327	B335000BLADES	464	052819	CO501-12N19	162	0053560	A92114.0	56	0054383	A9401.8	68
052327	M52CON27	145	052820	CO501-12N20	162	0053577	A92114.5	56	0054390	A9401.9	68
052328	M52CON28	145	052821	CO501-12N21	162	0053584	A92115.0	56	0054406	A9405/64	68
052329	M52CON29	145	0052822	A9216.2	56	0053591	A92115.5	56	0054604	A9402.0	68
052330	M52CON30	145	052827	CO501-12N27	162	053604	CO500-61/16	162	0054611	A9402.1	68
052331	M52CON31	145	052829	CO501-12N29	162	053605	CO500-65/64	162	0054628	A9402.2	68
052332	M52CON32	145	052830	CO501-12N30	162	053606	CO500-63/32	162	0054710	A9402.3	68
052333	M52CON33	145	0052839	A9216.3	56	0053607	A92116.0	56	0054727	A9403/32	68
0052334	B3351BLADES	464	052840	CO501-12N40	162	053607	CO500-67/64	162	0054734	A9402.4	68
052334	M52CON34	145	0052846	A9216.4	56	053608	CO500-61/8	162	0054789	A9402.5	68
052335	M52CON35	145	0052853	A9216.5	56	053609	CO500-69/64	162	0054796	A9402.6	68
052336	M52CON36	145	0052860	A9216.6	56	053610	CO500-65/32	162	0054802	A9402.7	68
052339	M52CON39	145	0052877	A9216.7	56	053611	CO500-611/64	162	0054833	A9407/64	68
052340	M52CON40	145	0052884	A9216.8	56	053612	CO500-63/16	162	0054840	A9402.8	68
0052341	B33510BLADES	464	0052891	A9216.9	56	053613	CO500-613/64	162	0054857	A9402.9	68
0052358	B33511BLADES	464	0052907	A9217.0	56	0053614	A9401.0	68	0054871	A9403.0	68
0052365	B33512BLADES	464	0052914	A9217.1	56	053614	CO500-67/32	162	055001	R55A	135
0052372	B3352BLADES	464	0052921	A9217.2	56	053615	CO500-615/64	162	055002	R55B	135
0052389	B3353BLADES	464	0052938	A9217.3	56	053616	CO500-61/4	162	055003	R55C	135
0052396	B3354BLADES	464	0052945	A9217.4	56	0053621	A9401.1	68	055004	R55D	135
0052402	B3355BLADES	464	0052952	A9217.5	56	0053638	A9401.2	68	055005	R55E	135
0052419	B3356BLADES	464	0052969	A9217.6	56	0053645	A9401.3	68	055006	R55F	135
0052426	B3357BLADES	464	0052976	A9217.7	56	053701	CO501-6N1	162	055007	R55G	135
0052433	B3358BLADES	464	0052983	B4001.0	437	053702	CO501-6N2	162	055008	R55H	135
0052440	B3359BLADES	464	0052990	B4001.2	437	053703	CO501-6N3	162	055009	R55I	135
0052457	A92018.0	56	0053003	B4001.4	437	053704	CO501-6N4	162	055010	R55J	135
0052464	A92019.0	56	0053010	B4001.5	437	053705	CO501-6N5	162	055011	R55K	135
0052471	A92020.0	56	0053027	B4001.6	437	053706	CO501-6N6	162	055012	R55L	135
0052488	A9212.5	56	0053034	B4001.8	437	053707	CO501-6N7	162	055013	R55M	135
0052495	A9212.6	56	0053041	B4002.0	437	053708	CO501-6N8	162	055014	R55N	135
0052501	A9213.0	56	0053058	B4002.2	437	053709	CO501-6N9	162	055015	R55O	135
0052518	A9213.1	56	0053065	B4002.5	437	053710	CO501-6N10	162	055016	R55P	135
0052525	A9213.2	56	0053072	B4002.8	437	053711	CO501-6N11	162	055017	R55Q	135
0052532	A9213.3	56	0053089	A9217.8	56	053712	CO501-6N12	162	055018	R55R	135
0052549	A9213.4	56	0053096	A9217.9	56	053713	CO501-6N13	162	055019	R55S	135
0052556	A9213.5	56	0053102	A9218.0	56	053714	CO501-6N14	162	055020	R55T	135
0052563	A9213.6	56	0053119	A9218.1	56	053715	CO501-6N15	162	055021	R55U	135
0052570	A9213.7	56	0053126	B41110.0	439	053716	CO501-6N16	162	055022	R55V	135
0052587	A9213.8	56	0053133	A9218.2	56	053717	CO501-6N17	162	055023	R55W	135
0052594	A9213.9	56	0053140	B41112.0	439	053718	CO501-6N18	162	055024	R55X	135
0052600	A9214.0	56	0053157	A9218.3	56	053719	CO501-6N19	162	055025	R55Y	135
052604	CO500-121/16	162	0053164	B41114.0	439	053720	CO501-6N20	162	055026	R55Z	135
052605	CO500-125/64	162	0053171	B41115.0	439	053721	CO501-6N21	162	0055465	A9403.1	68
052606	CO500-123/32	162	0053188	B41116.0	439	053722	CO501-6N22	162	0055472	A9401/8	68
052607	CO500-127/64	162	0053195	B4115.0	439	053723	CO501-6N23	162	0055533	A9403.2	68
052608	CO500-121/8	162	0053201	B4116.0	439	053724	CO501-6N24	162	0055540	A9403.3	68
052609	CO500-129/64	162	0053218	B4117.0	439	053725	CO501-6N25	162	0055588	A9403.4	68
052610	CO500-125/32	162	0053225	B4118.0	439	053726	CO501-6N26	162	0055595	A9403.5	68
052611	CO500-1211/64	162	0053232	B4119.0	439	053727	CO501-6N27	162	055608	QC0860P1/8	154
052612	CO500-123/16	162	0053249	A9218.4	56	053728	CO501-6N28	162	055609	QC0860P9/64	154
052613	CO500-1213/64	162	0053256	A9218.5	56	053729	CO501-6N29	162	055610	QC0860P5/32	154
052614	CO500-127/32	162	0053263	A9218.6	56	053730	CO501-6N30	162	055611	QC0860P11/64	154
052615	CO500-1215/64	162	0053270	A9218.7	56	053731	CO501-6N31	162	055612	QC0860P3/16	154
052616	CO500-121/4	162	0053287	A9218.8	56	053732	CO501-6N32	162	055613	QC0860P13/64	154
0052617	A9214.1	56	0053294	A9218.9	56	053733	CO501-6N33	162	055614	QC0860P7/32	154
0052624	A9214.2	56	0053300	A9219.0	56	053734	CO501-6N34	162	055615	QC0860P15/64	154
0052631	A9214.3	56	0053317	A9219.1	56	053735	CO501-6N35	162	055616	QC0860P1/4	154
0052648	A9214.4	56	0053324	A9219.2	56	053736	CO501-6N36	162	055617	QC0860P17/64	154
0052655	A9214.5	56	0053331	A9219.3	56	053737	CO501-6N37	162	0055618	A9409/64	68
0052662	A9214.6	56	0053348	A9219.4	56	053738	CO501-6N38	162	055618	QC0860P9/32	154
0052679	A9214.7	56	0053355	A9219.5	56	053739	CO501-6N39	162	055619	QC0860P19/64	154
0052686	A9214.8	56	0053362	A9219.6	56	053740	CO501-6N40	162	055620	QC0860P5/16	154
0052693	A9214.9	56	0053379	A9219.7	56	053741	CO501-6N41	162	055621	QC0860P21/64	154
0052709	A9215.0	56	0053386	A9219.8	56	053742	CO501-6N42	162	055622	QC0860P11/32	154
0052716	A9215.1	56	0053393	A9219.9	56	053743	CO501-6N43	162	055623	QC0860P23/64	154
0052723	A9215.2	56	0053409	A92110.0	56	053744	CO501-6N44	162	055624	QC0860P3/8	154
0052730	A9215.3	56	0053416	A92110.2	56	053745	CO501-6N45	162	0055625	A9403.6	68

# EDP NUMBER INDEX - 055625 - 0058206

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
055625	QC0860P25/64	154	056460	5ATL4.6	139	057418	08609/32	147	058027	500-627/64	157
055626	QC0860P13/32	154	056480	5ATL4.8	139	057420	08605/16	147	058028	500-67/16	157
055627	QC0860P27/64	154	056500	5ATL5.0	139	057422	086011/32	147	058029	500-629/64	157
055628	QC0860P7/16	154	056550	5ATL5.5	139	057424	08603/8	147	058030	500-615/32	157
055629	QC0860P29/64	154	056560	5ATL5.6	139	057426	086013/32	147	058031	500-631/64	157
055630	QC0860P15/32	154	0056561	A9404.8	68	057428	08607/16	147	058032	500-61/2	157
055631	QC0860P31/64	154	056570	5ATL5.7	139	057430	086015/32	147	058101	501-6N1	157
0055632	A9403.7	68	056600	5ATL6.0	139	057432	08601/2	147	058102	501-6N2	157
055632	QC0860P1/2	154	0056615	A9404.9	68	0057780	A9405.5	68	058103	501-6N3	157
055904	QC91G1/16	142	056640	5ATL6.4	139	0057797	A9407/32	68	058104	501-6N4	157
055905	QC91G5/64	142	0056646	A9405.0	68	0057810	A9405.6	68	058105	501-6N5	157
055906	QC91G3/32	142	056650	5ATL6.5	139	0057827	A9405.7	68	058106	501-6N6	157
055907	QC91G7/64	142	056680	5ATL6.8	139	0057834	A9405.8	68	058107	501-6N7	157
055908	QC91G1/8	142	056720	5ATL7.2	139	0057841	A9405.9	68	058108	501-6N8	157
055909	QC91G9/64	142	056750	5ATL7.5	139	0057858	A94015/64	68	058109	501-6N9	157
055910	QC91G5/32	142	056770	5ATL7.0	139	0057865	A9406.0	68	058110	501-6N10	157
055911	QC91G11/64	142	056780	5ATL7.8	139	0057872	A9406.1	68	058111	501-6N11	157
055912	QC91G3/16	142	056800	5ATL8.0	139	057904	QC91P1/16	142	058112	501-6N12	157
055913	QC91G13/64	142	056820	5ATL8.2	139	057905	QC91P5/64	142	058113	501-6N13	157
055914	QC91G7/32	142	0056820	A9405.1	68	057906	QC91P3/32	142	058114	501-6N14	157
055915	QC91G15/64	142	056850	5ATL8.5	139	057907	QC91P7/64	142	058115	501-6N15	157
055916	QC91G1/4	142	0056882	A94013/64	68	057908	QC91P1/8	142	058116	501-6N16	157
055917	QC91G17/64	142	056900	5ATL9.0	139	057909	QC91P9/64	142	058117	501-6N17	157
055918	QC91G9/32	142	056920	5ATL9.2	139	057910	QC91P5/32	142	058118	501-6N18	157
055919	QC91G19/64	142	056950	5ATL9.5	139	057911	QC91P11/64	142	058119	501-6N19	157
055920	QC91G5/16	142	0056974	A9405.2	68	057912	QC91P3/16	142	058120	501-6N20	157
055921	QC91G21/64	142	056980	5ATL9.8	139	057913	QC91P13/64	142	058121	501-6N21	157
055922	QC91G11/32	142	0057001	A9405.3	68	057914	QC91P7/32	142	058122	501-6N22	157
055924	QC91G3/8	142	0057056	A9405.4	68	057915	QC91P15/64	142	058123	501-6N23	157
055925	QC91G25/64	142	057100	5ATL10.0	139	057916	QC91P1/4	142	058124	501-6N24	157
055926	QC91G13/32	142	057102	5ATL10.2	139	057917	QC91P17/64	142	058125	501-6N25	157
055927	QC91G27/64	142	057105	5ATL10.5	139	057918	QC91P9/32	142	058126	501-6N26	157
055928	QC91G7/16	142	057110	5ATL11.0	139	057919	QC91P19/64	142	058127	501-6N27	157
055929	QC91G29/64	142	057112	5ATL11.2	139	057920	QC91P5/16	142	058128	501-6N28	157
055931	QC91G31/64	142	057115	5ATL11.5	139	057921	QC91P21/64	142	058129	501-6N29	157
055932	QC91G1/2	142	057120	5ATL12.0	139	057922	QC91P11/32	142	058130	501-6N30	157
0056011	A9403.8	68	057125	5ATL12.5	139	057923	QC91P23/64	142	058131	501-6N31	157
0056028	A9403.9	68	057130	5ATL13.0	139	057924	QC91P3/8	142	058132	501-6N32	157
056100	5ATL1.0	139	057135	5ATL13.5	139	057925	QC91P25/64	142	058133	501-6N33	157
056120	5ATL1.2	139	057138	5ATL13.8	139	057926	QC91P13/32	142	058134	501-6N34	157
056125	5ATL1.25	139	057140	5ATL14.0	139	057927	QC91P27/64	142	058135	501-6N35	157
056130	5ATL1.3	139	057145	5ATL14.5	139	057928	QC91P7/16	142	058136	501-6N36	157
056140	5ATL1.4	139	057150	5ATL15.0	139	057929	QC91P29/64	142	058137	501-6N37	157
056150	5ATL1.5	139	057155	5ATL15.5	139	057930	QC91P15/32	142	058138	501-6N38	157
056160	5ATL1.6	139	057160	5ATL16.0	139	057931	QC91P31/64	142	058139	501-6N39	157
0056165	A9405/32	68	057165	5ATL16.5	139	057932	QC91P1/2	142	058140	501-6N40	157
056170	5ATL1.7	139	057170	5ATL17.0	139	057933	QC91P33/64	142	058141	501-6N41	157
0056172	A9404.0	68	057175	5ATL17.5	139	057934	QC91P17/32	142	058142	501-6N42	157
056180	5ATL1.8	139	057180	5ATL18.0	139	057935	QC91P35/64	142	058143	501-6N43	157
056190	5ATL1.9	139	057185	5ATL18.5	139	057936	QC91P9/16	142	058144	501-6N44	157
056200	5ATL2.0	139	057190	5ATL19.0	139	057937	QC91P37/64	142	058145	501-6N45	157
056210	5ATL2.1	139	057195	5ATL19.5	139	057938	QC91P19/32	142	0058145	A9406.2	68
056215	5ATL2.15	139	057200	5ATL20.0	139	057940	QC91P5/8	142	058146	501-6N46	157
056220	5ATL2.2	139	057205	5ATL20.5	139	057942	QC91P21/32	142	058147	501-6N47	157
0056226	A9404.1	68	057210	5ATL21.0	139	057944	QC91P11/16	142	058148	501-6N48	157
056230	5ATL2.3	139	057215	5ATL21.5	139	058003	500-63/64	157	058149	501-6N49	157
0056233	A9404.2	68	057220	5ATL22.0	139	058004	500-61/16	157	058150	501-6N50	157
056240	5ATL2.4	139	057225	5ATL22.5	139	058005	500-65/64	157	058151	501-6N51	157
056250	5ATL2.5	139	057230	5ATL23.0	139	058006	500-63/32	157	058152	501-6N52	157
0056257	A9404.3	68	057235	5ATL23.5	139	058007	500-67/64	157	0058152	A9406.3	68
0056264	A94011/64	68	057240	5ATL24.0	139	058008	500-61/8	157	058153	501-6N53	157
0056271	A9404.4	68	057245	5ATL24.5	139	058009	500-69/64	157	058154	501-6N54	157
0056288	A9404.5	68	057250	5ATL25.0	139	058010	500-65/32	157	058155	501-6N55	157
0056295	A9404.6	68	057255	5ATL25.5	139	058011	500-611/64	157	058156	501-6N56	157
056300	5ATL3.0	139	057260	5ATL26.0	139	058012	500-63/16	157	058157	501-6N57	157
0056301	A9404.7	68	057265	5ATL26.5	139	058013	500-613/64	157	058158	501-6N58	157
056310	5ATL3.1	139	057270	5ATL27.0	139	058014	500-67/32	157	058159	501-6N59	157
0056318	A9403/16	68	057280	5ATL28.0	139	058015	500-615/64	157	058160	501-6N60	157
056320	5ATL3.2	139	057285	5ATL28.5	139	058016	500-61/4	157	0058169	A9401/4	68
056330	5ATL3.3	139	057290	5ATL29.0	139	058017	500-617/64	157	0058176	A9406.4	68
056340	5ATL3.4	139	057295	5ATL29.5	139	058018	500-69/32	157	0058183	A9406.5	68
056350	5ATL3.5	139	057300	5ATL30.0	139	058019	500-619/64	157	0058190	A9406.6	68
056360	5ATL3.6	139	057305	5ATL30.5	139	058020	500-65/16	157	058201	502-6A	157
056370	5ATL3.7	139	057310	5ATL31.0	139	058021	500-621/64	157	058202	502-6B	157
056380	5ATL3.8	139	057408	08601/8	147	058022	500-611/32	157	058203	502-6C	157
056400	5ATL4.0	139	057410	08605/32	147	058023	500-623/64	157	058204	502-6D	157
056420	5ATL4.2	139	057412	08603/16	147	058024	500-63/8	157	058205	502-6E	157
056430	5ATL4.3	139	057414	08607/32	147	058025	500-625/64	157	058206	502-6F	157
056450	5ATL4.5	139	057416	08601/4	147	058026	500-613/32	157	0058206	A9406.7	68

# EDP NUMBER INDEX - 058207 - 059412

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
058207	502-6G	157	0058473	A94021/64	68	058831	R89CON31	115	059125	501-12N25	160
058208	502-6H	157	0058503	A9408.4	68	058836	R89CON36	115	059126	501-12N26	160
058209	502-6I	157	0058510	A9408.5	68	058839	R89CON39	115	059127	501-12N27	160
058210	502-6J	157	0058558	A9408.6	68	058840	R89CON40	115	0059128	A94014.5	68
058211	502-6K	157	0058572	A9408.7	68	058841	R89CON41	115	059129	501-12N29	160
058212	502-6L	157	0058589	A94011/32	68	058842	R89CON42	115	059130	501-12N30	160
058213	502-6M	157	0058596	A9408.8	68	058843	R89CON43	115	059131	501-12N31	160
0058213	A94017/64	68	0058602	A9408.9	68	058844	R89CON44	115	059136	501-12N36	160
058214	502-6N	157	0058626	A9409.0	68	058845	R89CON45	115	059137	501-12N37	160
058215	502-6O	157	0058633	A9409.1	68	058846	R89CON46	115	059140	501-12N40	160
058216	502-6P	157	0058640	A94023/64	68	058849	R89CON49	115	059141	501-12N41	160
058217	502-6Q	157	0058657	A9409.2	68	058850	R89CON50	115	059142	501-12N42	160
058218	502-6R	157	0058664	A9409.3	68	058851	R89CON51	115	059143	501-12N43	160
058219	502-6S	157	0058671	A9409.4	68	058852	R89CON52	115	059144	501-12N44	160
058220	502-6T	157	0058688	A9409.5	68	0058855	A9407/16	68	059145	501-12N45	160
0058220	A9406.8	68	0058695	A9403/8	68	0058862	A94011.2	68	059146	501-12N46	160
058221	502-6U	157	0058701	A9409.6	68	0058886	A94011.5	68	059147	501-12N47	160
058222	502-6V	157	058704	R88CO1/16	115	0058893	A94029/64	68	059148	501-12N48	160
058223	502-6W	157	058705	R88CO5/64	115	0058909	A94011.8	68	059149	501-12N49	160
058224	502-6X	157	058706	R88CO3/32	115	0058916	A94015/32	68	059150	501-12N50	160
058225	502-6Y	157	058707	R88CO7/64	115	0058923	A94012.0	68	0059166	A94037/64	68
058226	502-6Z	157	058708	R88CO1/8	115	0058930	A94012.2	68	0059180	A94015.0	68
0058237	A9406.9	68	058709	R88CO9/64	115	0058978	A94031/64	68	059201	502-12A	160
0058244	A9407.0	68	058710	R88CO5/32	115	0058985	A94012.5	68	059202	502-12B	160
0058251	A9407.1	68	058711	R88CO11/64	115	0058992	A9401/2	68	059203	502-12C	160
0058268	A9409/32	68	058712	R88CO3/16	115	059003	500-123/64	160	0059203	A94019/32	68
0058275	A9407.2	68	058713	R88CO13/64	115	059004	500-121/16	160	059204	502-12D	160
0058282	A9407.3	68	058714	R88CO7/32	115	059005	500-125/64	160	059205	502-12E	160
0058299	A9407.4	68	058715	R88CO15/64	115	059006	500-123/32	160	059206	502-12F	160
058304	QC41P1/16	128	058716	R88CO1/4	115	059007	500-127/64	160	059207	502-12G	160
0058305	A9407.5	68	058717	R88CO17/64	115	059008	500-121/8	160	059208	502-12H	160
058305	QC41P5/64	128	0058718	A9409.7	68	059009	500-129/64	160	059209	502-12I	160
058306	QC41P3/32	128	058718	R88CO9/32	115	059010	500-125/32	160	059210	502-12J	160
058307	QC41P7/64	128	058719	R88CO19/64	115	059011	500-1211/64	160	0059210	A94015.5	68
058308	QC41P1/8	128	058720	R88CO5/16	115	059012	500-123/16	160	059211	502-12K	160
058309	QC41P9/64	128	058721	R88CO21/64	115	0059012	A94013.0	68	059212	502-12L	160
058310	QC41P5/32	128	058722	R88CO11/32	115	059013	500-1213/64	160	059213	502-12M	160
058311	QC41P11/64	128	058723	R88CO23/64	115	059014	500-127/32	160	059214	502-12N	160
0058312	A94019/64	68	058724	R88CO3/8	115	059015	500-1215/64	160	059215	502-12O	160
058312	QC41P3/16	128	0058725	A9409.8	68	059016	500-121/4	160	059216	502-12P	160
058313	QC41P13/64	128	058725	R88CO25/64	115	059017	500-1217/64	160	059217	502-12Q	160
058314	QC41P7/32	128	058726	R88CO13/32	115	059018	500-129/32	160	059218	502-12R	160
058315	QC41P15/64	128	058727	R88CO27/64	115	059019	500-1219/64	160	059219	502-12S	160
058316	QC41P1/4	128	058728	R88CO7/16	115	059020	500-125/16	160	059220	502-12T	160
058317	QC41P17/64	128	058729	R88CO29/64	115	059021	500-1221/64	160	059221	502-12U	160
058318	QC41P9/32	128	058730	R88CO15/32	115	059022	500-1211/32	160	059222	502-12V	160
058319	QC41P19/64	128	058731	R88CO31/64	115	059023	500-1223/64	160	059223	502-12W	160
058320	QC41P5/16	128	0058732	A9409.9	68	059024	500-123/8	160	059224	502-12X	160
058321	QC41P21/64	128	058732	R88CO1/2	115	059025	500-1225/64	160	059225	502-12Y	160
058322	QC41P11/32	128	0058749	A94025/64	68	059026	500-1213/32	160	059226	502-12Z	160
058323	QC41P23/64	128	0058756	A94010.0	68	059027	500-1227/64	160	0059227	A9405/8	68
058324	QC41P3/8	128	0058763	A94010.2	68	059028	500-127/16	160	0059234	A94016.0	68
058325	QC41P25/64	128	0058770	A94010.3	68	059029	500-1229/64	160	0059241	A94016.5	68
058326	QC41P13/32	128	0058787	A94013/32	68	059030	500-1215/32	160	0059258	A94021/32	68
058327	QC41P27/64	128	0058794	A94010.4	68	059031	500-1231/64	160	0059265	A94017.0	68
058328	QC41P7/16	128	0058800	A94010.5	68	059032	500-121/2	160	0059272	A94011/16	68
058329	QC41P29/64	128	058803	R89CON3	115	0059043	A94033/64	68	0059289	A94017.5	68
058330	QC41P15/32	128	058805	R89CON5	115	0059050	A94017/32	68	0059296	A94045/64	68
058331	QC41P31/64	128	058806	R89CON6	115	0059067	A94013.5	68	0059302	A94018.0	68
058332	QC41P1/2	128	058807	R89CON7	115	0059081	A94014.0	68	0059326	A94023/32	68
058333	QC41P33/64	128	058808	R89CON8	115	059101	501-12N1	160	0059333	A94047/64	68
058334	QC41P17/32	128	058809	R89CON9	115	059103	501-12N3	160	0059340	A94019.0	68
058335	QC41P35/64	128	058810	R89CON10	115	059104	501-12N4	160	0059357	A9403/4	68
058336	QC41P19/16	128	058811	R89CON11	115	059105	501-12N5	160	0059364	A94020.0	68
058337	QC41P37/64	128	058812	R89CON12	115	059107	501-12N7	160	0059371	A9411.0	68
058338	QC41P19/32	128	058813	R89CON13	115	059109	501-12N9	160	0059388	A9411.5	68
058340	QC41P5/8	128	058816	R89CON16	115	059110	501-12N10	160	0059401	A9412.0	68
058341	QC41P41/64	128	0058817	A94027/64	68	059111	501-12N11	160	059401	QC91PN1	142
058342	QC41P21/32	128	058820	R89CON20	115	0059111	A9409/16	68	059402	QC91PN2	142
0058343	A9407.6	68	058821	R89CON21	115	059112	501-12N12	160	059403	QC91PN3	142
058344	QC41P11/16	128	058822	R89CON22	115	059113	501-12N13	160	059404	QC91PN4	142
0058350	A9407.7	68	0058824	A94010.8	68	059116	501-12N16	160	059405	QC91PN5	142
0058374	A9407.8	68	058824	R89CON24	115	059117	501-12N17	160	059406	QC91PN6	142
0058381	A9407.9	68	058825	R89CON25	115	059118	501-12N18	160	059407	QC91PN7	142
0058398	A9405/16	68	058826	R89CON26	115	059119	501-12N19	160	059408	QC91PN8	142
0058404	A9408.0	68	058827	R89CON27	115	059120	501-12N20	160	059409	QC91PN9	142
0058411	A9408.1	68	058829	R89CON29	115	059121	501-12N21	160	059410	QC91PN10	142
0058435	A9408.2	68	058830	R89CON30	115	059122	501-12N22	160	059411	QC91PN11	142
0058442	A9408.3	68	0058831	A94011.0	68	059123	501-12N23	160	059412	QC91PN12	142

# EDP NUMBER INDEX - 059413 - 0061749

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
059413	QC91PN13	142	059624	12903/8	147	060019	QC41PN19	128	0061145	A9417.2	68
059414	QC91PN14	142	059625	129025/64	147	060020	QC41PN20	128	0061152	A9417.3	68
059415	QC91PN15	142	059626	129013/32	147	060021	QC41PN21	128	0061169	A9417.4	68
059416	QC91PN16	142	059627	129027/64	147	060022	QC41PN22	128	0061176	A9417.5	68
059417	QC91PN17	142	059628	12907/16	147	060023	QC41PN23	128	0061183	A9417.6	68
0059418	A9412.5	68	059629	129029/64	147	060024	QC41PN24	128	0061190	A9417.7	68
059418	QC91PN18	142	059630	129015/32	147	060025	QC41PN25	128	0061206	A9417.8	68
059419	QC91PN19	142	059631	129031/64	147	060026	QC41PN26	128	0061213	A9417.9	68
059420	QC91PN20	142	059632	12901/2	147	060027	QC41PN27	128	0061220	A9418.0	68
059421	QC91PN21	142	059633	129033/64	147	060028	QC41PN28	128	0061237	A9418.1	68
059422	QC91PN22	142	059634	129017/32	147	060029	QC41PN29	128	0061244	A9418.2	68
059423	QC91PN23	142	059635	129035/64	147	060030	QC41PN30	128	0061251	A9418.3	68
059424	QC91PN24	142	059636	12909/16	147	060031	QC41PN31	128	0061268	A9418.4	68
059425	QC91PN25	142	059637	129037/64	147	060032	QC41PN32	128	0061275	A9418.5	68
059426	QC91PN26	142	059638	129019/32	147	060033	QC41PN33	128	0061282	A9418.6	68
059427	QC91PN27	142	059639	129039/64	147	060034	QC41PN34	128	0061299	A9418.7	68
059428	QC91PN28	142	059640	12905/8	147	060035	QC41PN35	128	0061305	A9418.8	68
059429	QC91PN29	142	059642	129021/32	147	060036	QC41PN36	128	0061312	A9418.9	68
059430	QC91PN30	142	059644	129011/16	147	060037	QC41PN37	128	0061329	A9419.0	68
059431	QC91PN31	142	059646	129023/32	147	060038	QC41PN38	128	0061336	A9419.1	68
0059432	A9413.0	68	059648	12903/4	147	060039	QC41PN39	128	0061343	A9419.2	68
059432	QC91PN32	142	0059654	A9413.3	68	060040	QC41PN40	128	0061350	A9419.3	68
059433	QC91PN33	142	0059661	A9413.4	68	0060216	A9413.9	68	0061367	A9419.4	68
059434	QC91PN34	142	059716	18131/4	149	0060223	A9414.0	68	0061374	A9419.5	68
059435	QC91PN35	142	059717	181317/64	149	060308	QC1290P1/8	154	0061381	A9419.6	68
059436	QC91PN36	142	059718	18139/32	149	060309	QC1290P9/64	154	0061398	A9419.7	68
059437	QC91PN37	142	059719	181319/64	149	060310	QC1290P5/32	154	061401	QC41GN1	128
059438	QC91PN38	142	059720	18135/16	149	060311	QC1290P11/64	154	061402	QC41GN2	128
059439	QC91PN39	142	059721	181321/64	149	060312	QC1290P3/16	154	061403	QC41GN3	128
059440	QC91PN40	142	059722	181311/32	149	060313	QC1290P13/64	154	0061404	A9419.8	68
059441	QC91PN41	142	059723	181323/64	149	060314	QC1290P7/32	154	061404	QC41GN4	128
059442	QC91PN42	142	059724	18133/8	149	0060315	A9414.1	68	061405	QC41GN5	128
059443	QC91PN43	142	059725	181325/64	149	060315	QC1290P15/64	154	061406	QC41GN6	128
059444	QC91PN44	142	059726	181313/32	149	060316	QC1290P1/4	154	061407	QC41GN7	128
059445	QC91PN45	142	059727	181327/64	149	060317	QC1290P17/64	154	061408	QC41GN8	128
059446	QC91PN46	142	059728	18137/16	149	060318	QC1290P9/32	154	061409	QC41GN9	128
059447	QC91PN47	142	059729	181329/64	149	060319	QC1290P19/64	154	061410	QC41GN10	128
059448	QC91PN48	142	059730	181315/32	149	060320	QC1290P5/16	154	0061411	A9419.9	68
0059449	A9413.1	68	059731	181331/64	149	060321	QC1290P21/64	154	061411	QC41GN11	128
059449	QC91PN49	142	059732	18131/2	149	0060322	A9414.2	68	061412	QC41GN12	128
059450	QC91PN50	142	059733	181333/64	149	060322	QC1290P11/32	154	061413	QC41GN13	128
059451	QC91PN51	142	059734	181317/32	149	060323	QC1290P23/64	154	061414	QC41GN14	128
059452	QC91PN52	142	059735	181335/64	149	060324	QC1290P3/8	154	061415	QC41GN15	128
0059463	A9413.2	68	059736	18139/16	149	060325	QC1290P25/64	154	061416	QC41GN16	128
059512	15113/16	149	059737	181337/64	149	060326	QC1290P13/32	154	061417	QC41GN17	128
059516	15111/4	149	059738	181319/32	149	060327	QC1290P27/64	154	061418	QC41GN18	128
059520	15115/16	149	059739	181339/64	149	060328	QC1290P7/16	154	061419	QC41GN19	128
059522	151111/32	149	059740	18135/8	149	060330	QC1290P15/32	154	061420	QC41GN20	128
059524	15113/8	149	059742	181321/32	149	060331	QC1290P31/64	154	061421	QC41GN21	128
059528	15117/16	149	059744	181311/16	149	060332	QC1290P1/2	154	061422	QC41GN22	128
059532	15111/2	149	059746	181323/32	149	0060377	A9414.3	68	061423	QC41GN23	128
059534	151117/32	149	059748	18133/4	149	0060384	A9414.4	68	061424	QC41GN24	128
059536	15119/16	149	059750	181325/32	149	0060414	A9414.5	68	061425	QC41GN25	128
059540	15115/8	149	059752	181313/16	149	0060421	A9414.6	68	061426	QC41GN26	128
059542	151121/32	149	059756	18137/8	149	0060445	A9414.7	68	061427	QC41GN27	128
059544	151111/16	149	059760	181315/16	149	0060452	A9414.8	68	0061428	A94110.0	68
059546	151123/32	149	59764	18131	149	0060476	A9414.9	68	061428	QC41GN28	128
059548	15113/4	149	0059838	A9413.5	68	0060490	A9415.0	68	061429	QC41GN29	128
059550	151125/32	149	0059944	A9413.6	68	0060513	A9415.1	68	061430	QC41GN30	128
059552	151113/16	149	0059968	A9413.7	68	0060605	A9415.2	68	061431	QC41GN31	128
059554	15117/8	149	0059982	A9413.8	68	0060612	A9415.3	68	061432	QC41GN32	128
059556	151115/16	149	060001	QC41PN1	128	0060674	A9415.4	68	061433	QC41GN33	128
59558	15111	149	060002	QC41PN2	128	0060681	A9415.5	68	061434	QC41GN34	128
059608	12901/8	147	060003	QC41PN3	128	0060728	A9415.6	68	0061435	A94110.2	68
059609	12909/64	147	060004	QC41PN4	128	0060735	A9415.7	68	061435	QC41GN35	128
059610	12905/32	147	060005	QC41PN5	128	0060766	A9415.8	68	061436	QC41GN36	128
059611	129011/64	147	060006	QC41PN6	128	0060773	A9415.9	68	061437	QC41GN37	128
059612	12903/16	147	060007	QC41PN7	128	0060797	A9416.0	68	061438	QC41GN38	128
059613	129013/64	147	060008	QC41PN8	128	0060889	A9416.1	68	061439	QC41GN39	128
059614	12907/32	147	060009	QC41PN9	128	0060940	A9416.2	68	061440	QC41GN40	128
059615	129015/64	147	060010	QC41PN10	128	0060995	A9416.3	68	0061442	A94110.3	68
059616	12901/4	147	060011	QC41PN11	128	0061022	A9416.4	68	0061466	A94110.5	68
059617	129017/64	147	060012	QC41PN12	128	0061046	A9416.5	68	0061480	A94111.0	68
059618	12909/32	147	060013	QC41PN13	128	0061053	A9416.6	68	0061497	A94111.2	68
059619	129019/64	147	060014	QC41PN14	128	0061091	A9416.7	68	0061633	A94111.5	68
059620	12905/16	147	060015	QC41PN15	128	0061107	A9416.8	68	0061657	A94111.8	68
059621	129021/64	147	060016	QC41PN16	128	0061114	A9416.9	68	0061688	A94112.0	68
059622	129011/32	147	060017	QC41PN17	128	0061121	A9417.0	68	0061718	A94112.2	68
059623	129023/64	147	060018	QC41PN18	128	0061138	A9417.1	68	0061749	A94112.5	68

