

DORMER



**UNION
BUTTERFIELD®**

Catalog

2015



List Number Index

0	1816..... 477	981..... 394	C15R10.... 197	E071..... 275	F330..... 338	R458..... 37
0860..... 143	1900..... 478	9002..... 397	C15R10CO . 207	E201..... 243	F370..... 341	R459..... 46
1	1985..... 244	9003..... 398	C15R10P... 197	E252..... 243	G	R51..... 131
1215..... 327	1994..... 323	9008..... 400	C20R18.... 198	E3302..... 366	G132..... 466	R510..... 41
1290..... 143	2	9009..... 399	C20R18P... 198	E3302M... 367	G135..... 458	R51FS..... 137
1301..... 347	2A..... 78	A	C21R10CO . 207	E3302V... 366	G136..... 461	R52..... 131
1500..... 265	2AB..... 78	A002..... 78	C247..... 403	E3303..... 374	G137..... 467	R520..... 35
1500S..... 265	2ACO..... 106	A002S..... 78	C252A..... 201	E3303V... 374	G138..... 468	R55..... 131
1500A..... 268	209..... 160	A012..... 74	C252AB... 201	E3304..... 376	G142..... 462	R56..... 174
1500L..... 274	209CO... 170	A012S..... 74	C26M42CO . 212	E3304M... 377	G149..... 460	R56CO.... 179
1500OV... 279	229SET... 329	A022..... 116	C26R15.... 199	E3304MV . 377	G154..... 459	R57..... 176
1505..... 280	2010..... 334	A088..... 210	C26R15CO . 207	E3304V... 376	G171..... 464	R58..... 178
1508..... 276	2025..... 343	A094..... 202	C26R15P... 199	E4302..... 365	G236..... 469	R88CO.... 111
1511..... 145	2325M... 344	A095..... 203	C26R42.... 209	E4304..... 375	G335..... 458	R89CO.... 111
1519..... 322	2510..... 336	A097..... 198	C273..... 405	E500..... 270	G338..... 468	R950..... 19
1528..... 265	2710M... 340	A100..... 78	C29HX10... 206	E501..... 278	G400..... 454	R960..... 22
1534..... 284	3	A101..... 86	C29L10.... 204	E504..... 283	G560..... 461	S
1534NE... 293	3300..... 301	A108..... 97	C29M40CO . 212	E513..... 272	G570..... 463	S209..... 160
1534NR... 289	3300M... 302	A125..... 145	C29R10.... 197	E5302..... 368	G600..... 465	S400HA... 356
1541..... 304	3306E... 303	A160..... 182	C29R10CO . 207	E5304..... 378	H	S401HA... 357
1542..... 316	3850..... 328	A170..... 172	C29R10P... 197	E5304V... 378	H853..... 25	S402HA... 358
1543..... 312	4	A190..... 201	C29R40.... 209	E550..... 317	H855..... 28	S403HA... 359
1544..... 307	4ASM.... 122	A191..... 201	C29R40C... 211	E547..... 318	H858..... 31	S404HA... 360
1545..... 308	4ASMCO... 130	A217..... 193	C29R51.... 213	E620..... 320	H860..... 34	S405HA... 361
1545A..... 308	411..... 479	A218..... 193	C33R56.... 214	E621..... 320	H861..... 34	S406HA... 362
1548..... 309	430..... 479	A221..... 194	C346..... 396	E6302..... 369	HX10..... 88	S406HB... 363
1549..... 313	4500..... 440	A225..... 193	C502AB... 201	E6302V... 369	HX15..... 88	S407HA... 364
1567..... 314	4531..... 427	A243..... 152	C60M41CO . 212	E6304..... 379	HX18..... 88	SPL-120... 190
1568..... 310	4532..... 434	A244..... 152	C60R18.... 198	E6304V... 379	L	SPL-90.... 190
1572..... 319	4533..... 423	A245..... 119	C60R18CO . 207	E650..... 325	L10..... 85	SPLG-120.. 190
1578..... 319	4535..... 428	A287..... 205	C60R18P... 198	E651..... 324	L110..... 348	SPLG-90... 190
1580..... 299	4536..... 433	A345..... 166	C60R41.... 209	E653..... 326	M	SPR-120... 189
1580M... 300	4537..... 433	A350..... 163	C60R41C... 211	E654..... 324	M40CO.... 127	SPR-90.... 189
1582..... 295	4579..... 438	A510..... 56	C8R56.... 214	E710..... 305	M41CO.... 127	SPRG-120... 189
1585..... 285	4587..... 443	A520..... 49	C8R56CO . 214	E711..... 311	M42CO.... 127	SPRG-90... 189
1585A... 285	4588..... 432	A530..... 163	C8R57.... 214	E712..... 315	M51CO.... 141	SPS-120... 188
1585NR... 291	4591..... 444	A553..... 59	CO500-12.. 158	E721..... 305	M52CO.... 141	SPS-90.... 188
1585OV... 294	4600..... 445	A720..... 126	CO500-6... 158	EB3302... 370	Q	SPSG-120... 188
1586..... 295	4602..... 457	A900..... 61	CO501-12.. 158	EB3302M . 371	QC0860P... 150	SPSG-90... 188
1587..... 296	4603..... 455	A901..... 61	CO501-6... 158	EB3302MV . 371	QC1290P... 150	T
1588..... 296	4608..... 456	A920..... 52	D	EB3302V... 370	QC21G.... 102	T400..... 439
1590..... 297	4702..... 470	A921..... 52	D33F..... 183	EB3304... 380	QC21GM... 105	TC9002.... 397
1591..... 297	4703..... 473	A940..... 64	D33L..... 183	EB3304M . 381	QC21P.... 102	TC9003.... 398
1592..... 316	4704..... 474	A941..... 64	D33M..... 186	EB3304MV . 381	QC21PM... 105	TN1500.... 269
1593..... 294	4705..... 471	A951..... 168	D33W..... 183	EB3304V... 380	QC41G.... 124	TN1534.... 284
1595..... 276	4706..... 471	A952..... 168	D444..... 180	EB5302... 372	QC41P.... 124	TN1541.... 304
1599..... 281	5	A976..... 67	DC..... 191	EB5304... 382	QC91G.... 138	TN1543.... 312
1599M... 282	5ATL..... 135	A977..... 67	DS-90..... 187	EB5304V... 382	QC91GM... 140	TN1585.... 285
1599SB... 282	5ATS..... 163	A978..... 67	E	EB6302... 373	QC91P.... 138	TN1785.... 288
1600..... 281	500-12... 156	ATR41..... 196	E000..... 239	EB6302V... 373	QC91PM... 140	TS10..... 195
1629AP... 241	500-6.... 153	B	E000TIN... 239	EB6304... 383	R	TS18..... 195
1630AP... 254	501-12... 156	B100..... 446	E001..... 239	EB6304V... 383	R10..... 70	TS41..... 195
1634..... 287	501-6.... 153	B101..... 435	E002..... 253	EP006H... 237	R10A..... 91	TS51..... 195
1641..... 256	502-12... 156	B121..... 437	E003..... 253	EP016H... 237	R10B..... 94	TS52..... 195
1659AP... 242	502-6.... 153	B122..... 431	E005..... 236	EP10..... 238	R10CO.... 106	U
1660AP... 255	6	B157..... 430	E006..... 236	EP11..... 238	R10H..... 97	U1511.... 321
1671..... 257	6541..... 306	B170..... 420	E007..... 250	EP20..... 233	R10P..... 70	
1672AP... 230	7	B301..... 448	E008..... 250	EP21..... 233	R15..... 70	
1673AP... 235	76HA.... 192	B334..... 441	E011..... 239	EP30..... 233	R15A..... 91	
1674..... 230	707..... 480	B335..... 442	E013..... 253	EP31..... 233	R15B..... 94	
1675..... 235	727..... 480	B400..... 415	E016..... 236	EP40..... 261	R15CO.... 106	
1676AP... 245	757..... 480	B411..... 417	E018..... 250	EP41..... 261	R15P..... 70	
1677AP... 249	8	B441..... 414	E021..... 234	EX006H... 251	R18..... 70	
1678..... 245	883..... 407	B442..... 416	E023..... 248	EX016H... 251	R18A..... 91	
1679..... 249	8007..... 347	B481..... 418	E025..... 231	EX10..... 252	R18B..... 94	
1681AP... 258	9	B901..... 429	E026..... 231	EX11..... 252	R18CO.... 106	
1687AP... 260	905..... 392	C	E027..... 246	EX20..... 247	R18H..... 97	
1691AP... 259	920..... 387	C110..... 384	E028..... 246	EX21..... 247	R18P..... 70	
1697AP... 260	920K.... 388	C114COMB. 200	E031..... 234	EX30..... 247	R40..... 113	
1700M... 277	923..... 386	C114COMBC 208	E033..... 248	EX31..... 247	R40C..... 119	
1700S... 277	930..... 395	C114COMBP 199	E035..... 231	EX40..... 263	R41..... 113	
1785M... 288	940..... 408	C115COMB. 200	E036..... 231	EX41..... 263	R41C..... 119	
1785NR... 292	945..... 402	C115COMBC 208	E037..... 246	F	R42..... 113	
1788M... 298	948..... 401	C115COMBP 199	E038..... 246	F201..... 342	R42C..... 119	
1800..... 477	960..... 409	C123..... 390	E041..... 262	F302..... 345	R453..... 43	
1813..... 145	963..... 389	C13R10CO . 207	E043..... 264	F312..... 346	R454..... 43	
1815..... 477	980..... 393	C15L10.... 204	E061..... 275	F320..... 338	R457..... 37	

DORMER



**UNION
BUTTERFIELD®**

SIMPLY RELIABLE

A FRESH NEW LOOK...

The latest Dormer catalog has been updated and improved for 2015.

Never has tool selection been so easy!

Some key features we have incorporated into this catalog include:

- Use of text to help describe product features and benefits
- Icons to describe basic product features e.g. substrate, coating & standard
- Similar products grouped together for easy comparison
- Several indices to find the product by your preferred method:
 - By List Number
 - By EDP Number
 - By Text Description
- And, a completely new feature for 2015, by Visual Index - a quick reference guide preceding each section detailing primary product features, a product image, diameter range and speeds/feeds information by material type
- An improved and extended technical section including troubleshooting guides, decimal equivalent charts and cutting tool terminology.
- Cutting data (speeds and feeds) all grouped together, by list number, immediately following the technical section.
- 3 separate languages available: English, French and Spanish



- Assistance with choosing the most "popular" item where there are multiple options, such as hand taps
- Additional column for package quantity information

Of course, our dedicated and knowledgeable customer service and technical field representatives are always available to assist you should you have any questions.

We hope that you enjoy using our catalog and thank you for your continued support. If you have any ideas or suggestions to further improve future publications please do not hesitate to contact us.

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DORMER PRAMET

OUR BRANDS



DORMER

Founded in Sheffield, England in 1913, Dormer quickly expanded to become one of the world's most respected producers of High Speed Steel cutting tools. Today, Dormer is a truly global brand with 30 sales offices and representation in over 100 countries.

The core product program consists of drills, taps, end mills, reamers, and countersinks in both High Speed Steel/High Speed Cobalt, and Solid Carbide. Tools are designed for general purpose machining and for multi-application production environments.



PRECISION

Founded in Crystal Lake, IL in 1952, Precision has been developing drills for over 60 years. Over time, the product range has been expanded to include solid carbide end mills. The Precision brand represents the majority of our drill offering for all your general purpose needs.

The drill program offers jobber, screw machine length, taper length, extra length, aircraft extension, combined drills and countersinks (center), spotting, reduced shank, taper shank, and sets. The range includes High Speed Steel, High Speed Cobalt, and Solid Carbide substrates for light to heavy-duty general purpose machining.



UNION BUTTERFIELD®

With roots dating back to 1895, the Union Butterfield brand has undergone a series of changes in its storied history. The one constant that has remained is a product offering that continues to develop with the changes in technology. The new APPLIX range of cut taps and threadformers is a prime example. New technologies and leading edge coatings have been incorporated into the design to make the new APPLIX range the ideal tap for your threading needs.

Union Butterfield today offers taps and tapping accessories, end mills, dies, reamers, countersinks, counterbores, and cutting fluids for general purpose, multi-application, and material specific applications. The Flashtap program is available with short lead times on semi-standard taps.

Table of Contents










004 - 007		Table of Contents
008 - 214		Drills
216 - 329		Taps
330 - 348		Dies
350 - 409		End Mills
410 - 448		Reamers
450 - 475		Countersinks/ Counterbores
476 - 480		Miscellaneous
481 - 544		Technical
545 - 608		Speed/Feed Info EDP # Index

TABLE OF CONTENTS - DRILLS



Application Products

Hydra Replaceable Head

Heads	19-24
3 X D Bodies	25-27
5 X D Bodies	28-30
8 X D Bodies	31-33
Screws & Screw Drivers	34

Screw Machine Length (Stub)/Short Length

CDX Carbide	35-36
MPX Carbide	37-40
ADX HSS	49-51
PFX Cobalt Parabolic Flute	52-55

Jobber Length/Standard Length

CDX Carbide	41-42
MPX Carbide	43-45
ADX Solid Design	56-58
ADX Coolant Thru	59-60
PFX Cobalt Parabolic Flute	61-63

8xD Length

MPX Carbide	46-48
-----------------------	-------

Taper Length

PFX Cobalt Parabolic Flute	64-66
--------------------------------------	-------

Extra Length

PFX Cobalt Parabolic Flute	67-69
--------------------------------------	-------

General Purpose

Jobber Length

HSS	
General Purpose	70-87
TiN Tipped	74-84
Left Hand	85
HX Heavy Duty, 135° Split Point	88-90
Aircraft Type A, 118° Split Point	91-93
Aircraft Type B, 135° Split Point	94-96
Quick Spiral	97-101
Parabolic Flute	102-105
Cobalt	
NAS Type J, 135° Split Point	106-110
NAS Type D, 135° Split Point	111-112
Sets	197-208

Screw Machine Length (Stub)

HSS	
General Purpose	113-115
TiN Tipped	116-118
NAS Type C, 135° Split Point	119-123
Parabolic Flute	124-125
Cobalt	
Micro	126
Heavy Duty, 135° Split Point	127-130
Sets	209-212

Taper Length

HSS	
General Purpose	131-136
High Helix	137
Parabolic	138-140
Cobalt	
Heavy Duty	141-144
Sets	213

Extra Length

HSS	
Overall Length - 8"	143-144
Overall Length - 12"	143-144
Overall Length - 15"	145-149
Overall Length - 18"	145-149
Parabolic	150-151

Aircraft Extension

HSS, Type B	
Overall Length - 6"	152-155
Overall Length - 12"	156-157
Cobalt, Type B	
Overall Length - 6"	158-159
Overall Length - 12"	158-159

Taper Shank

HSS, General Purpose	
Regular	160-165
TiN coated	163-165
Small Taper	160-162
Long Series	163-165
Extra length	166-169
Cobalt, Heavy Duty	170-171

Reduced Shank

HSS	
1/2" Shank	172-177
1/2" Shank with tri-flats	176-177
3/4" Shank	178
Cobalt	
1/2" Shank	179
Sets	214

Special Purpose Drills

Carbide Tipped	180-182
Combined Drill & Countersink	192-194
Spotting	188-190
Hexagonal Shank	195
Tapered Aircraft Router	196

Solid Carbide

General Purpose	183-186
Spotting	187
Combined Drill & Countersink	191

Sets

Jobber Length	197-208
Screw Machine Length	209-212
Taper Length	213
Reduced Shank	214



TABLE OF CONTENTS - TAPS

Application Products

Spiral Point Taps

Multi-Application	
Fractional/Machine Screw	230-234
Internal Coolant - Inch	230
Metric	235-239
Internal Coolant - Metric	235
Hard Materials	
Fractional/Machine Screw	241
Metric	242
DDX - High Hook	244

Straight Flute Taps

For cast iron	243
-------------------------	-----

Hand Taps (Straight Flute)

Fractional/Machine Screw	
Steam Tempered	268
Bright/Gold	265-267, 275
TiN Coated	269
Metric	270-273, 277
8-Pitch	280
Left Hand	274,278
Oversize	279
Optional Flute	276
For Cast Iron	281-283

Spiral Point Taps

Relieved Style	
Fractional/Machine Screw	284-287
Metric	288
Non-Relieved Style	
Fractional/Machine Screw	289-291
Metric	292
Oversize - Relieved Style	
Fractional/Machine Screw	294
Extension - Non-Relieved Style	
Fractional/Machine Screw	293

Spiral Flute Taps

30° Regular Spiral	
Fractional/Machine Screw	295
52° High Spiral	
Fractional/Machine Screw	296
Metric	298
40° Spiral - Heavy Duty	
Fractional/Machine Screw	297

Thread Forming Taps

Rol-Rite, Spiral Lobe	
Fractional/Machine Screw	299
Metric	300

Spiral Flute Taps

Multi-Application	
Fractional/Machine Screw	245-248
Internal Coolant - Inch	245
Metric	249-253
Internal Coolant, Metric	249
Hard Materials	
Fractional/Machine Screw	254
Metric	255

Thread Forming Taps

Fractional/Machine Screw	256, 258-259
Metric	257, 260

Pipe Taps

Straight Flute	261-262
Spiral Flute	263-264

General Purpose

Rol-Form, Lube Grooves	
Fractional/Machine Screw	301
Metric	302
Extension Rol-Form	
Fractional/ Machine Screw	303

Pipe Taps

NPT	
Medium Hook	304-306
High Hook	308
Low Rake	307
Spiral Flute	309
Interrupted Thread	310-311
NPTF (Dryseal)	
Medium Hook	312,315
Spiral Flute	313
Interrupted Thread	314
NPS	
Straight Pipe	316
NPSF	
Straight Pipe, Dryseal	316
Rc (British Standard)	317
G (British Standard)	318

Special Purpose Taps

STI (Screw Thread Insert)	319-320
Nut Style	321
Pulley Style	322
Combination Drill & Tap	323-326

Miscellaneous

Tap Wrench	327-328
Drill & Tap Sets	329

TABLE OF CONTENTS - DIES



Round Adjustable, Split Type

Carbon Steel (UNC,UNF,UNS,NPT)	334-335
HSS (UNC, UNF, M)	336-340
HSS (BSP)	341

Hex Rethreading Bolt Dies (Dienuts)

Carbon Steel(UNC,UNF,UNS,NPT,M)	343-344
HSS (M, MF)	345-346

Gun Nosed Dies

HSS, Left Hand (M)	342
------------------------------	-----

Die Stocks	347-348
----------------------	---------

TABLE OF CONTENTS - END MILLS

Application Products

Solid Carbide, center cutting

2-Flute	
Regular Length	
Square End	356
Corner Radius	357
Long Reach	
Ball Nose	358
3-Flute	
Regular Length	
Square End	359

Corner Radius	360
4-Flute	
Regular Length, Unequal Helix, Corner Rad	
For Stainless Steel	
Cylindrical Shank	362
Weldon Shank	363
For Steel	
Cylindrical Shank	364
Multi-Flute Finishing	
Long length corner radius	361

General Purpose

Solid Carbide, Center Cutting

2-Flute	
Square End, Single End	
Regular	366-367
Long	368
Extra-Long	369
Square End, Double End	
Regular	365
Ball Nose	
Regular	370-371
Long	372
Extra-Long	373
3-Flute	
Square End, Single End	
Regular	374
4-Flute	
Square End, Single End	
Regular	376-377
Long	378
Extra-Long	379
Square End, Double End	
Regular	375
Ball Nose	
Regular	380-381
Long	382
Extra-Long	383

Ball Nose	
Regular	392
High Helix for Aluminum, Square End, Single End	
Regular	393
Long	394
3-Flute	
Square End, Single End	
Regular	395
Long	396
4-Flute	
Square End, Single End	
Regular	402,409
Square End, Double End	
Regular	401
Multi-Flute	
Square End, Single End	
Regular	403,408
Long	405

Cobalt Roughing End Mills

Fine Profile	
Regular Length	
Bright	397
TiCN	397
Long Length	
Bright	400
Coarse Profile	
Regular Length	
Bright	398
TiCN	398
Long Length	
Bright	399

HSS and Cobalt Finishing End Mills

2-Flute	
Square End, Single End	
Regular	384-385,387,389-390
Regular, Keyway	388
Square End, Double End	
Regular	386

Special Purpose Cutters

Corner Rounding	407
---------------------------	-----



TABLE OF CONTENTS - REAMERS

Application Products

Carbide Reamer

Machine Reamer, Unequal Spacing	414-417
High Precision, Centesimal	418-419

Cobalt Reamer

High Precision, Centesimal	420-422
--------------------------------------	---------

General Purpose

High Speed Steel & Cobalt Reamers

Straight Shank

Chucking, Straight Flute	423-426
Chucking, Spiral Flute	428-430
Chucking, Expansion	427
Car	431

Taper Shank

Chucking, Straight Flute	433
Chucking, Spiral Flute	433,435-436
Chucking, Expansion	434
Bridge	437-438

Taper Pin, Right Hand Cut

Straight Flute	443
Spiral Flute, Left Hand	444
High Spiral Flute, Left Hand	432
Hand Reamer, Straight Flute	448

Adjustable Hand Reamer	441-442
Core Drill	439
Taper Pipe	445
Hand	440,446-447

TABLE OF CONTENTS - COUNTERSINKS & COUNTERBORES

COUNTERSINK

60°

Single Flute	455
3-Flute	456-458
3-Flute, Taper Shank	467
4-Flute	457

82°

Single Flute	455
3-Flute	456-459
4-Flute	457

90°

Single Flute	455,460
Carbide 3-Flute	454
HSS 3-Flute	456,461,462
HSCO 3-Flute	463
Long Reach 3-Flute	465
Multi-Flute	466

Taper Shank 3-Flute	468
Set 3-Flute	469

100°

3-Flute	456,464
-------------------	---------

COUNTERBORE

Straight Shank, Interchangeable Pilot Type

Short	470
-----------------	-----

Aircraft Series

Short	471-472
Long	471-472

Taper Shank, Interchangeable Pilot Type

Short	473
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Pilots, Detachable	474-475
------------------------------	---------

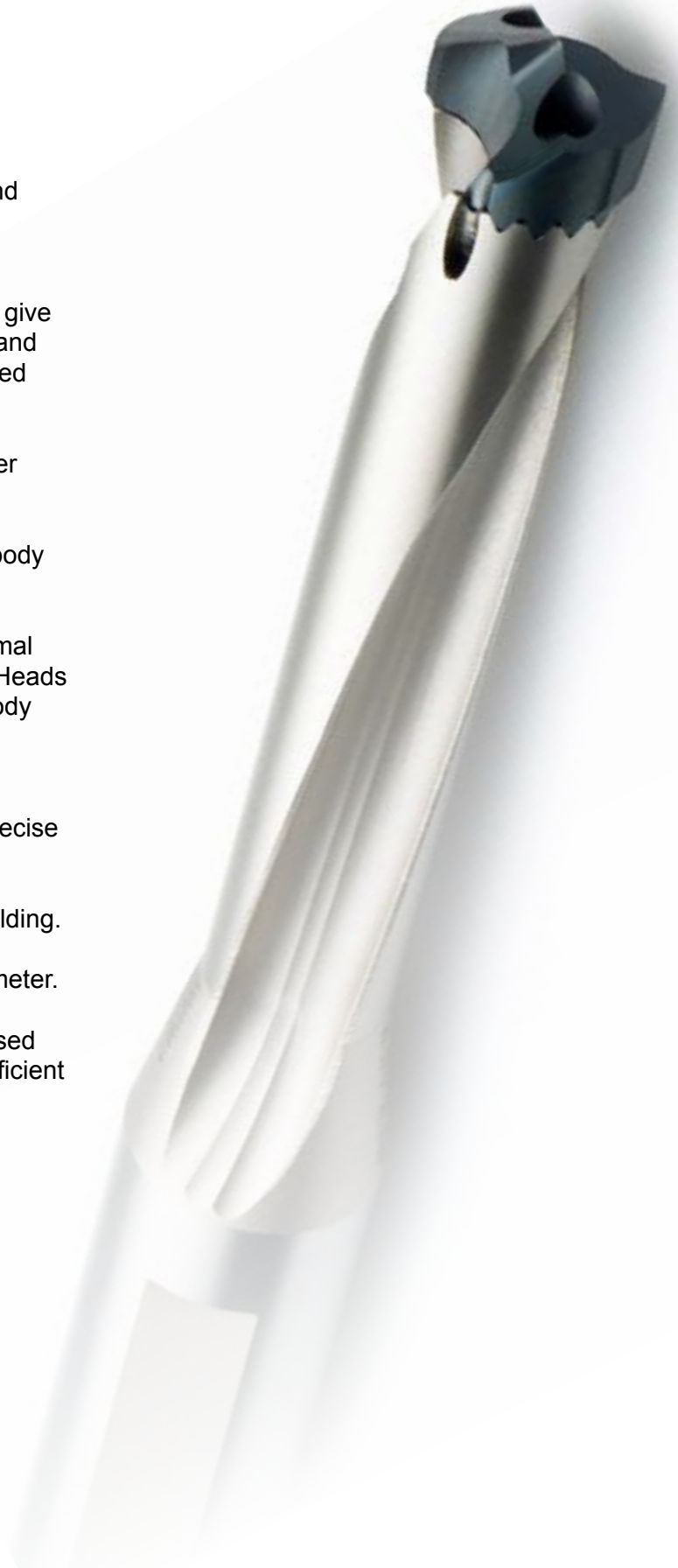
TABLE OF CONTENTS - MISCELLANEOUS

MISCELLANEOUS

Screw Extractor	477
Drilling & Tapping Fluid	478
Drill Sleeves	479
Tool Bit Blanks	480

Customer Benefits

- High productivity across a wide range of materials, including carbon and alloy steels, stainless steel, titanium, nickel and cast iron.
- Two head types available - the R960 head has been developed specifically to give optimum performance in stainless steel and cast iron. The R950 head is recommended for steels.
- Consistently high performance, even after numerous head changes.
- Reduction in inventory costs – one drill body fits multiple head sizes.
- Easy and quick head changes with minimal interruptions to the production process. Heads can be changed without removing the body from the machine.
- Exact fit of head to body maximizes tool rigidity for superior hole accuracy and precise tolerances.
- Shank design allows for versatile tool holding.
- A choice of drilling depths, up to 8 x diameter.
- Internal coolant channels provide optimised coolant direction and pressure to give efficient chip evacuation and longer tool life.



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

Head Style:	R950			R960		
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
Body Style:	H853	H855	H858	H853	H855	H858
Tool Material:	HSS	HSS	HSS	HSS	HSS	HSS
Standard:						
Depth of Cut:	3XD	5XD	8XD	3XD	5XD	8XD
Finish/Coating:						
Shank:						
Direction of Cut:						
Coolant:						

Application Material Groups (AMG)			Hardness HRC	Range:	Page #	19,25	19,28	19,31	22,25	22,28	22,31	ISO
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120 HB	12.00 - 42.50	1.1				361W	361V	328U	P 1
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200 HB	12.00 - 42.50	1.2				328W	328V	295U	P 1
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<24	14.00 - 42.50	1.3	328W	328V	295U				P 2
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<24	14.00 - 42.50	1.4	279W	279V	246U				P 3
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>24<38	14.00 - 42.50	1.5	279W	279V	246U				P 4
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>38	14.00 - 42.50	1.6	197T	197T	197S				H 1
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55	14.00 - 42.50	1.7							H 3
	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63	14.00 - 42.50	1.8							H 4
2. Stainless Steel	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<24	12.00 - 42.50	2.1				197V	164V	148U	M 1
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<24	12.00 - 42.50	2.2				164T	164S	131S	M 3
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, DUPLEX	<32	12.00 - 42.50	2.3				131T	131S	115S	M 2
	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<32	12.00 - 42.50	2.4	115T	115T	98S				S 2
3. Cast Iron	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150 HB	12.00 - 42.50	3.1				394V	374V	348U	K 1
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150 HB<32	12.00 - 42.50	3.2				380V	354V	328U	K 2
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200 HB	14.00 - 42.50	3.3	289V	279V	262U				K 3
	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200 HB<32	14.00 - 42.50	3.4	289V	279V	262U				K 4
4. Titanium	4.1 Titanium, unalloyed	Commercially Pure	<200 HB	12.00 - 42.50	4.1				148T	148T	115S	S 1
	4.2 Titanium, alloyed	6Al4V, 6A14V-2Sn, Monel, Monel K	<28	12.00 - 42.50	4.2				115T	115T	98S	S 2
	4.3 Titanium, alloyed	6A14V-4Mo, 7A14V-4Mo, 4911-4967	>28<38	12.00 - 42.50	4.3				98S	98S	82S	S 3
5. Nickel	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150 HB	12.00 - 42.50	5.1				115T	115T	98S	S 1
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<28	12.00 - 42.50	5.2				98S	98S	82S	S 2
	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>28<38	12.00 - 42.50	5.3				82S	82S	66S	S 3
6. Copper	6.1 Copper	Commercially Pure	<100 HB	12.00 - 42.50	6.1							N 3
	6.2 β-Brass, Bronze	314-340, 350-370	<200 HB	12.00 - 42.50	6.2							N 4
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200 HB	12.00 - 42.50	6.3							N 3
	6.4 High Strength Bronze	Ampco 18-25	<49	12.00 - 42.50	6.4							N 4
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	Commercially Pure	<100 HB	12.00 - 42.50	7.1							N 1
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150 HB	12.00 - 42.50	7.2							N 1
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120 HB	12.00 - 42.50	7.3							N 1
	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120 HB	12.00 - 42.50	7.4							N 2
8. Synthetic Materials	8.1 Thermoplastics	Ultrad, Polystrol	---	12.00 - 42.50	8.1							O
	8.2 Thermosetting plastics	Bakelit, Pertinax	---	12.00 - 42.50	8.2							O
	8.3 Reinforced plastic materials	CFK, GFKAFK	---	12.00 - 42.50	8.3							O
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54	12.00 - 42.50	9.1							H
10. Graphite	10.1 Standard graphite		---	12.00 - 42.50	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	DORMER	DIN 1897	DIN ANSI	DIN ANSI	DIN 338	DORMER	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	TN	TN	TN	TN	TN	TN	TN	Alumina Top	Alumina Top	TN	TN	Alumina Top	Alumina Top	Alumina Top
Shank:	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H	DIN 6539-H
Flute Form:	N	N	N	N	N	N	W	W	W	W	W	W	W	W	W
Direction of Cut:	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻	↻
Coolant Through:															
Image															
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 #	35	37	37	41	43	43	46	49	52	52	56	59	61	61	64
1.1	328X	410W	443W	328W	410V	443V	443V	187M	131J	197M	187M	279L	125H	197J	125F
1.2	295X	361W	394W	295W	361V	394V	394V	154M	112J	171M	154M	230L	108H	164J	108F
1.3	295X	295W	361W	295W	295V	361V	361U	131K	105I	174J	131K	197L	85H	144I	72G
1.4	262X	262V	328W	262W	262V	328V	328U	105I	105I	174J	98H	148H	85H	144I	72G
1.5	180X	197V	262W	180V	197V	262V	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 1989-1	DIN 1989-2	DIN 1989-3	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°	118°	135°
	W	W	W	W				N	N	N	N	N	N			N	
	A941	A976	A977	A978	R10P R15P R18P	R10 R15 R18	A012	NEW A012S	2A	2AB	A100	A002	NEW 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	
	64	67	67	67	70	70	74	74	78	78	78	78	78	85	86	88	
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																	

	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
	91	94	97	97	102	102	105	105	106	106	111	113	116	119
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-E	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	HSS	
	ANSI	DIN 1897	ANSI	ANSI	DIN 1899	ANSI	DIN 1897	ANSI	DIN 340	ANSI	ANSI	ANSI	DIN 340	DIN 340	ANSI	ANSI	
	2.5XD	2.5XD	3XD	3XD	2.5XD	2.5XD	2.5XD	6XD	6XD	6XD	6XD	6XD	6XD	6XD	12XD	15XD	
	135°	135°	135°	135°	118°	135°	135°	118°	118°	118°	135°	135°	135°	135°	135°	118°	
		N			N		N		N	W							
	A245	4ASM	QC41P	QC41G	A720	M40CO M41CO M42CO	4ASMC0	R51 R52 R55	5ATL	R51FS	QC91P	QC91G	QC91PM	QC91GM	M51CO M52CO	0860 1290	1511 1813
	N40 - 29/64	1.00 - 12.50	1/16 - 11/16	1/16 - 1/2	0.15 - 1.40	N60 - 3/4	2.30 - 12.00	N80 - 1.3/4	1.00 - 31.00	1/16 - 1/2	1/16 - 11/16	1/16 - 1/2	1.50 - 17.00	1.50 - 12.50	1/16 - 1"	1/8 - 3/4	3/16 - 1"
	119	122	124	124	126	127	130	131	135	137	138	138	140	140	141	143	145
1.1	115J	115J	98F	115F	115A	125K	125K	89G	89G		98F	115F	98F	115F	89G	79E	79E
1.2	98J	98J	59F	69F	98A	108H	108H	82G	82G		59F	69F	59F	69F	82G	72E	72E
1.3	89G	89G	66H	75H	89A	98G	98G	66E	66E		66H	75H	66H	75H	66E	52C	52C
1.4	69G	69G	59F	69F	75A	89G	89G	52E	52E		59F	69F	59F	69F	52E	49C	49C
1.5	46F	46F	46D	56D	56A	59F	59F	30D	30D		46D	56D	46D	56D	30D	20A	20A
1.6	33E	33E			33A	36E	36E	20B	20B						20B	16A	16A
1.7																	
1.8																	
2.1	52F	52F	89H	105H	72A	72F	72F	33D	33D		89H	105H	89H	105H	33D	30C	30C
2.2	30H	30H	49F	59F	33A	36H	36H	20F	20F		49F	59F	49F	59F	20F	13E	13E
2.3	33D	33D	49D	59D	49A	49D	49D	13B	13B		49D	59D	49D	59D	13B	26A	26A
2.4																	
3.1	105J	105J	151H	171H	98A	112K	112K	92H	92H		151H	171H	151H	171H	92H	72G	72G
3.2	89G	89G	79H	89H	79A	98F	98F	69E	69E		79H	89H	79H	89H	69E	59D	59D
3.3	66F	66F	79F	95F	66A	72F	72F	49D	49D		79F	95F	79F	95F	49D	43C	43C
3.4	52F	52F		59D	46A	56F	56F	43D	43D			59D		59D	43D	30C	30C
4.1	89G	89G	89H		75A	98G	98G	56E	56E		89H		89H	56E	36D	36D	
4.2	52E	52E	49F		56A	59F	59F	30C	30C		49F		49F	30C	30B	30B	
4.3	26C	26C			26A	33C	33C	13A	13A					13A	16A	16A	
5.1	43H	43H	49F	59H	33A	49H	49H	26F	26F		49F	59H	49F	59H	26F	16E	16E
5.2	26F	26F			23A	30F	30F	13D	13D					13D	13C	13C	
5.3	13B	13B			13A	20C	20C	10A	10A					10A	10A	10A	
6.1	118H	118H	89I	98I	115A	125I	125I	98E	98E	89I	89I	98I	89I	98I	98E	79D	79D
6.2	125J	125J	79H	89H	131A	131K	131K	105H	105H		79H	89H	79H	89H	105H	108G	108G
6.3	89I	89I	79H	89H	115A	89J	89J	89G	89G		79H	89H	79H	89H	89G	72F	72F
6.4	52H	52H			89A	52I	52I	52E	52E					52E	52D	52D	
7.1	108K	108K	351H		115A	115K	115K	105I	105I	348H	351H	400H	351H	400H	105I	79H	79H
7.2	98J	98J	325H		98A	108J	108J	89H	89H	325H	325H	351H	325H	351H	89H	72G	72G
7.3	98I	98I			89A	102I	102I	89G	89G						89G	72F	72F
7.4	82I	82I	276H		89A	98G	98G	82E	82E	276H	276H	315H	276H	315H	82E	66E	66E
8.1	98K	98K			157A	115M	115M	115I	115I						115I	98H	98H
8.2	115I	115I			82A	92K	92K	85G	85G						85G	85F	85F
8.3	56G	56G				56I	56I	39E	39E						39E	33D	33D
9.1	13C	13C				20C	20C	10A	10A						10A	10A	10A
10.1																	

	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E
	SS 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°
	TT				TT	TT	TT	TT	TT	TT	TT	TT	TT	TT	TT	TT
	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
	145	150	152	152	153	156	158	158	160	163	163	163	166	168	168	170
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	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"
	172	174	176	178	180	182	183	186	187	188	188	188	188	188	189	189
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	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
	189	189	190	190	190	190	191	192	193	193	193	194	195	195	195	196
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		108I	108I	108I	108I	108I	125J	125J	125J	
6.3	89D	89D	89D	89D	89D	89D	820V	89H	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		108J	108J	108J	108J	108J	108K	108K	108K	
7.2	98E	98E	98E	98E	98E	98E		98I	98I	98I	98I	98I	98J	98J	98J	
7.3	98D	98D	98D	98D	98D	98D		98H	98H	98H	98H	98H	98I	98I	98I	
7.4	82D	82D	82D	82D	82D	82D		72H	72H	72H	72H	72H	72H	72H	72H	79F
8.1	98F	98F	98F	98F	98F	98F		98J	98J	98J	98J	98J	98K	98K	98K	
8.2	115E	115E	115E	115E	115E	115E		92H	92H	92H	92H	92H	115I	115I	115I	
8.3	56D	56D	56D	56D	56D	56D		46F	46F	46F	46F	46F	56G	56G	56G	
9.1	39A	39A	39A	39A	39A	39A		10B	10B	10B	10B	10B	13C	13C	13C	10B
10.1																

List Number Index - Drills



Pgs. 8 - 214

0860	143	A976	67	D444	180	R454	43
209	160	A977	67	DC	191	R457	37
1290	143	A978	67	DS-90	187	R458	37
1511	145	ATR41	196	H853	25	R459	46
1813	145	C114COMB	200	H855	28	R51	131
209CO	170	C114COMBC	208	H858	31	R510	41
2A	78	C114COMBP	199	H860	34	R51FS	137
2AB	78	C115COMB	200	H861	34	R52	131
2ACO	106	C115COMBC	208	HX10	88	R520	35
4ASM	122	C115COMBP	199	HX15	88	R55	131
4ASMCO	130	C13R10CO	207	HX18	88	R56	174
500-12	156	C15L10	204	L10	85	R56CO	179
500-6	153	C15R10	197	M40CO	127	R57	176
501-12	156	C15R10CO	207	M41CO	127	R58	178
501-6	153	C15R10P	197	M42CO	127	R88CO	111
502-12	156	C20R18	198	M51CO	141	R89CO	111
502-6	153	C20R18P	198	M52CO	141	R950	19
5ATL	135	C21R10CO	207	QC0860P	150	R960	22
5ATS	163	C252A	201	QC1290P	150	S209	160
76HA	192	C252AB	201	QC21G	102	SPL-120	190
A002	78	C26M42CO	212	QC21GM	105	SPL-90	190
A012	74	C26R15	199	QC21P	102	SPLG-120	190
A022	116	C26R15CO	207	QC21PM	105	SPLG-90	190
A088	210	C26R15P	199	QC41G	124	SPR-120	189
A097	198	C26R42	209	QC41P	124	SPR-90	189
A100	78	C29HX10	206	QC91G	138	SPRG-120	189
A101	86	C29L10	204	QC91GM	140	SPRG-90	189
A108	97	C29M40CO	212	QC91P	138	SPS-120	188
A125	145	C29R10	197	QC91PM	140	SPS-90	188
A160	182	C29R10CO	207	R10	70	SPSG-120	188
A170	172	C29R10P	197	R10A	91	SPSG-90	188
A190	201	C29R40	209	R10B	94	TS10	195
A191	201	C29R40C	211	R10CO	106	TS18	195
A217	193	C29R51	213	R10H	97	TS41	195
A218	193	C33R56	214	R10P	70	TS51	195
A221	194	C502AB	201	R15	70	TS52	195
A225	193	C60M41CO	212	R15A	91		
A245	119	C60R18	198	R15B	94		
A345	166	C60R18CO	207	R15CO	106		
A350	163	C60R18P	198	R15P	70		
A510	56	C60R41	209	R18	70		
A520	49	C60R41C	211	R18A	91		
A530	163	C8R56	214	R18B	94		
A553	59	C8R56CO	214	R18CO	106		
A720	126	C8R57	214	R18H	97		
A900	61	CO500-12	158	R18P	70		
A901	61	CO500-6	158	R40	113		
A920	52	CO501-12	158	R40C	119		
A921	52	CO501-6	158	R41	113		
A940	64	D33F	183	R41C	119		
A941	64	D33L	183	R42	113		
A951	168	D33M	186	R42C	119		
A952	168	D33W	183	R453	43		

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 500

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
	12.60	0.4961	9.4	1	0037928
1/2	12.70	0.5000	9.4	1	0010914
	12.80	0.5039	9.4	1	0037935
	12.90	0.5079	9.4	1	0037942
	13.00	0.5118	9.7	1	0010921
33/64	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
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
14.50		0.5709	10.3	1	0011010
14.60		0.5748	11.0	1	0038017
37/64	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
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 ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ 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
	16.20	0.6378	11.6	1	0038093
41/64	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
47/64	18.60	0.7323	13.5	1	0038178
	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	0012345
	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	0012406
	20.00	0.7874	14.1	1	0012413
51/64	20.24	0.7969	14.1	1	0012437
	20.50	0.8071	14.1	1	0012451
13/16	20.64	0.8125	14.8	1	0012468
	21.00	0.8268	14.8	1	0012475
53/64	21.03	0.8281	14.8	1	0012536
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	0012635
	22.50	0.8858	15.0	1	0032336
57/64	22.62	0.8906	15.0	1	0012642
	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

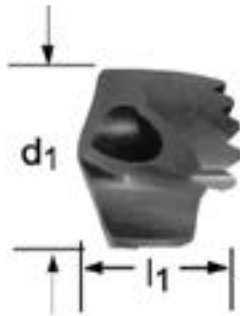
d ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ mm	Pack Qty	R950
61/64	24.21	0.9531	15.4	1	0012741
	24.50	0.9646	15.4	1	0038260
31/32	24.61	0.9688	15.4	1	0012772
	25.00	0.9844	15.8	1	0012819
63/64	25.00	0.9844	15.8	1	0012826
1"	25.40	1.0000	15.8	1	0012833
	25.50	1.0039	15.8	1	0038277
	25.65	1.0098	15.8	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 500

d_1 $\varnothing h_7$ Inch	d_1 $\varnothing h_7$ 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 ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ 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
43/64	17.07	0.6719	12.2	1	0016183
	17.10	0.6732	12.2	1	0039700
	17.20	0.6772	12.2	1	0039717
11/16	17.46	0.6875	12.2	1	0016190
	17.50	0.6890	12.2	1	0016503
	17.60	0.6929	12.9	1	0032381
45/64	17.70	0.6969	12.9	1	0039724
	17.86	0.7031	12.9	1	0016640
	18.00	0.7087	12.9	1	0016664
	18.10	0.7126	12.9	1	0039731
23/32	18.20	0.7165	12.9	1	0039748
	18.26	0.7188	12.9	1	0016671
	18.50	0.7283	12.9	1	0016688
	18.60	0.7323	13.5	1	0039755
47/64	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
25/32	19.70	0.7756	14.1	1	0039816
	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
13/16	20.50	0.8071	14.1	1	0017159
	20.64	0.8125	14.8	1	0017197
53/64	21.00	0.8268	14.8	1	0017166
	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
	29/32	23.02	0.9063	15.1	1
59/64	23.42	0.9219	15.1	1	0017456
	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_1 $\varnothing h_7$ Inch	d_1 $\varnothing h_7$ mm	d_1 decimal Inch	l_1 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

3xD Hydra Bodies

H853

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 500



H853
Coolant Through



12.00 - 42.50

Hydra Head $d_1 \varnothing$	Hydra Head R950 EDP#	Hydra Head R960 EDP#	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
			$d_2 \varnothing h_6$ inch	l_2 mm	l_1 mm	l_3 mm	H853 EDP#	$d_2 \varnothing h_6$ mm	l_2 mm	l_1 mm	l_3 mm	H853 EDP#
15/32	0010860	0013472	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.0	0010877	0013489	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.1	0037904	0038338	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.2	0037911	0038376	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
31/64	0010884	0013496	5/8	44.0	105.0	48.0	0033043	16.0	44.0	105.0	48.0	0017777
12.5	0010907	0013519	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.6	0037928	0038413	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
1/2	0010914	0013526	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.8	0037935	0038437	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
12.9	0037942	0038451	5/8	44.0	105.0	48.0	0033050	16.0	44.0	105.0	48.0	0017791
13.0	0010921	0013533	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
33/64	0010938	0013540	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
13.2	0037959	0038468	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
17/32	0010945	0013557	5/8	47.0	110.0	48.0	0033067	16.0	47.0	110.0	48.0	0017906
13.5	0010952	0016022	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.6	0037966	0038499	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.7	0037973	0038529	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
13.8	0037980	0038543	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
35/64	0010969	0016039	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.0	0010983	0016046	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.1	0037997	0038567	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.2	0038000	0038574	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
9/16	0011003	0016053	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.5	0011010	0016060	3/4	52.5	116.5	48.0	0033074	16.0	52.5	116.5	48.0	0017913
14.6	0038017	0038581	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
37/64	0011140	0016077	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
14.7	0038024	0039601	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
14.8	0038031	0039618	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.0	0011201	0016084	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
19/32	0011218	0016091	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293

HYDRA DRILL



Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
			d ₂ Øh ₆ inch	l ₂ mm	l ₁ mm	l ₃ mm	H853 EDP#	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	H853 EDP#
15.1	0038048	0039625	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.2	0038055	0039632	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.24	0032268	0032350	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
39/64	0011232	0016107	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.5	0011362	0016114	3/4	55.5	126.5	50.0	0033081	20.0	55.5	126.5	50.0	0018293
15.6	0038062	0039649	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
15.7	0038079	0039656	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
5/8	0011379	0016121	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.0	0011386	0016138	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.08	0032275	0032367	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.1	0038086	0039663	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.2	0038093	0039670	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
41/64	0011393	0016145	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.3	0032282	0032374	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.5	0011409	0016152	3/4	59.5	131.5	50.0	0033098	20.0	59.5	131.5	50.0	0018316
16.6	0038109	0039687	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
21/32	0012161	0016169	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
16.7	0038116	0039694	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.0	0012185	0016176	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
43/64	0012215	0016183	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.1	0038123	0039700	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.2	0038130	0039717	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
11/16	0012239	0016190	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.5	0012253	0016503	3/4	62.5	136.5	50.0	0033104	20.0	62.5	136.5	50.0	0018323
17.6	0032299	0032381	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
17.7	0038147	0039724	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
45/64	0012260	0016640	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.0	0012277	0016664	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.1	0038154	0039731	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.2	0038161	0039748	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
23/32	0012284	0016671	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.5	0012307	0016688	3/4	66.5	141.5	50.0	0033111	20.0	66.5	141.5	50.0	0018330
18.6	0038178	0039755	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
47/64	0012321	0016695	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
18.7	0038185	0039762	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
18.9	0038192	0039779	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.0	0012338	0016817	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
3/4	0012345	0016879	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.1	0038208	0039786	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.2	0038215	0039793	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.25	0032305	0032398	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.3	0032312	0032404	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.35	0032329	0032411	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
49/64	0012376	0016886	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.5	0012383	0016947	1	69.5	156.5	56.0	0033128	25.0	69.5	156.5	56.0	0018347
19.6	0038222	0039809	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
19.7	0038239	0039816	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
25/32	0012406	0016954	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
20.0	0012413	0017111	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
51/64	0012437	0017128	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
20.5	0012451	0017159	1	73.5	156.5	56.0	0033135	25.0	73.5	156.5	56.0	0018354
13/16	0012468	0017197	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
21.0	0012475	0017166	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
53/64	0012536	0017203	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
27/32	0012550	0017227	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
21.5	0012574	0017234	1	76.5	156.5	56.0	0033142	25.0	76.5	156.5	56.0	0018361
55/64	0012604	0017241	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.0	0012628	0017258	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
7/8	0012635	0017371	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.5	0032336	0032428	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
57/64	0012642	0017401	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
22.7	0038246	0039823	1	80.1	161.5	56.0	0033159	25.0	80.1	161.5	56.0	0018378
23.0	0012666	0017425	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
29/32	0012673	0017432	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
59/64	0012680	0017456	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385



HYDRA DRILL

Hydra Head Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	3xD Hydra Body - Fractional Shank					3xD Hydra Body - Metric Shank				
			d ₂ Øh ₆ inch	l ₂ mm	l ₁ mm	l ₃ mm	H853 EDP#	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	H853 EDP#
23.5	0038253	0039830	1	82.5	160.5	56.0	0033166	25.0	82.5	160.5	56.0	0018385
15/16	0012703	0017562	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
24.0	0012727	0017579	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
61/64	0012741	0017586	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
24.5	0038260	0039847	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
31/32	0012772	0017593	1	86.2	170.2	60.0	0033173	32.0	86.2	170.2	60.0	0018392
25.0	0012819	0017722	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
63/64	0012826	0017746	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
1	0012833	0017753	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
25.5	0038277	0039854	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
25.65	0032343	0032435	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
1.1/64	0012840	0018958	1.1/4	88.0	170.0	60.0	0033180	32.0	88.0	170.0	60.0	0018408
26.0	0013090	0018965	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.1/32	0013120	0018972	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
26.5	0038284	0039878	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.3/64	0013229	0018989	1.1/4	92.0	175.0	60.0	0033197	32.0	92.0	175.0	60.0	0018415
1.1/16	0013243	0018996	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
27.0	0013267	0019009	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
1.5/64	0013274	0019016	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
27.5	0038291	0039885	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
1.3/32	0013281	0019023	1.1/4	94.0	175.0	60.0	0033210	32.0	94.0	175.0	60.0	0018422
28.0	0013304	0019030	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.7/64	0013311	0019047	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
28.5	0038307	0039892	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.1/8	0013328	0019054	1.1/4	97.0	180.0	60.0	0033227	32.0	97.0	180.0	60.0	0018439
1.9/64	0013342	0019061	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
29.0	0013366	0019078	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
1.5/32	0013380	0019085	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
29.5	0038314	0039908	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
1.11/64	0013427	0019092	1.1/4	100.0	185.0	60.0	0033234	32.0	100.0	185.0	60.0	0018446
30.0	0013434	0019108	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
1.3/16	0013441	0019115	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
30.5	0013465	0019122	1.1/4	104.0	185.0	60.0	0033425	32.0	104.0	185.0	60.0	0018453
1.7/32	46104481	—	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
31.00	46104482	—	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
1.1/4	46104483	—	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
32.00	46104484	—	—	—	—	—	—	32.0	111.5	196.5	60.0	46111405
32.50	46104485	—	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
1.19/64	46104486	—	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
33.00	46104487	—	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
33.50	46104488	—	—	—	—	—	—	32.0	116.5	201.5	60.0	46111406
34.00	46104489	—	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
1.11/32	46104530	—	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
34.50	46104531	—	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
1.3/8	46104532	—	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
35.00	46104533	—	—	—	—	—	—	40.0	121.5	216.5	70.0	46111407
36.00	46104534	—	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
1.27/64	46104535	—	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
36.50	46104536	—	—	—	—	—	—	40.0	125.5	221.5	70.0	46111408
37.00	46104537	—	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
1.15/32	46104538	—	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
37.50	46104539	—	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
38.00	46104540	—	—	—	—	—	—	40.0	131.5	226.5	70.0	46111409
1.1/2	46104541	—	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
38.50	46104542	—	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
1.17/32	46104543	—	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
39.00	46104544	—	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
39.50	46104545	—	—	—	—	—	—	40.0	136.5	231.5	70.0	46111410
1.9/16	46104546	—	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
40.00	46104547	—	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
41.00	46104548	—	—	—	—	—	—	40.0	146.5	246.5	70.0	46111411
1.5/8	46104549	—	—	—	—	—	—	40.0	151.5	251.5	70.0	46111412
42.00	46104550	—	—	—	—	—	—	40.0	151.5	251.5	70.0	46111412

HYDRA DRILL



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 500

H855
Coolant
Through



12.00 - 42.50

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

Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	5xD Hydra Body - Fractional Shank					5xD Hydra Body - Metric Shank				
			d ₂ Øh ₆ inch	l ₂ mm	l ₁ mm	l ₃ mm	H855 EDP#	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	H855 EDP#
15.1	0038048	0039625	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.2	0038055	0039632	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.24	0032268	0032350	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
39/64	0011232	0016107	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.5	0011362	0016114	3/4	86.5	156.5	50.0	0034705	20.0	86.5	156.5	50.0	0018507
15.6	0038062	0039649	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
15.7	0038079	0039656	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
5/8	0011379	0016121	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.0	0011386	0016138	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.08	0032275	0032367	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.1	0038086	0039663	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.2	0038093	0039670	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
41/64	0011393	0016145	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.3	0032282	0032374	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.5	0011409	0016152	3/4	92.5	166.5	50.0	0034712	20.0	92.5	166.5	50.0	0018514
16.6	0038109	0039687	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
21/32	0012161	0016169	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
16.7	0038116	0039694	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.0	0012185	0016176	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
43/64	0012215	0016183	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.1	0038123	0039700	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.2	0038130	0039717	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
11/16	0012239	0016190	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.5	0012253	0016503	3/4	97.5	171.5	50.0	0034736	20.0	97.5	171.5	50.0	0018521
17.6	0032299	0032381	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
17.7	0038147	0039724	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
45/64	0012260	0016640	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.0	0012277	0016664	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.1	0038154	0039731	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.2	0038161	0039748	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
23/32	0012284	0016671	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.5	0012307	0016688	3/4	103.5	176.5	50.0	0034743	20.0	103.5	176.5	50.0	0018538
18.6	0038178	0039755	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
47/64	0012321	0016695	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
18.7	0038185	0039762	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
18.9	0038192	0039779	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.0	0012338	0016817	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
3/4	0012345	0016879	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.1	0038208	0039786	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.2	0038215	0039793	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.25	0032305	0032398	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.3	0032312	0032404	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.35	0032329	0032411	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
49/64	0012376	0016886	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.5	0012383	0016947	1	108.5	191.5	56.0	0034798	25.0	108.5	191.5	56.0	0018545
19.6	0038222	0039809	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
19.7	0038239	0039816	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
25/32	0012406	0016954	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
20.0	0012413	0017111	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
51/64	0012437	0017128	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
20.5	0012451	0017159	1	114.5	196.5	56.0	0034804	25.0	114.5	196.5	56.0	0018552
13/16	0012468	0017197	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
21.0	0012475	0017166	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
53/64	0012536	0017203	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
27/32	0012550	0017227	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
21.5	0012574	0017234	1	119.5	196.5	56.0	0034811	25.0	119.5	196.5	56.0	0018569
55/64	0012604	0017241	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.0	0012628	0017258	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
7/8	0012635	0017371	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.5	0032336	0032428	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
57/64	0012642	0017401	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
22.7	0038246	0039823	1	125.1	201.1	56.0	0034835	25.0	125.1	201.1	56.0	0018576
23.0	0012666	0017425	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
29/32	0012673	0017432	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583

HYDRA DRILL



Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	5xD Hydra Body - Fractional Shank					5xD Hydra Body - Metric Shank				
			d ₂ Øh ₆ inch	l ₂ mm	l ₁ mm	l ₃ mm	H855 EDP#	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	H855 EDP#
59/64	0012680	0017456	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
23.5	0038253	0039830	1	129.5	210.5	56.0	0034842	25.0	129.5	210.5	56.0	0018583
15/16	0012703	0017562	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
24.0	0012727	0017579	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
61/64	0012741	0017586	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
24.5	0038260	0039847	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
31/32	0012772	0017593	1	135.2	220.2	60.0	0034859	32.0	135.2	220.2	60.0	0018590
25.0	0012819	0017722	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
63/64	0012826	0017746	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
1	0012833	0017753	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
25.5	0038277	0039854	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
25.65	0032343	0032435	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
1.1/64	0012840	0018958	1.1/4	140.0	225.0	60.0	0034866	32.0	140.0	225.0	60.0	0018606
26.0	0013090	0018965	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.1/32	0013120	0018972	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
26.5	0038284	0039878	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.3/64	0013229	0018989	1.1/4	146.0	230.0	60.0	0034873	32.0	146.0	230.0	60.0	0018613
1.1/16	0013243	0018996	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
27.0	0013267	0019009	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
1.5/64	0013274	0019016	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
27.5	0038291	0039885	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
1.3/32	0013281	0019023	1.1/4	151.0	235.0	60.0	0034897	32.0	151.0	235.0	60.0	0018620
28.0	0013304	0019030	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.7/64	0013311	0019047	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
28.5	0038307	0039892	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.1/8	0013328	0019054	1.1/4	157.0	240.0	60.0	0034903	32.0	157.0	240.0	60.0	0018637
1.9/64	0013342	0019061	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
29.0	0013366	0019078	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
1.5/32	0013380	0019085	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
29.5	0038314	0039908	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
1.11/64	0013427	0019092	1.1/4	162.0	245.0	60.0	0034934	32.0	162.0	245.0	60.0	0018644
30.0	0013434	0019108	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
1.3/16	0013441	0019115	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
30.5	0013465	0019122	1.1/4	167.0	255.0	60.0	0034965	32.0	167.0	255.0	60.0	0018651
1.7/32	46104481	—	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
31.00	46104482	—	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
1.1/4	46104483	—	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
32.00	46104484	—	—	—	—	—	—	32.0	176.5	261.5	60.0	46111413
32.50	46104485	—	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
1.19/64	46104486	—	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
33.00	46104487	—	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
33.50	46104488	—	—	—	—	—	—	32.0	186.5	271.5	60.0	46111414
34.00	46104489	—	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
1.11/32	46104530	—	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
34.50	46104531	—	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
1.3/8	46104532	—	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
35.00	46104533	—	—	—	—	—	—	40.0	196.5	291.5	70.0	46111415
36.00	46104534	—	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
1.27/64	46104535	—	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
36.50	46104536	—	—	—	—	—	—	40.0	201.5	296.5	70.0	46111416
37.00	46104537	—	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
1.15/32	46104538	—	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
37.50	46104539	—	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
38.00	46104540	—	—	—	—	—	—	40.0	211.5	306.5	70.0	46111417
1.1/2	46104541	—	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
38.50	46104542	—	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
1.17/32	46104543	—	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
39.00	46104544	—	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
39.50	46104545	—	—	—	—	—	—	40.0	211.5	316.5	70.0	46111418
1.9/16	46104546	—	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
40.00	46104547	—	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
41.00	46104548	—	—	—	—	—	—	40.0	226.5	325.5	70.0	46111419
1.5/8	46104549	—	—	—	—	—	—	40.0	236.5	336.5	70.0	46111420
42.00	46104550	—	—	—	—	—	—	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.



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

* For more information on Hydra, see page 500



**H858
Coolant
Through**



8XD

HSS

140°



14.00 - 42.50

Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	8xD Hydra Body - Metric Shank				H858 EDP#
			d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	
13.5	0010952	0016022	16.0	124.5	191.5	48.0	0018668
13.6	0037966	0038499	16.0	124.5	191.5	48.0	0018668
13.7	0037973	0038529	16.0	124.5	191.5	48.0	0018668
13.8	0037980	0038543	16.0	124.5	191.5	48.0	0018668
35/64	0010969	0016039	16.0	124.5	191.5	48.0	0018668
14.0	0010983	0016046	16.0	124.5	191.5	48.0	0018668
14.1	0037997	0038567	16.0	124.5	191.5	48.0	0018668
14.2	0038000	0038574	16.0	124.5	191.5	48.0	0018668
9/16	0011003	0016053	16.0	124.5	191.5	48.0	0018668
14.5	0011010	0016060	16.0	124.5	191.5	48.0	0018668
14.6	0038017	0038581	20.0	133.5	201.5	50.0	0018675
37/64	0011140	0016077	20.0	133.5	201.5	50.0	0018675
14.7	0038024	0039601	20.0	133.5	201.5	50.0	0018675
14.8	0038031	0039618	20.0	133.5	201.5	50.0	0018675
15.0	0011201	0016084	20.0	133.5	201.5	50.0	0018675
19/32	0011218	0016091	20.0	133.5	201.5	50.0	0018675
15.1	0038048	0039625	20.0	133.5	201.5	50.0	0018675
15.2	0038055	0039632	20.0	133.5	201.5	50.0	0018675
15.24	0032268	0032350	20.0	133.5	201.5	50.0	0018675
39/64	0011232	0016107	20.0	133.5	201.5	50.0	0018675
15.5	0011362	0016114	20.0	133.5	201.5	50.0	0018675
15.6	0038062	0039649	20.0	141.5	211.5	50.0	0018682
15.7	0038079	0039656	20.0	141.5	211.5	50.0	0018682
5/8	0011379	0016121	20.0	141.5	211.5	50.0	0018682
16.0	0011386	0016138	20.0	141.5	211.5	50.0	0018682
16.08	0032275	0032367	20.0	141.5	211.5	50.0	0018682
16.1	0038086	0039663	20.0	141.5	211.5	50.0	0018682
16.2	0038093	0039670	20.0	141.5	211.5	50.0	0018682
41/64	0011393	0016145	20.0	141.5	211.5	50.0	0018682
16.3	0032282	0032374	20.0	141.5	211.5	50.0	0018682

HYDRA DRILL



Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	8xD Hydra Body - Metric Shank				
			d ₂ Øh _s mm	l ₂ mm	l ₁ mm	l ₃ mm	H858 EDP#
16.5	0011409	0016152	20.0	141.5	211.5	50.0	0018682
16.6	0038109	0039687	20.0	150.5	221.5	50.0	0018699
21/32	0012161	0016169	20.0	150.5	221.5	50.0	0018699
16.7	0038116	0039694	20.0	150.5	221.5	50.0	0018699
17.0	0012185	0016176	20.0	150.5	221.5	50.0	0018699
43/64	0012215	0016183	20.0	150.5	221.5	50.0	0018699
17.1	0038123	0039700	20.0	150.5	221.5	50.0	0018699
17.2	0038130	0039717	20.0	150.5	221.5	50.0	0018699
11/16	0012239	0016190	20.0	150.5	221.5	50.0	0018699
17.5	0012253	0016503	20.0	150.5	221.5	50.0	0018699
17.6	0032299	0032381	20.0	158.5	226.5	50.0	0018705
17.7	0038147	0039724	20.0	158.5	226.5	50.0	0018705
45/64	0012260	0016640	20.0	158.5	226.5	50.0	0018705
18.0	0012277	0016664	20.0	158.5	226.5	50.0	0018705
18.1	0038154	0039731	20.0	158.5	226.5	50.0	0018705
18.2	0038161	0039748	20.0	158.5	226.5	50.0	0018705
23/32	0012284	0016671	20.0	158.5	226.5	50.0	0018705
18.5	0012307	0016688	20.0	158.5	226.5	50.0	0018705
18.6	0038178	0039755	25.0	167.5	251.5	56.0	0018712
47/64	0012321	0016695	25.0	167.5	251.5	56.0	0018712
18.7	0038185	0039762	25.0	167.5	251.5	56.0	0018712
18.9	0038192	0039779	25.0	167.5	251.5	56.0	0018712
19.0	0012338	0016817	25.0	167.5	251.5	56.0	0018712
3/4	0012345	0016879	25.0	167.5	251.5	56.0	0018712
19.1	0038208	0039786	25.0	167.5	251.5	56.0	0018712
19.2	0038215	0039793	25.0	167.5	251.5	56.0	0018712
19.25	0032305	0032398	25.0	167.5	251.5	56.0	0018712
19.3	0032312	0032404	25.0	167.5	251.5	56.0	0018712
19.35	0032329	0032411	25.0	167.5	251.5	56.0	0018712
49/64	0012376	0016886	25.0	167.5	251.5	56.0	0018712
19.5	0012383	0016947	25.0	167.5	251.5	56.0	0018712
19.6	0038222	0039809	25.0	175.5	264.5	56.0	0018729
19.7	0038239	0039816	25.0	175.5	264.5	56.0	0018729
25/32	0012406	0016954	25.0	175.5	264.5	56.0	0018729
20.0	0012413	0017111	25.0	175.5	264.5	56.0	0018729
51/64	0012437	0017128	25.0	175.5	264.5	56.0	0018729
20.5	0012451	0017159	25.0	175.5	264.5	56.0	0018729
13/16	0012468	0017197	25.0	184.5	266.5	56.0	0018736
21.0	0012475	0017166	25.0	184.5	266.5	56.0	0018736
53/64	0012536	0017203	25.0	184.5	266.5	56.0	0018736
27/32	0012550	0017227	25.0	184.5	266.5	56.0	0018736
21.5	0012574	0017234	25.0	184.5	266.5	56.0	0018736
55/64	0012604	0017241	25.0	192.1	271.1	56.0	0018743
22.0	0012628	0017258	25.0	192.1	271.1	56.0	0018743
7/8	0012635	0017371	25.0	192.1	271.1	56.0	0018743
22.5	0032336	0032428	25.0	192.1	271.1	56.0	0018743
57/64	0012642	0017401	25.0	192.1	271.1	56.0	0018743
22.7	0038246	0039823	25.0	192.1	271.1	56.0	0018743
23.0	0012666	0017425	25.0	200.5	280.5	56.0	0018750
29/32	0012673	0017432	25.0	200.5	280.5	56.0	0018750
59/64	0012680	0017456	25.0	200.5	280.5	56.0	0018750
23.5	0038253	0039830	25.0	200.5	280.5	56.0	0018750
15/16	0012703	0017562	32.0	208.2	295.2	60.0	0018767
24.0	0012727	0017579	32.0	208.2	295.2	60.0	0018767
61/64	0012741	0017586	32.0	208.2	295.2	60.0	0018767
24.5	0038260	0039847	32.0	208.2	295.2	60.0	0018767
31/32	0012772	0017593	32.0	208.2	295.2	60.0	0018767
25.0	0012819	0017722	32.0	217.0	300.0	60.0	0018774
63/64	0012826	0017746	32.0	217.0	300.0	60.0	0018774
1	0012833	0017753	32.0	217.0	300.0	60.0	0018774
25.5	0038277	0039854	32.0	217.0	300.0	60.0	0018774
25.65	0032343	0032435	32.0	217.0	300.0	60.0	0018774
1.1/64	0012840	0018958	32.0	217.0	300.0	60.0	0018774
26.0	0013090	0018965	32.0	225.0	310.0	60.0	0018781

Hydra Head d ₁ Ø	Hydra Head R950 EDP#	Hydra Head R960 EDP#	8xD Hydra Body - Metric Shank				
			d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm	H858 EDP#
1.1/32	0013120	0018972	32.0	225.0	310.0	60.0	0018781
26.5	0038284	0039878	32.0	225.0	310.0	60.0	0018781
1.3/64	0013229	0018989	32.0	225.0	310.0	60.0	0018781
1.1/16	0013243	0018996	32.0	234.0	320.0	60.0	0018798
27.0	0013267	0019009	32.0	234.0	320.0	60.0	0018798
1.5/64	0013274	0019016	32.0	234.0	320.0	60.0	0018798
27.5	0038291	0039885	32.0	234.0	320.0	60.0	0018798
1.3/32	0013281	0019023	32.0	234.0	320.0	60.0	0018798
28.0	0013304	0019030	32.0	242.0	325.0	60.0	0018804
1.7/64	0013311	0019047	32.0	242.0	325.0	60.0	0018804
28.5	0038307	0039892	32.0	242.0	325.0	60.0	0018804
1.1/8	0013328	0019054	32.0	242.0	325.0	60.0	0018804
1.9/64	0013342	0019061	32.0	251.0	335.0	60.0	0018811
29.0	0013366	0019078	32.0	251.0	335.0	60.0	0018811
1.5/32	0013380	0019085	32.0	251.0	335.0	60.0	0018811
29.5	0038314	0039908	32.0	251.0	335.0	60.0	0018811
1.11/64	0013427	0019092	32.0	251.0	335.0	60.0	0018811
30.0	0013434	0019108	32.0	259.0	345.0	60.0	0018828
1.3/16	0013441	0019115	32.0	259.0	345.0	60.0	0018828
30.5	0013465	0019122	32.0	259.0	345.0	60.0	0018828
1.7/32	46104481	—	32.0	271.5	356.5	60.0	46111421
31.00	46104482	—	32.0	271.5	356.5	60.0	46111421
1.1/4	46104483	—	32.0	271.5	356.5	60.0	46111421
32.00	46104484	—	32.0	271.5	356.5	60.0	46111421
32.50	46104485	—	40.0	286.5	371.5	60.0	46111422
1.19/64	46104486	—	40.0	286.5	371.5	60.0	46111422
33.00	46104487	—	40.0	286.5	371.5	60.0	46111422
33.50	46104488	—	40.0	286.5	371.5	60.0	46111422
34.00	46104489	—	40.0	301.5	396.5	70.0	46111423
1.11/32	46104530	—	40.0	301.5	396.5	70.0	46111423
34.50	46104531	—	40.0	301.5	396.5	70.0	46111423
1.3/8	46104532	—	40.0	301.5	396.5	70.0	46111423
35.00	46104533	—	40.0	301.5	396.5	70.0	46111423
36.00	46104534	—	40.0	311.5	406.5	70.0	46111424
1.27/64	46104535	—	40.0	311.5	406.5	70.0	46111424
36.50	46104536	—	40.0	311.5	406.5	70.0	46111424
37.00	46104537	—	40.0	326.5	421.5	70.0	46111425
1.15/32	46104538	—	40.0	326.5	421.5	70.0	46111425
37.50	46104539	—	40.0	326.5	421.5	70.0	46111425
38.00	46104540	—	40.0	326.5	421.5	70.0	46111425
1.1/2	46104541	—	40.0	336.5	431.5	70.0	46111426
38.50	46104542	—	40.0	336.5	431.5	70.0	46111426
1.17/32	46104543	—	40.0	336.5	431.5	70.0	46111426
39.00	46104544	—	40.0	336.5	431.5	70.0	46111426
39.50	46104545	—	40.0	336.5	431.5	70.0	46111426
1.9/16	46104546	—	40.0	351.5	451.5	70.0	46111427
40.00	46104547	—	40.0	351.5	451.5	70.0	46111427
41.00	46104548	—	40.0	351.5	451.5	70.0	46111427
1.5/8	46104549	—	40.0	361.5	461.5	70.0	46111428
42.00	46104550	—	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 500

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

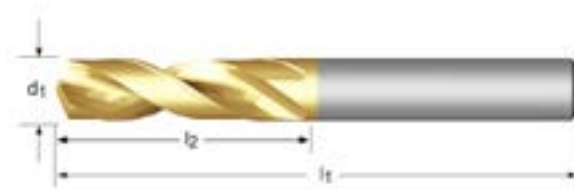
Multi-Application, Screw Machine Length, Parallel Shank

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 $\varnothing h_7$ Inch	d_1 $\varnothing h_7$ 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

CDX SOLID CARBIDE DRILL



d_1 Øh, Inch	d_1 Øh, mm	d_1 decimal Inch	l_2 mm	l_1 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

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 Split Point for enhanced penetration rate. TiAlN-Top coating increases wear resistance, improves tool life at high RPM.

R457

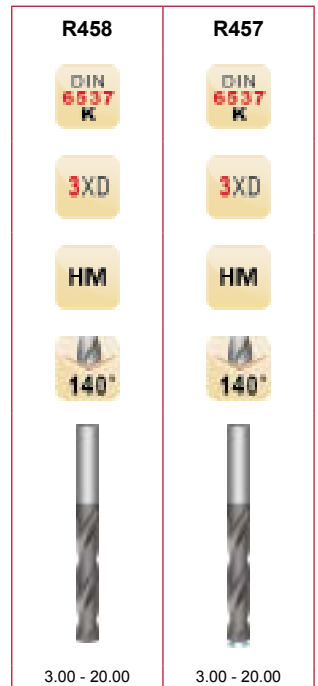
- 1.1 1.2 1.3 1.4 1.5 1.6 1.7 1.8 2.1 2.2 2.3 3.1 3.2 3.3 3.4
4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4

Coolant through clears chips away from the cutting edge. Self centering Split Point for enhanced penetration rates. TiAlN-Top coating increases surface hardness, improves tool life at high RPM.

High productivity in a wide range of materials



MP-X



d ₁ Ø "Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ 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	0.1250	20	62	36	6	1	0624845	0624432
	3.20	0.1260	20	62	36	6	1	0626450	0626122
30	3.26	0.1285	20	62	36	6	1	0042267	—
	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	0.1360	20	62	36	6	1	0042274	—
	3.50	0.1378	20	62	36	6	1	0615355	0614914
28	3.57	0.1406	20	62	36	6	1	0042281	—
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	0.1440	20	62	36	6	1	0042298	—
	3.70	0.1457	20	62	36	6	1	0626474	0626146
26	3.73	0.1470	24	66	36	6	1	0042304	—
25	3.80	0.1495	24	66	36	6	1	0626498	—
24	3.86	0.1520	24	66	36	6	1	0042328	—
	3.90	0.1535	24	66	36	6	1	0626504	0626160
23	3.91	0.1540	24	66	36	6	1	0042335	—
5/32	3.97	0.1563	24	66	36	6	1	0625163	0624753
22	3.99	0.1570	24	66	36	6	1	0042342	—
	4.00	0.1575	24	66	36	6	1	0615362	0614921
21	4.04	0.1590	24	66	36	6	1	0042359	—
	4.05	0.1594	24	66	36	6	1	—	0626177
20	4.09	0.1610	24	66	36	6	1	0042366	—
	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	0.1660	24	66	36	6	1	0042373	—
	4.30	0.1693	24	66	36	6	1	0615386	0614945
18	4.31	0.1695	24	66	36	6	1	0042380	—
11/64	4.37	0.1719	24	66	36	6	1	0624876	0624463
17	4.39	0.1730	24	66	36	6	1	0042397	—
	4.40	0.1732	24	66	36	6	1	0135013	0134832

MPX SOLID CARBIDE DRILL



d ₁ Ø "/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₅ mm	Pack Qty	R458	R457
	4.50	0.1772	24	66	36	6	1	0615393	0614952
16	4.50	0.1770	24	66	36	6	1	0042403	—
15	4.57	0.1800	24	66	36	6	1	0042410	—
	4.60	0.1811	24	66	36	6	1	0626528	0626191
14	4.62	0.1820	24	66	36	6	1	0042427	—
13	4.70	0.1850	24	66	36	6	1	0135020	—
3/16	4.76	0.1875	28	66	36	6	1	0625033	0624623
	4.80	0.1890	28	66	36	6	1	0135037	0134849
12	4.80	0.1890	28	66	36	6	1	0042441	—
11	4.85	0.1910	28	66	36	6	1	0042458	—
	4.90	0.1929	28	66	36	6	1	0135044	0622070
10	4.92	0.1935	28	66	36	6	1	0042465	—
9	4.98	0.1960	28	66	36	6	1	0042472	—
	5.00	0.1969	28	66	36	6	1	0615409	0614969
	5.05	0.1988	28	66	36	6	1	—	0626214
8	5.06	0.1990	28	66	36	6	1	0042489	—
	5.10	0.2008	28	66	36	6	1	0615416	0614976
7	5.11	0.2010	28	66	36	6	1	0042496	—
13/64	5.16	0.2031	28	66	36	6	1	0624890	0624487
6	5.18	0.2040	28	66	36	6	1	0042502	—
	5.20	0.2047	28	66	36	6	1	0135051	0134856
5	5.22	0.2055	28	66	36	6	1	0042519	—
4	5.31	0.2090	28	66	36	6	1	0042526	—
3	5.41	0.2130	28	66	36	6	1	0042533	—
	5.50	0.2165	28	66	36	6	1	0615423	0614983
7/32	5.56	0.2188	28	66	36	6	1	0625194	0624784
	5.60	0.2205	28	66	36	6	1	0626535	0626221
2	5.61	0.2210	28	66	36	6	1	0042540	—
	5.70	0.2244	28	66	36	6	1	0626542	0626238
1	5.79	0.2280	28	66	36	6	1	0042557	—
	5.80	0.2283	28	66	36	6	1	0626559	0626245
15/64	5.95	0.2344	28	66	36	6	1	0624913	0624500
	6.00	0.2362	28	66	36	6	1	0615430	0614990
	6.05	0.2382	34	79	36	8	1	—	0626252
	6.10	0.2402	34	79	36	8	1	0626566	0626269
	6.20	0.2441	34	79	36	8	1	0135068	0134863
	6.30	0.2480	34	79	36	8	1	0626573	0626276
1/4	6.35	0.2500	34	79	36	8	1	0624838	0624425
	6.40	0.2520	34	79	36	8	1	0135075	0134870
	6.50	0.2559	34	79	36	8	1	0615447	0615003
	6.60	0.2598	34	79	36	8	1	0626580	0626283
	6.70	0.2638	34	79	36	8	1	0135082	0134887
17/64	6.75	0.2656	34	79	36	8	1	0624937	0624524
	6.80	0.2677	34	79	36	8	1	0615454	0615010
	6.90	0.2717	34	79	36	8	1	0615461	0615027
	7.00	0.2756	34	79	36	8	1	0615478	0615034
	7.10	0.2795	41	79	36	8	1	0626597	0626290
9/32	7.14	0.2813	41	79	36	8	1	0625217	0624807
	7.30	0.2874	41	79	36	8	1	0626603	0626306
	7.40	0.2913	41	79	36	8	1	0615485	0615041
	7.50	0.2953	41	79	36	8	1	0615492	0615058
19/64	7.54	0.2969	41	79	36	8	1	0624951	0624548
	7.60	0.2992	41	79	36	8	1	0626610	0626313
	7.70	0.3031	41	79	36	8	1	0135099	0134894
	7.80	0.3071	41	79	36	8	1	0626627	0626320
	7.90	0.3110	41	79	36	8	1	0135105	0134900
5/16	7.94	0.3125	41	79	36	8	1	0625156	0624746
	8.00	0.3150	41	79	36	8	1	0615508	0615065
	8.05	0.3169	47	89	40	10	1	—	0626337
	8.10	0.3189	47	89	40	10	1	0626634	0626689
	8.20	0.3228	47	89	40	10	1	0135112	0134917
21/64	8.33	0.3281	47	89	40	10	1	0624975	0624562
	8.40	0.3307	47	89	40	10	1	0135129	0134924
	8.50	0.3346	47	89	40	10	1	0615515	0615072
	8.60	0.3386	47	89	40	10	1	0615522	0615089
	8.70	0.3425	47	89	40	10	1	0615539	0615096



MPX SOLID CARBIDE DRILL

d ₁ Ø “/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	Pack Qty	R458	R457
11/32	8.73	0.3437	47	89	40	10	1	0624869	0624456
	8.80	0.3465	47	89	40	10	1	0626641	0626344
	8.90	0.3504	47	89	40	10	1	—	0134931
	9.00	0.3543	47	89	40	10	1	0615546	0615102
	9.10	0.3583	47	89	40	10	1	0626658	0626351
	9.13	0.3594	47	89	40	10	1	0624999	0624586
23/64	9.30	0.3661	47	89	40	10	1	0615553	0615119
	9.40	0.3701	47	89	40	10	1	0135136	0134948
	9.50	0.3740	47	89	40	10	1	0615560	0615126
3/8	9.52	0.3750	47	89	40	10	1	0625057	0624647
	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
	9.90	0.3898	47	89	40	10	1	0135150	0134955
25/64	9.92	0.3906	47	89	40	10	1	0625002	0624593
	10.00	0.3937	47	89	40	10	1	0615133	0614693
	10.05	0.3957	55	102	45	12	1	—	0625958
	10.10	0.3976	55	102	45	12	1	0626382	0625965
	10.20	0.4016	55	102	45	12	1	0615140	0614709
	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
	10.50	0.4134	55	102	45	12	1	0615171	0614730
	10.60	0.4173	55	102	45	12	1	0626399	0625972
27/64	10.72	0.4219	55	102	45	12	1	0625019	0624609
	10.80	0.4252	55	102	45	12	1	0042694	—
	11.00	0.4331	55	102	45	12	1	0615188	0614747
7/16	11.11	0.4375	55	102	45	12	1	0625187	0624777
	11.20	0.4409	55	102	45	12	1	0615195	0614754
	11.40	0.4488	55	102	45	12	1	0135167	0134962
	11.50	0.4528	55	102	45	12	1	0615201	0614761
	11.51	0.4531	55	102	45	12	1	0625026	0624616
29/64	11.60	0.4567	55	102	45	12	1	0135174	0134979
	11.80	0.4646	55	102	45	12	1	0626405	0625989
	11.91	0.4688	55	102	45	12	1	0624906	0624494
15/32	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
	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
1/2	12.70	0.5000	60	107	45	14	1	0626429	0626016
	12.70	0.5000	60	107	45	14	1	0624821	0624418
	12.80	0.5039	60	107	45	14	1	0135181	0134986
33/64	13.00	0.5118	60	107	45	14	1	0615249	0614808
	13.10	0.5156	60	107	45	14	1	0625071	0624661
17/32	13.49	0.5313	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	0.5625	65	115	48	16	1	0625200	0624791
	14.50	0.5709	65	115	48	16	1	0615287	0614846
37/64	14.68	0.5781	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
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	0.6250	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

MPX SOLID CARBIDE DRILL



d_1 \emptyset "/Nr.	d_1 $\emptyset m_7$ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 $\emptyset h_5$ mm	Pack Qty	R458	R457
	16.50	0.6496	73	123	48	18	1	0135211	0626030
21/32	16.67	0.6562	73	123	48	18	1	0624968	0624555
	17.00	0.6693	73	123	48	18	1	0135228	0626047
43/64	17.07	0.6719	73	123	48	18	1	0625125	0624715
	17.46	0.6875	73	123	48	18	1	0624852	0624449
11/16	17.50	0.6890	73	123	48	18	1	0135235	0626054
	17.80	0.7008	73	123	48	18	1	0135273	—
	17.86	0.7031	73	123	48	18	1	0625132	0624722
45/64	18.00	0.7087	73	123	48	18	1	0135280	0626061
	18.26	0.7188	79	131	50	20	1	0624982	0624579
23/32	18.50	0.7283	79	131	50	20	1	0135297	0626078
	18.65	0.7344	79	131	50	20	1	0625149	0624739
47/64	18.80	0.7402	79	131	50	20	1	—	0622056
	19.00	0.7480	79	131	50	20	1	0135327	0626085
	19.05	0.7500	79	131	50	20	1	0625040	0624630
3/4	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 ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	Pack Qty	R510
1/8	3.00	0.1181	33	61	1	0115657
	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
3/16	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
	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
1/4	5.60	0.2205	57	93	1	0216811
	5.70	0.2244	57	93	1	0216828
	6.00	0.2362	57	93	1	0115787
	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
1/2	7.40	0.2913	69	109	1	0115848
	7.50	0.2953	69	109	1	0115855
	7.80	0.3071	75	117	1	0345269

CDX SOLID CARBIDE DRILL



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
	7.90	0.3110	75	117	1	0345276
5/16	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
	9.50	0.3740	81	125	1	0115916
3/8	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
	12.00	0.4724	101	151	1	0115619
1/2	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

Multi-Application, Standard Length, Reinforced Shank

R454 Self centering Split Point for enhanced penetration rate. TiAlN-Top 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

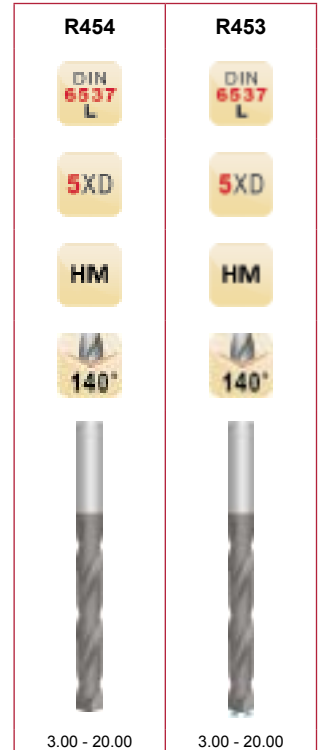
R453 Coolant through clears chips away from the cutting edge. Self centering Split Point for enhanced penetration rates. TiAlN-Top coating increases surface hardness, improves tool life at high RPM.

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



MP-X



d ₁ Ø Inch	d ₁ Ø _{m7} mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø _{h6} mm	Pack Qty	R454	R453
1/8	3.00	0.1181	28	66	36	6	1	0614433	0614051
	3.10	0.1220	28	66	36	6	1	0625712	0625385
	3.18	0.1250	28	66	36	6	1	0624029	0623619
	3.20	0.1260	28	66	36	6	1	0625729	0625392
	3.30	0.1299	28	66	36	6	1	0614440	0616147
	3.40	0.1339	28	66	36	6	1	0614457	0614068
9/64	3.50	0.1378	28	66	36	6	1	0614464	0614075
	3.57	0.1406	28	66	36	6	1	0624401	0623992
	3.60	0.1417	28	66	36	6	1	0625736	0625408
	3.70	0.1457	28	66	36	6	1	0625743	0625415
	3.80	0.1496	36	74	36	6	1	0625750	0625422
	3.90	0.1535	36	74	36	6	1	0625767	0628911
5/32	3.97	0.1563	36	74	36	6	1	0624340	0623930
	4.00	0.1575	36	74	36	6	1	0614471	0614082
	4.05	0.1594	36	74	36	6	1	—	0625439
	4.10	0.1614	36	74	36	6	1	0625774	0625446
	4.20	0.1654	36	74	36	6	1	0614488	0616154
	4.30	0.1693	36	74	36	6	1	0614495	0614099
11/64	4.37	0.1719	36	74	36	6	1	0624050	0623640
	4.40	0.1732	36	74	36	6	1	0134450	0134191
	4.50	0.1772	36	74	36	6	1	0614501	0614105
	4.60	0.1811	36	74	36	6	1	0625781	0625453
	4.70	0.1850	36	74	36	6	1	0625798	0625460
	4.76	0.1875	44	82	36	6	1	0624210	0623800
3/16	4.80	0.1890	44	82	36	6	1	0134467	0134207
	4.90	0.1929	44	82	36	6	1	0134474	0134214
	5.00	0.1969	44	82	36	6	1	0614518	0614112
	5.05	0.1988	44	82	36	6	1	—	0625477
	5.10	0.2008	44	82	36	6	1	0614525	0614129
	5.16	0.2031	44	82	36	6	1	0624074	0623664
13/64	5.20	0.2047	44	82	36	6	1	0134481	0134221
	5.50	0.2165	44	82	36	6	1	0614532	0614136
	5.56	0.2188	44	82	36	6	1	0624371	0623961

MPX SOLID CARBIDE DRILL



d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₅ mm	Pack Qty	R454	R453
	5.60	0.2205	44	82	36	6	1	0625804	0625484
	5.70	0.2244	44	82	36	6	1	0625811	0625491
	5.80	0.2283	44	82	36	6	1	0625828	0625507
15/64	5.95	0.2344	44	82	36	6	1	0624098	0623688
	6.00	0.2362	44	82	36	6	1	0614549	0614143
	6.05	0.2382	53	91	36	8	1	—	0625514
	6.10	0.2402	53	91	36	8	1	0625835	0625521
	6.20	0.2441	53	91	36	8	1	0134498	0134238
	6.30	0.2480	53	91	36	8	1	0625842	0625538
1/4	6.35	0.2500	53	91	36	8	1	0624012	0623602
	6.40	0.2520	53	91	36	8	1	0134504	0134245
	6.50	0.2559	53	91	36	8	1	0614556	0614150
	6.60	0.2598	53	91	36	8	1	0625859	0625545
	6.70	0.2638	53	91	36	8	1	0614563	0134252
17/64	6.75	0.2656	53	91	36	8	1	0624111	0623701
	6.80	0.2677	53	91	36	8	1	0614570	0616116
	6.90	0.2717	53	91	36	8	1	0614587	0614167
	7.00	0.2756	53	91	36	8	1	0614594	0614174
	7.10	0.2795	53	91	36	8	1	0625866	0625552
9/32	7.14	0.2813	53	91	36	8	1	0624395	0623985
	7.30	0.2874	53	91	36	8	1	0625873	0625569
	7.40	0.2913	53	91	36	8	1	0614600	0616161
	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
	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	0.3125	53	91	36	8	1	0624333	0623923
	8.00	0.3150	53	91	36	8	1	0614624	0614198
	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
21/64	8.33	0.3281	61	103	40	10	1	0624159	0623749
	8.40	0.3307	61	103	40	10	1	0134542	0134337
	8.50	0.3346	61	103	40	10	1	0614631	0614204
	8.60	0.3386	61	103	40	10	1	0614648	0616178
	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
	8.90	0.3504	61	103	40	10	1	0134559	0134344
	9.00	0.3543	61	103	40	10	1	0614662	0614228
	9.10	0.3583	61	103	40	10	1	0625927	0625620
23/64	9.13	0.3594	61	103	40	10	1	0624173	0623763
	9.30	0.3661	61	103	40	10	1	0614679	0616123
	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	0.3750	61	103	40	10	1	0624234	0623824
	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
	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
	10.10	0.3976	70	118	45	12	1	0625651	0625248
	10.20	0.4016	70	118	45	12	1	0614259	0613887
	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
	10.50	0.4134	70	118	45	12	1	0614280	0613900
	10.60	0.4173	70	118	45	12	1	0625668	0625255
27/64	10.72	0.4219	70	118	45	12	1	0624197	0623787
	11.00	0.4331	70	118	45	12	1	0614297	0613917
7/16	11.11	0.4375	70	118	45	12	1	0624364	0623954
	11.20	0.4409	70	118	45	12	1	0614303	0613924
	11.40	0.4488	70	118	45	12	1	0134597	0134375



MPX SOLID CARBIDE DRILL

d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	Pack Qty	R454	R453
29/64	11.50	0.4528	70	118	45	12	1	0614310	0613931
	11.51	0.4531	70	118	45	12	1	0624203	0623794
	11.60	0.4567	70	118	45	12	1	0134603	0134382
15/32	11.80	0.4646	70	118	45	12	1	0625675	0625262
	11.91	0.4688	70	118	45	12	1	0624081	0623671
	12.00	0.4724	70	118	45	12	1	0614327	0613948
	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
	12.70	0.5000	76	124	45	14	1	0625699	0625286
1/2	12.70	0.5000	76	124	45	14	1	0624005	0623596
	12.80	0.5039	76	124	45	14	1	0134610	0134399
	13.00	0.5118	76	124	45	14	1	0614358	0613979
33/64	13.10	0.5156	76	124	45	14	1	0624258	0623848
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	0.5625	82	133	48	16	1	0624388	0623978
	14.50	0.5709	82	133	48	16	1	0614396	0614013
37/64	14.68	0.5781	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
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	0.6250	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	0.6719	91	143	48	18	1	0624302	0623893
11/16	17.46	0.6875	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	0.7088	91	143	48	18	1	0134696	0625330
23/32	18.26	0.7188	99	143	48	20	1	—	0623756
23/32	18.26	0.7188	99	153	50	20	1	0624166	—
	18.50	0.7283	99	153	50	20	1	0134702	0625347
	18.65	0.7345	99	153	50	20	1	0624326	0623916
47/64	19.00	0.7480	99	153	50	20	1	0134719	0625354
	19.05	0.7500	99	153	50	20	1	0624227	0623817
3/4	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

MPX SOLID CARBIDE DRILL



Multi-Application, 8xD, Reinforced Shank

R459 Coolant through clears chips away from the cutting edge. Self centering Split Point for enhanced penetration rates. TiAlN-Top coating increases surface hardness, improves tool life at high RPM.

MP-X

- 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



3.00 - 16.00

d_1 Ø _{m7} Inch	d_1 Ø _{m7} mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø _{h6} 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	0.1250	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	0.1719	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	0.1875	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
7/32	5.56	0.2188	62	104	36	6	1	46719015



MPX SOLID CARBIDE DRILL

d ₁ Øm ₇ Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	Pack Qty	R459
	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	0.2344	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	0.2656	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	0.2813	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	0.3281	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	0.3750	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	0.4219	128	180	45	12	1	46719077
	10.80	0.4252	128	180	45	12	1	46719078
	11.00	0.4331	128	180	45	12	1	46719079
7/16	11.11	0.4375	128	180	45	12	1	46719080
	11.20	0.4409	128	180	45	12	1	46719081

MPX 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
	11.30	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	0.4688	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	0.5156	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	0.5625	172	227	48	16	1	46719100
	14.50	0.5709	172	227	48	16	1	46719101
37/64	14.68	0.5781	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	0.6250	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 Øh ₈ Inch	d ₁ Øh 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



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
	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

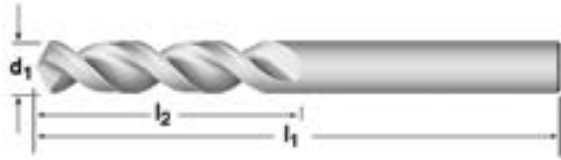
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2
 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2

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.

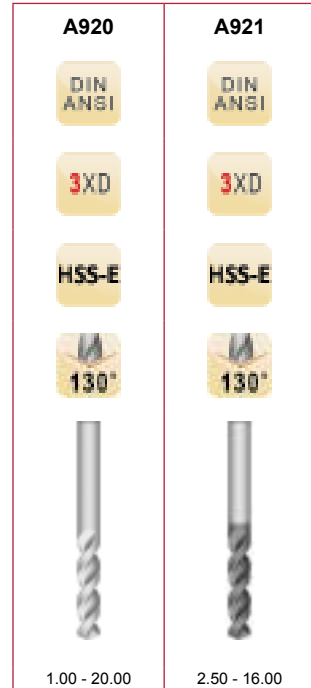
A921

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 ₈ Inch	d_1 Øh ₈ 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



PFX SCREW MACHINE DRILL

d ₁ Øh ₈ Inch	d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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 ₁ Øh ₈ Inch	d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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	—



PFX 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	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



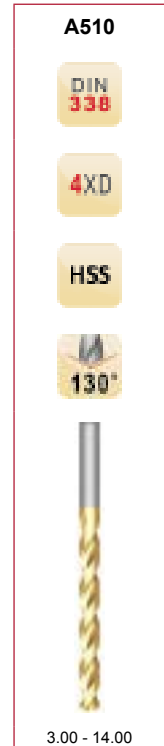
Multi-Application, Jobber Length

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 $\varnothing h_8$ Inch	d_1 $\varnothing h_8$ 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



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
	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



ADX STANDARD LENGTH DRILL

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

ADX

A553 Step shank (DIN 6535HA)

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

- 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



A553

5.00 - 20.00

d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ 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



PFX JOBBER LENGTH DRILL

Premium Cobalt Jobber Length - Parabolic Flute for Advanced Chip Removal

A900

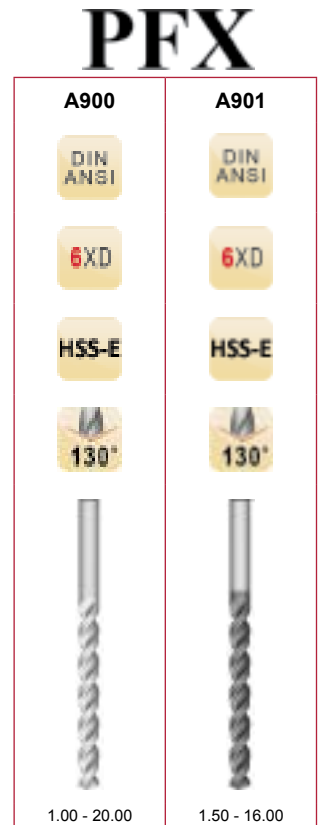
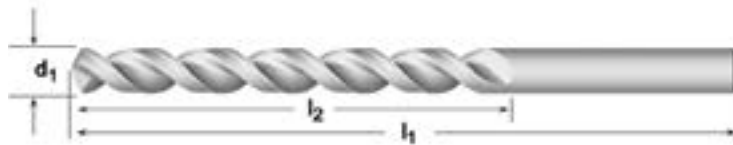
- 1.1
- 1.2
- 1.3
- 1.4
- 1.5
- 1.6
- 2.1
- 2.2
- 2.3
- 3.1
- 3.2
- 3.3
- 3.4
- 4.1
- 4.2
- 4.3
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- 5.2
- 5.3
- 6.1
- 6.2
- 6.3
- 6.4
- 7.1
- 7.2
- 7.3
- 7.4
- 8.1
- 8.2

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
- 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.



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 ₈ Inch	d_1 Øh ₈ 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



PFX 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	A900	A901
	8.70	0.3425	81	125	1	0047286	0048399
11/32	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
	9.10	0.3583	81	125	1	0047330	0048436
23/64	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
	9.50	0.3740	81	125	1	0047385	0048474
3/8	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
	9.90	0.3898	87	133	1	0047439	0048627
25/64	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	—
11/16	17.46	0.6875	143	194	1	0634448	—
	17.50	0.6890	130	191	1	0047743	—
45/64	17.86	0.7031	130	191	1	0634455	—
	18.00	0.7087	130	191	1	0047750	—
23/32	18.26	0.7187	130	191	1	0634462	—
	18.50	0.7283	135	198	1	0634479	—
47/64	18.65	0.7344	135	198	1	0634486	—
	19.00	0.7480	135	198	1	0047767	—
3/4	19.05	0.7500	135	198	1	0634493	—
49/64	19.45	0.7656	135	198	1	0634509	—
	19.50	0.7677	140	205	1	0634516	—
25/32	19.84	0.7812	140	205	1	0634523	—
	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.

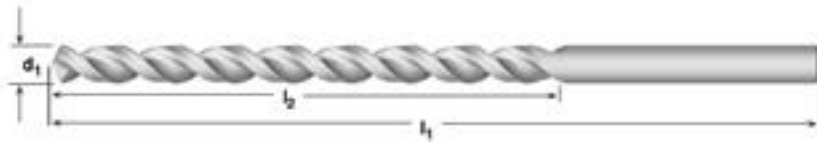
PFX

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.



d_1 Øh ₈ Inch	d_1 Øh ₈ 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



PFX TAPER LENGTH DRILL

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

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

A976

A977

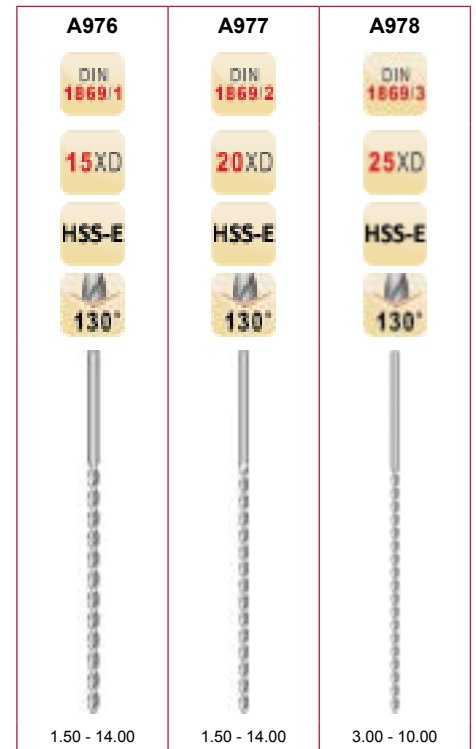
A978

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.

- 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



PFX



d_1 \varnothing_h Inch	d_1 \varnothing_h mm	d_1 decimal Inch	l_2 mm	l_1 mm	Pack Qty	A976	A977	A978
	1.50	0.0591	100	150	1	—	0347386 ¹⁾	—
	1.50	0.0591	75	115	1	0347362	—	—
1/16	1.59	0.0625	100	150	1	—	0347393 ¹⁾	—
	2.00	0.0787	110	160	1	—	0347409 ¹⁾	—
	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 ¹⁾	—
	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 ¹⁾
	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	—	—

¹⁾ Dormer Standard

PFX EXTRA LENGTH DRILL



d ₁ Øh ₈ Inch	d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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	—	—



PFX EXTRA 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	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 ¹⁾	—

JOBBER DRILL



General Purpose Jobber Length

* Sets Available on pgs. 197-200

R10P - Fractional Sizes

R15P - Letter Sizes

R18P - Wire Gauge Sizes

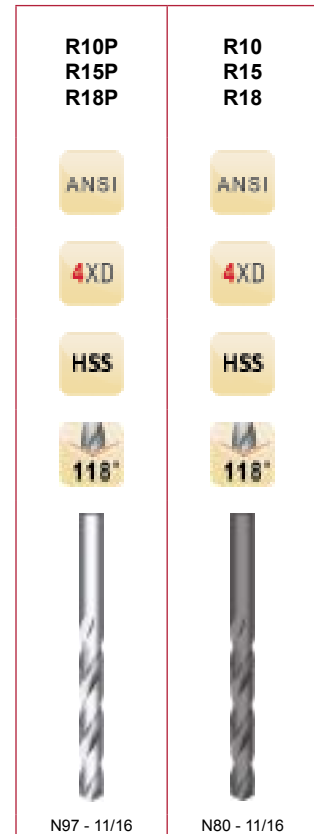
Bright Finish improves chip flow in soft or non-ferrous materials

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	R10P R15P R18P	R10 R15 R18
	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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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_1 Ø Inch	d_1 Ø Nr.	d_1 Ø letter	d_1 decimal Inch	l_2 Inch	l_1 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

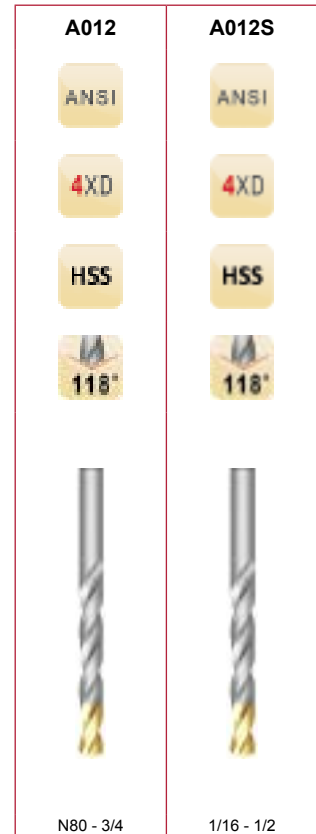
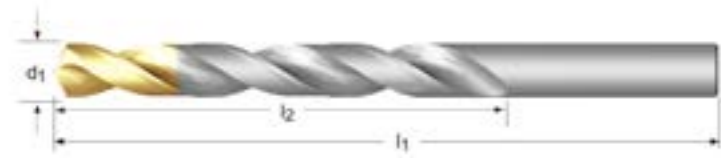
Low thrust design self centering Split Point for easier penetration.
TiN Coated Tip increases surface hardness and improves tool life.