# EDP NUMBER INDEX - 0061817 - 091549

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0061817	A94113.0	68	080544	QC21GN44	106	087927	SPL-905/8	194	091302	R581.11/16	182
0061848	A94113.5	68	080545	QC21GN45	106	087928	SPL-903/4	194	091304	R581.3/4	182
0061862	A94114.0	68	080546	QC21GN46	106	087929	SPL-901	194	091306	R581.13/16	182
0061886	A94114.5	68	080547	QC21GN47	106	087930	SPLG-901/4	194	091308	R581.7/8	182
0061909	A94115.0	68	080548	QC21GN48	106	087931	SPLG-903/8	194	091310	R581.15/16	182
0061916	A94115.5	68	080549	QC21GN49	106	087932	SPLG-901/2	194	091312	R582	182
0061930	A94116.0	68	080550	QC21GN50	106	087934	SPLG-903/4	194	091433	R5633/64	178
062304	QC41G1/16	128	080551	QC21GN51	106	087935	SPLG-901	194	091434	R5617/32	178
062305	QC41G5/64	128	080552	QC21GN52	106	087950	SPS-1201/4	192	091435	R5635/64	178
062306	QC41G3/32	128	081704	QC21G1/16	106	087951	SPS-1203/8	192	091436	R569/16	178
062307	QC41G7/64	128	081705	QC21G5/64	106	087952	SPS-1201/2	192	091437	R5637/64	178
062308	QC41G1/8	128	081706	QC21G3/32	106	087953	SPS-1205/8	192	091438	R5619/32	178
062309	QC41G9/64	128	081707	QC21G7/64	106	087954	SPS-1203/4	192	091439	R5639/64	178
062310	QC41G5/32	128	081708	QC21G1/8	106	087955	SPS-1201	192	091440	R565/8	178
062311	QC41G11/64	128	081709	QC21G9/64	106	087956	SPSG-1201/4	192	091441	R5641/64	178
062312	QC41G3/16	128	081710	QC21G5/32	106	087957	SPSG-1203/8	192	091442	R5621/32	178
062313	QC41G13/64	128	081711	QC21G11/64	106	087958	SPSG-1201/2	192	091443	R5643/64	178
062314	QC41G7/32	128	081712	QC21G3/16	106	087959	SPSG-1205/8	192	091444	R5611/16	178
062315	QC41G15/64	128	081713	QC21G13/64	106	087960	SPSG-1203/4	192	091445	R5645/64	178
062316	QC41G1/4	128	081714	QC21G7/32	106	087961	SPSG-1201	192	091446	R5623/32	178
062317	QC41G17/64	128	081715	QC21G15/64	106	087962	SPR-1201/4	193	091447	R5647/64	178
062318	QC41G9/32	128	081716	QC21G1/4	106	087963	SPR-1203/8	193	091448	R563/4	178
062319	QC41G19/64	128	081717	QC21G17/64	106	087964	SPR-1201/2	193	091449	R5649/64	178
062320	QC41G5/16	128	081718	QC21G9/32	106	087965	SPR-1205/8	193	091450	R5625/32	178
062321	QC41G21/64	128	081719	QC21G19/64	106	087966	SPR-1203/4	193	091451	R5651/64	178
062322	QC41G11/32	128	081720	QC21G5/16	106	087967	SPR-1201	193	091452	R5613/16	178
062323	QC41G23/64	128	081721	QC21G21/64	106	087968	SPRG-1201/4	193	091453	R5653/64	178
062324	QC41G3/8	128	081722	QC21G11/32	106	087969	SPRG-1203/8	193	091454	R5627/32	178
062325	QC41G25/64	128	081723	QC21G23/64	106	087970	SPRG-1201/2	193	091455	R5655/64	178
062326	QC41G13/32	128	081724	QC21G3/8	106	087971	SPRG-1205/8	193	091456	R567/8	178
062327	QC41G27/64	128	081725	QC21G25/64	106	087973	SPRG-1201	193	091457	R5657/64	178
062328	QC41G7/16	128	081726	QC21G13/32	106	087974	SPL-1201/4	194	091458	R5629/32	178
062329	QC41G29/64	128	081727	QC21G27/64	106	087975	SPL-1203/8	194	091459	R5659/64	178
062330	QC41G15/32	128	081728	QC21G7/16	106	087976	SPL-1201/2	194	091460	R5615/16	178
062331	QC41G31/64	128	081729	QC21G29/64	106	087977	SPL-1205/8	194	091461	R5661/64	178
062332	QC41G1/2	128	081730	QC21G15/32	106	087978	SPL-1203/4	194	091462	R5631/32	178
080501	QC21GN1	106	081731	QC21G31/64	106	087980	SPLG-1201/4	194	091463	R5663/64	178
080502	QC21GN2	106	081732	QC21G1/2	106	087981	SPLG-1203/8	194	091464	R561	178
080503	QC21GN3	106	0085189	E201M10	265	087982	SPLG-1201/2	194	091465	R561.1/64	178
080504	QC21GN4	106	0085196	E201M4	265	087985	SPLG-1201	194	091467	R561.3/64	178
080505	QC21GN5	106	0085202	E201M5	265	090101	C60R18PSET	203	091468	R561.1/16	178
080506	QC21GN6	106	0085219	E201M6	265	090114	C114COMBPSET	203	091469	R561.5/64	178
080507	QC21GN7	106	0085226	E201M8	265	090123	C115COMBPSET	203	091470	R561.3/32	178
080508	QC21GN8	106	0087268	E252M10	265	090126	C26R15PSET	203	091471	R561.7/64	178
080509	QC21GN9	106	0087275	E252M12	265	090154	C29R51SET	217	091472	R561.1/8	178
080510	QC21GN10	106	0087282	E252M14	265	090161	C20R18PSET	202	091473	R561.9/64	178
080511	QC21GN11	106	0087299	E252M16	265	090162	C29R10PSET	201	091474	R561.11/64	178
080512	QC21GN12	106	0087305	E252M18	265	090163	C15R10PSET	201	091475	R561.13/64	178
080513	QC21GN13	106	0087312	E252M20	265	090170	C29R40SET	213	091476	R561.3/16	178
080514	QC21GN14	106	0087329	E252M22	265	090173	C26R42SET	213	091477	R561.15/64	178
080515	QC21GN15	106	0087336	E252M24	265	090174	C60R41SET	213	091479	R561.9/32	178
080516	QC21GN16	106	0087343	E252M8	265	090231	C33R56SET	218	091480	R561.1/4	178
080517	QC21GN17	106	087900	SPS-901/4	192	090290	C29R10COSET	211	091482	R561.5/16	178
080518	QC21GN18	106	087901	SPS-903/8	192	090291	C15R10COSET	211	091483	R561.3/8	178
080519	QC21GN19	106	087902	SPS-901/2	192	090292	C26R15COSET	211	091484	R561.7/16	178
080520	QC21GN20	106	087903	SPS-905/8	192	090328	C8R56COSET	218	091485	R561.1/2	178
080521	QC21GN21	106	087904	SPS-903/4	192	090556	C8R56SET	218	091486	R561.1/32	178
080522	QC21GN22	106	087905	SPS-901	192	090558	C8R57SET	218	091487	R561.5/32	178
080523	QC21GN23	106	087906	SPSG-901/4	192	090600	C60R18COSET	211	091488	R561.7/32	178
080524	QC21GN24	106	087907	SPSG-903/8	192	091010	C29HX10SET	210	091492	R561.13/32	178
080525	QC21GN25	106	087908	SPSG-901/2	192	091264	R581	182	091495	R561.15/32	178
080526	QC21GN26	106	087909	SPSG-905/8	192	091266	R581.1/32	182	091497	R561.11/32	178
080527	QC21GN27	106	087910	SPSG-903/4	192	091268	R581.1/16	182	091533	R5733/64	180
080528	QC21GN28	106	087911	SPSG-901	192	091270	R581.3/32	182	091534	R5717/32	180
080529	QC21GN29	106	087912	SPR-901/4	193	091272	R581.1/8	182	091535	R5735/64	180
080530	QC21GN30	106	087913	SPR-903/8	193	091274	R581.5/32	182	091536	R579/16	180
080531	QC21GN31	106	087914	SPR-901/2	193	091276	R581.3/16	182	091537	R5737/64	180
080532	QC21GN32	106	087915	SPR-905/8	193	091278	R581.7/32	182	091538	R5719/32	180
080533	QC21GN33	106	087916	SPR-903/4	193	091280	R581.1/4	182	091539	R5739/64	180
080534	QC21GN34	106	087917	SPR-901	193	091282	R581.9/32	182	091540	R575/8	180
080535	QC21GN35	106	087918	SPRG-901/4	193	091284	R581.5/16	182	091541	R5741/64	180
080536	QC21GN36	106	087919	SPRG-903/8	193	091286	R581.11/32	182	091542	R5721/32	180
080537	QC21GN37	106	087920	SPRG-901/2	193	091288	R581.3/8	182	091543	R5743/64	180
080538	QC21GN38	106	087921	SPRG-905/8	193	091290	R581.13/32	182	091544	R5711/16	180
080539	QC21GN39	106	087922	SPRG-903/4	193	091292	R581.7/16	182	091545	R5745/64	180
080540	QC21GN40	106	087923	SPRG-901	193	091294	R581.15/32	182	091546	R5723/32	180
080541	QC21GN41	106	087924	SPL-901/4	194	091296	R581.1/2	182	091547	R5747/64	180
080542	QC21GN42	106	087925	SPL-903/8	194	091298	R581.9/16	182	091548	R573/4	180
080543	QC21GN43	106	087926	SPL-901/2	194	091300	R581.5/8	182	091549	R5749/64	180

# EDP NUMBER INDEX - 091550 - 099983

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
091550	R5725/32	180	094006	E500M11NO2	292	095003	E501M16NO3	300	096727	E513M5X.5NO2	294
091551	R5751/64	180	094013	E500M11NO3	292	095010	E501M18NO3	300	096734	E513M5X.5NO3	294
091552	R5713/16	180	094037	E500M12NO2	292	095027	E501M20NO2	300	096741	E513M5X.5NO7	294
091553	R5753/64	180	094044	E500M12NO3	292	095034	E501M20NO3	300	096758	E513M50X1.5NO3	294
091554	R5727/32	180	094051	E500M12NO6	292	095041	E501M24NO3	300	096765	E513M6X.75NO3	294
091555	R5755/64	180	094068	E500M12NO8	292	095058	E501M3NO2	300	096772	E513M6X.75NO7	294
091556	R577/8	180	094075	E500M14NO2	292	095065	E501M3NO3	300	096789	E513M7X.75NO2	294
091557	R5757/64	180	094082	E500M14NO3	292	095072	E501M4NO2	300	096796	E513M7X.75NO3	294
091558	R5729/32	180	094099	E500M14NO8	292	095089	E501M4NO3	300	096802	E513M8X.75NO3	294
091559	R5759/64	180	094105	E500M16NO2	292	095096	E501M5NO2	300	096819	E513M8X.75NO7	294
091560	R5715/16	180	094112	E500M16NO3	292	095102	E501M5NO3	300	096826	E513M8X1.0NO3	294
091561	R5761/64	180	094129	E500M16NO8	292	095119	E501M6NO2	300	096833	E513M9X1.0NO3	294
091562	R5731/32	180	094136	E500M18NO2	292	095126	E501M6NO3	300	097601	76HAN1	196
091563	R5763/64	180	094143	E500M18NO3	292	095133	E501M8NO2	300	097602	76HAN2	196
091564	R571	180	094167	E500M2.2NO2	292	095140	E501M8NO3	300	097603	76HAN3	196
091565	R571.1/64	180	094174	E500M2.2NO3	292	096079	E513M10X1.25NO3	294	097604	76HAN4	196
091567	R571.3/64	180	094198	E500M2.3NO2	292	096086	E513M10X1.0NO3	294	097605	76HAN5	196
091568	R571.1/16	180	094204	E500M2.3NO3	292	096093	E513M11X1.0NO2	294	097606	76HAN6	196
091569	R571.5/64	180	094228	E500M2.5NO2	292	096109	E513M11X1.0NO3	294	097607	76HAN7	196
091570	R571.3/32	180	094235	E500M2.5NO3	292	096116	E513M12X1.25NO3	294	097608	76HAN8	196
091571	R571.7/64	180	094242	E500M2.5NO8	292	096123	E513M12X1.25NO7	294	097610	76HAN0	196
091572	R571.1/8	180	094259	E500M2NO1	292	096130	E513M12X1.5NO2	294	097620	76HAN00	196
091573	R571.9/64	180	094266	E500M2NO2	292	096147	E513M12X1.5NO3	294	097630	76HAN000	196
091575	R571.11/64	180	094273	E500M2NO3	292	096154	E513M12X1.0NO3	294	099193	E5471.1/2NO2	340
091576	R571.3/16	180	094280	E500M2NO8	292	096161	E513M14X1.25NO3	294	099209	E5471.1/2NO3	340
091577	R571.13/64	180	094297	E500M2NO3	292	096178	E513M14X1.5NO3	294	099216	E5471.1/4NO2	340
091579	R571.15/64	180	094303	E500M2NO8	292	096185	E513M14X1.0NO3	294	099223	E5471.1/4NO3	340
091580	R571.1/4	180	094310	E500M22NO2	292	096192	E513M15X1.5NO2	294	099254	E5471NO3	340
091582	R571.5/16	180	094327	E500M22NO3	292	096208	E513M15X1.5NO3	294	099261	E5471/2NO3	340
091583	R571.3/8	180	094341	E500M24NO2	292	096222	E513M16X1.5NO3	294	099278	E5471/4NO3	340
091584	R571.7/16	180	094358	E500M24NO3	292	096239	E513M16X1.5NO7	294	099285	E5471/8NO3	340
091585	R571.1/2	180	094365	E500M27NO2	292	096246	E513M16X1.0NO3	294	099292	E5472NO3	340
091586	R571.1/32	180	094372	E500M27NO3	292	096253	E513M16X1.0NO7	294	099308	E5473/4NO3	340
091587	R571.5/32	180	094402	E500M3.5NO1	292	096260	E513M18X1.5NO3	294	099315	E5473/8NO3	340
091588	R571.7/32	180	094419	E500M3.5NO2	292	096277	E513M18X1.0NO2	294	099322	E5475/8NO2	340
091589	R571.9/32	180	094426	E500M3.5NO3	292	096284	E513M18X1.0NO3	294	099339	E5475/8NO3	340
091592	R571.11/32	180	094433	E500M3.5NO8	292	096291	E513M18X1.0NO7	294	099353	E5477/8NO2	340
091595	R571.13/32	180	094440	E500M3NO2	292	096307	E513M18X2.0NO2	294	099360	E5477/8NO3	340
091598	R571.15/32	180	094457	E500M3NO3	292	096314	E513M18X2.0NO3	294	099445	E5501	339
092333	R56CO33/64	183	094464	E500M3NO6	292	096321	E513M18X2.0NO7	294	099452	E5501.1/2	339
092334	R56CO17/32	183	094471	E500M3NO8	292	096338	E513M20X1.5NO3	294	099469	E5501.1/4	339
092335	R56CO35/64	183	094488	E500M30NO2	292	096345	E513M20X1.0NO2	294	099476	E5501/2	339
092336	R56CO9/16	183	094495	E500M30NO3	292	096352	E513M20X1.0NO3	294	099483	E5501/4	339
092337	R56CO37/64	183	094525	E500M33NO3	292	096369	E513M20X1.0NO7	294	099490	E5501/8	339
092338	R56CO19/32	183	094549	E500M36NO2	292	096376	E513M20X2.0NO2	294	099506	E5502	339
092339	R56CO39/64	183	094556	E500M36NO3	292	096383	E513M20X2.0NO3	294	099513	E5503/4	339
092340	R56CO5/8	183	094587	E500M39NO3	292	096390	E513M22X1.5NO3	294	099520	E5503/8	339
092341	R56CO41/64	183	094617	E500M4.5NO2	292	096406	E513M22X1.0NO2	294	099701	C21R10COSET	211
092342	R56CO21/32	183	094624	E500M4.5NO3	292	096413	E513M22X1.0NO3	294	099705	C114COMBCSET	212
092343	R56CO43/64	183	094648	E500M4NO2	292	096420	E513M22X2.0NO2	294	099706	C115COMBCSET	212
092344	R56CO11/16	183	094655	E500M4NO3	292	096437	E513M22X2.0NO3	294	099834	E7101	327
092345	R56CO45/64	183	094662	E500M4NO6	292	096444	E513M22X2.0NO7	294	099841	E7101.1/2	327
092346	R56CO23/32	183	094679	E500M4NO8	292	096451	E513M24X1.5NO3	294	099858	E7101.1/4	327
092347	R56CO47/64	183	094686	E500M42NO3	292	096468	E513M24X1.5NO7	294	099865	E7101/2	327
092348	R56CO3/4	183	094709	E500M45NO3	292	096475	E513M24X1.0NO2	294	099872	E7101/4	327
092349	R56CO49/64	183	094730	E500M48NO3	292	096482	E513M24X1.0NO3	294	099889	E7101/8	327
092350	R56CO25/32	183	094761	E500M5NO2	292	096499	E513M24X2.0NO2	294	099896	E7102	327
092351	R56CO51/64	183	094778	E500M5NO3	292	096505	E513M24X2.0NO3	294	099902	E7103/4	327
092352	R56CO13/16	183	094785	E500M5NO8	292	096512	E513M25X1.5NO3	294	099903	C29R40CSET	215
092353	R56CO53/64	183	094792	E500M52NO3	292	096529	E513M26X1.5NO2	294	099919	E7103/8	327
092354	R56CO27/32	183	094808	E500M6NO1	292	096536	E513M26X1.5NO3	294	099926	E7111	333
092355	R56CO55/64	183	094815	E500M6NO2	292	096543	E513M28X1.5NO2	294	099930	C60R41CSET	215
092356	R56CO7/8	183	094822	E500M6NO3	292	096550	E513M28X1.5NO3	294	099933	E7111/2	333
092357	R56CO57/64	183	094839	E500M6NO8	292	096567	E513M3X.35NO3	294	099935	C29L10SET	208
092358	R56CO29/32	183	094846	E500M7NO3	292	096574	E513M30X1.5NO2	294	099940	E7111/4	333
092359	R56CO59/64	183	094853	E500M7NO6	292	096581	E513M30X1.5NO3	294	099944	C13R10COSET	211
092360	R56CO15/16	183	094860	E500M7NO8	292	096598	E513M32X1.5NO3	294	099955	C15L10SET	208
092361	R56CO61/64	183	094877	E500M8NO2	292	096604	E513M33X2.0NO2	294	099957	E7111/8	333
092362	R56CO31/32	183	094884	E500M8NO3	292	096611	E513M33X2.0NO3	294	099960	C60M41COSET	216
092363	R56CO63/64	183	094891	E500M8NO6	292	096628	E513M35X1.5NO2	294	099961	C26M42COSET	216
092364	R56CO1	183	094907	E500M8NO8	292	096635	E513M35X1.5NO3	294	099962	C29M40COSET	216
093900	E500M1.6NO3	292	094914	E500M9NO3	292	096642	E513M36X2.0NO3	294	099964	E7113/4	333
093924	E500M1.7NO2	292	094938	E501M10NO2	300	096659	E513M36X3.0NO2	294	099971	E7113/8	333
093931	E500M1.7NO3	292	094945	E501M10NO3	300	096666	E513M36X3.0NO3	294	099976	C60R18SET	202
093948	E500M1.8NO2	292	094952	E501M12NO2	300	096673	E513M39X3.0NO3	294	099977	C29R10SET	201
093955	E500M1.8NO3	292	094969	E501M12NO3	300	096680	E513M4X.5NO3	294	099978	C15R10SET	201
093979	E500M10NO2	292	094976	E501M14NO2	300	096697	E513M40X1.5NO3	294	099981	C20R18SET	202
093986	E500M10NO3	292	094983	E501M14NO3	300	096703	E513M42X1.5NO3	294	099982	C115COMBSET	204
093993	E500M10NO8	292	094990	E501M16NO2	300	096710	E513M45X1.5NO3	294	099983	C26R15SET	203

# EDP NUMBER INDEX - 099985 - 0128930

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
099985	C502ABSET	205	0108802	G13740.0	489	0115824	R5107.0	44	0121924	A17047/64	176
099987	C252ASET	205	0108819	G13750.0	489	0115831	R5107.3	44	0121931	A17049/64	176
099988	C252ABSET	205	0108826	G13763.0	489	0115848	R5107.4	44	0121948	A17053/64	176
0099988	E7121	337	0108833	G13780.0	489	0115855	R5107.5	44	0121955	A17055/64	176
099990	C114COMBSET	204	0108895	G13825.0	490	0115862	R5108.0	44	0121962	A17059/64	176
0099995	E7121.1/4	337	0108925	G13830.0	490	0115879	R5108.5	44	0121979	A17061/64	176
0100004	E7121/16	337	0108932	G13831.0	490	0115886	R5109.0	44	0121986	A17063/64	176
0100011	E7121/2	337	0108949	G13834.0	490	0115893	R5109.2	44	0122198	B1573.0	452
0100028	E7121/4	337	0108956	G13837.0	490	0115909	R5109.3	44	0122297	C3463.0	418
0100035	E7121/8	337	0108963	G13840.0	490	0115916	R5109.5	44	0122303	C3464.0	418
0100042	E7123/4	337	0108970	G13850.0	490	0115923	R52010.0	38	0122310	C3465.0	418
0100059	E7123/8	337	0108987	G13863.0	490	0115930	R52010.2	38	0122327	C3466.0	418
0104996	F201M10	364	0108994	G13880.0	490	0115947	R52010.4	38	0122440	E500M2.6NO3	292
0105009	F201M12	364	0109038	G14910	482	0115954	R52010.5	38	0122457	E500M56NO3	292
0105016	F201M14	364	0109045	G14915	482	0115961	R52011.0	38	0122464	E500M1NO3	292
0105023	F201M16	364	0109052	G14920	482	0115978	R52011.5	38	0122471	E500M1.2NO3	292
0105030	F201M4	364	0109069	G14925	482	0115985	R52012.0	38	0122488	E500M1.4NO3	292
0105047	F201M5	364	0109076	G14930	482	0115992	R52012.5	38	0122495	E501M22NO3	300
0105054	F201M6	364	0109083	G14935	482	0116005	R52013.0	38	0122501	E504M5NO3	305
0105061	F201M8	364	0109090	G14940	482	0116012	R52014.0	38	0122518	E504M6NO3	305
0105528	F302M10	367	0109106	G1495	482	0116029	R52014.5	38	0122525	E504M8NO3	305
0105535	F302M11	367	0109113	G14950	482	0116036	R52015.0	38	0122532	E504M10NO3	305
0105542	F302M12	367	0109502	G33825.0	490	0116043	R52016.0	38	0122556	E504M4NO3	305
0105559	F302M14	367	0109519	G33831.0	490	0116050	R52016.5	38	0122563	E504M3NO3	305
0105566	F302M16	367	0109526	G33837.0	490	0116067	R5203.0	38	0122587	E504M16NO3	305
0105573	F302M18	367	0109533	G33840.0	490	0116074	R5203.1	38	0123003	E513M30X2.0NO3	294
0105580	F302M20	367	0109540	G33850.0	490	0116081	R5203.2	38	0123010	E513M27X1.5NO3	294
0105597	F302M22	367	0109557	G33863.0	490	0116098	R5203.3	38	0123027	E513M5X.75NO3	294
0105603	F302M24	367	0109632	G56010.0	483	0116104	R5203.4	38	0123034	E513M6X.5NO3	294
0105610	F302M27	367	0109649	G56010.4	483	0116111	R5203.5	38	0123041	E513M27X2.0NO3	294
0105627	F302M3	367	0109656	G56012.4	483	0116128	R5203.6	38	0123058	E513M8X.5NO3	294
0105634	F302M30	367	0109663	G56016.5	483	0116135	R5203.7	38	0123065	E513M10X.75NO3	294
0105641	F302M33	367	0109670	G56020.5	483	0116142	R5203.8	38	0123072	E513M11X.75NO3	294
0105658	F302M36	367	0109687	G56025.0	483	0116159	R5203.9	38	0124079	E7111.1/2	333
0105672	F302M4	367	0109694	G5606.3	483	0116166	R5204.0	38	0126233	C34610.0	418
0105719	F302M5	367	0111604	L1101	370	0116173	R5204.1	38	0126240	C34611.0	418
0105733	F302M6	367	0111611	L1102A	370	0116180	R5204.2	38	0126257	C34612.0	418
0105740	F302M7	367	0111628	L1102B	370	0116197	R5204.3	38	0126264	C34613.0	418
0105757	F302M8	367	0111635	L1103	370	0116203	R5204.4	38	0126271	C34614.0	418
0108260	G13212.5	488	0111642	L1104	370	0116210	R5204.5	38	0126288	C34615.0	418
0108277	G13216.0	488	0111659	L1105F	370	0116227	R5204.6	38	0126295	C34616.0	418
0108284	G13220.0	488	0111666	L1105	370	0116234	R5204.7	38	0126301	C34618.0	418
0108291	G1328.0	488	0111673	L1106F	370	0116241	R5204.8	38	0126318	C34620.0	418
0108444	G13512.5	480	0111680	L1106	370	0116258	R5204.9	38	0126325	C3467.0	418
0108451	G13516.0	480	0111697	L1107F	370	0116265	R5205.0	38	0126332	C3468.0	418
0108468	G13520.0	480	0111703	L1107	370	0116272	R5205.1	38	0126349	C3469.0	418
0108475	G13525.0	480	0111710	L1108F	370	0116289	R5205.2	38	0127513	E650M10	347
0108482	G1356.3	480	0111727	L1108	370	0116296	R5205.3	38	0127520	E650M12	347
0108499	G1358.0	480	0111734	L1109F	370	0116303	R5205.4	38	0127537	E650M14	347
0108505	G13610.0	483	0111741	L1109	370	0116319	R5205.5	38	0127544	E650M16	347
0108512	G13610.4	483	0111758	L11010F	370	0116326	R5205.6	38	0127551	E650M4	347
0108529	G13611.5	483	0111765	L11010	370	0116333	R5205.7	38	0127568	E650M5	347
0108536	G13612.4	483	0115558	R51010.0	44	0116340	R5205.8	38	0127575	E650M6	347
0108543	G13613.4	483	0115565	R51010.2	44	0116357	R5205.9	38	0127582	E650M8	347
0108550	G13615.0	483	0115572	R51010.4	44	0116364	R5206.0	38	0127711	G5608.0	483
0108567	G13616.5	483	0115589	R51010.5	44	0116371	R5206.1	38	0127728	G5608.3	483
0108574	G13619.0	483	0115596	R51011.0	44	0116388	R5206.2	38	0127735	G56031.0	483
0108581	G13620.5	483	0115602	R51011.5	44	0116395	R5206.3	38	0127957	B170.98	442
0108598	G13623.0	483	0115619	R51012.0	44	0116401	R5206.4	38	0127964	B170.99	442
0108604	G13625.0	483	0115626	R51013.0	44	0116418	R5206.5	38	0127971	B1701.0	442
0108611	G13626.0	483	0115633	R51014.0	44	0116425	R5206.8	38	0127988	B1701.01	442
0108628	G13628.0	483	0115640	R51014.25	44	0116432	R5206.9	38	0127995	B1701.02	442
0108635	G13630.0	483	0115657	R5103.0	44	0116449	R5207.0	38	0128008	B1701.03	442
0108642	G13631.0	483	0115664	R5103.3	44	0116456	R5207.3	38	0128015	B1701.04	442
0108659	G1364.3	483	0115671	R5103.4	44	0116463	R5207.4	38	0128022	B1701.05	442
0108666	G1365.0	483	0115688	R5103.5	44	0116470	R5207.5	38	0128459	B1701.49	442
0108673	G1365.3	483	0115695	R5104.0	44	0116487	R5207.8	38	0128466	B1701.5	442
0108680	G1365.8	483	0115701	R5104.1	44	0116494	R5208.0	38	0128473	B1701.52	442
0108697	G1366.0	483	0115718	R5104.2	44	0116500	R5208.5	38	0128725	G40010.4	476
0108703	G1366.3	483	0115725	R5104.3	44	0116517	R5209.0	38	0128732	G40012.4	476
0108710	G1367.0	483	0115732	R5104.5	44	0116524	R5209.2	38	0128749	G40016.5	476
0108727	G1367.3	483	0115749	R5104.9	44	0116531	R5209.3	38	0128756	G40020.5	476
0108734	G1368.0	483	0115756	R5105.0	44	0116548	R5209.5	38	0128763	G40025.0	476
0108741	G1368.3	483	0115763	R5105.1	44	0121863	A17029/32	176	0128770	G40031.0	476
0108758	G1369.4	483	0115770	R5105.5	44	0121870	A17033/64	176	0128787	G4006.3	476
0108765	G13716.0	489	0115787	R5106.0	44	0121887	A17035/64	176	0128794	G4008.3	476
0108772	G13720.0	489	0115794	R5106.5	44	0121894	A17037/64	176	0128916	B1701.98	442
0108789	G13725.0	489	0115800	R5106.8	44	0121900	A17039/64	176	0128923	B1701.99	442
0108796	G13731.5	489	0115817	R5106.9	44	0121917	A17043/64	176	0128930	B17010.0	442



# EDP NUMBER INDEX - 0128947 - 0136133

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0128947	B17010.01	442	0134276	B1705.5	442	0134689	R45417.8	46	0135112	R4588.2	40
0128954	B17010.02	442	0134283	B1705.51	442	0134689	R45417.8	46	0135129	R4588.4	40
0128961	B17010.03	442	0134290	B1705.52	442	0134696	R45418.0	46	0135129	R4588.4	40
0128978	B17010.04	442	0134306	R4537.7	46	0134696	R45418.0	46	0135136	R4589.4	40
0128985	B17010.05	442	0134306	R4537.7	46	0134702	R45418.5	46	0135136	R4589.4	40
0129463	B17010.49	442	0134313	R4537.9	46	0134702	R45418.5	46	0135143	R4589.7	40
0129470	B17010.51	442	0134313	R4537.9	46	0134719	R45419.0	46	0135143	R4589.7	40
0129487	B17010.52	442	0134320	R4538.2	46	0134719	R45419.0	46	0135150	R4589.9	40
0129883	B17010.98	442	0134320	R4538.2	46	0134726	R45419.5	46	0135150	R4589.9	40
0129890	B17010.99	442	0134337	R4538.4	46	0134726	R45419.5	46	0135167	R45811.4	40
0129906	B17011.0	442	0134337	R4538.4	46	0134733	R45419.8	46	0135167	R45811.4	40
0129913	B17011.01	442	0134344	R4538.9	46	0134733	R45419.8	46	0135174	R45811.6	40
0129920	B17011.02	442	0134344	R4538.9	46	0134740	R45420.0	46	0135174	R45811.6	40
0129937	B17011.03	442	0134351	R4539.4	46	0134740	R45420.0	46	0135181	R45812.8	40
0129944	B17011.04	442	0134351	R4539.4	46	0134757	B1705.98	442	0135181	R45812.8	40
0129951	B17011.05	442	0134368	R4539.9	46	0134764	B1705.99	442	0135198	R45813.8	40
0130384	B17011.49	442	0134368	R4539.9	46	0134771	B1706.0	442	0135198	R45813.8	40
0130391	B17011.5	442	0134375	R45311.4	46	0134788	B1706.01	442	0135204	R45815.8	40
0130407	B17011.51	442	0134375	R45311.4	46	0134795	B1706.02	442	0135204	R45815.8	40
0130414	B17011.52	442	0134382	R45311.6	46	0134801	B1706.03	442	0135211	R45816.5	40
0130865	B17011.98	442	0134382	R45311.6	46	0134818	B1706.04	442	0135211	R45816.5	40
0130872	B17011.99	442	0134399	R45312.8	46	0134825	B1706.05	442	0135228	R45817.0	40
0130889	B17012.0	442	0134399	R45312.8	46	0134832	R4574.4	40	0135228	R45817.0	40
0130896	B1702.0	442	0134405	R45313.8	46	0134832	R4574.4	40	0135235	R45817.5	40
0130902	B1702.01	442	0134405	R45313.8	46	0134849	R4574.8	40	0135235	R45817.5	40
0130919	B1702.02	442	0134412	R45314.8	46	0134849	R4574.8	40	0135242	B1706.49	442
0130926	B1702.03	442	0134412	R45314.8	46	0134856	R4575.2	40	0135259	B1706.5	442
0130933	B1702.04	442	0134429	R45315.8	46	0134856	R4575.2	40	0135266	B17010.5	442
0130940	B1702.05	442	0134429	R45315.8	46	0134863	R4576.2	40	0135273	R45817.8	40
0131367	B1702.49	442	0134436	R45317.8	46	0134863	R4576.2	40	0135273	R45817.8	40
0131374	B1702.5	442	0134436	R45317.8	46	0134870	R4576.4	40	0135280	R45818.0	40
0131381	B1702.51	442	0134443	R45319.8	46	0134870	R4576.4	40	0135280	R45818.0	40
0131398	B1702.52	442	0134443	R45319.8	46	0134887	R4576.7	40	0135297	R45818.5	40
0131848	B1702.98	442	0134450	R4544.4	46	0134887	R4576.7	40	0135297	R45818.5	40
0131855	B1702.99	442	0134450	R4544.4	46	0134894	R4577.7	40	0135303	B1706.51	442
0131862	B1703.0	442	0134467	R4544.8	46	0134894	R4577.7	40	0135310	B1706.52	442
0131879	B1703.02	442	0134467	R4544.8	46	0134900	R4577.9	40	0135327	R45819.0	40
0131886	B1703.03	442	0134474	R4544.9	46	0134900	R4577.9	40	0135327	R45819.0	40
0131893	B1703.04	442	0134474	R4544.9	46	0134917	R4578.2	40	0135334	R45819.5	40
0131909	B1703.05	442	0134481	R4545.2	46	0134917	R4578.2	40	0135334	R45819.5	40
0132302	B1703.49	442	0134481	R4545.2	46	0134924	R4578.4	40	0135341	R45819.8	40
0132319	B1703.5	442	0134498	R4546.2	46	0134924	R4578.4	40	0135341	R45819.8	40
0132326	B1703.51	442	0134498	R4546.2	46	0134931	R4578.9	40	0135358	R45820.0	40
0132333	B1703.52	442	0134504	R4546.4	46	0134931	R4578.9	40	0135358	R45820.0	40
0132784	B1703.98	442	0134504	R4546.4	46	0134948	R4579.4	40	0135709	EP00M3	259
0132791	B1703.99	442	0134511	R4547.7	46	0134948	R4579.4	40	0135716	EP00M3DIN376	259
0132807	B1704.0	442	0134511	R4547.7	46	0134955	R4579.9	40	0135723	EP00M3.5	259
0132814	B1704.01	442	0134528	R4547.9	46	0134955	R4579.9	40	0135730	EP00M4	259
0132821	B1704.02	442	0134528	R4547.9	46	0134962	R45711.4	40	0135747	EP00M4DIN376	259
0132838	B1704.03	442	0134535	R4548.2	46	0134962	R45711.4	40	0135754	EP00M4.5	259
0132845	B1704.04	442	0134535	R4548.2	46	0134979	R45711.6	40	0135761	B1706.98	442
0132852	B1704.05	442	0134542	R4548.4	46	0134979	R45711.6	40	0135778	B1706.99	442
0133286	B1704.49	442	0134542	R4548.4	46	0134986	R45712.8	40	0135785	B1707.0	442
0133293	B1704.5	442	0134559	R4548.9	46	0134986	R45712.8	40	0135792	B1707.01	442
0133309	B1704.51	442	0134559	R4548.9	46	0134993	R45713.8	40	0135808	B1707.02	442
0133316	B1704.52	442	0134566	R4549.4	46	0134993	R45713.8	40	0135815	B1707.03	442
0133767	B1704.98	442	0134566	R4549.4	46	0135006	R45714.8	40	0135822	B1707.04	442
0133774	B1704.99	442	0134573	R4549.7	46	0135006	R45714.8	40	0135839	B1707.05	442
0133781	B1705.0	442	0134573	R4549.7	46	0135013	R4584.4	40	0135846	EP00M5	259
0133798	B1705.01	442	0134580	R4549.9	46	0135013	R4584.4	40	0135853	EP00M5DIN376	259
0133804	B1705.02	442	0134580	R4549.9	46	0135020	R4584.7	40	0135860	EP00M6	259
0133811	B1705.03	442	0134597	R45411.4	46	0135020	R4584.7	40	0135877	EP00M6DIN376	259
0133828	B1705.04	442	0134597	R45411.4	46	0135037	R4584.8	40	0135884	EP00M7	259
0133835	B1705.05	442	0134603	R45411.6	46	0135037	R4584.8	40	0135891	EP00M8	259
0134191	R4534.4	46	0134603	R45411.6	46	0135044	R4584.9	40	0135907	EP00M8DIN376	259
0134191	R4534.4	46	0134610	R45412.8	46	0135044	R4584.9	40	0135914	EP00M10	259
0134207	R4534.8	46	0134610	R45412.8	46	0135051	R4585.2	40	0135921	EP00M10DIN376	259
0134207	R4534.8	46	0134627	R45413.8	46	0135051	R4585.2	40	0135938	EP00M12	259
0134214	R4534.9	46	0134627	R45413.8	46	0135068	R4586.2	40	0135945	EP00M14	259
0134214	R4534.9	46	0134634	R45414.8	46	0135068	R4586.2	40	0135952	EP00M16	259
0134221	R4535.2	46	0134634	R45414.8	46	0135075	R4586.4	40	0135969	EP00M18	259
0134221	R4535.2	46	0134641	R45415.8	46	0135075	R4586.4	40	0135976	EP00M20	259
0134238	R4536.2	46	0134641	R45415.8	46	0135082	R4586.7	40	0135983	EP00M22	259
0134238	R4536.2	46	0134658	R45416.5	46	0135082	R4586.7	40	0135990	EP00M24	259
0134245	R4536.4	46	0134658	R45416.5	46	0135099	R4587.7	40	0136003	EP00M27	259
0134245	R4536.4	46	0134665	R45417.0	46	0135099	R4587.7	40	0136010	EP00M30	259
0134252	R4536.7	46	0134665	R45417.0	46	0135105	R4587.9	40	0136119	EP01M3	259
0134252	R4536.7	46	0134672	R45417.5	46	0135105	R4587.9	40	0136126	EP01M3DIN376	259
0134269	B1705.49	442	0134672	R45417.5	46	0135112	R4588.2	40	0136133	EP01M3.5	259