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



JOBBER DRILL

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
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 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
	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	—



JOBBER DRILL

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
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
0.15 - 15.00	1.00 - 17.50	0.20 - 20.00	1.00 - 16.00	1.00 - 16.00

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
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	—	—

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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 Øh ₈ mm	d ₁ Øh ₈ "/Nr./letter	d ₁ decimal Inch	l ₂ mm	l ₁ 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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d ₁ Øh ₈ mm	d ₁ Øh 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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d ₁ Øh ₈ mm	d ₁ Øh ₈ "/Nr./letter	d ₁ decimal Inch	l ₂ mm	l ₁ 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	—	—

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d ₁ Øh ₈ mm	d ₁ Øh ₈ "/Nr./letter	d ₁ decimal Inch	l ₂ mm	l ₁ 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 ₁ Øh ₈ mm	d ₁ Øh ₈ "/Nr./letter	d ₁ decimal Inch	l ₂ mm	l ₁ 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	—	—	0002565	—	—
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

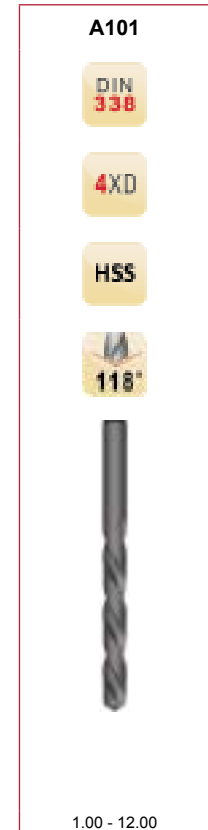
d ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	Pack Qty	L10
1/32	0.0313	1/2	1.3/8	12	010902
3/64	0.0469	3/4	1.3/4	12	010903
1/16	0.0625	7/8	1.7/8	12	010904
5/64	0.0781	1"	2"	12	010905
3/32	0.0938	1.1/4	2.1/4	12	010906
7/64	0.1094	1.1/2	2.5/8	12	010907
1/8	0.1250	1.5/8	2.3/4	12	010908
9/64	0.1406	1.3/4	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

JOBBER DRILL



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



d_1 $\varnothing h_8$ mm	d_1 decimal Inch	l_2 mm	l_1 mm	A101
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

d₁ Øh₈ mm	d₁ decimal Inch	l₂ mm	l₁ 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)

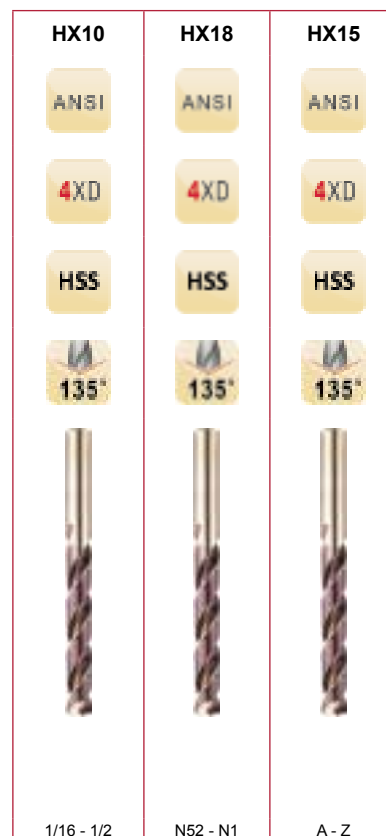
* HX10 set available on pg. 206

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 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
	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

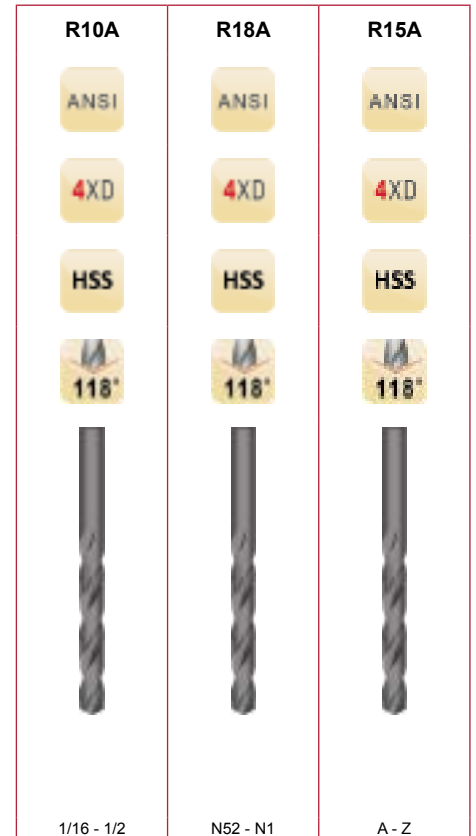
General Purpose Jobber Length (NAS 907 Type A)

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 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
	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 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
		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



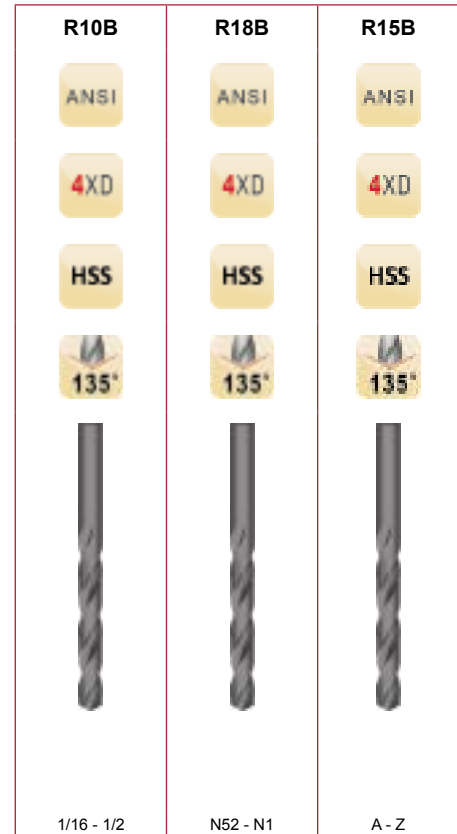
Heavy Duty Jobber Length (NAS 907 Type B)

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 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
	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	0.2374	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

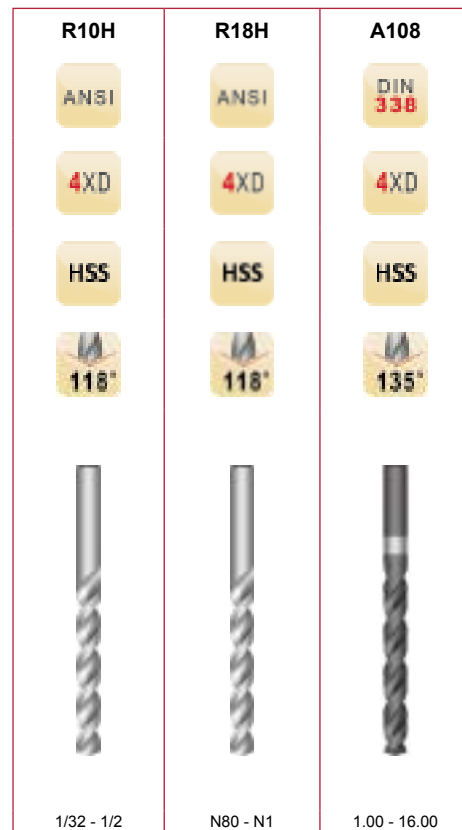
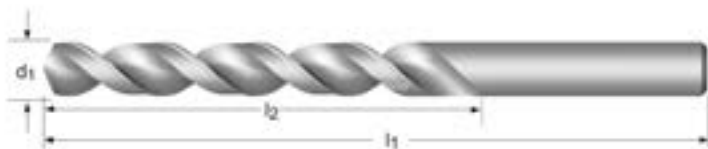
R10H - Fractional Sizes

R18H - Wire Gauge Sizes

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

A108 - 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 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
		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 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
	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 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
		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 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
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

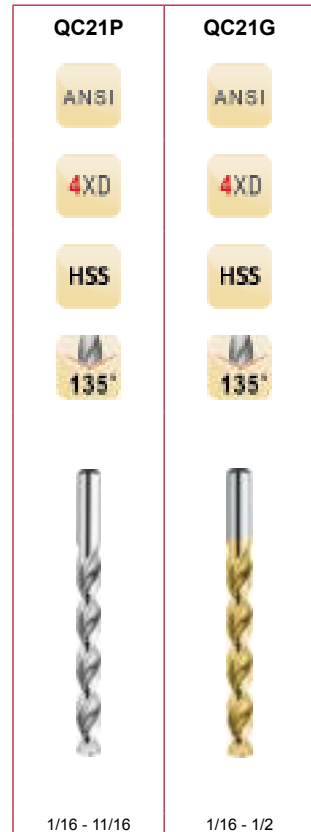
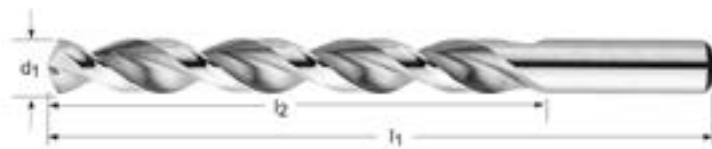


General Purpose Jobber Length Parabolic Flute

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 ₁ Ø "Nr./letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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	—



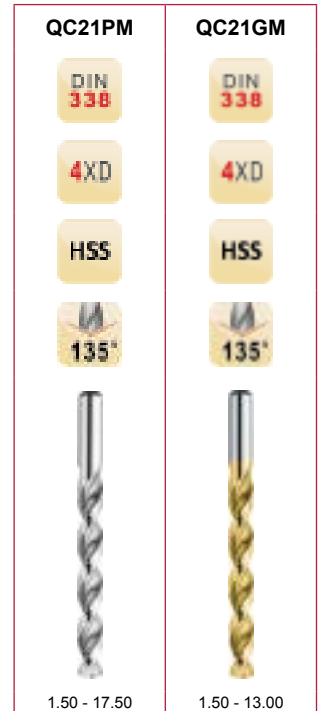
JOBBER DRILL

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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ Ø mm	d ₁ decimal Inch	l ₂ Inch	l ₂ mm	l ₁ Inch	l ₁ mm	Pack Qty	R10CO	R18CO	R15CO	2ACO
	80			0.0135	1/8		3/4		12	—	¹⁾	018380	—
	79			0.0145	1/8		3/4		12	—	¹⁾	018379	—
1/64				0.0156	3/16		3/4		12	010301	¹⁾	—	—
	78			0.0160	3/16		7/8		12	—	¹⁾	018378	—
	77			0.0180	3/16		7/8		12	—	¹⁾	018377	—
	76			0.0200	3/16		7/8		12	—	¹⁾	018376	—
	75			0.0210	1/4		1"		12	—	¹⁾	018375	—
	74			0.0225	1/4		1"		12	—	¹⁾	018374	—
	73			0.0240	5/16		1.1/8		12	—	¹⁾	018373	—
	72			0.0250	5/16		1.1/8		12	—	¹⁾	018372	—
	71			0.0260	3/8		1.1/4		12	—	¹⁾	018371	—
	70			0.0280	3/8		1.1/4		12	—	¹⁾	018370	—
	69			0.0292	1/2		1.3/8		12	—	¹⁾	018369	—
	68			0.0310	1/2		1.3/8		12	—	¹⁾	018368	—
1/32				0.0313	1/2		1.3/8		12	010302	¹⁾	—	—
	67			0.0320	1/2		1.3/8		12	—	¹⁾	018367	—
	66			0.0330	1/2		1.3/8		12	—	¹⁾	018366	—
	65			0.0350	5/8		1.1/2		12	—	¹⁾	018365	—
	64			0.0360	5/8		1.1/2		12	—	¹⁾	018364	—
	63			0.0370	5/8		1.1/2		12	—	¹⁾	018363	—
	62			0.0380	5/8		1.1/2		12	—	¹⁾	018362	—
	61			0.0390	11/16		1.5/8		12	—	¹⁾	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		—	—

¹⁾ No Split Point



COBALT JOBBER DRILL

d ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ Ø mm	d ₁ decimal Inch	l ₂ Inch	l ₂ mm	l ₁ Inch	l ₁ 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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ Ø mm	d ₁ decimal Inch	l ₂ Inch	l ₂ mm	l ₁ Inch	l ₁ 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	—	—
			3.70	0.1457		39		70	12	—	—	—	016437
	26			0.1470	1.7/8		3"		12	—	018326	—	—
				0.1476		39		70	12	—	—	—	016372
			3.80	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
			4.50	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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ Ø mm	d ₁ decimal Inch	l ₂ Inch	l ₂ mm	l ₁ Inch	l ₁ 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	—	—	—	016491	
				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		6	—	—	015323	—	
			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		6	—	—	—	016302	
			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	—	—	—	—	
				0.4134	3.7/8		5.1/4		6	—	—	—	016305	
				0.4134	3.7/8		5.1/4		6	—	—	—	—	
27/64				0.4219	3.15/16		5.3/8		6	010327	—	—	—	

COBALT JOBBER DRILL



d ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ Ø mm	d ₁ decimal Inch	l ₂ Inch	l ₂ mm	l ₁ Inch	l ₁ 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	—	—	—



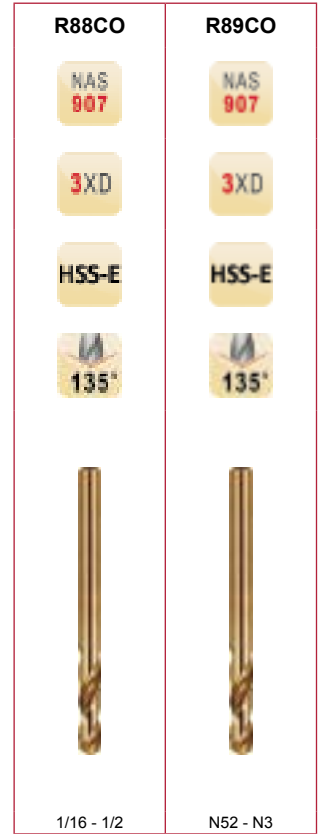
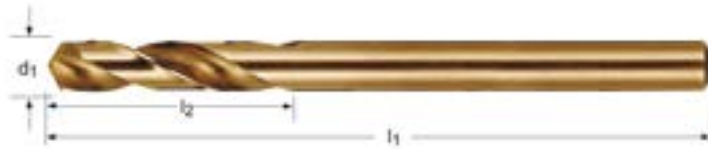
COBALT JOBBER DRILL

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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ decimal Inch	l ₂ Inch	l ₁ 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



- ¹⁾ Sizes 45/64 and larger are steam oxide
- ²⁾ 1" reduced shank
- ³⁾ 1-1/4" reduced shank
- ⁴⁾ 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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ¹⁾	—	—
23/32			0.7188	3"	4.3/4	1	040546 ¹⁾	—	—
47/64			0.7344	3.1/8	5"	1	040547 ¹⁾	—	—
3/4			0.7500	3.1/8	5"	1	040548 ¹⁾	—	—
49/64			0.7656	3.1/4	5.1/8	1	040549 ¹⁾	—	—
25/32			0.7813	3.1/4	5.1/8	1	040550 ¹⁾	—	—
51/64			0.7969	3.3/8	5.1/4	1	040551 ¹⁾	—	—
13/16			0.8125	3.3/8	5.1/4	1	040552 ¹⁾	—	—
53/64			0.8281	3.1/2	5.3/8	1	040553 ¹⁾	—	—
27/32			0.8438	3.1/2	5.3/8	1	040554 ¹⁾	—	—
55/64			0.8594	3.1/2	5.1/2	1	040555 ¹⁾	—	—
7/8			0.8750	3.1/2	5.1/2	1	040556 ¹⁾	—	—
57/64			0.8906	3.5/8	5.5/8	1	040557 ¹⁾	—	—
29/32			0.9063	3.5/8	5.5/8	1	040558 ¹⁾	—	—
59/64			0.9219	3.3/4	5.3/4	1	040559 ¹⁾	—	—
15/16			0.9375	3.3/4	5.3/4	1	040560 ¹⁾	—	—
61/64			0.9531	3.7/8	5.7/8	1	040561 ¹⁾	—	—
31/32			0.9688	3.7/8	5.7/8	1	040562 ¹⁾	—	—
63/64			0.9844	4"	6"	1	040563 ¹⁾	—	—
1"			1.0000	4"	6"	1	040600 ¹⁾	—	—
1.1/16			1.0625	4"	6.1/4	1	040604 ¹⁾²⁾	—	—
1.1/8			1.1250	4"	6.3/8	1	040608 ¹⁾²⁾	—	—
1.3/16			1.1875	4.1/4	6.5/8	1	040612 ¹⁾²⁾	—	—
1.1/4			1.2500	4.3/8	6.3/4	1	040616 ¹⁾²⁾	—	—
1.5/16			1.3125	4.3/8	7"	1	040620 ¹⁾³⁾	—	—
1.3/8			1.3750	4.1/2	7.1/8	1	040624 ¹⁾³⁾	—	—
1.7/16			1.4375	4.3/4	7.3/8	1	040628 ¹⁾³⁾	—	—
1.1/2			1.5000	4.7/8	7.1/2	1	040632 ¹⁾³⁾	—	—
1.9/16			1.5625	4.7/8	7.3/4	1	040636 ¹⁾⁴⁾	—	—
1.5/8			1.6250	4.7/8	7.3/4	1	040640 ¹⁾⁴⁾	—	—
1.3/4			1.7500	5.1/8	8"	1	040648 ¹⁾⁴⁾	—	—
1.13/16			1.8125	5.3/8	8.1/4	1	040652 ¹⁾⁴⁾	—	—
1.7/8			1.8750	5.3/8	8.1/4	1	040656 ¹⁾⁴⁾	—	—
1.15/16			1.9375	5.5/8	8.1/2	1	040660 ¹⁾⁴⁾	—	—
2"			2.0000	5.5/8	8.1/2	1	040700 ¹⁾⁴⁾	—	—

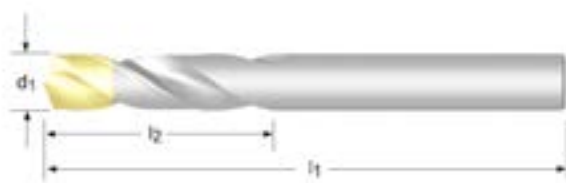
SCREW MACHINE DRILL



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 Ø _{h8} Inch	d_1 Ø _{h8} 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

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
	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.



R40C	R41C	R42C	A245
1/16 - 1/2	N60 - N1	A - Z	N40 - 29/64

* Outgoing product

d ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	Pack Qty	R40C	R41C	R42C	A245
	60		0.0400	1/2	1.3/8	12	—	041860 ¹⁾	—	—
	59		0.0410	1/2	1.3/8	12	—	041859 ¹⁾	—	—
	58		0.0420	1/2	1.3/8	12	—	041858 ¹⁾	—	—
	57		0.0430	1/2	1.3/8	12	—	041857 ¹⁾	—	—
	56		0.0465	1/2	1.3/8	12	—	041856 ¹⁾	—	—
	55		0.0520	5/8	1.5/8	12	—	041855 ¹⁾	—	—
	54		0.0550	5/8	1.5/8	12	—	041854 ¹⁾	—	—
	53		0.0595	5/8	1.5/8	12	—	041853 ¹⁾	—	—
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	—	—

¹⁾ Not Split Point



SCREW MACHINE 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	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	—



SCREW MACHINE 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	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

DIN
1897

2.5XD

HSS

135°



1.00 - 12.50



d ₁ Ø mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	Pack Qty	4ASM
1.00	0.0394	6	22	12	046100 ¹⁾
1.25	0.0492	8	30	12	046125 ¹⁾
1.30	0.0512	8	30	12	046130 ¹⁾
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

¹⁾ 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

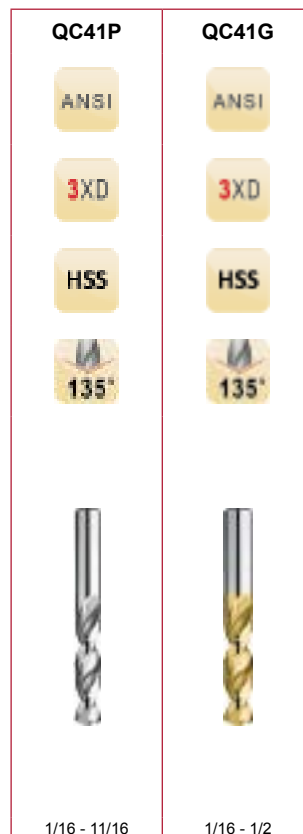


General Purpose Screw Machine Length Parabolic Flute

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.



1/16 - 11/16

1/16 - 1/2

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 ₁ Ø "Nr.	d ₁ decimal Inch	l ₂ Inch	l ₁ 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

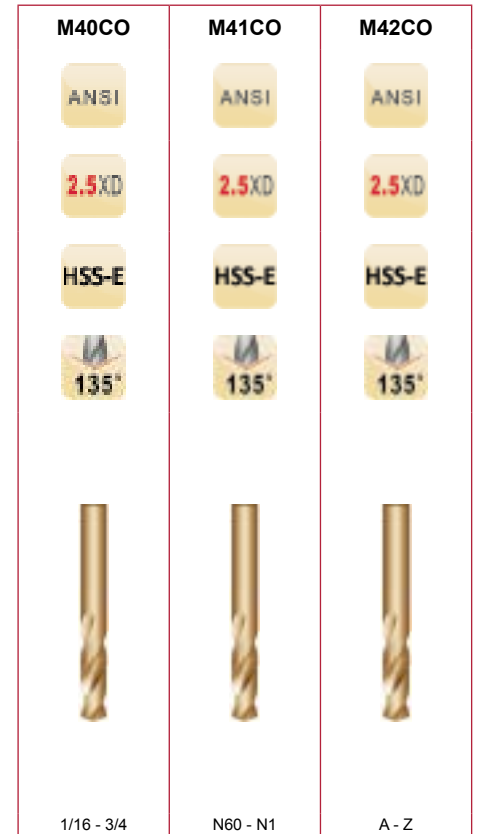
Heavy Duty Screw Machine Length

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 ¹⁾	—
	59		0.0410	1/2	1.3/8	12	—	041359 ¹⁾	—
	58		0.0420	1/2	1.3/8	12	—	041358 ¹⁾	—
	57		0.0430	1/2	1.3/8	12	—	041357 ¹⁾	—
	56		0.0465	1/2	1.3/8	12	—	041356 ¹⁾	—
	55		0.0520	5/8	1.5/8	12	—	041355 ¹⁾	—
	54		0.0550	5/8	1.5/8	12	—	041354 ¹⁾	—
	53		0.0595	5/8	1.5/8	12	—	041353 ¹⁾	—
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	—

¹⁾ Not Split Point

COBALT SCREW MACHINE 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	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 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
		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

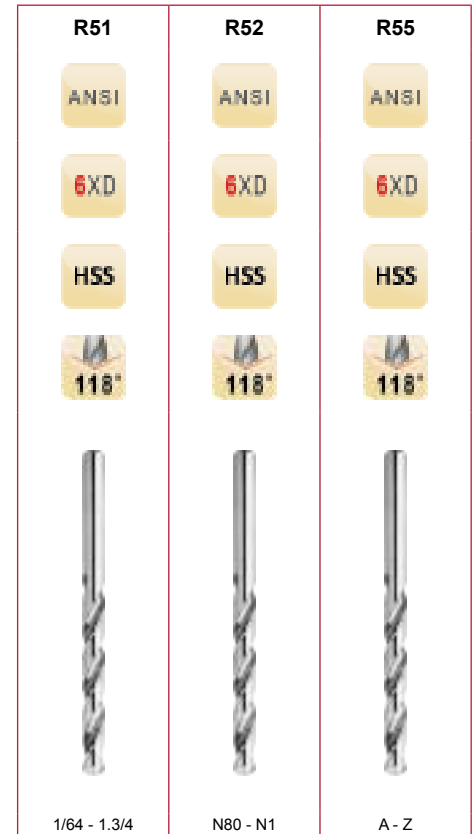
R51 - Fractional Sizes

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 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
	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 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
		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	¹⁾	—
23/32			0.7188	5.5/8	9.1/2	1	051046	¹⁾	—
47/64			0.7344	5.7/8	9.3/4	1	051047	¹⁾	—
3/4			0.7500	5.7/8	9.3/4	1	051048	¹⁾	—
49/64			0.7656	6"	9.7/8	1	051049	¹⁾	—
25/32			0.7813	6"	9.7/8	1	051050	¹⁾	—
51/64			0.7969	6.1/8	10"	1	051051	¹⁾	—
13/16			0.8125	6.1/8	10"	1	051052	¹⁾	—
53/64			0.8281	6.1/8	10"	1	051053	¹⁾	—
27/32			0.8438	6.1/8	10"	1	051054	¹⁾	—
55/64			0.8594	6.1/8	10"	1	051055	¹⁾	—
7/8			0.8750	6.1/8	10"	1	051056	¹⁾	—
57/64			0.8906	6.1/8	10"	1	051057	¹⁾	—

¹⁾ steam oxide

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

¹⁾ 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 ₁ Ø mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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 ₁ Ø mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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 ¹⁾
18.50	0.7283	162	247	1	057185 ¹⁾
19.00	0.7480	162	247	1	057190 ¹⁾
19.50	0.7677	166	254	1	057195 ¹⁾
20.00	0.7874	166	254	1	057200 ¹⁾
20.50	0.8071	171	261	1	057205 ¹⁾
21.00	0.8268	171	261	1	057210 ¹⁾
21.50	0.8465	176	268	1	057215 ¹⁾
22.00	0.8661	176	268	1	057220 ¹⁾
22.50	0.8858	180	275	1	057225 ¹⁾
23.00	0.9055	180	275	1	057230 ¹⁾
23.50	0.9252	180	275	1	057235 ¹⁾
24.00	0.9449	185	282	1	057240 ¹⁾
24.50	0.9646	185	282	1	057245 ¹⁾
25.00	0.9843	185	282	1	057250 ¹⁾
25.50	1.0039	190	290	1	057255 ¹⁾
26.00	1.0236	190	290	1	057260 ¹⁾
26.50	1.0433	190	290	1	057265 ¹⁾
27.00	1.0630	195	298	1	057270 ¹⁾
28.00	1.1024	195	298	1	057280 ¹⁾
28.50	1.1220	201	307	1	057285 ¹⁾
29.00	1.1417	201	307	1	057290 ¹⁾
29.50	1.1614	201	307	1	057295 ¹⁾
30.00	1.1811	201	307	1	057300 ¹⁾
30.50	1.2008	207	316	1	057305 ¹⁾
31.00	1.2205	207	316	1	057310 ¹⁾

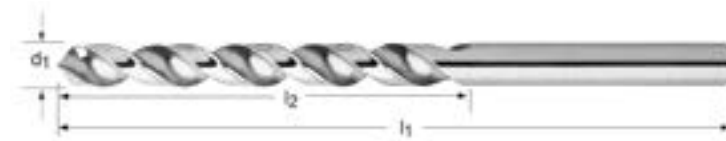
¹⁾ steam oxide



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

ANSI

6XD

HSS

118°



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

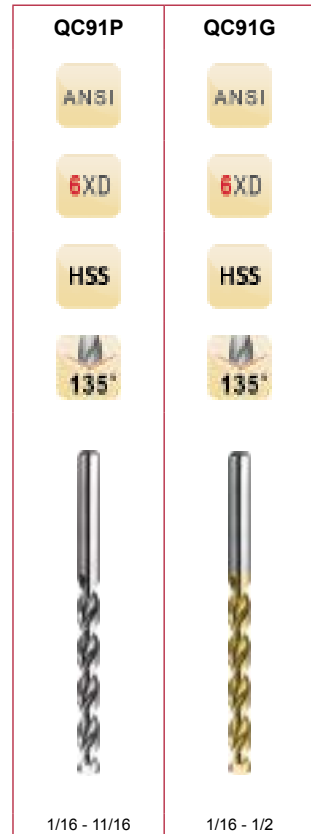


General Purpose Taper Length Parabolic Flute

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 ₁ Ø "/Nr.	d ₁ decimal Inch	l ₂ Inch	l ₁ 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

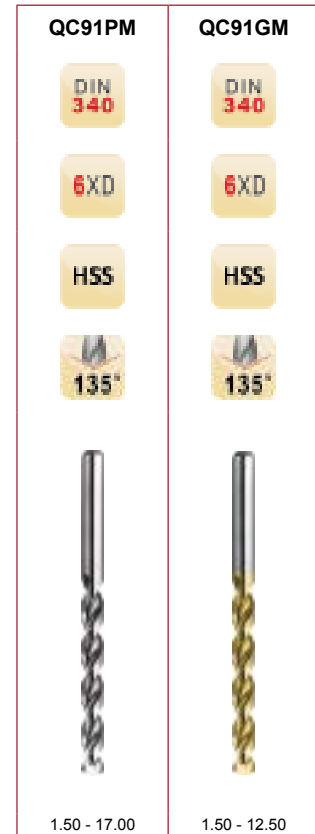


General Purpose Taper Length Parabolic Flute, Metric

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	—



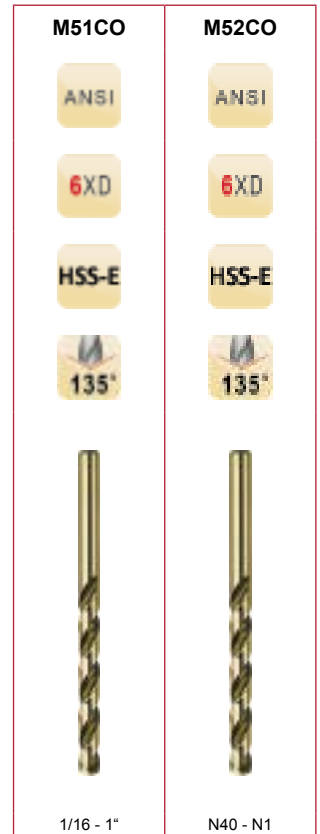
COBALT TAPER LENGTH DRILL

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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ decimal Inch	l ₂ Inch	l ₁ 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	¹⁾ —
17/32		0.5313	4.3/4	8"	1	051334	¹⁾ —
35/64		0.5469	4.7/8	8.1/4	1	051335	¹⁾ —
9/16		0.5625	4.7/8	8.1/4	1	051336	¹⁾ —
37/64		0.5781	4.7/8	8.3/4	1	051337	¹⁾ —
19/32		0.5937	4.7/8	8.3/4	1	051338	¹⁾ —
39/64		0.6094	4.7/8	8.3/4	1	051339	¹⁾ —
5/8		0.6250	4.7/8	8.3/4	1	051340	¹⁾ —
41/64		0.6406	5.1/8	9"	1	051341	¹⁾ —
21/32		0.6563	5.1/8	9"	1	051342	¹⁾ —
43/64		0.6719	5.3/8	9.1/4	1	051343	¹⁾ —
11/16		0.6875	5.3/8	9.1/4	1	051344	¹⁾ —
45/64		0.7031	5.5/8	9.1/2	1	051345	¹⁾ —
23/32		0.7188	5.5/8	9.1/2	1	051346	¹⁾ —
47/64		0.7344	5.7/8	9.3/4	1	051347	¹⁾ —
3/4		0.7500	5.7/8	9.3/4	1	051348	¹⁾ —
49/64		0.7656	6"	9.7/8	1	051349	¹⁾ —
25/32		0.7813	6"	9.7/8	1	051350	¹⁾ —
51/64		0.7969	6.1/8	10"	1	051351	¹⁾ —
13/16		0.8125	6.1/8	10"	1	051352	¹⁾ —
53/64		0.8281	6.1/8	10"	1	051353	¹⁾ —
27/32		0.8438	6.1/8	10"	1	051354	¹⁾ —
55/64		0.8594	6.1/8	10"	1	051355	¹⁾ —
7/8		0.8750	6.1/8	10"	1	051356	¹⁾ —
57/64		0.8906	6.1/8	10"	1	051357	¹⁾ —
29/32		0.9063	6.1/8	10"	1	051358	¹⁾ —
59/64		0.9219	6.1/8	10.3/4	1	051359	¹⁾ —
15/16		0.9375	6.1/8	10.3/4	1	051360	¹⁾ —
61/64		0.9531	6.3/8	11"	1	051361	¹⁾ —
31/32		0.9688	6.3/8	11"	1	051362	¹⁾ —
63/64		0.9844	6.3/8	11"	1	051363	¹⁾ —
1"		1.0000	6.3/8	11"	1	051364	¹⁾ —

¹⁾ Notched Point



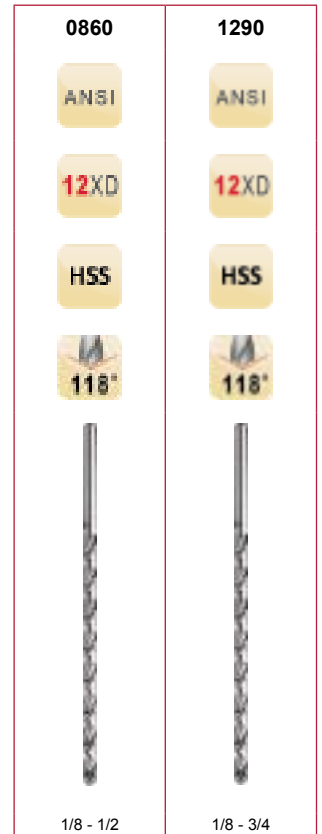
EXTRA LENGTH DRILL

General Purpose Extra Length

0860 8" Overall length

1290 12" Overall length

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



d₁ Ø	d₁ decimal	l₂	l₁	Pack Qty	0860	1290
Inch	Inch	Inch	Inch			
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 ¹⁾
17/32	0.5313	9"	12"	1	—	059634 ¹⁾
35/64	0.5469	9"	12"	1	—	059635 ¹⁾
9/16	0.5625	9"	12"	1	—	059636 ¹⁾
37/64	0.5781	9"	12"	1	—	059637 ¹⁾
19/32	0.5937	9"	12"	1	—	059638 ¹⁾
39/64	0.6094	9"	12"	1	—	059639 ¹⁾
5/8	0.6250	9"	12"	1	—	059640 ¹⁾
21/32	0.6563	9"	12"	1	—	059642 ¹⁾
11/16	0.6875	9"	12"	1	—	059644 ¹⁾
23/32	0.7188	9"	12"	1	—	059646 ¹⁾
3/4	0.7500	9"	12"	1	—	059648 ¹⁾

1) 33/64 and larger are steam oxide

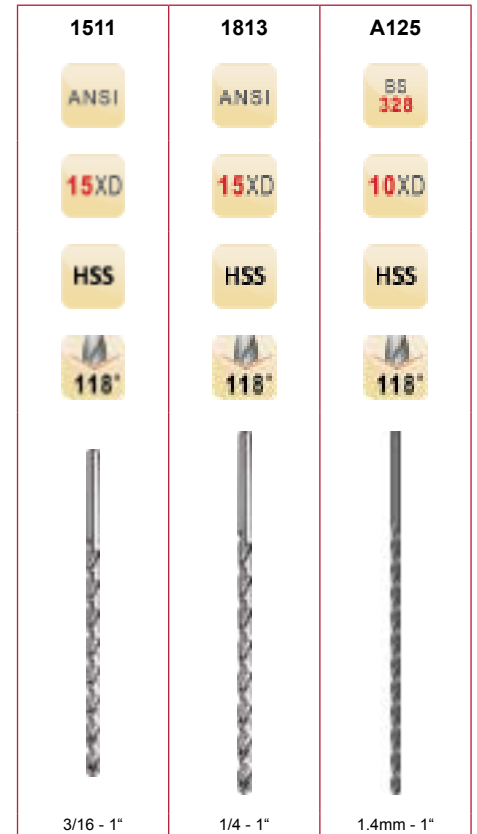
General Purpose Extra Length

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



d ₁ Ø Inch	d ₁ decimal Inch	d ₁ Øh ₈ mm	l ₂ Inch	l ₁ Inch	l ₂ mm	l ₁ 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



EXTRA LENGTH DRILL



d ₁ Ø Inch	d ₁ decimal Inch	d ₁ Øh ₈ mm	l ₂ Inch	l ₁ Inch	l ₂ mm	l ₁ 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



EXTRA LENGTH DRILL



d ₁ Ø Inch	d ₁ decimal Inch	d ₁ Øh ₈ mm	l ₂ Inch	l ₁ Inch	l ₂ mm	l ₁ 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



EXTRA LENGTH DRILL



d ₁ Ø Inch	d ₁ decimal Inch	d ₁ Øh ₈ mm	l ₂ Inch	l ₁ Inch	l ₂ mm	l ₁ 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	—	—



EXTRA LENGTH DRILL



d_1 Ø Inch	d_1 decimal Inch	d_1 Ø _{h₈} 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ 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

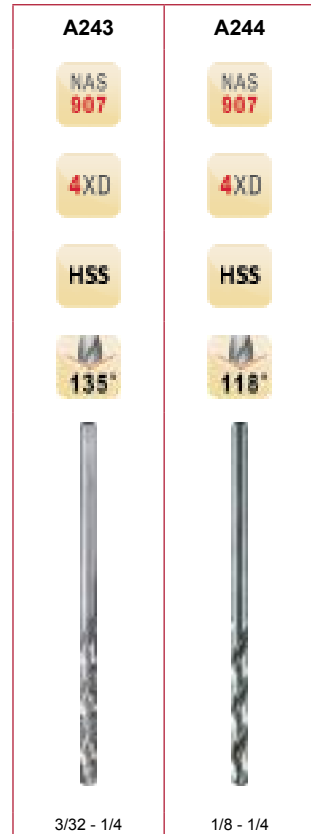
d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	Pack Qty	QC0860P	QC1290P
3/8	0.3750	9"	12"	1	—	060324
25/64	0.3906	6"	8"	1	055625	—
25/64	0.3906	9"	12"	1	—	060325
13/32	0.4063	6"	8"	1	055626	—
13/32	0.4063	9"	12"	1	—	060326
27/64	0.4219	6"	8"	1	055627	—
27/64	0.4219	9"	12"	1	—	060327
7/16	0.4375	6"	8"	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 Type B)

A243 Low thrust design self centering 135° Split Point for easier penetration. Bright Finish improves chip flow in soft or non-ferrous materials.
A244



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_1 Ø Inch	d_1 Ø Nr.	d_1 Ø letter	d_1 decimal Inch	l_2 Inch	l_1 Inch	Pack Qty	500-6	501-6	502-6
	60		0.0400	11/16	6"	12	—	058160 ¹⁾	—
	59		0.0410	11/16	6"	12	—	058159 ¹⁾	—
	58		0.0420	11/16	6"	12	—	058158 ¹⁾	—
	57		0.0430	3/4	6"	12	—	058157 ¹⁾	—
	56		0.0465	3/4	6"	12	—	058156 ¹⁾	—
3/64			0.0469	3/4	6"	12	058003	—	—
	55		0.0520	7/8	6"	12	—	058155 ¹⁾	—
	54		0.0550	7/8	6"	12	—	058154 ¹⁾	—
	53		0.0595	7/8	6"	12	—	058153 ¹⁾	—
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	—

¹⁾ Not Split Point

AIRCRAFT EXTENSION 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	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 ₁ Ø Inch	d ₁ Ø Nr.	d ₁ Ø letter	d ₁ decimal Inch	l ₂ Inch	l ₁ 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



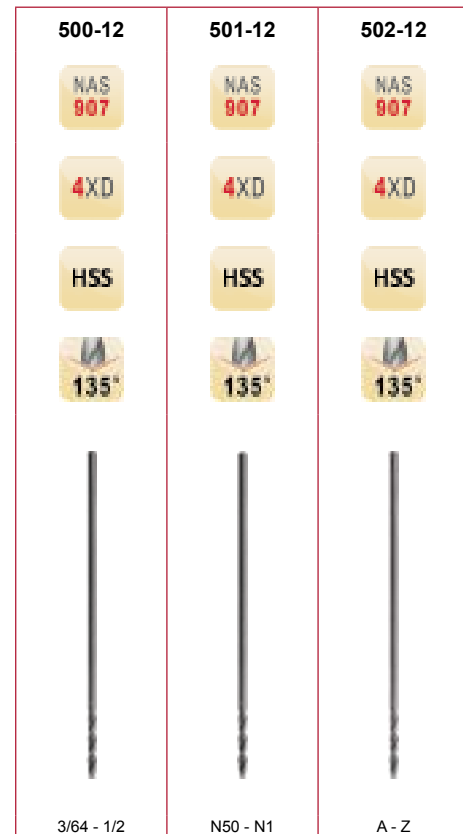
Aircraft Extension (NAS 907 Type B)

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 ¹⁾	—	—
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	—

¹⁾ Not Split Point



AIRCRAFT EXTENSION 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	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	—
	13		0.1850	2.5/16	12"	12	—	059113	—
3/16			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	—
		A	0.2340	2.5/8	12"	6	—	—	059201
15/64			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	—	—
	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	—	—	—
	30	0.1285	1.5/8	12"	12	—	—	—	052830



AIRCRAFT EXTENSION DRILL

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
	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	d_1 decimal	l_2	l_1	MTS	Pack Qty	209	S209
Inch	Inch	Inch	Inch				
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 ₁ Ø	d ₁ decimal	l ₂	l ₁	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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	MTS	Pack Qty	209	S209
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.



d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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 ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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



TAPER SHANK DRILL



d ₁ Øh ₈ mm	d ₁ decimal Inch	l ₂ mm	l ₁ 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



8.00 - 50.00



d_1 Øh ₈ Inch	d_1 Øh ₈ 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



TAPER SHANK DRILL

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	3	1	0419670
	23.00	0.9055	270	405	3	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 ¹⁾
	25.50	1.0039	290	440	3	1	0419717 ¹⁾
	26.00	1.0236	290	440	3	1	0418253 ¹⁾
	26.50	1.0433	290	440	3	1	0419724 ¹⁾
	27.00	1.0630	305	460	3	1	0418260 ¹⁾
	28.00	1.1024	305	460	3	1	0418277 ¹⁾
	29.00	1.1417	305	460	3	1	0419731 ¹⁾
	30.00	1.1811	305	460	3	1	0418314 ¹⁾
1.1/4	31.75	1.2500	320	480	3	1	0418048 ¹⁾
	31.00	1.2205	320	480	3	1	0419748 ¹⁾
	32.00	1.2598	320	505	4	1	0419755 ¹⁾
	33.00	1.2992	320	505	4	1	0422564 ¹⁾
	34.00	1.3386	340	530	4	1	0419762 ¹⁾
	35.00	1.3780	340	530	4	1	0419779 ¹⁾
	36.00	1.4173	340	530	4	1	0419786 ¹⁾
	37.00	1.4567	340	530	4	1	0419793 ¹⁾
	38.00	1.4961	360	555	4	1	0419809 ¹⁾
1.1/2	38.10	1.5000	360	555	4	1	0419540 ¹⁾
	39.00	1.5354	360	555	4	1	0419816 ¹⁾
	40.00	1.5748	360	555	4	1	0419823 ¹⁾
	41.00	1.6142	360	555	4	1	0419830 ¹⁾
	42.00	1.6535	360	555	4	1	0419847 ¹⁾
1.3/4	44.45	1.7500	385	585	4	1	0419557 ¹⁾
	45.00	1.7717	385	585	4	1	0419854 ¹⁾
	48.00	1.8898	405	605	4	1	0419861 ¹⁾
	50.00	1.9685	405	605	4	1	0419878 ¹⁾

¹⁾ < 10xD

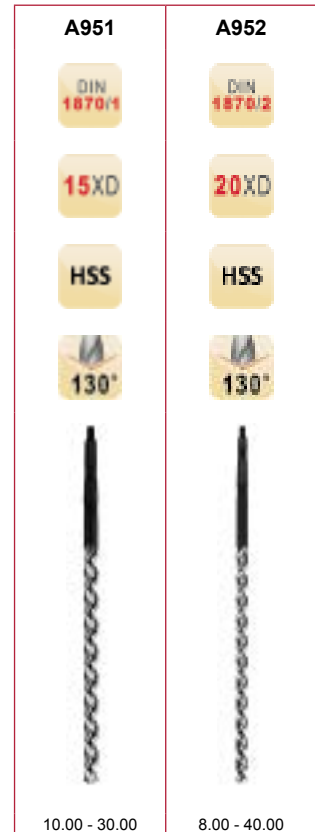
TAPER SHANK DRILL



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 ¹⁾	—
14.50	0.5709	275	425	2	1	—	0419960 ²⁾
15.00	0.5906	220	340	2	1	0418505 ¹⁾	—
15.00	0.5906	275	425	2	1	—	0419977 ²⁾
15.50	0.6102	230	355	2	1	0418512 ¹⁾	—
15.50	0.6102	295	445	2	1	—	0419984 ²⁾
16.00	0.6299	230	355	2	1	0418529 ¹⁾	—
16.00	0.6299	295	445	2	1	—	0420195 ²⁾
16.50	0.6496	230	355	2	1	0418536 ¹⁾	—
16.50	0.6496	295	445	2	1	—	0419991 ²⁾
17.00	0.6693	230	355	2	1	0418543 ¹⁾	—
17.00	0.6693	295	445	2	1	—	0420003 ²⁾

¹⁾ < 15xD

²⁾ < 20xD

TAPER SHANK DRILL

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

¹⁾ < 15xD

²⁾ < 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ 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 ₈ Inch	d_1 Øh ₈ mm	d_1 decimal Inch	l_2 Inch	l_1 Inch	l_2 mm	l_1 mm	Pack Qty	A170
	13.00	0.5118					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



REDUCED SHANK DRILL

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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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

ANSI

1.5XD

HSS

118°



1" - 2"

d ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	d ₂ 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

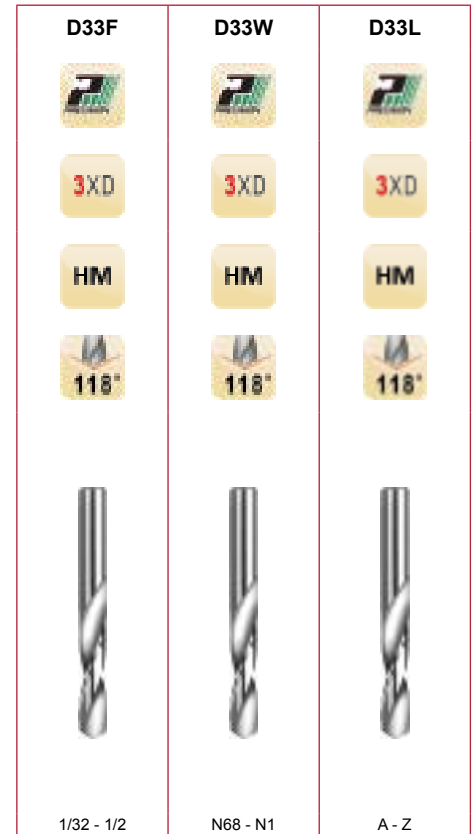
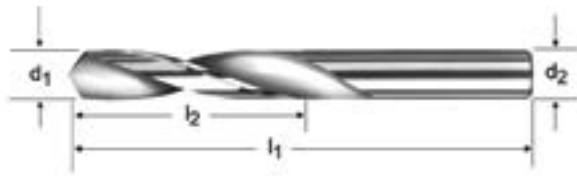
General Purpose Solid Carbide Jobber Length

D33F - Fractional Sizes

D33W - Wire Gauge Sizes

D33L - Letter Sizes

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 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
	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	—	0003561	—
	16		0.1770	1.5/8	2.3/4	1	—	0003562	—
	15		0.1800	1.5/8	2.3/4	1	—	0003563	—
	14		0.1820	1.5/8	2.3/4	1	—	0003564	—
	13		0.1850	1.5/8	2.3/4	1	—	0003565	—
3/16			0.1875	1.5/8	2.3/4	1	0003566	—	—
	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 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
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



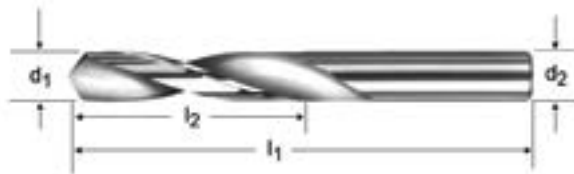
General Purpose Solid Carbide Jobber Length, Metric

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



DS-90



1/8 - 1/2

d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	Pack Qty	DS-90
1/8	0.1250	9/16	1.1/2	1	003332
3/16	0.1875	3/4	2"	1	003334
1/4	0.2500	1"	2.1/2	1	003336
5/16	0.3125	1"	2.1/2	1	003338
3/8	0.3750	1"	2.1/2	1	003340
1/2	0.5000	1.1/4	3"	1	003342

SPECIAL PURPOSE DRILL



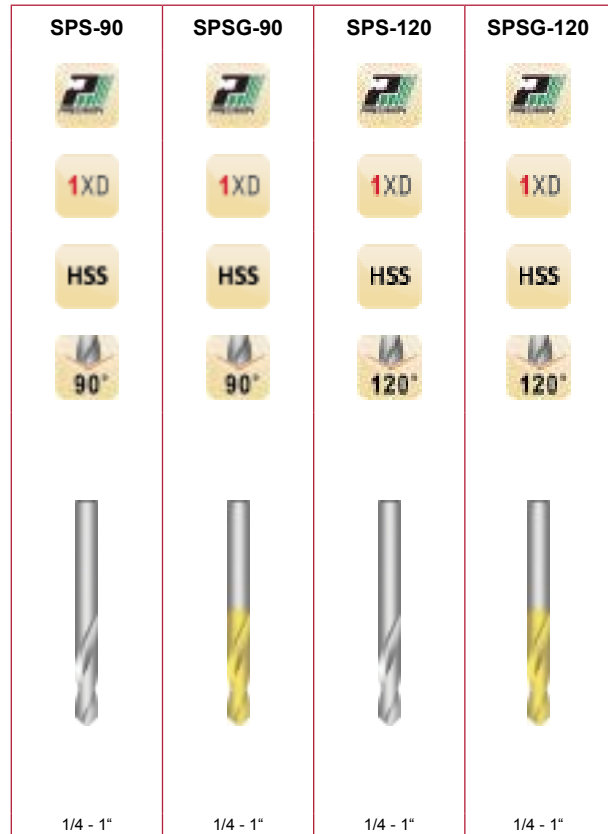
Spotting Drill - Short Length

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	SPSTG-90	SPS-120	SPSTG-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

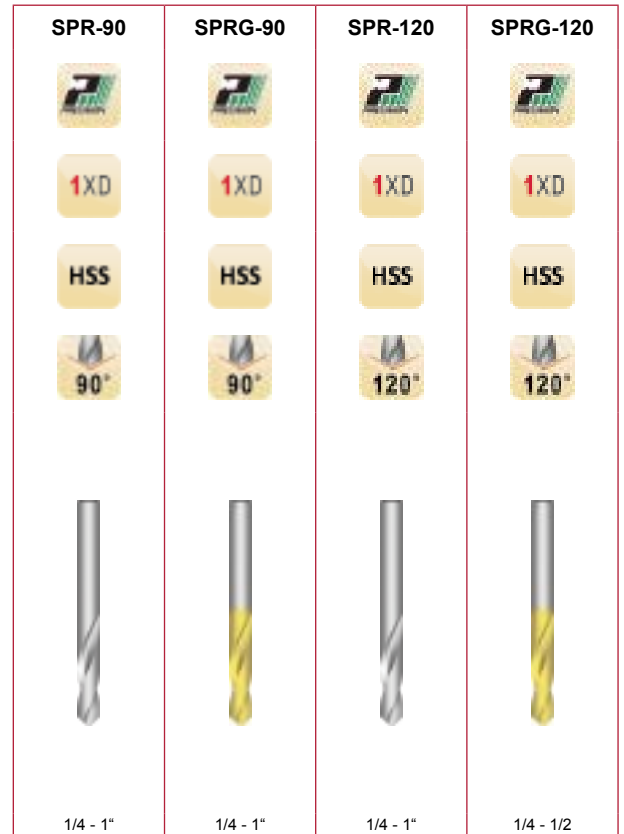
Spotting Drill - Regular Length

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	1.1/4	1/8	1	003251
1	3/64	3/64	1.1/4	1/8	1	003252
2	5/64	5/64	1.7/8	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 ₁ Ø Inch	l ₂ Inch	l ₁ Inch	d ₂ 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	3	097607
8	5/16	5/16	3.1/2	3/4	3	097608

General Purpose Combined Drill and Countersink (Center Drill)

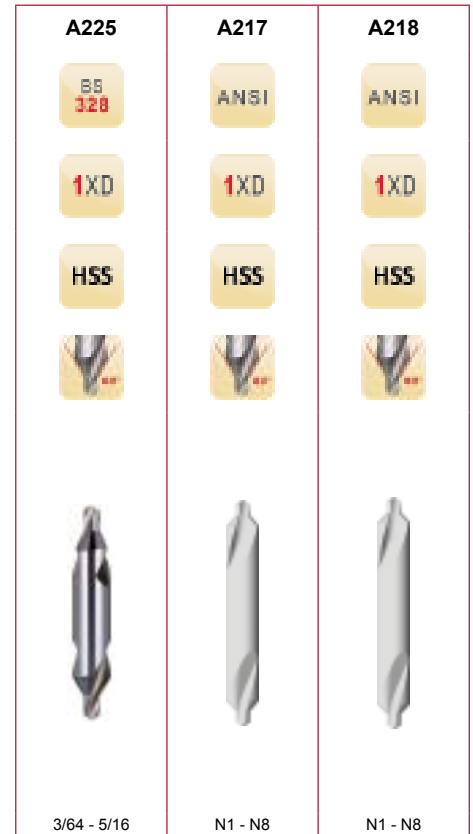
A225 60° C'sink. Bright Finish improves chip flow in soft or non-ferrous materials

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 ₁ Ø Inch	d ₁ decimal Inch	l ₂ max/min Inch	l ₁ Inch	d ₂ 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

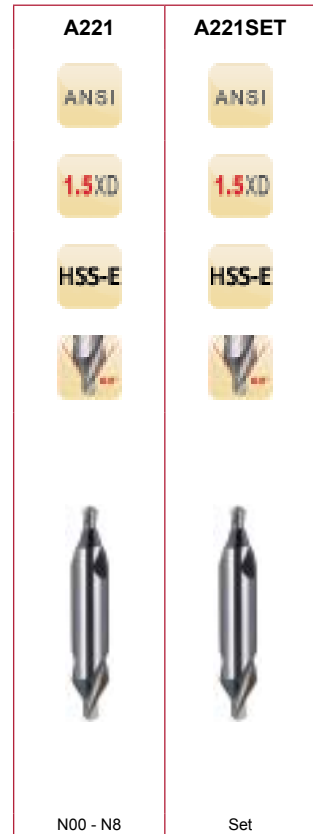


Cobalt Combined Drill and Countersink (Center Drill)

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 ₁ Ø Inch	Style	d ₁ decimal Inch	Pieces per Set	l ₂ Inch	Contents of set	l ₁ Inch	d ₂ Ø Inch	Pack Qty	A221	A221SET
00		0.025		0.0250		1/32		1.1/8	1/8	1	0241851	¹⁾ —
0		1/32		0.0313		1/32		1.1/8	1/8	1	0241844	¹⁾ —
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

¹⁾ single ended only



SPECIAL PURPOSE DRILL

Threaded Hex Shank Drills

TS41 - Stub, Wire Gauge Sizes

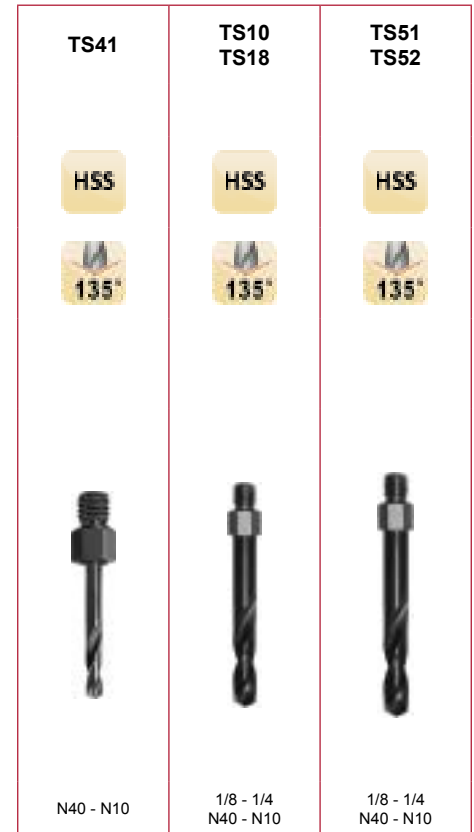
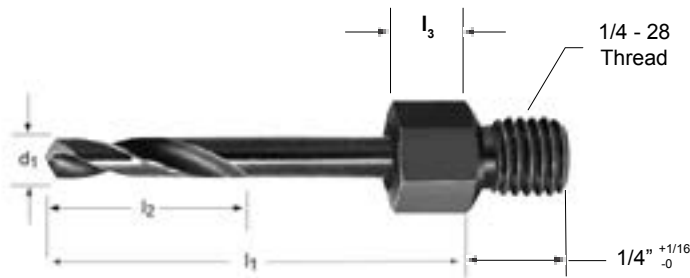
TS10 - Short, Fractional Sizes

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 ₁ Ø Nr.	d ₁ Ø Inch	d ₁ decimal Inch	l ₂ Inch	l ₁ Inch	l ₃ 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		0.1610	1.1/8	2.1/8	1/4	1	—	—	017921
20		0.1590	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



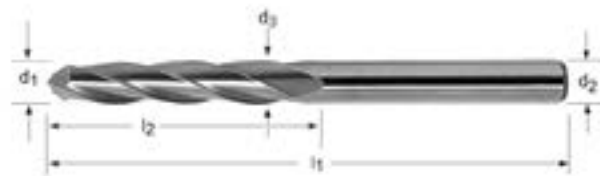
3-Flute Tapered Aircraft Router

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 ₁ Ø Inch	d ₂ Ø Inch	l ₂ Inch	l ₁ Inch	d ₃ 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	3	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
ANSI	ANSI	ANSI	ANSI
4XD	4XD	4XD	4XD
HSS	HSS	HSS	HSS
118"	118"	118"	118"
Set	Set	Set	Set

Set	Style	Pieces per Set		Pack Qty	C26R15P	C26R15	C115COMBP	C114COMBP
		Sizes						
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

JOBBER DRILL SETS



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



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



JOBBER DRILL SETS

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	1/16-1/4 x 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
ANSI	ANSI	ANSI
2.5XD	2.5XD	2.5XD
HSS	HSS	HSS
118°	118°	118°
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
ANSI	ANSI
2.5XD	2.5XD
HSS	HSS
135°	135°
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	—



Visual Index - Taps



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	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



Visual Index - Taps

Thread Form:	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	M	MF	
Standard:	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	
Class of Fit:	2B	2B	2B	2B	3B	3B	3B	3B	2B	2B	2B	2B	2B	2B	4H	4H	
Hole Type:																	
Depth of Cut:	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	
Tool Material:	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	
Chamfer:	P	P	P	P	B 3.5-5	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
Flute Geometry:																	
Direction of Cut:																	
Finish/Coating:																	
		Coolant Through	Coolant Through														
Style:	1672AP (UNC)	1672AP (UNF)	1674 (UNC)	1674 (UNF)	E025	E035	E026	E036	EP20	EP30	EP21	EP31	E021	E031	1673AP (M)	1673AP (MF)	
Range:	No.4 - 1"	No.10 - 3/4"	1/4 - 1"	1/4 - 1"	No.6 - 1"	No.6 - 1"	No.2 - 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	
Page #	230	230	230	230	231	231	231	231	233	233	233	233	234	234	235	235	
1.1	110	110	120	120	82	82	82	82	82	82	82	82	82	82	110	110	
1.2	90	90	100	100	72	72	72	72	72	72	72	72	72	72	90	90	
1.3	55	55	65	65	59	59	59	59	59	59	59	59	59	59	55	55	
1.4	55	55	65	65	52	52	52	52	52	52	52	52	52	52	55	55	
1.5	45	45	50	50	33	33	33	33	33	33	33	33	33	33	45	45	
1.6					16	16	16	16	16	16	16	16	16	16			
1.7																	
1.8																	
2.1	50	50	60	60			26	26			23	23	23	23	50	50	
2.2	40	40	40	40			23	23			20	20	20	20	40	40	
2.3	40	40	45	45			16	16			13	13	13	13	40	40	
2.4																	
3.1					49	49	49	49	49	49	49	49	49	49			
3.2					26	26	26	26	26	26	26	26	26	26			
3.3					49	49	49	49	49	49	49	49	49	49			
3.4					26	26	26	26	26	26	26	26	26	26			
4.1	35	35	40	40	33	33			33	33					35	35	
4.2	25	25	30	30	16	16			16	16					25	25	
4.3																	
5.1	35	35	40	40	39	39			39	39					35	35	
5.2	20	20	25	25	16	16			16	16					20	20	
5.3																	
6.1	45	45	50	50	39	39			39	39					45	45	
6.2	120	120	125	125	98	98			98	98					120	120	
6.3	100	100	110	110	66	66			66	66					100	100	
6.4																	
7.1	85	85	95	95	52	52			52	52					85	85	
7.2	100	100	120	120	115	115			115	115					100	100	
7.3	85	85	95	95	66	66			66	66					85	85	
7.4	30	30	40	40	49	49			49	49					30	30	
8.1					98	98			98	98							
8.2																	
8.3																	
9.1																	
10.1																	

Visual Index - Taps

	M	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC
	DIN 376	ANSI	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
	6HX	2B	2B	2B	2B	2B	2B	3B	3B	3B	3B	2B	2B	2B	2B	2B
	2XD	2.5XD	2.5XD	3XD	3XD	3XD	3XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD
	HSS-E PM	HSS	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
	C 2-3			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
	ET	ET	ET	TDN	TDN	TDN	TDN	ET	ET	ET	ET	ET	ET	ET	ET	ET
	E252	1985 (UNC)	1985 (UNF)	1676AP (UNC)	1676AP (UNF)	1678 (UNC)	1678 (UNF)	E027	E037	E028	E038	EX20	EX30	EX21	EX31	E023
	M8 - M24	No.4 - 1"	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"
	243	244	244	245	245	245	245	246	246	246	246	247	247	247	247	248
1.1		75	75	100	100	110	110	82	82	82	82	82	82	82	82	82
1.2		69	69	80	80	90	90	72	72	72	72	72	72	72	72	72
1.3		49	49	50	50	55	55	59	59	59	59	59	59	59	59	59
1.4		49	49	50	50	55	55	52	52	52	52	52	52	52	52	52
1.5		30	30	40	40	45	45	33	33	33	33	33	33	33	33	33
1.6		16	16						16			16				
1.7																
1.8																
2.1		36	36	45	45	50	50			23	23			23	23	23
2.2		20	20	30	30	35	35			20	20			20	20	20
2.3				35	35	40	40			13	13			13	13	13
2.4																
3.1	49															
3.2	26															
3.3	49															
3.4	26															
4.1		20	20	30	30	35	35	33	33			33	33			
4.2		16	16	20	20	25	25	16	16			16	16			
4.3		7	7													
5.1		30	30	30	30	35	35	39	39			39	39			
5.2		16	16	15	15	20	20	16	16			16	16			
5.3		10	10													
6.1				40	40	45	45	39								
6.2	66			100	100	120	120	98								
6.3				90	90	100	100	66								
6.4	16															
7.1				80	80	90	90	52	52			52	52			
7.2				95	95	115	115	115	115			115	115			
7.3				80	80	90	90	66	66			66	66			
7.4	49			30	30	35	35	49	49			49	49			
8.1								98	98							
8.2	33															
8.3																
9.1																
10.1																

Visual Index - Taps



	UNF	M	MF	M	M	M	MF	M	M	MF	MF	M	M	MF	UNC	UNF	M
ISO	529	DIN ANSI	DIN ANSI	DIN ANSI	ANSI	ANSI	ANSI	DR 379413 279412	DR 379413 279412	DIN 374	DIN 374	ISO 529	ISO 529	ISO 529	DIN ANSI	DIN ANSI	DIN ANSI
2B	8H	8H	8H	8H	8H	8H	8H	8H	8H	8H	8H	8H	8H	8H	2B	2B	8H
2.5XD	3XD	3XD	3XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	1.5XD	1.5XD	1.5XD
HSS-E	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-E	HSS PM	HSS PM	HSS PM
C 2-3	Semi-8	Semi-8	Semi-8	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	Semi-8	Semi-8	Semi-8
λ45°	λ50°	λ50°	λ50°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ45°	λ17°
ET	TDN	TDN	TDN	ET	ET	ET	ET	ET	ET	ET	ET	ET	ET	TDN Tap	TDN Tap	TDN Tap	
			Coolant Through														
	E033	1677AP (M)	1677AP (MF)	1679 (M)	E007	E008	E018	EX006H	EX016H	EX10	EX11	E002	E003	E013	1630AP (UNC)	1630AP (UNF)	1660AP (M)
	No.8 - 1"	M4 - M24	M8 - M24	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
	248	249	249	249	250	250	250	251	251	252	252	253	253	253	254	254	255
1.1	82	100	100	110	82	82	82	82	82	82	82	82	82	82			
1.2	72	80	80	90	72	72	72	72	72	72	72	72	72	72			
1.3	59	50	50	55	59	59	59	59	59	59	59	59	59	59			
1.4	52	50	50	55	52	52	52	52	52	52	52	52	52	52			
1.5	33	40	40	45	33	33	33	33	33	33	33	33	33	33	45	45	45
1.6	16														25	25	25
1.7																	
1.8																	
2.1	23	45	45	50		23	23		23		23		23	23			
2.2	20	30	30	35		20	20		20		20		20	20			
2.3	13	35	35	40		13	13		13		13		13	13			
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		30	30	35	33			33		33		33					
4.2		20	20	25	16			16		16		16					
4.3																	
5.1		30	30	35	39			39		39		39			10	10	10
5.2		15	15	20	16			16		16		16					
5.3															15	15	15
6.1		40	40	45													
6.2		100	100	120													
6.3		90	90	100													
6.4															25	25	25
7.1		80	80	89	52			52		52		52					
7.2		95	95	115	115			115		115		115					
7.3		80	80	90	66			66		66		66					
7.4		30	30	35	49			49		49		49					
8.1																	
8.2																	
8.3																	
9.1																	
10.1																	

Visual Index - Taps

	UNC	UNF	M	UNC	UNF	UNC	UNF	M	MF	M	G	G	G	G	G	G
	ANSI	ANSI	ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN ANSI	DIN 5156	DIN 5156	DIN 5156	DIN 5156	DIN 5156	DIN 5156
	2B 3B	2B 3B	4H	2B	2B	2B	2B	4H	4H	4H	Normal	Normal	Normal	Normal	Normal	Normal
				3XD	3XD	3XD	3XD	3XD	3XD	3XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD	2.5XD
	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS PM	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
	E 1.5-2	E 1.5-2	E 1.5-2	Semi-8	Semi-8	Semi-8	Semi-8	Semi-8	Semi-8	Semi-8	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3	C 2-3
	14	14	14	14 Top	14 Top	14 Top	14 Top	14 Top	14 Top	14 Top	14	14	14	14	14	14
	1641 (UNC)	1641 (UNF)	1671 (M)	1681AP (UNC)	1681AP (UNF)	1691AP (UNC)	1691AP (UNF)	1687AP (M)	1687AP (MF)	1697AP (M)	EP40	EP41	E041	EX40	EX41	E043
	No.4 - 1/2	No.10 - 3/8	M3 - M10	No.4 - 1"	No.10 - 7/8	1/4 - 1"	5/16 - 1/2	M4 - M20	M10 - M16	M6 - M20	1/8 - 1"	1/8 - 1"	1/8 - 3/4	1/8 - 1.1/2	1/8 - 1.1/2	1/8 - 3/4
	256	256	257	258	258	259	259	260	260	260	261	261	262	263	263	264
1.1	150	150	150	150	150	165	165	150	150	165	82	82	82	82	82	82
1.2	125	125	125	125	125	135	135	125	125	135	72	72	72	72	72	72
1.3	90	90	90	90	90	100	100	90	90	100	59	59	59	59	59	59
1.4	90	90	90	90	90	100	100	90	90	100	52	52	52	52	52	52
1.5											33	33	33	33	33	33
1.6											16	16	16			16
1.7																
1.8																
2.1	70	70	70	70	70	80	80	70	70	80		23	23		23	23
2.2	60	60	60	60	60	70	70	60	60	70		20	20		20	20
2.3	50	50	50	50	50	60	60	50	50	60		13	13		13	13
2.4																
3.1											49	49	49			
3.2											26	26	26			
3.3											49	49	49			
3.4											26	26	26			
4.1	60	60	60	60	60	70	70	60	60	70	33			33		
4.2											16			16		
4.3																
5.1	45	45	45	45	45	55	55	45	45	55	39			39		
5.2											16			16		
5.3																
6.1	55	55	55	55	55	70	70	55	55	70	39					
6.2	180	180	180	180	180	200	200	180	180	200	98					
6.3	130	130	130	130	130	160	160	130	130	160	66					
6.4																
7.1	180	180	180	180	180	200	200	180	180	200	52			52		
7.2	200	200	200	200	200	240	240	200	200	240	115			115		
7.3	230	230	230	230	230	260	260	230	230	260	66			66		
7.4											49			49		
8.1											98			98		
8.2																
8.3																
9.1																
10.1																

Visual Index - Taps



	UNC	UNF	UNS	UNC	UNF	UNC	UNF	UNC	UNF	M	MF	UNC	UNF	UNS	UNC	UNF	UNC	UNF
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ISO 529	ISO 529	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI
	2B 3B	2B 3B	3B	2B 3B	2B 3B	3B	3B	3B	3B	8H	8H	3B	3B	3B	2B 3B	2B 3B	3B	2B 3B
	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
	1500 (UNC) 1/4 - 1.1/2	1500 (UNF) 1/4 - 1.1/2	1500 (UNS) 11/16 - 1"	1528 (UNC) No.1 - No.12	1528 (UNF) No.0 - No.12	1500A (UNC) 1/4 - 1"	1500A (UNF) 1/4 - 7/8	TN1500 (UNC) 1/4 - 7/8	TN1500 (UNF) 1/4 - 3/4	E500 M1 - M56	E513 M3 - M50	1500L (UNC) 1/4 - 1"	1500L (UNF) 1/4 - 1"	1500L (UNS) 1"	E061 No.6 - 1.1/2	E071 No.6 - 1.1/2	1508 (UNC) 1/4 - 1/2	1508 (UNF) 1/4 - 1/2
	265	265	265	265	265	268	268	269	269	270	272	274	274	274	275	275	276	276
1.1	60	60	60	60	60	60	60	59	59	23	23	60	60	60	72	72	60	60
1.2	45	45	45	45	45	45	45	46	46	20	20	45	45	45	66	66	45	45
1.3	30	30	30	30	30	30	30	30	30	16	16	30	30	30	52	52	30	30
1.4	30	30	30	30	30	30	30	30	30	13	13	30	30	30	39	39	30	30
1.5	20	20	20	20	20	20	20	20	20	10	10	20	20	20	23	23	20	20
1.6	10	10	10	10	10	10	10	10	10			10	10	10	13	13	10	10
1.7																		
1.8																		
2.1	25	25	25	25	25	25	25	26	26			25	25	25			25	25
2.2	15	15	15	15	15	15	15	15	15			15	15	15			15	15
2.3	15	15	15	15	15	15	15	16	16			15	15	15			15	15
2.4																		
3.1	50	50	50	50	50	50	50	49	49	39	39	50	50	50	39	39	50	50
3.2	30	30	30	30	30	30	30	30	30	23	23	30	30	30	23	23	30	30
3.3	30	30	30	30	30	30	30	30	30	33	33	30	30	30	33	33	30	30
3.4	15	15	15	15	15	15	15	16	16	16	16	15	15	15	16	16	15	15
4.1	20	20	20	20	20	20	20	20	20			20	20	20			20	20
4.2	15	15	15	15	15	15	15	16	16			15	15	15			15	15
4.3																		
5.1	20	20	20	20	20	20	20	20	20			20	20	20			20	20
5.2	10	10	10	10	10	10	10	10	10			10	10	10			10	10
5.3																		
6.1	25	25	25	25	25	25	25	26	26	13	13	25	25	25	39	39	25	25
6.2	80	80	80	80	80	80	80	79	79	33	33	80	80	80	98	98	80	80
6.3	60	60	60	60	60	60	60	59	59	23	23	60	60	60	66	66	60	60
6.4	10	10	10	10	10	10	10	10	10	7	7	10	10	10			10	10
7.1	50	50	50	50	50	50	50	49	49			50	50	50			50	50
7.2	100	100	100	100	100	100	100	98	98	39	39	100	100	100			100	100
7.3	75	75	75	75	75	75	75	75	75	23	23	75	75	75	66	66	75	75
7.4	20	20	20	20	20	20	20	20	20	16	16	20	20	20	49	49	20	20
8.1	25	25	25	25	25	25	25	30	30			25	25	25			25	25
8.2	15	15	15	15	15	15	15	16	16	16	16	15	15	15	39	39	15	15
8.3										10	10				23	23		
9.1																		
10.1																		

Visual Index - Taps

	UNC	UNF	M	M	UNC	UNS	UNC	UNF	UNC	UNF	M	M	M	UNC	UNF	UNC	UNF
	ANSI	ANSI	ANSI	ISO 529	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ISO 529	ANSI	ANSI	ANSI	ANSI
	3B	3B	8H	8H		2B	3B	3B	2B	2B	8H	8H	8H	2B 3B	2B 3B	2B	2B
	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	2.5XD	2.5XD	2.5XD	2.5XD
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
					P												
	1595 (UNC)	1595 (UNF)	1700 (M)	E501	1500OV (UNC)	1505 (UNS)	1599 (UNC)	1599 (UNF)	1600 (UNC)	1600 (UNF)	1599 (M)	1599SB (M)	E504	1534 (UNC)	1534 (UNF)	TN1534 (UNC)	TN1534 (UNF)
	1/4 - 5/16	1/4 - 1/4	M1.6 - M36	M3 - M24	1/4 - 5/8	1.1/8 - 2"	1/4 - 3/4	1/4 - 3/4	1/4 - 3/4	1/4 - 3/4	M6 - M14	M6 - M12	M3 - M24	No.5 - No.12	No.5 - No.12	No.4 - No.12	No.10
	276	276	277	278	279	280	281	281	281	281	282	282	283	284	284	284	284
1.1	66	66	49	23	49	49							46	66	66	79	79
1.2	59	59	36	20	36	36							39	66	66	75	75
1.3	39	39	26	16	26	26							33	39	39	49	49
1.4	39	39	26	13	26	26							26	39	39	49	49
1.5	26	26	16	10	16	16							20	26	26	30	30
1.6	16	16	7		7	7								16	16	20	20
1.7																	
1.8																	
2.1	30	30	20		20	20								30	30	39	39
2.2	20	20	13		13	13								20	20	26	26
2.3	20	20	13		13	13								20	20	26	26
2.4																	
3.1	46	46	39	39	39	39	49	49	49	49	49	49	59	46	46	49	49
3.2	26	26	26	23	26	26	36	36	36	36	36	36	39	26	26	30	30
3.3	26	26	26	33	26	26	36	36	36	36	36	36	72	26	26	30	30
3.4	16	16	13	16	13	13	20	20	20	20	20	20	39	16	16	20	20
4.1	20	20	16		16	16								20	20		
4.2	16	16	13		13	13								16	16		
4.3	7	7												7	7		
5.1	26	26	16		16	16								26	26	30	30
5.2	10	10	7		7	7								10	10	13	13
5.3																	
6.1	30	30	20	13	20	20								30	30	39	39
6.2	89	89	66	33	66	66							66	89	89	115	115
6.3	69	69	49	23	49	49							46	69	69	89	89
6.4	10	10	7	7	7	7	13	13	13	13	13	13	13	10	10	13	13
7.1	49	49	39		39	39								49	49	66	66
7.2	98	98	79	39	79	79							79	98	98	125	125
7.3	66	66	59	23	59	59							46	66	66	79	79
7.4	20	20	16	16	16	16							33	20	20	26	26
8.1	98	98	26		26	26								98	98	121	121
8.2	26	26	13	16	13	13	13	13	13	13	13	13	33	26	26	30	30
8.3				10									20				
9.1																	
10.1																	

Visual Index - Taps



	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	M	M	UNC	UNF	UNS	UNC	UNF	M
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI
	3B	3B	2B 3B	2B 3B	2B 3B	3B	3B	3B	8H	8H	2B 3B	2B 3B	3B	2B 3B	2B 3B	8H
	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
							P	P								
			BT	BT	TK	TK										
	1585 (UNC) 1/4 - 3/4	1585 (UNF) 1/4 - 3/4	1585A (UNC) 1/4 - 3/4	1585A (UNF) 1/4 - 3/4	TN1585 (UNC) 1/4 - 1/2	TN1585 (UNF) 1/4 - 1/2	1634 (UNC) No.4 - No.8	1634 (UNF) No.10	1785M M2 - M18	TN1785 M4 - M12	1534NR (UNC) No.1 - No.12	1534NR (UNF) No.0 - No.12	1534NR (UNS) No.4	1585NR (UNC) 1/4 - 3/4	1585NR (UNF) 1/4 - 3/4	1785NR M1.6 - M20
	285	285	285	285	285	285	287	287	288	288	289	289	289	291	291	292
1.1	66	66	66	66	79	79	66	66	66	79	66	66	66	66	66	66
1.2	66	66	66	66	75	75	66	66	66	75	66	66	66	59	59	59
1.3	39	39	39	39	49	49	39	39	39	49	39	39	39	46	46	46
1.4	39	39	39	39	49	49	39	39	39	49	39	39	39	33	33	33
1.5	26	26	26	26	30	30	26	26	26	30	26	26	26	16	16	16
1.6	16	16	16	16	20	20	16	16	16	20	16	16	16	10	10	10
1.7																
1.8																
2.1	30	30	30	30	39	39	30	30	30	39	30	30	30	20	20	20
2.2	20	20	20	20	26	26	20	20	20	26	20	20	20	13	13	13
2.3	20	20	20	20	26	26	20	20	20	26	20	20	20	10	10	10
2.4																
3.1	46	46	46	46	49	49	46	46	46	49	46	46	46			46
3.2	26	26	26	26	30	30	26	26	26	30	26	26	26			26
3.3	26	26	26	26	30	30	26	26	26	30	26	26	26			26
3.4	16	16	16	16	20	20	16	16	16	20	16	16	16			16
4.1	20	20	20	20			20	20	20		20	20	20			
4.2	16	16	16	16			16	16	16		16	16	16			
4.3	7	7	7	7			7	7	7		7	7	7	10	10	10
5.1	26	26	26	26	30	30	26	26	26	30	26	26	26	33	33	33
5.2	10	10	10	10	13	13	10	10	10	13	10	10	10	13	13	13
5.3																
6.1	30	30	30	30	39	39	30	30	30	39	30	30	30	33	33	33
6.2	89	89	89	89	115	115	89	89	89	115	89	89	89			
6.3	69	69	69	69	89	89	69	69	69	89	69	69	69	49	49	49
6.4	10	10	10	10	13	13	10	10	10	13	10	10	10			
7.1	49	49	49	49	66	66	49	49	49	66	49	49	49	33	33	33
7.2	98	98	98	98	125	125	98	98	98	125	98	98	98	82	82	82
7.3	66	66	66	66	79	79	66	66	66	79	66	66	66	43	43	43
7.4	20	20	20	20	26	26	20	20	20	26	20	20	20	33	33	33
8.1	98	98	98	98	121	121	98	98	98	121	98	98	98	66	66	66
8.2	26	26	26	26	30	30	26	26	26	30	26	26	26			
8.3																
9.1																
10.1																

Visual Index - Taps

	UNC	UNF	UNC	UNF	UNC	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF	UNC	UNF
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI
	3B	2B 3B	2B 3B	2B 3B	2B	3B	3B	3B	3B	3B	3B	2B 3B	2B 3B	3B	3B	3B	3B
	2.5XD	2.5XD	2.5XD	2.5XD	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
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
	P	P															
						$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 30^\circ$	$\lambda 52^\circ$	$\lambda 52^\circ$	$\lambda 52^\circ$	$\lambda 52^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$	$\lambda 40^\circ$
	1534NE (UNC) No.4 - 1/2	1534NE (UNF) No.10 - 1/2	1593 (UNC) No.6 - No.10	1593 (UNF) No.10	1585OV (UNC) 1/4 - 5/8	1582 (UNC) No.4 - No.10	1582 (UNF) No.10 - No.10	1586 (UNC) 1/4 - 1/2	1586 (UNF) 1/4 - 1/2	1587 (UNC) No.3 - No.12	1587 (UNF) No.4 - No.10	1588 (UNC) 1/4 - 1/2	1588 (UNF) 1/4 - 1/2	1590 (UNC) No.6 - No.10	1590 (UNF) No.6 - No.10	1591 (UNC) 1/4 - 1/2	1591 (UNF) 1/4 - 1/2
	293	293	294	294	294	295	295	295	295	296	296	296	296	297	297	297	297
1.1	66	66	66	66	66	66	66	66	66					69	69	69	69
1.2	66	66	66	66	66	49	49	49	49					59	59	59	59
1.3	39	39	39	39	39	36	36	36	36					39	39	39	39
1.4	39	39	39	39	39	36	36	36	36					39	39	39	39
1.5	26	26	26	26	26									30	30	30	30
1.6	16	16	16	16	16												
1.7																	
1.8																	
2.1	30	30	30	30	30	26	26	26	26					30	30	30	30
2.2	20	20	20	20	20	20	20	20	20					26	26	26	26
2.3	20	20	20	20	20	20	20	20	20					20	20	20	20
2.4																	
3.1	46	46	46	46	46												
3.2	26	26	26	26	26												
3.3	26	26	26	26	26												
3.4	16	16	16	16	16												
4.1	20	20	20	20	20	20	20	20	20					20	20	20	20
4.2	16	16	16	16	16	16	16	16	16					16	16	16	16
4.3	7	7	7	7	7	7	7	7	7					7	7	7	7
5.1	26	26	26	26	26	20	20	20	20								
5.2	10	10	10	10	10	16	16	16	16								
5.3														10	10	10	10
6.1	30	30	30	30	30					30	30	30	30				
6.2	89	89	89	89	89					79	79	79	79				
6.3	69	69	69	69	69					79	79	79	79				
6.4	10	10	10	10	10												
7.1	49	49	49	49	49					49	49	49	49				
7.2	98	98	98	98	98					66	66	66	66				
7.3	66	66	66	66	66					66	66	66	66				
7.4	20	20	20	20	20												
8.1	98	98	98	98	98												
8.2	26	26	26	26	26												
8.3																	
9.1																	
10.1																	

Visual Index - Taps



	M	UNC	UNF	M	UNC	UNF	M	UNC	UNF	NPT	NPT	NPT	NPT	NPT	NPT	NPT	
	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI	ANSI #94.9	ANSI #94.9	ANSI #94.9	ANSI #94.9	ANSI	
	8H	2B 3B	2B 3B	8H	2B 3B	2B 3B	8H	2B	2B	Normal	Normal	Normal	Normal	Normal	Normal	Normal	
	2.5XD	1.25XD	2.5XD	2.5XD	3XD	3XD	3XD	2.5XD	2.5XD	2XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	
	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			
	1788 (M)	1580 (UNC)	1580 (UNF)	1580 (M)	3300 (UNC)	3300 (UNF)	3300 (M)	3306E (UNC)	3306E (UNF)	1541 (NPT)	TN1541	E710	E721	6541	1544 (NPT)	1545 (NPT)	1545A (NPT)
	M3 - M12	No.2 - 3/8	No.10 - 3/8	M3 - M12	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
	298	299	299	300	301	301	302	303	303	304	304	305	305	306	307	308	308
1.1		98	98	98	98	98	98	98	98	13	16	13	13		13	13	13
1.2		79	79	79	79	79	79	79	79	13	16	13	13		13	13	13
1.3		49	49	49	49	49	49	49	49	20	23	20	20		20	20	20
1.4		49	49	49	49	49	49	49	49	16	20	16	16		16	16	16
1.5		30	30	30	30	30	30	30	30	10	13	10	10		10	10	10
1.6																	
1.7																	
1.8																	
2.1		39	39	39	39	39	39	39	39								
2.2		30	30	30	30	30	30	30	30								
2.3																	
2.4																	
3.1										20	23	20	20		20	20	20
3.2										13	16	13	13		13	13	13
3.3										20	23	20	20		20	20	20
3.4										13	16	13	13		13	13	13
4.1		30	30	30	30	30	30	30	30								
4.2		26	26	26	26	26	26	26	26								
4.3																	
5.1		30	30	30	30	30	30	30	30								
5.2																	
5.3																	
6.1	30	39	39	39	39	39	39	39	39								
6.2	79	121	121	121	121	121	121	121	121	36	39	36	36		36	36	36
6.3	79	98	98	98	98	98	98	98	98								
6.4																	
7.1	49	79	79	79	79	79	79	79	79								
7.2	66	161	161	161	161	161	161	161	161								
7.3	66	98	98	98	98	98	98	98	98	36	39	36	36		36	36	36
7.4																	
8.1										23	26	23	23		23	23	23
8.2										13	16	13	13		13	13	13
8.3																	
9.1																	
10.1																	

Visual Index - Taps

	NPT	NPT	NPT	NPTF	NPTF	NPTF	NPTF	NPTF	NPSM	NPSF	Rc	G	UNC	UNF	UNC	UNF	EGM
	ANSI	ANSI	ANSI B94.9	ANSI	ANSI	ANSI	ANSI	ANSI B94.9	ANSI	ANSI	ISO 2284	ISO 2284	ANSI	ANSI	ANSI	ANSI	ISO ISO
	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	3B	3B	2B 3B	2B 3B	4H
	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
	1548 (NPT)	1568 (NPT)	E711	1543 (NPTF)	TN1543	1549 (NPTF)	1567 (NPTF)	E712	1542 (NPS)	1592 (NPSF)	E550	E547	1572 (UNC)	1572 (UNF)	1578 (UNC)	1578 (UNF)	E620
	1/16 - 1"	1/8 - 1.1/2"	1/8 - 1.1/2	1/16 - 1"	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
	309	310	311	312	312	313	314	315	316	316	317	318	319	319	319	319	320
1.1	13	13	13	13	16	13	13	13	13	13	72	23	49	49	66	66	23
1.2	13	13	13	13	16	13	13	13	13	13	66	20	30	30	59	59	20
1.3	20	20	20	20	23	20	20	20	20	20	52	16	26	26	46	46	16
1.4	16	16	16	16	20	16	16	16	16	16	39	13	26	26	33	33	13
1.5	10	10	10	10	13	10	10	10	10	10	23	10			16	16	10
1.6											13				10	10	
1.7																	
1.8																	
2.1											23		16	16	20	20	
2.2											16		7	7	13	13	
2.3											23				10	10	
2.4																	
3.1	20	20	20	20	23	20	20	20	20	20	39	39					39
3.2	13	13	13	13	16	13	13	13	13	13	23	23					23
3.3	20	20	20	20	23	20	20	20	20	20	33	33					33
3.4	13	13	13	13	16	13	13	13	13	13	16	16					16
4.1																	
4.2																	
4.3															10	10	
5.1															33	33	
5.2															13	13	
5.3																	
6.1											39	13	26	26	33	33	13
6.2	36	36	36	36	39	36	36	36	36	36	98	33	66	66	49	49	33
6.3											66	23	49	49	49	49	23
6.4											13	7					7
7.1													39	39	33	33	
7.2											115	39	79	79	82	82	39
7.3	36	36	36	36	39	36	36	36	36	36	66	23	59	59	43	43	23
7.4	23	23	23	23	26	23	23	23	23	23	49	16	16	16	33	33	16
8.1	13	13	13	13	16	13	13	13	13	13					66	66	
8.2											39	16					16
8.3											23	10					10
9.1																	
10.1																	

Visual Index - Taps



	EGM	UNC	UNC	UNC	UNF	UNC	UNF	M	NPT
	ISO	ANSI	ANSI	ANSI	ANSI	DIN	DIN	ISO	ANSI
	4H	3B	3B	2B	2B	2B	Medium	4H	Normal
	2XD	3.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD	1.5XD
	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
	C 2-3	T	P			C 2-3	C 2-3	C 2-3	
	λ40°			λ15°	λ15°	λ30°	λ30°	λ30°	λ27°
	E621	U1511	1519 (UNC)	1994 (UNC)	1994 (UNF)	E651	E654	E650	E653
	M3 - M16	1/4 - 1/2	1/4 - 3/4	No.4 - 1/2	No.10 - 1/2	No.6 - 5/8	No.8 - 5/8	M3 - M16	1/8 - 1"
	320	321	322	323	323	324	324	325	326
1.1		39	49	82	82	82	82	82	82
1.2	59	33	36	72	72	72	72	72	72
1.3	46	26	26	59	59	59	59	59	59
1.4	33	20	26	49	49	49	49	49	49
1.5	16	16	16						
1.6			7						
1.7									
1.8									
2.1	20		20						
2.2	13		13						
2.3	10		13						
2.4									
3.1		46	39						
3.2		26	26	26	26	26	26	26	26
3.3		39	26						
3.4			13						
4.1			16						
4.2			13						
4.3									
5.1			16						
5.2	13		7						
5.3									
6.1			20						
6.2		52	66	98	98	98	98	98	98
6.3		39	49	66	66	66	66	66	66
6.4			7						
7.1	33		39	59	59	59	59	59	59
7.2	82	66	79	115	115	115	115	115	115
7.3	43	39	59						
7.4	33		16						
8.1			26	98	98	98	98	98	98
8.2		26	13						
8.3									
9.1									
10.1									



Pgs. 216 - 329

1215.....	327	3850	328	E008.....	250	EP10.....	238
1500.....	265	6541	306	E011.....	239	EP11.....	238
1505.....	280	1500A.....	268	E013.....	253	EP20.....	233
1508.....	276	1500L.....	274	E016.....	236	EP21.....	233
1519.....	322	1500OV.....	279	E018.....	250	EP30.....	233
1528.....	265	1534NE.....	293	E021.....	234	EP31.....	233
1534.....	284	1534NR.....	289	E023.....	248	EP40.....	261
1541.....	304	1545A.....	308	E025.....	231	EP41.....	261
1542.....	316	1580M.....	300	E026.....	231	EX006H.....	251
1543.....	312	1585A.....	285	E027.....	246	EX016H.....	251
1544.....	307	1585NR.....	291	E028.....	246	EX10.....	252
1545.....	308	1585OV.....	294	E031.....	234	EX11.....	252
1548.....	309	1599M.....	282	E033.....	248	EX20.....	247
1549.....	313	1599SB.....	282	E035.....	231	EX21.....	247
1567.....	314	1629AP.....	241	E036.....	231	EX30.....	247
1568.....	310	1630AP.....	254	E037.....	246	EX31.....	247
1572.....	319	1659AP.....	242	E038.....	246	EX40.....	263
1578.....	319	1660AP.....	255	E041.....	262	EX41.....	263
1580.....	299	1672AP.....	230	E043.....	264	TN1500.....	269
1582.....	295	1673AP.....	235	E061.....	275	TN1534.....	284
1585.....	285	1676AP.....	245	E071.....	275	TN1541.....	304
1586.....	295	1677AP.....	249	E201.....	243	TN1543.....	312
1587.....	296	1681AP.....	258	E252.....	243	TN1585.....	285
1588.....	296	1687AP.....	260	E500.....	270	TN1785.....	288
1590.....	297	1691AP.....	259	E501.....	278	U1511.....	321
1591.....	297	1697AP.....	260	E504.....	283		
1592.....	316	1700M.....	277	E513.....	272		
1593.....	294	1785M.....	288	E547.....	318		
1595.....	276	1785NR.....	292	E550.....	317		
1599.....	281	1788M.....	298	E620.....	320		
1600.....	281	229SET.....	329	E621.....	320		
1634.....	287	3300M.....	302	E650.....	325		
1641.....	256	3306E.....	303	E651.....	324		
1671.....	257	E000.....	239	E653.....	326		
1674.....	230	E000TIN.....	239	E654.....	324		
1675.....	235	E001.....	239	E710.....	305		
1678.....	245	E002.....	253	E711.....	311		
1679.....	249	E003.....	253	E712.....	315		
1985.....	244	E005.....	236	E721.....	305		
1994.....	323	E006.....	236	EP006H.....	237		
3300.....	301	E007.....	250	EP016H.....	237		

APPLIX SPIRAL POINT TAPS

UNION BUTTERFIELD

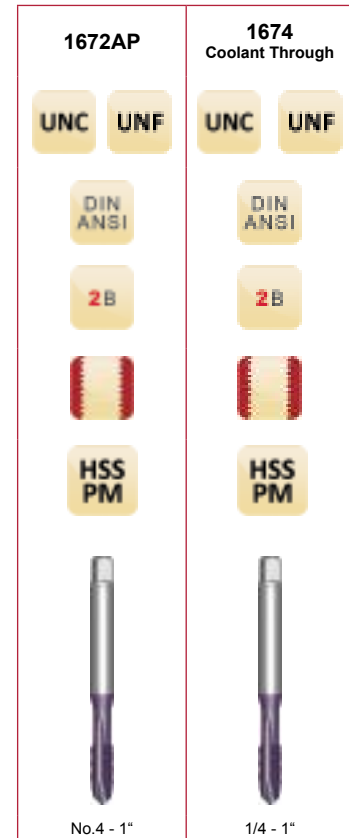
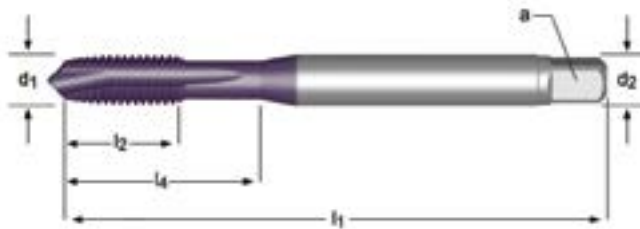
APPLIX

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



UNC	UNF	TPI	l_1 Inch	l_2 Inch	l_4 Inch (Neck Length)	d_2 Ø Inch	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	¹⁾ —
6		32	2.205	0.472	0.787	0.141	0.110	2	H2	1	46204864	¹⁾ —
8		32	2.480	0.512	0.827	0.168	0.131	3	H3	1	46204869	¹⁾ —
	10	32	2.756	0.512	0.984	0.194	0.152	3	H3	1	46204852	¹⁾ —
10		24	2.756	0.591	0.984	0.194	0.152	3	H3	1	46204851	¹⁾ —
	1/4	28	3.150	0.669	1.181	0.255	0.191	3	H4	1	46204850	¹⁾ 1716512 ¹⁾
1/4		20	3.150	0.669	1.181	0.255	0.191	3	H5	1	46204849	¹⁾ 1716510 ¹⁾
	5/16	24	3.543	0.669	1.378	0.318	0.238	3	H4	1	46204861	¹⁾ —
5/16		18	3.543	0.787	1.378	0.318	0.238	3	H5	1	46204860	¹⁾ 1716514 ¹⁾
	3/8	24	3.937	0.709	1.535	0.381	0.286	3	H4	1	46204858	¹⁾ —
3/8		16	3.937	0.866	1.535	0.381	0.286	3	H5	1	46204857	¹⁾ 1716518 ¹⁾
	7/16	20	3.937	0.866		0.323	0.242	3	H5	1	46204866	²⁾ —
7/16		14	3.937	0.866		0.323	0.242	3	H5	1	46204865	²⁾ —
	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	²⁾ —
1/2		13	4.331	0.984		0.367	0.275	3	H5	1	46204847	²⁾ 1716534 ²⁾
	5/8	18	3.937	0.866		0.480	0.360	4	H5	1	46204863	²⁾ —
5/8		11	4.331	1.063		0.480	0.360	4	H5	1	46204862	²⁾ 1716538 ²⁾
	3/4	16	4.331	0.984		0.590	0.442	4	H5	1	46204856	²⁾ —
3/4		10	4.291	1.181		0.590	0.442	4	H5	1	46204855	²⁾ —
3/4		10	4.921	1.181		0.590	0.442	4	H5	1	—	1716542 ²⁾
7/8		9	5.512	1.260		0.697	0.523	4	H6	1	46204868	²⁾ —
1"		8	6.299	1.417		0.800	0.600	4	H6	1	46204854	²⁾ — ²⁾

¹⁾ Reinforced Shanks

²⁾ 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.

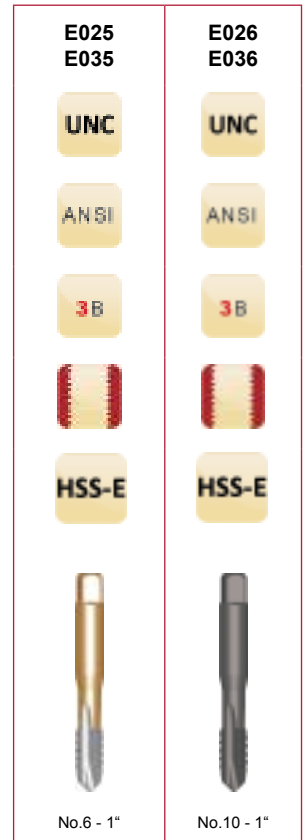
E025 = UNC Sizes, E035 = UNF Sizes

- 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 ¹⁾
4		40	1.7/8	0.6091	0.1410	0.1100	2	H2	N43	2.35	0.6091	1	—	0581254 ¹⁾
5		40	1.15/16	0.7404	0.1410	0.1100	2	H2	N38	2.65	0.7404	1	—	0581261 ¹⁾
	6	40	2"	0.2610	0.1410	0.1100	2	H2	N33	2.95	0.5938	1	0581957 ¹⁾	—
6		32	2"	0.2610	0.1410	0.1100	2	H2	N36	2.85	0.5938	1	0581070 ¹⁾	0581278 ¹⁾
	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 ¹⁾	0581285 ¹⁾
	10	32	2.3/8	0.4303	0.1940	0.1520	2	H2	N21	4.10	0.8434	1	0581971 ¹⁾	0581245 ¹⁾
10		24	2.3/8	0.4303	0.1940	0.1520	2	H3	N25	3.90	0.8434	1	0581094 ¹⁾	0581292 ¹⁾
	12	28	2.3/8	0.4173	0.2200	0.1650	2	H3	N14	4.70	0.8848	1	— ¹⁾	0582152 ¹⁾
12		24	2.3/8	0.4173	0.2200	0.1650	2	H3	N16	4.50	0.8848	1	0581100 ¹⁾	0581308 ¹⁾
	1/4	28	2.1/2	0.5075	0.2550	0.1910	2	H3	N3	5.50	1.0073	1	0581995 ¹⁾	0582169 ¹⁾
	1/4	28	2.1/2	0.5075	0.2550	0.1910	3	H3	N3	5.50	1.0073	1	0582008 ¹⁾	0582176 ¹⁾
1/4		20	2.1/2	0.5075	0.2550	0.1910	2	H3	N7	5.10	1.0073	1	0581117 ¹⁾	0581315 ¹⁾
1/4		20	2.1/2	0.5075	0.2550	0.1910	3	H3	N7	5.10	1.0073	1	0581124 ¹⁾	0581339 ¹⁾
1/4		20	2.1/2	0.5075	0.2550	0.1910	3	H11	N7	5.10	1.0073	1	—	0581322 ¹⁾³⁾
	5/16	24	2.23/32	0.5939	0.3180	0.2380	2	H3	I	6.90	1.1891	1	0582015 ¹⁾	0582183 ¹⁾
	5/16	24	2.23/32	0.5939	0.3180	0.2380	3	H3	I	6.90	1.1891	1	0582022 ¹⁾	0582190 ¹⁾
5/16		18	2.23/32	0.5939	0.3180	0.2380	2	H3	F	6.60	1.1891	1	0581131 ¹⁾	0581346 ¹⁾
5/16		18	2.23/32	0.5939	0.3180	0.2380	3	H3	F	6.60	1.1891	1	0581148 ¹⁾	0581360 ¹⁾
5/16		18	2.23/32	0.5939	0.3180	0.2380	3	H11	F	6.60	1.1891	1	—	0581353 ¹⁾³⁾
	3/8	24	2.15/16	0.6020	0.3810	0.2860	2	H3	Q	8.50	1.2915	1	0582039 ¹⁾	0582206 ¹⁾
	3/8	24	2.15/16	0.6020	0.3810	0.2860	3	H3	Q	8.50	1.2915	1	0582046 ¹⁾	—
3/8		16	2.15/16	0.6020	0.3810	0.2860	2	H3	5/16	8.00	1.2915	1	0581155 ¹⁾	0581377 ¹⁾
3/8		16	2.15/16	0.6020	0.3810	0.2860	3	H3	5/16	8.00	1.2915	1	0581162 ¹⁾	0581391 ¹⁾
3/8		16	2.15/16	0.6020	0.3810	0.2860	3	H11	5/16	8.00	1.2915	1	—	0581384 ¹⁾³⁾
	7/16	20	3.5/32	0.9055	0.3230	0.2420	3	H3	25/64	9.90	—	1	0582053 ²⁾	0582220 ²⁾
7/16		14	3.5/32	0.9055	0.3230	0.2420	3	H3	U	9.40	—	1	0581179 ²⁾	0581407 ²⁾
	1/2	20	3.3/8	0.9055	0.3670	0.2750	2	H3	29/64	11.50	—	1	0582060 ²⁾	0582237 ²⁾

¹⁾ Reinforced Shanks
²⁾ Reduced Shanks
³⁾ Oversize +.005", not 3B

SPIRAL POINT TAPS



UNC	UNF	TPI	l ₁ Inch	l ₂ Inch	d ₂ ∅ Inch	a Inch	# of Flutes	Limits			l ₄ 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 ²⁾³⁾
	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 ²⁾³⁾
	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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

³⁾ 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.

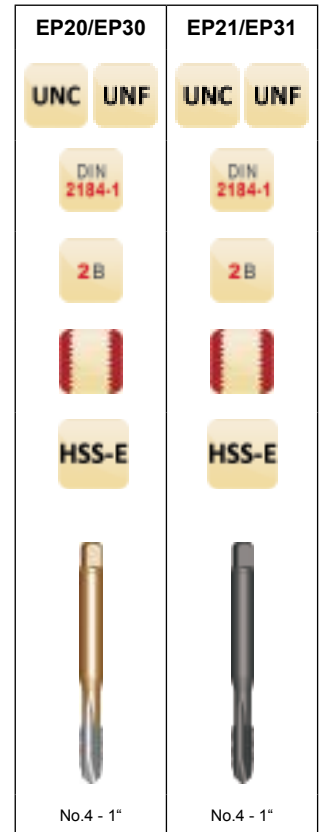
EP20 = UNC Sizes, EP30 = UNF Sizes

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

Note: DIN shank and square dimensions will necessitate metric holders

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

Note: ISO shank and square dimensions will necessitate metric holders

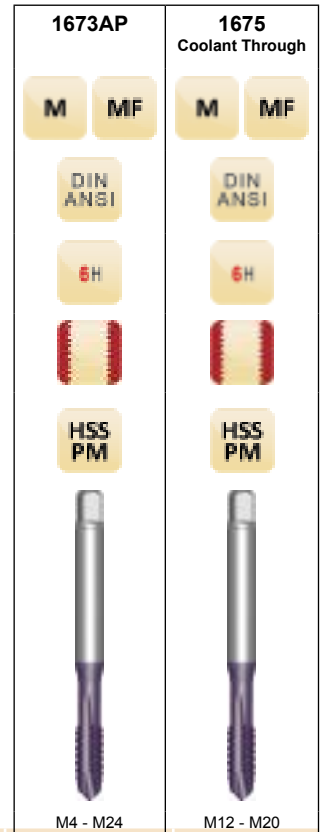
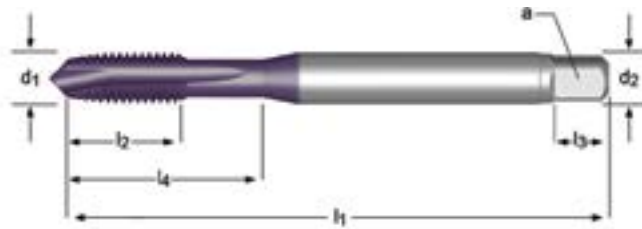
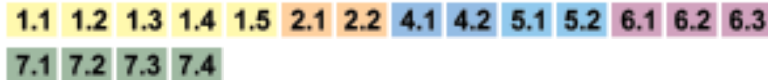
¹⁾ Reinforced Shanks
²⁾ Reduced Shanks

MXP Multi-Application, Plug Chamfer



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.



M	MF	P	l ₁	l ₂	l ₄	d ₂	a	# of Flutes	Limits	Pack Qty	1673AP	1675
		mm	mm	mm	Inch (Neck Length)	Inch Ø	Inch					
4		0.70	63	13	21	0.168	0.131	3	D4	1	46204884 ¹⁾	—
5		0.80	70	15	25	0.194	0.152	3	D4	1	46204885 ¹⁾	—
6		1.00	80	17	30	0.255	0.191	3	D5	1	46204886 ¹⁾	—
	8	1.00	17		35	0.318	0.238	3	D5	1	46205008 ¹⁾	—
8		1.25	90	20	35	0.318	0.238	3	D5	1	46204887 ¹⁾	—
	10	1.25	16		39	0.381	0.286	3	D6	1	46204870 ¹⁾	—
10		1.25	100	16	39	0.381	0.286	3	D6	1	—	—
	12	1.25	21			0.367	0.275	3	D6	1	46204871 ¹⁾	—
	12	1.50	100	22	39	0.381	0.286	3	D6	1	46205009 ²⁾	—
	12	1.50	22			0.367	0.275	3	D6	1	46204872 ²⁾	—
12		1.50	100	22		0.367	0.275	3	D6	1	—	—
12		1.75	110	24		0.367	0.275	3	D6	1	46204873 ²⁾	1716722 ²⁾
	14	1.50	22			0.429	0.322	4	D7	1	46204874 ²⁾	—
14		1.50	100	22		0.429	0.322	4	D7	1	—	—
14		2.00	110	26		0.429	0.322	4	D7	1	46204875 ²⁾	—
	16	1.50	22			0.480	0.360	4	D7	1	46204876 ²⁾	—
16		1.50	100	22		0.480	0.360	4	D7	1	—	—
16		2.00	110	27		0.480	0.360	4	D7	1	46204877 ²⁾	1716730 ²⁾
	18	1.50	25			0.542	0.406	4	D7	1	46204878 ²⁾	—
18		1.50	110	25		0.542	0.406	4	D7	1	—	—
20		1.50	125	25		0.652	0.489	4	D7	1	—	—
20		2.50	140	32		0.652	0.489	4	D7	1	46204881 ²⁾	1716738 ²⁾
	24	2.00	27			0.760	0.570	4	D8	1	46204882 ²⁾	—
24		2.00	140	27		0.760	0.570	4	D8	1	—	—
24		3.00	160	34		0.760	0.570	4	D8	1	46204883 ²⁾	—

¹⁾ Reinforced Shanks
²⁾ 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.

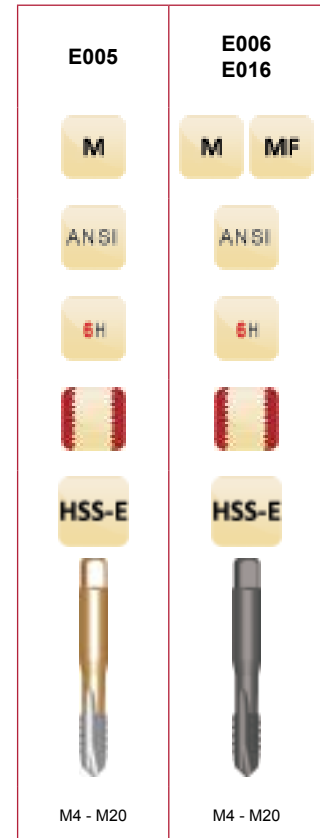
E005 = Metric Coarse

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	l ₁	l ₂	d ₂	a	# of Flutes			l ₄	Limits	Pack Qty	E005	E006 E016
mm		mm	Inch	Inch	Ø Inch	Inch		↔	↔	Inch				
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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

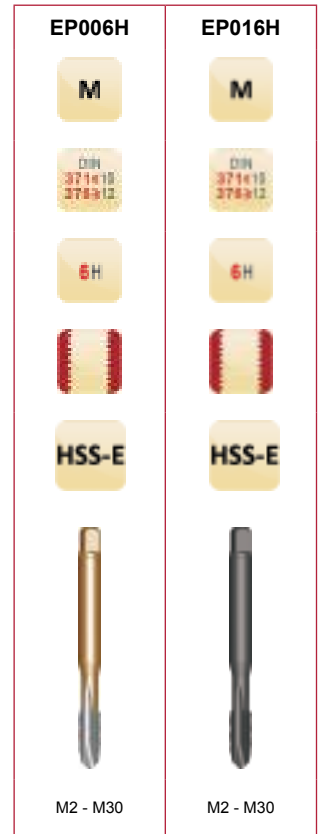
Multi-Application, Plug Chamfer

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

Note: DIN shank and square dimensions will necessitate metric holders

¹⁾ Reinforced Shanks
²⁾ 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 ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ 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

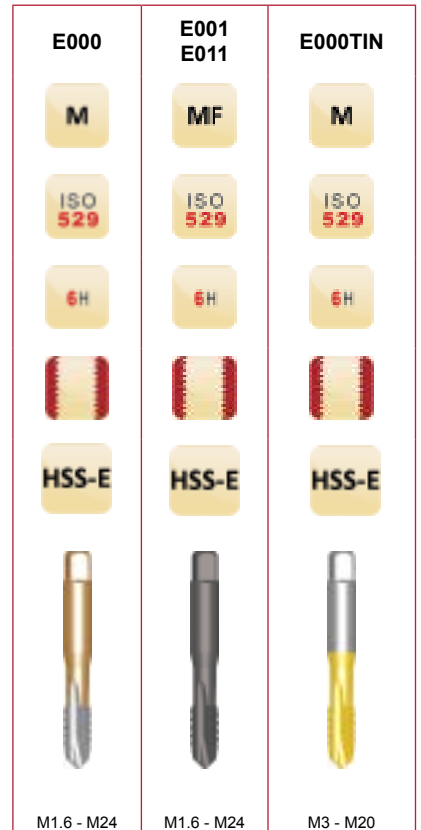
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 3.1 3.2 3.3 3.4 4.1 4.2
5.1 5.2 6.1 6.2 6.3 7.3 7.4 8.2

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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

SPIRAL POINT TAPS



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

¹⁾ Reinforced Shanks

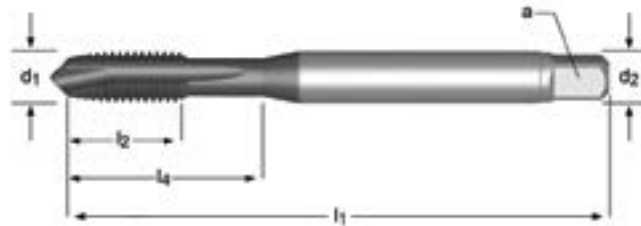
²⁾ Reduced Shanks

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

¹⁾ Reinforced Shanks

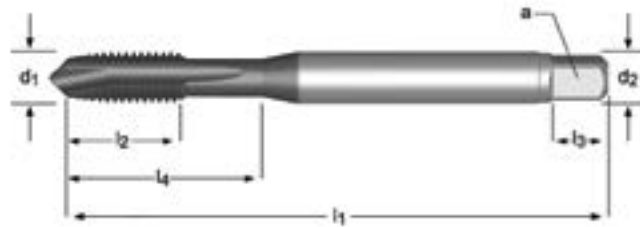
²⁾ Reduced Shanks

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

SH



HSS PM



M3 - M12

M	P mm	l_1 mm	l_2 mm	l_4 Inch (Neck Length)	d_2 Ø Inch	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 ¹⁾
5	0.80	70	15	25	0.194	0.152	3	D4	1	46204834 ¹⁾
6	1.00	80	17	30	0.255	0.191	3	D5	1	46204835 ¹⁾
8	1.25	90	20	35	0.318	0.238	3	D5	1	46204837 ¹⁾
10	1.50	100	22	39	0.381	0.286	3	D6	1	46204829 ¹⁾
12	1.75	110	24		0.367	0.275	3	D6	1	46204831 ²⁾

¹⁾ Reinforced Shanks

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

Note: DIN shank and square dimensions will necessitate metric holders

¹⁾ Reinforced Shanks
²⁾ 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_1 Inch	l_2 Inch	l_3 Inch	d_2 Ø Inch	a Inch	# of Flutes	l_4 Inch	Pack Qty	1985
	4	48	1.7/8	9/16	0.1410	0.1100	3/16	2	0.69	1	1013038 ¹⁾
4		40	1.7/8	9/16	0.1410	0.1100	3/16	2	0.69	1	1013037 ¹⁾
	5	44	1.15/16	5/8	0.1410	0.1100	3/16	2	0.75	1	1013040 ¹⁾
5		40	1.15/16	5/8	0.1410	0.1100	3/16	2	0.75	1	1013039 ¹⁾
	6	40	2"	11/16	0.1410	0.1100	3/16	2	0.78	1	1013042 ¹⁾
6		32	2"	11/16	0.1410	0.1100	3/16	2	0.78	1	1013041 ¹⁾
	8	36	2.1/8	3/4	0.1680	0.1310	1/4	2	0.81	1	1013044 ¹⁾
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	0.81	1	1013043 ¹⁾
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	0.94	1	1013046 ¹⁾
10		24	2.3/8	7/8	0.1940	0.1520	1/4	2	0.94	1	1013045 ¹⁾
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	2	1.19	1	1013050 ¹⁾
1/4		20	2.1/2	1"	0.2550	0.1910	5/16	2	1.19	1	1013049 ¹⁾
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	3	1.31	1	1013052 ¹⁾
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	3	1.31	1	1013051 ¹⁾
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	1.44	1	1013054 ¹⁾
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	3	1.44	1	1013053 ¹⁾
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	3	—	1	1013056 ²⁾
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	3	—	1	1013055 ²⁾
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	—	1	1013058 ²⁾
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	3	—	1	1013057 ²⁾
	9/16	18	3.19/32	1.21/32	0.4290	0.3220	1/2	3	—	1	1013060 ²⁾
9/16		12	3.19/32	1.21/32	0.4290	0.3220	1/2	3	—	1	1013059 ²⁾
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	3	—	1	1013062 ²⁾
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	3	—	1	1013061 ²⁾
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	3	—	1	1013066 ²⁾
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	3	—	1	1013065 ²⁾
	7/8	14	4.11/16	2.7/32	0.6970	0.5230	3/4	4	—	1	1013068 ²⁾
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	—	1	1013067 ²⁾
1"		8	5.1/8	2.1/2	0.8000	0.6000	13/16	4	—	1	1013069 ²⁾

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

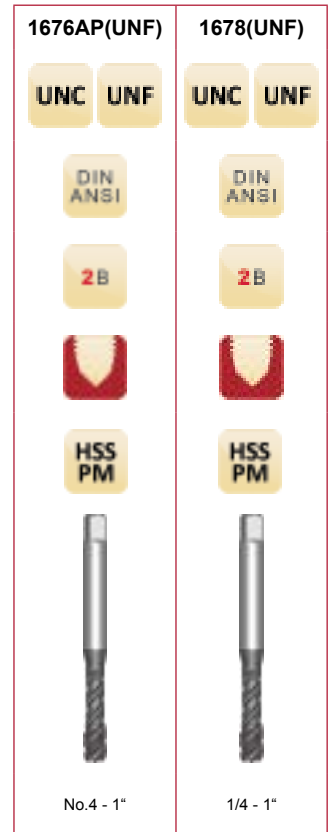


MXL Multi-Application, Semi-Bottoming

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	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 ¹⁾	—
6		32	2.205	0.236	0.787	0.141	0.110	3	H2	1	46204907 ¹⁾	—
8		32	2.480	0.236	0.827	0.168	0.131	3	H3	1	46204912 ¹⁾	—
	10	32	2.756	0.354	0.984	0.194	0.152	3	H3	1	46204895 ¹⁾	—
10		24	2.756	0.354	0.984	0.194	0.152	3	H3	1	46204894 ¹⁾	—
	1/4	28	3.150	0.433	1.181	0.255	0.191	3	H4	1	46204893 ¹⁾	1717512 ¹⁾
1/4		20	3.150	0.433	1.181	0.255	0.191	3	H5	1	46204892 ¹⁾	1717510 ¹⁾
	5/16	24	3.543	0.472	1.378	0.318	0.238	3	H4	1	46204904 ¹⁾	—
5/16		18	3.543	0.472	1.378	0.318	0.238	3	H5	1	46204903 ¹⁾	1717514 ¹⁾
	3/8	24	3.937	0.551	1.535	0.381	0.286	3	H4	1	46204901 ¹⁾	—
3/8		16	3.937	0.551	1.535	0.381	0.286	3	H5	1	46204900 ¹⁾	1717518 ¹⁾
	7/16	20	3.937	0.591		0.323	0.242	3	H5	1	46204909 ²⁾	1717532 ²⁾
7/16		14	3.937	0.591		0.323	0.242	3	H5	1	46204908 ²⁾	1717530 ²⁾
	1/2	20	3.937	0.630		0.367	0.275	3	H5	1	46204891 ²⁾	—
1/2		13	4.331	0.630		0.367	0.275	3	H5	1	46204890 ²⁾	1717534 ²⁾
	5/8	18	3.937	0.745		0.480	0.360	3	H5	1	46204906 ²⁾	—
5/8		11	4.331	0.745		0.480	0.360	3	H5	1	46204905 ²⁾	1717538 ²⁾
	3/4	16	4.331	0.820		0.590	0.442	3	H5	1	46204899 ²⁾	—
3/4		10	4.921	0.820		0.590	0.442	3	H5	1	46204898 ²⁾	1717542 ²⁾
	7/8	14	4.921	0.910		0.697	0.523	4	H6	1	46204910 ²⁾	—
7/8		9	5.512	0.910		0.697	0.523	4	H6	1	46204911 ²⁾	46204932 ²⁾
1"		8	6.299	1.025		0.800	0.600	4	H6	1	46204897 ²⁾	1717546 ²⁾

¹⁾ Reinforced Shanks

²⁾ 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

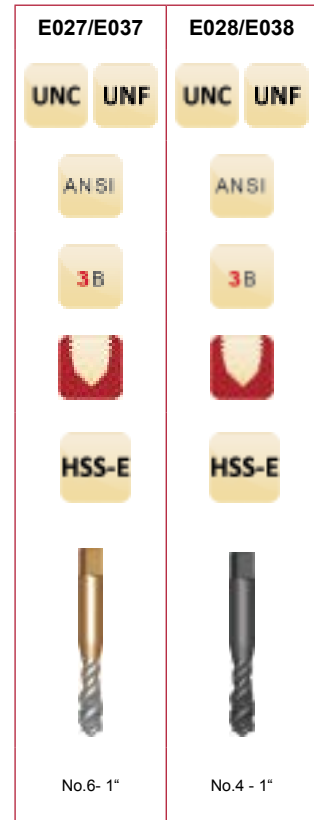
1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 6.1 6.2 6.3 7.1 7.2 7.3
7.4 8.1

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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

³⁾ 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

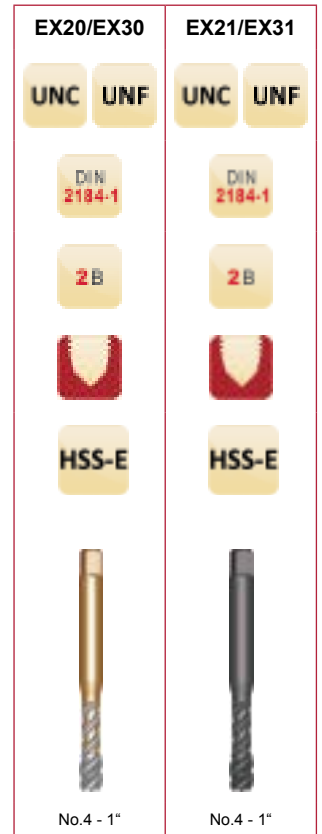
1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

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

Note: DIN shank and square dimensions will necessitate metric holders

¹⁾ Reinforced Shanks

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

Note: ISO shank and square dimensions will necessitate metric holders

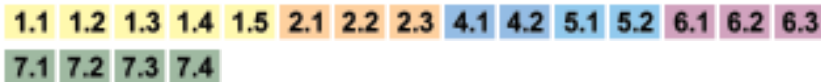
¹⁾ Reinforced Shanks

²⁾ 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.