# EDP NUMBER INDEX - 0136140 - 0148532

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0136140	..EP01M4	259	0137130	..EX01M27	273	0137925	..EP11M22X1.5	260	0138717	..B1709.98	442
0136157	..EP01M4DIN376	259	0137147	..EX01M30	273	0137932	..EP11M24X1.5	260	0138724	..B1709.99	442
0136164	..EP01M4.5	259	0137154	..EX01M33	273	0137949	..EP11M24X2.0	260	0139950	..E500M1.6NO2	292
0136171	..EP01M5	259	0137161	..EX01M36	273	0137956	..EP11M25X1.5	260	0139967	..E500M7NO2	292
0136188	..EP01M5DIN376	259	0137178	..EX01M39	273	0137963	..EP11M26X1.5	260	0140314	..B1006.5	468
0136195	..EP01M6	259	0137185	..EX01M42	273	0137970	..EP11M27X1.5	260	0140321	..B1007.5	468
0136201	..EP01M6DIN376	259	0137192	..EX01M48	273	0137987	..EP11M27X2.0	260	0140338	..B1008.5	468
0136218	..EP01M7	259	0137208	..EX01M52	273	0137994	..EP11M28X1.5	260	0140345	..B1009.5	468
0136225	..EP01M8	259	0137215	..EX01M56	273	0138007	..EP11M30X1.5	260	0140352	..B15713.0	452
0136232	..EP01M8DIN376	259	0137222	..EX01M64	273	0138014	..EP11M30X2.0	260	0140369	..B15714.0	452
0136249	..EP01M10	259	0137239	..EP00M2	259	0138021	..EP204-40	255	0140376	..B15715.0	452
0136256	..EP01M10DIN376	259	0137246	..EP00M2.5	259	0138038	..EP205-40	255	0140383	..B15716.0	452
0136263	..EP01M12	259	0137253	..EP01M2	259	0138045	..EP206-32	255	0140390	..B15717.0	452
0136270	..B1707.49	442	0137260	..B1708.49	442	0138052	..EP208-32	255	0140406	..B15718.0	452
0136287	..B1707.5	442	0137277	..B1708.5	442	0138069	..EP2010-24	255	0140413	..B15719.0	452
0136294	..B1707.51	442	0137284	..B1708.52	442	0138076	..EP2012-24	255	0140420	..B15720.0	452
0136300	..B1707.52	442	0137291	..EP01M2.5	259	0138083	..EP201/4	255	0140819	..B33413	463
0136317	..EP01M14	259	0137307	..EX00M2	273	0138090	..EP205/16	255	0140826	..B33414	463
0136324	..EP01M16	259	0137314	..EX00M2.5	273	0138106	..EP203/8	255	0140833	..B33415	463
0136331	..EP01M18	259	0137321	..EX01M2	273	0138113	..EP207/16	255	0140840	..B33416	463
0136348	..EP01M20	259	0137338	..EX01M2.5	273	0138120	..EP201/2	255	0144152	..B4003.0	437
0136355	..EP01M22	259	0137345	..EP10M4X.5	260	0138137	..EP205/8	255	0144169	..B4003.2	437
0136362	..EP01M24	259	0137352	..EP10M5X.5	260	0138144	..EP203/4	255	0144176	..B4003.5	437
0136379	..EP01M27	259	0137369	..EP10M6X.75	260	0138151	..EP207/8	255	0144183	..B4004.0	437
0136386	..EP01M30	259	0137376	..EP10M8X.75	260	0138168	..EP201	255	0144190	..B4004.5	437
0136591	..EX00M3	273	0137383	..EP10M8X1.0	260	0138175	..EP214-40	255	0144206	..B4005.0	437
0136607	..EX00M3.5	273	0137390	..EP10M10X.75	260	0138182	..EP215-40	255	0144213	..B4005.5	437
0136614	..EX00M4	273	0137406	..EP10M10X1.0	260	0138199	..EP216-32	255	0144220	..B4006.0	437
0136621	..EX00M5	273	0137413	..EP10M10X1.25	260	0138205	..EP218-32	255	0144237	..B4006.5	437
0136638	..EX00M6	273	0137420	..EP10M12X1.0	260	0138212	..EP2110-24	255	0144244	..B4007.0	437
0136645	..EX00M6DIN376	273	0137437	..EP10M12X1.25	260	0138229	..EP2112-24	255	0144251	..B4008.0	437
0136652	..EX00M7	273	0137444	..EP10M12X1.5	260	0138236	..B1709.49	442	0144268	..B4009.0	437
0136669	..EX00M8	273	0137451	..EP10M14X1.0	260	0138243	..B1709.5	442	0144275	..B4010.0	437
0136676	..EX00M8DIN376	273	0137468	..EP10M14X1.25	260	0138250	..B1709.51	442	0144282	..B4011.0	437
0136683	..EX00M10	273	0137475	..EP10M14X1.5	260	0138267	..B1709.52	442	0144299	..B4012.0	437
0136690	..EX00M10DIN376	273	0137482	..EP10M16X1.0	260	0138274	..EP211/4	255	0144305	..B4016.0	437
0136706	..EX00M12	273	0137499	..EP10M16X1.5	260	0138281	..EP215/16	255	0144312	..B4018.0	437
0136713	..EX00M14	273	0137505	..EP10M18X1.0	260	0138298	..EP213/8	255	0144329	..B4020.0	437
0136720	..EX00M16	273	0137512	..EP10M18X1.5	260	0138304	..EP217/16	255	0144336	..B41117.0	439
0136737	..EX00M18	273	0137529	..EP10M20X1.0	260	0138311	..EP211/2	255	0144343	..B41118.0	439
0136744	..EX00M20	273	0137536	..EP10M20X1.5	260	0138328	..EP215/8	255	0144350	..B41119.0	439
0136751	..B1707.98	442	0137543	..EP10M22X1.5	260	0138335	..EP213/4	255	0144367	..B41120.0	439
0136768	..B1707.99	442	0137550	..EP10M24X1.5	260	0138342	..EP217/8	255	0144374	..B41122.0	439
0136775	..B1708.01	442	0137567	..EP10M24X2.0	260	0138359	..EP211	255	0144381	..B41124.0	439
0136782	..B1708.02	442	0137574	..EP10M25X1.5	260	0138366	..EP308-36	255	0144398	..B41125.0	439
0136799	..B1708.03	442	0137581	..EP10M26X1.5	260	0138373	..EP3010-32	255	0144404	..B41126.0	439
0136805	..B1708.04	442	0137598	..EP10M27X1.5	260	0138380	..EP301/4	255	0144411	..B41130.0	439
0136812	..B1708.05	442	0137604	..EP10M27X2.0	260	0138397	..EP305/16	255	0144589	..B33513BLADES	464
0136829	..EX00M22	273	0137611	..EP10M28X1.5	260	0138403	..EP303/8	255	0144596	..B33514BLADES	464
0136836	..EX00M24	273	0137628	..EP10M30X1.5	260	0138410	..EP307/16	255	0144602	..B33515BLADES	464
0136843	..EX00M27	273	0137635	..EP10M30X2.0	260	0138427	..EP301/2	255	0144619	..B33516BLADES	464
0136850	..EX00M30	273	0137642	..EP11M4X.5	260	0138434	..EP305/8	255	0144626	..B3350NUT	464
0136867	..EX00M33	273	0137659	..EP11M5X.5	260	0138441	..EP303/4	255	0144633	..B33500NUT	464
0136874	..EX00M36	273	0137666	..EP11M6X.75	260	0138458	..EP307/8	255	0144640	..B335000NUT	464
0136881	..EX00M39	273	0137673	..EP11M8X.75	260	0138465	..EP301	255	0144657	..B3351NUT	464
0136898	..EX00M42	273	0137680	..EP11M8X1.0	260	0138472	..EP318-36	255	0144664	..B3352NUT	464
0136904	..EX00M48	273	0137697	..EP11M10X.75	260	0138489	..EP3110-32	255	0144671	..B3353NUT	464
0136911	..EX00M52	273	0137703	..EP11M10X1.0	260	0138496	..EP311/4	255	0144688	..B3354NUT	464
0136928	..EX00M56	273	0137710	..EP11M10X1.25	260	0138502	..EP315/16	255	0144695	..B3355NUT	464
0136935	..EX00M64	273	0137727	..EP11M12X1.0	260	0138519	..EP313/8	255	0144701	..B3356NUT	464
0136942	..EX01M3	442	0137734	..B1708.98	442	0138526	..EP317/16	255	0144718	..B3357NUT	464
0136959	..B1708.0	442	0137741	..B1708.99	442	0138533	..EP311/2	255	0144725	..B3358NUT	464
0136966	..EX01M3.5	273	0137758	..B1709.0	442	0138540	..EP315/8	255	0144732	..B3359NUT	464
0136973	..EX01M4	273	0137765	..B1709.01	442	0138557	..EP313/4	255	0144749	..B33510NUT	464
0136980	..EX01M5	273	0137772	..B1709.02	442	0138564	..EP317/8	255	0144756	..B33511NUT	464
0136997	..EX01M6	273	0137789	..B1709.03	442	0138571	..EP311	255	0144763	..B33512NUT	464
0137000	..EX01M6DIN376	273	0137796	..B1709.04	442	0138588	..EP401/8	283	0144770	..B33513NUT	464
0137017	..EX01M7	273	0137802	..B1709.05	442	0138595	..EP401/4	283	0144787	..B33514NUT	464
0137024	..EX01M8	273	0137819	..EP11M12X1.25	260	0138601	..EP403/8	283	0144794	..B33515NUT	464
0137031	..EX01M8DIN376	273	0137826	..EP11M12X1.5	260	0138618	..EP401/2	283	0144800	..B33516NUT	464
0137048	..EX01M10	273	0137833	..EP11M14X1.0	260	0138625	..EP405/8	283	0144817	..G13510.0	480
0137055	..EX01M10DIN376	273	0137840	..EP11M14X1.25	260	0138632	..EP403/4	283	0147054	..EP413/4	283
0137062	..EX01M12	273	0137857	..EP11M14X1.5	260	0138649	..EP407/8	283	0148433	..A53033.0	167
0137079	..EX01M14	273	0137864	..EP11M16X1.0	260	0138656	..EP401	283	0148457	..A53035.0	167
0137086	..EX01M16	273	0137871	..EP11M16X1.5	260	0138663	..EP411/8	283	0148471	..A53040.0	167
0137093	..EX01M18	273	0137888	..EP11M18X1.0	260	0138670	..EP411/4	283	0148501	..A9762.0X125	71
0137109	..EX01M20	273	0137895	..EP11M18X1.5	260	0138687	..EP413/8	283	0148518	..A9762.2X135	71
0137116	..EX01M22	273	0137901	..EP11M20X1.0	260	0138694	..EP411/2	283	0148525	..A9762.5X140	71
0137123	..EX01M24	273	0137918	..EP11M20X1.5	260	0138700	..EP415/8	283	0148532	..A9763.0X150	71

# EDP NUMBER INDEX - 0148549 - 0157183

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0148549	.A9763.3X155	71	0149737	.EX10M10X1.25	274	0150757	.E5473/4NO2	340	0154885	.E500M2.3NO1	292
0148556	.A9763.5X165	71	0149744	.EX10M12X1.0	274	0151945	.EX213/8	269	154908	.E500M2.2NO6	292
0148563	.A9763.7X165	71	0149751	.EX10M12X1.25	274	0152119	.E500M9NO2	292	0154915	.E500M2.2NO1	292
0148570	.A9764.0X175	71	0149768	.EX10M12X1.5	274	0152225	.E500M33NO2	292	0154939	.E500M2NO6	292
0148587	.A9764.5X185	71	0149775	.EX10M14X1.0	274	0152232	.E500M39NO2	292	0154960	.E500M1.8NO1	292
0148594	.A9765.0X195	71	0149782	.EX10M14X1.25	274	0152249	.E500M42NO2	292	0154977	.E500M1.7NO8	292
0148600	.A9765.5X205	71	0149799	.EX10M14X1.5	274	0152256	.E500M45NO2	292	0154991	.E500M1.7NO6	292
0148617	.A9766.0X205	71	0149805	.EX10M16X1.0	274	0152263	.E500M48NO2	292	0155004	.E500M1.7NO1	292
0148624	.A9766.5X215	71	0149812	.EX10M16X1.5	274	0152447	.E501M24NO2	300	0155028	.E500M1.6NO6	292
0148631	.A9767.0X225	71	0149829	.EX10M18X1.0	274	0152454	.E513M4X.5NO2	294	0155035	.E500M1.6NO1	292
0148648	.A9767.5X225	71	0149836	.EX10M18X1.5	274	0152461	.E513M6X.75NO2	294	0155431	.E513M22X1.5NO7	294
0148693	.A9768.0X240	71	0149843	.EX10M20X1.0	274	0152478	.E513M8X.75NO2	294	0155448	.E513M22X1.0NO7	294
0148662	.A9768.5X240	71	0149850	.EX10M20X1.5	274	0152485	.E513M8X1.0NO2	294	0155455	.E513M20X2.0NO7	294
0148679	.A9769.0X250	71	0149867	.EX10M22X1.5	274	0152492	.E513M10X1.0NO2	294	0155462	.E513M20X1.5NO7	294
0148686	.A9769.5X250	71	0149874	.EX10M24X1.5	274	0152508	.E513M10X1.25NO2	294	0155479	.E513M18X1.5NO7	294
0148709	.A9769.5X250	71	0149881	.EX10M24X2.0	274	0152515	.E513M12X1.5NO2	294	0155486	.E513M14X1.5NO7	294
0148716	.A9770.0X265	71	0149888	.EX10M24X2.0	274	0152522	.E513M12X1.25NO2	294	0155493	.E513M14X1.25NO7	294
0148709	.A9773.0X190	71	0149898	.EX10M25X1.5	274	0152539	.E513M14X1.0NO2	294	0155509	.E513M14X1.0NO7	294
0148723	.A9773.5X210	71	0149904	.EX10M26X1.5	274	0152546	.E513M14X1.25NO2	294	0155516	.E513M12X1.5NO7	294
0148730	.A9774.0X220	71	0149911	.EX10M27X1.5	274	0152553	.E513M14X1.5NO2	294	0155523	.E513M12X1.0NO7	294
0148747	.A9774.5X235	71	0149928	.EX10M27X2.0	274	0152560	.E513M16X1.0NO2	294	0155530	.E513M10X1.25NO7	294
0148747	.A9775.0X245	71	0149935	.EX10M28X1.5	274	0152577	.E513M16X1.5NO2	294	0155547	.E513M10X1.0NO7	294
0148754	.A9775.5X260	71	0149942	.EX10M30X1.5	274	0152584	.E513M18X1.5NO2	294	0155554	.E513M8X1.0NO7	294
0148761	.A9776.0X260	71	0149959	.EX10M30X2.0	274	0152591	.E513M20X1.5NO2	294	0155561	.E513M4X.5NO7	294
0148778	.A9776.5X275	71	0149966	.EX11M4X.50	274	0152607	.E513M22X1.5NO2	294	0155578	.E513M32X1.5NO2	294
0148785	.A9777.0X290	71	0149973	.EX11M5X.50	274	0152614	.E513M24X1.5NO2	294	0155660	.E513M50X1.5NO2	294
0148792	.A9777.5X290	71	0149980	.EX11M6X.75	274	0152621	.E513M25X1.5NO2	294	0155677	.E513M45X1.5NO2	294
0148808	.A9778.0X305	71	0149997	.EX11M8X.75	274	0152638	.E513M36X2.0NO2	294	0155684	.E513M42X1.5NO2	294
0148815	.A9778.5X305	71	0150009	.EX11M8X1.0	274	0152645	.E513M39X3.0NO2	294	0155691	.E513M40X1.5NO2	294
0148822	.A9779.0X320	71	0150016	.EX11M10X.75	274	0152980	.E500M14NO1	292	0155721	.E513M30X2.0NO2	294
0148839	.A9779.5X320	71	0150023	.EX11M10X1.0	274	0153246	.E500M10NO1	292	0155738	.E513M27X1.5NO2	294
0148846	.A9779.5X320	71	0150030	.EX11M10X1.25	274	0154298	.E500M48NO1	292	0155745	.E513M24X2.0NO7	294
0148853	.A9783.5X265	71	0150047	.EX11M12X1.0	274	0154304	.E500M45NO1	292	0155752	.E513M9X1.0NO2	294
0148860	.A9784.0X280	71	0150054	.EX11M12X1.25	274	0154311	.E500M42NO1	292	0155728	.E513M5X.5NO1	294
0148877	.A9784.5X295	71	0150061	.EX11M12X1.5	274	0154328	.E500M39NO1	292	0156735	.E500M2.6NO1	292
0148884	.A9785.0X315	71	0150078	.EX11M14X1.0	274	0154335	.E500M36NO1	292	0156742	.E500M2.6NO2	292
0148891	.A9785.5X330	71	0150085	.EX11M14X1.25	274	0154342	.E500M33NO1	292	0156766	.E513M4X.5NO1	294
0148907	.A9786.0X330	71	0150092	.EX11M14X1.5	274	0154359	.E500M30NO1	292	0156773	.E513M5X.75NO2	294
0148914	.A9786.5X350	71	0151018	.EX11M16X1.0	274	0154366	.E500M27NO1	292	0156780	.E513M6X.5NO1	294
0148921	.A9787.0X370	71	0150115	.EX11M16X1.5	274	0154380	.E500M24NO7	292	0156797	.E513M6X.5NO2	294
0148938	.A9787.5X370	71	0150122	.EX11M18X1.0	274	0154397	.E500M24NO6	292	0156803	.E513M6X.75NO1	294
0148945	.A9788.0X390	71	0150139	.EX11M18X1.5	274	0154403	.E500M24NO1	292	0156810	.E513M14X1.0NO1	294
0148952	.A9788.5X390	71	0150146	.EX11M20X1.0	274	0154427	.E500M22NO6	292	0156827	.E513M14X1.25NO1	294
0148969	.A9789.0X410	71	0150153	.EX11M20X1.5	274	0154434	.E500M22NO1	292	0156834	.E513M14X1.25NO6	294
0148976	.A9789.5X410	71	0150160	.EX11M22X1.5	274	0154441	.E500M20NO7	292	0156841	.E513M14X1.5NO1	294
0148983	.A9789.5X410	71	0150177	.EX11M24X1.5	274	0154458	.E500M20NO6	292	0156858	.E513M14X1.5NO6	294
0148990	.A9789.5X430	71	0150184	.EX11M24X2.0	274	0154465	.E500M20NO1	292	0156865	.E513M16X1.0NO1	294
0148990	.R5103.2	44	0150191	.EX11M25X1.5	274	0154489	.E500M18NO6	292	0156872	.E513M16X1.5NO1	294
0149003	.R5108.7	44	0150207	.EX11M26X1.5	274	0154496	.E500M18NO1	292	0156889	.E513M16X1.5NO6	294
0149027	.A10111.0	90	0150214	.EX11M27X1.5	274	0154502	.E500M16NO7	292	0156896	.E513M18X1.0NO1	294
0149133	.A19131M	205	0150221	.EX11M27X2.0	274	0154519	.E500M16NO6	292	0156902	.E513M18X1.5NO1	294
0149270	.G1426.3	484	0150238	.EX11M28X1.5	274	0154526	.E500M16NO1	292	0156919	.E513M18X1.5NO6	294
0149287	.G14210.4	484	0150245	.EX11M30X1.5	274	0154533	.E500M14NO7	292	0156926	.E513M18X2.0NO1	294
0149294	.G14212.4	484	0150252	.EX11M30X2.0	274	0154540	.E500M14NO6	292	0156933	.E513M20X1.0NO1	294
0149300	.G14216.5	484	0150269	.EX204-40	269	0154557	.E500M12NO7	292	0156940	.E513M20X1.5NO1	294
0149317	.G14220.5	484	0150276	.EX205-40	269	0154564	.E500M12NO1	292	0156957	.E513M20X1.5NO6	294
0149324	.G14225.0	484	0150283	.EX206-32	269	0154588	.E500M11NO6	292	0156964	.E513M20X2.0NO1	294
0149331	.G14231.0	484	0150290	.EX208-32	269	0154595	.E500M11NO1	292	0156971	.E513M22X1.5NO1	294
0149348	.G1546.3	481	0150306	.EX209-32	269	0154601	.E500M10NO7	292	0156988	.E513M22X2.0NO1	294
0149355	.G1548.3	481	0150313	.EX210-24	269	0154618	.E500M10NO6	292	0156995	.E513M24X1.5NO1	294
0149362	.G15410.4	481	0150320	.EX2012-24	269	0154632	.E500M9NO6	292	0157008	.E513M24X2.0NO1	294
0149379	.G15412.4	481	0150337	.EX205/16	269	0154649	.E500M9NO1	292	0157015	.E513M25X1.5NO1	294
0149386	.G15416.5	481	0150344	.EX203/8	269	0154656	.E500M8NO7	292	0157022	.E513M25X1.5NO6	294
0149393	.G15420.5	481	0150351	.EX207/16	269	0154663	.E500M8NO1	292	0157039	.E513M32X1.5NO1	294
0149409	.G15425.0	481	0150368	.EX201/2	269	0154687	.E500M7NO1	292	0157046	.E513M5X.75NO1	294
0149546	.G3356.3	480	0150375	.EX205/8	269	0154694	.E500M6NO7	292	0157053	.E513M8X.75NO1	294
0149553	.G3358.0	480	0150382	.EX203/4	269	0154700	.E500M6NO6	292	0157060	.E513M8X1.0NO1	294
0149560	.G33510.0	480	0150399	.EX207/8	269	0154717	.E500M5NO7	292	0157077	.E513M10X1.0NO1	294
0149577	.G33512.5	480	0150405	.EX201	269	0154724	.E500M5NO6	292	0157084	.E513M10X1.0NO6	294
0149584	.G33516.0	480	0150412	.EX214-40	269	0154731	.E500M5NO1	292	0157091	.E513M10X1.25NO1	294
0149591	.G33520.0	480	0150429	.EX215-40	269	0154755	.E500M4.5NO6	292	0157107	.E513M10X1.25NO6	294
0149607	.G33525.0	480	0150436	.EX216-32	269	0154762	.E500M4.5NO1	292	0157114	.E513M12X1.0NO1	294
0149645	.EP417/8	283	0150443	.EX218-32	269	0154779	.E500M4NO7	292	0157121	.E513M12X1.25NO1	294
0149652	.EP411	283	0150450	.EX2110-24	269	0154786	.E500M4NO1	292	0157138	.E513M12X1.25NO6	294
0149669	.EX10M4X.50	274	0150467	.EX2112-24	269	0154809	.E500M3.5NO6	292	0157145	.E513M12X1.5NO1	294
0149676	.EX10M5X.50	274	0150474	.EX211/4	269	0154816	.E500M3NO7	292	0157152	.E513M12X1.5NO6	294
0149683	.EX10M6X.75	274	0150481	.EX215/16	269	0154823	.E500M3NO1	292	0157169	.E5471/8NO1	340
0149690	.EX10M8X.75	274	0150568	.G1428.3	484	0154847	.E500M2.5NO6	292	0157176	.E5471/8NO2	340
0149706	.EX10M8X1.0	274	0150719	.E500M20NO2	292	0154854	.E500M2.5NO1	292	0157183	.E5471/8NO7	340
0149713	.EX10M10X.75	274	0150740	.E513M25X1.5NO7	294						
0149720	.EX10M10X1.0	274									

# EDP NUMBER INDEX - 0157190 - 0179826

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0157190	E5471/4NO1	340	0164754	F201M18	364	0169063	A51017/64	60	0173848	A12511/64X200	149
0157206	E5471/4NO2	340	0164761	F201M20	364	0169070	A5109/32	60	0173855	A1253/16X160	149
0157213	E5471/4NO7	340	0165607	E201M3	265	0169087	A51019/64	60	0173862	A1253/16X200	149
0157220	E5473/8NO1	340	0167861	E650M3	347	0169094	A5105/16	60	0173879	A1253/16X250	149
0157237	E5473/8NO2	340	0168059	G1424.8	484	0169100	A51021/64	60	0173886	A1253/16X315	149
0157244	E5473/8NO7	340	0168066	G1425.0	484	0169117	A51011/32	60	0173893	A1253/16X400	149
0157251	E5471/2NO1	340	0168073	G1426.0	484	0169124	A51023/64	60	0173909	A12513/64X200	149
0157268	E5471/2NO2	340	0168080	G1427.0	484	0169131	A5103/8	60	0173916	A12513/64X250	149
0157275	E5471/2NO7	340	0168097	G1427.3	484	0169148	A51025/64	60	0173923	A12513/64X315	149
0157282	E5475/8NO1	340	0168103	G1428.0	484	0169155	A51013/32	60	0173930	A1257/32X200	149
0157299	E5473/4NO1	340	0168110	G14210.0	484	0169162	A51027/64	60	0173947	A1257/32X250	149
0157305	E5477/8NO1	340	0168127	G14211.5	484	0169179	A5107/16	60	0173954	A1257/32X315	149
0157312	E5471NO1	340	0168134	G14215.0	484	0169186	A51029/64	60	0173961	A12515/64X200	149
0157329	E5471NO2	340	0168141	G14219.0	484	0169193	A51015/32	60	0173978	A12515/64X250	149
0157336	E5471.1/4NO1	340	0168158	G14223.0	484	0169209	A51031/64	60	0173985	A1251/4X200	149
0157343	E5471.1/2NO1	340	0168318	EX211	269	0169216	A5101/2	60	0173992	A1251/4X250	149
0157367	E5472NO1	340	0168325	EX308-36	269	0171264	A5201/8	53	0174005	A1251/4X315	149
0157374	E5472NO2	340	0168332	EX3010-32	269	0171271	A5209/64	53	0174012	A1251/4X400	149
0159408	E5501/8NO7	339	0168349	EX301/4	269	0171288	A5205/32	53	0174029	A1251/4X500	149
0159422	E5501/4NO7	339	0168356	EX305/16	269	0171295	A52011/64	53	0174036	A12517/64X200	149
0159446	E5503/8NO7	339	0168363	EX303/8	269	0171301	A5203/16	53	0174043	A12517/64X250	149
0159460	E5501/2NO7	339	0168370	EX307/16	269	0171318	A52013/64	53	0174050	A1259/32X200	149
0159484	E5503/4NO7	339	0168387	EX301/2	269	0171325	A5207/32	53	0174067	A1259/32X250	149
0159491	E7101/16NO3	327	0168394	EX305/8	269	0171332	A52015/64	53	0174074	A1259/32X315	149
0159507	EX217/16	269	0168400	EX303/4	269	0171349	A5201/4	53	0174081	A1255/16X200	149
0159514	EX211/2	269	0168417	EX307/8	269	0171356	A52017/64	53	0174098	A1255/16X250	149
0159552	EX215/8	269	0168424	EX301	269	0171363	A5209/32	53	0174104	A1255/16X315	149
0159576	EX213/4	269	0168431	EX318-36	269	0171370	A52019/64	53	0174111	A1255/16X400	149
0159590	EX217/8	269	0168448	EX3110-32	269	0171387	A5205/16	53	0174128	A1255/16X500	149
0159644	E513M9X1.0NO1	294	0168455	EX311/4	269	0171394	A52021/64	53	0174135	A12521/64X315	149
0159651	E513M11X1.0NO1	294	0168462	EX315/16	269	0171400	A52011/32	53	0174142	A12513/32X250	149
0159828	E501M3NO1	300	0168479	EX313/8	269	0171417	A52023/64	53	0174159	A12511/32X315	149
0159835	E501M4NO1	300	0168486	EX317/16	269	0171424	A5203/8	53	0174166	A12511/32X400	149
0159859	E501M6NO1	300	0168493	EX311/2	269	0171431	A52025/64	53	0174180	A12523/64X315	149
0159866	E501M8NO1	300	0168509	EX315/8	269	0171448	A52013/32	53	0174197	A1253/8X250	149
0159873	E501M10NO1	300	0168516	EX313/4	269	0171455	A52027/64	53	0174203	A1253/8X315	149
0159880	E501M12NO1	300	0168523	EX317/8	269	0171462	A5207/16	53	0174210	A1253/8X400	149
0159897	E501M14NO1	300	0168530	EX311	269	0171479	A52029/64	53	0174227	A1253/8X500	149
0159903	E501M16NO1	300	0168547	EX401/8	285	0171486	A52015/32	53	0174234	A12513/32X250	149
0159910	E501M20NO1	300	0168554	EX401/4	285	0171493	A52031/64	53	0174241	A12513/32X315	149
0159927	E500M3X.6NO1	292	0168561	EX403/8	285	0171509	A5201/2	53	0174265	A1257/16X250	149
0159934	E500M3X.6NO2	292	0168578	EX401/2	285	0172728	A1701.1/32	176	0174272	A1257/16X315	149
0159941	E500M3X.6NO3	292	0168585	EX405/8	285	0172735	A1701.1/16	176	0174289	A1257/16X400	149
0159958	E500M5X.9NO1	292	0168592	EX403/4	285	0172759	A1701.1/8	176	0174296	A12515/32X250	149
0159965	E500M5X.9NO2	292	0168608	EX407/8	285	0172766	A1701.5/32	176	0174302	A12515/32X315	149
0159972	E500M5X.9NO3	292	0168615	EX401	285	0172773	A1701.3/16	176	0174319	A1251/2X250	149
0159989	E500M5X.9NO6	292	0168622	EX401.1/8	285	0172780	A1701.7/32	176	0174326	A1251/2X315	149
0159996	E500M5.5X.9NO1	292	0168639	EX401.1/4	285	0172797	A1701.1/4	176	0174333	A1251/2X400	149
0160008	E500M5.5X.9NO2	292	0168646	EX401.1/2	285	0172803	A1701.5/16	176	0174340	A1251/2X500	149
0160015	E500M5.5X.9NO3	292	0168653	EX411/8	285	0172810	A1701.3/8	176	0179413	A1903	205
0160039	E513M3X.35NO1	294	0168660	EX411/4	285	0172827	A1701.7/16	176	0179437	A19012	205
0160046	E513M3X.35NO2	294	0168677	EX413/8	285	0172834	A1701.1/2	176	0179451	A19018	205
0160053	E513M7X.75NO1	294	0168684	EX411/2	285	0172988	A225BS1	197	0179468	A19020	205
0160060	E513M8X.5NO1	294	0168691	EX415/8	285	0172995	A225BS2	197	0179482	A190209	205
0160077	E513M8X.5NO2	294	0168707	EX413/4	285	0173008	A225BS3	197	0179499	A19161-80	205
0160084	E513M10X.75NO1	294	0168714	EX417/8	285	0173015	A225BS4	197	0179598	B1001/16	468
0160091	E513M10X.75NO2	294	0168721	EX411	285	0173022	A225BS5	197	0179604	B1005/64	468
0160107	E513M11X.75NO1	294	0168738	EX411.1/8	285	0173039	A225BS5A	197	0179611	B1003/32	468
0160114	E513M11X.75NO2	294	0168745	EX411.1/4	285	0173046	A225BS6	197	0179628	B1007/64	468
0160152	E500M1NO1	292	0168752	EX411.1/2	285	0173053	A225BS7	197	0179635	B1001/8	468
0160169	E500M1NO2	292	0168769	E000M1.6	261	0173657	A1251/16X125	149	0179642	B1009/64	468
0160176	E500M1.2NO1	292	0168776	E000M2	261	0173664	A1251/16X160	149	0179659	B1005/32	468
0160183	E500M1.2NO2	292	0168783	E000M2.5	261	0173671	A1255/64X125	149	0179666	B10011/64	468
0160190	E500M1.4NO1	292	0168790	E001M1.6	261	0173688	A1255/64X160	149	0179673	B1003/16	468
0160206	E500M1.4NO2	292	0168806	E001M2	261	0173695	A1253/32X125	149	0179680	B10013/64	468
0160213	E500M4X.75NO1	292	0168813	E001M2.5	261	0173701	A1253/32X160	149	0179697	B1007/32	468
0160220	E500M4X.75NO2	292	0168820	E002M2	275	0173718	A1257/64X125	149	0179703	B10015/64	468
0160237	E500M4X.75NO3	292	0168837	E002M2.5	275	0173725	A1257/64X160	149	0179710	B1001/4	468
0160244	E500M2X.45NO1	292	0168844	E003M2	275	0173732	A12511/8X160	149	0179727	B10017/64	468
0160251	E500M2X.45NO2	292	0168851	E003M2.5	275	0173749	A1251/8X200	149	0179734	B1009/32	468
0160268	E500M2X.45NO3	292	0168974	A5101/8	60	0173756	A1251/8X250	149	0179741	B10019/64	468
0160763	E5473/4NO7	340	0168981	A5109/64	60	0173763	A1251/8X315	149	0179758	B1005/16	468
0161463	E7211/8	327	0168998	A5105/32	60	0173770	A1259/64X160	149	0179765	B10021/64	468
0161470	E7211/4	327	0169001	A51011/64	60	0173787	A1259/64X200	149	0179772	B10011/32	468
0161487	E7213/8	327	0169018	A5103/16	60	0173794	A1255/32X160	149	0179789	B10023/64	468
0161494	E7211/2	327	0169025	A51013/64	60	0173800	A1255/32X200	149	0179796	B1003/8	468
0161500	E7213/4	327	0169032	A5107/32	60	0173817	A1255/32X250	149	0179802	B10025/64	468
0161517	E7211	327	0169049	A51015/64	60	0173824	A1255/32X315	149	0179819	B10013/32	468
0164747	F201M3	364	0169056	A5101/4	60	0173831	A12511/64X160	149	0179826	B1007/16	468

# EDP NUMBER INDEX - 0179840 - 0212547

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0179840	B1001/2	468	0181560	B1013.0	457	0206386	F312M10X1.25	368	0209370	F3703/4X2	363
0179857	B10017/32	468	0181577	B1013.5	457	0206393	F312M12X1.0	368	0209387	F3707/8X2.1/4	363
0179864	B1009/16	468	0181584	B1014.0	457	0206409	F312M12X1.25	368	0209394	F3701X2.1/4	363
0179871	B10019/32	468	0181591	B1014.5	457	0206416	F312M12X1.5	368	0209400	F3701.1/4X3	363
0179888	B1005/8	468	0181607	B1015.0	457	0206430	F312M14X1.5	368	0209417	F3701.1/2X4	363
0179895	B10011/16	468	0181614	B1015.5	457	0206454	F312M16X1.5	368	0210314	E7101/8NO7	327
0179901	B1003/4	468	0181621	B1016.0	457	0206461	F312M18X1.5	368	0210321	E7101/4NO7	327
0179925	B10013/16	468	0181638	B1016.5	457	0206485	F312M20X1.5	368	0210338	E7103/8NO7	327
0179949	B1007/8	468	0181645	B1017.0	457	0206508	F312M22X1.5	368	0210345	E7101/2NO7	327
0179970	B1001	468	0181669	B1018.0	457	0206522	F312M24X1.5	368	0210352	E7103/4NO7	327
0179987	B1001.5	468	0181676	B1018.5	457	0206539	F312M24X2.0	368	0210666	R5201/8	38
0179994	B1001.6	468	0181683	B1019.0	457	0206614	F3204-40X13/16	360	0210673	R5209/64	38
0180006	B10010.5	468	0181690	B1019.5	457	0206621	F3205-40X13/16	360	0210680	R5205/32	38
0180013	B10011.5	468	0181706	B10110.0	457	0206645	F3206-32X13/16	360	0210697	R52011/64	38
0180020	B10012.5	468	0181713	B10110.5	457	0206669	F3208-32X13/16	360	0210703	R5203/16	38
0180037	B10013.5	468	0181720	B10111.0	457	0206676	F3208-32X1	360	0210710	R52013/64	38
0180044	B10014.5	468	0181744	B10112.0	457	0206683	F32010-24X13/16	360	0210727	R5207/32	38
0180051	B10021.0	468	0181751	B10112.5	457	0206690	F32010-24X1	360	0210734	R52015/64	38
0180068	B10023.0	468	0181768	B10113.0	457	0206706	F32012-24X13/16	360	0210741	R5201/4	38
0180075	B10027.0	468	0181775	B10113.5	457	0206720	F32014X13/16	360	0210758	R52017/64	38
0180082	B10029.0	468	0181782	B10114.0	457	0206737	F32014X1	360	0210765	R5209/32	38
0180099	B10031.0	468	0181799	B10114.5	457	0206744	F32014X1.5/16	360	0210789	R5205/16	38
0180105	B10033.0	468	0181805	B10115.0	457	0206751	F32014X1.1/2	360	0210802	R52011/32	38
0180112	B10037.0	468	0181812	B10115.5	457	0206768	F3205/16X1	360	0210819	R52023/64	38
0180129	B10039.0	468	0181829	B10116.0	457	0206782	F3205/16X1.1/2	360	0210826	R5203/8	38
0180808	B9011.5	451	0181836	B10116.5	457	0206799	F3203/8X1	360	0210840	R52013/32	38
0180815	B9011/16	451	0181843	B10117.0	457	0206805	F3203/8X1.5/16	360	0210857	R52027/64	38
0180822	B9012.0	451	0181850	B10118.0	457	0206812	F3203/8X1.1/2	360	0210864	R5207/16	38
0180839	B9013/32	451	0181867	B10119.0	457	0206843	F3207/16X1.5/16	360	0210871	R52029/64	38
0180846	B9012.5	451	0181874	B10120.0	457	0206850	F3207/16X1.1/2	360	0210888	R52015/32	38
0180853	B9013.0	451	0181881	B10121.0	457	0206867	F32012X1.5/16	360	0210895	R52031/64	38
0180860	B9011/8	451	0181898	B10122.0	457	0206874	F32012X1.1/2	360	0210901	R5201/2	38
0180877	B9013.5	451	0181904	B10123.0	457	0206881	F32012X2	360	0210918	R5209/16	38
0180884	B9019/64	451	0181911	B10124.0	457	0206904	F3209/16X1.1/2	360	0210925	R5205/8	38
0180891	B9015/32	451	0181928	B10125.0	457	0206928	F3205/8X1.1/2	360	0211427	A9203/64	56
0180907	B9014.0	451	0181935	B10126.0	457	0206935	F3205/8X2	360	0211434	A9201.25	56
0180921	B9014.5	451	0181942	B10127.0	457	0206959	F3203/4X1.1/2	360	0211441	A920N55	56
0180938	B9013/16	451	0181959	B10128.0	457	0206966	F3203/4X2	360	0211458	A9201.35	56
0180945	B9015.0	451	0181966	B10129.0	457	0206973	F3207/8X2	360	0211465	A9201.45	56
0180952	B90113/64	451	0181973	B10130.0	457	0206980	F3201X2	360	0211489	A9201.55	56
0180969	B9015.5	451	0181980	B10131.0	457	0206997	F3201.1/8X3	360	0211502	A9201.75	56
0180976	B9017/32	451	0181997	B10132.0	457	0207000	F3201.1/4X3	360	0211571	A9202.15	56
0180983	B90115/64	451	0182017	B10134.0	457	0207307	F3304-48X13/16	360	0211601	A9202.35	56
0180990	B9016.0	451	0182024	B10135.0	457	0207314	F3305-44X13/16	360	0211625	A920N41	56
0181003	B9011/4	451	0182031	B10136.0	457	0207338	F3306-40X13/16	360	0211670	A9202.65	56
0181010	B9017.0	451	0182048	B10137.0	457	0207352	F3308-36X13/16	360	0211717	A920N33	56
0181027	B9019/32	451	0182055	B10138.0	457	0207376	F33010-32X13/16	360	0211755	A920N29	56
0181034	B9015/16	451	0182062	B10139.0	457	0207383	F33010-32X1	360	0211830	A920N19	56
0181041	B9018.0	451	0182079	B10140.0	457	0207390	F33012-28X13/16	360	0211960	A920N3	56
0181058	B90111/32	451	0182086	B10141.0	457	0207413	F33014X13/16	360	0212103	A920N	56
0181065	B9019.0	451	0182093	B10142.0	457	0207420	F33014X1	360	0212196	A920Y	56
0181072	B9013/8	451	0182109	B10143.0	457	0207444	F33014X1.1/2	360	0212219	A92010.75	56
0181089	B90110.0	451	0182116	B10144.0	457	0207451	F3305/16X1	360	0212226	A92011.25	56
0181102	B90111.0	451	0182123	B10145.0	457	0207468	F3305/16X1.5/16	360	0212233	A92012.75	56
0181119	B9017/16	451	0182130	B10146.0	457	0207475	F3305/16X1.1/2	360	0212257	A92033/64	56
0181126	B90112.0	451	0182147	B10147.0	457	0207482	F3303/8X1	360	0212264	A92035/64	56
0181133	B9011/2	451	0182154	B10148.0	457	0207499	F3303/8X1.5/16	360	0212271	A9209/16	56
0181140	B1011/8	457	0182178	B10150.0	457	0207505	F3303/8X1.1/2	360	0212288	A92037/64	56
0181157	B1015/32	457	0182277	B3011/16	470	0207512	F3307/16X1	360	0212295	A92014.75	56
0181164	B1013/16	457	0182284	B3015/64	470	0207529	F3307/16X1.5/16	360	0212301	A92019/32	56
0181188	B1011/4	457	0182291	B3013/32	470	0207536	F3307/16X1.1/2	360	0212318	A92039/64	56
0181201	B1015/16	457	0182307	B3017/64	470	0207543	F33012X1.5/16	360	0212325	A9205/8	56
0181225	B1013/8	457	0182314	B3011/8	470	0207550	F33012X1.1/2	360	0212332	A92041/64	56
0181232	B10113/32	457	0182321	B3019/64	470	0207574	F3309/16X1.5/16	360	0212349	A92016.5	56
0181249	B1017/16	457	0182338	B3015/32	470	0207581	F3309/16X1.1/2	360	0212356	A92021/32	56
0181256	B10115/32	457	0182345	B30111/64	470	0207604	F3305/8X1.1/2	360	0212363	A92016.75	56
0181263	B1011/2	457	0182352	B3013/16	470	0207611	F3305/8X2	360	0212370	A92043/64	56
0181287	B1019/16	457	0182369	B3017/32	470	0207635	F3303/4X1.1/2	360	0212387	A92011/16	56
0181300	B1015/8	457	0182376	B3011/4	470	0207642	F3303/4X2	360	0212394	A92045/64	56
0181348	B1013/4	457	0182383	B3019/32	470	0207659	F3307/8X2	360	0212400	A92023/32	56
0181362	B10113/16	457	0182390	B3015/16	470	0207666	F3301X2	360	0212417	A92018.5	56
0181386	B1017/8	457	0182406	B30111/32	470	0207673	F3301.1/8X3	360	0212424	A92047/64	56
0181423	B1011	457	0182413	B3013/8	470	0207680	F3301.1/4X3	360	0212431	A9203/4	56
0181447	B1011.1/8	457	0182420	B30113/32	470	0207703	F3301.1/2X3	360	0212448	A92049/64	56
0181461	B1011.1/4	457	0182437	B3017/16	470	0209325	F3701/8X1	363	0212455	A92019.5	56
0181485	B1011.3/8	457	0182444	B3011/2	470	0209332	F3701/4X1.5/16	363	0212462	A92025/32	56
0181508	B1011.1/2	457	0206331	F312M8X.75	368	0209349	F3703/8X1.1/2	363	0212509	A9212.7	56
0181522	B1011.3/4	457	0206348	F312M8X1.0	368	0209356	F3701/2X2	363	0212523	A9217/64	56
0181546	B1012	457	0206379	F312M10X1.0	368	0209363	F3705/8X2	363	0212547	A921N34	56