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_1 mm	l_2 mm	l_4 Inch (Neck Length)	Limits	d_2 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	¹⁾ —
5		0.80	70	9	25	D4	0.194	0.152	3	1	46204928	¹⁾ —
6		1.00	80	11	30	D5	0.255	0.191	3	1	46204929	¹⁾ 1717704
	8	1.00	90	12	35	D5	0.318	0.238	3	1	46205010	¹⁾ —
8		1.25	90	12	35	D5	0.318	0.238	3	1	46204930	¹⁾ 1717706
	10	1.25	100	14	39	D6	0.381	0.286	3	1	46204913	¹⁾ 1717708
10		1.50	100	14	39	D6	0.381	0.286	3	1	46204914	¹⁾ 1717710
	12	1.50	100	16		D6	0.367	0.275	3	1	46204915	²⁾ —
12		1.75	110	16		D6	0.367	0.275	3	1	46204916	²⁾ 1717722
	14	1.50	100	18		D7	0.429	0.322	3	1	46204917	²⁾ —
14		2.00	110	18		D7	0.429	0.322	3	1	46204918	²⁾ 1717726
16		2.00	110	19		D7	0.480	0.360	3	1	46204920	²⁾ 1717730
	18	1.50	110	21		D7	0.542	0.406	3	1	46204921	²⁾ —
18		2.50	125	21		D7	0.542	0.406	3	1	46204922	²⁾ 1717734
	20	1.50	125	21		D7	0.652	0.489	3	1	46204923	²⁾ —
20		2.50	140	21		D7	0.652	0.489	3	1	46204924	²⁾ 1717738
24		3.00	160	26		D8	0.760	0.570	4	1	46204926	²⁾ 1717742

¹⁾ Reinforced Shanks
²⁾ 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

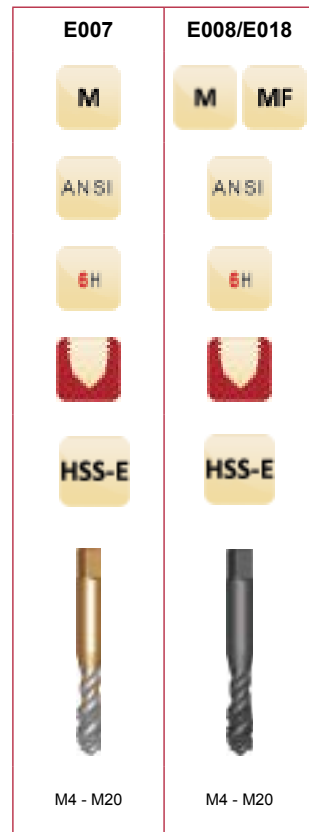
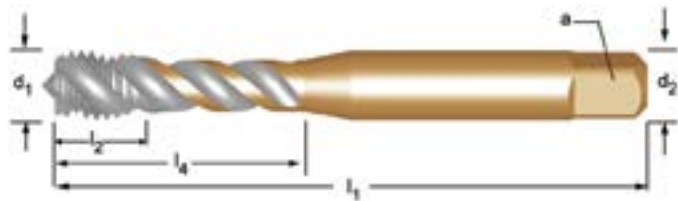
1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

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

E018

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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

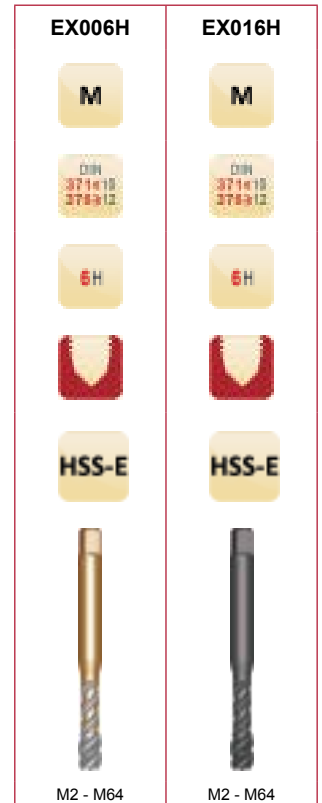
Multi-Application, Semi-Bottoming

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

Note: DIN shank and square dimensions will necessitate metric holders

¹⁾ Reinforced Shanks
²⁾ Reduced Shanks

SPIRAL FLUTE TAPS (45°)



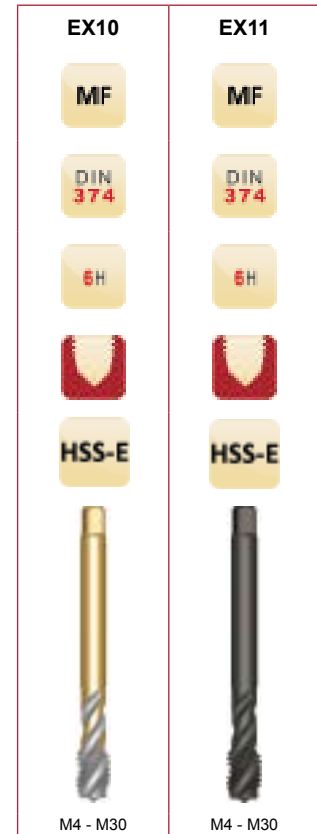
Multi-Application, Semi-Bottoming

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 ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes	Limit	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

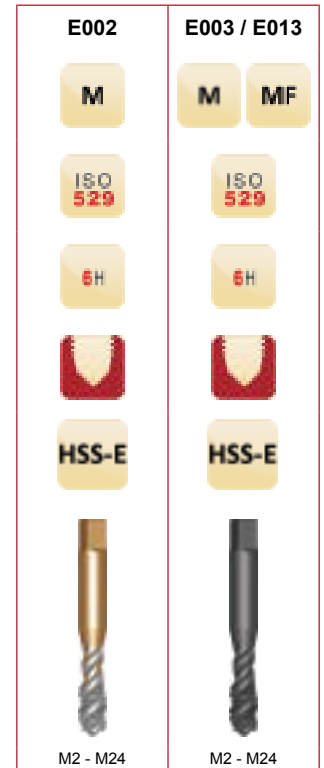
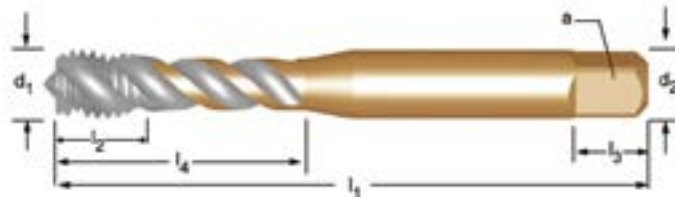
1.1 1.2 1.3 1.4 1.5 4.1 4.2 5.1 5.2 7.1 7.2 7.3 7.4

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

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

¹⁾ Reinforced Shanks

²⁾ 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)



M3 - M12

M	P mm	l_1 mm	l_2 mm	l_4 Inch (Neck Length)	d_2 Ø Inch	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 ¹⁾
5	0.80	70	9	25	0.194	0.152	3	D4	1	46204843 ¹⁾
6	1.00	80	11	30	0.255	0.191	3	D5	1	46204844 ¹⁾
8	1.25	90	12	35	0.318	0.238	3	D5	1	46204846 ¹⁾
10	1.50	100	14	39	0.381	0.286	3	D6	1	46204838 ¹⁾
12	1.75	110	16		0.367	0.275	3	D6	1	46204840 ²⁾

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

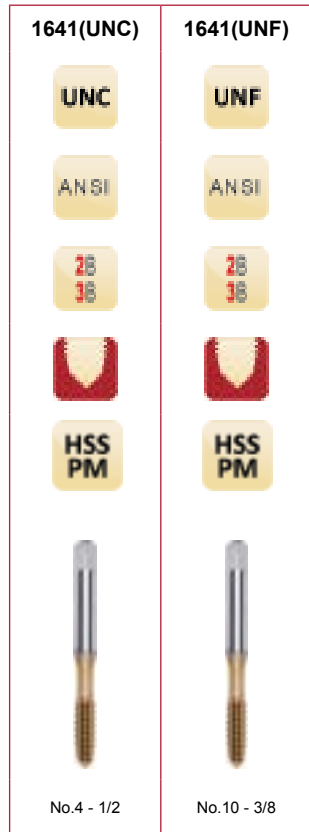
THREAD FORMING TAPS

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



UNC	UNF	TPI	l_1 Inch	l_2 Inch	l_4 Inch (Neck Length)	l_3 Inch	d_2 Ø Inch	a Inch	Limits	Pack Qty	1641(UNC)	1641(UNF)
4		40	1.7/8	5/16	1/4	3/16	0.141	0.110	H3	1	1712221	—
4		40	1.7/8	5/16	1/4	3/16	0.141	0.110	H5	1	1712223	—
6		32	2"	3/8	5/16	3/16	0.141	0.110	H3	1	1712233	—
6		32	2"	3/8	5/16	3/16	0.141	0.110	H5	1	1712235	—
8		32	2.1/8	3/8	3/8	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	3/8	1/4	0.194	0.152	H4	1	—	1712258
	10	32	2.3/8	1/2	3/8	1/4	0.194	0.152	H6	1	—	1712260
10		24	2.3/8	1/2	3/8	1/4	0.194	0.152	H6	1	1712254	—
	1/4	28	2.1/2	5/8	3/8	5/16	0.255	0.191	H4	1	—	1712270
	1/4	28	2.1/2	5/8	3/8	5/16	0.255	0.191	H6	1	—	1712272
1/4		20	2.1/2	5/8	3/8	5/16	0.255	0.191	H4	1	1712264	—
1/4		20	2.1/2	5/8	3/8	5/16	0.255	0.191	H6	1	1712266	—
	5/16	24	2.23/32	11/16	7/16	3/8	0.318	0.238	H7	1	—	1712285
5/16		18	2.23/32	11/16	7/16	3/8	0.318	0.238	H5	1	1712277	—
5/16		18	2.23/32	11/16	7/16	3/8	0.318	0.238	H7	1	1712279	—
	3/8	24	2.15/16	3/4	1/2	7/16	0.381	0.286	H7	1	—	1712297
3/8		16	2.15/16	3/4	1/2	7/16	0.381	0.286	H5	1	1712289	—
3/8		16	2.15/16	3/4	1/2	7/16	0.381	0.286	H7	1	1712291	—
1/2		13	3.3/8	15/16	23/32	7/16	0.367	0.275	H5	1	1712301	—
1/2		13	3.3/8	15/16	23/32	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)

M

ANSI

SH



HSS
PM



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	3/16	3/16	0.141	0.110	D5	1	1713051
4	0.70	2.1/8	3/8	3/8	1/4	0.168	0.131	D6	1	1713052
5	0.80	2.3/8	1/2	3/8	1/4	0.194	0.152	D7	1	1713053
6	1.00	2.1/2	5/8	3/8	5/16	0.255	0.191	D8	1	1713054
8	1.00	2.23/32	11/16	7/16	3/8	0.318	0.238	D9	1	1713055
8	1.25	2.23/32	11/16	7/16	3/8	0.318	0.238	D9	1	1713056
10	1.50	2.15/16	3/4	1/2	7/16	0.381	0.286	D10	1	1713057

THREAD FORMING TAPS

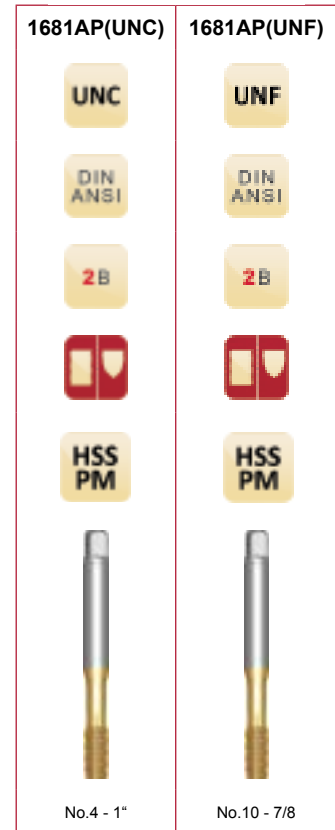
UNION
BUTTERFIELD

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



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

¹⁾ Reinforced Shanks

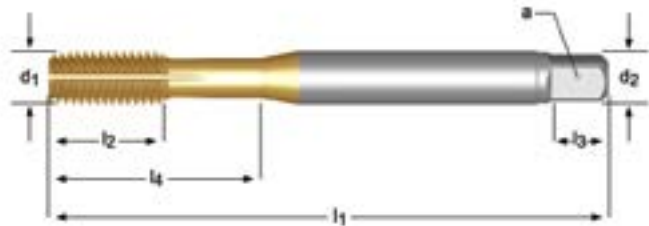
²⁾ Reduced Shanks

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

¹⁾ Reinforced Shanks

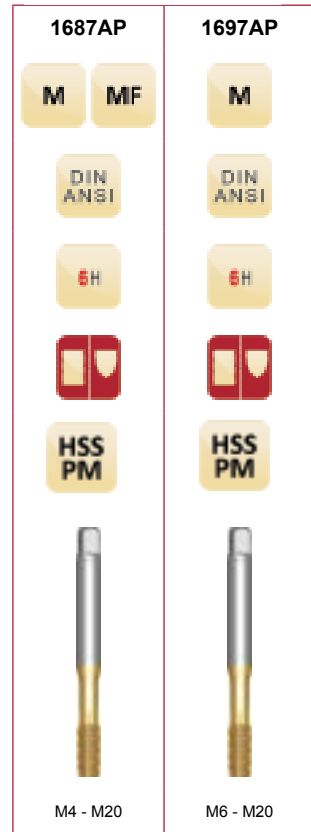
²⁾ Reduced Shanks

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.



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

¹⁾ Reinforced Shanks

²⁾ Reduced Shanks

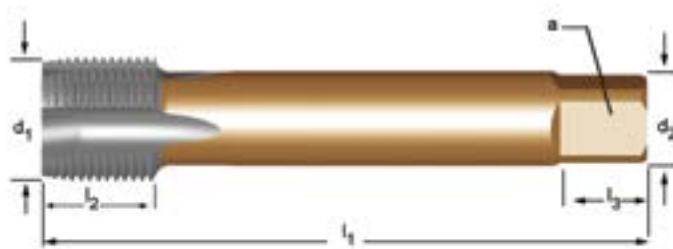
Parallel Thread, G (BSP), Plug Style

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 ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ 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

PIPE TAPS, STRAIGHT FLUTE



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 ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ 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

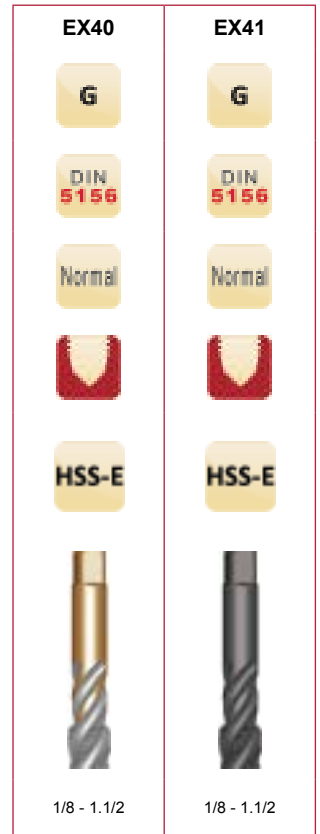
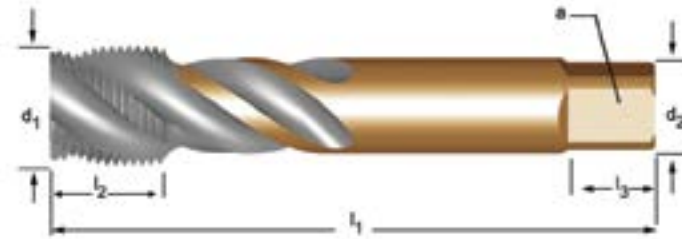
Parallel Thread, G(BSP), Semi- Bottoming

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 ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ 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

PIPE TAPS, SPIRAL FLUTE



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




Normal



HSS-E



1/8 - 3/4

G(BSP)	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ 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

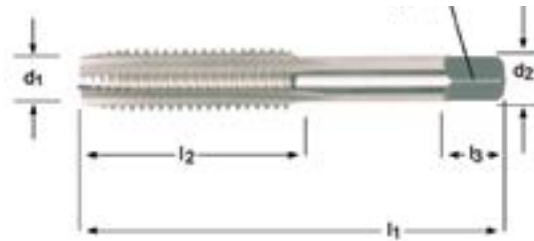
Plug - 3-5 pitch chamfer length

Bottoming - 1-2 pitch chamfer length

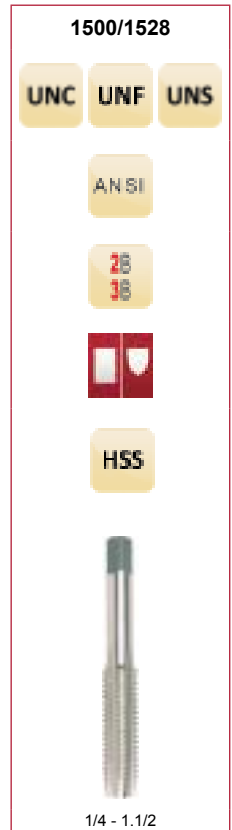
1500 - Fractional sizes

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 ₁	TPI UNC	TPI UNF	TPI UNS	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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		64		1.3/4	7/16	0.1410	0.1100	3/16	3	H2	1	1010609	1010611	1010613	1011003
2				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 ₁	TPI UNC	TPI UNF	TPI UNS	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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
8	32			2.1/8	3/4	0.1680	0.1310	1/4	4	H3	1	1010698	1010701	1010704	1011017
8		36		2.1/8	3/4	0.1680	0.1310	1/4	4	H2	1	1010717	1010719	1010720	1011018
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
10	24			2.3/8	7/8	0.1940	0.1520	1/4	4	H3	1	1010725	1010728	1010731	1011021
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
10		32		2.3/8	7/8	0.1940	0.1520	1/4	4	H3	1	1010746	1010749	1010752	1011024
12	24			2.3/8	15/16	0.2200	0.1650	9/32	4	H3	1	1010765	1010767	1010768	1011025
12		28		2.3/8	15/16	0.2200	0.1650	9/32	4	H3	1	1010769	1010771	1010772	1011026
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	—
1/4	20			2.1/2	1"	0.2550	0.1910	5/16	4	H3	1	1010003	1010006	1010010	1011029
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	—
1/4		28		2.1/2	1"	0.2550	0.1910	5/16	4	H3	1	1010014	1010017	1010021	1011032
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	—
5/16	18			2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	1	1010025	1010028	1010032	1011035
5/16		24		2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	1	1010036	1010039	1010043	1011038
3/8	16			2.15/16	1.1/4	0.3810	0.2860	7/16	4	H2	1	1010046	1010049	1010053	—
3/8	16			2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	1	1010047	1010050	1010054	1011041
3/8	16			2.15/16	1.1/4	0.3810	0.2860	7/16	4	H5	1	—	1010051	1010055	—
3/8		24		2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	1	1010058	1010061	1010065	1011044
7/16	14			3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	1	1010067	1010070	1010074	1011045
7/16		20		3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	1	1010076	1010079	1010083	1011046
1/2	13			3.3/8	1.21/32	0.3670	0.2750	7/16	4	H2	1	—	1010087	1010091	—
1/2	13			3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	1010085	1010088	1010092	1011047
1/2	13			3.3/8	1.21/32	0.3670	0.2750	7/16	4	H5	1	—	1010089	1010093	—
1/2		20		3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	1	1010094	1010097	1010101	1011048
9/16	12			3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	1	1010103	1010106	1010108	1011049
9/16		18		3.19/32	1.21/32	0.4290	0.3220	1/2	4	H3	1	1010110	1010113	1010116	1011050
5/8	11			3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	1	1010118	1010121	1010123	1011051
5/8		18		3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	1	1010125	1010128	1010131	1011052
11/16			11	4.1/32	1.13/16	0.5420	0.4060	5/8	4	H3	1	—	—	—	1011053
11/16			16	4.1/32	1.13/16	0.5420	0.4060	5/8	4	H3	1	—	—	—	1011054
3/4	10			4.1/4	2"	0.5900	0.4420	11/16	4	H3	1	1010139	1010142	1010144	1011055
3/4		16		4.1/4	2"	0.5900	0.4420	11/16	4	H3	1	1010146	1010149	1010152	1011056
7/8	9			4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	1	1010154	1010157	1010159	1011057
7/8		14		4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	1	1010160	1010163	1010166	1011058

HAND TAPS

Nominal d ₁	TPI UNC	TPI UNF	TPI UNS	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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.



¹⁾ Male centers on thread end

²⁾ Female centers / flat ends

1500A

UNC UNF

ANSI

3B

HSS



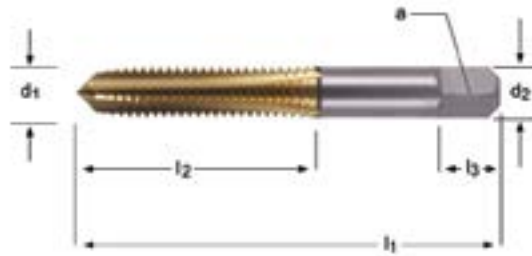
1/4 - 1"

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

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.



¹⁾ Male centers on thread end

²⁾ 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	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 ¹⁾
1/4		20	2.1/2	1.0000	0.2550	0.1910	5/16	4	H3	Plug	1	1060006 ¹⁾
	5/16	24	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1060039 ¹⁾
5/16		18	2.23/32	1.1/8	0.3180	0.2380	3/8	4	H3	Plug	1	1060028 ¹⁾
	3/8	24	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1060061 ¹⁾
3/8		16	2.15/16	1.1/4	0.3810	0.2860	7/16	4	H3	Plug	1	1060050 ¹⁾
	7/16	20	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1060079 ²⁾
7/16		14	3.5/32	1.7/16	0.3230	0.2420	13/32	4	H3	Plug	1	1060070 ²⁾
	1/2	20	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1060097 ²⁾
1/2		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Plug	1	1060088 ²⁾
		13	3.3/8	1.21/32	0.3670	0.2750	7/16	4	H3	Bottoming	1	1060092 ²⁾
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Plug	1	1060121 ²⁾
	5/8	18	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Bottoming	1	1060131 ²⁾
5/8		11	3.13/16	1.13/16	0.4800	0.3600	9/16	4	H3	Bottoming	1	1060123 ²⁾
	3/4	16	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Bottoming	1	1060152 ²⁾
3/4		10	4.1/4	2"	0.5900	0.4420	11/16	4	H3	Bottoming	1	1060144 ²⁾
7/8		9	4.11/16	2.7/32	0.6970	0.5230	3/4	4	H4	Plug	1	1060157 ²⁾

HAND TAPS



General Purpose

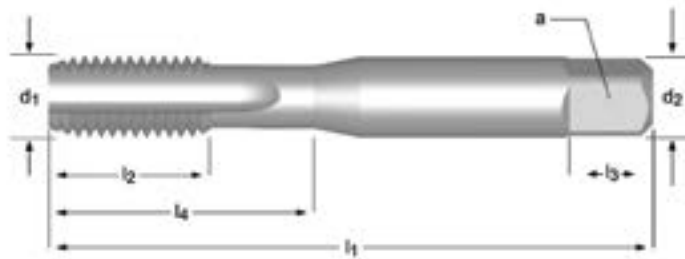
E500 The most versatile taps for hand use or machine tapping in a wide variety of materials in through or blind hole applications. Available in 3 chamfer lengths - taper, plug, and bottoming.

Taper - 7-10 pitch chamfer length

Plug - 3-5 pitch chamfer length

Bottoming - 1-2 pitch chamfer length

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



E500

M

ISO
529

EH



HSS




M1 - M56

Note: ISO shank and square dimensions will necessitate metric holders

Nominal d ₁	Pitch M	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes	Flute Depth mm	l ₄ mm	Pack Qty	Taper	Plug	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

HAND TAPS

Nominal d ₁	Pitch M	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes	 mm	l ₄ mm	Pack Qty	Taper	Plug	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

HAND TAPS

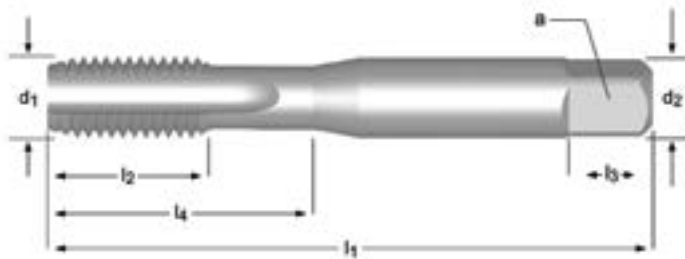


General Purpose

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 bottoming.

Taper - 7-10 pitch chamfer length
 Plug - 3-5 pitch chamfer length
 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

EH



HSS




M3 - M50

Note: ISO shank and square dimensions will necessitate metric holders

Nominal d ₁	Pitch MF	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	# of Flutes	l ₃ mm	l ₄ mm	Pack Qty	Taper	Plug	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

HAND TAPS

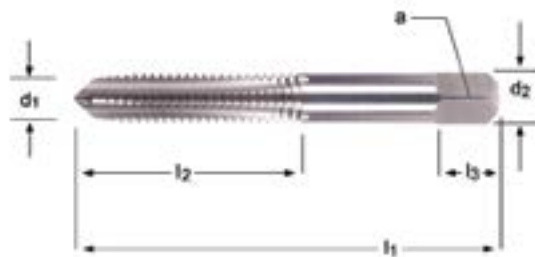
Nominal d ₁	Pitch MF	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	# of Flutes	l ₃ mm		l ₄ mm	Pack Qty	Taper	Plug	Bottoming	2 Pc Sets	3 Pc Sets
18	1.00	112	29	14.00	11.20	4	14	17		1	0156896	0096277	0096284	0096291	—
18	1.50	112	29	14.00	11.20	4	14	16.5		1	0156902	0152584	0096260	0155479	0156919
18	2.00	112	29	14.00	11.20	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

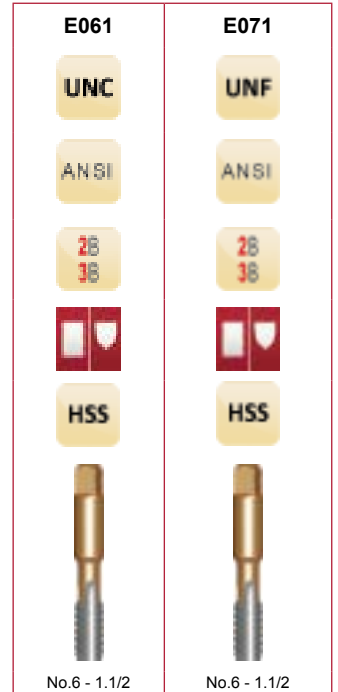
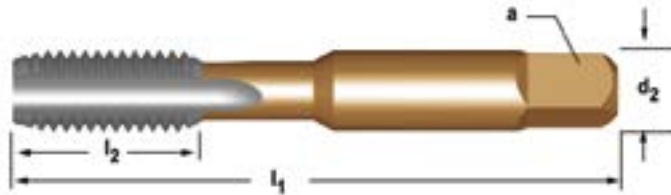
General Purpose

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 bottoming.

Taper - 7-10 pitch chamfer length
 Plug - 3-5 pitch chamfer length
 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 ₁	TP UNC UNF	TPI UNC UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	# of Flutes	Limits	Chamfer		l ₄ Inch	Pack Qty	Taper	Plug	Bottoming	Sets
									++	++						
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	0348802	0348819	0348826 ¹⁾	
1"	12	5.1/8	1.4173	0.8000	0.6000	4	H4	59/64	23.25		1	0349939	0349946	0349953	0349960 ¹⁾	
1"	14	5.1/8	1.4173	0.8000	0.6000	4	H4	59/64	23.25		1	0349977	0349984	0349991	0350003 ¹⁾	
1.1/8	7	5.7/16	1.3976	0.8950	0.6710	4	H4	63/64	25.00		1	0388112	0388129	0388136	0259719 ¹⁾	
1.1/8	12	5.7/16	1.3976	0.8950	0.6710	4	H4	1.3/64	26.50		1	0388235	0388242	0388259	—	
1.1/4	7	5.3/4	1.6338	1.0210	0.7650	4	H4	1.7/64	28.00		1	0388143	0388150	0388167	0259702 ¹⁾	
1.1/4	12	5.3/4	1.6338	1.0210	0.7650	4	H4	1.5/32	29.50		1	0388266	0388273	0388280	—	
1.3/8	6	6.1/16	1.8700	1.1090	0.8300	4	H4	1.7/32	30.75		1	0388174	0388181	0388198	—	
1.3/8	12	6.1/16	1.8700	1.1090	0.8300	4	H4	1.9/32	32.75		1	0388297	0388303	0388310	—	
1.1/2	6	6.3/8	1.8700	1.2330	0.9520	4	H4	1.11/32	34.00		1	0388204	0388211	0388228	0259696 ¹⁾	
1.1/2	12	6.3/8	1.8700	1.2330	0.9250	4	H4	1.27/64	36.00		1	0388327	0388334	0388341	—	

¹⁾ 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

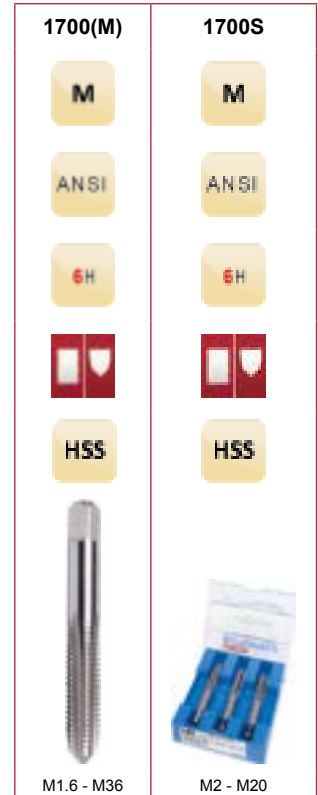
		l_1	l_2	d_2	a	l_3				Pack Qty	1508(UNC)	1508(UNF)	1595	
UNC	UNF	TPI	Inch	Inch	Inch	Inch	# of Flutes	Limits	Chamfer					
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Plug	1	—	1010223	—
	1/4	28	2.1/2	1"	0.2550	0.1910	5/16	2	H3	Plug	1	—	—	1010208
	1/4	20	2.1/2	1"	0.2550	0.1910	5/16	3	H3	Plug	1	1010216	—	—
1/4		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 ₁	Pitch M	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	l ₃ 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	—

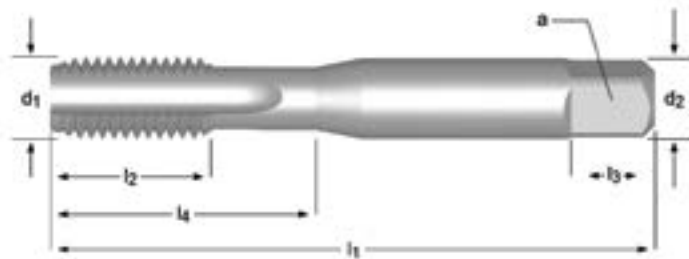
HAND TAPS



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 bottoming chamfer. For through or blind hole applications.



E501

M

ISO
529

5H



HSS



M3 - M24

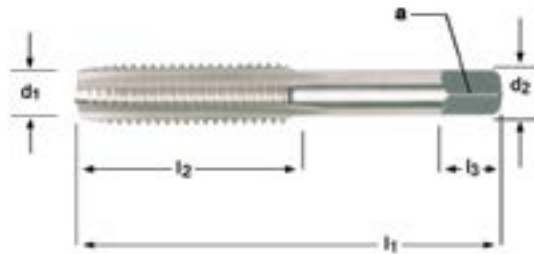
Nominal d ₁	Pitch M	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes	Flute Width mm	l ₄ mm	Limits	Pack Qty	Taper	Plug	Bottoming
3	0.50	48	12.5	3.15	2.50	5	3	2.5	12.5	D3	1	0159828	0095058	0095065
4	0.70	53	14	4.00	3.15	6	3	3.3	14	D4	1	0159835	0095072	0095089
5	0.80	58	11	5.00	4.00	7	3	4.2	22	D4	1	—	0095096	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



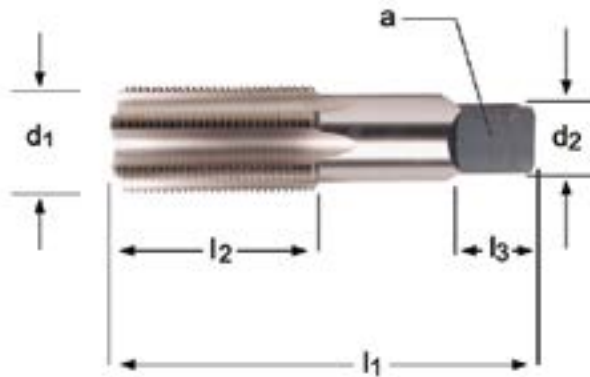
1/4 - 5/8

UNC	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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



H55



1.1/8 - 2"

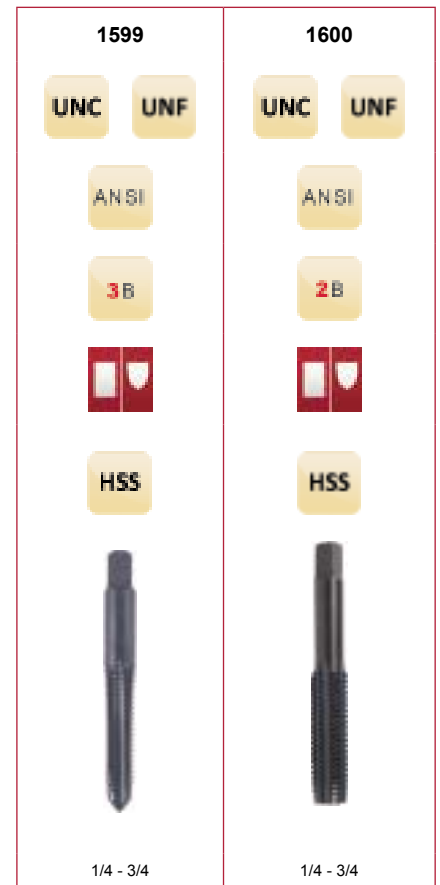
Nominal d_1	TPI UNC/UNS	l_1 Inch	l_2 Inch	d_2 Ø Inch /	a Inch	l_3 Inch	# of Flutes	Limits	Pack Qty	Taper	Plug	Bottoming
1.1/8	8	5.7/16	2.9/16	0.8960	0.6720	7/8	4	H5	1	1013310	1013311	1013312
1.1/4	8	5.3/4	2.9/16	1.0210	0.7660	1"	4	H5	1	1013313	1013314	1013315
1.3/8	8	6.1/16	3"	1.1080	0.8310	1.1/16	4	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



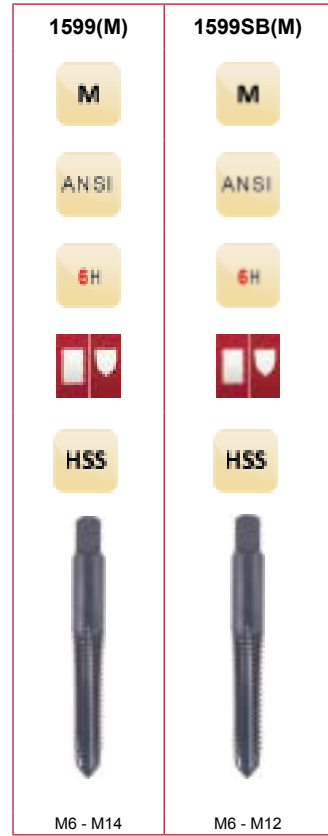
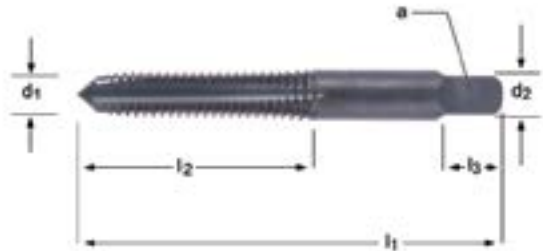
Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ Inch	# of Flutes	Limits	Pack Qty	1599 Plug	1599 Bottoming	1600 Plug	1600 Bottoming
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	4	H3	1	1010256	1010257	—	—
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	4	H5	1	—	—	1011256	1011257
1/4		28	2.1/2	1"	0.2550	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.

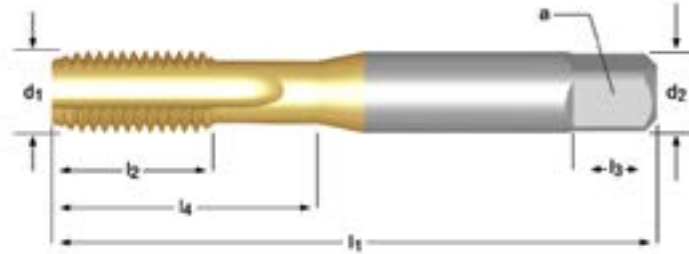
1599SB(M)



Nominal d ₁	Pitch M	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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



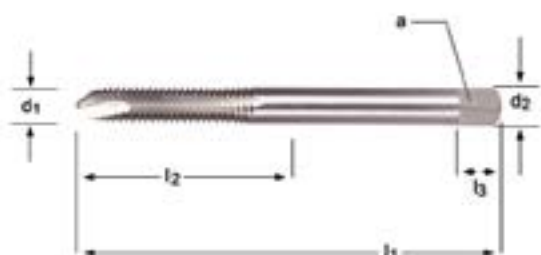
Relieved Style, Machine Screw Sizes

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	a	l_3	# of Flutes	Limits	Chamfer	Pack Qty	1534	TN1534
UNC	UNF	TPI	Inch	Inch	Inch	Inch	Inch						
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	1.15/16	5/8	0.1410	0.1100	3/16	2	H2	Bottoming	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	Plug	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	36	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	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	—
8		32	2.1/8	3/4	0.1680	0.1310	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	—
	12	28	2.3/8	15/16	0.2200	0.1650	9/32	2	H3	Bottoming	1	1012380	—
12		24	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

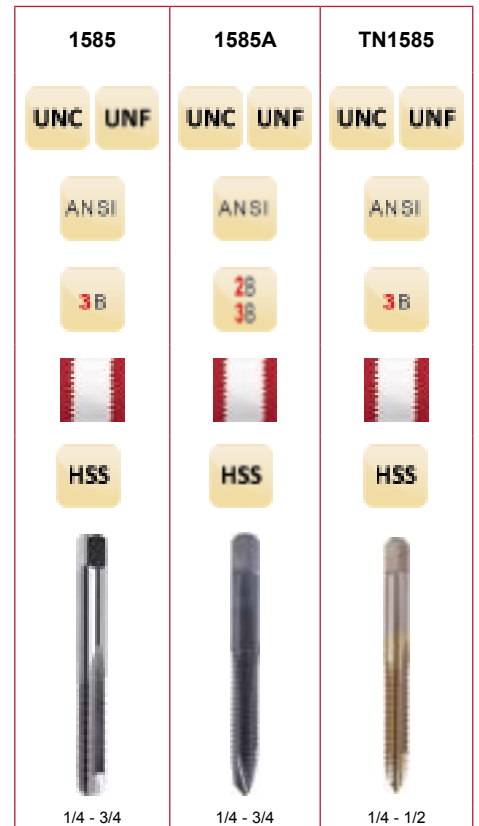
- 1585** Spiral point taps are designed to solve the problem of tap breakage in through hole applications in a variety of materials.
- 1585A** The angular flutes in the cutting face propel the chips ahead of the cutting zone, thus reducing loading and clogging in the flutes.
- TN1585**

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.



		l_1	l_2	d_2	l_3	a	# of Flutes	Limits	Chamfer	Pack Qty	1585	1585A	TN1585	
UNC	UNF	TPI	Inch	Inch	Inch	Inch	Inch							
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	—	—
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	

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	Inch	Inch	Flutes	Limits	Chamfer	Qty			
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



N4 - N10

UNC	UNF	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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



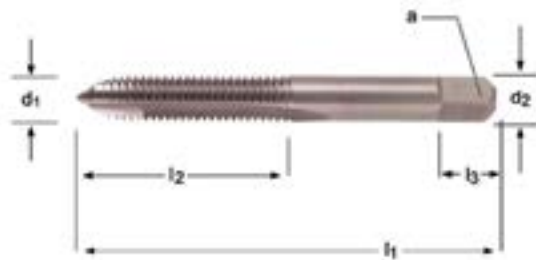
Relieved Style, Metric

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.

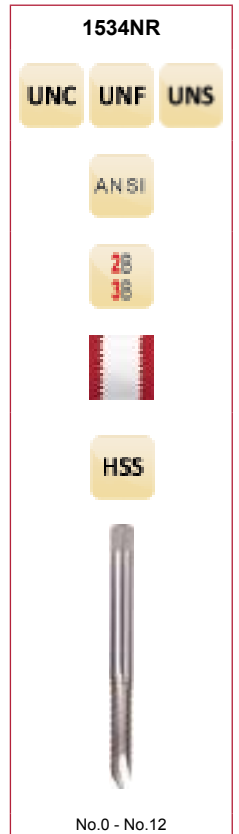
Bright Finish - improves chip flow in soft or non-ferrous materials.
TiN Coating - increases surface hardness and improves tool life.



M	P mm	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch	l ₃ 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	0.1310	1/4	0.1680	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	0.1520	1/4	0.1940	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"	0.1910	5/16	0.2550	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	0.2380	3/8	0.3180	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	0.2860	7/16	0.3810	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	0.2750	7/16	0.3670	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.



UNC	UNF	UNS	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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			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		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	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

28
36



HSS



1/4 - 3/4

Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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	20		2.1/2	1"	0.2550	0.1910	5/16	2	H3	1	1012815	1012817
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	2	H5	1	1012816	—
1/4	20		2.1/2	1"	0.2550	0.1910	5/16	3	H3	1	1012818	—
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		28	2.1/2	1"	0.2550	0.1910	5/16	2	H3	1	1012822	1012824
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	2	H2	1	1012828	—
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	2	H3	1	1012829	—
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	2	H5	1	1012830	—
5/16	18		2.23/32	1.1/8	0.3180	0.2380	3/8	3	H3	1	1012832	1012831
5/16		24	2.23/32	1.1/8	0.3180	0.2380	3/8	2	H3	1	1012836	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H2	1	1012842	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1012843	—
3/8	16		2.15/16	1.1/4	0.3810	0.2860	7/16	3	H5	1	1012844	—
3/8		24	2.15/16	1.1/4	0.3810	0.2860	7/16	3	H3	1	1012847	—
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H2	1	1012849	—
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1012850	—
7/16	14		3.5/32	1.7/16	0.3230	0.2420	13/32	3	H5	1	1012851	—
7/16		20	3.5/32	1.7/16	0.3230	0.2420	13/32	3	H3	1	1012853	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H2	1	1012856	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1012857	—
1/2	13		3.3/8	1.21/32	0.3670	0.2750	7/16	3	H5	1	1012858	—
1/2		20	3.3/8	1.21/32	0.3670	0.2750	7/16	3	H3	1	1012861	—
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		18	3.13/16	1.13/16	0.4800	0.3600	9/16	3	H3	1	1012867	—
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		16	4.1/2	2"	0.5900	0.4420	11/16	3	H3	1	1012868	—

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	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	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

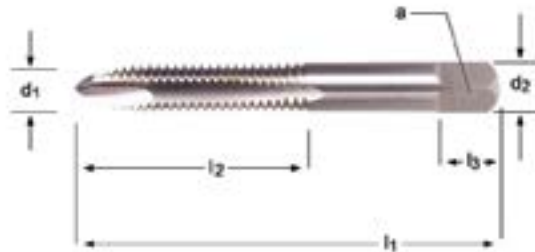


Overdose / Relieved Style

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
ZB		ZB
HSS		HSS
N6 - N10		1/4 - 5/8

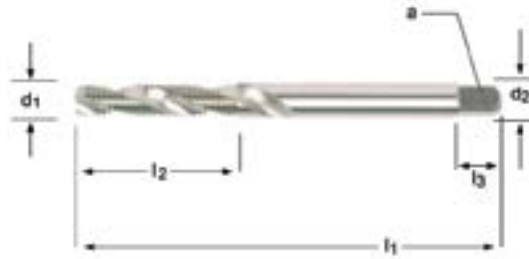
UNC	UNF	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	a Inch	l_3 Inch	# of Flutes	Limits	Chamfer	Pack Qty	1593	1585OV
6		32	2"	11/16	0.1410	0.1100	3/16	2	H7	Plug	1	1010877	—
8		32	2.1/8	3/4	0.1680	0.1310	1/4	2	H7	Plug	1	1010879	—
	10	32	2.3/8	7/8	0.1940	0.1520	1/4	2	H7	Plug	1	1010883	—
10		24	2.3/8	7/8	0.1940	0.1520	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 ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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

28
38



HSS



N4 - 1/2

Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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



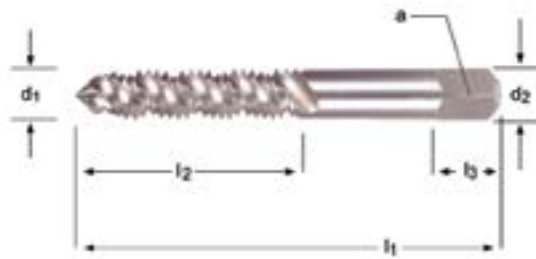
N6 - 1/2

Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	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

EH



HSS



M3 - M12

Nominal d_1	Pitch M	l_1 Inch	l_2 Inch	d_2 \varnothing Inch /	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

2
3

HSS



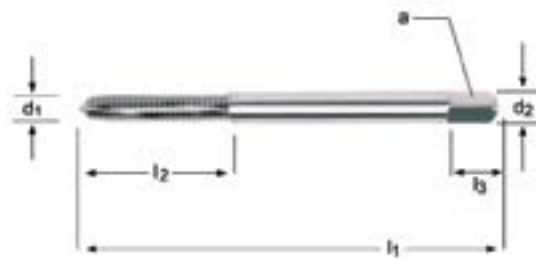
N2 - 3/8

Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ ∅ Inch /	a Inch	l ₃ 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

H



HSS

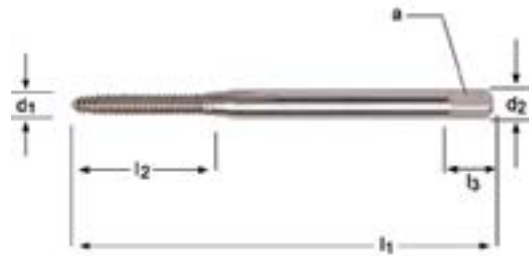


M3 - M12

Nominal d_1	Pitch M	l_1 Inch	l_2 Inch	d_2 Ø Inch /	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

26 16

HSS

N0 - 1/2

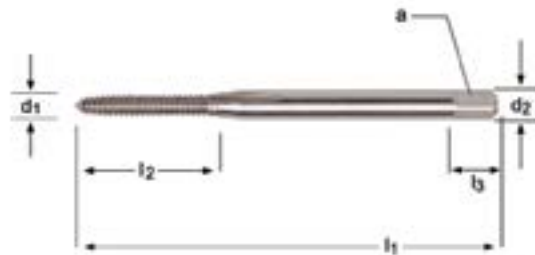
Nominal d ₁	TPI UNC	TPI UNF	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ Inch	Limits	Pack Qty	Plug	Bottoming
0		80	1.5/8	5/16	0.1410	0.1100	3/16	H2	1	—	1310110
1	64		1.11/16	3/8	0.1410	0.1100	3/16	H2	1	—	1310111
1		72	1.11/16	3/8	0.1410	0.1100	3/16	H2	1	—	1310112
2	56		1.3/4	7/16	0.1410	0.1100	3/16	H2	1	—	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

EH



HSS



M3 - M10

Nominal d_1	Pitch M	l_1 Inch	l_2 Inch	d_2 Ø Inch /	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	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

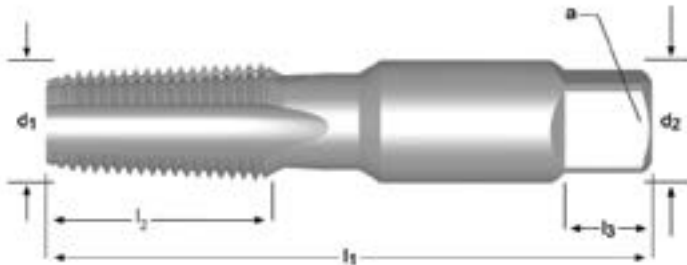
General Purpose, Medium Hook, NPT

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



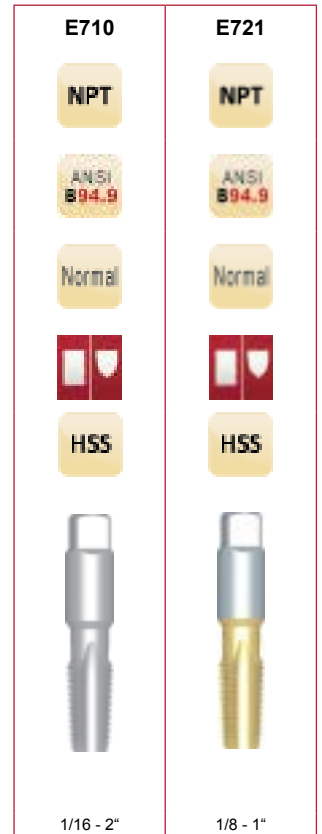
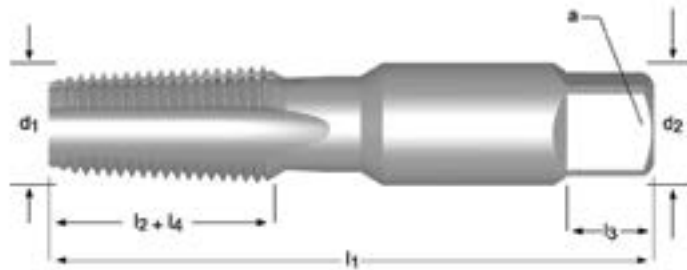
1541(NPT)	TN1541
1/16 - 2"	1/8 - 3/4"

Nominal d ₁	TPI	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ 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.



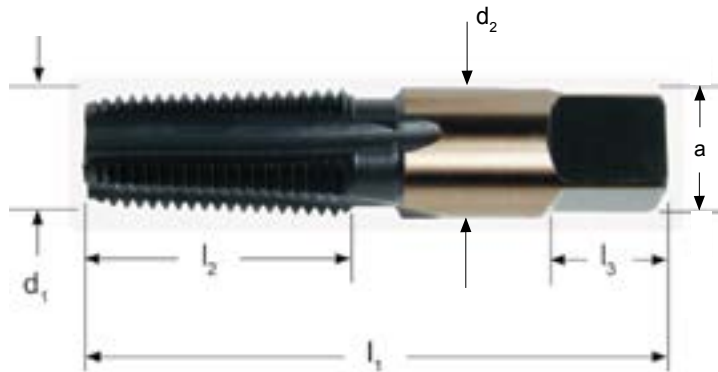
Nominal d ₁	TPI	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm		# of Flutes	l ₄ mm	Pack Qty	E710		E721	
1/16	27	65	17	7.9	5.9	8	6.3	4	11.7	1	0159491	—		
1/8	27	70	19	11.1	8.3	10	8.5	4	11.9	1	0099889	0161463		
1/4	18	75	27	14.3	10.7	11	11	4	17.6	1	0099872	0161470		
3/8	18	80	27	17.8	13.5	13	14.5	4	19.5	1	0099919	0161487		
1/2	14	100	35	17.5	13.1	16	18	4	22.7	1	0099865	0161494		
3/4	14	105	35	23.0	17.2	17	23	5	24.4	1	0099902	0161500		
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	—		

* Sets (No. 7) include:
 1 pc 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



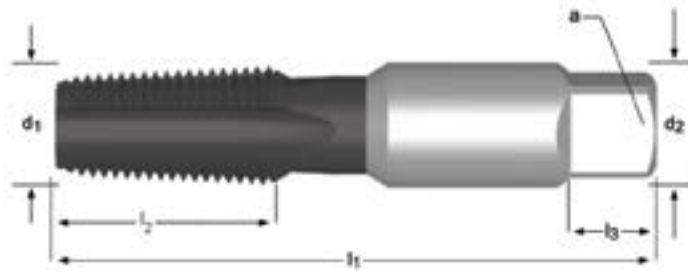
1/8 - 2"

NPT	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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

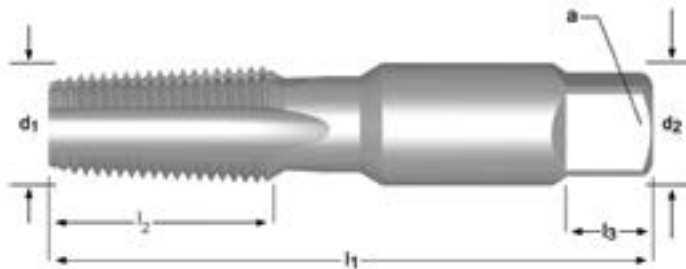
NPT	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	a Inch	l_3 Inch	# of Flutes	Pack Qty	1544
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1011760
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1011761
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1011762
3/8	18	2.9/16	1.1/16	0.7000	0.5310	1/2	4	1	1011763
1/2	14	3.1/8	1.3/8	0.6880	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
NPT	NPT
ANSI	ANSI
Normal	Normal
HSS	HSS
1/18 - 1"	1/16 - 3/4

NPT	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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"

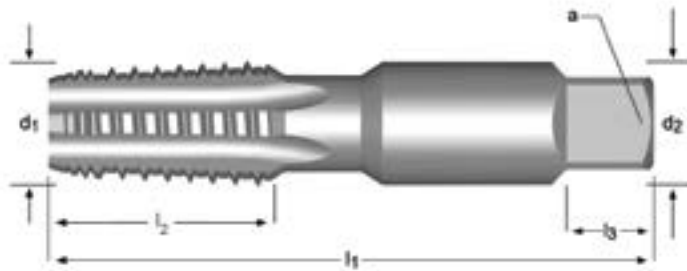
		l_1	l_2	d_2 Ø	a	l_3	# of Flutes	Pack Qty	1548
NPT	TPI	Inch	Inch	Inch	Inch	Inch			
1/16	27	2.1/8	11/16	0.3130	0.2340	3/8	4	1	1010920
1/8	27	2.1/8	3/4	0.3130	0.2340	3/8	4	1	1010924
1/8	27	2.1/8	3/4	0.4380	0.3280	3/8	4	1	1010922
1/4	18	2.7/16	1.1/16	0.5630	0.4210	7/16	4	1	1010926
3/8	18	2.9/16	1.1/16	0.7000	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

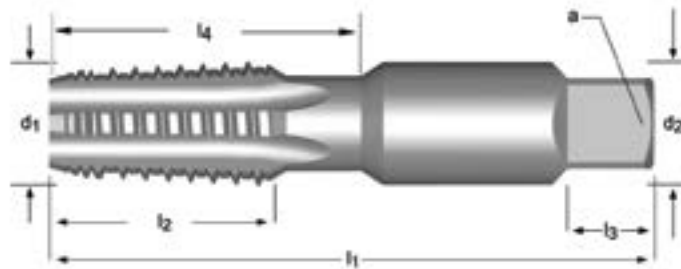


1/8 - 1.1/2

		l_1	l_2	d_2	a	l_3	# of Flutes	Pack Qty	1568
NPT	TPI	Inch	Inch	Ø Inch	Inch	Inch			
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

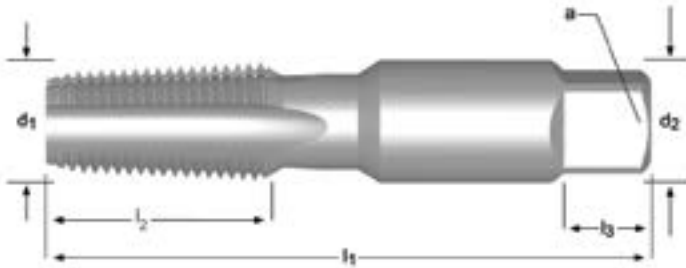
NPT	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes	Pack Qty	E711	
1/8	27	10.29	70	19	309	11.1	8.3	10	5	8.5	1	0099957
1/4	18	13.72	75	27	44.6	14.3	10.7	11	5	11.0	1	0099940
3/8	18	17.15	80	27	46.5	17.8	13.5	13	5	14.5	1	0099971
1/2	14	21.33	100	35	57.7	17.5	13.1	16	5	18.0	1	0099933
3/4	14	26.67	105	35	59.4	23.0	17.2	17	5	23.0	1	0099964
1"	11.5	33.40	115	43	72.4	28.6	21.4	21	5	29.0	1	0099926
1.1/2	11.5	48.26	135	43	71.9	38.1	28.6	25	7	44.0	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 ∅ Inch	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



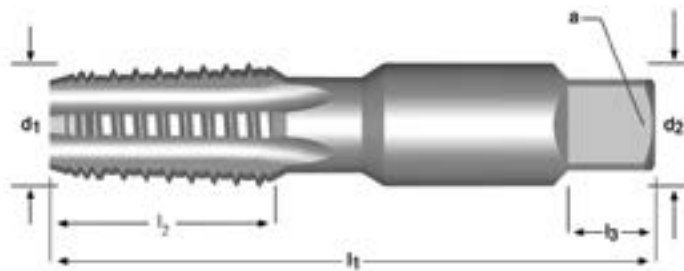
1/16 - 3/4

NPTF		l_1	l_2	d_2 Ø	a	l_3	# of Flutes	Pack Qty	1549
TPI	Inch	Inch	Inch	Inch	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

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

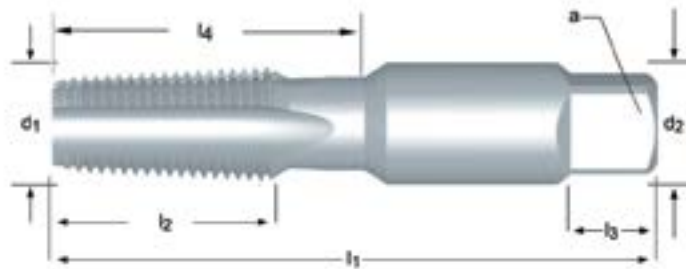


1/8 - 1"

NPTF	TPI	l_1 Inch	l_2 Inch	d_2 Ø Inch	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

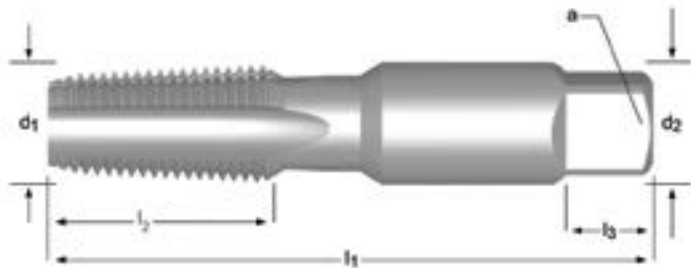
NPTF	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes		Pack Qty	E712
1/16	27	7.94	65	17	11.7	8.1	6.0	8	4	6.20	1	0100004
1/8	27	10.29	70	19	11.9	11.1	8.3	10	4	8.40	1	0100035
1/4	18	13.72	75	27	17.6	14.3	10.7	11	4	10.90	1	0100028
3/8	18	17.15	80	27	19.5	17.8	13.5	13	4	14.25	1	0100059
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 NPS - 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.

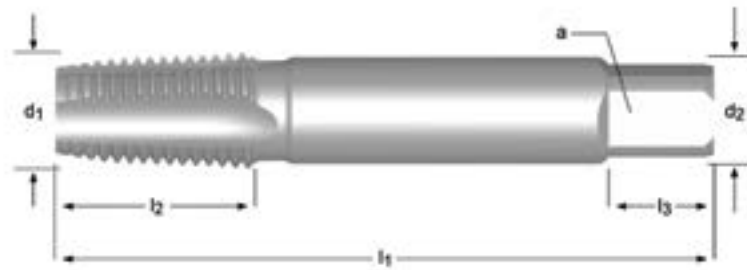


1542	1592
NPSM	NPSF
ANSI	ANSI
Normal	Normal
HSS	HSS
1/8 - 1"	1/8 - 3/4"

Nominal d ₁	TPI	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch /	a Inch	l ₃ Inch	# of Flutes	Pack Qty	1542	1592
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 ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ 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	0159408
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	0159422
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	0159446
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	0159460
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	0159484
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

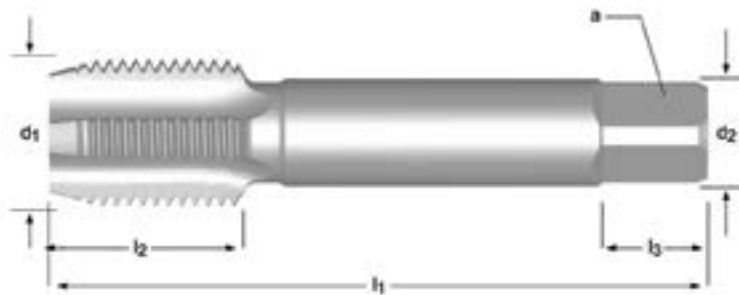
- * Sets (No. 7) include:
- 1 pc semi-bottoming +
 - 1 pc semi-bottoming (Truncated)

PIPE TAPS



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
2204


Normal



HSS



1/8 - 2"

Nominal d_1	TPI	l_1 mm	l_2 mm	d_2 \varnothing mm	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

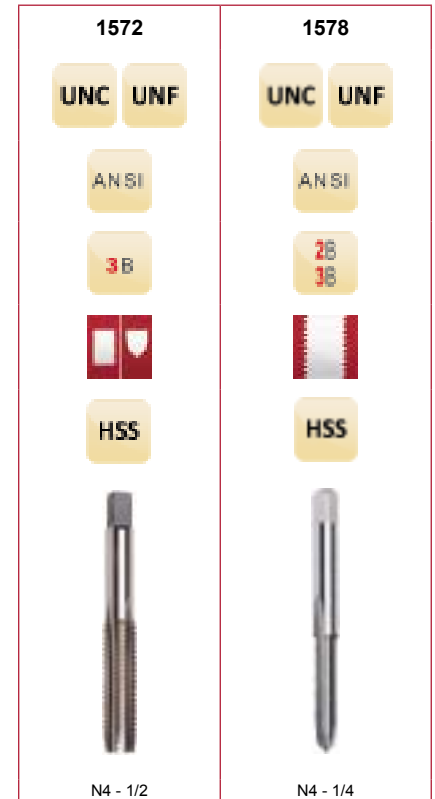
Note: ISO shank and square dimensions will necessitate metric holders

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_1	TPI UNC	TPI UNF	l_1 Inch	l_2 Inch	d_2 \emptyset Inch /	a Inch	l_3 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	3	H3	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

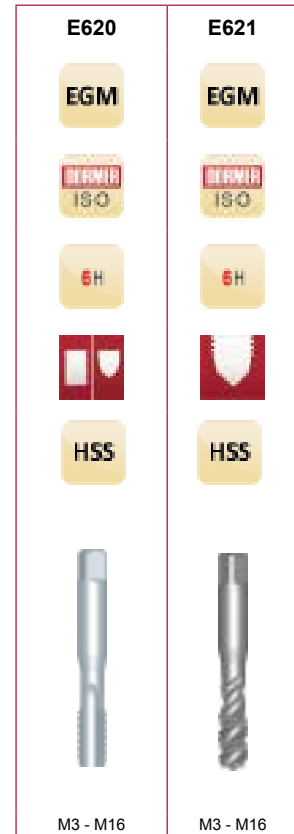
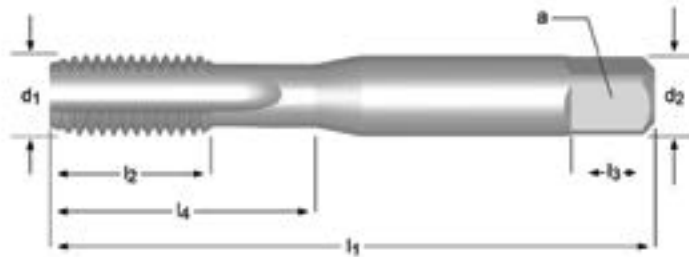


Screw Thread Insert, STI, Semi-Bottoming

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 ₁	P mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	a mm	l ₃ mm	# of Flutes		l ₄ 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	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	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 ₁ Ø Inch	l ₁ Inch	l ₂ Inch	d ₂ Ø Inch	a Inch	l ₃ Inch	l ₄ 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



HSS



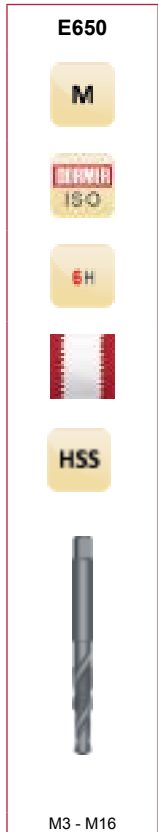
No.6 - 5/8

UNC	UNF	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ 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 ₁ Ø	l ₁	l ₂	l ₄	d ₂ Ø	a	l ₃	# 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

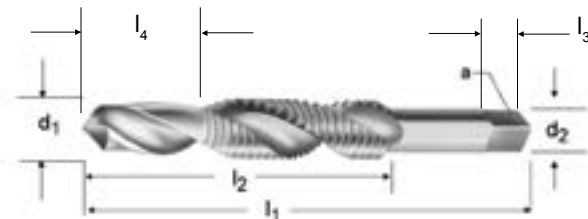
SPECIAL PURPOSE TAPS



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 ₁ nom Inch	l ₁ Inch	l ₂ Inch	l ₃ Inch	l ₄ Inch	d ₂ 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	1215
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 ₁ 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	19"	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, R15P & R18P). Metal index.



229SET

UNC

ANSI

HSS



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:		
Standard:		
Tolerance:		
Chamfer:		
Tool Material:		
Direction of Cut:		
Finish/Coating:		
Style:	2010(UNC)	2010(UNF)
Range:	No.4 - 1.1/2	No.10 - 1.1/2

Application Material Groups (AMG)			Hardness HRC	Page #	334	334
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	Bakelitt, 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
					1.75KP	1.75KP		1.75KP
	CS	CS	HSS	HSS	HSS	HSS	HSS	HSS
	2010(UNS)	2010(NPT)	2510(UNC)	2510(UNF)	F320	F330	2710M	F370
	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
	334	334	336	336	338	338	340	341
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



	M	UNC	UNF	UNS	NPT	M	M	MF
	ISO 2568	ANSI	ANSI	ANSI	ANSI	ANSI	BS 1127: 1950	BS 1127: 1950
	6g						6g	6g
	1.75KP						1.75KP	1.75KP
	HSS	CS	CS	CS	CS	CS	HSS	HSS
	F201	2025(UNC)	2025(UNF)	2025(UNS)	2025(NPT)	2325M	F302	F312
	M3 - M20	1/4 - 1.1/2	1/4 - 1.1/2	11/16 - 1"	1/8 - 1"	M6 - M20	M3 - M36	M8 - M24
	342	343	343	343	343	344	345	346
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								



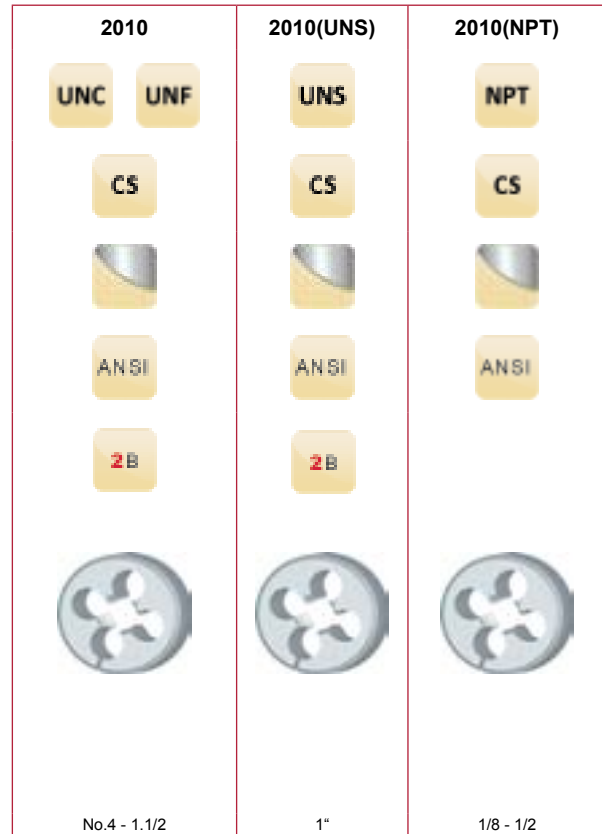
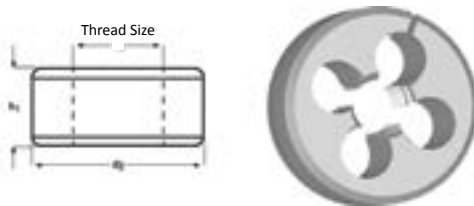
Pgs. 330-348

1301.....	347
2010.....	334
2025.....	343
2325M.....	344
2510.....	336
2710M.....	340
8007.....	347
F201	342
F302	345
F312	346
F320	338
F330	338
F370	341
L110.....	348

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



UNC	UNF	UNS	NPT	TPI	d ₂ Ø Inch	h ₁ 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			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

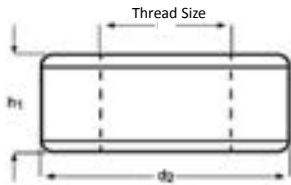
UNC	UNF	UNS	NPT	TPI	d ₂ Ø Inch	h ₁ Inch	Pack Qty	2010 (UNC)(UNF)	2010 (UNS)	2010 (NPT)
	7/16			20	1.1/2	1/2	1	1410107	—	—
7/16				14	1"	3/8	1	1410101	—	—
7/16				14	1.1/2	1/2	1	1410103	—	—
	1/2			20	1.1/2	1/2	1	1410114	—	—
1/2				13	1.1/2	1/2	1	1410110	—	—
1/2				13	2"	5/8	1	1410111	—	—
			1/4	18	1.1/2	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



2510(UNC)	2510(UNF)
UNC	UNF
HSS	HSS
ANSI	ANSI
2B	2B
N5 - 7/8	N5 - 7/8

UNC	UNF	TPI	d ₂ Ø Inch	h ₁ 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 ₂ ∅ Inch	h ₁ 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	—

DIES

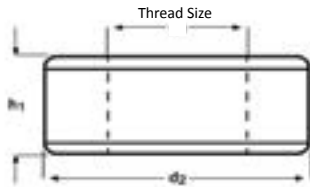


Round Adjustable, Split Type

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 ₁ nom mm	d ₂ Ø Inch	h ₁ 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	—
8		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	—

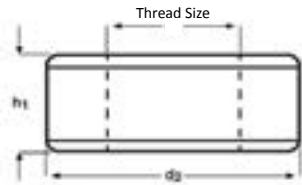
DIES

UNC	UNF	TPI	d ₁ nom mm	d ₂ ∅ Inch	h ₁ 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

SH



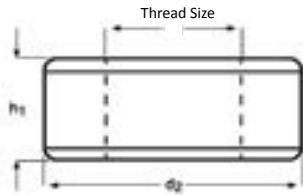
M2 - M20

M	P mm	d ₂ Ø Inch	h ₁ 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

B8
11271
1950

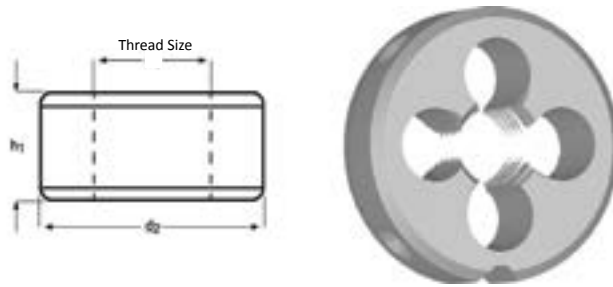
1/8 - 1.1/2

G(BSP)	TPI	d_1 nom mm	d_2 Ø Inch	h_1 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

SH



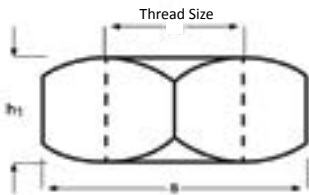
M3 - M20

M	P mm	d ₂ Ø mm	h ₁ 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



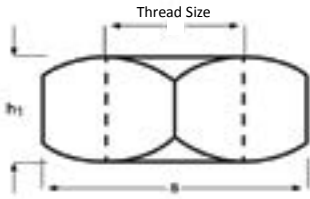
2025(UNC)	2025(UNF)	2025(UNS)	2025(NPT)
UNC	UNF	UNS	NPT
CS	CS	CS	CS
ANSI	ANSI	ANSI	ANSI
2B	2B	2B	
1/4 - 1.1/2	1/4 - 1.1/2	11/16 - 1"	1/8 - 1"

UNC	UNF	UNS	NPT	TPI	S Inch	h ₁ 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	—	—	—
	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	—	—	—
	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	—	—	—
		1/4		18	1.1/4	5/8	1	—	—	—	1410271
	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	—	—	—
		3/8		18	1.1/16	5/8	1	—	—	—	1410272
		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	—	—	—
		1/2		14	1.5/8	3/4	1	—	—	—	1410273
	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	—	—	—
		3/4		14	2"	13/16	1	—	—	—	1410274
	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"		11.5	2.3/8	1"	1	—	—	—	1410275
	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

EH

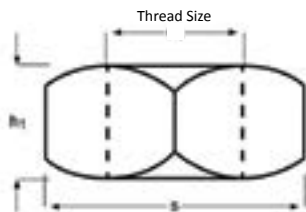
M6 - M20

M	P mm	S Inch	h ₁		Pack Qty	2325M
			Inch			
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

11271
1950

EH

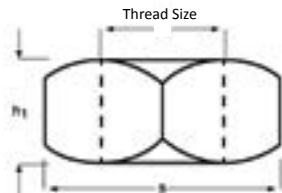
M3 - M36

M	P mm	S decimal Inch	h ₁ 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

H55

H8
1127
1950

SH

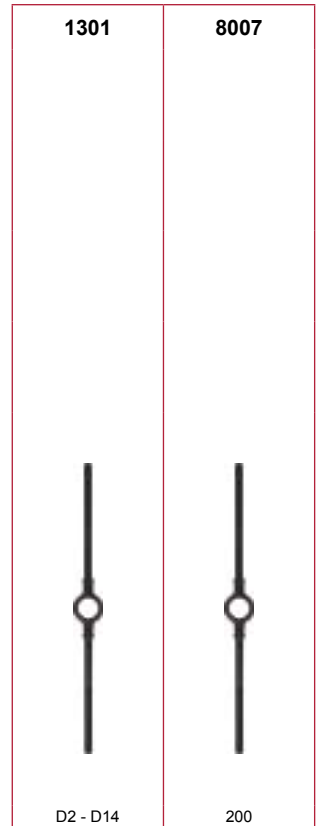
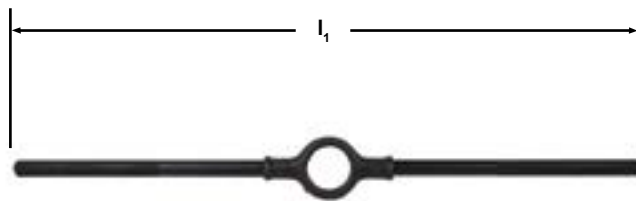
M8 - M24

MF	P mm	S decimal Inch	h ₁ 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	0.007	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	0.003	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			

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, 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	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 4	Z 4	Z 4	Z 4	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2	Z 2
Cut Length:																
Helix:	42°	30°	37°	45°	45°	45°	λ°	λ°	λ°	30°	30°	30°	30°	30°	30°	30°
Shank:																
Finish/Coating:																
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 #	356	357	358	359	360	361	362	363	364	365	366	366	367	368	369	369
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 2	Z 3	Z 3	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	Z 4	
	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	
	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	Normal	
	EB3302	EB3302V	EB3302M	EB3302MV	EB5302	EB6302	EB6302V	E3303	E3303V	E4304	E3304	E3304V	E3304M	E3304MV	E5304	E5304V	E6304
	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"
	370	370	371	371	372	373	373	374	374	375	376	376	377	377	378	378	379
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																	

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HSS-E PM	HSS	HSS	HSS	HSS-E	HSS-E PM	HSS	HSS
	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
	30°	30°	30°	30°	30°	30°	30°	30°	30°	30° 12'	30°	30°	30°	30°	30° 12'	30°	38°
	TAK	TAK	TAK	TAK	TAK	TAK	TAK	TAK	TAK	OH 1820					OH 1820		
	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"
	379	380	380	381	381	382	382	383	383	384	386	387	388	389	390	392	393
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 Z	Z Z	Z Z	Z 4-6	Z 4-6	Z 4-6	Z 4-6	Z 4-6	Z 4-6	Z 4	Z 4	Z 4-6	Z 4-6	Z 4	Z 4-6	Z 4-6
	38°	30°	30° 12°	30°	30°	30°	30°	30°	30°	30°	30°	30° 12°	30° 12°	10°	30°	30°
	+0.03 -0.00	+0.03 -0.00	ø8	+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
	981	930	C346	9002	TC9002	9003	TC9003	9009	9008	948	945	C247	C273	883	940	960
	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"
	394	395	396	397	398	398	398	399	400	401	402	403	405	407	408	409
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	131T	148T	164T	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		



Pgs. 350-409

883..... 407	E3304 376	EB6304V 383
905..... 392	E3304M 377	S400HA 356
920..... 387	E3304MV 377	S401HA 357
923..... 386	E3304V 376	S402HA 358
930..... 395	E4302 365	S403HA 359
940..... 408	E4304 375	S404HA 360
945..... 402	E5302 368	S405HA 361
948..... 401	E5304 378	S406HA 362
960..... 409	E5304V 378	S406HB 363
963..... 389	E6302 369	S407HA 364
980..... 393	E6302V 369	TC9002 397
981..... 394	E6304 379	TC9003 398
9002..... 397	E6304V 379	
9003..... 398	EB3302 370	
9008..... 400	EB3302M 371	
9009..... 399	EB3302MV .. 371	
920K 388	EB3302V 370	
C110 384	EB3304 380	
C123 390	EB3304M 381	
C247 403	EB3304MV .. 381	
C273 405	EB3304V 380	
C346 396	EB5302 372	
E3302 366	EB5304 382	
E3302M 367	EB5304V 382	
E3302V 366	EB6302 373	
E3303 374	EB6302V 373	
E3303V 374	EB6304 383	

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.



S400HA

HM



W



1/16 - 3/4

Cutting Diameter Tolerance = + 0 / - 0.0012"

Shank Diameter Tolerance = + 0 / - 0.0003"

d ₁ Ø Inch	d ₁ decimal Inch	d ₂ Ø Inch	l ₂ Inch	l ₁ 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



Solid Carbide 2-Flute End Mill

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"

S401HA

HM

5/32 - 3/4

d ₁ Ø Inch	d ₁ decimal Inch	r ± 0.0010	d ₂ Ø Inch	l ₂ Inch	l ₁ Inch	# of Flutes	l ₃ Inch	d ₃ 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

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 ₁ Ø Inch	d ₁ decimal Inch	r ± 0.0010	d ₂ Ø Inch	l ₂ Inch	l ₁ Inch	# of Flutes	l ₃ Inch	d ₃ 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

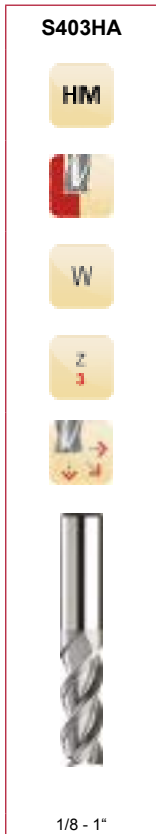
Solid Carbide 3-Flute End Mill

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"



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 ₁ Ø Inch	d ₁ decimal Inch	r ± 0.0010	d ₂ Ø Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	d ₁ decimal Inch	r Inch	d ₂ Ø Inch	l ₂ Inch	l ₁ 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 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



S406HA

HM



N



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

Solid Carbide 4-Flute End Mill

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"

S406HB

HM



N



3/8 - 1"

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

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"



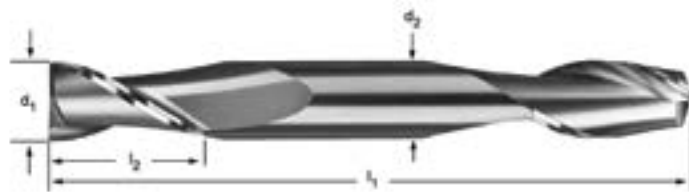
d_1 Ø Inch	d_1 decimal Inch	r ± 0.0012	d_2 Ø Inch	l_2 Inch	l_1 Inch	# of Flutes	Pack Qty	S407HA
1/8	0.1250	0.010	1/8	3/8	1.1/2	4	1	46612317
3/16	0.1875	0.010	3/16	7/16	2"	4	1	46612318
1/4	0.2344	0.015	1/4	1/2	2.1/2	4	1	46612319
5/16	0.3125	0.015	5/16	13/16	2.1/2	4	1	46612320
3/8	0.3750	0.015	3/8	7/8	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



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	E4302
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

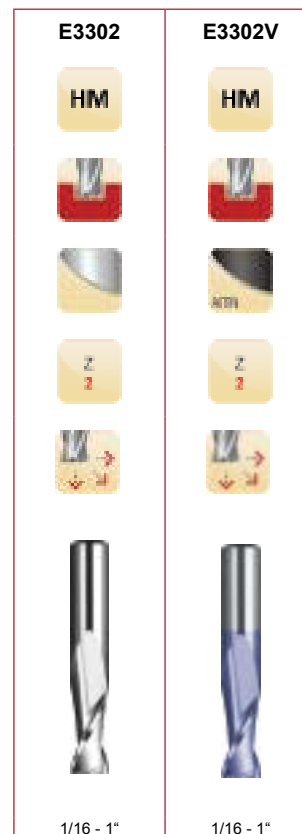
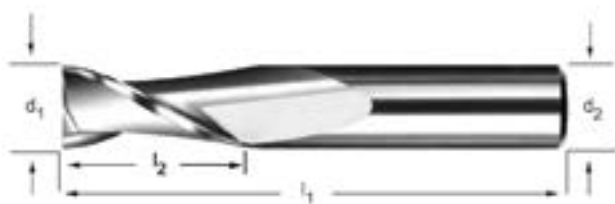
Solid Carbide 2 Flute End Mill



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



2.00 - 25.00

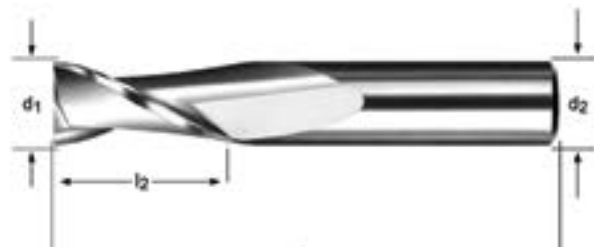
d ₁ Ø mm	d ₁ decimal Inch	d ₂ Ø mm	l ₂ mm	l ₁ mm	# of Flutes	Pack Qty	E3302M
2.00	0.0787	3.0	6.0	38.0	2	1	001028
2.50	0.0984	3.0	7.0	38.0	2	1	001029
3.00	0.1181	3.0	12.0	38.0	2	1	001030
4.00	0.1575	4.0	14.0	50.0	2	1	001032
4.50	0.1772	5.0	14.0	50.0	2	1	001033
5.00	0.1969	5.0	16.0	50.0	2	1	001034
6.00	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

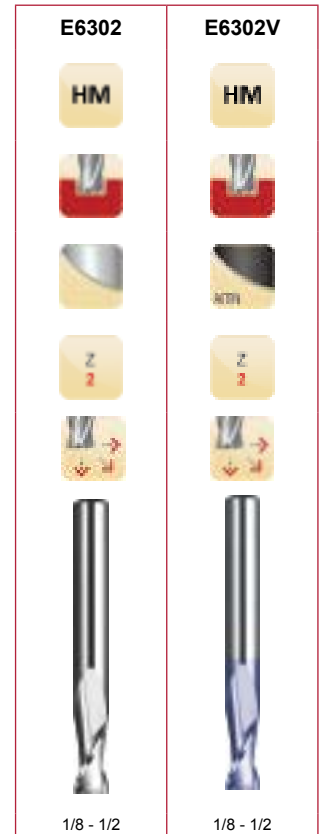


Solid Carbide 2 Flute End Mill

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	E6302	E6302V
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

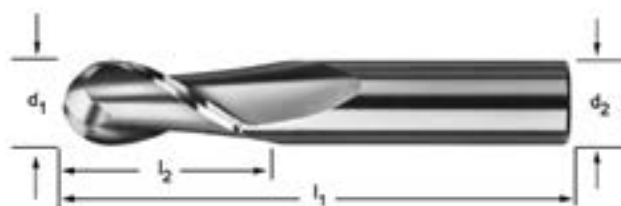
Solid Carbide 2 Flute End Mill



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

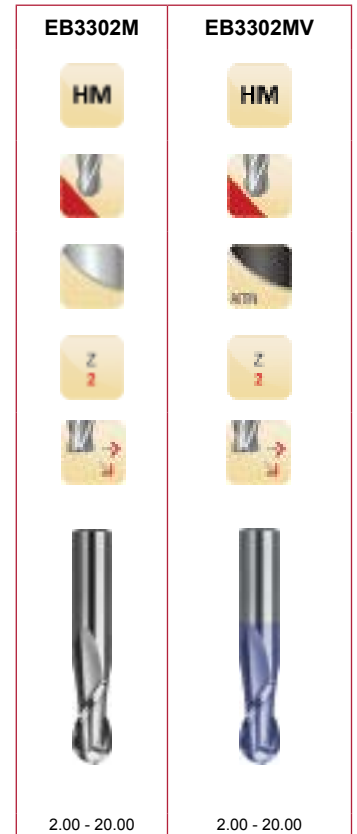


Solid Carbide 2 Flute End Mill

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.



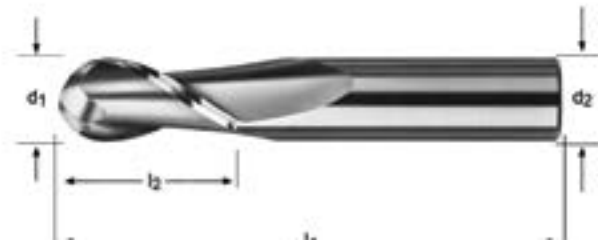
d_1 Ø mm	d_1 decimal Inch	d_2 Ø mm	l_2 mm	l_1 mm	# of Flutes	Pack Qty	EB3302M	EB3302MV
2.00	0.0787	3.0	6.0	38.0	2	1	001228	—
2.50	0.0984	3.0	6.0	38.0	2	1	001229	—
3.00	0.1181	3.0	12.0	38.0	2	1	001230	004402
4.00	0.1575	4.0	14.0	50.0	2	1	001232	004404
5.00	0.1969	5.0	16.0	50.0	2	1	001234	004406
6.00	0.2362	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

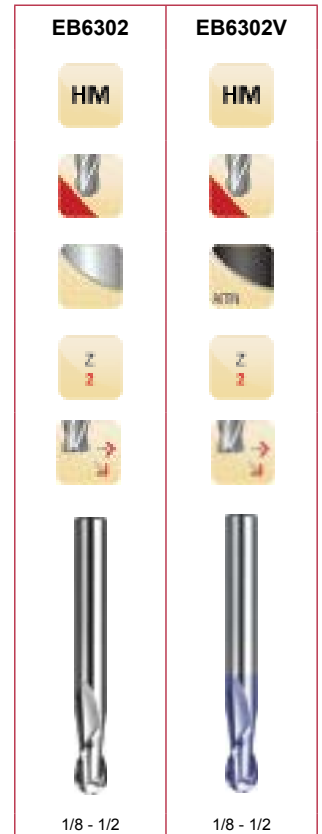


Solid Carbide 2 Flute End Mill

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

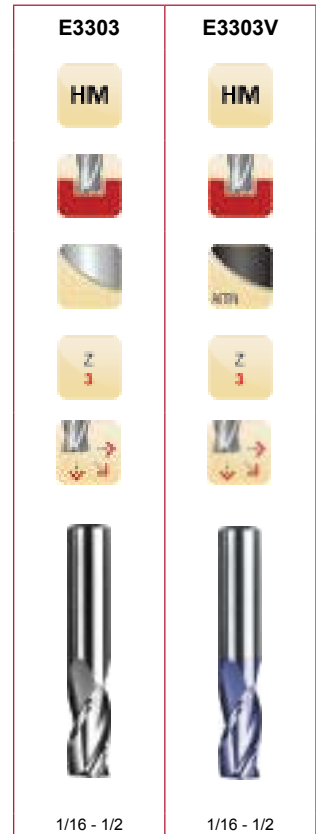
Solid Carbide 3 Flute End Mill



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	E3303	E3303V
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.



E4304

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	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 ₁ Ø Inch	d ₁ decimal Inch	d ₂ Ø Inch	l ₂ Inch	l ₁ 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_1 Ø mm	d_1 decimal Inch	d_2 Ø mm	l_2 mm	l_1 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

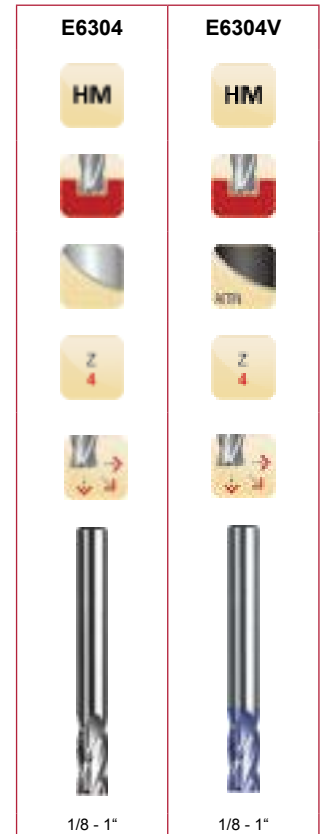


Solid Carbide 4 Flute End Mill

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

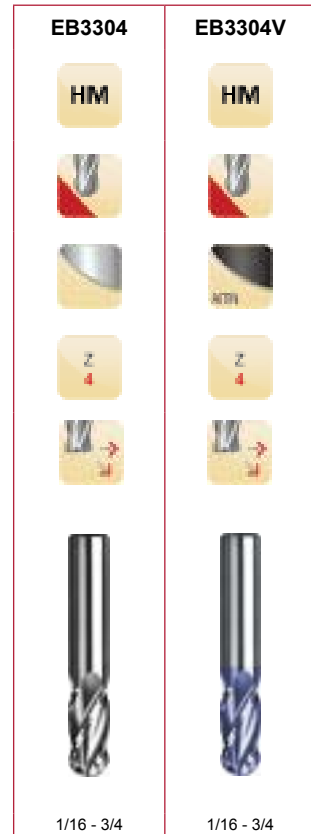
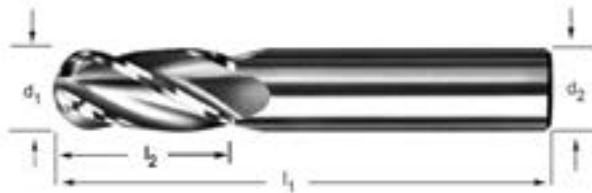
Solid Carbide 4 Flute End Mill



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

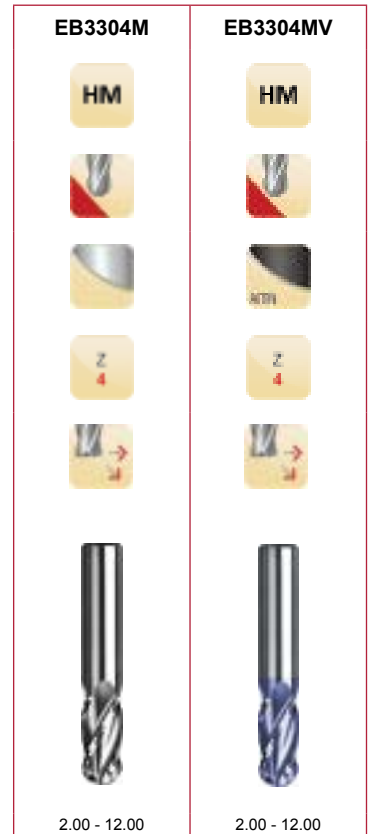


Solid Carbide 4 Flute End Mill

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
11.00	0.4331	11.0	25.0	70.0	4	1	—	—
12.00	0.4724	12.0	25.0	75.0	4	1	001331	004763

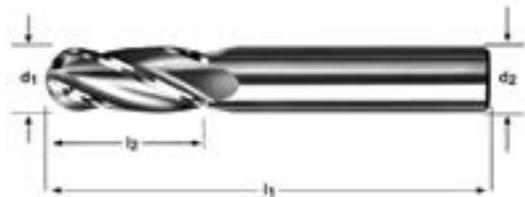
Solid Carbide 4 Flute End Mill



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

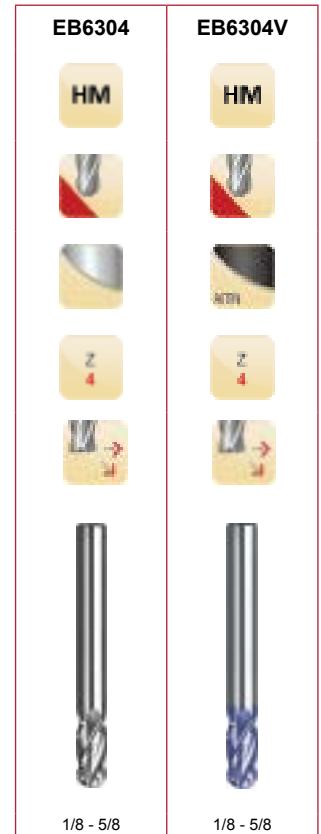


Solid Carbide 4 Flute End Mill

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



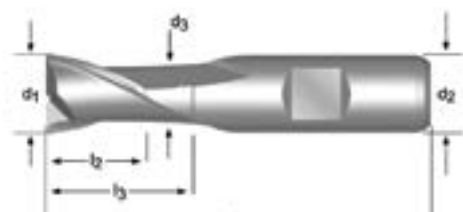
Stub Length, Square End, Weldon Shank, 30° Helix

C110 Powdered Metal. P9 slotting tolerance.

C110



1.00 - 50.00



d_1 Ø Inch	d_1 Ø mm	d_2 Ø _{h_s} 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 ¹⁾²⁾
	5.00	6	8	52	2	-	-	1	0353455
	5.50	6	8	52	2	-	-	1	0353462
	5.75	6	8	52	2	-	-	1	0353479 ¹⁾²⁾
	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 ¹⁾²⁾
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

¹⁾ Diameter tolerance h10

²⁾ Slot not in P9 tolerance

³⁾ Available in HSCo only

HSS-PM 2 Flute End Mill

d ₁ Ø Inch	d ₁ Ø mm	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	# of Flutes	l ₃ mm	d ₃ 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 ¹⁾²⁾
	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 ¹⁾²⁾
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 ¹⁾²⁾
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 ¹⁾²⁾
	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 ¹⁾³⁾
	36.00	32	32	112	2	51.5	31.5	1	0628997 ¹⁾³⁾
	40.00	40	38	130	2	59.5	39.0	1	0629000 ¹⁾³⁾
1.5"	45.00	40	38	130	2	59.5	38.0	1	0629017 ¹⁾³⁾
	50.00	50	45	147	2	66.5	48.0	1	0629024 ¹⁾³⁾

¹⁾ Diameter tolerance h10

²⁾ Slot not in P9 tolerance

³⁾ 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



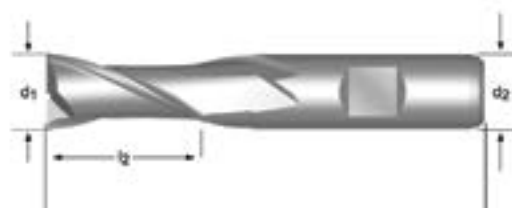
1/8 - 3/4

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

HSS 2 Flute End Mill

Regular Length, Square End, Weldon Shank, 30° Helix

920 Bright finish improves chip flow in soft or non-ferrous materials.



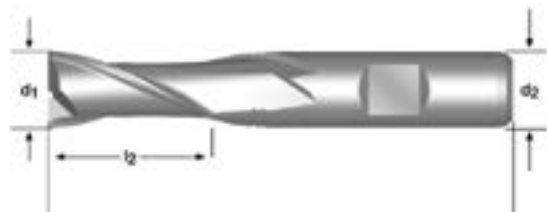
d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 Ø Inch	# of Flutes	Pack Qty	920
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110302
3/16	0.1875	7/16	2.3/8	3/8	2	1	5110303
1/4	0.2500	1/2	2.7/16	3/8	2	1	5110304
5/16	0.3125	9/16	2.1/2	3/8	2	1	5110305
3/8	0.3750	9/16	2.1/2	3/8	2	1	5110306
7/16	0.4375	13/16	2.11/16	3/8	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

HSS

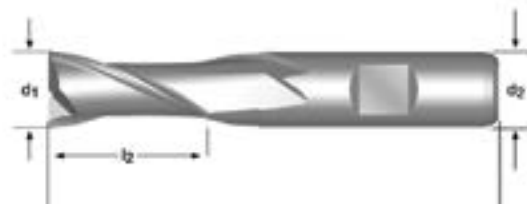


1/8 - 1"

d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 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



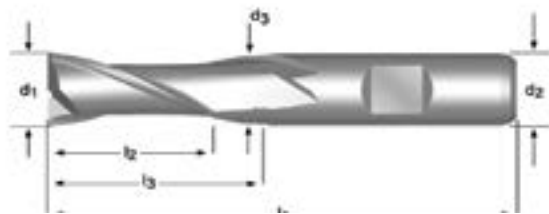
Regular Length, Square End, Weldon Shank, 30° Helix

C123 Powdered Metal. P9 slotting tolerance.

C123



1/16 - 40.00



d_1 Ø Inch	d_1 Ø mm	d_2 Ø _{h6} mm	l_2 mm	l_1 mm	# of Flutes	l_3 mm	d_3 Ø mm	Pack Qty	C123
1/16	1.59	6	7	51	2	—	—	1	0640012 ¹⁾
	2.00	6	7	51	2	—	—	1	0353646
	2.50	6	8	52	2	—	—	1	0353653
1/8	3.00	6	8	52	2	—	—	1	0353714
	3.18	6	10	54	2	—	—	1	0640029 ¹⁾
5/32	3.50	6	10	54	2	—	—	1	0353721
	3.97	6	11	55	2	—	—	1	0640036 ¹⁾
3/16	4.00	6	11	55	2	—	—	1	0353769
	4.50	6	11	55	2	—	—	1	0353776
	4.76	6	13	57	2	—	—	1	0640043 ¹⁾
1/4	5.00	6	13	57	2	—	—	1	0353790
	5.50	6	13	57	2	—	—	1	0353806
	6.00	6	13	57	2	—	—	1	0353813
	6.35	10	16	66	2	—	—	1	0640050 ¹⁾
5/16	6.50	10	16	66	2	—	—	1	0353820
	7.00	10	16	66	2	—	—	1	0353837
	7.50	10	16	66	2	—	—	1	0353844
	7.94	10	19	69	2	—	—	1	0640067 ¹⁾
3/8	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
	9.52	10	22	72	2	31.5	9.5	1	0640074 ¹⁾
1/2	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
9/16	12.70	12	26	83	2	37.5	11.5	1	0640081 ¹⁾
	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 ¹⁾

¹⁾ Diameter tolerance -.0005 inches / -.0013 inches

²⁾ Diameter tolerance -.0005 inches / -.0015 inches

³⁾ Available in HSCo only



HSS-PM 2 Flute End Mill

d_1 Ø Inch	d_1 Ø mm	d_2 Ø _{h₆} 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 ¹⁾
	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 ²⁾
	20.00	20	38	104	2	53.5	19.5	1	0353660
	22.00	20	38	104	2	53.5	19.5	1	0353677
1"	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 ³⁾
	40.00	40	63	155	2	84.5	39.0	1	0353783 ³⁾

¹⁾ Diameter tolerance -.0005 inches / -.0013 inches

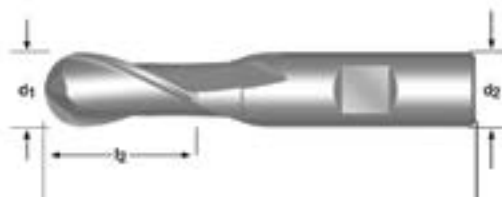
²⁾ Diameter tolerance -.0005 inches / -.0015 inches

³⁾ 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.

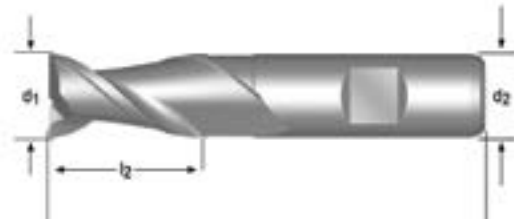


d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 mm	d_2 Ø Inch	# of Flutes	Pack Qty	905
1/8	0.1250	3/8	2.5/16	3/8	2	1	5110390
3/16	0.1875	1/2	2.3/8	3/8	2	1	5110391
1/4	0.2500	5/8	2.7/16	3/8	2	1	5110392
5/16	0.3125	3/4	2.1/2	3/8	2	1	5110393
3/8	0.3750	3/4	2.1/2	3/8	2	1	5110394
7/16	0.4375	1"	3.1/4	1/2	2	1	5110395
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.

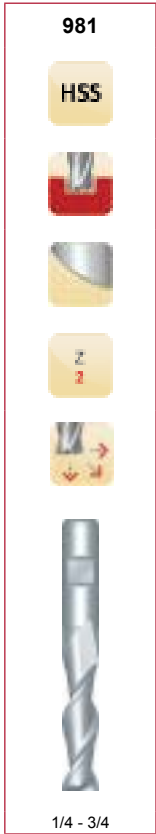
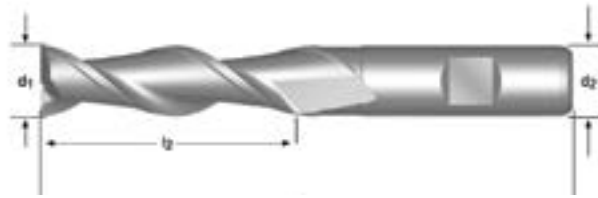


d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 Ø Inch	# of Flutes	Pack Qty	980
1/4	0.2500	5/8	2.7/16	3/8	2	1	5110602
5/16	0.3125	3/4	2.1/2	3/8	2	1	5110603
3/8	0.3750	3/4	2.1/2	3/8	2	1	5110604
1/2	0.5000	1.1/4	3.1/4	1/2	2	1	5110606
3/4	0.7500	1.5/8	3.7/8	3/4	2	1	5110608
1"	1.0000	2"	4.1/2	1"	2	1	5110609

HSS 2 Flute End Mill

Long Length, Square End, Weldon Shank, 37° Helix

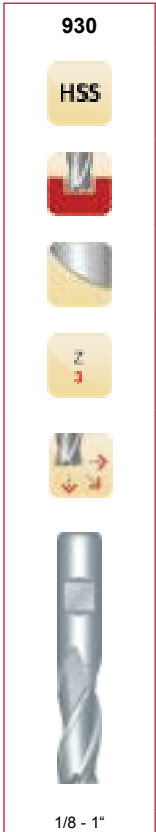
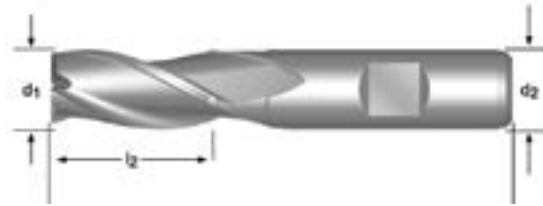
981 High Helix design for aluminum and other non-ferrous materials.



d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 Ø Inch	# of Flutes	Pack Qty	981
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	930
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



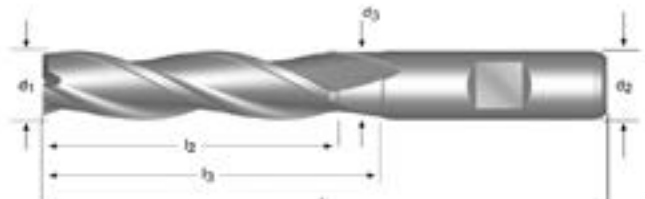
Long Length, Square End, Weldon Shank, 30° Helix

C346 P9 slotting tolerance. 3 flute design provides less chatter.