# EDP NUMBER INDEX - 0212554 - 0348512

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0212554	A921N33	56	0218082	L1104INCH	370	0273258	E6515/8	346	0345306	R51010.8	44
0212561	A9212.9	56	0234013	A245N10	123	0273265	E6517/16	346	0346402	R5206.6	38
0212578	A921N32	56	0234099	A245N18	123	0273272	E6518-32	346	0346419	R5206.7	38
0212585	A921N31	56	0234105	A245N19	123	0273289	E6519/16	346	0346426	R5207.1	38
0212592	A9211/8	56	0234136	A245N21	123	0279717	A9762.3X135	71	0346433	R5207.2	38
0212622	A9219/64	56	0234150	A245N23	123	0279724	A9762.1X125	71	0346440	R5207.6	38
0212677	A9215/32	56	0234167	A245N24	123	0279731	A9762.4X140	71	0346457	R5207.7	38
0214398	A1259/64X315	149	0234181	A245N26	123	0279748	A9762.6X140	71	0346464	R5207.9	38
0214404	A12511/64X315	149	0234198	A245N27	123	0279755	A9762.7X150	71	0346471	R5208.1	38
0214442	A12515/64X315	149	0234211	A245N29	123	0279762	A9762.8X150	71	0346488	R5208.2	38
0214466	A12517/64X500	149	0234242	A245N31	123	0279779	A9762.9X150	71	0346495	R5208.3	38
0214473	A1259/32X500	149	0234341	A245N40	123	0279786	A9763.1X155	71	0346501	R5208.4	38
0214480	A12519/64X315	149	0234594	A245N9	123	0279793	A9763.2X155	71	0346518	R5208.6	38
0214497	A12519/64X500	149	0235003	A24525/64	123	0279809	A9763.4X165	71	0346525	R5208.8	38
0214503	A12521/64X500	149	0235041	A24529/64	123	0279816	A9763.6X165	71	0346532	R5208.9	38
0214510	A12511/32X500	149	0235140	A2453/8	123	0279823	A9763.8X175	71	0346549	R5209.1	38
0214527	A12523/64X500	149	0235379	A2459/32	123	0279830	A9763.9X175	71	0346556	R5209.6	38
0214534	A12525/64X315	149	0238202	A1701.11/64	176	0279847	A9764.1X175	71	0346563	R5209.7	38
0214541	A12525/64X500	149	0238240	A1701.15/64	176	0279854	A9764.2X175	71	0346570	R5209.8	38
0214558	A12513/32X500	149	0238288	A1701.7/64	176	0279861	A9764.3X185	71	0346587	R5209.9	38
0214565	A12527/64X315	149	0238301	A1701.9/64	176	0279878	A9764.4X185	71	0346778	R52010.1	38
0214589	A1257/16X500	149	0239216	A217N1	197	0279885	A9764.6X185	71	0347072	A9761/8	71
0214596	A12529/64X315	149	0239223	A217N2	197	0279892	A9764.7X185	71	0347089	A9765/32	71
0214602	A12529/64X500	149	0239230	A217N3	197	0279908	A9764.8X195	71	0347096	A9761/4	71
0214619	A12515/32X500	149	0239247	A217N4	197	0279915	A9764.9X195	71	0347102	A9765/16	71
0214626	A12531/64X315	149	0239254	A217N5	197	0279922	A9765.1X195	71	0347119	A97611/32	71
0214633	A12531/64X500	149	0239261	A217N6	197	0279939	A9765.2X195	71	0347126	A9763/8	71
0214640	A12533/64X315	149	0239278	A217N7	197	0279946	A9765.3X195	71	0347133	A97610.5	71
0214657	A12533/64X500	149	0239285	A217N8	197	0279953	A9765.4X205	71	0347140	A97611.0	71
0214664	A12517/32X315	149	0239292	A218N1	197	0279960	A9765.6X205	71	0347157	A97611.5	71
0214671	A12517/32X500	149	0239308	A218N2	197	0279977	A9765.7X205	71	0347164	A97612.0	71
0214688	A12535/64X315	149	0239315	A218N3	197	0279984	A9765.8X205	71	0347171	A97612.5	71
0214695	A12535/64X500	149	0239322	A218N4	197	0279991	A9765.9X205	71	0347188	A9761/2	71
0214701	A1259/16X315	149	0239339	A218N5	197	0280003	A9766.1X215	71	0347195	A97613.0	71
0214718	A1259/16X500	149	0239346	A218N6	197	0280010	A9766.2X215	71	0347201	A97614.0	71
0214725	A12537/64X315	149	0239353	A218N7	197	0280027	A9766.3X215	71	0347218	A9771/8	71
0214749	A12519/32X315	149	0239360	A218N8	197	0280034	A9766.4X215	71	0347225	A9773/16	71
0214756	A12519/32X500	149	0240410	A2431/4X6	156	0280041	A9766.6X215	71	0347232	A9771/4	71
0214763	A12539/64X315	149	0240434	A2431/8X6	156	0280058	A9766.7X215	71	0347249	A97711/32	71
0214770	A12539/64X500	149	0240441	A2433/16X6	156	0280065	A9766.8X225	71	0347256	A97710.5	71
0214787	A1255/8X315	149	0240458	A2433/32X6	156	0280072	A9766.9X225	71	0347263	A97711.0	71
0214794	A1255/8X500	149	0240465	A2435/32X6	156	0286012	A92111/64	56	0347270	A97711.5	71
0214800	A12521/32X315	149	0240816	A243N10X6	156	0297247	E6531	348	0347287	A97712.0	71
0214817	A12521/32X500	149	0240823	A243N11X6	156	0297261	E6531/2	348	0347294	A97712.5	71
0214824	A12511/16X315	149	0240922	A243N20X6	156	0297278	E6531/4	348	0347300	A97713.0	71
0214831	A12511/16X500	149	0240939	A243N21X6	156	0297285	E6531/8	348	0347317	A97714.0	71
0214848	A12523/32X315	149	0241035	A243N30X6	156	0297292	E6533/4	348	0347324	A9783.0	71
0214855	A12523/32X500	149	0241141	A243N40X6	156	0297308	E6533/8	348	0347331	A9781/4	71
0214862	A1253/4X315	149	0241844	A221N0	198	0308523	A28718	209	0347362	A9761.5	71
0214879	A1253/4X500	149	0241851	A221N00	198	0335635	A9213/16	56	0347379	A9767/16	71
0214886	A12525/32X500	149	0241868	A221N1	198	0338971	E65410-32	346	0347386	A9771.5	71
0214893	A12513/16X500	149	0241875	A221N2	198	0338988	E6541/2	346	0347393	A9771/16	71
0214909	A1257/8X500	149	0241882	A221N3	198	0338995	E65412-28	346	0347409	A9772.0	71
0214916	A12515/16X500	149	0241899	A221N4	198	0339008	E6541/4	346	0347416	A9773/32	71
0214923	A1251X500	149	0241905	A221N5	198	0339015	E6543/8	346	0347935	A9763/16	71
0216781	R5103.7	44	0241912	A221N6	198	0339022	E6545/16	346	0348284	E0618-32N01	297
0216798	R5104.6	44	0241929	A221N7	198	0339039	E6545/8	346	0348291	E0616-32N01	297
0216804	R5104.7	44	0241936	A221N8	198	0339046	E6547/16	346	0348307	E0616-32N02	297
0216811	R5105.6	44	0252345	B1221	453	0339053	E6548-36	346	0348314	E0616-32N03	297
0216828	R5105.7	44	0252352	B1221.1/16	453	0340684	E5475/8NO7	340	0348321	E0616-32N06	297
0216835	R5109.4	44	0252369	B12211/16	453	0343111	E513M3.5X.35NO3	294	0348338	E0618-32N02	297
0216842	R51010.3	44	0252376	B1221/2	453	0343128	E513M9X.75NO3	294	0348345	E0618-32N03	297
0216859	R51011.2	44	0252383	B12213/16	453	0343135	E513M10X.5NO3	294	0348352	E0618-32N06	297
0216866	R5208.7	38	0252390	B12215/16	453	0343142	E513M11X1.25NO3	294	0348369	E06110-24N01	297
0216873	R5209.4	38	0252406	B1223/4	453	0343166	E513M12X.75NO3	294	0348376	E06110-24N02	297
0216880	R52010.3	38	0252413	B1225/8	453	0343173	E513M13X1.5NO3	294	0348383	E06110-24N03	297
0216897	R52011.2	38	0252420	B1227/8	453	0343203	E513M16X1.25NO3	294	0348390	E06110-24N06	297
0216903	R52013.5	38	0252437	B1229/16	453	0343302	E513M36X1.5NO3	294	0348406	E06112-24N01	297
0216910	R52014.2	38	0259696	E0611.1/2NO6	297	0343319	E513M42X3.0NO3	294	0348413	E06112-24N02	297
0216927	R52014.25	38	0259702	E0611.1/4NO6	297	0343333	E513M48X1.5NO3	294	0348420	E06112-24N03	297
0216934	R52015.1	38	0259719	E0611.1/8NO6	297	0343340	E513M48X2.0NO3	294	0348437	E06112-24N06	297
0217887	G2361	491	259818	E0711.1/2NO6	297	0343357	E513M48X3.0NO3	294	0348444	E0611/4NO1	297
0218013	L11013/16	370	259832	E0711.1/8NO6	297	0344750	G2362	491	0348451	E0611/4NO2	297
0218020	L1101INCH	370	0273197	E65110-24	346	0345245	R5103.9	44	0348468	E0611/4NO3	297
0218037	L1101.5/16	370	0273203	E6511/2	346	0345252	R5106.6	44	0348475	E0611/4NO6	297
0218044	L1101.1/2	370	0273210	E65112-24	346	0345269	R5107.8	44	0348482	E0615/16NO1	297
0218051	L1102INCH	370	0273227	E6511/4	346	0345276	R5107.9	44	0348499	E0615/16NO2	297
0218068	L1102.1/4	370	0273234	E6513/8	346	0345283	R5108.8	44	0348505	E0615/16NO3	297
0218075	L1103INCH	370	0273241	E6515/16	346	0345290	R5109.9	44	0348512	E0615/16NO6	297

# EDP NUMBER INDEX - 0348529 - 0354841

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0348529	E0613/8NO1	297	0349908	E0717/8NO2	297	0351253	A0028.4	82	0353356	C11025.0	406
0348536	E0613/8NO2	297	0349915	E0717/8NO3	297	0351260	A0028.5	82	0353363	C11028.0	406
0348543	E0613/8NO3	297	0349922	E0717/8NO6	297	0351277	A0028.6	82	0353370	C1103.0	406
0348550	E0613/8NO6	297	0349939	E0711X12NO1	297	0351284	A0028.7	82	0353387	C1103.5	406
0348567	E0617/16NO1	297	0349946	E0711X12NO2	297	0351291	A00211/32	82	0353394	C1103.8	406
0348574	E0617/16NO2	297	0349953	E0711X12NO3	297	0351307	A0028.8	82	0353400	C11030.0	406
0348581	E0617/16NO3	297	0349960	E0711X12NO6	297	0351314	A0028.9	82	0353417	C11032.0	406
0348598	E0617/16NO6	297	0349977	E0711X14NO1	297	0351321	A0029.0	82	0353424	C1104.0	406
0348604	E0611/2NO1	297	0349984	E0711X14NO2	297	0351338	A0029.1	82	0353431	C1104.5	406
0348611	E0611/2NO2	297	0349991	E0711X14NO3	297	0351345	A00223/64	82	0353448	C1104.8	406
0348628	E0611/2NO3	297	0350003	E0711X14NO6	297	0351352	A0029.2	82	0353455	C1105.0	406
0348635	E0611/2NO6	297	0350577	A0023.0	82	0351369	A0029.3	82	0353462	C1105.5	406
0348642	E0619/16NO2	297	0350584	A0023.1	82	0351376	A0029.4	82	0353479	C1105.75	406
0348659	E0619/16NO3	297	0350591	A0021/8	82	0351383	A0029.5	82	0353486	C1106.0	406
0348666	E0619/16NO6	297	0350607	A0023.2	82	0351390	A0023/8	82	0353493	C1106.5	406
0348673	E0615/8NO1	297	0350614	A0023.3	82	0351406	A0029.6	82	0353509	C1107.0	406
0348680	E0615/8NO2	297	0350621	A0023.4	82	0351413	A0029.7	82	0353516	C1107.5	406
0348697	E0615/8NO3	297	0350638	A0023.5	82	0351420	A0029.8	82	0353523	C1108.0	406
0348703	E0615/8NO6	297	0350645	A0029/64	82	0351437	A0029.9	82	0353530	C1108.5	406
0348710	E0613/4NO1	297	0350652	A0023.6	82	0351444	A00225/64	82	0353547	C1109.0	406
0348727	E0613/4NO2	297	0350669	A0023.7	82	0351451	A00210.0	82	0353554	C1109.5	406
0348734	E0613/4NO3	297	0350676	A0023.8	82	0351468	A00210.1	82	0353561	C12310.0	412
0348741	E0613/4NO6	297	0350683	A0023.9	82	0351475	A00210.2	82	0353578	C12311.0	412
0348758	E0617/8NO1	297	0350690	A0025/32	82	0351482	A00210.3	82	0353585	C12312.0	412
0348765	E0617/8NO2	297	0350706	A0024.0	82	0351499	A00213/32	82	0353592	C12313.0	412
0348772	E0617/8NO3	297	0350713	A0024.1	82	0351505	A00210.4	82	0353608	C12314.0	412
0348789	E0617/8NO6	297	0350720	A0024.2	82	0351512	A00210.5	82	0353615	C12315.0	412
0348796	E0611NO1	297	0350737	A0024.3	82	0351529	A00210.6	82	0353622	C12316.0	412
0348802	E0611NO2	297	0350744	A00211/64	82	0351536	A00210.7	82	0353639	C12318.0	412
0348819	E0611NO3	297	0350751	A0024.4	82	0351543	A00227/64	82	0353646	C1232.0	412
0348826	E0611NO6	297	0350768	A0024.5	82	0351550	A00210.8	82	0353653	C1232.5	412
0349427	E0716-40NO1	297	0350775	A0024.6	82	0351567	A00210.9	82	0353660	C12320.0	412
0349434	E0716-40NO2	297	0350782	A0024.7	82	0351574	A00211.0	82	0353677	C12322.0	412
0349441	E0716-40NO3	297	0350799	A0023/16	82	0351581	A00211.1	82	0353691	C12325.0	412
0349458	E0716-40NO6	297	0350805	A0024.8	82	0351598	A0027/16	82	0353714	C1233.0	412
0349465	E0718-36NO1	297	0350812	A0024.9	82	0351604	A00211.2	82	0353721	C1233.5	412
0349472	E0718-36NO2	297	0350829	A0025.0	82	0351611	A00211.3	82	0353738	C12330.0	412
0349489	E0718-36NO3	297	0350836	A0025.1	82	0351628	A00211.4	82	0353745	C12332.0	412
0349496	E0718-36NO6	297	0350843	A00213/64	82	0351635	A00211.5	82	0353752	C12336.0	412
0349502	E07110-32NO1	297	0350850	A0025.2	82	0351642	A00229/64	82	0353769	C1234.0	412
0349519	E07110-32NO2	297	0350867	A0025.3	82	0351659	A00211.6	82	0353776	C1234.5	412
0349526	E07110-32NO3	297	0350874	A0025.4	82	0351666	A00211.7	82	0353783	C12340.0	412
0349533	E07110-32NO6	297	0350881	A0025.5	82	0351673	A00211.8	82	0353790	C1235.0	412
0349540	E07112-28NO1	297	0350898	A0027/32	82	0351680	A00211.9	82	0353806	C1235.5	412
0349557	E07112-28NO2	297	0350904	A0025.6	82	0351697	A00215/32	82	0353813	C1236.0	412
0349564	E07112-28NO3	297	0350911	A0025.7	82	0351703	A00212.0	82	0353820	C1236.5	412
0349571	E07112-28NO6	297	0350928	A0025.8	82	0351710	A00212.1	82	0353837	C1237.0	412
0349588	E0711/4NO1	297	0350935	A0025.9	82	0351727	A00212.2	82	0353844	C1237.5	412
0349595	E0711/4NO2	297	0350942	A00215/64	82	0351734	A00212.3	82	0353851	C1238.0	412
0349601	E0711/4NO3	297	0350959	A0026.0	82	0351741	A00231/64	82	0353868	C1238.5	412
0349618	E0711/4NO6	297	0350966	A0026.1	82	0351758	A00212.4	82	0353875	C1239.0	412
0349625	E0715/16NO1	297	0350973	A0026.2	82	0351765	A00212.5	82	0353882	C1239.5	412
0349632	E0715/16NO2	297	0350980	A0026.3	82	0351772	A00212.6	82	0354582	C24710.0	425
0349649	E0715/16NO3	297	0350997	A0021/4	82	0351789	A0021/2	82	0354599	C24711.0	425
0349656	E0715/16NO6	297	0351000	A0026.4	82	0351796	A00212.7	82	0354605	C24712.0	425
0349663	E0713/8NO1	297	0351017	A0026.5	82	0351802	A00212.8	82	0354612	C24713.0	425
0349670	E0713/8NO2	297	0351024	A0026.6	82	0351819	A00212.9	82	0354629	C24714.0	425
0349687	E0713/8NO3	297	0351031	A0026.7	82	0351826	A00213.0	82	0354636	C24715.0	425
0349694	E0713/8NO6	297	0351048	A00217/64	82	0351833	E0619/16NO1	297	0354643	C24716.0	425
0349700	E0717/16NO1	297	0351055	A0026.8	82	0351932	E0713/4NO6	297	0354650	C24718.0	425
0349717	E0717/16NO2	297	0351062	A0026.9	82	0353165	C1101.0	406	0354667	C2472.0	425
0349724	E0717/16NO3	297	0351079	A0027.0	82	0353172	C1101.5	406	0354674	C2472.5	425
0349731	E0717/16NO6	297	0351086	A0027.1	82	0353189	C1101.8	406	0354681	C24720.0	425
0349748	E0711/2NO1	297	0351093	A0029/32	82	0353196	C11010.0	406	0354698	C24722.0	425
0349755	E0711/2NO2	297	0351109	A0027.2	82	0353202	C11010.5	406	0354704	C24725.0	425
0349762	E0711/2NO3	297	0351116	A0027.3	82	0353219	C11011.0	406	0354711	C24728.0	425
0349779	E0711/2NO6	297	0351123	A0027.4	82	0353226	C11012.0	406	0354728	C2473.0	425
0349786	E0719/16NO1	297	0351130	A0027.5	82	0353233	C11013.0	406	0354735	C2473.5	425
0349793	E0719/16NO2	297	0351147	A00219/64	82	0353240	C11014.0	406	0354742	C24730.0	425
0349809	E0719/16NO3	297	0351154	A0027.6	82	0353257	C11015.0	406	0354759	C24732.0	425
0349816	E0719/16NO6	297	0351161	A0027.7	82	0353264	C11016.0	406	0354766	C2474.0	425
0349823	E0715/8NO1	297	0351178	A0027.8	82	0353271	C11017.0	406	0354773	C2474.5	425
0349830	E0715/8NO2	297	0351185	A0027.9	82	0353288	C11018.0	406	0354780	C2475.0	425
0349847	E0715/8NO3	297	0351192	A0025/16	82	0353295	C11019.0	406	0354797	C2475.5	425
0349854	E0715/8NO6	297	0351208	A0028.0	82	0353301	C1102.0	406	0354803	C2476.0	425
0349861	E0713/4NO1	297	0351215	A0028.1	82	0353318	C1102.5	406	0354810	C2476.5	425
0349878	E0713/4NO2	297	0351222	A0028.2	82	0353325	C1102.8	406	0354827	C2477.0	425
0349885	E0713/4NO3	297	0351239	A0028.3	82	0353332	C11020.0	406	0354834	C2477.5	425
0349892	E0717/8NO1	297	0351246	A00221/64	82	0353349	C11022.0	406	0354841	C2478.0	425

# EDP NUMBER INDEX - 0354858 - 0419960

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0354858	C2478.5	425	0380987	R5107/16	44	0388310	E0711.3/8NO3	297	0418345	A3454/164	170
0354865	C2479.0	425	0380994	R5107/32	44	0388327	E0711.1/2NO1	297	0418352	A3455/8	170
0354872	C2479.5	425	0381007	R5109/32	44	0388334	E0711.1/2NO2	297	0418369	A3457/16	170
0354889	C27310.0	427	0381014	R5109/64	44	0388341	E0711.1/2NO3	297	0418376	A3457/8	170
0354896	C27311.0	427	0381021	R5101/2	44	0388907	E6516-32	346	0418383	A3458.0	170
0354902	C27312.0	427	0381038	R5101/4	44	0390795	A55310.0	63	0418390	A3458.5	170
0354919	C27313.0	427	0381045	R5103/8	44	0390801	A55310.2	63	0418406	A3459.0	170
0354926	C27314.0	427	0384497	A00214.0	82	0390818	A55310.3	63	0418413	A3459/16	170
0354933	C27315.0	427	0384824	E620M3	342	0390825	A55310.5	63	0418420	A95110.0	172
0354940	C27316.0	427	0384831	E620M4	342	0390849	A55311.0	63	0418437	A95111.0	172
0354957	C27318.0	427	0384848	E620M5	342	0390856	A55311.3	63	0418444	A95112.0	172
0354964	C2732.0	427	0384855	E620M6	342	0390863	A55311.5	63	0418451	A95112.5	172
0354971	C2732.5	427	0384862	E620M8	342	0390870	A55312.0	63	0418468	A95113.0	172
0354988	C27320.0	427	0384879	E620M10	342	0390887	A55312.5	63	0418475	A95113.5	172
0354995	C27322.0	427	0384886	E620M12	342	0390894	A55313.0	63	0418482	A95114.0	172
0355008	C27325.0	427	0384893	E620M14	342	0390924	A55313.5	63	0418499	A95114.5	172
0355015	C27328.0	427	0384909	E620M16	342	0390948	A55314.0	63	0418505	A95115.0	172
0355022	C2733.0	427	0384916	E621M3	342	0390955	A55314.25	63	0418512	A95115.5	172
0355039	C2733.5	427	0384923	E621M4	342	0390962	A55314.5	63	0418529	A95116.0	172
0355046	C27330.0	427	0384930	E621M5	342	0390986	A55315.0	63	0418536	A95116.5	172
0355053	C27332.0	427	0384947	E621M6	342	0391006	A55315.25	63	0418543	A95117.0	172
0355060	C2734.0	427	0384954	E621M8	342	0391013	A55315.5	63	0418550	A95117.5	172
0355077	C2734.5	427	0384961	E621M10	342	0391037	A55316.0	63	0418567	A95118.0	172
0355084	C2735.0	427	0384978	E621M12	342	0391051	A55316.5	63	0418574	A95118.5	172
0355091	C2735.5	427	0384985	E621M14	342	0391075	A55317.0	63	0418581	A95119.0	172
0355107	C2736.0	427	0384992	E621M16	342	0391099	A55317.5	63	0418598	A95119.5	172
0355114	C2737.0	427	0385180	A00213.1	82	0391105	A55317.75	63	0418604	A95120.0	172
0355121	C2738.0	427	0385197	A00213.3	82	0391112	A55318.0	63	0418611	A95121.0	172
0355138	C2739.0	427	0385203	A00213.6	82	0391150	A55319.0	63	0418628	A95122.0	172
0372555	G17110.4	486	0385210	A00213.7	82	0391167	A55319.25	63	0418635	A95123.0	172
0372562	G17112.4	486	0385227	A00213.8	82	0391198	A55320.0	63	0418642	A95124.0	172
0372579	G17116.5	486	0385234	A00214.25	82	0391204	A5535.0	63	0418659	A95125.0	172
0372586	G17120.5	486	0385241	A00214.5	82	0391228	A5535.2	63	0418666	A95126.0	172
0372593	G17125.0	486	0385258	A00214.75	82	0391242	A5535.5	63	0418673	A95127.0	172
0372609	G1716.3	486	0385265	A00215.0	82	0391280	A5536.0	63	0418680	A95128.0	172
0372616	G1718.3	486	0385272	A00215.25	82	0391297	A5536.3	63	0418697	A95129.0	172
0375907	A2441/4X6	156	0385289	A00215.5	82	0391303	A5536.5	63	0418703	A95130.0	172
0375914	A2441/8X6	156	0385296	A00215.75	82	0391327	A5536.8	63	0419540	A3451.1/2	170
0375921	A2443/16X6	156	0385302	A00216.0	82	0391334	A5536.9	63	0419557	A3451.3/4	170
0375938	A2445/32X6	156	0385319	A00217/32	82	0391341	A5537.0	63	0419564	A34511.5	170
0376041	A0022.0	82	0385326	A00219/32	82	0391365	A5537.4	63	0419571	A34512.5	170
0376058	A0022.1	82	0385333	A00233/64	82	0391372	A5537.5	63	0419588	A34513.5	170
0376065	A0022.5	82	0385340	A00235/64	82	0391402	A5538.0	63	0419601	A34515.5	170
0376072	A0022.6	82	0385357	A00237/64	82	0391419	A5538.5	63	0419618	A34516.5	170
0376089	A0022.7	82	0385364	A00239/64	82	0391426	A5538.7	63	0419625	A34517.5	170
0376096	A0022.8	82	0385371	A0025/8	82	0391433	A5539.0	63	0419632	A34518.5	170
0376102	A0022.9	82	0385388	A0029/16	82	0391457	A5539.5	63	0419649	A34519.5	170
0376119	A0023/32	82	385395	A09518	207	0392331	A095206	207	0419656	A34520.5	170
0376126	A0027/64	82	0385418	A095201	207	0418031	A3451	170	0419663	A34521.5	170
0376782	A0021.0	82	0385425	A095202	207	0418048	A3451.1/4	170	0419670	A34522.5	170
0376799	A0021.1	82	0385432	A095203	207	0418055	A3451/2	170	0419687	A34523.0	170
0376805	A0021.2	82	0385449	A095204	207	0418062	A34510.0	170	0419694	A34523.5	170
0376812	A0021.3	82	0385494	A00213.9	82	0418079	A34511.0	170	0419700	A34524.5	170
0376829	A0021.4	82	0385524	A00213.2	82	0418086	A34511/16	170	0419717	A34525.5	170
0376836	A0021.5	82	0385531	A00213.4	82	0418093	A34512.0	170	0419724	A34526.5	170
0376843	A0021.6	82	0385548	A00213.5	82	0418109	A34513.0	170	0419731	A34529.0	170
0376850	A0021.7	82	0385562	A095209	207	0418116	A34513/32	170	0419748	A34531.0	170
0376867	A0021.8	82	0385579	A00213.25	82	0418123	A34514.0	170	0419755	A34532.0	170
0376874	A0021.9	82	0385586	A00213.75	82	0418130	A34515.0	170	0419762	A34534.0	170
0376881	A0021/16	82	0388112	E0611.1/8NO1	297	0418147	A34516.0	170	0419779	A34535.0	170
0376898	A0022.2	82	0388129	E0611.1/8NO2	297	0418154	A34517.0	170	0419786	A34536.0	170
0376904	A0022.3	82	0388136	E0611.1/8NO3	297	0418161	A34517/32	170	0419793	A34537.0	170
0376911	A0022.4	82	0388143	E0611.1/4NO1	297	0418178	A34518.0	170	0419809	A34538.0	170
0376928	A0023/64	82	0388150	E0611.1/4NO2	297	0418185	A34519.0	170	0419816	A34539.0	170
0376935	A0025/64	82	0388167	E0611.1/4NO3	297	0418192	A34520.0	170	0419823	A34540.0	170
0380802	R5101/8	44	0388174	E0611.3/8NO1	297	0418208	A34521.0	170	0419830	A34541.0	170
0380833	R51013/32	44	0388181	E0611.3/8NO2	297	0418215	A34521/32	170	0419847	A34542.0	170
0380840	R51013/64	44	0388198	E0611.3/8NO3	297	0418222	A34522.0	170	0419854	A34545.0	170
0380857	R51015/32	44	0388204	E0611.1/2NO1	297	0418239	A34524.0	170	0419861	A34548.0	170
0380864	R51015/64	44	0388211	E0611.1/2NO2	297	0418246	A34525.0	170	0419878	A34550.0	170
0380888	R51019/64	44	0388228	E0611.1/2NO3	297	0418253	A34526.0	170	0419885	A95210.0	172
0380901	R51023/64	44	0388235	E0711.1/8NO1	297	0418260	A34527.0	170	0419892	A95210.5	172
0380918	R51025/64	44	0388242	E0711.1/8NO2	297	0418277	A34528.0	170	0419908	A95211.0	172
0380925	R51027/64	44	0388259	E0711.1/8NO3	297	0418284	A34529/64	170	0419915	A95211.5	172
0380932	R51029/64	44	0388266	E0711.1/4NO1	297	0418291	A3453/4	170	0419922	A95212.0	172
0380949	R5103/16	44	0388273	E0711.1/4NO2	297	0418307	A3453/8	170	0419939	A95212.5	172
0380956	R51031/64	44	0388280	E0711.1/4NO3	297	0418314	A34530.0	170	0419946	A95213.5	172
0380963	R5105/16	44	0388297	E0711.3/8NO1	297	0418321	A34537/64	170	0419953	A95214.0	172
0380970	R5105/32	44	0388303	E0711.3/8NO2	297	0418338	A34539/64	170	0419960	A95214.5	172



# EDP NUMBER INDEX - 0419977 - 0571309

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0419977	.A95215.0	172	0421932	.B4812.52	440	0567753	.E001M5	261	0568958	.E013M22X1.5	275
0419984	.A95215.5	172	0421949	.B4812.53	440	0567760	.E001M6	261	0569108	.E0214-40	256
0419991	.A95216.5	172	0421956	.B4812.97	440	0567777	.E001M8	261	0569115	.E0216-32	256
0420003	.A95217.0	172	0421963	.B4812.98	440	0567784	.E001M10	261	0569122	.E0218-32	256
0420010	.A95217.5	172	0421970	.B4812.99	440	0567791	.E001M12	261	0569139	.E02110-24	256
0420027	.A95218.0	172	0421987	.B4813.00	440	0567807	.E001M14	261	0569146	.E02112-24	256
0420034	.A95218.5	172	0421994	.B4813.01	440	0567814	.E001M16	261	0569153	.E0211/4	256
0420041	.A95219.0	172	0422007	.B4813.02	440	0567821	.E001M18	261	0569160	.E0215/16	256
0420058	.A95219.5	172	0422014	.B4813.03	440	0567838	.E001M20	261	0569177	.E0213/8	256
0420065	.A95220.0	172	0422021	.B4813.97	440	0567845	.E001M22	261	0569184	.E0217/16	256
0420072	.A95221.0	172	0422038	.B4813.98	440	0567852	.E001M24	261	0569191	.E0211/2	256
0420089	.A95222.0	172	0422045	.B4813.99	440	0567869	.E002M3	275	0569207	.E0215/8	256
0420096	.A95223.0	172	0422052	.B4814.00	440	0567876	.E002M3.5	275	0569214	.E0213/4	256
0420102	.A95224.0	172	0422069	.B4814.01	440	0567883	.E002M4	275	0569221	.E0217/8	256
0420119	.A95225.0	172	0422076	.B4814.02	440	0567890	.E002M5	275	0569238	.E0211	256
0420126	.A95226.0	172	0422083	.B4814.03	440	0567906	.E002M6	275	0569382	.E0234-40	270
0420133	.A95227.0	172	0422090	.B4814.97	440	0567913	.E002M8	275	0569399	.E0236-32	270
0420140	.A95228.0	172	0422106	.B4814.98	440	0567920	.E002M10	275	0569405	.E0238-32	270
0420157	.A95229.0	172	0422113	.B4814.99	440	0567937	.E002M12	275	0569412	.E02310-24	270
0420164	.A95230.0	172	0422120	.B4815.00	440	0567944	.E002M14	275	0569429	.E02312-24	270
0420171	.A34510.5	170	0422137	.B4815.01	440	0567951	.E002M16	275	0569436	.E0231/4	270
0420188	.A95213.0	172	0422144	.B4815.02	440	0567968	.E002M18	275	0569443	.E0235/16	270
0420195	.A95216.0	172	0422151	.B4815.03	440	0567975	.E002M20	275	0569450	.E0233/8	270
0420201	.A3459.5	170	0422168	.B4815.97	440	0567982	.E002M22	275	0569467	.E0237/16	270
0421086	.B44110.0	436	0422175	.B4815.98	440	0567999	.E002M24	275	0569474	.E0231/2	270
0421093	.B44111.0	436	0422182	.B4815.99	440	0568002	.E003M3	275	0569481	.E0235/8	270
0421109	.B44112.0	436	0422199	.B4816.00	440	0568019	.E003M3.5	275	0569498	.E0233/4	270
0421116	.B44114.0	436	0422205	.B4816.01	440	0568026	.E003M4	275	0569504	.E0237/8	270
0421123	.B44115.0	436	0422212	.B4816.02	440	0568033	.E003M5	275	0569511	.E0231	270
0421130	.B44116.0	436	0422229	.B4816.03	440	0568040	.E003M6	275	0569641	.E0318-36	256
0421147	.B44117.0	436	0422236	.B4817.97	440	0568057	.E003M8	275	0569658	.E03110-32	256
0421154	.B44118.0	436	0422243	.B4817.98	440	0568064	.E003M10	275	0569665	.E0311/4	256
0421161	.B44119.0	436	0422250	.B4817.99	440	0568071	.E003M12	275	0569672	.E0315/16	256
0421178	.B44120.0	436	0422267	.B4818.00	440	0568088	.E003M14	275	0569689	.E0313/8	256
0421185	.B44210.0	438	0422274	.B4818.01	440	0568095	.E003M16	275	0569696	.E0317/16	256
0421192	.B44212.0	438	0422281	.B4818.02	440	0568101	.E003M18	275	0569702	.E0311/2	256
0421208	.B44214.0	438	0422298	.B4818.03	440	0568118	.E003M20	275	0569719	.E0319/16	256
0421215	.B44215.0	438	0422304	.B4818.04	440	0568125	.E003M22	275	0569726	.E0315/8	256
0421222	.B44216.0	438	0422311	.B4819.97	440	0568132	.E003M24	275	0569733	.E0313/4	256
0421239	.B44217.0	438	0422328	.B4819.98	440	0568385	.E011M4X.5	261	0569740	.E0317/8	256
0421246	.B44218.0	438	0422335	.B4819.99	440	0568392	.E011M5X.5	261	0569757	.E0311	256
0421253	.B44220.0	438	0422564	.A34533.0	170	0568408	.E011M6X.5	261	0569818	.E0411/8	284
0421567	.B4810.98	440	0423585	.A95231.0	172	0568415	.E011M6X.75	261	0569825	.E0411/4	284
0421574	.B4810.99	440	0423592	.A95232.0	172	0568422	.E011M8X.75	261	0569832	.E0413/8	284
0421581	.B4811.00	440	0423608	.A95233.0	172	0568439	.E011M8X1.0	261	0569849	.E0411/2	284
0421598	.B4811.01	440	0423615	.A95238.0	172	0568446	.E011M10X1.0	261	0569856	.E0413/4	284
0421604	.B4811.02	440	0423622	.A95240.0	172	0568453	.E011M10X1.25	261	0569917	.E0431/8	286
0421611	.B4811.03	440	0423639	.A9528.0	172	0568460	.E011M12X1.0	261	0569924	.E0431/4	286
0421628	.B4811.48	440	0423646	.A9528.5	172	0568477	.E011M12X1.25	261	0569931	.E0433/8	286
0421635	.B4811.49	440	0423653	.A9529.0	172	0568484	.E011M12X1.5	261	0569948	.E0431/2	286
0421642	.B4811.50	440	0423660	.A95234.0	172	0568491	.E011M14X1.0	261	0569955	.E0433/4	286
0421659	.B4811.51	440	0423677	.A95235.0	172	0568507	.E011M14X1.25	261	0570081	.E0338-36	270
0421666	.B4811.52	440	0423912	.A217SET	197	0568514	.E011M14X1.5	261	0570098	.E03310-32	270
0421673	.B4811.53	440	0423929	.A218SET	197	0568521	.E011M16X1.0	261	0570104	.E0331/4	270
0421680	.B4811.98	440	0423936	.A221SET	198	0568538	.E011M16X1.5	261	0570111	.E0335/16	270
0421697	.B4811.99	440	0426296	.B1223/8	453	0568545	.E011M18X1.0	261	0570128	.E0333/8	270
0421703	.B48110.00	440	0426302	.B44113.0	436	0568552	.E011M18X1.5	261	0570135	.E0337/16	270
0421710	.B48110.01	440	0426319	.B44219.0	438	0568569	.E011M20X1.0	261	0570142	.E0331/2	270
0421727	.B48110.02	440	0441312	.A921N7	56	0568576	.E011M20X1.5	261	0570159	.E0339/16	270
0421734	.B48110.03	440	0441336	.A92113/64	56	0568583	.E011M20X2.0	261	0570166	.E0335/8	270
0421741	.B48110.04	440	0566961	.A720.16	130	0568590	.E011M22X1.5	261	0570173	.E0333/4	270
0421758	.B48110.05	440	0566978	.A720.27	130	0568606	.E011M24X1.5	261	0570180	.E0337/8	270
0421765	.B48111.97	440	0567586	.E000M3	261	0568613	.E011M24X2.0	261	0570197	.E0331	270
0421772	.B48111.98	440	0567593	.E000M3.5	261	0568798	.E013M4X.5	275	0571125	.A0121/4	78
0421789	.B48111.99	440	0567609	.E000M4	261	0568804	.E013M5X.5	275	0571163	.A012A	78
0421796	.B48112.00	440	0567616	.E000M5	261	0568811	.E013M6X.5	275	0571170	.A012B	78
0421802	.B48112.01	440	0567623	.E000M6	261	0568828	.E013M6X.75	275	0571187	.A012C	78
0421819	.B48112.02	440	0567630	.E000M8	261	0568835	.E013M8X.75	275	0571194	.A012D	78
0421826	.B48112.03	440	0567647	.E000M10	261	0568842	.E013M8X1.0	275	0571200	.A012E	78
0421833	.B48112.04	440	0567654	.E000M12	261	0568859	.E013M10X1.0	275	0571217	.A012F	78
0421840	.B48112.05	440	0567661	.E000M14	261	0568866	.E013M10X1.25	275	0571224	.A012G	78
0421857	.B4812.00	440	0567678	.E000M16	261	0568873	.E013M12X1.0	275	0571231	.A012H	78
0421864	.B4812.01	440	0567685	.E000M18	261	0568880	.E013M12X1.25	275	0571248	.A012I	78
0421871	.B4812.02	440	0567692	.E000M20	261	0568897	.E013M12X1.5	275	0571255	.A012J	78
0421888	.B4812.03	440	0567708	.E000M22	261	0568903	.E013M14X1.5	275	0571262	.A012K	78
0421895	.B4812.48	440	0567715	.E000M24	261	0568910	.E013M16X1.0	275	0571279	.A012L	78
0421901	.B4812.49	440	0567722	.E001M3	261	0568927	.E013M16X1.5	275	0571286	.A012M	78
0421918	.B4812.50	440	0567739	.E001M3.5	261	0568934	.E013M18X1.5	275	0571293	.A012N	78
0421925	.B4812.51	440	0567746	.E001M4	261	0568941	.E013M20X1.5	275	0571309	.A012N1	78

# EDP NUMBER INDEX - 0571316 - 0582282

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0571316	A012N10	78	0572108	A01235/64	78	0580387	E005M10	258	0581360	E0265/163FL	253
0571323	A012N11	78	0572115	A01237/64	78	0580394	E005M103FL	258	0581377	E0263/8	253
0571330	A012N12	78	0572122	A01239/64	78	0580400	E005M12	258	0581384	E0263/8H11	253
0571347	A012N13	78	0572139	A0125/16	78	0580417	E005M123FL	258	0581391	E0263/83FL	253
0571354	A012N14	78	0572146	A0125/32	78	0580424	E005M14	258	0581407	E0267/16	253
0571361	A012N15	78	0572153	A0125/8	78	0580431	E005M16	258	0581414	E0261/2	253
0571378	A012N16	78	0572160	A0127/16	78	0580448	E005M18	258	0581421	E0261/2H11	253
0571385	A012N17	78	0572177	A0127/32	78	0580455	E005M20	258	0581438	E0261/23FL	253
0571392	A012N18	78	0572184	A0127/64	78	0580462	E006M4	258	0581445	E0269/16	253
0571408	A012N19	78	0572191	A0129/16	78	0580479	E006M5	258	0581452	E0265/8H11	253
0571415	A012N2	78	0572207	A0129/32	78	0580486	E006M53FL	258	0581469	E0265/8	253
0571422	A012N20	78	0572214	A0129/64	78	0580493	E006M6	258	0581476	E0263/4	253
0571439	A012N21	78	0573433	C11011.5	406	0580509	E006M63FL	258	0581483	E0267/8	253
0571446	A012N22	78	0573440	C11011.7	406	0580516	E006M8	258	0581490	E0261	253
0571453	A012N23	78	0573457	C11012.5	406	0580523	E006M10	258	0581506	E0276-32	268
0571460	A012N24	78	0573464	C11013.7	406	0580530	E006M103FL	258	0581513	E0278-32	268
0571477	A012N25	78	0573471	C11015.7	406	0580547	E006M12	258	0581520	E02710-24	268
0571484	A012N26	78	0573488	C11024.0	406	0580554	E006M123FL	258	0581537	E02712-24	268
0571491	A012N27	78	0573495	C1107.75	406	0580561	E006M14	258	0581544	E0271/4	268
0571507	A012N28	78	0573501	C1109.7	406	0580578	E006M16	258	0581551	E0275/16	268
0571514	A012N29	78	0573952	A0121/64	78	0580585	E006M18	258	0581568	E0273/8	268
0571521	A012N3	78	0573969	A0121/32	78	0580592	E006M20	258	0581575	E0277/16	268
0571538	A012N30	78	0573976	A0123/64	78	0580608	E007M4	272	0581582	E0271/2	268
0571545	A012N31	78	0573983	A012N53	78	0580615	E007M5	272	0581599	E0279/16	268
0571552	A012N32	78	0573990	A012N54	78	0580622	E007M6	272	0581605	E0275/8	268
0571569	A012N33	78	0574003	A012N55	78	0580639	E007M8	272	0581612	E0273/4	268
0571576	A012N34	78	0574010	A012N56	78	0580646	E007M10	272	0581629	E0277/8	268
0571583	A012N35	78	0574027	A012N57	78	0580653	E007M12	272	0581636	E0271	268
0571590	A012N36	78	0574034	A012N58	78	0580660	E007M14	272	0581643	E0284-40	268
0571606	A012N37	78	0574041	A012N59	78	0580677	E007M16	272	0581650	E0285-40	268
0571613	A012N38	78	0574058	A012N60	78	0580684	E007M18	272	0581667	E0286-32	268
0571620	A012N39	78	0574065	A012N61	78	0580691	E007M20	272	0581674	E0288-32	268
0571637	A012N4	78	0574072	A012N62	78	0580707	E008M4	272	0581681	E02810-24	268
0571644	A012N40	78	0574089	A012N63	78	0580714	E008M5	272	0581698	E02812-24	268
0571651	A012N41	78	0574096	A012N64	78	0580721	E008M6	272	0581704	E0281/4	268
0571668	A012N42	78	0574102	A012N65	78	0580738	E008M8	272	0581711	E0285/16	268
0571675	A012N43	78	0574119	A012N66	78	0580745	E008M10	272	0581728	E0283/8	268
0571682	A012N44	78	0574126	A012N67	78	0580752	E008M12	272	0581735	E0283/8H5	268
0571699	A012N45	78	0574133	A012N68	78	0580769	E008M14	272	0581742	E0287/16	268
0571705	A012N46	78	0574140	A012N69	78	0580776	E008M16	272	0581759	E0281/2	268
0571712	A012N5	78	0574157	A012N70	78	0580783	E008M18	272	0581766	E0289/16	268
0571729	A012N6	78	0574164	A012N71	78	0580790	E008M20	272	0581773	E0285/8	268
0571736	A012N7	78	0574171	A012N72	78	0580950	E016M8X1.0	258	0581780	E0283/4	268
0571743	A012N8	78	0574188	A012N73	78	0580967	E016M10X1.0	258	0581797	E0287/8	268
0571750	A012N9	78	0574195	A012N74	78	0580974	E016M14X1.5	258	0581803	E0281	268
0571767	A012C	78	0574201	A012N75	78	0580981	E016M18X1.5	258	0581957	E0356-40	253
0571774	A012P	78	0574218	A012N76	78	0581032	E018M8X1.0	272	0581964	E0358-36	253
0571781	A012Q	78	0574225	A012N77	78	0581049	E018M10X1.0	272	0581971	E03510-32	253
0571798	A012R	78	0574232	A012N78	78	0581056	E018M14X1.5	272	0581988	E03512-28	253
0571804	A012S	78	0574249	A012N79	78	0581063	E018M18X1.5	272	0581995	E0351/4	253
0571811	A012T	78	0574256	A012N80	78	0581070	E0256-32	253	0582008	E0351/43FL	253
0571828	A012U	78	0574317	A09718	202	0581087	E0258-32	253	0582015	E0355/16	253
0571835	A012V	78	0574324	A09712	202	0581094	E02510-24	253	0582022	E0355/163FL	253
0571842	A012W	78	0574331	A09714	202	0581100	E02512-24	253	0582039	E0353/8	253
0571859	A012X	78	0574348	A09720	202	0581117	E0251/4	253	0582046	E0353/83FL	253
0571866	A012Y	78	0574355	A09760	202	0581124	E0251/43FL	253	0582053	E0357/163FL	253
0571873	A012Z	78	0574362	A09730	202	0581131	E0255/16	253	0582060	E0351/2	253
0571880	A0121/2	78	0578636	A0121/16	78	0581148	E0255/163FL	253	0582077	E0351/23FL	253
0571897	A0121/8	78	0578643	A0125/64	78	0581155	E0253/8	253	0582084	E0359/16	253
0571903	A01211/32	78	0578650	A012N47	78	0581162	E0253/83FL	253	0582091	E0355/8	253
0571910	A01211/64	78	0578667	A012N48	78	0581179	E0257/16	253	0582107	E0353/4	253
0571927	A01213/32	78	0578674	A012N49	78	0581186	E0251/2	253	0582114	E0357/8	253
0571934	A01213/64	78	0578681	A012N50	78	0581193	E0251/23FL	253	0582121	E0351-12	253
0571941	A01215/32	78	0578698	A012N51	78	0581209	E0259/16	253	0582138	E0351-14	253
0571958	A01215/64	78	0578704	A012N52	78	0581216	E0255/8	253	0582145	E03610-32	253
0571965	A01217/32	78	0578711	A01211/16	78	0581223	E0253/4	253	0582152	E03612-28	253
0571972	A01217/64	78	0578728	A01221/32	78	0581230	E0257/8	253	0582169	E0361/4	253
0571989	A01219/32	78	0578735	A01223/32	78	0581247	E0251	253	0582176	E0361/43FL	253
0571996	A01219/64	78	0578742	A01245/64	78	0581254	E0264-40	253	0582183	E0365/16	253
0572009	A01221/64	78	0578759	A0123/4	78	0581261	E0265-40	253	0582190	E0365/163FL	253
0572016	A01223/64	78	0578766	A01247/64	78	0581278	E0266-32	253	0582206	E0363/8	253
0572023	A01225/64	78	0580301	E005M4	258	0581285	E0268-32	253	0582213	E0363/83FL	253
0572030	A01227/64	78	0580318	E005M43FL	258	0581292	E02610-24	253	0582220	E0367/163FL	253
0572047	A01229/64	78	0580325	E005M5	258	0581308	E02612-24	253	0582237	E0361/2	253
0572054	A0123/16	78	0580332	E005M53FL	258	0581315	E0261/4	253	0582244	E0361/23FL	253
0572061	A0123/32	78	0580349	E005M6	258	0581322	E0261/4H11	253	0582251	E0369/16	253
0572078	A0123/8	78	0580356	E005M63FL	258	0581339	E0261/43FL	253	0582268	E0365/8	253
0572085	A01231/64	78	0580363	E005M8	258	0581346	E0265/16	253	0582275	E0363/4	253
0572092	A01233/64	78	0580370	E005M83FL	258	0581353	E0265/16H11	253	0582282	E0367/8	253

# EDP NUMBER INDEX - 0582299 - 0615034

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0582299	E0361-12	253	0589199	A0223/8	120	0600214	A0222.8	120	0614259	R45410.2	46
0582305	E0361-14	253	0589205	A0224.0	120	0600221	A0222.9	120	0614266	R45410.3	46
0582312	E03710-32	268	0589212	A0224.1	120	0600238	A0223/32	120	0614273	R45410.4	46
0582329	E0371/4	268	0589229	A0224.2	120	0600245	A0227/64	120	0614280	R45410.5	46
0582336	E0375/16	268	0589236	A0224.3	120	0600382	A022.5	120	0614297	R45411.0	46
0582343	E0373/8	268	0589243	A0224.4	120	0600399	A022.6	120	0614303	R45411.2	46
0582350	E0377/16	268	0589250	A0224.5	120	0600405	A022.7	120	0614310	R45411.5	46
0582367	E0371/2	268	0589267	A0224.6	120	0600412	A022.8	120	0614327	R45412.0	46
0582374	E0379/16	268	0589274	A0224.7	120	0600429	A022.9	120	0614334	R45412.2	46
0582381	E0375/8	268	0589281	A0224.8	120	0600436	A0221.0	120	0614341	R45412.5	46
0582398	E0373/4	268	0589298	A0224.9	120	0600443	A0221.1	120	0614358	R45413.0	46
0582404	E0377/8	268	0589304	A0225.0	120	0600450	A0221.2	120	0614365	R45413.5	46
0582411	E0371-12	268	0589311	A0225.1	120	0600467	A0221.3	120	0614372	R45414.0	46
0582428	E0371-14	268	0589328	A0225.2	120	0600474	A0221.4	120	0614389	R45414.25	46
0582435	E03810-32	268	0589335	A0225.3	120	0600481	A0221.5	120	0614396	R45414.5	46
0582442	E0381/4	268	0589342	A0225.4	120	0600498	A0221.6	120	0614402	R45415.0	46
0582459	E0385/16	268	0589359	A0225.5	120	0600504	A0221.7	120	0614419	R45415.5	46
0582466	E0383/8	268	0589366	A0225.6	120	0600511	A0221.8	120	0614426	R45416.0	46
0582473	E0387/16	268	0589373	A0225.7	120	0600528	A0221.9	120	0614433	R4543.0	46
0582480	E0381/2	268	0589380	A0225.8	120	0600535	A0221/16	120	0614440	R4543.3	46
0582497	E0389/16	268	0589397	A0225.9	120	0600542	A0221/32	120	0614457	R4543.4	46
0582503	E0385/8	268	0589403	A0225/16	120	0600559	A0223/64	120	0614464	R4543.5	46
0582510	E0383/4	268	0589410	A0225/32	120	0600566	A0225/64	120	0614471	R4544.0	46
0582527	E0387/8	268	0589427	A0225/8	120	0605356	A0023.25	82	0614488	R4544.2	46
0582534	E0381-12	268	0589434	A0226.0	120	0609309	C27340.0	427	0614495	R4544.3	46
0582541	E0381-14	268	0589441	A0226.1	120	0609316	C24717.0	425	0614501	R4544.5	46
0583180	E006M43FL	258	0589458	A0226.2	120	0609323	C24719.0	425	0614518	R4545.0	46
0583197	E006M83FL	258	0589465	A0226.3	120	0609330	C24721.0	425	0614525	R4545.1	46
0583203	E0262-56	253	0589472	A0226.4	120	0609347	C24723.0	425	0614532	R4545.5	46
0588697	A0223.0	120	0589489	A0226.5	120	0609354	C24724.0	425	0614549	R4546.0	46
0588703	A0221/2	120	0589496	A0226.6	120	0609361	C24726.0	425	0614556	R4546.5	46
0588710	A0221/4	120	0589502	A0226.7	120	0609378	C24736.0	425	0614563	R4546.7	46
0588727	A0221/8	120	0589519	A0226.8	120	0609385	C24740.0	425	0614570	R4546.8	46
0588734	A02210.0	120	0589526	A0226.9	120	0612057	A720.17	130	0614587	R4546.9	46
0588741	A02210.1	120	0589533	A0227.0	120	0612064	A720.55	130	0614594	R4547.0	46
0588758	A02210.2	120	0589540	A0227.1	120	0612071	A720.62	130	0614600	R4547.4	46
0588765	A02210.3	120	0589557	A0227.2	120	0612088	A720.65	130	0614617	R4547.5	46
0588772	A02210.4	120	0589564	A0227.3	120	0612101	A720.75	130	0614624	R4548.0	46
0588789	A02210.5	120	0589571	A0227.4	120	0612125	A720.85	130	0614631	R4548.5	46
0588796	A02210.6	120	0589588	A0227.5	120	0612149	A720.95	130	0614648	R4548.6	46
0588802	A02210.7	120	0589595	A0227.6	120	0612163	A7201.05	130	0614655	R4548.7	46
0588819	A02210.8	120	0589601	A0227.7	120	0613870	R45310.0	46	0614662	R4549.0	46
0588826	A02210.9	120	0589618	A0227.8	120	0613887	R45310.2	46	0614679	R4549.3	46
0588833	A02211.0	120	0589625	A0227.9	120	0613894	R45310.3	46	0614686	R4549.5	46
0588840	A02211.1	120	0589632	A0227/16	120	0613900	R45310.5	46	0614693	R45710.0	40
0588857	A02211.2	120	0589649	A0227/32	120	0613917	R45311.0	46	0614709	R45710.2	40
0588864	A02211.3	120	0589656	A0228.0	120	0613924	R45311.2	46	0614716	R45710.3	40
0588871	A02211.5	120	0589663	A0228.1	120	0613931	R45311.5	46	0614723	R45710.4	40
0588888	A02211.6	120	0589670	A0228.2	120	0613948	R45312.0	46	0614730	R45710.5	40
0588895	A02211.7	120	0589687	A0228.3	120	0613955	R45312.2	46	0614747	R45711.0	40
0588901	A02211.8	120	0589694	A0228.4	120	0613962	R45312.5	46	0614754	R45711.2	40
0588918	A02211.9	120	0589700	A0228.5	120	0613979	R45313.0	46	0614761	R45711.5	40
0588925	A02211/32	120	0589717	A0228.6	120	0613986	R45313.5	46	0614778	R45712.0	40
0588932	A02211/64	120	0589724	A0228.7	120	0613993	R45314.0	46	0614785	R45712.2	40
0588949	A02212.0	120	0589731	A0228.8	120	0614006	R45314.25	46	0614792	R45712.5	40
0588956	A02212.1	120	0589748	A0228.9	120	0614013	R45314.5	46	0614808	R45713.0	40
0588963	A02212.2	120	0589755	A0229.0	120	0614020	R45315.0	46	0614815	R45713.5	40
0588970	A02212.5	120	0589762	A0229.1	120	0614037	R45315.5	46	0614822	R45714.0	40
0588987	A02213.0	120	0589779	A0229.2	120	0614044	R45316.0	46	0614839	R45714.25	40
0588994	A02213.5	120	0589786	A0229.3	120	0614051	R4533.0	46	0614846	R45714.5	40
0589007	A02213/32	120	0589793	A0229.4	120	0614068	R4533.4	46	0614853	R45715.0	40
0589014	A02213/64	120	0589809	A0229.5	120	0614075	R4533.5	46	0614860	R45715.5	40
0589021	A02214.0	120	0589816	A0229.6	120	0614082	R4534.0	46	0614877	R45716.0	40
0589038	A02214.5	120	0589823	A0229.7	120	0614099	R4534.3	46	0614884	R4573.0	40
0589045	A02215.0	120	0589830	A0229.8	120	0614105	R4534.5	46	0614891	R4573.3	40
0589052	A02215.5	120	0589847	A0229.9	120	0614112	R4535.0	46	0614907	R4573.4	40
0589069	A02215/64	120	0589854	A0229/16	120	0614129	R4535.1	46	0614914	R4573.5	40
0589076	A02216.0	120	0589861	A0229/32	120	0614136	R4535.5	46	0614921	R4574.0	40
0589083	A0223.1	120	0589878	A0229/64	120	0614143	R4536.0	46	0614938	R4574.2	40
0589090	A0223.2	120	0600115	A0222.0	120	0614150	R4536.5	46	0614945	R4574.3	40
0589106	A0223.25	120	0600122	A0222.1	120	0614167	R4536.9	46	0614952	R4574.5	40
0589113	A0223.3	120	0600139	A0222.2	120	0614174	R4537.0	46	0614969	R4575.0	40
0589120	A0223.4	120	0600146	A0222.25	120	0614181	R4537.5	46	0614976	R4575.1	40
0589137	A0223.5	120	0600153	A0222.3	120	0614198	R4538.0	46	0614983	R4575.5	40
0589144	A0223.6	120	0600160	A0222.4	120	0614204	R4538.5	46	0614990	R4576.0	40
0589151	A0223.7	120	0600177	A0222.5	120	0614211	R4538.7	46	0615003	R4576.5	40
0589168	A0223.8	120	0600184	A0222.6	120	0614228	R4539.0	46	0615010	R4576.8	40
0589175	A0223.9	120	0600191	A0222.65	120	0614235	R4539.5	46	0615027	R4576.9	40
0589182	A0223/16	120	0600207	A0222.7	120	0614242	R45410.0	46	0615034	R4577.0	40

# EDP NUMBER INDEX - 0615041 - 0625989

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0615041	R4577.4	40	0623633	R45311/32	46	0624418	R4571/2	40	0625200	R4589/16	40
0615058	R4577.5	40	0623640	R45311/64	46	0624425	R4571/4	40	0625217	R4589/32	40
0615065	R4578.0	40	0623657	R45313/32	46	0624432	R4571/8	40	0625224	R4589/64	40
0615072	R4578.5	40	0623664	R45313/64	46	0624449	R45711/16	40	0625231	R45310.05	46
0615089	R4578.6	40	0623671	R45315/32	46	0624456	R45711/32	40	0625248	R45310.1	46
0615096	R4578.7	40	0623688	R45315/64	46	0624463	R45711/64	40	0625255	R45310.6	46
0615102	R4579.0	40	0623695	R45317/32	46	0624470	R45713/32	40	0625262	R45311.8	46
0615119	R4579.3	40	0623701	R45317/64	46	0624487	R45713/64	40	0625279	R45312.05	46
0615126	R4579.5	40	0623718	R45319/32	46	0624494	R45715/32	40	0625286	R45312.7	46
0615133	R45810.0	40	0623725	R45319/64	46	0624500	R45715/64	40	0625293	R45315.1	46
0615140	R45810.2	40	0623732	R45321/32	46	0624517	R45717/32	40	0625309	R45316.5	46
0615157	R45810.3	40	0623749	R45321/64	46	0624524	R45717/64	40	0625316	R45317.0	46
0615164	R45810.4	40	0623756	R45323/32	46	0624531	R45719/32	40	0625323	R45317.5	46
0615171	R45810.5	40	0623763	R45323/64	46	0624548	R45719/64	40	0625330	R45318.0	46
0615188	R45811.0	40	0623770	R45325/64	46	0624555	R45721/32	40	0625347	R45318.5	46
0615195	R45811.2	40	0623787	R45327/64	46	0624562	R45721/64	40	0625354	R45319.0	46
0615201	R45811.5	40	0623794	R45329/64	46	0624579	R45723/32	40	0625361	R45319.5	46
0615218	R45812.0	40	0623800	R4533/16	46	0624586	R45723/64	40	0625378	R45320.0	46
0615225	R45812.2	40	0623817	R4533/4	46	0624593	R45725/64	40	0625385	R4533.1	46
0615232	R45812.5	40	0623824	R4533/8	46	0624609	R45727/64	40	0625392	R4533.2	46
0615249	R45813.0	40	0623831	R45331/64	46	0624616	R45729/64	40	0625408	R4533.6	46
0615256	R45813.5	40	0623848	R45333/64	46	0624623	R4573/16	40	0625415	R4533.7	46
0615263	R45814.0	40	0623855	R45335/64	46	0624630	R4573/4	40	0625422	R4533.8	46
0615270	R45814.25	40	0623862	R45337/64	46	0624647	R4573/8	40	0625439	R4534.05	46
0615287	R45814.5	40	0623879	R45339/64	46	0624654	R45731/64	40	0625446	R4534.1	46
0615294	R45815.0	40	0623886	R45341/64	46	0624661	R45733/64	40	0625453	R4534.6	46
0615300	R45815.5	40	0623893	R45343/64	46	0624678	R45735/64	40	0625460	R4534.7	46
0615317	R45816.0	40	0623909	R45345/64	46	0624685	R45737/64	40	0625477	R4535.05	46
0615324	R4583.0	40	0623916	R45347/64	46	0624692	R45739/64	40	0625484	R4535.6	46
0615331	R4583.3	40	0623923	R4535/16	46	0624708	R45741/64	40	0625491	R4535.7	46
0615348	R4583.4	40	0623930	R4535/32	46	0624715	R45743/64	40	0625507	R4535.8	46
0615355	R4583.5	40	0623947	R4535/8	46	0624722	R45745/64	40	0625514	R4536.05	46
0615362	R4584.0	40	0623954	R4537/16	46	0624739	R45747/64	40	0625521	R4536.1	46
0615379	R4584.2	40	0623961	R4537/32	46	0624746	R4575/16	40	0625538	R4536.3	46
0615386	R4584.3	40	0623978	R4539/16	46	0624753	R4575/32	40	0625545	R4536.6	46
0615393	R4584.5	40	0623985	R4539/32	46	0624760	R4575/8	40	0625552	R4537.1	46
0615409	R4585.0	40	0623992	R4539/64	46	0624777	R4577/16	40	0625559	R4537.3	46
0615416	R4585.1	40	0624005	R4541/2	46	0624784	R4577/32	40	0625576	R4537.6	46
0615423	R4585.5	40	0624012	R4541/4	46	0624791	R4579/16	40	0625583	R4537.8	46
0615430	R4586.0	40	0624029	R4541/8	46	0624807	R4579/32	40	0625590	R4538.05	46
0615447	R4586.5	40	0624036	R45411/16	46	0624814	R4579/64	40	0625606	R4538.1	46
0615454	R4586.8	40	0624043	R45411/32	46	0624821	R4581/2	40	0625613	R4538.8	46
0615461	R4586.9	40	0624050	R45411/64	46	0624838	R4581/4	40	0625620	R4539.1	46
0615478	R4587.0	40	0624067	R45413/32	46	0624845	R4581/8	40	0625637	R4539.6	46
0615485	R4587.4	40	0624074	R45413/64	46	0624852	R45811/16	40	0625644	R4539.8	46
0615492	R4587.5	40	0624081	R45415/32	46	0624869	R45811/32	40	0625651	R4540.1	46
0615508	R4588.0	40	0624098	R45415/64	46	0624876	R45811/64	40	0625668	R4540.6	46
0615515	R4588.5	40	0624104	R45417/32	46	0624883	R45813/32	40	0625675	R4541.8	46
0615522	R4588.6	40	0624111	R45417/64	46	0624890	R45813/64	40	0625682	R45412.1	46
0615539	R4588.7	40	0624128	R45419/32	46	0624906	R45815/32	40	0625699	R45412.7	46
0615546	R4589.0	40	0624135	R45419/64	46	0624913	R45815/64	40	0625705	R45415.1	46
0615553	R4589.3	40	0624142	R45421/32	46	0624920	R45817/32	40	0625712	R4543.1	46
0615560	R4589.5	40	0624159	R45421/64	46	0624937	R45817/64	40	0625729	R4543.2	46
0615577	A720.7	130	0624166	R45423/32	46	0624944	R45819/32	40	0625736	R4543.6	46
0615584	A720.8	130	0624173	R45423/64	46	0624951	R45819/64	40	0625743	R4543.7	46
0615591	A720.9	130	0624180	R45425/64	46	0624968	R45821/32	40	0625750	R4543.8	46
0615607	A7201.0	130	0624180	R45425/64	46	0624975	R45821/64	40	0625767	R4543.9	46
0615614	A7201.1	130	0624197	R45427/64	46	0624982	R45823/32	40	0625774	R4544.1	46
0615621	A7201.2	130	0624203	R45429/64	46	0624999	R45823/64	40	0625781	R4544.6	46
0615638	A7201.3	130	0624210	R4543/16	46	0625002	R45825/64	40	0625798	R4544.7	46
0615645	A7201.4	130	0624227	R4543/4	46	0625019	R45827/64	40	0625804	R4545.6	46
0616116	R4536.8	46	0624234	R4543/8	46	0625026	R45829/64	40	0625811	R4545.7	46
0616123	R4539.3	46	0624241	R45431/64	46	0625033	R4583/16	40	0625828	R4545.8	46
0616130	R45310.4	46	0624258	R45433/64	46	0625040	R4583/4	40	0625835	R4546.1	46
0616147	R4533.3	46	0624265	R45435/64	46	0625057	R4583/8	40	0625842	R4546.3	46
0616154	R4534.2	46	0624272	R45437/64	46	0625064	R45831/64	40	0625859	R4546.6	46
0616161	R4537.4	46	0624289	R45439/64	46	0625071	R45833/64	40	0625866	R4547.1	46
0616178	R4538.6	46	0624296	R45441/64	46	0625088	R45835/64	40	0625873	R4547.3	46
0616185	A088200S	214	0624302	R45443/64	46	0625095	R45837/64	40	0625880	R4547.6	46
0621929	C1101	406	0624319	R45445/64	46	0625101	R45839/64	40	0625897	R4547.8	46
0622032	R45814.8	40	0624326	R45447/64	46	0625118	R45841/64	40	0625903	R4548.1	46
0622049	R45715.8	40	0624333	R4545/16	46	0625125	R45843/64	40	0625910	R4548.8	46
0622056	R45718.8	40	0624340	R4545/32	46	0625132	R45845/64	40	0625927	R4549.1	46
0622063	R45719.8	40	0624357	R4545/8	46	0625149	R45847/64	40	0625934	R4549.6	46
0622070	R4574.9	40	0624364	R4547/16	46	0625156	R4585/16	40	0625941	R4549.8	46
0623596	R4531/2	46	0624371	R4547/32	46	0625163	R4585/32	40	0625958	R45710.05	46
0623602	R4531/4	46	0624388	R4549/16	46	0625170	R4585/8	40	0625965	R45710.1	40
0623619	R4531/8	46	0624395	R4549/32	46	0625187	R4587/16	40	0625972	R45710.6	40
0623626	R45311/16	46	0624401	R4549/64	46	0625194	R4587/32	40	0625989	R45711.8	40

# EDP NUMBER INDEX - 0625996 - 0640258

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0625996	R45712.05	40	0629024	C11050.0	406	0634516	A90019.5	65	0635872	A9415/32	68
0626009	R45712.1	40	0629031	C1106.75	406	0634523	A90025/32	65	0635889	A94111/64	68
0626016	R45712.7	40	0629055	R4539.7	46	0634547	A9011.55	65	0635896	A9413/16	68
0626023	R45715.1	40	0629055	R4539.7	46	0634554	A9011/16	65	0635902	A94113/64	68
0626030	R45716.5	40	0629062	R4579.7	40	0634561	A9011.6	65	0635919	A9417/32	68
0626047	R45717.0	40	0629062	R4579.7	40	0634592	A9011.75	65	0635926	A94115/64	68
0626054	R45717.5	40	0632956	A9217/32	56	0634615	A9011.8	65	0635933	A9411/4	68
0626061	R45718.0	40	0632994	A92115/64	56	0634639	A9011.9	65	0635940	A94117/64	68
0626078	R45718.5	40	0633038	A9211/4	56	0634646	A901N48	65	0635957	A9419/32	68
0626085	R45719.0	40	0633069	A92117/64	56	0634653	A9015/64	65	0635964	A94119/64	68
0626092	R45719.5	40	0633106	A9219/32	56	0634677	A901N46	65	0635971	A9415/16	68
0626108	R45720.0	40	0633113	A921L	56	0634684	A901N45	65	0635988	A94121/64	68
0626115	R4573.1	40	0633137	A92119/64	56	0634691	A9012.1	65	0635995	A94111/32	68
0626122	R4573.2	40	0633151	A9215/16	56	0634707	A9012.15	65	0636008	A94123/64	68
0626139	R4573.6	40	0633175	A92121/64	56	0634738	A9012.35	65	0636015	A9413/8	68
0626146	R4573.7	40	0633205	A92111/32	56	0634752	A9013/32	65	0636022	A94125/64	68
0626153	R4573.8	40	0633236	A92123/64	56	0634769	A9012.4	65	0636039	A94113/32	68
0626160	R4573.9	40	0633250	A9213/8	56	0634776	A901N41	65	0636046	A94127/64	68
0626177	R4574.05	40	0633274	A92125/64	56	0634783	A901N40	65	0636053	A9417/16	68
0626184	R4574.1	40	0633304	A92113/32	56	0634820	A9012.7	65	0636060	A94129/64	68
0626191	R4574.6	40	0633328	A92127/64	56	0634844	A9017/64	65	0636077	A94115/32	68
0626207	R4574.7	40	0633335	A92110.75	56	0634882	A9012.9	65	0636084	A94131/64	68
0626214	R4575.05	40	0633342	A9217/16	56	0634912	A9011/8	65	0636091	A9411/2	68
0626221	R4575.6	40	0633359	A92111.25	56	0634929	A901N30	65	0636107	A94133/64	68
0626238	R4575.7	40	0633366	A92129/64	56	0634943	A9019/64	65	0636114	A94135/64	68
0626245	R4575.8	40	0633373	A92115/32	56	0634967	A901N26	65	0636121	A9419/16	68
0626252	R4576.05	40	0633380	A92131/64	56	0634998	A9015/32	65	0636138	A94137/64	68
0626269	R4576.1	40	0633397	A9211/2	56	0635001	A901N22	65	0636145	A94119/32	68
0626276	R4576.3	40	0633403	A92112.75	56	0635032	A901N19	65	0636152	A94139/64	68
0626283	R4576.6	40	0633410	A92133/64	56	0635056	A90111/64	65	0636169	A9415/8	68
0626290	R4577.1	40	0633427	A92135/64	56	0635094	A9013/16	65	0636176	E000M7	261
0626306	R4577.3	40	0633434	A9219/16	56	0635155	A90113/64	65	0636183	E001M7	261
0626313	R4577.6	40	0633441	A92137/64	56	0635209	A9017/32	65	0636190	E002M7	275
0626320	R4577.8	40	0633458	A92114.75	56	0635216	A901N2	65	0636206	E003M7	275
0626337	R4578.05	40	0633465	A92119/32	56	0635247	A90115/64	65	0636295	C1101/16	406
0626344	R4578.8	40	0633472	A92139/64	56	0635285	A9011/4	65	06369801	C1103/32	406
0626351	R4579.1	40	0633489	A9215/8	56	0635308	A901G	65	06369818	C1101/8	406
0626368	R4579.6	40	0633519	A900N58	65	0635315	A90117/64	65	06369825	C1103/16	406
0626375	R4579.8	40	0633540	A9003/64	65	0635322	A901H	65	06369832	C1101/4	406
0626382	R45810.1	40	0633557	A9001.25	65	0635353	A9019/32	65	06369849	C1105/16	406
0626399	R45810.6	40	0633571	A9001.35	65	0635384	A90119/64	65	06369856	C1103/8	406
0626405	R45811.8	40	0633601	A9001.55	65	0635407	A9015/16	65	06369863	C11013/32	406
0626412	R45812.1	40	0633618	A900N52	65	0635414	A901O	65	06369870	C1107/16	406
0626429	R45812.7	40	0633625	A9001.75	65	0635421	A90121/64	65	06369887	C1101/2	406
0626436	R45815.1	40	0633632	A900N50	65	0635452	A90111/32	65	06369894	C11017/32	406
0626443	R4583.1	40	0633649	A900N49	65	0635483	A90123/64	65	06369900	C1109/16	406
0626450	R4583.2	40	0633694	A9002.15	65	0635506	A9013/8	65	06369917	C1105/8	406
0626467	R4583.6	40	0633717	A900N43	65	0635520	A90125/64	65	06369924	C11011/16	406
0626474	R4583.7	40	0633724	A9002.35	65	0635537	A901X	65	06369931	C1103/4	406
0626481	R4583.73	40	0633748	A900N41	65	0635551	A90113/32	65	06369948	C1107/8	406
0626498	R4583.8	40	0633755	A900N40	65	0635575	A90127/64	65	06369962	C1101.1/8	406
0626504	R4583.9	40	0633786	A900N37	65	0635582	A90110.75	65	06369979	C1101.1/4	406
0626511	R4584.1	40	0633830	A900N32	65	0635599	A9017/16	65	06369986	C11035.0	406
0626528	R4584.6	40	0633946	A900N19	65	0635605	A90111.25	65	06369993	C1101.1/2	406
0626535	R4585.6	40	0633984	A900N14	65	0635612	A90129/64	65	0640005	C1101.3/4	406
0626542	R4585.7	40	0634011	A900N9	65	0635629	A90115/32	65	0640012	C1231/16	412
0626559	R4585.8	40	0634066	A900N3	65	0635636	A90131/64	65	0640029	C1231/8	412
0626566	R4586.1	40	0634134	A900G	65	0635643	A90112.75	65	0640036	C1235/32	412
0626573	R4586.3	40	0634271	A90010.75	65	0635650	A90133/64	65	0640043	C1233/16	412
0626580	R4586.6	40	0634295	A90012.75	65	0635667	A90135/64	65	0640050	C1231/4	412
0626597	R4587.1	40	0634318	A90033/64	65	0635674	A9019/16	65	0640067	C1235/16	412
0626603	R4587.3	40	0634325	A90035/64	65	0635681	A90137/64	65	0640074	C1233/8	412
0626610	R4587.6	40	0634332	A9009/16	65	0635704	A90119/32	65	0640081	C1231/2	412
0626627	R4587.8	40	0634349	A90037/64	65	0635711	A90139/64	65	0640098	C1239/16	412
0626634	R4588.1	40	0634356	A90014.75	65	0635728	A9015/8	65	0640104	C1235/8	412
0626641	R4588.8	40	0634363	A90019/32	65	0635735	A9403/64	68	0640111	C1233/4	412
0626658	R4589.1	40	0634370	A90039/64	65	0635742	A94035/64	68	0640128	C1231	412
0626665	R4589.6	40	0634387	A9005/8	65	0635759	A94039/64	68	0640135	C1231.1/2	412
0626672	R4589.8	40	0634394	A90041/64	65	0635766	A94041/64	68	0640142	C2471/8	425
0626689	R4578.1	40	0634400	A90016.5	65	0635773	A94043/64	68	0640159	C2473/16	425
0628911	R4533.9	46	0634417	A90021/32	65	0635780	A94049/64	68	0640166	C2471/4	425
0628942	C11017.7	406	0634431	A90043/64	65	0635797	A94025/32	68	0640173	C2475/16	425
0628959	C11019.7	406	0634448	A90011/16	65	0635803	A9413/64	68	0640180	C2473/8	425
0628966	C11021.7	406	0634455	A90045/64	65	0635810	A9411/16	68	0640197	C2471/2	425
0628973	C11024.7	406	0634462	A90023/32	65	0635827	A9415/64	68	0640203	C2479/16	425
0628980	C11026.0	406	0634479	A90018.5	65	0635834	A9413/32	68	0640210	C2475/8	425
0628997	C11036.0	406	0634486	A90047/64	65	0635841	A9417/64	68	0640227	C2473/4	425
0629000	C11040.0	406	0634493	A9003/4	65	0635858	A9411/8	68	0640234	C2477/8	425
0629017	C11045.0	406	0634509	A90049/64	65	0635865	A9419/64	68	0640241	C2471	425
									0640258	C24750.0	425