C346



3.00 - 20.00

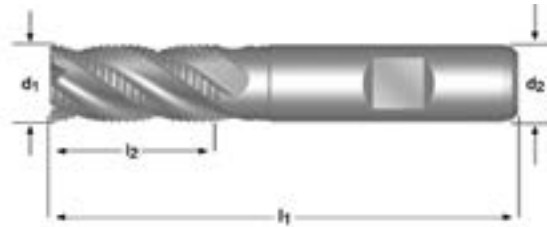


d ₁ Ø mm	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	# of Flutes	l ₃ mm	d ₃ Ø mm	Pack Qty	C346
3.00	6	12	56	3	-	-	1	0122297
4.00	6	19	63	3	-	-	1	0122303
5.00	6	24	68	3	-	-	1	0122310
6.00	6	24	68	3	-	-	1	0122327
7.00	10	30	80	3	-	-	1	0126325
8.00	10	38	88	3	-	-	1	0126332
9.00	10	38	88	3	-	-	1	0126349
10.00	10	45	95	3	-	-	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

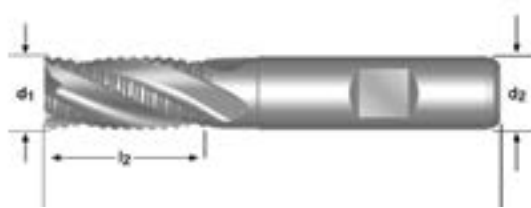
Cobalt Multi-Flute End Mill



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.

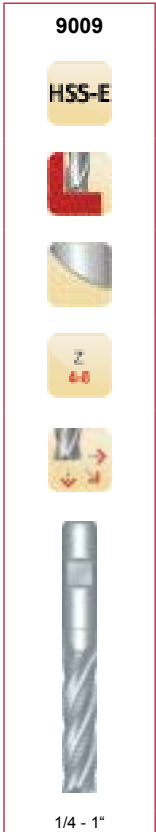
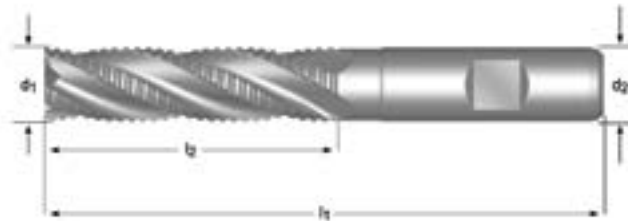


d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 Ø Inch	# of Flutes	Pack Qty	9003	TC9003
1/4	0.2500	5/8	2.7/16	3/8	4	1	5210028	5270028
5/16	0.3125	3/4	2.1/2	3/8	4	1	5210029	5270029
3/8	0.3750	3/4	2.1/2	3/8	4	1	5210030	5270030
7/16	0.4375	1.1/4	3.1/4	1/2	4	1	5210031	5270031
1/2	0.5000	1.1/4	3.1/4	1/2	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

Cobalt 4 Flute End Mill

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

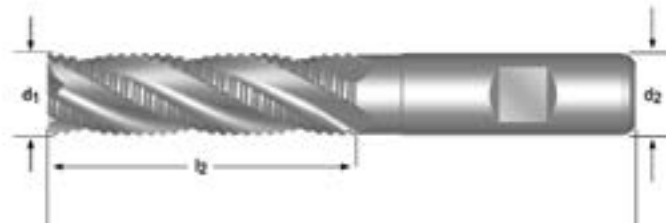
HSS-E



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

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



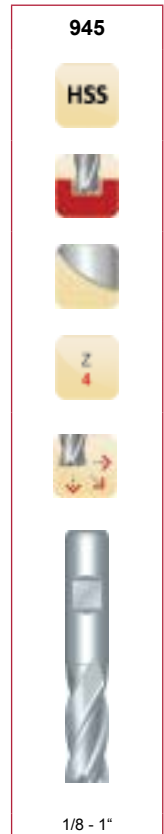
1/8 - 3/4

d_1 Ø Inch	d_1 decimal Inch	l_2 Inch	l_1 Inch	d_2 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"	4.1/2	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

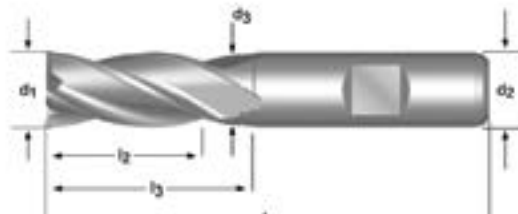


N

Z 4-8




2.00 - 50.00



d ₁ Ø Inch	d ₁ Ø mm	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	# of Flutes	l ₃ mm	d ₃ Ø mm	Pack Qty	C247
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾

¹⁾ Diameter tolerance +.0025 inches / -.0005 inches

²⁾ Not center Cutting

³⁾ Available in HSCo only

HSS-PM 4 Flute End Mill



d ₁ Ø Inch	d ₁ Ø mm	d ₂ Øh ₆ 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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ²⁾³⁾
	40.00	40	63	155	6	84.5	39.0	1	0609385 ²⁾³⁾
	50.00	50	75	177	8	96.5	48.0	1	0640258 ²⁾³⁾

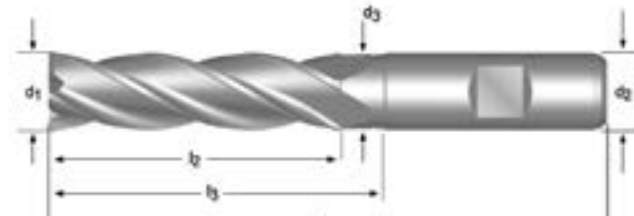
¹⁾ Diameter tolerance +.0025 inches / -.0005 inches

²⁾ Not center Cutting

³⁾ Available in HSCo only

Long Length, Square End, Weldon Shank

C273 Powdered Metal. Bright finish improves chip flow in soft or non-ferrous materials.



C273

HSS-E
PM



Z
4-6



2.00 - 40.00

d ₁ Ø Inch	d ₁ Ø mm	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	# of Flutes	l ₃ mm	d ₃ 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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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 ¹⁾
	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

¹⁾ Diameter tolerance +.0025 inches / -.0005 inches

²⁾ Available in HSCo only

³⁾ Not Center Cutting

HSS-PM 4 Flute End Mill



d_1 Ø Inch	d_1 Ø mm	d_2 Ø _{h₆} 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 ¹⁾
	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 ²⁾³⁾

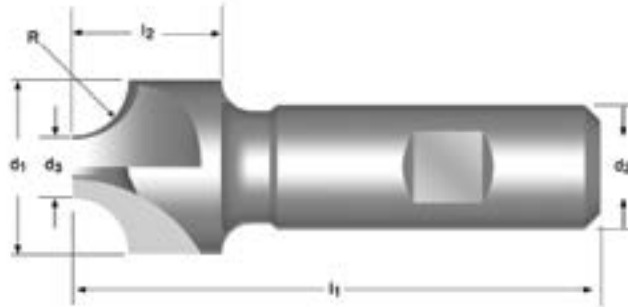
¹⁾ Diameter tolerance +.0025 inches / -.0005 inches

²⁾ Available in HSCo only

³⁾ Not Center Cutting

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 ₁ Ø	d ₂ Ø	d ₃ Ø	l ₂	l ₁	# 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.



940

HSS



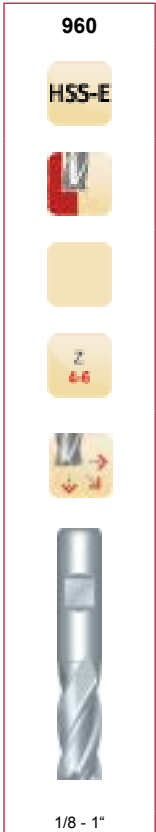
1/8 - 1"

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

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	---
	8.2 Thermosetting plastics	Bakelit, Pertinax	---
	8.3 Reinforced plastic materials	CFK, GFKAFK	---
9. Hard Mat.	9.1 Cermets (Metal-ceramics)	Ferrotic	<54 H
10. Graphite	10.1 Standard graphite		---

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	± 0.015 ± 0.004 ± 0.002	± 0.015 ± 0.004 ± 0.002	USCTI	USCTI	USCTI	H7	H7			USCTI
Taper Gradient:														
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 #	414	415	416	417	418	420	423	427	428	429	430	431	432	433
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	DORMER	ANSI	ANSI	ANSI	DIN 204	BS 328
			B									B	A
	USCTI	USCTI	H7	K11	USCTI	USCTI	USCTI		USCTI	USCTI	USCTI	H7	
													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 N16 Blades Nuts	N0 - N10	N0 - N10	1/8 - 1"	1.50 - 50.00	1/16 - 1/2
	433	434	435	437	438	439	440	441 442	443	444	445	446	448
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	49E
7.4					46D			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													



Pgs. 410 - 448

4500.....	440	B301.....	448
4531.....	427	B334.....	441
4532.....	434	B335.....	442
4533.....	423	B400.....	415
4535.....	428	B411.....	417
4536.....	433	B441.....	414
4537.....	433	B442.....	416
4579.....	438	B481.....	418
4587.....	443	B901.....	429
4588.....	432	T400.....	439
4591.....	444		
4600.....	445		
B100.....	446		
B101.....	435		
B121.....	437		
B122.....	431		
B157.....	430		
B170.....	420		

APPLICATION CARBIDE REAMER



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



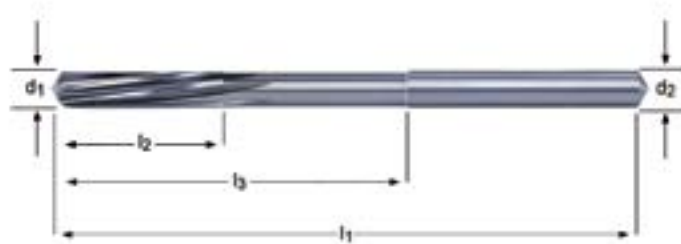
10.00 - 20.00

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 Øh ₉ mm	Pack Qty	B400
1.0	34	6	15	3	1.0	1	0052983 ¹⁾
1.2	38	8	16.5	3	1.2	1	0052990 ¹⁾
1.4	40	8	18	3	1.4	1	0053003 ¹⁾
1.5	40	8	18	3	1.5	1	0053010 ¹⁾
1.6	49	11	26	3	1.6	1	0053027 ¹⁾
1.8	49	11	25	4	1.8	1	0053034 ¹⁾
2.0	49	11	24	4	2.0	1	0053041 ¹⁾
2.2	57	15	30	4	2.2	1	0053058 ¹⁾
2.5	57	15	28	4	2.5	1	0053065 ¹⁾
2.8	61	15	32	4	2.8	1	0053072 ¹⁾
3.0	61	15	30	6	3.0	1	0144152 ¹⁾
3.2	70	18	33	6	3.2	1	0144169 ¹⁾
3.5	70	18	33	6	3.5	1	0144176 ¹⁾
4.0	75	19	44	6	4.0	1	0144183 ¹⁾
4.5	80	21	46	6	4.5	1	0144190 ¹⁾
5.0	86	23	53	6	5.0	1	0144206 ¹⁾
5.5	93	26	56	6	5.6	1	0144213 ¹⁾
6.0	93	26	56	6	5.6	1	0144220 ¹⁾
6.5	101	28	63	6	6.3	1	0144237 ²⁾
7.0	109	31	69	6	7.1	1	0144244 ²⁾
8.0	117	33	75	6	8.0	1	0144251 ²⁾
9.0	125	36	81	6	9.0	1	0144268 ²⁾
10.0	133	38	87	6	10.0	1	0144275 ²⁾
12.0	151	44	105	6	10.0	1	0144282 ²⁾
14.0	160	47	110	8	12.5	1	0144299 ²⁾
16.0	170	52	120	8	12.5	1	0144305 ²⁾
18.0	182	56	130	6	14.0	1	0144312 ³⁾
20.0	195	60	137	6	16.0	1	0144329 ³⁾

¹⁾ Solid Carbide
²⁾ Carbide Head
³⁾ Carbide Tipped

APPLICATION CARBIDE REAMER



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

HM



DIN
8051



10.00 - 20.00

d_1 Ø	l_1	l_2	l_3	# 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 ¹⁾
6.0	138	26	72.5	6	1	1	0053201 ¹⁾
7.0	150	31	84.5	6	1	1	0053218 ¹⁾
8.0	156	33	90.5	6	1	1	0053225 ¹⁾
9.0	162	36	96.5	6	1	1	0053232 ¹⁾
10.0	168	38	102.5	6	1	1	0053126 ¹⁾
12.0	182	44	116.5	6	1	1	0053140 ¹⁾
14.0	189	47	123.5	8	1	1	0053164 ¹⁾
15.0	204	50	124	8	2	1	0053171 ¹⁾
16.0	210	52	130	8	2	1	0053188 ¹⁾
17.0	214	54	134	6	2	1	0144336 ²⁾
18.0	219	56	139	6	2	1	0144343 ²⁾
19.0	223	58	143	6	2	1	0144350 ²⁾
20.0	228	60	148	6	2	1	0144367 ²⁾
22.0	237	64	157	6	2	1	0144374 ²⁾
24.0	268	68	169	8	3	1	0144381 ²⁾
25.0	268	68	169	8	3	1	0144398 ²⁾
26.0	273	70	174	8	3	1	0144404 ²⁾
30.0	281	73	182	8	3	1	0144411 ²⁾

¹⁾ Carbide Head

²⁾ 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 ₁ Ø mm	l ₁ mm	l ₂ mm	l ₃ mm	# of Flutes	d ₂ Øh ₆ 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

APPLICATION CARBIDE REAMER

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

APPLICATION COBALT REAMER



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 Øh 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

APPLICATION COBALT REAMER

d_1 Ø mm	l_1 mm	l_2 mm	l_3 mm	# of Flutes	d_2 Ø h_9 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 ₉ 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
10.50	133	38.0	87	6	10.0	1	0135266
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_1 Ø "Nr./letter	d_1 decimal Inch	d_2 decimal Inch	l_2 Inch	l_1 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 ₁ Ø "/Nr./letter	d ₁ decimal Inch	d ₂ decimal Inch	l ₂ Inch	l ₁ 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 ₁ Ø "Nr./letter	d ₁ decimal Inch	d ₂ decimal Inch	l ₂ Inch	l ₁ 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

HSS REAMER



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.

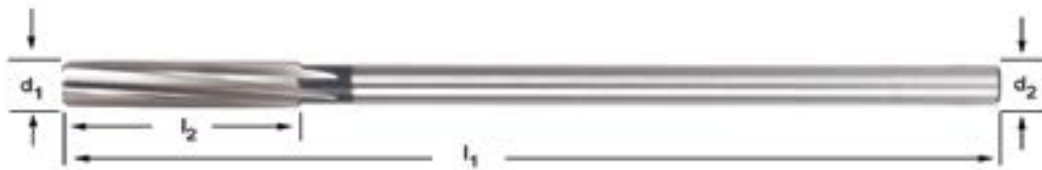
Produced per ASME B94.2-1995 standards.

4535

HSS



ANSI



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



B8
J28



1.50mm - 1/2

d_1 Ø Inch	d_1 Ø mm	l_1 mm	l_2 mm	# of Flutes	Pack Qty	B901
	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

COBALT REAMER



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 ₁ Ø mm	l ₁ mm	l ₂ mm	l ₃ mm	l ₄ mm	# of Flutes	d ₂ Øh ₉ 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



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	B122
3/8	0.3750	4.5/8	2.1/2	1.3/8	4	3/8	1/4	1	0426296
1/2	0.5000	5.7/8	3.3/4	2	5	1/2	9/32	1	0252376
9/16	0.5625	5.7/8	3.3/4	2	5	1/2	11/32	1	0252437
5/8	0.6250	6.3/8	4.1/4	2.1/4	5	1/2	11/32	1	0252413
11/16	0.6875	6.3/8	4.1/4	2.1/4	5	1/2	3/8	1	0252369
3/4	0.7500	6.7/8	4.1/2	2.1/2	5	1/2	13/32	1	0252406
13/16	0.8125	6.7/8	4.1/2	2.1/2	5	1/2	7/16	1	0252383
7/8	0.8750	6.7/8	4.1/2	2.1/2	5	1/2	15/32	1	0252420
15/16	0.9375	6.7/8	4.1/2	2.1/2	5	1/2	9/16	1	0252390
1"	1.0000	6.7/8	4.1/2	2.1/2	5	1/2	19/32	1	0252345
1.1/16	1.0625	6.7/8	4.1/2	2.1/2	5	1/2	11/16	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.

Produced per ASME B94.2-1995 standards.



4588

HSS



ANSI



7/0 - 10

nom Ø	d_1 Ø Inch	d_2 Ø Inch	d_3 Ø Inch	l_2 Inch	l_1 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

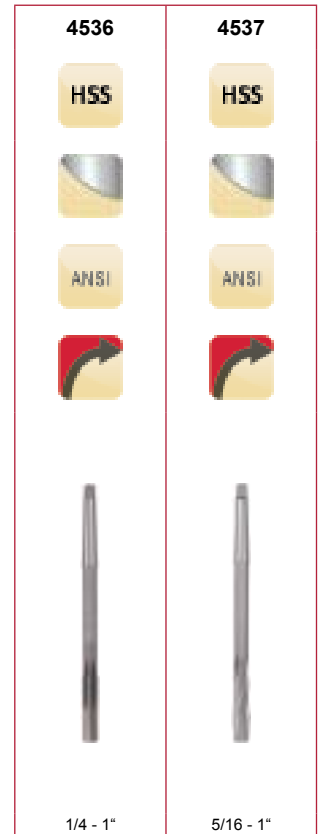
Note: Nom Ø is the Taper Pin number
Per American Standard Taper Pin Specification (ASA B5.20-1958)

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

88
328

3.00mm - 2"

Note: All sizes have 1mm x 45 chamfer (lead).
Cutting diameters are produced to H7 tolerance

d ₁ Ø Inch	d ₁ Ø mm	l ₁ mm	l ₂ 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
5/8	15.88	187	87	8	2	1	0181300

HSS REAMER



d ₁ Ø Inch	d ₁ Ø mm	l ₁ mm	l ₂ 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

IT

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

HSS



ANSI

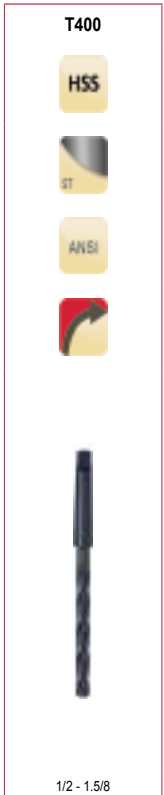


7/16 - 1.1/16

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 Inch	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"	6	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

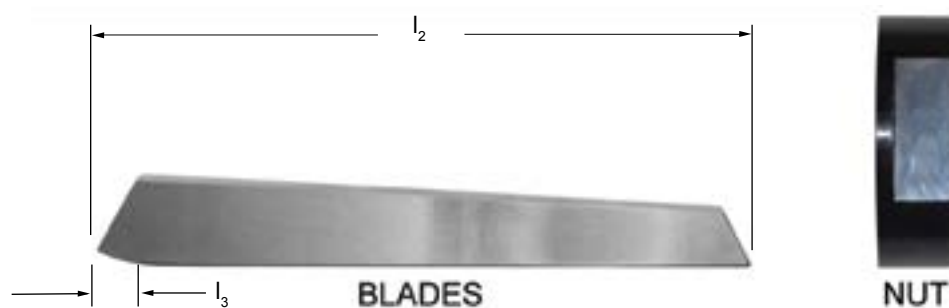
Nr.	d min-max mm	l ₁ mm	l ₂ mm	l ₃ mm	# of Flutes	a mm	Pack Qty	B334
000	6.4 - 7.2	110	32	7	4	3.0	1	0052174
00	7.2 - 8.0	110	32	7	4	3.4	1	0052167
0	8.0 - 9.0	115	34	9	5	3.8	1	0052150
1	9.0 - 10.0	115	34	9	5	4.3	1	0052181
2	10.0 - 11.0	115	34	9	5	4.9	1	0052228
3	11.0 - 12.0	125	35	9	5	4.9	1	0052235
4	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



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



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



N0 - N10

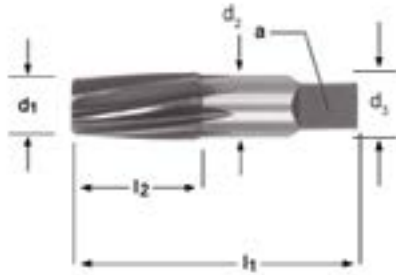
nom Ø	d ₁ Ø Inch	d ₂ Ø Inch	d ₃ Ø Inch	l ₂ Inch	l ₁ Inch	# of Flutes	Pack Qty	4591
0	0.1287	0.1638	11/64	1.11/16	2.15/16	6	1	5011146
1	0.1447	0.1798	3/16	1.11/16	2.15/16	6	1	5011147
2	0.1600	0.2010	13/64	1.15/16	3.3/16	6	1	5011148
3	0.1813	0.2294	15/64	2.5/16	3.11/16	6	1	5011149
4	0.2071	0.2600	17/64	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 ₁ Ø Inch	d ₂ Ø Inch	d ₃ Ø Inch	l ₂ Inch	l ₁ 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.

HSS REAMER



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

HSS REAMER

d ₁ Ø Inch	d ₁ Ø mm	l ₁ mm	l ₂ mm	l ₃ 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	

HSS REAMER



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.



B301



1/16 - 1/2

nom Ø	d ₁ Ø mm	l ₁ mm	l ₂ mm	# of Flutes	a mm	d ₂ Ø mm	Pack Qty	B301
1/16	1.10	51	25	4	1.2	1.63	1	0182277 ¹⁾
5/64	1.50	51	25	4	1.6	2.03	1	0182284 ¹⁾
3/32	1.75	57	32	4	2.0	2.41	1	0182291 ¹⁾
7/64	2.03	64	38	4	2.2	2.82	1	0182307 ¹⁾
1/8	2.30	70	44	4	2.5	3.23	1	0182314 ¹⁾
9/64	2.64	73	48	4	2.8	3.63	1	0182321 ¹⁾
5/32	2.95	76	51	4	3.1	4.01	1	0182338 ¹⁾
11/64	3.23	89	57	4	3.6	4.42	1	0182345 ¹⁾
3/16	3.50	102	70	4	4.0	4.95	1	0182352 ¹⁾
7/32	4.13	102	70	6	4.5	5.59	1	0182369 ¹⁾
1/4	4.64	117	86	6	5.0	6.43	1	0182376 ²⁾
9/32	5.23	143	105	6	5.6	7.42	1	0182383 ²⁾
5/16	5.84	143	105	6	6.3	8.03	1	0182390 ²⁾
11/32	6.43	152	114	6	7.1	8.81	1	0182406 ²⁾
3/8	7.03	165	127	6	8.0	9.68	1	0182413 ²⁾
13/32	7.42	191	146	6	8.0	10.46	1	0182420 ²⁾
7/16	8.21	191	146	6	9.0	11.25	1	0182437 ²⁾
1/2	9.41	210	165	6	10.0	12.85	1	0182444 ²⁾

¹⁾ Limit of tolerance +0.0030

²⁾ Limit of tolerance +0.0050



Visual Index - Countersinks & Counterbores



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	

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	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		AlTiN	Tan
Standard:	DIN 338C	ANSI	ANSI	ANSI	DIN 334C	DIN 334C	DIN 338C	DEFINIE	DIN 335C	DIN 335C	DIN 335C	DIN 335C	DIN 338C
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 #	454	455	456	457	458	458	459	460	461	461	462	463	464
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		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
	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"
	465	466	467	468	468	469	470	471	471	473	474
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											



Pgs. 450-475

4602.....	457
4603.....	455
4608.....	456
4702.....	470
4703.....	473
4704.....	474
4705.....	471
4706.....	471
G132.....	466
G135.....	458
G136.....	461
G137.....	467
G138.....	468
G142.....	462
G149.....	460
G154.....	459
G171.....	464
G236.....	469
G335.....	458
G338.....	468
G400.....	454
G560.....	461
G570.....	463
G600.....	465

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



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



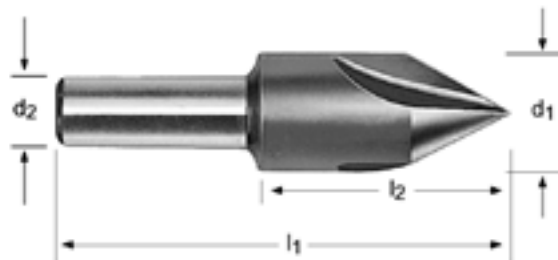
1/4 - 1.1/2

d ₁ Ø Inch	angle	d ₂ Ø Inch	l ₂ Inch	l ₁ 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

HSS



ANSI



1/4 - 1"

d ₁ Ø Inch	Angle	d ₂ Ø Inch	l ₂ Inch	l ₁ 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	4602
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
HSS	HSS
DIN 334C	DIN 334C
6.30 - 25.00	6.30 - 25.00

max d mm	min d mm	l ₂ mm	l ₁ mm	d ₂ Øh ₉ 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 ₂ mm	l ₁ mm	d ₂ Øh ₉ 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

COBALT COUNTERSINK



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



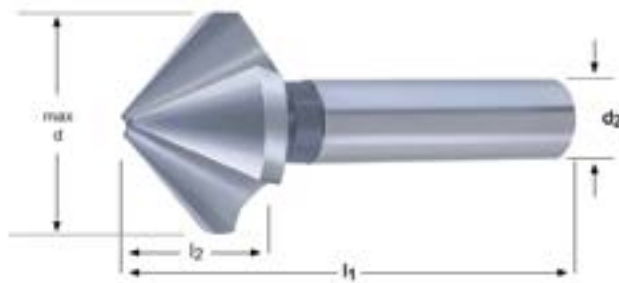
5.00 - 50.00

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.



max d mm	min d mm	l_2 mm	l_1 mm	d_2 $\varnothing h_9$ 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

HSS



DIN 335C



4.80 - 31.00

max d mm	min d mm	l_2 mm	l_1 mm	d_2 $\varnothing h_9$ 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

AlTiCN

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. TiAlN coating increases surface hardness and improves tool life at higher speeds.

G171



6.30 - 25.00



max d mm	min d mm	l ₂ mm	l ₁ mm	d ₂ Øh ₉ 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.



G600

HSS



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	G600
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

HSS COUNTERSINK



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



8.00 - 20.00

max d mm	min d mm	l ₂ mm	l ₁ mm	d ₂ Øh ₉ 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 ₂ mm	l ₁ 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 ₂ mm	l ₁ 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.



G236

HSS

DIN 335C

Set

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	4702
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

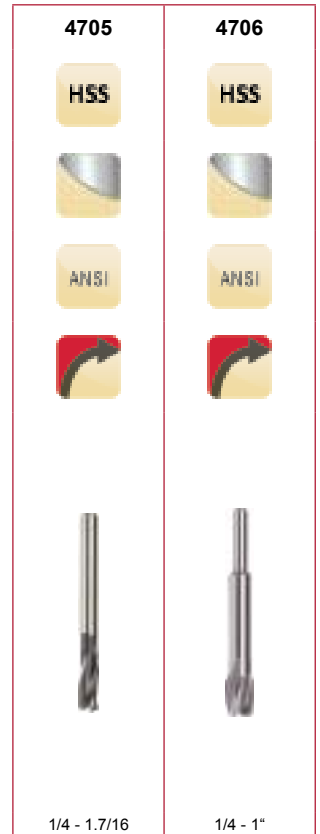
HSS COUNTERBORE

Counterbore Body, Aircraft Series - Interchangeable Pilot Type

4705 Long Series, 3-flute with corner radius

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 ₁ Ø Inch	l ₂ Inch	l ₁ Inch	d ₂ Ø Inch	l ₃ Inch	d ₃ 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 ¹⁾
1/4	3/4	3.13/16	15/64	3.1/16	15/64	3	3/32	1/8	3/16	1	6210107 ¹⁾	—
5/16	1/2	2.3/8	1/4	7/8	17/64	4	3/32	1/8	1/4	1	—	6210139 ¹⁾
5/16	3/4	3.13/16	19/64	3.1/16	19/64	3	3/32	1/8	1/4	1	6210109 ¹⁾	—
11/32	1/2	2.3/8	1/4	7/8	19/64	4	3/32	1/8	9/32	1	—	6210140 ¹⁾
3/8	1/2	2.3/8	1/4	7/8	5/16	4	3/32	3/16	5/16	1	—	6210141 ²⁾
3/8	3/4	3.13/16	5/16	3.1/16	5/16	3	3/32	3/16	5/16	1	6210111 ¹⁾	—
13/32	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	11/32	1	—	6210142 ²⁾
7/16	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	3/8	1	—	6210143 ²⁾
7/16	3/4	3.13/16	3/8	3.1/16	3/8	3	1/8	3/16	3/8	1	6210113 ¹⁾	—
15/32	1/2	2.13/16	1/4	7/8	5/16	4	1/8	1/4	13/32	1	—	6210144 ²⁾
1/2	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	7/16	1	—	6210145 ²⁾
1/2	3/4	3.13/16	7/16	3.1/16	7/16	3	1/8	1/4	7/16	1	6210115 ¹⁾	—
17/32	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	15/32	1	—	6210146 ²⁾
17/32	3/4	5.3/8	1/2	4.5/8	1/2	3	1/8	1/4	15/32	1	6210116 ¹⁾	—
9/16	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	1/2	1	—	6210147 ²⁾
9/16	3/4	5.3/8	1/2	4.5/8	1/2	3	1/8	1/4	1/2	1	6210117 ¹⁾	—
19/32	3/4	5.3/8	1/2	4.3/16	9/16	3	1/8	1/4	17/32	1	6210118 ¹⁾	—
5/8	3/4	5.3/8	1/2	4.3/16	9/16	3	1/8	1/4	9/16	1	6210119 ¹⁾	—
11/16	1/2	2.13/16	1/4	7/8	1/2	4	1/8	1/4	5/8	1	—	6210151 ³⁾
21/32	1.1/4	5.3/8	1/2	3.5/8	9/16	3	3/16	1/4	19/32	1	6210120 ¹⁾	—
11/16	1.1/4	5.3/8	1/2	3.5/8	5/8	3	3/16	1/4	5/8	1	6210121 ¹⁾	—
3/4	1.1/4	5.3/8	1/2	3.5/8	11/16	3	3/16	5/16	11/16	1	6210123 ¹⁾	—

¹⁾ 1/32 Corner Radius
²⁾ 3/64 Corner Radius
³⁾ 0.0550" Corner Radius

HSS COUNTERBORE



d ₁ Ø Inch	l ₂ Inch	l ₁ Inch	d ₂ Ø Inch	l ₃ Inch	d ₃ 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 ³⁾
25/32	1.1/4	5.3/8	1/2	3.5/8	11/16	3	3/16	5/16	23/32	1	6210124 ¹⁾	—
13/16	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	5/16	3/4	1	6210125 ¹⁾	—
13/16	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	3/4	1	—	6210155 ³⁾
7/8	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	5/16	13/16	1	6210126 ¹⁾	—
7/8	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	13/16	1	—	6210157 ³⁾
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"	1.1/4	5.3/8	1/2	3.5/8	3/4	3	3/16	3/8	15/16	1	6210128 ¹⁾	—
1"	1/2	2.13/16	1/4	7/8	1/2	4	3/16	3/8	15/16	1	—	6210161 ³⁾

¹⁾ 1/32 Corner Radius

²⁾ 3/64 Corner Radius

³⁾ 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 ₁ Ø Inch	l ₂ Inch	l ₁ Inch	MTS	d ₂ Neck Dia. Inch	l ₃ Shank Length Inch	# of Flutes	pilot (p) mounting Ø Inch	pilot Ø min	pilot Ø max	Pack Qty	4703
1/4	3/4	3.13/16	1	15/64	2.9/16	3	3/32	1/8	3/16	1	6210066
5/16	3/4	3.13/16	1	19/64	2.9/16	3	3/32	1/8	1/4	1	6210068
3/8	1"	4.1/16	1	11/32	2.9/16	3	5/32	3/16	5/16	1	6210070
7/16	1"	4.1/16	1	13/32	2.9/16	3	5/32	3/16	3/8	1	6210072
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
5/8	1.1/4	5.1/8	2	9/16	3.1/8	3	3/16	1/4	9/16	1	6210078
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
1.7/8	2.1/4	8.1/8	4	1.1/2	4.7/8	5	7/16	1/2	1.13/16	1	6210097
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

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 ₁ Ø Inch	l ₂ Inch	l ₁ 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 ₁ Ø Inch	l ₂ Inch	l ₁ 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

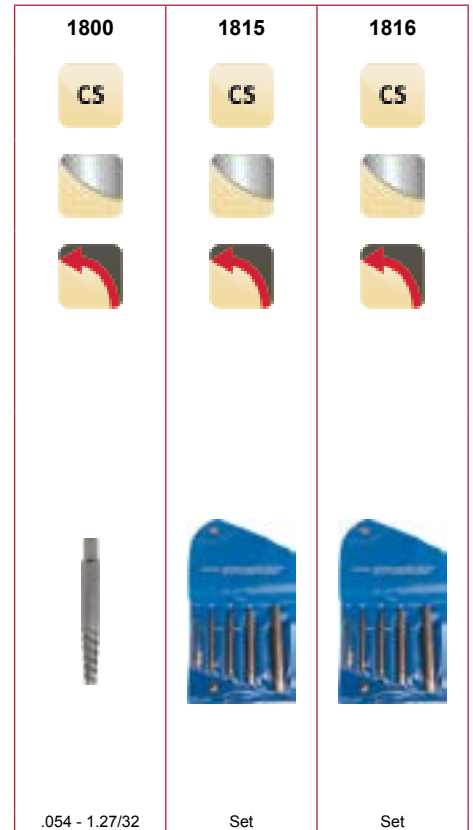


Pgs. 476-480

411.....	479
430.....	479
707.....	480
727.....	480
757.....	480
1800.....	477
1815.....	477
1816.....	477
1900.....	478

SCREW EXTRACTOR

- 1800** Screw Extractor
- 1815** Screw Extractor Set, 5 piece
- 1816** Screw Extractor Set, 6 piece



Nr.	d ₁ Ø Inch	Sizes in Set	d ₂ Ø Inch	Pieces per Set	l ₁ 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.

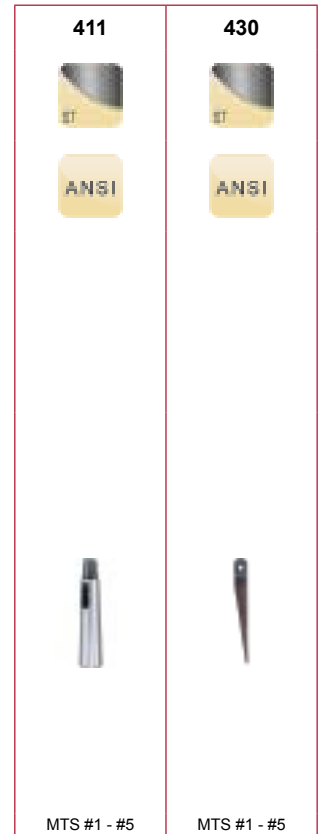


Sizes	Style	Description	Pack Qty	1900
1/2 oz	Trial Size	Drilling & Tapping Fluid	1	1910512
4 oz	Squirt Bottle	Drilling & Tapping Fluid	24	1910501
16 oz	Squirt Bottle	Light Tapping Fluid	12	1910502
1 gal	Bottle	Light Tapping Fluid	6	1910503
5 gal	Dispenser	Drilling & Tapping Fluid	1	1910506
5 gal	Pail	Drilling & Tapping Fluid	1	1910504
55 gal	Drum	Drilling & Tapping Fluid	1	1910505
1 lb	Stick	Wax	24	1950501
20 oz	Aerosol Can	Foam	12	1910509
1 gal	Bottle	Drilling & Tapping Fluid	6	1930503
16 oz	Squirt Bottle	Drilling & Tapping Fluid	12	1930502
16 oz	Squirt Bottle	Light Tapping Fluid (single)	1	46437347
16 oz	Squirt Bottle	Drilling & Tapping Fluid (single)	1	46437348
20 oz	Aerosol 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	—

MISCELLANEOUS

TOOL BIT BLANKS

- 707** HSS ground blank with 10° beveled ends
- 727** Cobalt ground blank with 10° beveled ends
- 757** Cobalt Vanadium (T-15) ground blanks with 10° beveled ends



Sizes	Overall Length	Pack Qty	707	727	757
3/16	2.1/2	1	6310293	6310317	6310305
1/4	2.1/2	1	6310294	6310318	6310306
5/16	2.1/2	1	6310295	6310319	6310307
3/8	3"	1	6310296	6310320	6310308
7/16	3.1/2	1	6310297	6310321	6310309
1/2	4"	1	6310298	6310322	6310310
5/8	4.1/2	1	6310299	6310323	6310311
3/4	5"	1	6310300	6310324	6310312
1"	7"	1	6310302	6310326	6310314

Notas: Tamañas columna representa la anchura y altura (cuadrado)
 Tolerancias en anchura y altura = ± 0.002
 Tolerancias en longitud total = $\pm 1/16$ "

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-phos (TiAlCrSiN)



Purple / Bronze (Dual oxide surface treatment)



Alcrona Top (AlCrN - Top)



Aluminium Titanium Carbo-Nitride



Aluminium Titanium Nitride

Technical Section - Icon Descriptions



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

Countersink⁰



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

Technical Section - Icon Descriptions



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

Technical Section - Icon Descriptions



Milling icons

Diameter tolerance



Industry standard shaft tolerances

Helix Angle



Unequal Helix

of teeth or flutes



Shank



Straight Shank



Weldon Shank



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
HSS	M2	810-850	0.9	6.4	5.0	4.2	1.8	-	HSS
HSS-E	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	
HSS PM	-	830-870	0.9	6.25	5.0	4.2	1.9	-	HSS Powder Metal
HSS-E PM	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	
CS	-	775-825	1.03	-	-	1.5	-	-	Chromium Steel

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.

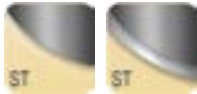
Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.

Properties	HSS materials	Carbide materials	K10/30F (often used for solid tools)
Hardness (HV30)	800-950	1300-1800	1600
Density (g/cm ³)	8.0-9.0	7.2-15	14.45
Compressive strength (N/mm ²)	3000-4000	3000-8000	6250
Flexural strength, (bending) (N/mm ²)	2500-4000	1000-4700	4300
Heat resistance (°C)	550	1000	900
E-module (KN/mm ²)	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.

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.



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)
	Dark grey	Fe 304	400	Max. 5	Conversion into the surface	–	550
	Bronze	Fe 304	400	Max. 5	Conversion into the surface	–	550
	Grey	FeN	1300	20	Diffusion zone	–	550
	Gold	TiN	2300	1-4	Mono-layer	0.4	600
	Blue grey	TiCN	3000	1-4	Multi-layer gradient	0.4	500
	Black grey	TiAlN	3300	3	Nano structured	0.3-0.35	900
	Silver grey	CrN	1750	3-4	Mono-layer	0.5	700
	Blue grey	AlCrN Top	3200		Mono-layer	0.35	1100
	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	1/16	.0625	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	35/64	.5469
79	.0145	52	.0635	29	.1360	5.5 mm	.2165	8.2 mm	.3228	14.00 mm	.5512
1/64	.0156	1.65 mm	.0650	3.5 mm	.1378	7/32	.2188	P	.3230	9/16	.5625
.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	9/64	.1406	2	.2210	8.3 mm	.3268	37/64	.5781
.45 mm	.0177	1.75 mm	.0689	3.6 mm	.1417	5.7 mm	.2244	21/64	.3281	15.00 mm	.5906
77	.0180	50	.0700	27	.1440	5.75 mm	.2264	8.4 mm	.3307	19/32	.5938
.5 mm	.0197	1.8 mm	.0709	3.7 mm	.1457	1	.2280	Q	.3320	39/64	.6094
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	5/8	.6250
.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	15/64	.2344	8.7 mm	.3425	41/64	.6406
.6 mm	.0236	1.95 mm	.0768	24	.1520	6 mm	.2362	11/32	.3438	16.50 mm	.6496
73	.0240	5/64	.0781	3.9 mm	.1535	B	.2380	8.75 mm	.3445	21/32	.6562
72	.0250	47	.0785	23	.1540	6.1 mm	.2402	8.8 mm	.3465	17.00 mm	.6693
.65 mm	.0256	2 mm	.0787	5/32	.1562	C	.2420	S	.3480	43/64	.6719
71	.0260	2.05 mm	.0807	22	.1570	6.2 mm	.2441	8.90 mm	.3504	11/16	.6875
.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	45/64	.7031
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	23/64	.3594	23/32	.7188
68	.0310	44	.0860	4.2 mm	.1654	1/4	.2500	9.20 mm	.3622	18.50 mm	.7283
1/32	.0312	2.2 mm	.0866	19	.1660	6.4 mm	.2520	9.25 mm	.3642	47/64	.7344
.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	3/4	.7500
66	.0330	2.3 mm	.0906	18	.1695	6.6 mm	.2598	9.40 mm	.3701	49/64	.7656
.85 mm	.0335	2.35 mm	.0925	11/64	.1719	G	.2610	9.50 mm	.3740	19.50 mm	.7677
65	.0350	42	.0935	17	.1730	6.7 mm	.2638	3/8	.3750	25/32	.7812
.9 mm	.0354	3/32	.0938	4.4 mm	.1732	17/64	.2656	V	.3770	20.00 mm	.7874
64	.0360	2.4 mm	.0945	16	.1770	6.75 mm	.2657	9.60 mm	.3780	51/64	.7969
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	13/16	.8125
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	53/64	.8281
1 mm	.0394	39	.0995	13	.1850	7 mm	.2756	9.90 mm	.3898	27/32	.8438
60	.0400	38	.1015	4.7 mm	.1850	J	.2770	25/64	.3906	21.50 mm	.8465
59	.0410	2.60 mm	.1024	4.75 mm	.1870	7.1 mm	.2795	10.00 mm	.3937	55/64	.8594
1.05 mm	.0413	37	.1040	3/16	.1875	K	.2810	X	.3970	22.00 mm	.8661
58	.0420	2.7 mm	.1063	4.8 mm	.1890	9/32	.2812	Y	.4040	7/8	.8750
57	.0430	36	.1065	12	.1890	7.2 mm	.2835	13/32	.4062	22.50 mm	.8858
1.1 mm	.0433	2.75 mm	.1083	11	.1910	7.25 mm	.2854	Z	.4130	57/64	.8906
1.15 mm	.0453	7/64	.1094	4.9 mm	.1929	7.3 mm	.2874	10.50 mm	.4134	23.00 mm	.9055
56	.0465	35	.1100	10	.1935	L	.2900	27/64	.4219	29/32	.9062
3/64	.0469	2.8 mm	.1102	9	.1960	7.4 mm	.2913	11.00 mm	.4331	59/64	.9219
1.2 mm	.0472	34	.1110	5 mm	.1969	M	.2950	7/16	.4375	23.50 mm	.9252
1.25 mm	.0492	33	.1130	8	.1990	7.5 mm	.2953	11.50 mm	.4528	15/16	.9375
1.3 mm	.0512	2.9 mm	.1142	5.1 mm	.2008	19/64	.2969	29/64	.4531	24.00 mm	.9449
55	.0520	32	.1160	7	.2010	7.6 mm	.2992	15/32	.4688	61/64	.9531
1.35 mm	.0531	3 mm	.1181	13/64	.2031	N	.3020	12.00 mm	.4724	24.50 mm	.9646
54	.0550	31	.1200	6	.2040	7.7 mm	.3031	31/64	.4844	31/32	.9688
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	1/8	.1250	5	.2055	7.8 mm	.3071	1/2	.5000	63/64	.9844
1.5 mm	.0591	3.2 mm	.1260	5.25 mm	.2067	7.9 mm	.3110	13.00 mm	.5118	1.0000	1.0000
53	.0595	3.25 mm	.1280	5.3 mm	.2087	5/16	.3125	33/64	.5156		
1.55 mm	.0610	30	.1285	4	.2090	8 mm	.3150	17/32	.5312		

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.

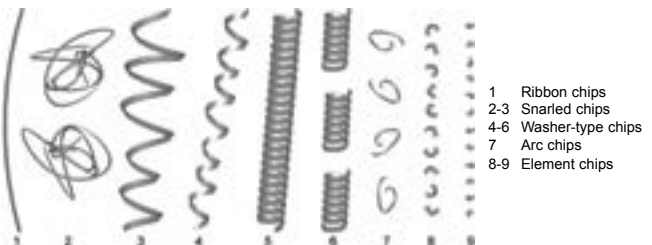


TYPES OF CHIPS

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).



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.

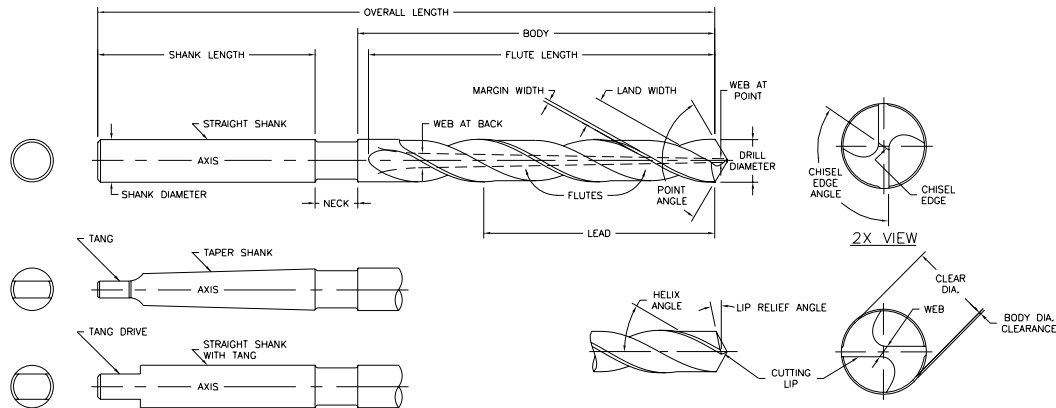
INDUSTRY STANDARD TOLERANCES FOR SHAFTS & HOLES

Tolerance values are shown in Microns (μm)

Formula for Microns ...1 μm = 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 (μm)							
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

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

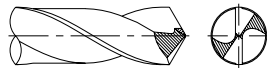
contributes to walking at the drill point, often making it necessary to spot the hole for improved accuracy.



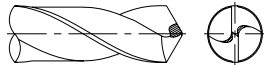
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DRILL NOMENCLATURE

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
IPM = Inches Per Minute	$IPR \times RPM = \mathbf{IPM}$
IPR = Inches Per Revolution	$\frac{IPM}{RPM} = \mathbf{IPR}$
RPM = Revolutions Per Minute	$\frac{SFM \times 3.82}{D} = \mathbf{RPM}$
SFM = Surface Feet Per Minute	$D \times RPM \times .26 = \mathbf{SFM}$
D = Drill Diameter	

Note: For element and tolerance information, see specific technical sections on Solid Carbide or High Speed Steel.

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
Wear on Outer Corners	<ul style="list-style-type: none"> • Reduce cutting speed • Increase feed (IPR) • Improve direction of coolant flow • Increase coolant pressure • Add corner break
Chipping of Chisel Edge	<ul style="list-style-type: none"> • Check accuracy of drill runout • Check workpiece clamping accuracy and movement • Check point centrality and lip height • Increase feed rate
Chipping of Cutting Lips	<ul style="list-style-type: none"> • Check accuracy of drill runout • Check workpiece clamping accuracy and movement • Reduce speed • Reduce point clearance • Increase hone
Cracking of Lands	<ul style="list-style-type: none"> • Check movement of workpiece • Increase back taper • Check accuracy of drill runout • Chip packing; increase flute form opening or peck drill (HSS or HSCO only) • Slow down helix, horizontal drilling • Increase feed • When spot drilling, reduce feed • Improve direction of coolant flow • Increase coolant pressure
Oversize Hole	<ul style="list-style-type: none"> • Increase speed, reduce feed • Check workpiece clamping accuracy and movement • Check accuracy of drill runout • Chip packing, increase flute form opening or peck drill (HSS or HSCO only) • Check point centrality and lip height
Undersize Hole	<ul style="list-style-type: none"> • Improve direction of coolant flow • Reduce cutting speed, increase feed • Check drill diameter
Hole Not Round	<ul style="list-style-type: none"> • Check accuracy of drill runout • Check workpiece clamping accuracy and movement • Check point centrality and lip height • Chip packing, increase flute form opening or peck drill (HSS or HSCO only)
Drill Breakage	<ul style="list-style-type: none"> • Chip packing, increase flute form opening or peck drill (HSS or HSCO only) • Check workpiece clamping accuracy and movement • Check accuracy of drill runout • Reduce feed rate, increase feed rate • Improve direction of coolant flow • Increase coolant pressure

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)

Ø (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)

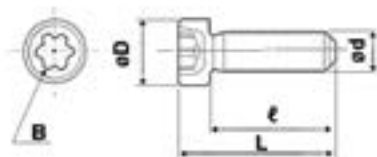
Ø (inch)	H8	H9	H10	H12
≤ .1181	0 / +0.0006	0 / +0.0010	0 / +0.0016	0 / +0.0040
>.1181≤.2362	0 / +0.0007	0 / +0.0012	0 / +0.0019	0 / +0.0048
>.2362 ≤.3937	0 / +0.0009	0 / +0.0015	0 / +0.0023	0 / +0.0059
>.3937≤.7087	0 / +0.0011	0 / +0.0017	0 / +0.0028	0 / +0.0071
>.7087≤1.1811	0 / +0.0013	0 / +0.0021	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.

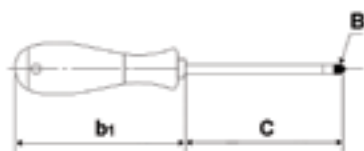
Torque Table

					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

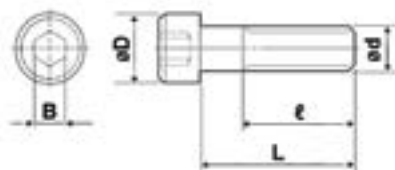
Screws and screw-drivers data



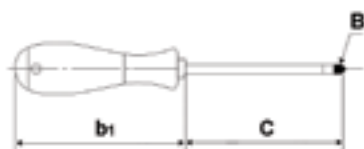
e-code	d	Pitch	L (mm)	l (mm)	D (mm)	B
H860N1	M2.2	0.45	7.5	5.7	3.5	8IP
H860N2	M2.5	0.45	9.0	7.0	4.1	10IP
H860N3	M3.0	0.50	10.5	8.0	4.9	15IP
H860N4	M3.5	0.60	11.5	8.8	5.5	15IP
H860N5	M4.0	0.70	12.5	9.5	6.0	20IP
H860N6	M4.5	0.75	14.3	10.8	6.8	25IP



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

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

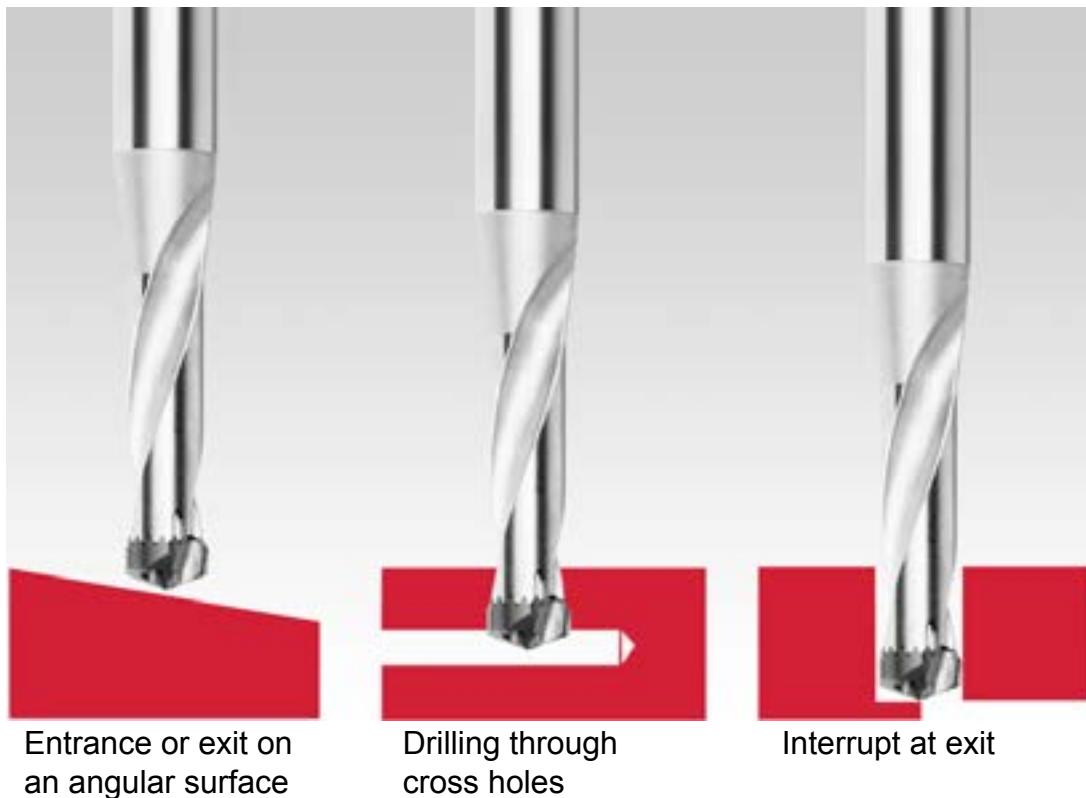
Always use tool holders and collets that provide good concentricity between the drill and the machine spindle. Use a positive stop to prevent the tool from backing up into the holder. Radial runout in the tool assembly must be accurately checked and maintained.