# EDP NUMBER INDEX - 0640265 - 1010507

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0640265	C2731/8	427	1010128	15005/8X18H3NO2	287	1010265	15993/8X16NO3	304	1010355	15865/16X183FLNO3	317
0640272	C2733/16	427	1010131	15005/8X18H3NO3	287	1010266	15993/8X24NO2	304	1010356	15865/16X243FLNO2	317
0640289	C2731/4	427	1010132	15005/8X18H5NO3	287	1010267	15993/8X24NO3	304	1010357	15865/16X243FLNO3	317
0640296	C2733/8	427	1010139	15003/4X10H3NO1	287	1010268	15997/16X14NO2	304	1010358	15863/8X163FLNO2	317
0640302	C2731/2	427	1010141	15003/4X10H2NO2	287	1010270	15997/16X20NO2	304	1010359	15863/8X163FLNO3	317
0640319	C2735/8	427	1010142	15003/4X10H3NO2	287	1010271	15997/16X20NO3	304	1010360	15863/8X243FLNO2	317
0640326	C2733/4	427	1010144	15003/4X10H3NO3	287	1010272	15991/2X13NO2	304	1010361	15863/8X243FLNO3	317
0640340	C2731	427	1010146	15003/4X16H3NO1	287	1010273	15991/2X13NO3	304	1010362	15867/16X143FLNO2	317
0640357	C2731.1/2	427	1010149	15003/4X16H3NO2	287	1010274	15991/2X20NO2	304	1010363	15867/16X143FLNO3	317
1010001	15001/4X20H1NO1	287	1010152	15003/4X16H3NO3	287	1010275	15991/2X20NO3	304	1010366	15861/2X133FLNO2	317
1010002	15001/4X20H2NO1	287	1010154	15007/8X9H4NO1	287	1010277	15999/16X12NO3	304	1010367	15861/2X133FLNO3	317
1010003	15001/4X20H3NO1	287	1010157	15007/8X9H4NO2	287	1010279	15999/16X18NO3	304	1010368	15861/2X203FLNO2	317
1010004	15001/4X20H1NO2	287	1010159	15007/8X9H4NO3	287	1010280	15995/8X11NO2	304	1010369	15861/2X203FLNO3	317
1010005	15001/4X20H2NO2	287	1010160	15007/8X14H4NO1	287	1010281	15995/8X11NO3	304	1010375	U15111/4	343
1010006	15001/4X20H3NO2	287	1010163	15007/8X14H4NO2	287	1010282	15995/8X18NO2	304	1010376	U15115/16	343
1010007	15001/4X20H5NO2	287	1010166	15007/8X14H4NO3	287	1010283	15995/8X18NO3	304	1010377	U15113/8	343
1010008	15001/4X20H1NO3	287	1010167	15001X8H4NO1	287	1010285	15993/4X10NO3	304	1010378	U15111/2	343
1010009	15001/4X20H2NO3	287	1010170	15001X8H4NO2	287	1010286	15993/4X16NO2	304	1010379	15191/4X20X6	344
1010010	15001/4X20H3NO3	287	1010172	15001X8H4NO3	287	1010287	15993/4X16NO3	304	1010380	15191/4X20X8	344
1010011	15001/4X20H5NO3	287	1010173	15001X12H4NO1	287	1010290	15851/4X20H12FLNO2	307	1010381	15195/16X18X6	344
1010014	15001/4X28H3NO1	287	1010174	15001X12H4NO2	287	1010291	15851/4X20H22FLNO2	307	1010382	15195/16X18X8	344
1010016	15001/4X28H2NO2	287	1010175	15001X12H4NO3	287	1010292	15851/4X20H32FLNO2	307	1010383	15193/8X16X6	344
1010017	15001/4X28H3NO2	287	1010176	15001X14H4NO1	287	1010293	15851/4X20H52FLNO2	307	1010384	15193/8X16X8	344
1010018	15001/4X28H4NO2	287	1010178	15001X14H4NO2	287	1010294	15851/4X20H32FLNO3	307	1010385	15193/8X16X10	344
1010019	15001/4X28H1NO3	287	1010181	15001X14H4NO3	287	1010295	15851/4X20H33FLNO2	307	1010388	15191/2X13X6	344
1010020	15001/4X28H2NO3	287	1010182	15001.1/8X7H4NO1	287	1010296	15851/4X20H53FLNO2	307	1010389	15191/2X13X8	344
1010021	15001/4X28H3NO3	287	1010183	15001.1/8X7H4NO2	287	1010297	15851/4X20H12FLNO2	307	1010390	15191/2X13X10	344
1010022	15001/4X28H4NO3	287	1010184	15001.1/8X7H4NO3	287	1010298	15851/4X28H22FLNO2	307	1010392	15195/8X11X6	344
1010024	15005/16X18H2NO1	287	1010185	15001.1/8X12H4NO1	287	1010299	15851/4X28H32FLNO2	307	1010393	15195/8X11X8	344
1010025	15005/16X18H3NO1	287	1010186	15001.1/8X12H4NO2	287	1010300	15851/4X28H42FLNO2	307	1010394	15195/8X11X10	344
1010027	15005/16X18H2NO2	287	1010187	15001.1/8X12H4NO3	287	1010301	15851/4X28H32FLNO3	307	1010396	15193/4X10X10	344
1010028	15005/16X18H3NO2	287	1010188	15001.1/4X7H4NO1	287	1010302	15851/4X28H23FLNO2	307	1010398	15881/4X20NO2	318
1010031	15005/16X18H2NO3	287	1010189	15001.1/4X7H4NO2	287	1010303	15851/4X28H43FLNO2	307	1010399	15881/4X20NO3	318
1010032	15005/16X18H3NO3	287	1010190	15001.1/4X7H4NO3	287	1010304	15855/16X18H12FLNO2	307	1010400	15881/4X28NO2	318
1010036	15005/16X24H3NO1	287	1010191	15001.1/4X12H4NO1	287	1010305	15855/16X18H22FLNO2	307	1010401	15881/4X28NO3	318
1010039	15005/16X24H3NO2	287	1010192	15001.1/4X12H4NO2	287	1010306	15855/16X18H32FLNO2	307	1010402	15885/16X18NO2	318
1010041	15005/16X24H1NO3	287	1010193	15001.1/4X12H4NO3	287	1010307	15855/16X18H52FLNO2	307	1010403	15885/16X18NO3	318
1010043	15005/16X24H3NO3	287	1010194	15001.3/8X6H4NO1	287	1010308	15855/16X18H32FLNO3	307	1010404	15885/16X24NO2	318
1010046	15003/8X16H2NO1	287	1010195	15001.3/8X6H4NO2	287	1010309	15855/16X18H33FLNO2	307	1010405	15885/16X24NO3	318
1010047	15003/8X16H3NO1	287	1010196	15001.3/8X6H4NO3	287	1010310	15855/16X18H53FLNO2	307	1010406	15883/8X16NO2	318
1010049	15003/8X16H2NO2	287	1010197	15001.3/8X12H4NO1	287	1010311	15855/16X24H12FLNO2	307	1010407	15883/8X16NO3	318
1010050	15003/8X16H3NO2	287	1010198	15001.3/8X12H4NO2	287	1010312	15855/16X24H22FLNO2	307	1010408	15883/8X24NO2	318
1010051	15003/8X16H5NO2	287	1010199	15001.3/8X12H4NO3	287	1010313	15855/16X24H32FLNO2	307	1010409	15883/8X24NO3	318
1010053	15003/8X16H2NO3	287	1010200	15001.1/2X6H4NO1	287	1010315	15855/16X24H32FLNO3	307	1010410	15887/16X14NO2	318
1010054	15003/8X16H3NO3	287	1010201	15001.1/2X6H4NO2	287	1010316	15855/16X24H23FLNO2	307	1010411	15887/16X14NO3	318
1010055	15003/8X16H5NO3	287	1010202	15001.1/2X6H4NO3	287	1010317	15855/16X24H43FLNO2	307	1010412	15887/16X20NO2	318
1010058	15003/8X24H3NO1	287	1010203	15001.1/2X12H4NO1	287	1010318	15853/8X16H13FLNO2	307	1010413	15887/16X20NO3	318
1010061	15003/8X24H3NO2	287	1010204	15001.1/2X12H4NO2	287	1010319	15853/8X16H23FLNO2	307	1010414	15881/2X13NO2	318
1010065	15003/8X24H3NO3	287	1010205	15001.1/2X12H4NO3	287	1010320	15853/8X16H33FLNO2	307	1010415	15881/2X13NO3	318
1010067	15007/16X14H3NO1	287	1010206	15951/4X20NO2	298	1010321	15853/8X16H53FLNO2	307	1010416	15881/2X20NO2	318
1010070	15007/16X14H3NO2	287	1010207	15951/4X20NO3	298	1010324	15853/8X24H33FLNO2	307	1010417	15881/2X20NO3	318
1010071	15007/16X14H5NO2	287	1010208	15951/4X28NO2	298	1010325	15853/8X24H43FLNO2	307	1010419	15724-40H2NO2	341
1010074	15007/16X14H3NO3	287	1010209	15951/4X28NO3	298	1010327	15857/16X14H23FLNO2	307	1010421	15724-40H2NO3	341
1010076	15007/16X20H3NO1	287	1010210	15955/16X18NO2	298	1010328	15857/16X14H33FLNO2	307	1010427	15726-32H3NO2	341
1010079	15007/16X20H3NO2	287	1010211	15955/16X18NO3	298	1010329	15857/16X14H53FLNO2	307	1010429	15726-32H3NO3	341
1010083	15007/16X20H3NO3	287	1010216	15081/4X20NO2	298	1010331	15857/16X20H23FLNO2	307	1010435	15728-32H3NO2	341
1010085	15001/2X13H3NO1	287	1010219	15081/4X20NO3	298	1010332	15857/16X20H33FLNO2	307	1010437	15728-32H3NO3	341
1010087	15001/2X13H2NO2	287	1010223	15081/4X28NO2	298	1010333	15857/16X20H53FLNO2	307	1010438	157210-24H2NO2	341
1010088	15001/2X13H3NO2	287	1010226	15081/4X28NO3	298	1010334	15851/2X13H13FLNO2	307	1010440	157210-24H2NO3	341
1010089	15001/2X13H5NO2	287	1010230	15085/16X18NO2	298	1010335	15851/2X13H23FLNO2	307	1010442	157210-32H2NO2	341
1010091	15001/2X13H2NO3	287	1010233	15085/16X18NO3	298	1010336	15851/2X13H33FLNO2	307	1010443	157210-32H3NO2	341
1010092	15001/2X13H3NO3	287	1010236	15085/16X24NO2	298	1010337	15851/2X13H53FLNO2	307	1010444	157210-32H2NO3	341
1010093	15001/2X13H5NO3	287	1010237	15085/16X24NO3	298	1010338	15851/2X20H13FLNO2	307	1010445	157210-32H3NO3	341
1010094	15001/2X20H3NO1	287	1010240	15083/8X16NO2	298	1010339	15851/2X20H23FLNO2	307	1010451	15721/4X20H3NO2	341
1010097	15001/2X20H3NO2	287	1010243	15083/8X16NO3	298	1010340	15851/2X20H33FLNO2	307	1010453	15721/4X20H3NO3	341
1010098	15001/2X20H5NO2	287	1010246	15083/8X24NO2	298	1010341	15851/2X20H53FLNO2	307	1010456	15721/4X28H3NO3	341
1010101	15001/2X20H3NO3	287	1010247	15083/8X24NO3	298	1010342	15855/8X11H33FLNO2	307	1010458	15725/16X18H3NO2	341
1010103	15009/16X12H3NO1	287	1010248	15087/16X14NO2	298	1010343	15855/8X11H53FLNO2	307	1010466	15723/8X16H3NO2	341
1010106	15009/16X12H3NO2	287	1010250	15087/16X20NO2	298	1010344	15853/4X10H33FLNO2	307	1010468	15723/8X16H3NO3	341
1010108	15009/16X12H3NO3	287	1010252	15081/2X13NO2	298	1010345	15853/4X10H53FLNO2	307	1010474	15727/16X14H3NO2	341
1010110	15009/16X18H3NO1	287	1010253	15081/2X13NO3	298	1010346	15861/4X202FLNO2	317	1010482	15721/2X13H3NO2	341
1010113	15009/16X18H3NO2	287	1010254	15081/2X20NO2	298	1010347	15861/4X202FLNO3	317	1010491	15784-40H2	341
1010114	15009/16X18H5NO2	287	1010256	15991/4X20NO2	303	1010348	15861/4X203FLNO2	317	1010494	15786-32H2	341
1010116	15009/16X18H3NO3	287	1010257	15991/4X20NO3	303	1010349	15861/4X203FLNO3	317	1010495	15786-32H3	341
1010118	15005/8X11H3NO1	287	1010260	15995/16X18NO2	303	1010350	15861/4X282FLNO2	317	1010498	15788-32H2	341
1010121	15005/8X11H3NO2	287	1010261	15995/16X18NO3	303	1010351	15861/4X282FLNO3	317	1010499	15788-32H3	341
1010123	15005/8X11H3										

# EDP NUMBER INDEX - 1010508 - 1011283

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1010508	15781/4X28H2	341	1010646	15284-40H23FLNO2	287	1010767	152812-24H34FLNO2	287	1010920	15481/16X27	331
1010509	15781/4X28H3	341	1010647	15284-40H13FLNO3	287	1010768	152812-24H34FLNO3	287	1010921	15491/16X27	335
1010518	15411/16X27	326	1010648	15284-40H23FLNO3	287	1010769	152812-28H34FLNO1	287	1010922	15481/8X27	331
1010519	15411/8X27	326	1010649	15284-40H12FLNO2	287	1010771	152812-28H34FLNO2	287	1010923	15491/8X27	335
1010520	15411/4X18	326	1010650	15284-40H22FLNO2	287	1010772	152812-28H34FLNO3	287	1010924	15481/8X27X0.313	331
1010521	15413/8X18	326	1010652	15284-40H22FLNO3	287	1010775	1534NR0-80H1NO2	311	1010925	15491/8X27X0.313	335
1010522	15411/2X14	326	1010653	15284-48H23FLNO1	287	1010776	1534NR0-80H2NO2	311	1010926	15481/4X18	331
1010523	15413/4X14	326	1010655	15284-48H23FLNO2	287	1010778	1534NR0-80H2NO3	311	1010927	15491/4X18	335
1010524	15411X11.1/2	326	1010656	15284-48H23FLNO3	287	1010779	1534NR1-64H1NO2	311	1010928	15483/8X18	331
1010525	15411.1/4X11.1/2	326	1010660	15285-40H23FLNO1	287	1010780	1534NR1-64H2NO2	311	1010929	15493/8X18	335
1010526	15411.1/2X11.1/2	326	1010662	15285-40H23FLNO2	287	1010783	1534NR1-72H1NO2	311	1010930	15481/2X14	331
1010527	15412X11.1/2	326	1010664	15285-40H23FLNO3	287	1010784	1534NR1-72H2NO2	311	1010931	15491/2X14	335
1010528	15411/8X27X.0313	326	1010669	15285-44H23FLNO1	287	1010787	1534NR2-56H1NO2	311	1010932	15483/4X14	331
1010529	15431/16X27	334	1010671	15285-44H23FLNO2	287	1010788	1534NR2-56H2NO2	311	1010933	15493/4X14	335
1010530	15431/8X27	334	1010672	15285-44H23FLNO3	287	1010790	1534NR2-56H2NO3	311	1010934	15481X11.1/2	331
1010531	15431/4X18	334	1010673	15285-44H22FLNO2	287	1010791	1534NR2-64H1NO2	311	1010935	15491X11.1/2	335
1010532	15433/8X18	334	1010675	15286-32H13FLNO1	287	1010792	1534NR2-64H2NO2	311	1010937	15906-32NO2	319
1010533	15431/2X14	334	1010676	15286-32H23FLNO1	287	1010796	1534NR3-48H2NO2	311	1010938	15906-32NO3	319
1010534	15433/4X14	334	1010677	15286-32H33FLNO1	287	1010798	1534NR3-48H2NO3	311	1010939	15906-40NO2	319
1010535	15431X11.1/2	334	1010678	15286-32H13FLNO2	287	1010799	1534NR3-56H1NO2	311	1010940	15906-40NO3	319
1010539	15431/8X27X0.313	334	1010679	15286-32H23FLNO2	287	1010800	1534NR3-56H2NO2	311	1010941	15908-32NO2	319
1010551	15681/8X27	332	1010680	15286-32H33FLNO2	287	1010803	1534NR4-36H2NO2	311	1010942	15908-32NO3	319
1010552	15681/4X18	332	1010681	15286-32H13FLNO3	287	1010804	1534NR4-40H1NO2	311	1010943	15908-36NO2	319
1010553	15683/8X18	332	1010682	15286-32H23FLNO3	287	1010805	1534NR4-40H2NO2	311	1010944	15908-36NO3	319
1010554	15681/2X14	332	1010683	15286-32H33FLNO3	287	1010807	1534NR4-40H2NO3	311	1010945	159010-24NO2	319
1010555	15683/4X14	332	1010685	15286-32H22FLNO2	287	1010809	1534NR4-48H2NO2	311	1010946	159010-24NO3	319
1010556	15681X11.1/2	332	1010686	15286-32H32FLNO2	287	1010811	1534NR4-48H2NO3	311	1010947	159010-32NO2	319
1010557	15681.1/4X11.1/2	332	1010688	15286-32H22FLNO3	287	1010813	1534NR5-40H2NO2	311	1010948	159010-32NO3	319
1010558	15681.1/2X11.1/2	332	1010689	15286-32H32FLNO3	287	1010815	1534NR5-40H2NO3	311	1010953	15911/4X20NO2	319
1010560	15681/8X27X0.313	332	1010690	15286-40H23FLNO1	287	1010817	1534NR5-44H2NO2	311	1010954	15911/4X20NO3	319
1010561	15671/8X27	336	1010692	15286-40H23FLNO2	287	1010818	1534NR6-32H1NO2	311	1010955	15911/8X28NO2	319
1010562	15671/4X18	336	1010693	15286-40H23FLNO3	287	1010819	1534NR6-32H2NO2	311	1010956	15911/4X28NO3	319
1010563	15673/8X18	336	1010697	15288-32H24FLNO1	287	1010820	1534NR6-32H3NO2	311	1010957	15915/16X18NO2	319
1010564	15671/2X14	336	1010698	15288-32H34FLNO1	287	1010822	1534NR6-32H2NO3	311	1010958	15915/16X18NO3	319
1010565	15673/4X14	336	1010699	15288-32H14FLNO2	287	1010823	1534NR6-32H3NO3	311	1010959	15915/16X24NO2	319
1010566	15671X11.1/2	336	1010700	15288-32H24FLNO2	287	1010825	1534NR6-40H2NO2	311	1010961	15913/8X16NO2	319
1010570	15671/8X27X0.313	336	1010701	15288-32H34FLNO2	287	1010827	1534NR6-40H2NO3	311	1010962	15913/8X16NO3	319
1010581	15421/8X27	338	1010703	15288-32H24FLNO3	287	1010828	1534NR8-32H1NO2	311	1010963	15913/8X24NO2	319
1010582	15421/4X18	338	1010704	15288-32H34FLNO3	287	1010829	1534NR8-32H2NO2	311	1010965	15917/16X14NO2	319
1010583	15423/8X18	338	1010706	15288-32H22FLNO2	287	1010830	1534NR8-32H3NO2	311	1010966	15917/16X14NO3	319
1010584	15421/2X14	338	1010707	15288-32H32FLNO2	287	1010832	1534NR8-32H2NO3	311	1010967	15917/16X20NO2	319
1010585	15423/4X14	338	1010709	15288-32H22FLNO3	287	1010833	1534NR8-32H3NO3	311	1010968	15917/16X20NO3	319
1010586	15421X11.1/2	338	1010710	15288-32H32FLNO3	287	1010835	1534NR8-36H2NO2	311	1010969	15911/2X13NO2	319
1010587	15421/8X27X0.313	338	1010712	15288-32H23FLNO2	287	1010837	1534NR10-24H1NO2	311	1010970	15911/2X13NO3	319
1010588	15921/8X27	338	1010713	15288-32H33FLNO2	287	1010838	1534NR10-24H2NO2	311	1010971	15911/2X20NO2	319
1010589	15921/4X18	338	1010715	15288-32H23FLNO3	287	1010839	1534NR10-24H3NO2	311	1011070	15923/4X14	338
1010590	15923/8X18	338	1010716	15288-32H33FLNO3	287	1010841	1534NR10-24H2NO3	311	1011071	1534NR12-24H3NO2	311
1010591	15921/2X14	338	1010717	15288-36H24FLNO1	287	1010842	1534NR10-24H3NO3	311	1011072	1534NR12-24H3NO3	311
1010592	15921/8X27X0.313	338	1010719	15288-36H24FLNO2	287	1010843	1534NR10-32H1NO2	311	1011102	16344-40	309
1010593	15280-80H12FLNO1	287	1010720	15288-36H24FLNO3	287	1010844	1534NR10-32H2NO2	311	1011104	16346-32	309
1010594	15280-80H12FLNO2	287	1010724	152810-24H24FLNO1	287	1010845	1534NR10-32H3NO2	311	1011105	16348-32	309
1010595	15280-80H22FLNO2	287	1010725	152810-24H34FLNO1	287	1010847	1534NR10-32H2NO3	311	1011106	163410-32	309
1010596	15280-80H12FLNO3	287	1010726	152810-24H14FLNO2	287	1010848	1534NR10-32H3NO3	311	1011256	16001/4X20NO2	303
1010597	15280-80H22FLNO3	287	1010727	152810-24H24FLNO2	287	1010853	1534NR12-28H3NO2	311	1011257	16001/4X20NO3	303
1010598	15281-64H12FLNO1	287	1010728	152810-24H34FLNO2	287	1010877	15936-32	316	1011258	16001/4X28NO2	303
1010599	15281-64H12FLNO2	287	1010730	152810-24H24FLNO3	287	1010879	15938-32	316	1011259	16001/4X28NO3	303
1010601	15281-64H12FLNO3	287	1010731	152810-24H34FLNO3	287	1010881	159310-24	316	1011260	16005/16X18NO2	303
1010603	15281-72H12FLNO1	287	1010733	152810-24H22FLNO2	287	1010883	159310-32	316	1011261	16005/16X18NO3	303
1010604	15281-72H12FLNO2	287	1010734	152810-24H32FLNO2	287	1010887	15874-40NO2	318	1011262	16005/16X24NO2	303
1010606	15281-72H12FLNO3	287	1010736	152810-24H22FLNO3	287	1010888	15874-40NO3	318	1011263	16005/16X24NO3	303
1010607	15281-72H22FLNO3	287	1010737	152810-24H32FLNO3	287	1010890	15875-40NO3	318	1011264	16003/8X16NO2	303
1010608	15282-56H13FLNO1	287	1010739	152810-24H23FLNO2	287	1010891	15876-32NO2	318	1011265	16003/8X16NO3	303
1010609	15282-56H23FLNO1	287	1010740	152810-24H33FLNO2	287	1010892	15876-32NO3	318	1011266	16003/8X24NO2	303
1010610	15282-56H13FLNO2	287	1010743	152810-24H33FLNO3	287	1010895	15878-32NO2	318	1011267	16003/8X24NO3	303
1010611	15282-56H23FLNO2	287	1010745	152810-32H24FLNO1	287	1010896	15878-32NO3	318	1011268	16007/16X14NO2	303
1010612	15282-56H13FLNO3	287	1010746	152810-32H34FLNO1	287	1010897	158710-24NO2	318	1011269	16007/16X14NO3	303
1010613	15282-56H23FLNO3	287	1010748	152810-32H24FLNO2	287	1010898	158710-24NO3	318	1011270	16007/16X20NO2	303
1010615	15282-56H22FLNO2	287	1010749	152810-32H34FLNO2	287	1010899	158710-32NO2	318	1011271	16007/16X20NO3	303
1010617	15282-56H22FLNO3	287	1010751	152810-32H24FLNO3	287	1010900	158710-32NO3	318	1011272	16001/2X13NO2	303
1010625	15283-48H23FLNO1	287	1010752	152810-32H34FLNO3	287	1010905	15824-40NO2	317	1011273	16001/2X13NO3	303
1010627	15283-48H23FLNO2	287	1010754	152810-32H22FLNO2	287	1010906	15824-40NO3	317	1011274	16001/2X20NO2	303
1010629	15283-48H23FLNO3	287	1010755	152810-32H32FLNO2	287	1010909	15826-32NO2	317	1011275	16001/2X20NO3	303
1010631	15283-48H22FLNO2	287	1010757	152810-32H22FLNO3	287	1010910	15826-32NO3	317	1011276	16009/16X12NO2	303
1010634	15283-56H23FLNO1	287	1010758	152810-32H32FLNO3	287	1010913	15828-32NO2	317	1011277	16009/16X12NO3	303
1010636	15283-56H23FLNO2	287	1010760	152810-32H23FLNO2	287	1010914	15828-32NO3	317	1011278	16009/16X18NO2	303
1010637	15283-56H23FLNO3	287	1010761	152810-32H33FLNO2	287	1010915	158210-24NO2	317	1011279	16009/16X18NO3	303
1010643	15284-40H13FLNO1	287	1010763	152810-32H23FLNO3	287	1010916	158210-24NO3	317	1011280	16005/8X11NO2	303
1010644	15284-40H23FLNO1	287	1010764	152810-32H33FLNO3	287	1010917	158210-32NO2	317	1011281	16005/8X11NO3	303
10106											

# EDP NUMBER INDEX - 1011285 - 1013320

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1011285	16003/4X10NO3	303	1012414	1700M2X.4NO1	299	1012541	1700M22X1.5NO2	299	1012871	15451/4X18	330
1011287	16003/4X16NO3	303	1012415	1700M2X.4NO2	299	1012542	1700M22X1.5NO3	299	1012872	15453/8X18	330
1011748	15001/4	301	1012416	1700M2X.4NO3	299	1012543	1700M22X2.5NO1	299	1012873	15451/2X14	330
1011749	15005/16	301	1012421	1700M2.3X.4NO2	299	1012544	1700M22X2.5NO2	299	1012874	15453/4X14	330
1011750	15003/8	301	1012422	1700M2.3X.4NO3	299	1012545	1700M22X2.5NO3	299	1012875	15451X11.1/2	330
1011752	15001/2	301	1012423	1700M2.5X.45NO1	299	1012546	1700M24X2.0NO1	299	1012879	15451/8X27X0.313	330
1011753	15005/8	301	1012424	1700M2.5X.45NO2	299	1012547	1700M24X2.0NO2	299	1012890	1785NRM1.6	314
1011754	15851/4	316	1012425	1700M2.5X.45NO3	299	1012548	1700M24X2.0NO3	299	1012891	1785NRM2	314
1011755	15855/16	316	1012426	1700M2.6X.45NO1	299	1012555	1700M24X3.0NO1	299	1012893	1785NRM2.5	314
1011756	15853/8	316	1012427	1700M2.6X.45NO2	299	1012556	1700M24X3.0NO2	299	1012896	1785NRM3	314
1011757	15857/16	316	1012428	1700M2.6X.45NO3	299	1012557	1700M24X3.0NO3	299	1012897	1785NRM3.5	314
1011758	15851/2	316	1012432	1700M3X.5NO1	299	1012570	1700M30X3.5NO1	299	1012898	1785NRM4	314
1011759	15855/8	316	1012433	1700M3X.5NO2	299	1012571	1700M30X3.5NO2	299	1012899	1785NRM4.5	314
1011760	15441/16X27	329	1012434	1700M3X.5NO3	299	1012572	1700M30X3.5NO3	299	1012900	1785NRM5	314
1011761	15441/8X27	329	1012435	1700M3.5X.6NO1	299	1012574	1700M36X4.0NO2	299	1012901	1785NRM6	314
1011762	15441/4X18	329	1012436	1700M3.5X.6NO2	299	1012575	1700M36X4.0NO3	299	1012902	1785NRM7	314
1011763	15443/8X18	329	1012437	1700M3.5X.6NO3	299	1012659	1785M2	310	1012903	1785NRM8	314
1011764	15441/2X14	329	1012441	1700M4X.7NO1	299	1012661	1785M2.3	310	1012904	1785NRM10	314
1011765	15443/4X14	329	1012442	1700M4X.7NO2	299	1012662	1785M2.5	310	1012905	1785NRM12	314
1011766	15441X11.1/2	329	1012443	1700M4X.7NO3	299	1012663	1785M2.6	310	1012906	1785NRM14	314
1011767	15441.1/4X11.1/2	329	1012444	1700M4.5X.75NO1	299	1012664	1785M3	310	1012907	1785NRM16	314
1011772	1500L1/4X20	296	1012445	1700M4.5X.75NO2	299	1012666	1785M3.5	310	1012909	1785NRM20	314
1011775	1500L1/4X28	296	1012446	1700M4.5X.75NO3	299	1012668	1785M4	310	1012920	1788M3X.5NO2	320
1011778	1500L5/16X18	296	1012453	1700M5X.8NO1	299	1012669	1785M4.5	310	1012923	1788M4X.7NO2	320
1011781	1500L5/16X24	296	1012454	1700M5X.8NO2	299	1012672	1785M5	310	1012925	1788M5X.8NO2	320
1011784	1500L3/8X16	296	1012455	1700M5X.8NO3	299	1012674	1785M6	310	1012926	1788M6X1.0NO2	320
1011787	1500L3/8X24	296	1012459	1700M6X1.0NO1	299	1012676	1785M7	310	1012928	1788M8X1.25NO2	320
1011790	1500L7/16X14	296	1012460	1700M6X1.0NO2	299	1012678	1785M8	310	1012930	1788M10X1.5NO2	320
1011793	1500L7/16X20	296	1012461	1700M6X1.0NO3	299	1012680	1785M9	310	1012932	1788M12X1.75NO2	320
1011796	1500L1/2X13	296	1012465	1700M7X1.0NO1	299	1012682	1785M10	310	1012940	1788M3X.5NO3	320
1011799	1500L1/2X20	296	1012466	1700M7X1.0NO2	299	1012685	1785M11	310	1012942	1788M3.5X.6NO3	320
1011802	1500L9/16X12	296	1012467	1700M7X1.0NO3	299	1012686	1785M12	310	1012943	1788M4X.7NO3	320
1011805	1500L9/16X18	296	1012468	1700M8X1.0NO1	299	1012689	1785M14	310	1012945	1788M5X.8NO3	320
1011808	1500L5/8X11	296	1012469	1700M8X1.0NO2	299	1012693	1785M16	310	1012946	1788M6X1.0NO3	320
1011811	1500L5/8X18	296	1012470	1700M8X1.0NO3	299	1012696	1785M18	310	1012948	1788M8X1.25NO3	320
1011820	1500L3/4X10	296	1012471	1700M8X1.25NO1	299	1012699	153412-24H3NO3	306	1012950	1788M10X1.5NO3	320
1011823	1500L3/4X16	296	1012472	1700M8X1.25NO2	299	1012700	15345-40H1NO2	306	1012952	1788M12X1.75NO3	320
1011826	1500L7/8X9	296	1012473	1700M8X1.25NO3	299	1012774	15855/8X18H33FLNO2	307	1013037	19854-40	266
1011829	1500L7/8X14	296	1012478	1700M9X1.25NO2	299	1012775	15853/4X16H33FLNO2	307	1013038	19854-48	266
1011832	1500L1X8	296	1012479	1700M9X1.25NO3	299	1012813	1585NR1/4X20H12FLNO2	313	1013039	19855-40	266
1011835	1500L1X12	296	1012480	1700M10X1.25NO1	299	1012814	1585NR1/4X20H22FLNO2	313	1013040	19855-44	266
1011838	1500L1X14	296	1012481	1700M10X1.25NO2	299	1012815	1585NR1/4X20H32FLNO2	313	1013041	19856-32	266
1012276	1599M6	304	1012482	1700M10X1.25NO3	299	1012816	1585NR1/4X20H52FLNO2	313	1013042	19856-40	266
1012278	1599M8	304	1012483	1700M10X1.5NO1	299	1012817	1585NR1/4X20H32FLNO3	313	1013043	19858-32	266
1012280	1599M10	304	1012484	1700M10X1.5NO2	299	1012818	1585NR1/4X20H33FLNO2	313	1013044	19858-36	266
1012282	1599M12	304	1012485	1700M10X1.5NO3	299	1012820	1585NR1/4X28H12FLNO2	313	1013045	198510-24	266
1012356	15345-40H2NO2	306	1012493	1700M11X1.5NO2	299	1012821	1585NR1/4X28H22FLNO2	313	1013046	198510-32	266
1012357	15345-40H2NO3	306	1012494	1700M11X1.5NO3	299	1012822	1585NR1/4X28H32FLNO2	313	1013048	198512-28	266
1012358	15345-44H2NO2	306	1012495	1700M12X1.75NO1	299	1012823	1585NR1/4X28H42FLNO2	313	1013049	19851/4X20	266
1012359	15346-32H1NO2	306	1012496	1700M12X1.75NO2	299	1012824	1585NR1/4X28H32FLNO3	313	1013050	19851/4X28	266
1012360	15346-32H2NO2	306	1012497	1700M12X1.75NO3	299	1012828	1585NR5/16X18H22FLNO2	313	1013051	19855/16X18	266
1012361	15346-32H3NO2	306	1012498	1700M12X1.25NO1	299	1012829	1585NR5/16X18H32FLNO2	313	1013052	19855/16X24	266
1012363	15346-32H2NO3	306	1012499	1700M12X1.25NO2	299	1012830	1585NR5/16X18H52FLNO2	313	1013053	19853/8X16	266
1012364	15346-32H3NO3	306	1012500	1700M12X1.25NO3	299	1012832	1585NR5/16X18H33FLNO2	313	1013054	19853/8X24	266
1012366	15346-40H2NO2	306	1012501	1700M14X1.5NO1	299	1012833	1585NR5/16X18H53FLNO2	313	1013055	19857/16X14	266
1012367	15346-40H2NO3	306	1012502	1700M14X1.5NO2	299	1012836	1585NR5/16X24H32FLNO2	313	1013056	19857/16X20	266
1012368	15348-32H1NO2	306	1012503	1700M14X1.5NO3	299	1012842	1585NR3/8X16H23FLNO2	313	1013057	19851/2X13	266
1012369	15348-32H2NO2	306	1012504	1700M14X2.0NO1	299	1012843	1585NR3/8X16H33FLNO2	313	1013058	19851/2X20	266
1012370	15348-32H3NO2	306	1012505	1700M14X2.0NO2	299	1012844	1585NR3/8X16H53FLNO2	313	1013059	19859/16X12	266
1012372	15348-32H2NO3	306	1012506	1700M14X2.0NO3	299	1012845	1585NR3/8X24H13FLNO2	313	1013060	19859/16X18	266
1012373	15348-32H3NO3	306	1012513	1700M16X1.5NO1	299	1012847	1585NR3/8X24H33FLNO2	313	1013061	19855/8X11	266
1012375	15348-36H2NO2	306	1012514	1700M16X1.5NO2	299	1012849	1585NR7/16X14H23FLNO2	313	1013062	19855/8X18	266
1012376	153410-24H1NO2	306	1012515	1700M16X1.5NO3	299	1012850	1585NR7/16X14H33FLNO2	313	1013065	19853/4X10	266
1012377	153410-24H2NO2	306	1012516	1700M16X2.0NO1	299	1012851	1585NR7/16X14H53FLNO2	313	1013066	19853/4X16	266
1012378	153410-24H3NO2	306	1012517	1700M16X2.0NO2	299	1012853	1585NR7/16X20H33FLNO2	313	1013067	19857/8X9	266
1012379	153410-24H2NO3	306	1012518	1700M16X2.0NO3	299	1012856	1585NR1/2X13H23FLNO2	313	1013068	19857/8X14	266
1012380	153410-24H3NO3	306	1012522	1700M18X1.5NO1	299	1012857	1585NR1/2X13H33FLNO2	313	1013069	19851X8	266
1012381	153410-32H1NO2	306	1012523	1700M18X1.5NO2	299	1012858	1585NR1/2X13H53FLNO2	313	1013155	15001.1/4X7H9NO2	287
1012382	153410-32H2NO2	306	1012524	1700M18X1.5NO3	299	1012859	1585NR1/2X20H13FLNO2	313	1013310	15051.1/8NO1	302
1012383	153410-32H3NO2	306	1012525	1700M18X2.5NO1	299	1012860	1585NR1/2X20H23FLNO2	313	1013311	15051.1/8NO2	302
1012385	153410-32H2NO3	306	1012526	1700M18X2.5NO2	299	1012861	1585NR1/2X20H33FLNO2	313	1013312	15051.1/8NO3	302
1012386	153410-32H3NO3	306	1012527	1700M18X2.5NO3	299	1012862	1585NR1/2X20H53FLNO2	313	1013313	15051.1/4NO1	302
1012388	153412-28H3NO2	306	1012534	1700M20X1.5NO1	299	1012863	1585NR5/8X11H33FLNO2	313	1013314	15051.1/4NO2	302
1012389	153412-24H3NO2	306	1012535	1700M20X1.5NO2	299	1012864	1585NR5/8X11H53FLNO2	313	1013315	15051.1/4NO3	302
1012408	1700M1.6X.35NO1	299	1012536	1700M20X1.5NO3	299	1012865	1585NR3/4X10H33FLNO2	313	1013316	15051.3/8NO1	302
1012409	1700M1.6X.35NO2	299	1012537	1700M20X2.5NO1	299	1012866	1585NR3/4X10H53FLNO2	313	1013317	15051.3/8NO2	302
1012410	1700M1.6X.35NO3	299	1012538	1700M20X2.5NO2	299	1012867	1585NR5/8X18H33FLNO2	313	1013318	15051.3/8NO3	302
1012411	1700M1.8X.35NO1	299	1012539	1700M20X2.5NO3	299	1012868	1585NR3/4X16H33FLNO2	313	1013319	15051.1/2NO1	302
1012412	1700M1.8X.35NO2	299	1012540	1700M22X1.5NO1	299	1012870	15451/8X27	330	1013320	15051.1/2NO2	302



# EDP NUMBER INDEX - 1013321- 1410087

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1013321	15051.1/2NO3	302	1060028	TN15005/16X18NO2	291	1310018	15804-48H3NO3	321	1310213	33001/2X13H5NO3	323
1013322	15051.5/8NO1	302	1060039	TN15005/16X24NO2	291	1310022	15805-40H3NO3	321	1310215	33001/2X20H5NO2	323
1013323	15051.5/8NO2	302	1060050	TN15003/8X16NO2	291	1310028	15806-32H3NO2	321	1310217	33001/2X20H5NO3	323
1013324	15051.5/8NO3	302	1060061	TN15003/8X24NO2	291	1310029	15806-32H5NO2	321	1310400	1580M3X.5NO2	322
1013325	15051.3/4NO1	302	1060070	TN15007/16X14NO2	291	1310031	15806-32H3NO3	321	1310401	1580M3X.5NO3	322
1013326	15051.3/4NO2	302	1060079	TN15007/16X20NO2	291	1310032	15806-32H5NO3	321	1310402	1580M4X.7NO2	322
1013327	15051.3/4NO3	302	1060088	TN15001/2X13NO2	291	1310038	15808-32H3NO2	321	1310403	1580M4X.7NO3	322
1013328	15051.7/8NO1	302	1060092	TN15001/2X13NO3	291	1310039	15808-32H5NO2	321	1310404	1580M5X.8NO2	322
1013329	15051.7/8NO2	302	1060097	TN15001/2X20NO2	291	1310041	15808-32H3NO3	321	1310405	1580M5X.8NO3	322
1013330	15051.7/8NO3	302	1060121	TN15005/8X11NO2	291	1310042	15808-32H5NO3	321	1310406	1580M6X1.0NO2	322
1013331	15052NO1	302	1060123	TN15005/8X11NO3	291	1310048	158010-24H4NO2	321	1310407	1580M6X1.0NO3	322
1013332	15052NO2	302	1060131	TN15005/8X18NO3	291	1310051	158010-24H4NO3	321	1310408	1580M8X1.25NO2	322
1013333	15052NO3	302	1060144	TN15003/4X10NO3	291	1310055	158010-32H6NO2	321	1310409	1580M8X1.25NO3	322
1013352	15052.7/8NO1	302	1060152	TN15003/4X16NO3	291	1310057	158010-32H4NO3	321	1310410	1580M10X1.5NO2	322
1020002	1534NE4-40X4	315	1060157	TN15007/8X9NO2	291	1310058	158010-32H6NO3	321	1310411	1580M10X1.5NO3	322
1020004	1534NE6-32X4	315	1060292	TN15851/4-20H32FL	307	1310068	15801/4X20H4NO2	321	1310412	1580M12X1.75NO2	322
1020006	1534NE6-32X6	315	1060293	TN15851/4-20H52FL	307	1310069	15801/4X20H6NO2	321	1310413	1580M12X1.75NO3	322
1020008	1534NE8-32X4	315	1060295	TN15851/4-20H33FL	307	1310071	15801/4X20H4NO3	321	1310500	3300M3X.5NO2	324
1020010	1534NE8-32X6	315	1060296	TN15851/4-20H53FL	307	1310074	15801/4X28H4NO2	321	1310501	3300M3X.5NO3	324
1020012	1534NE10-24X4	315	1060299	TN15851/4-28H32FL	307	1310076	15801/4X28H4NO3	321	1310502	3300M4X.7NO2	324
1020014	1534NE10-24X6	315	1060306	TN15855/16-18H32FL	307	1310078	15805/16X18H5NO2	321	1310503	3300M4X.7NO3	324
1020016	1534NE10-32X4	315	1060309	TN15855/16-18H33FL	307	1310080	15805/16X18H5NO3	321	1310504	3300M5X.8NO2	324
1020018	1534NE10-32X6	315	1060310	TN15855/16-18H53FL	307	1310081	15805/16X18H7NO3	321	1310505	3300M5X.8NO3	324
1020020	1534NE1/4X20X4	315	1060313	TN15855/16-24H32FL	307	1310082	15805/16X24H5NO2	321	1310506	3300M6X1.0NO2	324
1020022	1534NE1/4X20X6	315	1060320	TN15853/8-16H33FL	307	1310084	15805/16X24H5NO3	321	1310507	3300M6X1.0NO3	324
1020024	1534NE1/4X28X4	315	1060321	TN15853/8-16H53FL	307	1310086	15803/8X16H5NO2	321	1310508	3300M8X1.25NO2	324
1020026	1534NE1/4X28X6	315	1060324	TN15853/8-24H33FL	307	1310088	15803/8X16H5NO3	321	1310509	3300M8X1.25NO3	324
1020028	1534NE5/16X18X4	315	1060328	TN15857/16-14H33FL	307	1310090	15803/8X24H5NO2	321	1310510	3300M10X1.5NO2	324
1020030	1534NE5/16X18X6	315	1060332	TN15857/16-20H33FL	307	1310092	15803/8X24H5NO3	321	1310511	3300M10X1.5NO3	324
1020032	1534NE5/16X24X4	315	1060336	TN15851/2-13H33FL	307	1310104	15801/2X13H5NO3	321	1310512	3300M12X1.75NO2	324
1020034	1534NE5/16X24X6	315	1060340	TN15851/2-20H33FL	307	1310110	33000-80H2NO3	323	1310513	3300M12X1.75NO3	324
1020036	1534NE3/8X16X4	315	1060519	TN15411/8	326	1310111	33001-64H2NO3	323	1321002	3306E4-40X4H3	325
1020038	1534NE3/8X16X6	315	1060520	TN15411/4	326	1310112	33001-72H2NO3	323	1321004	3306E4-40X4H5	325
1020040	1534NE3/8X24X4	315	1060521	TN15413/8	326	1310113	33002-56H2NO3	323	1321006	3306E6-32X4H3	325
1020042	1534NE3/8X24X6	315	1060522	TN15411/2	326	1310114	33002-56H3NO3	323	1321014	3306E8-32X4H3	325
1020044	1534NE7/16X14X6	315	1060523	TN15413/4	326	1310121	33004-40H3NO2	323	1321016	3306E8-32X4H5	325
1020046	1534NE7/16X20X6	315	1060530	TN15431/8	334	1310122	33004-40H5NO2	323	1321022	3306E10-24X4H4	325
1020048	1534NE1/2X13X6	315	1060531	TN15431/4	334	1310123	33004-40H3NO3	323	1321030	3306E10-32X4H4	325
1020050	1534NE1/2X20X6	315	1060532	TN15433/8	334	1310124	33004-40H5NO3	323	1321034	3306E10-32X6H4	325
1050006	1500A1/4X20	290	1060533	TN15431/2	334	1310127	33004-48H3NO3	323	1321038	3306E1/4X20X4H4	325
1050021	1500A1/4X28	290	1060534	TN15433/4	334	1310131	33005-40H3NO3	323	1321040	3306E1/4X20X4H6	325
1050028	1500A5/16X18	290	1060805	TN15344-40	306	1310132	33005-40H5NO3	323	1321042	3306E1/4X20X4H8	325
1050039	1500A5/16X24	290	1062361	TN15346-32	306	1310137	33006-32H3NO2	323	1321054	3306E1/4X28X4H8	325
1050050	1500A3/8X16	290	1062370	TN15348-32	306	1310138	33006-32H5NO2	323	1321062	3306E5/16X18X4H5	325
1050061	1500A3/8X24	290	1062378	TN153410-24	306	1310140	33006-32H3NO3	323	1321064	3306E5/16X18X4H7	325
1050070	1500A7/16X14	290	1062383	TN153410-32	306	1310141	33006-32H5NO3	323	1321080	3306E5/16X24X6H5	325
1050079	1500A7/16X20	290	1062389	TN153412-24	306	1310147	33008-32H3NO2	323	1410002	20100-80X13/16	356
1050088	1500A1/2X13	290	1062668	TN1785M4	310	1310148	33008-32H5NO2	323	1410006	20101-72X13/16	356
1050097	1500A1/2X20	290	1062672	TN1785M5	310	1310150	33008-32H3NO3	323	1410008	20102-56X13/16	356
1050106	1500A9/16X12	290	1062674	TN1785M6	310	1310151	33008-32H5NO3	323	1410010	20102-64X13/16	356
1050113	1500A9/16X18	290	1062678	TN1785M8	310	1310157	330010-24H4NO2	323	1410014	20103-56X13/16	356
1050121	1500A5/8X11	290	1062682	TN1785M10	310	1310158	330010-24H6NO2	323	1410016	20104-40X13/16	356
1050128	1500A5/8X18	290	1062686	TN1785M12	310	1310160	330010-24H4NO3	323	1410022	20105-40X13/16	356
1050142	1500A3/4X10	290	1110010	19944-40	345	1310161	330010-24H6NO3	323	1410024	20105-44X13/16	356
1050149	1500A3/4X16	290	1110020	19945-40	345	1310163	330010-32H4NO2	323	1410026	20106-32X13/16	356
1050157	1500A7/8X9	290	1110024	19945-44	345	1310164	330010-32H6NO2	323	1410027	20106-32X1	356
1050163	1500A7/8X14	290	1110030	19946-32	345	1310166	330010-32H4NO3	323	1410032	20108-32X13/16	356
1050170	1500A1X8	290	1110040	19948-32	345	1310167	330010-32H6NO3	323	1410033	20108-32X1	356
1050292	1585A1/4X20	307	1110044	19948-36	345	1310169	330012-24H4NO2	323	1410035	20108-36X13/16	356
1050299	1585A1/4X28	307	1110050	199410-24	345	1310171	330012-24H4NO3	323	1410038	201010-24X13/16	356
1050306	1585A5/16X18	307	1110054	199410-32	345	1310177	33001/4X20H4NO2	323	1410039	201010-24X1	356
1050313	1585A5/16X24	307	1110060	199412-24	345	1310178	33001/4X20H6NO2	323	1410041	201010-32X13/16	356
1050320	1585A3/8X16	307	1110064	199412-28	345	1310180	33001/4X20H4NO3	323	1410042	201010-32X1	356
1050324	1585A3/8X24	307	1110080	19941/4X20	345	1310181	33001/4X20H6NO3	323	1410044	201012-24X13/16	356
1050328	1585A7/16X14	307	1110084	19941/4X28	345	1310183	33001/4X28H4NO2	323	1410045	201012-24X1	356
1050332	1585A7/16X20	307	1110090	19945/16X18	345	1310185	33001/4X28H4NO3	323	1410047	201012-28X13/16	356
1050336	1585A1/2X13	307	1110094	19945/16X24	345	1310187	33005/16X18H5NO2	323	1410063	20101/4X20X13/16	356
1050340	1585A1/2X20	307	1110100	19943/8X16	345	1310188	33005/16X18H7NO2	323	1410064	20101/4X20X1	356
1050342	1585A5/8X11	307	1110104	19943/8X24	345	1310189	33005/16X18H5NO3	323	1410066	20101/4X20X1.1/2	356
1050344	1585A3/4X10	307	1110110	19947/16X14	345	1310190	33005/16X18H7NO3	323	1410069	20101/4X28X1	356
1052775	1585A3/4X16	307	1110114	19947/16X20	345	1310193	33005/16X24H5NO3	323	1410071	20101/4X28X1.1/2	356
1052869	1545A1/16	330	1110120	19941/2X13	345	1310195	33003/8X16H5NO2	323	1410074	20101/4X24X1	356
1052870	1545A1/8	330	1110124	19941/2X20	345	1310196	33003/8X16H7NO2	323	1410077	20101/4X32X1	356
1052871	1545A1/4	330	1310004	15802-56H2NO3	321	1310197	33003/8X16H5NO3	323	1410079	20105/16X18X13/16	356
1052872	1545A3/8	330	1310005	15802-56H3NO3	321	1310198	33003/8X16H7NO3	323	1410080	20105/16X18X1	356
1052873	1545A1/2	330	1310012	15804-40H3NO2	321	1310200	33003/8X24H7NO2	323	1410082	20105/16X18X1.1/2	356
1052874	1545A3/4	330	1310014	15804-40H3NO3	321	1310202	33003/8X24H7NO3	323	1410083	20105/16X18X2	356
1060006	TN15001/4X20NO2	291	1310015	15804-40H5NO3	321	1310205	33007/16X14H5NO3	323	1410085	20105/16X24X1	356
1060017	TN15001/4X28NO2	291	1310016	15804-48H3NO2	321	1310211	33001/2X13H5NO2	323	1410087	20105/16X24X1.1/2	356

# EDP NUMBER INDEX - 1410090 - 3210138

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1410090	20105/16X32X1	356	1410197	25105/8X18X1.1/2	358	1712221	16414-40H3	278	1810007	46001/8	467
1410093	20103/8X16X1	356	1410198	25105/8X18X2	358	1712223	16414-40H5	278	1810008	46001/4	467
1410095	20103/8X16X1.1/2	356	1410199	25103/4X10X2	358	1712233	16416-32H3	278	1810009	46003/8	467
1410096	20103/8X16X2	356	1410200	25103/4X16X2	358	1712235	16416-32H5	278	1810010	46001/2	467
1410097	20103/8X24X1	356	1410201	25107/8X9X2	358	1712239	16418-32H3	278	1810011	46003/4	467
1410099	20103/8X24X1.1/2	356	1410202	25107/8X14X2	358	1712241	16418-32H5	278	1810012	46001	467
1410101	20107/16X14X1	356	1410203	20101/8X27X1	356	1712245	16418-36H3	278	1810017	3850N8	350
1410103	20107/16X14X1.1/2	356	1410204	20101/8X27X1.1/2	356	1712254	164110-24H6	278	1810018	3850N9	350
1410104	20107/16X14X2	356	1410205	20101/4X18X1.1/2	356	1712258	164110-32H4	278	1810019	3850N10	350
1410105	20107/16X20X1	356	1410206	20101/4X18X2	356	1712260	164110-32H6	278	1810020	3850N11	350
1410107	20107/16X20X1.1/2	356	1410207	20103/8X18X1.1/2	356	1712264	16411/4X20H4	278	1810021	3850N12	350
1410108	20107/16X20X2	356	1410208	20103/8X18X2	356	1712266	16411/4X20H6	278	1810022	3850N14	350
1410110	20101/2X13X1.1/2	356	1410209	20101/2X14X2	356	1712270	16411/4X28H4	278	1810034	1301D14	369
1410111	20101/2X13X2	356	1410239	20251/4X20	365	1712272	16411/4X28H6	278	1810042	1301D2	369
1410114	20101/2X20X1.1/2	356	1410240	20251/4X28	365	1712277	16415/16X18H5	278	1810043	1301D3	369
1410115	20101/2X20X2	356	1410241	20255/16X18	365	1712279	16415/16X18H7	278	1810053	8007200	369
1410117	20109/16X12X1.1/2	356	1410242	20255/16X24	365	1712285	16415/16X24H7	278	1810096	1301D6	369
1410118	20109/16X12X2	356	1410243	20253/8X16	365	1712289	16413/8X16H5	278	1810372	1215T0	349
1410120	20109/16X18X1.1/2	356	1410244	20253/8X24	365	1712291	16413/8X16H7	278	1810373	1215T1	349
1410121	20109/16X18X2	356	1410245	20257/16X14	365	1712297	16413/8X20H7	278	1810374	1215T2	349
1410123	20105/8X11X1.1/2	356	1410246	20257/16X20	365	1712301	16411/2X13H5	278	1910501	19004OZ	500
1410124	20105/8X11X2	356	1410247	20251/2X13	365	1712304	16411/2X13H8	278	1910502	190016OZLT	500
1410126	20105/8X18X1.1/2	356	1410248	20251/2X20	365	1712307	16411/2X20H5	278	1910503	19001GALLT	500
1410127	20105/8X18X2	356	1410249	20259/16X12	365	1712313	16417/16X14H5	278	1910504	19005GALP	500
1410131	20103/4X10X2	356	1410250	20259/16X18	365	1713051	1671M3X.5	279	1910505	190055GAL	500
1410133	20103/4X16X2	356	1410251	20255/8X11	365	1713052	1671M4X.7	279	1910506	190055GAL	500
1410135	20107/8X9X2	356	1410252	20255/8X18	365	1713053	1671M5X.8	279	1910509	190020OZ	500
1410137	20107/8X14X2	356	1410253	202511/16X11	365	1713054	1671M6X1.0	279	1910512	19001/2OZ	500
1410140	20101X8X3	356	1410254	202511/16X16	365	1713055	1671M8X1.0	279	1930502	190016OZ	500
1410142	20101X12X3	356	1410255	20253/4X10	365	1713056	1671M8X1.25	279	1930503	19001GAL	500
1410144	20101X14X3	356	1410256	20253/4X16	365	1713057	1671M10X1.5	279	1950501	19001LB	500
1410145	20101.1/8X7X3	356	1410257	20257/8X9	365	1713059	1671M12X1.75	279	3210001	1800N1	499
1410146	20101.1/8X12X3	356	1410258	20257/8X14	365	1716510	16741/4X20	252	3210002	1800N2	499
1410147	20101.1/4X7X3	356	1410259	20251X8	365	1716512	16741/4X28	252	3210003	1800N3	499
1410148	20101.1/4X12X3	356	1410260	20251X12	365	1716514	16745/16X18	252	3210004	1800N4	499
1410149	20101.3/8X6X3	356	1410261	20251X14	365	1716516	16745/16X24	252	3210005	1800N5	499
1410150	20101.3/8X12X3	356	1410262	20251.1/8X7	365	1716518	16743/8X16	252	3210006	1800N6	499
1410151	20101.1/2X6X3	356	1410263	20251.1/8X12	365	1716530	16747/16X14	252	3210007	1800N7	499
1410152	20101.1/2X12X3	356	1410264	20251.1/4X7	365	1716534	16741/2X13	252	3210008	1800N8	499
1410153	25105-40X13/16	358	1410265	20251.1/4X12	365	1716536	16741/2X20	252	3210009	1800N9	499
1410154	25105-44X13/16	358	1410266	20251.3/8X6	365	1716538	16745/8X11	252	3210010	1800N10	499
1410156	25106-32X1	358	1410267	20251.3/8X12	365	1716542	16743/4X10	252	3210011	1800N11	499
1410157	25106-40X13/16	358	1410268	20251.1/2X6	365	1716544	16743/4X16	252	3210012	1800N12	499
1410159	25108-32X13/16	358	1410269	20251.1/2X12	365	1716546	16741X8	252	3210013	1815SET	499
1410160	25108-32X1	358	1410270	20251/8X27	365	1716704	1675M6X1.0	257	3210014	1816SET	499
1410161	25108-36X13/16	358	1410271	20251/4X18	365	1716706	1675M8X1.25	257	3210046	4111-2	501
1410163	251010-24X13/16	358	1410272	20253/8X18	365	1716708	1675M10X1.25	257	3210047	4111-3	501
1410164	251010-24X1	358	1410273	20251/2X14	365	1716710	1675M10X1.5	257	3210048	4111-4	501
1410165	251010-32X13/16	358	1410274	20253/4X14	365	1716720	1675M12X1.5	257	3210050	4112-3	501
1410166	251010-32X1	358	1410275	20251X11.1/2	365	1716722	1675M12X1.75	257	3210051	4112-4	501
1410167	251012-24X13/16	358	1410282	2025S824SET	365	1716724	1675M14X1.5	257	3210053	4113-4	501
1410168	251012-24X1	358	1410573	2710M2X.4X13/16	362	1716728	1675M16X1.5	257	3210054	4113-5	501
1410169	251012-28X13/16	358	1410575	2710M2.5X.45X13/16	362	1716730	1675M16X2.0	257	3210055	4114-5	501
1410171	25101/4X20X13/16	358	1410577	2710M3X.5X13/16	362	1716738	1675M20X2.5	257	3210057	4115-6	501
1410172	25101/4X20X1	358	1410579	2710M4X.7X13/16	362	1717510	16781/4X20	267	3210114	47041/8X3/32	496
1410173	25101/4X20X1.1/2	358	1410580	2710M4.5X.75X13/16	362	1717512	16781/4X28	267	3210115	47045/32X3/32	496
1410174	25101/4X28X13/16	358	1410581	2710M5X.8X1	362	1717514	16785/16X18	267	3210116	47043/16X3/32	496
1410175	25101/4X28X1	358	1410582	2710M6X1.0X1	362	1717516	16785/16X24	267	3210117	47047/32X3/32	496
1410176	25101/4X28X1.1/2	358	1410584	2710M8X1.25X1	362	1717518	16783/8X16	267	3210118	47041/4X3/32	496
1410177	25105/16X18X13/16	358	1410585	2710M9X1.25X1	362	1717520	16783/8X24	267	3210119	47043/16X5/32	496
1410178	25105/16X18X1	358	1410586	2710M10X1.5X1	362	1717530	16787/16X14	267	3210120	47047/32X5/32	496
1410179	25105/16X18X1.1/2	358	1410588	2710M12X1.75X1.1/2	362	1717532	16787/16X20	267	3210121	47041/4X5/32	496
1410180	25105/16X24X13/16	358	1410589	2710M14X2.0X1.1/2	362	1717534	16781/2X13	267	3210122	47049/32X5/32	496
1410181	25105/16X24X1	358	1410590	2710M16X2.0X1.1/2	362	1717538	16785/8X11	267	3210123	47045/16X5/32	496
1410182	25105/16X24X1.1/2	358	1410591	2710M18X2.5X2	362	1717540	16785/8X18	267	3210124	47043/8X5/32	496
1410183	25103/8X16X1	358	1410592	2710M20X2.5X2	362	1717542	16783/4X10	267	3210125	47041/4X3/16	496
1410184	25103/8X16X1.1/2	358	1410609	2325M6X1.0	366	1717546	16781X8	267	3210126	47045/16X3/16	496
1410185	25103/8X24X1	358	1410611	2325M8X1.25	366	1717704	1679M6X1.0	271	3210127	47043/8X3/16	496
1410186	25103/8X24X1.1/2	358	1410612	2325M9X1.25	366	1717706	1679M8X1.25	271	3210128	47047/16X3/16	496
1410187	25107/16X14X1	358	1410613	2325M10X1.5	366	1717708	1679M10X1.25	271	3210129	47041/2X3/16	496
1410188	25107/16X14X1.1/2	358	1410614	2325M11X1.5	366	1717710	1679M10X1.5	271	3210130	47049/16X3/16	496
1410189	25107/16X20X1	358	1410615	2325M12X1.75	366	1717722	1679M12X1.75	271	3210131	47045/8X3/16	496
1410190	25107/16X20X1.1/2	358	1410616	2325M14X2.0	366	1717726	1679M14X2.0	271	3210132	47045/16X1/4	496
1410191	25101/2X13X1.1/2	358	1410617	2325M14X1.25	366	1717730	1679M16X2.0	271	3210133	47043/8X1/4	496
1410192	25101/2X20X1.1/2	358	1410618	2325M16X2.0	366	1717734	1679M18X2.5	271	3210134	47047/16X1/4	496
1410193	25109/16X12X1.1/2	358	1410619	2325M8X2.5	366	1717736	1679M20X1.5	271	3210135	47041/2X1/4	496
1410194	25109/16X18X1.1/2	358	1410620	2325M18X1.5	366	1717738	1679M20X2.5	271	3210136	47049/16X1/4	496
1410195	25105/8X11X1.1/2	358	1410621	2325M20X2.5	366	1717740	1679M24X2.0	271	3210137	47045/8X1/4	496
1410196	25105/8X11X2	358	1410630	2710M12X1.75X1	362	1717742	1679M24X3.0	271	3210138	470411/16X1/4	496

# EDP NUMBER INDEX - 3210139 - 5010713

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
3210139	47043/4X1/4	496	4710597	46021X82	479	5010187	45333/64	445	5010602	4533D	445
3210140	470413/16X1/4	496	4710790	46033/8X60	477	5010198	4533N55	445	5010606	4533.2480	445
3210141	47047/8X1/4	496	4710791	46031/2X60	477	5010204	4533N54	445	5010608	4533.2490	445
3210142	47043/8X5/16	496	4710793	46033/4X60	477	5010213	4533N53	445	5010609	4533.2495	445
3210143	47047/16X5/16	496	4710794	46031X60	477	5010219	45331/16	445	5010610	45331/4	445
3210144	47041/2X5/16	496	4710795	46031.1/4X60	477	5010221	4533N52	445	5010612	4533.2510	445
3210145	47049/16X5/16	496	4710796	46031.1/2X60	477	5010228	4533N51	445	5010619	4533F	445
3210146	47045/8X5/16	496	4710797	46031/4X82	477	5010234	4533N50	445	5010622	4533G	445
3210147	470411/16X5/16	496	4710798	46033/8X82	477	5010240	4533N49	445	5010623	453317/64	445
3210148	47043/4X5/16	496	4710799	46031/2X82	477	5010246	4533N48	445	5010624	4533H	445
3210149	470413/16X5/16	496	4710800	46035/8X82	477	5010251	45335/64	445	5010626	4533LETTERI	445
3210151	470415/16X5/16	496	4710801	46033/4X82	477	5010252	4533N47	445	5010627	4533J	445
3210152	47041X5/16	496	4710802	46031X82	477	5010257	4533N46	445	5010628	4533K	445
3210155	47047/16X3/8	496	4710803	46031.1/4X82	477	5010259	4533N45	445	5010629	45339/32	445
3210156	47041/2X3/8	496	4710804	46031.1/2X82	477	5010267	4533N44	445	5010630	4533L	445
3210157	47049/16X3/8	496	4710805	46031/4X90	477	5010273	4533N43	445	5010631	4533M	445
3210158	47045/8X3/8	496	4710806	46033/8X90	477	5010282	4533N42	445	5010632	453319/64	445
3210159	470411/16X3/8	496	4710807	46031/2X90	477	5010283	45333/32	445	5010633	4533N	445
3210160	47043/4X3/8	496	4710808	46035/8X90	477	5010288	4533N41	445	5010636	4533.3105	445
3210161	470413/16X3/8	496	4710809	46033/4X90	477	5010292	4533N40	445	5010638	4533.3115	445
3210162	47047/8X3/8	496	4710810	46031X90	477	5010295	4533N39	445	5010639	4533.3120	445
3210163	470415/16X3/8	496	4710811	46031.1/4X90	477	5010299	4533N38	445	5010640	45335/16	445
3210173	47049/16X7/16	496	4710812	46031.1/2X90	477	5010304	4533N37	445	5010642	4533.3135	445
3210175	470411/16X7/16	496	5010054	45351/16	450	5010309	4533N36	445	5010645	4533O	445
3210176	47043/4X7/16	496	5010055	45355/64	450	5010316	45337/64	445	5010647	4533P	445
3210177	470413/16X7/16	496	5010056	45353/32	450	5010318	4533N35	445	5010648	453321/64	445
3210178	47047/8X7/16	496	5010057	45357/64	450	5010320	4533N34	445	5010649	4533Q	445
3210179	470415/16X7/16	496	5010058	45351/8	450	5010324	4533N33	445	5010650	4533R	445
3210180	47041X7/16	496	5010060	45355/32	450	5010330	4533N32	445	5010651	453311/32	445
3210183	47041.3/16X7/16	496	5010061	453511/64	450	5010338	4533N31	445	5010652	4533S	445
3210184	47041.1/4X7/16	496	5010062	45353/16	450	5010344	4533.1230	445	5010653	4533T	445
3210195	47049/16X1/2	496	5010063	453513/64	450	5010346	4533.1240	445	5010654	453323/64	445
3210197	470411/16X1/2	496	5010064	45357/32	450	5010349	4533.1247	445	5010655	4533U	445
3210198	47043/4X1/2	496	5010066	45351/4	450	5010350	45331/8	445	5010658	4533.3730	445
3210201	470415/16X1/2	496	5010067	453517/64	450	5010354	4533.1260	445	5010659	4533.3740	445
3210202	47041X1/2	496	5010068	45359/32	450	5010359	4533N30	445	5010660	4533.3745	445
3210203	47041.1/16X1/2	496	5010069	453519/64	450	5010374	4533N29	445	5010661	45333/8	445
3210210	47041.1/2X1/2	496	5010070	45355/16	450	5010383	4533N28	445	5010662	4533.3760	445
3210249	47041/8X1/8	496	5010071	453521/64	450	5010384	45339/64	445	5010663	4533V	445
3210251	47045/32X1/8	496	5010072	453511/32	450	5010391	4533N27	445	5010665	4533W	445
3210255	47043/16X1/8	496	5010073	453523/64	450	5010397	4533N26	445	5010666	453325/64	445
3210258	47047/32X1/8	496	5010074	45353/8	450	5010402	4533N25	445	5010667	4533X	445
3210259	47041/4X1/8	496	5010075	453525/64	450	5010407	4533N24	445	5010668	4533Y	445
3210261	47049/32X1/8	496	5010076	453513/32	450	5010411	4533N23	445	5010670	453313/32	445
3210262	47045/16X1/8	496	5010077	453527/64	450	5010416	45335/32	445	5010671	4533Z	445
3210263	47043/8X1/8	496	5010078	45357/16	450	5010418	4533N22	445	5010672	453327/64	445
3210264	47047/16X1/8	496	5010079	453529/64	450	5010422	4533N21	445	5010673	4533.4355	445
3210265	47041/2X1/8	496	5010080	453515/32	450	5010426	4533N20	445	5010674	4533.4365	445
3210266	47049/16X1/8	496	5010081	453531/64	450	5010436	4533N19	445	5010675	4533.4370	445
3210281	47043/16X3/16	496	5010082	45351/2	450	5010443	4533N18	445	5010676	45337/16	445
3210284	47047/32X3/16	496	5010083	453517/32	450	5010448	453311/64	445	5010677	4533.4385	445
3210287	47049/32X3/16	496	5010084	45359/16	450	5010451	4533N17	445	5010678	453329/64	445
3210294	470411/16X3/16	496	5010085	453519/32	450	5010459	4533N16	445	5010679	453315/32	445
3210296	470413/16X3/16	496	5010086	45355/8	450	5010465	4533N15	445	5010680	453331/64	445
3210297	47047/8X3/16	496	5010088	453511/16	450	5010469	4533N14	445	5010681	4533.4980	445
3210298	470415/16X3/16	496	5010090	45353/4	450	5010475	4533N13	445	5010682	4533.4990	445
3210300	47041/4X1/4	496	5010091	453525/32	450	5010476	4533.1855	445	5010683	4533.4995	445
3210302	47049/32X1/4	496	5010092	453513/16	450	5010478	4533.1865	445	5010684	45331/2	445
3210313	470415/16X1/4	496	5010094	45357/8	450	5010479	4533.1870	445	5010685	4533.5010	445
3210314	47041X1/4	496	5010095	453529/32	450	5010480	45333/16	445	5010690	453333/64	445
3210338	430N1	501	5010096	453515/16	450	5010482	4533.1885	445	5010691	453317/32	445
3210339	430N2	501	5010098	45351	450	5010483	4533N12	445	5010692	453335/64	445
3210340	430N3	501	5010140	45371/4	455	5010487	4533N11	445	5010693	45339/16	445
3210341	430N4	501	5010142	45375/16	455	5010492	4533N10	445	5010694	453337/64	445
3210342	430N5	501	5010144	45373/8	455	5010498	4533N9	445	5010695	453319/32	445
3210444	470411/32X3/16	496	5010148	45371/2	455	5010504	4533N8	445	5010696	453339/64	445
3210445	470413/32X3/16	496	5010152	45375/8	455	5010508	4533N7	445	5010698	45335/8	445
3210446	470415/32X3/16	496	5010154	453711/16	455	5010513	453313/64	445	5010700	453341/64	445
3210447	470417/32X1/4	496	5010156	45373/4	455	5010515	4533N6	445	5010701	453321/32	445
4111502	229CSET	351	5010158	453713/16	455	5010518	4533N5	445	5010702	453343/64	445
4710588	46021/2X60	479	5010160	45377/8	455	5010525	4533N4	445	5010703	453311/16	445
4710589	46025/8X60	479	5010162	453715/16	455	5010533	4533N3	445	5010704	453345/64	445
4710590	46023/4X60	479	5010164	45371	455	5010545	45337/32	445	5010705	453323/32	445
4710591	46027/8X60	479	5010167	45371.3/16	455	5010550	4533N2	445	5010706	453347/64	445
4710592	46021X60	479	5010173	4533N60	445	5010564	4533N1	445	5010708	45333/4	445
4710593	46021/2X82	479	5010175	4533N59	445	5010576	4533A	445	5010710	453349/64	445
4710594	46025/8X82	479	5010177	4533N58	445	5010577	453315/64	445	5010711	453325/32	445
4710595	46023/4X82	479	5010179	4533N57	445	5010585	4533B	445	5010712	453351/64	445
4710596	46027/8X82	479	5010186	4533N56	445	5010593	4533C	445	5010713	453313/16	445

# EDP NUMBER INDEX - 5010714 - 5110691

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
5010714	453353/64	445	5010852	45321.5/8	456	5011161	45883/0	454	5110310	9209/16X1/2	409
5010715	453327/32	445	5010854	45321.3/4	456	5011162	45882/0	454	5110311	9205/8X1/2	409
5010716	453355/64	445	5010858	45322	456	5011164	4588N1	454	5110312	92011/16X1/2	409
5010717	45337/8	445	5010928	45001/8	462	5011165	4588N2	454	5110313	9203/4X1/2	409
5010718	453357/64	445	5010929	45005/32	462	5011166	4588N3	454	5110314	9205/8X5/8	409
5010719	453329/32	445	5010930	45003/16	462	5011167	4588N4	454	5110315	92011/16X5/8	409
5010720	453359/64	445	5010932	45001/4	462	5011168	4588N5	454	5110316	9203/4X5/8	409
5010721	453315/16	445	5010934	45005/16	462	5011169	4588N6	454	5110317	92013/16X5/8	409
5010722	453361/64	445	5010936	45003/8	462	5011170	4588N7	454	5110318	9207/8X5/8	409
5010723	453331/32	445	5010938	45007/16	462	5011171	4588N8	454	5110319	92015/16X5/8	409
5010724	453363/64	445	5010940	45001/2	462	5011172	4588N9	454	5110320	9201X5/8	409
5010725	45331	445	5010941	450017/32	462	5011173	4588N10	454	5110321	9207/8X7/8	409
5010726	45331.1/16	445	5010942	45009/16	462	5011202	4533E	445	5110323	9201X7/8	409
5010727	45331.1/8	445	5010943	450019/32	462	5011204	45313/8	449	5110324	9201.1/8X7/8	409
5010728	45331.3/16	445	5010944	45005/8	462	5011205	453113/32	449	5110326	9201X1	409
5010729	45331.1/4	445	5010945	450021/32	462	5011206	45323/8	456	5110327	9201.1/8X1	409
5010731	45331.3/8	445	5010948	45003/4	462	5110001	9401/8X3/8	430	5110328	9201.1/4X1	409
5010733	45331.1/2	445	5010950	45007/8	462	5110002	9403/16X3/8	430	5110329	9201.3/8X1	409
5010734	45361/4	455	5010952	45001	462	5110003	9401/4X3/8	430	5110330	9201.1/2X1	409
5010735	45369/32	455	5010956	45001.1/2	462	5110004	9405/16X3/8	430	5110331	9201.1/4X1.1/4	409
5010736	45365/16	455	5011055	45797/16	460	5110005	9403/8X3/8	430	5110332	9201.1/2X1.1/4	409
5010737	453611/32	455	5011056	45791/2	460	5110006	9407/16X3/8	430	5110364	9231/8	408
5010738	45363/8	455	5011057	45799/16	460	5110007	9401/2X3/8	430	5110365	9235/32	408
5010739	453613/32	455	5011058	45795/8	460	5110008	9401/2X1/2	430	5110366	9233/16	408
5010740	45367/16	455	5011059	457911/16	460	5110009	9409/16X1/2	430	5110368	9231/4	408
5010742	45361/2	455	5011060	45793/4	460	5110010	9405/8X1/2	430	5110369	9239/32	408
5010744	45369/16	455	5011061	457913/16	460	5110011	94011/16X1/2	430	5110370	9235/16	408
5010746	45365/8	455	5011062	45797/8	460	5110012	9403/4X1/2	430	5110371	92311/32	408
5010747	453621/32	455	5011063	457915/16	460	5110013	9405/8X5/8	430	5110372	9233/8	408
5010748	453611/16	455	5011064	45791	460	5110014	94011/16X5/8	430	5110373	92313/32	408
5010750	45363/4	455	5011065	45791.1/16	460	5110015	9403/4X5/8	430	5110374	9237/16	408
5010751	453625/32	455	5011066	45791.1/8	460	5110016	94013/16X5/8	430	5110376	9231/2	408
5010752	453613/16	455	5011068	45791.1/4	460	5110017	9407/8X5/8	430	5110378	9235/8	408
5010754	45367/8	455	5011093	46081/4X60	478	5110019	9401X5/8	430	5110380	9233/4	408
5010756	453615/16	455	5011094	46083/8X60	478	5110020	9407/8X7/8	430	5110383	92315/16	408
5010758	45361	455	5011095	46081/2X60	478	5110022	9401X7/8	430	5110390	9051/8X3/8	414
5010761	45361.3/16	455	5011096	46085/8X60	478	5110025	9401X1	430	5110391	9053/16X3/8	414
5010778	45317/16	449	5011097	46083/4X60	478	5110029	9401.1/2X1	430	5110392	9051/4X3/8	414
5010779	453115/32	449	5011098	46081/4X82	478	5110071	9451/8	424	5110393	9055/16X3/8	414
5010780	45311/2	449	5011099	46083/8X82	478	5110072	9453/16	424	5110394	9053/8X3/8	414
5010782	45319/16	449	5011100	46081/2X82	478	5110073	9451/4	424	5110395	9057/16X1/2	414
5010784	45315/8	449	5011101	46085/8X82	478	5110074	9455/16	424	5110396	9051/2X1/2	414
5010785	453121/32	449	5011102	46083/4X82	478	5110075	9453/8	424	5110400	9051X1	414
5010786	453111/16	449	5011103	46081/4X90	478	5110076	9451/2	424	5110602	9801/4	415
5010788	45313/4	449	5011104	46083/8X90	478	5110077	9455/8	424	5110603	9805/16	415
5010790	453113/16	449	5011105	46081/2X90	478	5110078	94511/16	424	5110604	9803/8	415
5010792	45317/8	449	5011106	46085/8X90	478	5110079	9453/4	424	5110605	9807/16	415
5010796	45311	449	5011107	46083/4X90	478	5110080	9457/8	424	5110606	9801/2	415
5010797	45311.1/32	449	5011108	46081/4X100	478	5110081	9451	424	5110608	9803/4	415
5010799	45311.3/32	449	5011109	46083/8X100	478	5110162	9481/8	423	5110609	9801	415
5010801	45311.5/32	449	5011110	46081/2X100	478	5110163	9483/16	423	5110613	9811/4	416
5010802	45311.3/16	449	5011111	46085/8X100	478	5110164	9481/4	423	5110614	9815/16	416
5010804	45311.1/4	449	5011112	46083/4X100	478	5110165	9485/16	423	5110615	9813/8	416
5010805	45311.5/16	449	5011129	4587N0	465	5110166	9483/8	423	5110617	9811/2	416
5010806	45311.3/8	449	5011130	4587N1	465	5110167	9481/2	423	5110619	9813/4	416
5010807	45311.7/16	449	5011131	4587N2	465	5110168	9485/8	423	5110633	9631/8	411
5010808	45311.1/2	449	5011132	4587N3	465	5110169	9483/4	423	5110634	9633/16	411
5010809	45311.9/16	449	5011133	4587N4	465	5110221	9301/8X3/8	417	5110635	9631/4	411
5010811	45311.11/16	449	5011134	4587N5	465	5110222	9303/16X3/8	417	5110636	9635/16	411
5010812	45311.3/4	449	5011135	4587N6	465	5110223	9301/4X3/8	417	5110637	9633/8	411
5010813	45311.13/16	449	5011136	4587N7	465	5110224	9305/16X3/8	417	5110638	9631/2	411
5010814	45311.7/8	449	5011137	4587N8	465	5110225	9303/8X3/8	417	5110639	9635/8	411
5010815	45311.15/16	449	5011138	4587N9	465	5110226	9307/16X3/8	417	5110640	9633/4	411
5010820	45327/16	456	5011139	4587N10	465	5110228	9301/2X1/2	417	5110641	9631	411
5010822	45321/2	456	5011146	4591N0	466	5110229	9309/16X1/2	417	5110660	9601/8X4	431
5010826	45325/8	456	5011147	4591N1	466	5110231	9303/4X1/2	417	5110661	9603/16X4	431
5010827	453221/32	456	5011148	4591N2	466	5110232	9305/8X5/8	417	5110662	9601/4X4	431
5010828	453211/16	456	5011149	4591N3	466	5110233	9303/4X5/8	417	5110663	9605/16X4	431
5010830	45323/4	456	5011150	4591N4	466	5110235	9301X5/8	417	5110664	9603/8X4	431
5010834	45327/8	456	5011151	4591N5	466	5110237	9301X1	417	5110665	9601/2X4	431
5010838	45321	456	5011152	4591N6	466	5110243	9302X1.1/4	417	5110666	9605/8X4	431
5010839	45321.1/32	456	5011153	4591N7	466	5110302	9201/8X3/8	409	5110667	9603/4X4	431
5010840	45321.1/16	456	5011154	4591N8	466	5110303	9203/16X3/8	409	5110669	9601X4	431
5010841	45321.3/32	456	5011155	4591N9	466	5110304	9201/4X3/8	409	5110686	8831/16	429
5010842	45321.1/8	456	5011156	4591N10	466	5110305	9205/16X3/8	409	5110687	8833/32	429
5010846	45321.1/4	456	5011157	45887/0	454	5110306	9203/8X3/8	409	5110688	8831/8	429
5010848	45321.3/8	456	5011158	45886/0	454	5110307	9207/16X3/8	409	5110689	8835/32	429
5010849	45321.7/16	456	5011159	45885/0	454	5110308	9201/2X3/8	409	5110690	8833/16	429
5010850	45321.1/2	456	5011160	45884/0	454	5110309	9201/2X1/2	409	5110691	8831/4	429

# EDP NUMBER INDEX - 5110692 - 7350335

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
5110692	8835/16	429	5270032	TC90031/2	420	6210147	47069/16	493	7350257	E630M20	237
5110693	8833/8	429	5270034	TC90035/8	420	6210149	47065/8	493	7350258	E630M24	237
5110694	8837/16	429	5270035	TC90033/4	420	6210151	470611/16	493	7350259	E770M8X1.0	237
5110695	8831/2	429	5270036	TC90037/8	420	6210153	47063/4	493	7350260	E770M10X1.0	237
5110696	9303/4X3/4	417	5270037	TC90031	420	6210155	470613/16	493	7350261	E770M10X1.25	237
5110700	9059/16X1/2	414	6210031	47021/4	492	6210157	47067/8	493	7350262	E770M12X1.25	237
5110701	9055/8X1/2	414	6210032	47029/32	492	6210159	470615/16	493	7350263	E770M12X1.5	237
5110702	9053/4X1/2	414	6210033	47025/16	492	6210161	47061	493	7350264	E770M14X1.5	237
5110704	9051X3/4	414	6210034	470211/32	492	6310293	7073/16	502	7350265	E631M6	237
5110708	9203/4X3/4	409	6210035	47023/8	492	6310294	7071/4	502	7350266	E631M8	237
5110709	9207/8X3/4	409	6210036	470213/32	492	6310295	7075/16	502	7350267	E631M10	237
5110710	9201X3/4	409	6210037	47027/16	492	6310296	7073/8	502	7350268	E631M12	237
5110711	9403/4X3/4	430	6210038	470215/32	492	6310297	7077/16	502	7350269	E631M14	237
5110712	9407/8X3/4	430	6210039	47021/2	492	6310298	7071/2	502	7350270	E631M16	237
5110713	9401X3/4	430	6210040	470217/32	492	6310299	7075/8	502	7350271	E631M18	237
5110715	920K1/8	410	6210041	47029/16	492	6310300	7073/4	502	7350272	E631M20	237
5110716	920K3/16	410	6210042	470219/32	492	6310302	7071	502	7350273	E631M24	237
5110717	920K1/4	410	6210043	47025/8	492	6310305	7573/16	502	7350274	E771M10X1.25	237
5110718	920K5/16	410	6210045	470211/16	492	6310306	7571/4	502	7350275	E771M12X1.25	237
5110719	920K3/8	410	6210046	470223/32	492	6310307	7575/16	502	7350276	E771M12X1.5	237
5110720	920K1/2	410	6210047	47023/4	492	6310308	7573/8	502	7350277	E771M14X1.5	237
5110721	920K5/8	410	6210048	470225/32	492	6310309	7577/16	502	7350278	E8134-40	239
5110722	920K3/4	410	6210049	470213/16	492	6310310	7571/2	502	7350279	E8136-32	239
5110723	920K7/8	410	6210050	470227/32	492	6310311	7575/8	502	7350280	E8138-32	239
5110724	920K1	410	6210051	47027/8	492	6310312	7573/4	502	7350281	E81310-24	239
5110782	9602X6	431	6210055	47021	492	6310314	7571	502	7350282	E8131/4H5	239
5111714	9201.1/8X3/4	409	6210058	47021.3/16	492	6310317	7273/16	502	7350283	E8131/4H3	239
5111715	9201.1/4X3/4	409	6210065	47022	492	6310318	7271/4	502	7350284	E8135/16H5	239
5111717	9201.1/2X3/4	409	6210068	47035/16	495	6310319	7275/16	502	7350285	E8135/16H3	239
5111718	9201.3/4X3/4	409	6210074	47031/2	495	6310320	7273/8	502	7350286	E8133/8H5	239
5210014	90021/4	419	6210076	47039/16	495	6310321	7277/16	502	7350287	E8133/8H3	239
5210015	90025/16	419	6210080	470311/16	495	6310322	7271/2	502	7350288	E8137/16	239
5210016	90023/8	419	6210082	47033/4	495	6310323	7275/8	502	7350289	E8131/2H5	239
5210017	90027/16	419	6210084	470313/16	495	6310324	7273/4	502	7350290	E8131/2H3	239
5210018	90021/2	419	6210085	47037/8	495	6310326	7271	502	7350291	E8135/8H5	239
5210019	90029/16	419	6210086	470315/16	495	7350203	E8141/4	236	7350292	E8135/8H3	239
5210020	90025/8	419	6210087	47031	495	7350204	E8145/16	236	7350293	E8133/4H5	239
5210021	90023/4	419	6210088	47031.1/16	495	7350205	E8143/8	236	7350294	E8133/4H3	239
5210022	90027/8	419	6210089	47031.1/8	495	7350206	E8147/16	236	7350295	E8137/8H6	239
5210023	90021	419	6210090	47031.3/16	495	7350207	E8141/2	236	7350296	E8137/8H4	239
5210024	90021.1/4	419	6210091	47031.1/4	495	7350208	E8145/8	236	7350297	E8131H6	239
5210028	90031/4	420	6210092	47031.5/16	495	7350209	E8143/4	236	7350298	E8131H4	239
5210029	90035/16	420	6210093	47031.3/8	495	7350220	E8147/8	236	7350299	E91310-32	239
5210030	90033/8	420	6210094	47031.1/2	495	7350221	E8141	236	7350300	E9131/4H5	239
5210031	90037/16	420	6210095	47031.5/8	495	7350222	E91410-32	236	7350301	E9131/4H3	239
5210032	90031/2	420	6210096	47031.3/4	495	7350223	E9141/4	236	7350302	E9135/16H4	239
5210033	90039/16	420	6210098	47032	495	7350224	E9145/16	236	7350303	E9135/16H3	239
5210034	90035/8	420	6210099	47032.1/8	495	7350225	E9143/8	236	7350304	E9133/8H4	239
5210035	90033/4	420	6210100	47032.1/4	495	7350226	E9147/16	236	7350305	E9133/8H3	239
5210036	90037/8	420	6210102	47032.1/2	495	7350227	E9141/2	236	7350306	E9137/16	239
5210037	90031	420	6210107	47051/4	493	7350228	E9145/8	236	7350307	E9131/2H5	239
5210038	90031.1/4	420	6210109	47055/16	493	7350229	E9143/4	236	7350308	E9131/2H3	239
5210039	90031.1/2	420	6210110	470511/32	493	7350230	E9147/8	236	7350309	E9135/8H5	239
5210078	90081/4	422	6210111	47053/8	493	7350231	E8151/4	236	7350310	E9135/8H3	239
5210079	90083/8	422	6210112	470513/32	493	7350232	E8155/16	236	7350311	E9133/4H5	239
5210080	90081/2	422	6210113	47057/16	493	7350233	E8153/8	236	7350312	E9133/4H3	239
5210081	90085/8	422	6210115	47051/2	493	7350234	E8157/16	236	7350313	E9137/8H6	239
5210082	90083/4	422	6210116	470517/32	493	7350235	E8151/2	236	7350314	E9137/8H4	239
5210084	90081	422	6210117	47059/16	493	7350236	E8155/8	236	7350315	E9131H6	239
5210089	90091/4	421	6210118	470519/32	493	7350237	E8153/4	236	7350316	E9131H4	239
5210090	90093/8	421	6210119	47055/8	493	7350238	E8157/8	236	7350317	E629M4	243
5210091	90091/2	421	6210120	470521/32	493	7350239	E8151	236	7350318	E629M5	243
5210092	90095/8	421	6210121	470511/16	493	7350240	E9151/4	236	7350319	E629M6	243
5210093	90093/4	421	6210123	47053/4	493	7350241	E9155/16	236	7350320	E629M8	243
5210094	90097/8	421	6210124	470525/32	493	7350242	E9153/8	236	7350321	E629M10	243
5210095	90091	421	6210125	470513/16	493	7350243	E9157/16	236	7350322	E629M12	243
5270014	TC90021/4	419	6210126	47057/8	493	7350244	E9151/2	236	7350323	E629M14	243
5270015	TC90025/16	419	6210127	470515/16	493	7350245	E9155/8	236	7350324	E629M16	243
5270016	TC90023/8	419	6210136	47051.1/2	493	7350246	E9153/4	236	7350325	E629M18	243
5270017	TC90027/16	419	6210137	47061/4	493	7350247	E9157/8	236	7350326	E629M20	243
5270018	TC90021/2	419	6210138	47069/32	493	7350248	E9151	236	7350327	E629M24	243
5270020	TC90025/8	419	6210139	47065/16	493	7350249	E630M5	237	7350328	E769M8X1.0	243
5270021	TC90023/4	419	6210140	470611/32	493	7350250	E630M6	237	7350329	E769M10X1.25	243
5270022	TC90027/8	419	6210141	47063/8	493	7350251	E630M8	237	7350330	E769M12X1.25	243
5270023	TC90021	419	6210142	470613/32	493	7350252	E630M10	237	7350331	E769M12X1.5	243
5270028	TC90031/4	420	6210143	47067/16	493	7350253	E630M12	237	7350332	E769M14X1.5	243
5270029	TC90035/16	420	6210144	470615/32	493	7350254	E630M14	237	7350333	E769M16X1.5	243
5270030	TC90033/8	420	6210145	47061/2	493	7350255	E630M16	237	7350334	E769M18X1.5	243
5270031	TC90037/16	420	6210146	470617/32	493	7350256	E630M18	237	7350335	E8124-40	246

# EDP NUMBER INDEX - 7350336 - 8110602

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
7350336	E8126-32	246	7350415	E627M4	244	7350494	E625M6	242	7361223	R45315.3	46
7350337	E8128-32	246	7350416	E627M5	244	7350495	E625M8	242	7361224	R454B	46
7350338	E81210-24	246	7350417	E627M6	244	7350496	E625M10	242	7361225	R454C	46
7350339	E8121/4H5	246	7350418	E627M8	244	7350497	E625M12	242	7361226	R454E	46
7350340	E8121/4H3	246	7350419	E627M10	244	7350498	E625M14	242	7361227	R454F	46
7350341	E8125/16H5	246	7350420	E627M12	244	7350499	E625M16	242	7361228	R454G	46
7350342	E8125/16H3	246	7350421	E627M14	244	7350500	E625M18	242	7361229	R454I	46
7350343	E8123/8H5	246	7350422	E627M16	244	7350501	E625M20	242	7361230	R454J	46
7350344	E8123/8H3	246	7350423	E627M18	244	7350502	E625M24	242	7361231	R454K	46
7350345	E8127/16	246	7350424	E627M20	244	7350503	E765M8X1.0	242	7361232	R454P	46
7350346	E8121/2H5	246	7350425	E627M24	244	7350504	E765M10X1.25	242	7361233	R454R	46
7350347	E8121/2H3	246	7350426	E767M8X1.0	244	7350505	E765M12X1.25	242	7361234	R454S	46
7350348	E8125/8H5	246	7350427	E767M10X1.25	244	7350506	E765M12X1.5	242	7361235	R454V	46
7350349	E8125/8H3	246	7350428	E767M12X1.5	244	7350507	E765M14X1.5	242	7361236	R454W	46
7350350	E8123/4H5	246	7350429	E767M14X1.5	244	7350508	E765M16X1.5	242	7361237	R4575.3	40
7350351	E8123/4H3	246	7350430	E8104-40	248	7350509	E765M18X1.5	242	7361238	R4575.4	40
7350352	E8127/8H6	246	7350431	E8106-32	248	7350510	E8084-40	245	7361239	R4575.9	40
7350353	E8127/8H4	246	7350432	E8108-32	248	7350511	E8086-32	245	7361240	R457B	40
7350354	E8121H6	246	7350433	E81010-24	248	7350512	E8088-32	245	7361241	R457C	40
7350355	E8121H4	246	7350434	E8101/4	248	7350513	E80810-24	245	7361242	R457E	40
7350356	E91210-32	246	7350435	E8105/16	248	7350514	E8081/4	245	7361243	R457F	40
7350357	E9121/4H5	246	7350436	E8103/8	248	7350515	E8085/16	245	7361244	R457G	40
7350358	E9121/4H3	246	7350437	E8107/16	248	7350516	E8083/8	245	7361245	R457I	40
7350359	E9125/16H4	246	7350438	E8101/2	248	7350517	E8087/16	245	7361246	R457J	40
7350360	E9125/16H3	246	7350439	E8105/8	248	7350518	E8081/2	245	7361247	R457K	40
7350361	E9123/8H4	246	7350440	E8103/4	248	7350519	E8085/8	245	7361248	R4577.2	40
7350362	E9123/8H3	246	7350441	E8107/8	248	7350520	E8083/4	245	7361249	R457P	40
7350363	E9127/16	246	7350442	E8101	248	7350521	E8087/8	245	7361250	R4578.3	40
7350364	E9121/2H5	246	7350443	E91010-32	248	7350522	E8081	245	7361251	R457R	40
7350365	E9121/2H3	246	7350444	E9101/4	248	7350523	E90810-32	245	7361252	R457S	40
7350366	E9125/8H5	246	7350445	E9105/16	248	7350524	E9081/4	245	7361253	R4579.2	40
7350367	E9125/8H3	246	7350446	E9103/8	248	7350525	E9085/16	245	7361254	R457V	40
7350368	E9123/4H5	246	7350447	E9107/16	248	7350526	E9083/8	245	7361255	R457W	40
7350369	E9123/4H3	246	7350448	E9101/2	248	7350527	E9087/16	245	7361256	R45710.8	40
7350370	E9127/8H6	246	7350449	E9105/8	248	7350528	E9081/2	245	7361257	R45711.3	40
7350371	E9127/8H4	246	7350450	E9103/4	248	7350529	E9085/8	245	7361258	R45713.3	40
7350372	E9121H6	246	7350451	E9107/8	248	7350530	E9083/4	245	7361259	R45715.3	40
7350373	E9121H4	246	7350452	E9101	248	7350531	E9087/8	245	7361260	R4585.3	40
7350374	E628M4	250	7350453	E626M3	251	7350532	E9081	245	7361261	R4585.4	40
7350375	E628M5	250	7350454	E626M4	251	7350533	E624M4	249	7361262	R4585.9	40
7350376	E628M6	250	7350455	E626M5	251	7350534	E624M5	249	7361263	R458B	40
7350377	E628M8	250	7350456	E626M6	251	7350535	E624M6	249	7361264	R458C	40
7350378	E628M10	250	7350457	E626M8	251	7350536	E624M8	249	7361265	R458E	40
7350379	E628M12	250	7350458	E626M10	251	7350537	E624M10	249	7361266	R458F	40
7350380	E628M14	250	7350459	E626M12	251	7350538	E624M12	249	7361267	R458G	40
7350381	E628M16	250	7350460	E626M14	251	7350539	E624M14	249	7361268	R458I	40
7350382	E628M18	250	7350461	E626M16	251	7350540	E624M16	249	7361269	R458J	40
7350383	E628M20	250	7350462	E626M18	251	7350541	E624M18	249	7361270	R458K	40
7350384	E628M24	250	7350463	E626M20	251	7350542	E624M20	249	7361271	R4587.2	40
7350385	E768M8X1.0	250	7350464	E626M24	251	7350543	E624M24	249	7361272	R458P	40
7350386	E768M10X1.25	250	7350465	E766M8X1.0	251	7350544	E764M8X1.0	249	7361273	R4588.3	40
7350387	E768M12X1.5	250	7350466	E766M10X1.25	251	7350545	E764M10X1.25	249	7361274	R458R	40
7350388	E768M14X1.5	250	7350467	E766M12X1.25	251	7350546	E764M12X1.25	249	7361275	R458S	40
7350389	E768M16X1.5	250	7350468	E766M14X1.5	251	7350547	E764M12X1.5	249	7361276	R4588.9	40
7350390	E768M18X1.5	250	7350469	E8094-40	238	7350548	E764M14X1.5	249	7361277	R4589.2	40
7350391	E8114-40	241	7350470	E8096-32	238	7350549	E764M16X1.5	249	7361278	R458V	40
7350392	E8116-32	241	7350471	E8098-32	238	7350550	E764M18X1.5	249	7361279	R458W	40
7350393	E8118-32	241	7350472	E80910-24	238	7361201	R4535.3	46	7361280	R45810.7	40
7350394	E81110-24	241	7350473	E8091/4	238	7361202	R4535.4	46	7361281	R45810.9	40
7350395	E8111/4	241	7350474	E8095/16	238	7361203	R4535.9	46	7361282	R45811.1	40
7350396	E8115/16	241	7350475	E8093/8	238	7361204	R453B	46	7361283	R45811.3	40
7350397	E8113/8	241	7350476	E8097/16	238	7361205	R453C	46	7361284	R45811.7	40
7350398	E8117/16	241	7350477	E8091/2	238	7361206	R453E	46	7361285	R45811.9	40
7350399	E8111/2	241	7350478	E8095/8	238	7361207	R453F	46	7361286	R45813.3	40
7350400	E8115/8	241	7350479	E8093/4	238	7361208	R453G	46	7361287	R45815.3	40
7350401	E8113/4	241	7350480	E8097/8	238	7361209	R453I	46	7378063	DS1201/8	191
7350402	E8117/8	241	7350481	E8091	238	7361210	R453J	46	7378064	DS1203/16	191
7350403	E8111	241	7350482	E90910-32	238	7361211	R453K	46	7378065	DS1203/8	191
7350404	E91110-32	241	7350483	E9091/4	238	7361212	R4537.2	46	7378066	DS1205/16	191
7350405	E9111/4	241	7350484	E9095/16	238	7361213	R453P	46	7378067	DS1201/2	191
7350406	E9115/16	241	7350485	E9093/8	238	7361214	R4538.3	46	7378068	DS1201/4	191
7350407	E9113/8	241	7350486	E9097/16	238	7361215	R453R	46	7378069	DS1421/8	191
7350408	E9117/16	241	7350487	E9091/2	238	7361216	R453S	46	7378970	DS1423/16	191
7350409	E9111/2	241	7350488	E9095/8	238	7361217	R4539.2	46	7378971	DS1423/8	191
7350410	E9115/8	241	7350489	E9093/4	238	7361218	R453V	46	7378972	DS1425/16	191
7350411	E9113/4	241	7350490	E9097/8	238	7361219	R453W	46	7378973	DS1421/2	191
7350412	E9117/8	241	7350491	E9091	238	7361220	R45310.8	46	7378974	DS1421/4	191
7350413	E9111	241	7350492	E625M4	242	7361221	R45311.3	46	8110601	65411/8	328
7350414	E627M3	244	7350493	E625M5	242	7361222	R45313.3	46	8110602	65411/4	328

# EDP NUMBER INDEX - 8110603 - 46524900

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
8110603	.65413/8	328	46204850	.1672AP1/4X28	252	46204929	.1677APM6X1.0	271	46305903	.A10817/64	101
8110604	.65411/2	328	46204851	.1672AP10X24	252	46204930	.1677APM8X1.25	271	46305904	.A10819/64	101
8110605	.65413/4	328	46204852	.1672AP10X32	252	46204931	.16787/8X14	267	46305905	.A10821/64	101
8110606	.65411	328	46204853	.1672AP1X0X12	252	46204932	.16787/8X9	267	46305906	.A10823/64	101
8110607	.65411.1/4	328	46204854	.1672AP1X0X8	252	46204933	.1681AP1/2X13	280	46305907	.A10825/64	101
8110608	.65411.1/2	328	46204855	.1672AP3/4X10	252	46204934	.1681AP1/2X20	280	46305908	.A10827/64	101
8110609	.65412	328	46204856	.1672AP3/4X16	252	46204935	.1681AP1/4X20	280	46305909	.A10829/64	101
46073789	.A9011/2	65	46204857	.1672AP3/8X16	252	46204936	.1681AP1/4X28	280	46305920	.A10831/64	101
46196635	.E000TINM3	261	46204858	.1672AP3/8X24	252	46204937	.1681AP10X24	280	46371643	.1681AP12X24	280
46196636	.E000TINM4	261	46204859	.1672AP4X40	252	46204938	.1681AP10X32	280	46381760	.G5706.3	485
46196637	.E000TINM5	261	46204860	.1672AP5/16X18	252	46204940	.1681AP1X8	280	46381761	.G5708.3	485
46196638	.E000TINM6	261	46204861	.1672AP5/16X24	252	46204941	.1681AP3/4X10	280	46381762	.G57010.4	485
46196639	.E000TINM8	261	46204862	.1672AP5/8X11	252	46204942	.1681AP3/4X16	280	46381763	.G57012.4	485
46196690	.E000TINM10	261	46204863	.1672AP5/8X18	252	46204943	.1681AP3/8X16	280	46381764	.G57016.5	485
46196691	.E000TINM12	261	46204864	.1672AP6X32	252	46204944	.1681AP3/8X24	280	46381765	.G57020.5	485
46196692	.E000TINM16	261	46204865	.1672AP7/16X14	252	46204945	.1681AP4X40	280	46381766	.G57025.0	485
46196693	.E000TINM20	261	46204866	.1672AP7/16X20	252	46204946	.1681AP5/16X18	280	46381767	.G57031.0	485
46204754	.1629AP1/2X13	263	46204867	.1672AP7/8X14	252	46204947	.1681AP5/16X24	280	46381768	.G6006.3	487
46204755	.1629AP1/2X20	263	46204868	.1672AP7/8X9	252	46204948	.1681AP5/8X11	280	46381769	.G6008.3	487
46204756	.1629AP1/4X20	263	46204869	.1672AP8X32	252	46204949	.1681AP5/8X18	280	46381770	.G60010.4	487
46204757	.1629AP1/4X28	263	46204870	.1673APM10X1.25	257	46204950	.1681AP6X32	280	46381771	.G60012.4	487
46204758	.1629AP10X24	263	46204871	.1673APM10X1.5	257	46204951	.1681AP7/16X14	280	46381772	.G60015.0	487
46204759	.1629AP10X32	263	46204872	.1673APM12X1.5	257	46204952	.1681AP7/16X20	280	46381773	.G60016.5	487
46204791	.1629AP1X8	263	46204873	.1673APM12X1.75	257	46204953	.1681AP7/8X14	280	46381774	.G60020.5	487
46204792	.1629AP3/4X10	263	46204874	.1673APM14X1.5	257	46204954	.1681AP7/8X9	280	46381775	.G60025.0	487
46204794	.1629AP3/8X16	263	46204875	.1673APM14X2.0	257	46204955	.1681AP8X32	280	46437347	.190016OZLTSINGLE	500
46204795	.1629AP3/8X24	263	46204876	.1673APM16X1.5	257	46204956	.1687APM10X1.25	282	46437348	.190016OZSINGLE	500
46204796	.1629AP4X40	263	46204877	.1673APM16X2.0	257	46204957	.1687APM10X1.5	282	46437349	.190020OZSINGLE	500
46204797	.1629AP5/16X18	263	46204878	.1673APM18X1.5	257	46204958	.1687APM12X1.5	282	46437430	.19001LBSINGLE	500
46204798	.1629AP5/16X24	263	46204879	.1673APM18X2.5	257	46204959	.1687APM12X1.75	282	46521338	.G2363	491
46204799	.1629AP5/8X11	263	46204880	.1673APM20X1.5	257	46204960	.1687APM14X1.5	282	46524831	.A002S2.0	82
46204800	.1629AP5/8X18	263	46204881	.1673APM20X2.5	257	46204961	.1687APM14X2.0	282	46524832	.A002S2.5	82
46204801	.1629AP6X32	263	46204882	.1673APM24X2.0	257	46204962	.1687APM16X1.5	282	46524833	.A002S3.0	82
46204802	.1629AP7/16X14	263	46204883	.1673APM24X3.0	257	46204963	.1687APM16X2.0	282	46524834	.A002S3/8	82
46204803	.1629AP7/16X20	263	46204884	.1673APM4X.7	257	46204964	.1687APM18X1.5	282	46524835	.A002S3.2	82
46204804	.1629AP7/8X9	263	46204885	.1673APM5X.8	257	46204965	.1687APM18X2.5	282	46524836	.A002S3.3	82
46204805	.1629AP8X32	263	46204886	.1673APM6X1.0	257	46204966	.1687APM20X1.5	282	46524837	.A002S3.5	82
46204806	.1630AP1/2X13	276	46204887	.1673APM8X1.25	257	46204967	.1687APM20X2.5	282	46524838	.A002S5/32	82
46204807	.1630AP1/2X20	276	46204888	.16747/8X14	252	46204968	.1687APM24X2.0	282	46524839	.A002S4.0	82
46204808	.1630AP1/4X20	276	46204889	.16747/8X9	252	46204969	.1687APM24X3.0	282	46524860	.A002S4.1	82
46204809	.1630AP1/4X28	276	46204890	.1676AP1/2X13	267	46204970	.1687APM4X.7	282	46524861	.A002S4.2	82
46204810	.1630AP10X24	276	46204891	.1676AP1/2X20	267	46204971	.1687APM5X.8	282	46524862	.A002S4.5	82
46204811	.1630AP10X32	276	46204892	.1676AP1/4X20	267	46204972	.1687APM6X1.0	282	46524863	.A002S3/16	82
46204813	.1630AP1X8	276	46204893	.1676AP1/4X28	267	46204973	.1687APM8X1.25	282	46524864	.A002S5.0	82
46204814	.1630AP3/4X10	276	46204894	.1676AP10X24	267	46204974	.1691AP1/2X13	281	46524865	.A002S13/64	82
46204815	.1630AP3/4X16	276	46204895	.1676AP10X32	267	46204975	.1691AP1/2X20	281	46524866	.A002S5.5	82
46204816	.1630AP3/8X16	276	46204896	.1676AP1X0X12	267	46204976	.1691AP1/4X20	281	46524867	.A002S7/32	82
46204817	.1630AP3/8X24	276	46204897	.1676AP1X0X8	267	46204977	.1691AP1/4X28	281	46524868	.A002S6.0	82
46204818	.1630AP4X40	276	46204898	.1676AP3/4X10	267	46204979	.1691AP1X8	281	46524869	.A002S1/4	82
46204819	.1630AP5/16X18	276	46204899	.1676AP3/4X16	267	46204980	.1691AP3/4X10	281	46524870	.A002S6.5	82
46204820	.1630AP5/16X24	276	46204900	.1676AP3/8X16	267	46204982	.1691AP3/8X16	281	46524871	.A002S17/64	82
46204821	.1630AP5/8X11	276	46204901	.1676AP3/8X24	267	46204983	.1691AP3/8X24	281	46524872	.A002S6.8	82
46204822	.1630AP5/8X18	276	46204902	.1676AP4X40	267	46204984	.1691AP5/16X18	281	46524873	.A002S7.0	82
46204823	.1630AP6X32	276	46204903	.1676AP5/16X18	267	46204985	.1691AP5/16X24	281	46524874	.A002S7.5	82
46204824	.1630AP7/16X14	276	46204904	.1676AP5/16X24	267	46204986	.1691AP5/8X11	281	46524875	.A002S5/16	82
46204825	.1630AP7/16X20	276	46204905	.1676AP5/8X11	267	46204987	.1691AP5/8X18	281	46524876	.A002S8.0	82
46204826	.1630AP7/8X14	276	46204906	.1676AP5/8X18	267	46204988	.1691AP7/16X14	281	46524877	.A002S8.2	82
46204827	.1630AP7/8X9	276	46204907	.1676AP6X32	267	46204989	.1691AP7/16X20	281	46524878	.A002S8.5	82
46204828	.1630AP8X32	276	46204908	.1676AP7/16X14	267	46204990	.1697APM10X1.25	282	46524879	.A002S9.0	82
46204829	.1659APM10X1.5	264	46204909	.1676AP7/16X20	267	46204991	.1697APM10X1.5	282	46524880	.A002S9.5	82
46204831	.1659APM12X1.75	264	46204910	.1676AP7/8X14	267	46204993	.1697APM12X1.75	282	46524881	.A002S3/8	82
46204832	.1659APM3X.5	264	46204911	.1676AP7/8X9	267	46204995	.1697APM14X2.0	282	46524882	.A002S10.0	82
46204833	.1659APM4X.7	264	46204912	.1676AP8X32	267	46204996	.1697APM16X1.5	282	46524883	.A002S10.2	82
46204834	.1659APM5X.8	264	46204913	.1677APM10X1.25	271	46204997	.1697APM16X2.0	282	46524884	.A002S10.5	82
46204835	.1659APM6X1.0	264	46204914	.1677APM10X1.5	271	46205000	.1697APM20X1.5	282	46524885	.A002S11.0	82
46204836	.1659APM8X1.0	264	46204915	.1677APM12X1.5	271	46205001	.1697APM20X2.5	282	46524886	.A002S11.5	82
46204837	.1659APM8X1.25	264	46204916	.1677APM12X1.75	271	46205003	.1697APM24X3.0	282	46524887	.A002S12.0	82
46204838	.1660APM10X1.5	277	46204917	.1677APM14X1.5	271	46205004	.1697APM6X1.0	282	46524888	.A002S12.5	82
46204839	.1660APM12X1.5	277	46204918	.1677APM14X2.0	271	46205005	.1697APM8X1.25	282	46524889	.A002S1/2	82
46204840	.1660APM12X1.75	277	46204919	.1677APM16X1.5	271	46205007	.1660APM12X1.25	277	46524890	.A002S13.0	82
46204841	.1660APM3X.5	277	46204920	.1677APM16X2.0	271	46205008	.1673APM8X1.0	257	46524892	.A012S1/16	78
46204842	.1660APM4X.7	277	46204921	.1677APM18X1.5	271	46205009	.1673APM12X1.25	257	46524893	.A012S5/64	78
46204843	.1660APM5X.8	277	46204922	.1677APM18X2.5	271	46205010	.1677APM8X1.0	271	46524894	.A012S3/32	78
46204844	.1660APM6X1.0	277	46204923	.1677APM20X1.5	271	46262132	.46081X60	478	46524895	.A012S7/64	78
46204845	.1660APM8X1.0	277	46204924	.1677APM20X2.5	271	46262133	.46081X82	478	46524896	.A012S1/8	78
46204846	.1660APM8X1.25	277	46204925	.1677APM24X2.0	271	46262134	.46081X90	478	46524897	.A012S9/64	78
46204847	.1672AP1/2X13	252	46204926	.1677APM24X3.0	271	46262135	.46081X100	478	46524898	.A012S5/32	78
46204848	.1672AP1/2X20	252	46204927	.1677APM4X.7	271	46305901	.A108N10	101	46524899	.A012S11/64	78
46204849	.1672AP1/4X20	252	46204928	.1677APM5X.8	271	46305902	.A10815/64	101	46524900	.A012S3/16	78

# EDP NUMBER INDEX - 46524901 - 46719083

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
46524901	A012S13/64	78	46612321	S407HA3/8	386	46719004	R4594.7	50	46719044	R4597.9	50
46524902	A012S7/32	78	46612322	S407HA7/16	386	46719005	R4593/16	50	46719044	R4597.9	50
46524903	A012S15/64	78	46612323	S407HA1/2	386	46719005	R4593/16	50	46719045	R4595/16	50
46524904	A012S1/4	78	46612324	S407HA9/16	386	46719006	R4594.8	50	46719045	R4595/16	50
46524905	A012S17/64	78	46612325	S407HA5/8	386	46719006	R4594.8	50	46719046	R4598.0	50
46524906	A012S9/32	78	46612326	S407HA3/4	386	46719007	R4594.9	50	46719046	R4598.0	50
46524907	A012S19/64	78	46612327	S407HA1	386	46719007	R4594.9	50	46719047	R4598.1	50
46524908	A012S5/16	78	46612328	S406HA1/8	384	46719008	R4595.0	50	46719047	R4598.1	50
46524909	A012S21/64	78	46612329	S406HA3/16	384	46719008	R4595.0	50	46719048	R4598.2	50
46524910	A012S11/32	78	46612330	S406HA1/4	384	46719009	R4595.1	50	46719048	R4598.2	50
46524911	A012S23/64	78	46612331	S406HA5/16	384	46719009	R4595.1	50	46719049	R4598.3	50
46524912	A012S3/8	78	46612332	S406HA3/8	384	46719010	R45913/64	50	46719049	R4598.3	50
46524913	A012S25/64	78	46612333	S406HA7/16	384	46719010	R45913/64	50	46719050	R45921/64	50
46524914	A012S13/32	78	46612334	S406HA1/2	384	46719011	R4595.2	50	46719050	R45921/64	50
46524915	A012S27/64	78	46612335	S406HA9/16	384	46719011	R4595.2	50	46719051	R4598.4	50
46524916	A012S7/16	78	46612336	S406HA5/8	384	46719012	R4595.3	50	46719051	R4598.4	50
46524917	A012S29/64	78	46612337	S406HA3/4	384	46719012	R4595.3	50	46719052	R4598.5	50
46524918	A012S15/32	78	46612338	S406HA1	384	46719013	R4595.4	50	46719052	R4598.5	50
46524919	A012S31/64	78	46612339	S406HB3/8	385	46719013	R4595.4	50	46719053	R4598.6	50
46524920	A012S1/2	78	46612340	S406HB7/16	385	46719014	R4595.5	50	46719053	R4598.6	50
46610302	A094413	206	46612341	S406HB1/2	385	46719014	R4595.5	50	46719054	R4598.7	50
46610303	A094419	206	46612342	S406HB9/16	385	46719015	R4597/32	50	46719054	R4598.7	50
46610305	A09520	207	46612343	S406HB5/8	385	46719015	R4597/32	50	46719055	R45911/32	50
46610306	A095200	207	46612344	S406HB3/4	385	46719016	R4595.6	50	46719055	R45911/32	50
46612209	S400HA1/16	378	46612345	S406HB1	385	46719016	R4595.6	50	46719056	R4598.8	50
46612260	S400HA3/32	378	46660543	S405HA1/4XR.020	383	46719017	R4595.7	50	46719056	R4598.8	50
46612261	S400HA1/8	378	46660544	S405HA5/16XR.020	383	46719017	R4595.7	50	46719057	R4598.9	50
46612262	S400HA3/16	378	46660545	S405HA3/8XR.020	383	46719018	R4595.8	50	46719057	R4598.9	50
46612263	S400HA1/4	378	46660546	S405HA3/8XR.030	383	46719018	R4595.8	50	46719058	R4599.0	50
46612264	S400HA5/16	378	46660547	S405HA1/2XR.020	383	46719019	R4595.9	50	46719058	R4599.0	50
46612265	S400HA3/8	378	46660548	S405HA1/2XR.030	383	46719019	R4595.9	50	46719059	R4599.1	50
46612266	S400HA1/2X1	378	46660549	S405HA5/8XR.030	383	46719020	R45915/64	50	46719059	R4599.1	50
46612267	S400HA1/2X2	378	46660550	S405HA5/8XR.060	383	46719020	R45915/64	50	46719060	R45923/64	50
46612268	S400HA5/8	378	46660551	S405HA3/4XR.030	383	46719021	R4596.0	50	46719060	R45923/64	50
46612269	S400HA3/4X1.1/2	378	46660552	S405HA3/4XR.060	383	46719021	R4596.0	50	46719061	R4599.2	50
46612270	S400HA3/4X3	378	46660553	S405HA3/4XR.090	383	46719022	R4596.1	50	46719061	R4599.2	50
46612271	S401HA5/32	379	46718973	R4593.0	50	46719022	R4596.1	50	46719062	R4599.3	50
46612272	S401HA1/4	379	46718973	R4593.0	50	46719023	R4596.2	50	46719062	R4599.3	50
46612273	S401HA5/16	379	46718974	R4593.1	50	46719023	R4596.2	50	46719063	R4599.4	50
46612274	S401HA3/8	379	46718974	R4593.1	50	46719024	R4596.3	50	46719063	R4599.4	50
46612275	S401HA1/2	379	46718975	R4591/8	50	46719024	R4596.3	50	46719064	R4599.5	50
46612276	S401HA5/8	379	46718975	R4591/8	50	46719025	R4591/4	50	46719064	R4599.5	50
46612277	S401HA3/4	379	46718976	R4593.2	50	46719025	R4591/4	50	46719065	R4593/8	50
46612278	S402HA1/4X2.1/4	380	46718976	R4593.2	50	46719026	R4596.4	50	46719065	R4593/8	50
46612279	S402HA3/8X2.1/4	380	46718977	R4593.3	50	46719026	R4596.4	50	46719066	R4599.6	50
46612280	S402HA1/2X2.1/4	380	46718977	R4593.3	50	46719027	R4596.5	50	46719066	R4599.6	50
46612281	S402HA5/8X2.1/4	380	46718978	R4593.4	50	46719027	R4596.5	50	46719067	R4599.7	50
46612282	S402HA3/4X2.1/4	380	46718978	R4593.4	50	46719028	R4596.6	50	46719067	R4599.7	50
46612283	S402HA1X2.1/4	380	46718979	R4593.5	50	46719028	R4596.6	50	46719068	R4599.8	50
46612284	S402HA1/2X3.1/4	380	46718979	R4593.5	50	46719029	R4596.7	50	46719068	R4599.8	50
46612285	S402HA1/2X4	380	46718990	R4599/64	50	46719029	R4596.7	50	46719069	R4599.9	50
46612286	S402HA5/8X3.1/4	380	46718990	R4599/64	50	46719030	R45917/64	50	46719069	R4599.9	50
46612287	S402HA5/8X4.1/4	380	46718991	R4593.6	50	46719030	R45917/64	50	46719070	R45925/64	50
46612288	S402HA3/4X3.1/4	380	46718991	R4593.6	50	46719031	R4596.8	50	46719070	R45925/64	50
46612289	S402HA3/4X4.1/4	380	46718992	R4593.7	50	46719031	R4596.8	50	46719071	R45910.0	50
46612290	S402HA1X3.1/4	380	46718992	R4593.7	50	46719032	R4596.9	50	46719071	R45910.0	50
46612291	S402HA1X4.1/4	380	46718993	R4593.8	50	46719032	R4596.9	50	46719072	R45910.2	50
46612292	S403HA1/8	381	46718993	R4593.8	50	46719033	R4597.0	50	46719072	R45910.2	50
46612293	S403HA3/16	381	46718994	R4593.9	50	46719033	R4597.0	50	46719073	R45910.3	50
46612294	S403HA1/4	381	46718994	R4593.9	50	46719034	R4597.1	50	46719073	R45910.3	50
46612295	S403HA5/16	381	46718995	R4595/32	50	46719034	R4597.1	50	46719074	R45913/32	50
46612296	S403HA3/8	381	46718995	R4595/32	50	46719035	R4599/32	50	46719074	R45913/32	50
46612297	S403HA7/16	381	46718996	R4594.0	50	46719035	R4599/32	50	46719075	R45910.4	50
46612298	S403HA1/2	381	46718996	R4594.0	50	46719036	R4597.2	50	46719075	R45910.4	50
46612299	S403HA5/8	381	46718997	R4594.1	50	46719036	R4597.2	50	46719076	R45910.5	50
46612300	S403HA3/4	381	46718997	R4594.1	50	46719037	R4597.3	50	46719076	R45910.5	50
46612301	S403HA1	381	46718998	R4594.2	50	46719037	R4597.3	50	46719077	R45927/64	50
46612302	S404HA1/2XR.060	382	46718998	R4594.2	50	46719038	R4597.4	50	46719077	R45927/64	50
46612303	S404HA5/8XR.060	382	46718999	R4594.3	50	46719038	R4597.4	50	46719078	R45910.8	50
46612304	S404HA3/4XR.060	382	46718999	R4594.3	50	46719039	R4597.5	50	46719078	R45910.8	50
46612305	S404HA1XR.060	382	46719000	R45911/64	50	46719039	R4597.5	50	46719079	R45911.0	50
46612306	S404HA1/2XR.120	382	46719000	R45911/64	50	46719040	R45919/64	50	46719079	R45911.0	50
46612307	S404HA5/8XR.120	382	46719001	R4594.4	50	46719040	R45919/64	50	46719080	R4597/16	50
46612308	S404HA3/4XR.120	382	46719001	R4594.4	50	46719041	R4597.6	50	46719080	R4597/16	50
46612309	S404HA1XR.120	382	46719002	R4594.5	50	46719041	R4597.6	50	46719081	R45911.2	50
46612317	S407HA1/8	386	46719002	R4594.5	50	46719042	R4597.7	50	46719081	R45911.2	50
46612318	S407HA3/16	386	46719003	R4594.6	50	46719042	R4597.7	50	46719082	R45911.3	50
46612319	S407HA1/4	386	46719003	R4594.6	50	46719043	R4597.8	50	46719082	R45911.3	50
46612320	S407HA5/16	386	46719004	R4594.7	50	46719043	R4597.8	50	46719083	R45911.5	50



# EDP NUMBER INDEX - 46719083 - 47197820

EDP#	E-Code	Page #
46719083	R45911.5	50
46719084	R45929/64	50
46719084	R45929/64	50
46719085	R45911.8	50
46719085	R45911.8	50
46719086	R45915/32	50
46719086	R45915/32	50
46719087	R45912.0	50
46719088	R45912.2	50
46719088	R45912.2	50
46719089	R45931/64	50
46719089	R45931/64	50
46719090	R45912.5	50
46719090	R45912.5	50
46719091	R4591/2	50
46719091	R4591/2	50
46719092	R45912.8	50
46719092	R45912.8	50
46719093	R45913.0	50
46719093	R45913.0	50
46719094	R45933/64	50
46719094	R45933/64	50
46719095	R45917/32	50
46719095	R45917/32	50
46719096	R45913.5	50
46719096	R45913.5	50
46719097	R45935/64	50
46719097	R45935/64	50
46719098	R45914.0	50
46719098	R45914.0	50
46719099	R45914.25	50
46719099	R45914.25	50
46719100	R4599/16	50
46719100	R4599/16	50
46719101	R45914.5	50
46719101	R45914.5	50
46719102	R45937/64	50
46719102	R45937/64	50
46719103	R45915.0	50
46719103	R45915.0	50
46719104	R45919/32	50
46719104	R45919/32	50
46719105	R45915.1	50
46719105	R45915.1	50
46719106	R45939/64	50
46719106	R45939/64	50
46719107	R45915.5	50
46719107	R45915.5	50
46719108	R4595/8	50
46719108	R4595/8	50
46719109	R45916.0	50
46719109	R45916.0	50
46790303	2A1.95	82
47147792	G2364	491
47147805	G2365	491
47197820	1585NR5/16X18H32FLNO3	307

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