WORKPIECE

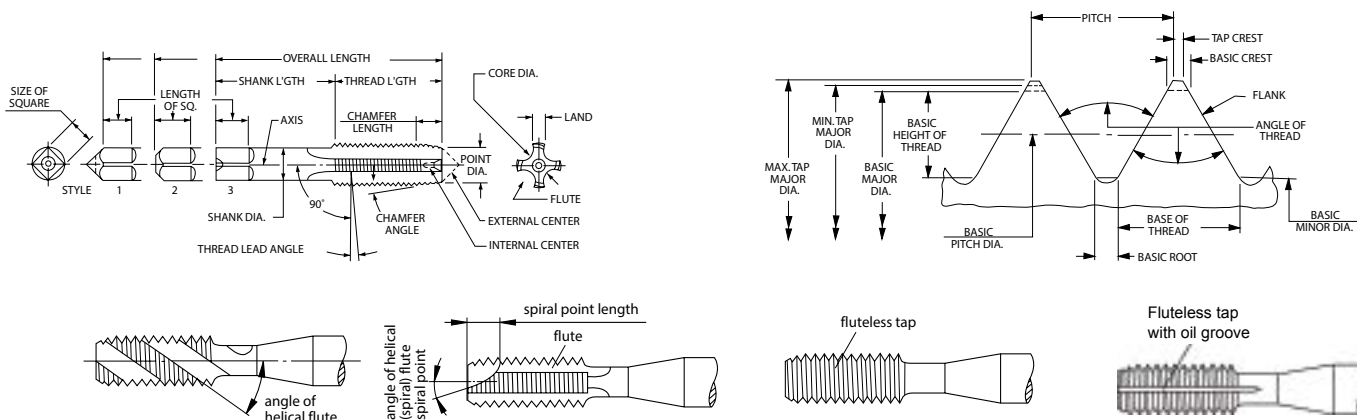
A secure and rigid workpiece will minimise deflection, and allow for better accuracy and true position of the hole.

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.



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.

Rake: 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.

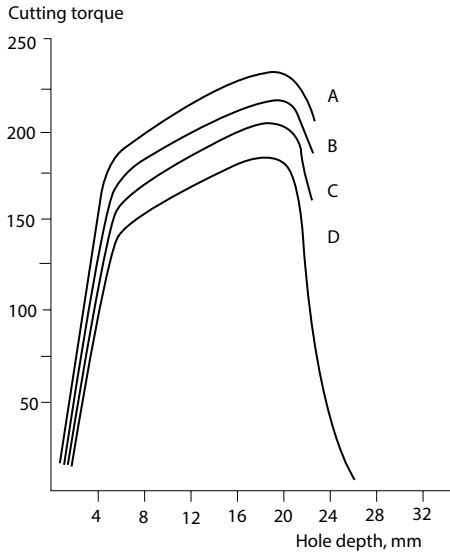
TAP GEOMETRIES & APPLICATIONS

Description	Chips
<p>Taps with straight flutes</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>Taps with interrupted thread</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>Spiral point taps</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>Nut taps</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>	

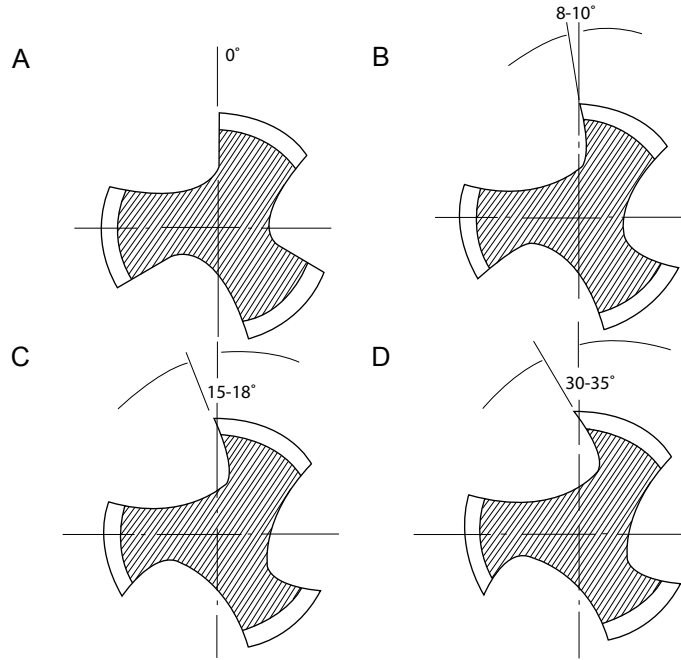
Description	Chips
<p>Taps with flutes only on the chamfer lead</p> <p>The cutting part of the tap is formed by gun nosing in the same manner as for a spiral point tap, the function being to drive the chips forward ahead of the cutting edges. This design is extremely rigid which facilitates good machining results. However, the short length of the gun nosing limits its application to a depth of hole less than about $1.5 \times \varnothing$.</p>	
<p>Taps with spiral flutes</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>Cold forming taps</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 (R_m) should not exceed 1200 N/mm^2 and the elongation factor (A_5) 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>Through coolant taps</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>	

TAPPING TECHNICAL DATA

Rake Angles

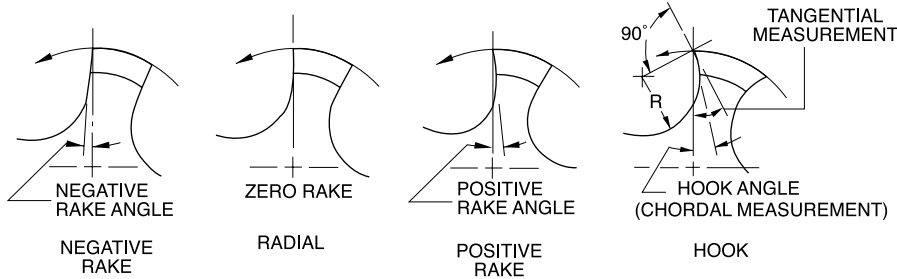


Threading tap M10 used with various rake angles in steel (low carbon steel)

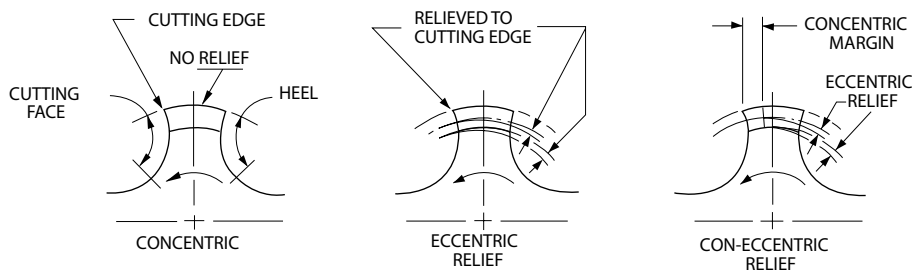


The rake angle has a primary influence on cutting forces and consequently the cutting torque and surface finish of the thread. Test results made with different rake angles are shown in the above diagram, illustrating how cutting torque

decreases with a larger rake angle. There is, however, a limit. A large rake angle means lower strength of the cutting edge.



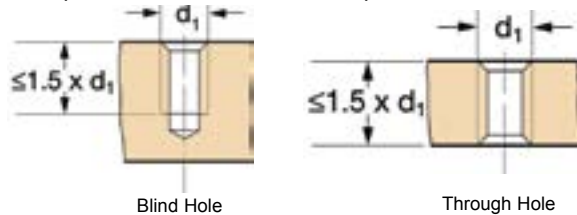
Relief Angles



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.

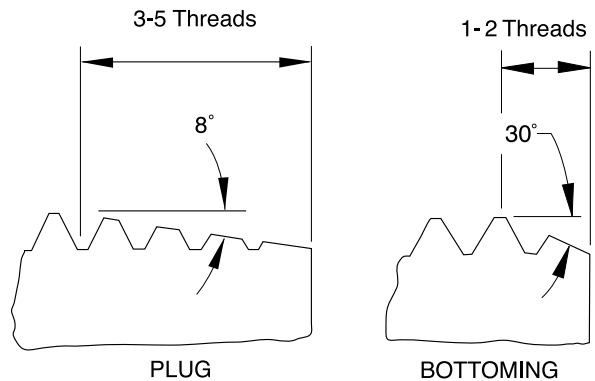
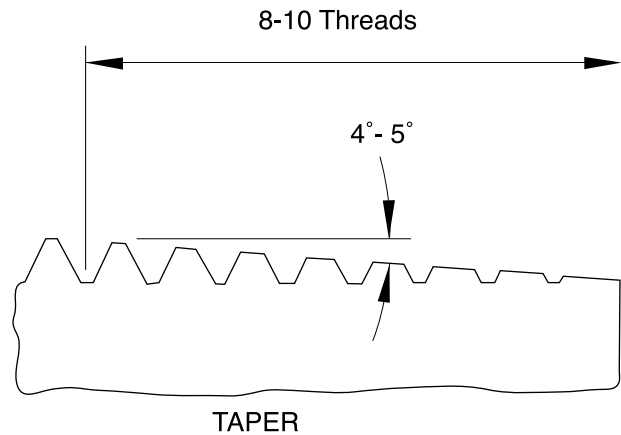
Generally, the form and length of chamfer depend on the type of hole to be tapped. Though holes do not normally cause difficulties whereas the tapping of blind holes can create certain problems associated with chip evacuation.



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.


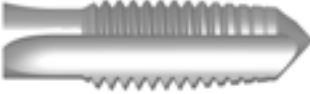






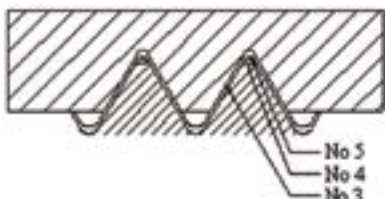
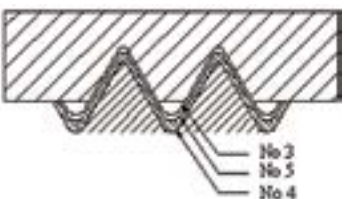
Proper tapping speeds are determined best by experiment. In the table below the speeds shown should be used as a guide only, and the suggested surface feet per minute adjusted upward or downward until the best results are obtained.

$$\text{RPM} = \frac{3.82 \times \text{SFM}}{D}$$

$$\text{SFM} = .26 \times \text{RPM} \times D$$

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	
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p>$\varnothing \leq M10$</p> </div> <div style="text-align: center;">  <p>$\varnothing \geq M12$</p> </div> </div>			

ISO	Set code number	Including tap number
	No. 6	No. 1 + No. 2 + No. 3
	No. 7	No. 2 + No. 3
	No. 8	No. 4 + No. 5 + No. 3
	No. 9	No. 5 + No. 3
DIN	Set code number	Including tap number
	No. 8	No.3 (form C) + No.4 (form A) + No.5 (form B)
	No. 9	No.3 (form C) + No.5 (form B)
ANSI	Set code number	Including tap number
	Hand Tap (No. 6)	Taper(No.1) + Plug(No.2) + Bottoming(No.3)

TAPPING TECHNICAL DATA

The Relationship Between H-Limit and Class of Fit

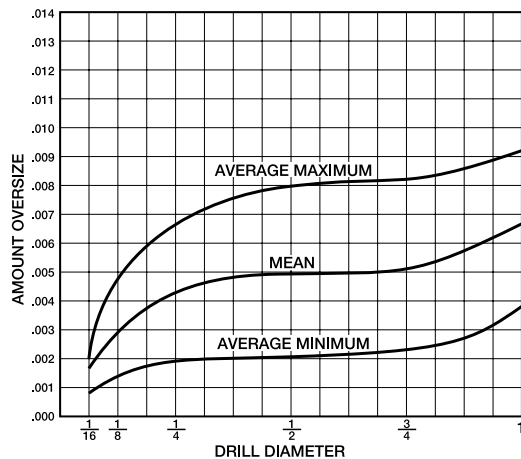
H-limits are used to properly size a tap for the threaded hole to be produced. They are selected based upon the tolerance required for the part. These tolerances are defined by the symbols class 1B, 2B, or 3B. Class 1B has the broadest tolerance and is generally applied to DIY (Do It Yourself) type nuts 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	.002
1/4	.0065	.004	.0025

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

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. = $\frac{\text{Amt. Tap PD High Limit Is Over Basic PD}}{.00052}$ "

DU Limit No. = $\frac{\text{Amt. Tap PD Low Limit Is Under Basic PD}}{.00052}$ "

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."

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.

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.

SELF-LOCKING THREAD FORM

Concept

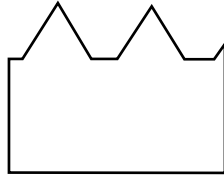
Designed to produce threads for self-locking operations and put a lock on fastener costs.

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.

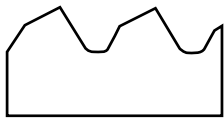
Although this is a made-to-order program, quantities of up to 48 pieces of any style would be delivered in no greater than 10 working days.

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



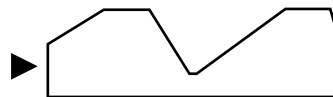
Standard Thread Form



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.

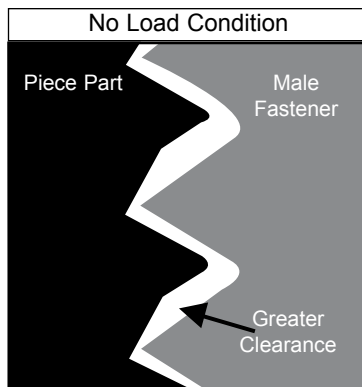
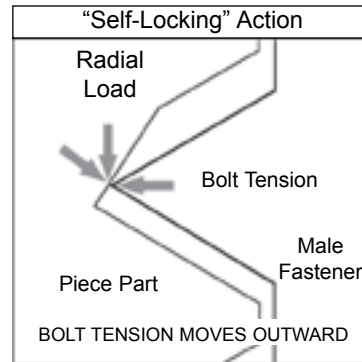
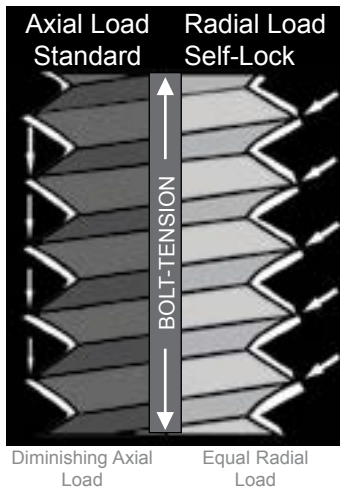
Reduces Fastener Costs
Utilizing this thread form converts standard male fasteners into highly efficient self-locking ones and may eliminate the necessity for costly locking fasteners, chemical bonds, nylon plugs or other devices to maintain tightness.

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.



SELF-LOCKING THREAD FORM

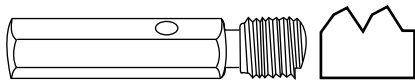
Gaging for Self-Locking Threads

How to Order

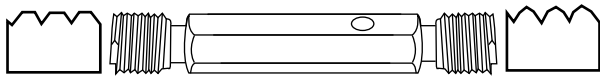
An essential element in high quality thread production is an accurate gaging capability. To facilitate the latter Precision offers a complete gaging system for self-locking threads, which consists of the following:

LARGER DIAMETERS

Go-Pitch Diameter and Ramp Gage

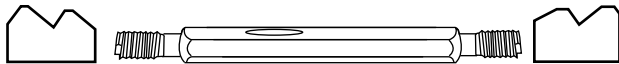


Hi-Pitch Diameter and Ramp Gage



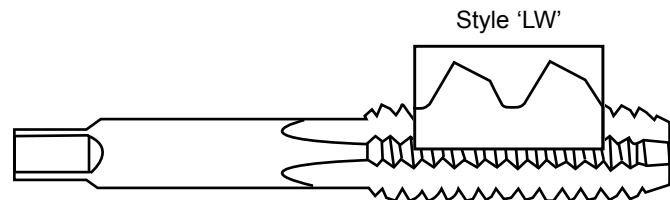
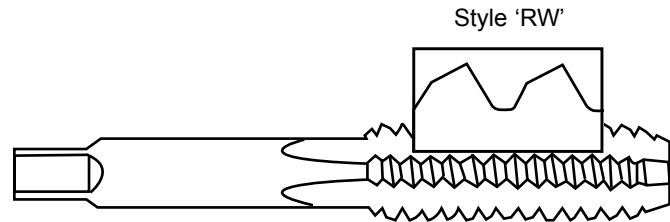
SMALLER DIAMETERS

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							

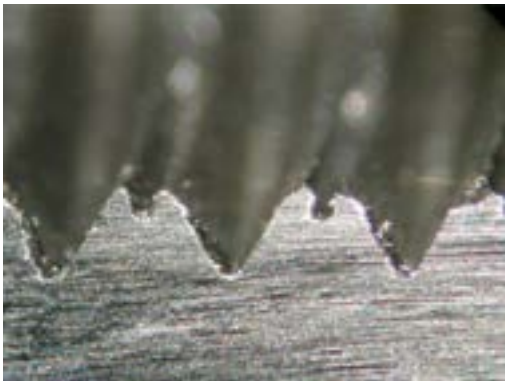
TAP DRILL SIZES FOR METRIC M-PROFILE SCREW THREADS

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

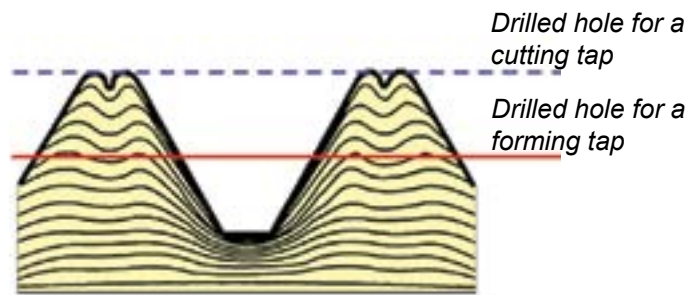
Note: "Probable Hole Size" columns listed above apply to HSS/HSCo Drills ONLY. When using Solid Carbide Drills as Tap-Drills you must ADD the average Oversize amount per diameter to the size listed in these "Probable Hole Size" columns.

FLOW OF MATERIAL WHEN FORMING A THREAD

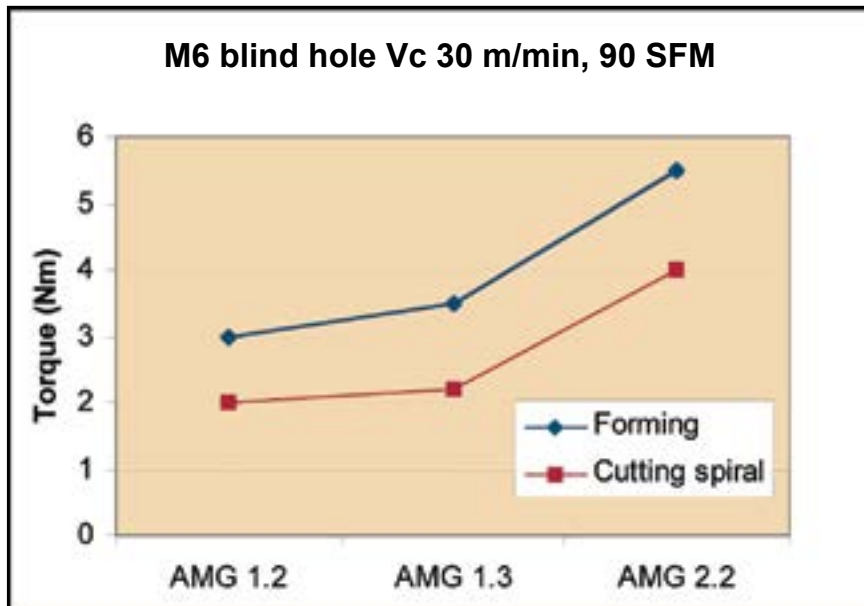
The tapping hole size depends upon the material being drilled, the cutting conditions selected and the condition of the equipment being used. If material is pushed up at the thread entry by the tap and/or the life of the tap is too short, select a slightly larger drill diameter. If on the other hand 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.

TAP PROJECTION AND HOLE SIZE FOR PIPE TAPS

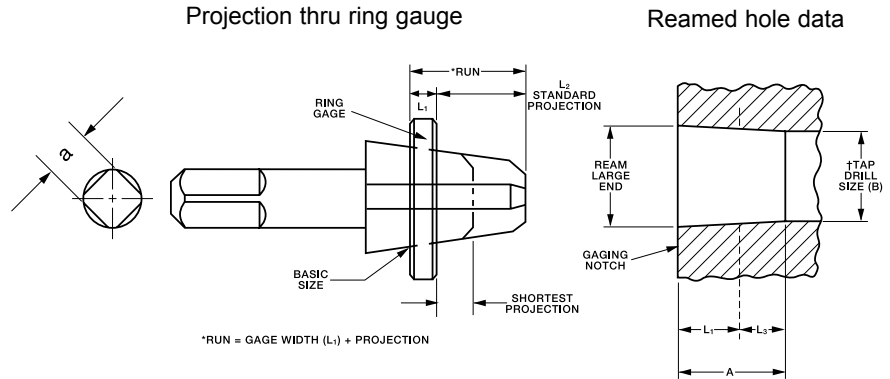
Nominal Size	Tap Thread Limits		Taper Per Ft. Limits		Projection				Ream Dia. Large End	Gage Width		A	Tap Drill Size B	Tap Drill Size BB
	L ₂	L ₂ Tolerance	Min.	Max.	NPT & NPTF		SAE - Short			L ₁	L ₃			
1/16 - 27	0.3120	±1/16	23/32	25/32	.250	0.3750	.222	.259	.2515	0.1600	.1111	.2711	15/64	C
1/8 - 27	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 L₁ Taper Thread Ring Gage.
 **Recommended sizes given permit direct tapping without reaming the hole, but only give a full thread for approx. L₁ 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	—	—								

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'
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'
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

TYPICAL TAPPING PROBLEMS

Problem	Cause	Solution
DIMENSIONAL ACCURACY		
Oversize Pitch Diameter		
	Incorrect Tap	<ol style="list-style-type: none"> 1. Use correct H limit 2. Use longer chamfered taps 3. Consider less free cutting NR style
	Chip packing	<ol style="list-style-type: none"> 1. Use spiral pointed or spiral fluted taps 2. Reduce number of flutes to create extra chip space 3. Use larger drill size 4. In blind hole applications, allow deeper holes where applicable or shorten the thread length of the parts 5. Use recommended lubricant
	Galling	<ol style="list-style-type: none"> 1. Apply surface treatment such as steam oxide, TiN, TiCN or CrN 2. Use recommended lubricant 3. Reduce tapping speed 4. Use correct tap for the material being tapped
	Operating Conditions	<ol style="list-style-type: none"> 1. Ensure correct tapping speeds to avoid torn threads 2. Check alignment of tap and drilled hole 3. Use lead screw tapper 4. Use tapping machine with adequate horsepower 5. Check misalignment of tap and drilled hole due to loose spindle or worn holder
	Tool Condition	<ol style="list-style-type: none"> 1. Check accuracy of chamfer lead grinding 2. Ensure correct cutting angles 3. Land widths too narrow 4. Check burrs from regrinding not present
Oversize Internal Diameter		
	Hole Size	<ol style="list-style-type: none"> 1. Use smaller drill size 2. Avoid tapered hole 3. Use taps with correct chamfer
	Galling	See solutions prescribed under Oversize Pitch Diameter
Undersized Pitch Diameter		
	Incorrect Tap	<ol style="list-style-type: none"> 1. Use oversize taps <ul style="list-style-type: none"> » For cutting materials such as copper alloy, aluminum alloy and cast iron » For cutting tubing which will have "spring back" action after tapping 2. Use taps with correct chamfer angle 3. Use taps with higher cutting angle
	Damaged Thread	Use proper reversing speed to avoid damaging tapped thread on the existing hole
	Leftover Chips	<ol style="list-style-type: none"> 1. Improve operating conditions to eliminate leftover chips in the hole 2. Remove left over chips prior to gage checking
Undersized Internal Diameter		
	Hole Size	Use larger drill size
SURFACE FINISH		
Torn or Rough Threads		
	Dull Tap	Resharpen
	Chamfer too short	Increase chamfer length
	Incorrect rake angle	Use correct rake angle suitable for material tapped
	Galling	<ol style="list-style-type: none"> 1. Use thread relieved taps 2. Reduce land width 3. Apply surface treatment such as steam oxide, TiN, or chrome 4. Use recommended lubricant 5. Reduce tapping speed 6. Use larger drill size 7. Check alignment between tap and hole

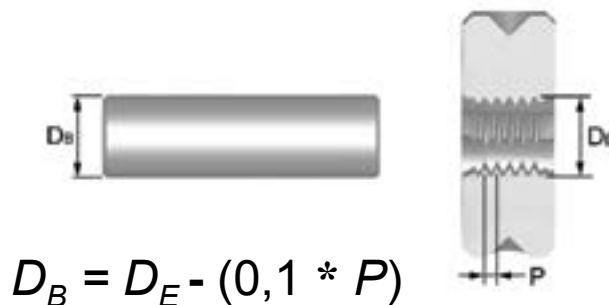
Problem	Cause	Solution
	Chip Packing	<ol style="list-style-type: none"> 1. Use spiral pointed or spiral fluted taps 2. Use larger drill size
Chattering on Tapped Thread		
	Too Positive	<ol style="list-style-type: none"> 1. Use lower rake angle 2. Reduce amount of thread relief - consider NR style 3. Use taps with wider land
	Tool Condition	Use taps with wider land
TOOL LIFE		
Breakage		
	Incorrect Tap Selection	<ol style="list-style-type: none"> 1. Tapping too deep. Avoid chip packing in the flutes or bottom of the hole. Use spiral pointed, spiral fluted or cold forming tap. 2. Use correct surface treatment such as steam oxide, TiN, TiCN or CrN
	Excessive Tapping Torque	<ol style="list-style-type: none"> 1. Hole too small - use correct size drill 2. Shorten thread length 3. Increase rake angle 4. Use a tap with more thread relief and reduced land width 5. Use spiral pointed or spiral fluted taps
	Operating Conditions	<ol style="list-style-type: none"> 1. Reduce tapping speed 2. Avoid misalignment between tap and the hole and tapered hole 3. Use floating type of tapping holder 4. Use tapping holder with torque adjustment 5. Avoid hitting bottom of the hole
	Tool Condition	<ol style="list-style-type: none"> 1. Use taps with wider land width 2. Remove all worn sections when regrinding the flutes 3. Regrind tool more frequently
Chipping		
	Incorrect Tap Selection	<ol style="list-style-type: none"> 1. Use tap with lower rake angle 2. Consider different tool steel 3. Reduce hardness of the tap 4. Increase chamfer length 5. Avoid chip packing in the flutes or in the bottom of the hole by using spiral fluted or spiral pointed taps
	Operating Conditions	<ol style="list-style-type: none"> 1. Reduce tapping speed 2. Avoid misalignment between tap and hole 3. Avoid sudden reverse in blind hole tapping 4. Avoid galling 5. Use larger drill size 6. Ensure adequate lubricant 7. Check for hard spots in the workpiece
Excessive Wear		
	Incorrect Tap Selection	<ol style="list-style-type: none"> 1. Consider specially designed taps 2. Change to an Applix style of tap made from PM material 3. Apply special surface treatment such as steam oxide, TiN, TiCN or CrN 4. Increase chamfer length
	Operating Conditions	<ol style="list-style-type: none"> 1. Reduce tapping speed 2. Apply adequate lubrication 3. Avoid work hardening the material being tapped 4. Use larger drill size
	Tool Condition	<ol style="list-style-type: none"> 1. Ensure correct rake angle 2. Minimize heat in grinding process to avoid de-tempering

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.

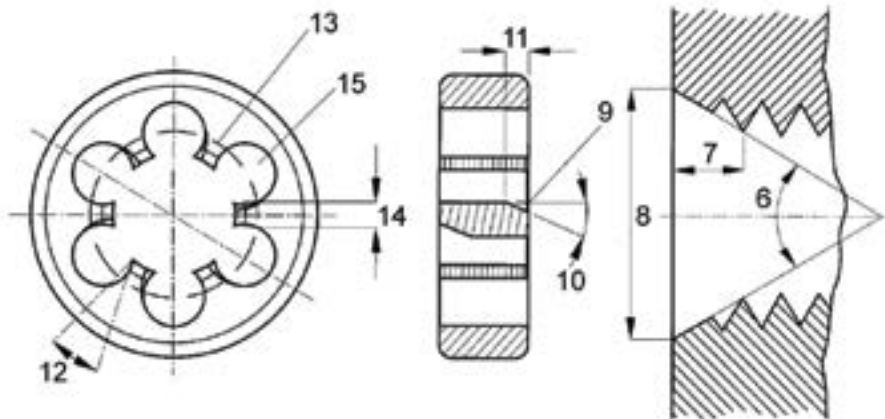
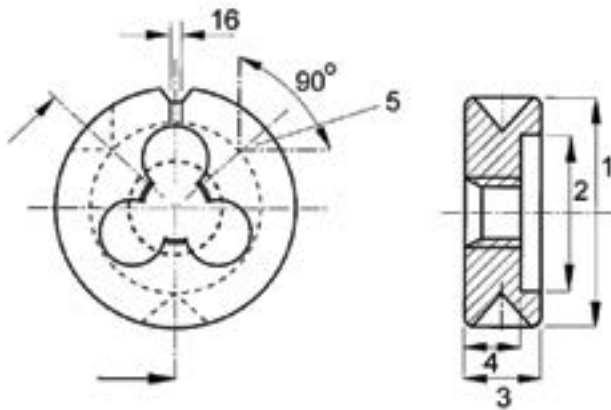
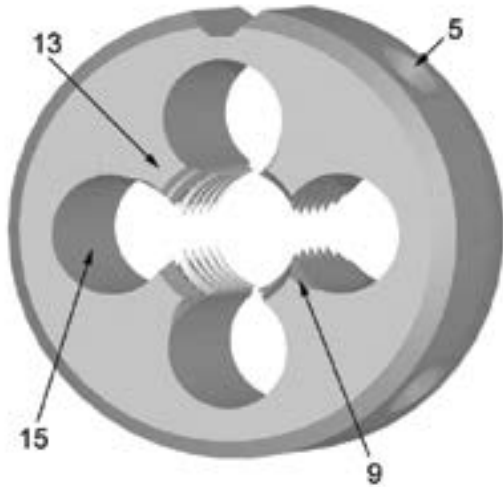


TROUBLE SHOOTING WHEN THREADING WITH DIES

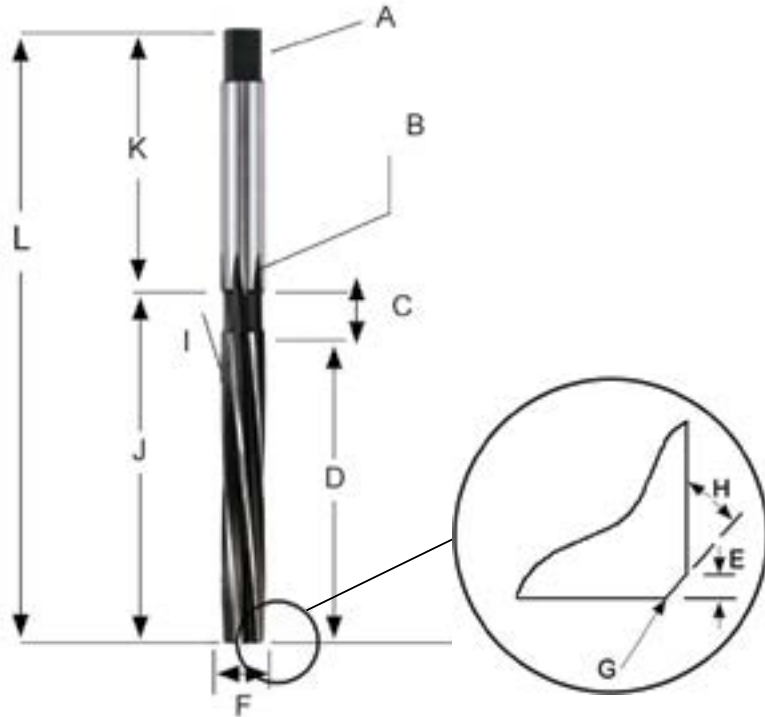
<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
Oversize / Undersize		
	Misalignment	Correct alignment, ensure cleanliness
	Incorrect axial feed rate	Ensure axial feed rate is controlled accurately
Poor finish		
	Incorrect rake angle for the material	Try alternative dies or special die
	Incorrect/lack of 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
Chipping / Breakage		
	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
Rapid wear		
	Incorrect/lack of lubricant	See lubricants section
	Speed too high	Follow recommendations in Catalog
Built up edge		
	Incorrect/lack of lubricant	See section lubricants
	Bar diameter too large	Reduce to appropriate size
	Speed too low	Follow recommendations in Catalog

DIE DEFINITIONS / NOMENCLATURE

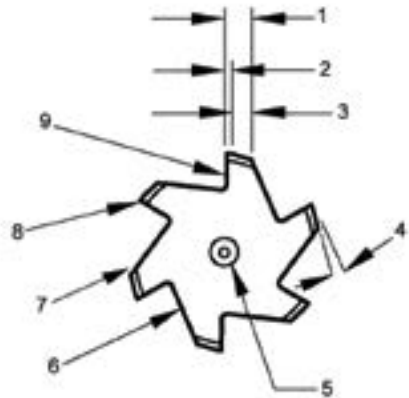
- 1 Outside Diameter
- 2 Recess Diameter
- 3 Thickness
- 4 Thread Length
- 5 Conical Hole for Fixing Screw
- 6 Chamfer Angle
- 7 Chamfer Length
- 8 Chamfer Diameter
- 9 Gun-nose
- 10 Spiral Angle
- 11 Spiral Length
- 12 Rake Angle
- 13 Land
- 14 Width of Land
- 15 Clearance Hole
- 16 Split of Adjustment



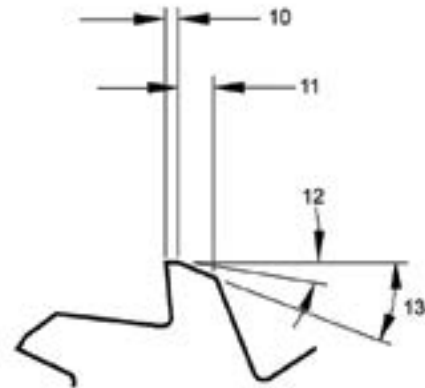
REAMER DEFINITIONS / NOMENCLATURE



- 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 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.

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"

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.

Applications - Reamer Selection

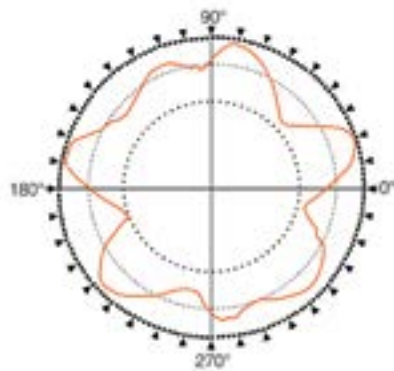
The most common types of reamers have a left-hand spiral because the main applications involve through holes requiring chips to be pushed forward. For blind holes, reamers with straight flutes or right hand spirals are recommended.

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 μm . This compared with a variance of up to 10 μm with unequal spacing.

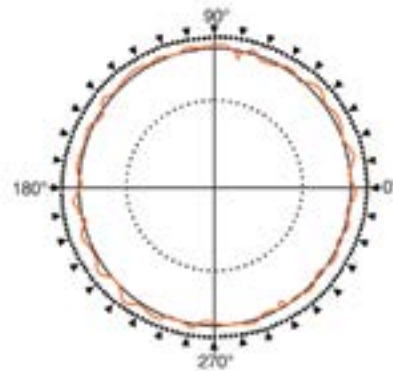
CARBIDE REAMERS - COMPARISON SPACING / EU SPACING

unequal spacing
roundness error up to 10 μm



Results of roundness

extremely unequal spacing
roundness error up to 1 - 2 μm



Results of roundness

TROUBLE SHOOTING WHEN REAMING

<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
Broken or twisted tangs		
	Incorrect fit between shank and socket	Ensure the shank and the socket are clean and free from damage
Rapid Tool Wear		
	Insufficient stock to remove	Increase the amount of stock to be removed
Oversize Hole		
	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
Undersize hole		
	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.
Oval and conical holes		
	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
Bad Hole finish		
	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
The tool clamps and breaks		
	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

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.



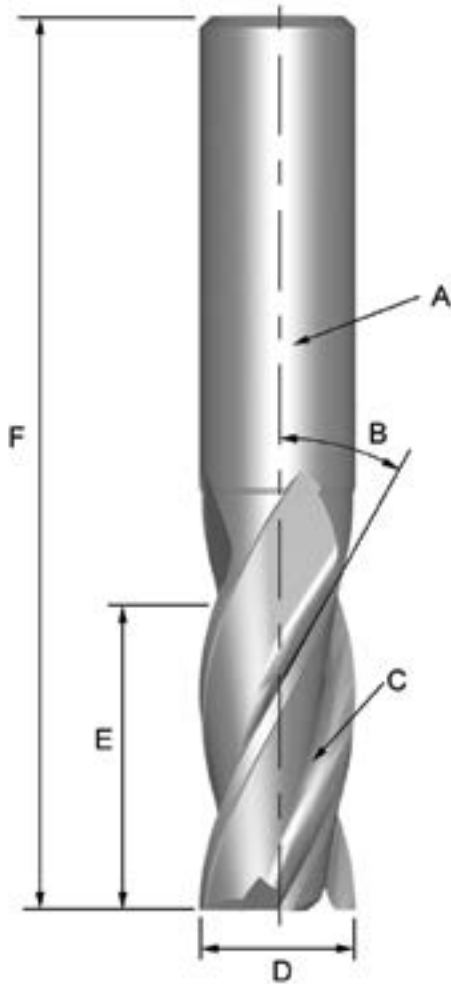
Technical Section - Counterboring and Countersinking



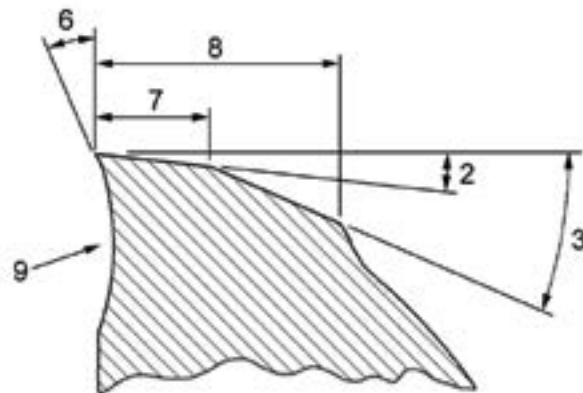
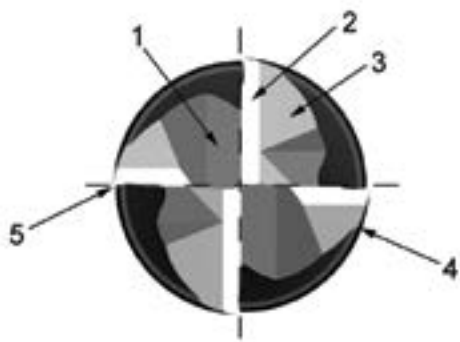
TROUBLE SHOOTING WHEN COUNTERBORING

<i>Problem</i>	<i>Cause</i>	<i>Solution</i>
Excessive Cutting Edge Wear		
	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
Chipping		
	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
Short Tool Life		
	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
Glazed Finish		
	Feed too light	Increase feed
	Dull cutting edge	Resharpen tool to original geometry
	Insufficient clearance	Resharpen tool with more clearance
Rough Finish		
	Dull cutting edge	Resharpen to original tool geometry
	Wrong feeds & speeds	Increase speed - also try reducing feed
Chattering		
	Insufficient machine horsepower	Use tool with fewer flutes as correct feeds & speeds must be maintained
	Vibration	Resharpen tool with more clearance

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

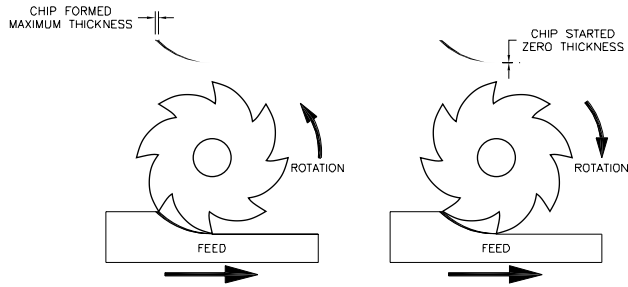
MILLING EFFECTIVELY

Types Of Cuts

Climb Milling Versus Conventional Milling

CLIMB MILLING

CONVENTIONAL MILLING



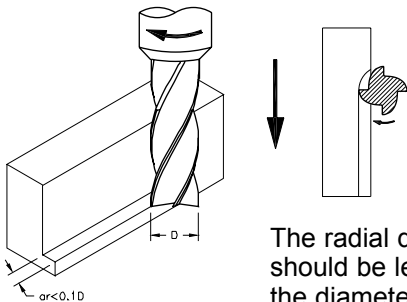
In conventional milling, the cutter revolves opposite to the direction of table feed. Therefore the width of the chip starts at zero and increases to a maximum at the end of the cut. This can lead to accelerated tool wear under some conditions. Conventional milling may be advantageous when milling hot 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.

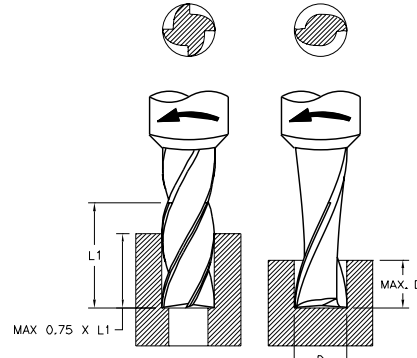
Peripheral Milling The milling of a surface which is parallel to the end mill axis.

Peripheral (Cylindrical, Slab) Milling



The radial depth of cut should be less than 0.1 of the diameter of the mill:
 $a_r < 0.1 D$.

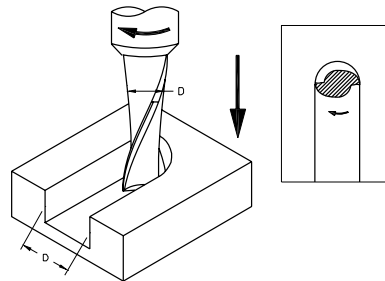
Plunge Milling The direct movement between the workpiece and the center line of the end mill when the end mill sinks directly into the workpiece.



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.

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"> • Large chip space. • Easy chip ejection. • Good for slot milling. • Good for heavy duty milling. • Less rigidity due to small section area. • Lower quality surface finish 	<ul style="list-style-type: none"> • Chip space almost as large as for 2 flutes. • Larger section area - higher rigidity than 2 flutes • Improved surface finish 	<ul style="list-style-type: none"> • Highest rigidity. • Largest section area – small chip space. • Gives best surface finish. • Recommended for profiling, side milling and shallow slotting. 	

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.



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.

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
SFM = Surface Feet Per Minute	$D \times \text{RPM} \times .26 = \text{SFM}$
RPM = Revolutions Per Minute	$\frac{\text{SFM} \times 3.82}{D} = \text{RPM}$
F = Feed in Inches Per Minute	$\text{Ft} \times \text{T} \times \text{RPM} = \text{F}$
Ft = Feed Per Tooth	$\frac{\text{F}}{\text{T} \times \text{RPM}} = \text{Ft}$
D = Cutting Diameter	
T = Number of Teeth	

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 SLOTTING

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 SLOTTING

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

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
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				

Axial Depth of Cut (DOC) recommendation = $0.2 \times D$
 Radial Depth of Cut (DOC) recommendation = $0.5 \times D$
 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
Axial DOC (maximum) = $0.5 \times D$				
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				

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
Axial DOC (maximum) = $1.0 \times D$				
Radial DOC (maximum) = $0.25 \times D$ (up to ϕ 3/8)				
Radial DOC (maximum) = $0.5 \times D$ (ϕ 1/2 - ϕ 1")				

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
Axial DOC (maximum) = $1.5 \times D$				
Radial DOC (maximum) = $0.05 \times D$				

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
Axial DOC (maximum) = $1.5 \times D$				
Radial DOC (maximum) = $0.05 \times D$				

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
Axial DOC (maximum) = $1.5 \times D$				
Radial DOC (maximum) = $0.05 \times D$				

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

SLOTING & 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)

SLOTING & 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)

SLOTING & 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)

SLOTING & 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)

SLOTING & 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

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)

MILLING TROUBLESHOOTING GUIDE

<i>Problem</i>	<i>Solution</i>	
Chipping of the Cutting Edge	<ul style="list-style-type: none"> • Apply hone .0005" to .001" • Try air blow or coolant • Reduce depth of cut • Check amount of wear on collet 	<ul style="list-style-type: none"> • Reduce feed per tooth • If wet cutting, change to dry cutting • Check tool runout • Improve the stability of the work-holding
Extreme Flank Wear	<ul style="list-style-type: none"> • Use coated end mill • If conventional milling, change to climb • If using water soluble cutting fluid, change to non-water soluble cutting fluid 	<ul style="list-style-type: none"> • Increase helix angle • If conventional milling, change to climb
Vibration / Chattering	<ul style="list-style-type: none"> • Use larger diameter end mill • Increase feed per tooth • Increase helix angle • Reduce length of flutes or overhang 	<ul style="list-style-type: none"> • Reduce cutting speed • Check or change the holder • Increase number of flutes • Tighten chuck or use stronger chuck
Deflection	<ul style="list-style-type: none"> • Reduce depth of cut • Increase feed per tooth • Increase helix angle • If using water soluble cutting fluid, change to non-water soluble cutting fluid 	<ul style="list-style-type: none"> • Use larger diameter end mill • Reduce length of flutes or overhang • If using 2-flute type, change to 4-flute type • If climb milling, change to conventional milling
Poor Surface Finish	<ul style="list-style-type: none"> • Reduce end mill runout • Increase cutting speed • Reduce feed per tooth • Use small hone .0003" to .0006" • Increase helix angle 	<ul style="list-style-type: none"> • Increase number of flutes • Increase volume of air or cutting fluid • Reduce depth of cut • If dry cutting, change to wet cutting
Waviness	<ul style="list-style-type: none"> • Reduce helix angle • Check end mill runout 	<ul style="list-style-type: none"> • Reduce depth of cut • Check or change the holder
End Mill Fracturing	<ul style="list-style-type: none"> • Reduce depth of cut • Reduce feed per tooth 	<ul style="list-style-type: none"> • Reduce length of flutes or overhang • If chip jamming occurs, reduce the number of flutes
Poor Chip Disposal	<ul style="list-style-type: none"> • Use air blow • Reduce depth of cut • Reduce feed per tooth 	<ul style="list-style-type: none"> • Reduce the number of flutes • Increase volume of air or cutting fluid • Increase cutting speed
Burring Workpiece Chipping	<ul style="list-style-type: none"> • Reduce helix angle • Reduce feed per tooth 	<ul style="list-style-type: none"> • Reduce depth of cut
Chip Welding	<ul style="list-style-type: none"> • Use coolant • Use coated end mill 	<ul style="list-style-type: none"> • Increase volume of cutting fluid • Increase helix angle



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	6A14V-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	Ultrad, 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 551. For material examples, see page 545.

	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
209	115I	98I	82F	66F	39E	30D			49E	30G	33C		98I	79E	66E	46E	75F
0860	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
1290	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
1511	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
1813	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
209CO	115J	98H	89G	75F	56E	33D			79E	36G	56C		115J	92G	72E	56E	92G
2A	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
2AB	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
2ACO	115J	98H	89G	79F	56E	33D			72E	36G	49C		115H	92D	72E	56E	92F
4ASM	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
4ASMCO	125K	108H	98G	89G	59F	36E			72F	36H	49D		112K	98F	72F	56F	98G
500-12			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
500-6			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
501-12			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
501-6			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
502-12			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
502-6			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
5ATL	89G	82G	66E	52E	30D	20B			33D	20F	13B		92H	69E	49D	43D	56E
5ATS	115I	98I	82F	66F	39E	30D			49E	30G	33C		98I	79E	66E	46E	75F
76HA	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
A002	154J	131J	115F	98F	59F	33E			66F	39G	52C		131J	98E	92E	85E	75F
A012	154J	131J	115F	98F	59F	33E			66F	39G	52C		131J	98E	92E	85E	75F
A022	115K	105K	82I	75H	52G	33E			49G	26I	30E		105K	82I	66G	52G	82I
A100	115H	98H	82F	66F	43E	30D			49E	26G	30C		98H	79F	66E	46E	75E
A101	35H	30H	25F	20F	13E	9D			15E	8G	9C		30H	24F	20E	14E	23E
A108	115I	98I	82G	66F	43E	30D			49E	30G	33D		98H	79F	66E	46E	82G
A125	79E	72E	52C	49C	20A	16A			30C	13E	26A		72G	59D	43C	30C	36D
A160	197E	197E	180D	164D	131C	121A			131B	115C	115A		164C	131A	115A	98A	115A
A170	115H	98H	82F	66E	43D	30C			49D	23F	23B		89H	72E	62D	39D	56E
A217	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
A218	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
A221	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
A225	115I	98I	82G	66F	43E	30D			49E	26G	33C		98I	79F	66E	46E	79F
A243			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
A244			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
A245	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
A345	79G	72G	56E	49D	20C	16B			39C	13E	26A		72G	59D	43C	30C	49D
A350	89I	82I	66G	52F	33E	20D			43E	13G	26C		85I	66F	59E	36E	52F
A510	187M	154M	131K	98H	69F	36D			92G	46I	62G		138K	105J	92J	82F	105G
A520	187M	154M	131K	105I	69G	36E			98I	52I	66G		157M	121K	98J	85F	112I
A530	154I	131I	98F	89F	66E	33D			79E	43G	66C		118I	92E	89E	72E	105F
A553	279L	230L	197L	148H	92F	49D			131G	62I	89G		230K	164J	148J	138F	148G
A554	279L	230L	197L	148H	92F	49D			131G	62I	89G		230K	164J	148J	138F	148G
A720	115A	98A	89A	75A	56A	33A			72A	33A	49A		98A	79A	66A	46A	75A
A900	125H	108H	85H	85H	69E	52E			49E	23E	30C		79J	62J	62J	46I	72E
A901	197J	164J	144I	144I	108G	85G			56E	30E	36C		190I	154I	112J	92I	115G
A920	131J	112J	105I	105I	75E	62E			49F	23F	30D		112L	85L	85L	62J	98G
A921	197M	171M	174J	174J	125G	98G			56F	30F	36D		174L	138L	138L	118J	157I
A940	125F	108F	72G	72G	56C	39C			49C	23E	30B			52I	52I	39H	59E
A941	174G	151G	118G	118G	75D	56D			56C	30E	36B		118I	98I	98I	79H	82F
A951	89G	72G	62E	49D	26C	20B			39C	20E	39A		72G	52D	43C	30C	59D
A952	89G	72G	62E	49D	26C	20B			39C	20E	39A		72G	52D	43C	30C	59D
A976	102C	85C	72C	72C	39A	33A			39B	23C	26A			75C	52C	36A	49C
A977	102B	85B	72B	72B	39A	33A			39B	23B	26A			75B	52B	36A	49B
A978	102A	85A	72A	72A	39A	33A			39A	23A	26A			75A	52A	36A	49A
ATR41			82F	66F	43E	30D			49E	26G	30C		98I	79F	66E	46E	75F
CO500-12						20B			95H	56F	56D	30D	161H	85H	85F	56D	
CO500-6						20B			95H	56F	56D	30D	161H	85H	85F	56D	
CO501-12						20B			95H	56F	56D	30D	161H	85H	85F	56D	
CO501-6						20B			95H	56F	56D	30D	161H	85H	85F	56D	
D33F	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
D33L	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
D33M	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
D33W	279S	246S	246S	230S	148S	148S	98S	98S	98S				246T	246T	180T	180T	
D444	197E	197E	180D	164D	131C	121A			131B	115C	115A		164C	131A	115A	98A	115A
DC	279S	246S	246S	230S	148S	148S	98S	98S					246T	246T	180T	180T	
DS-90	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 551. For material examples, see page 545.

	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 551. For material examples, see page 545.

	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 551. For material examples, see page 545.

	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 551. For material examples, see page 545.

	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
SPL-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPL-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPLG-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPLG-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPR-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPR-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPRG-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPRG-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPS-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPS-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPSG-120	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
SPSG-90	115E	98E	89C	69C	46C	33B			52C	30D	33B		105E	89C	66C	52B	89C
TS10	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
TS18	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
TS41	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
TS51	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G
TS52	115J	98J	89G	69G	46F	33E			52F	30H	33D		105J	89G	66F	52F	89G

Calculations: (inch)

RPM = SFM/D x 3.82
 SFM = RPM x D x .262
 IPM = IPR x RPM
 IPR = IPM ÷ RPM
 Inch = mm x .0394

Terms:

D = Drill Diameter
 RPM = Revolutions Per Minute
 SFM = Surface Feet per Minute
 IPM = Inches Per Minute
 IPR = Inches Per Revolution

APPLICATION MATERIAL GROUPS - DRILLS

SURFACE FEET PER MINUTE (SFM)

*Feed rate chart - see page 551. For material examples, see page 545.

	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 545.

	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 545.

	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 545.

	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 545.

	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 545.

	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												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 545.

	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 545.

	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 545.

	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 560 & 561. For material examples, see page 545.

	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 560 & 561. For material examples, see page 545.

	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 560 & 561. For material examples, see page 545.

	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 560 & 561. For material examples, see page 545.

	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
 ↓ 0,5D ↔ D	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
	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
	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	0.0066	0.0066	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
 ↓ D ↔ 0,8D	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
	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
	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
 ↓ 1,5D ↔ 0,25D	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
	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
	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
 ↓ 1,5D ↔ 0,1D	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
	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
	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)
 $RPM = SFM/D \times 3.82$ $F = Ft \times T \times RPM$
 $RPM = [(m/min.) \times 1000] \div (3.14 \times D)$

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 545.

	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 563. **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 562. For material examples, see page 545.

	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

SURFACE FEET PER MINUTE (SFM)

Material examples page 563.

	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 - 001400

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
000000	E53021/8	368	0000410	A1001.45	79	0001028	A10013.75	84	001141	E3304M12.0	377
000001	E53023/16	368	0000427	A1001.5	79	001028	E3302M2.0	367	001141	E3304M12.0	377
000002	E53021/4	368	0000434	A1001.55	79	001028	E3302M2.0	367	001143	E3304M14.0	377
000004	E53023/8	368	0000441	A1001.6	79	001029	E3302M2.5	367	001144	E3304M16.0	377
000006	E53021/2	368	0000458	A1001.65	80	001030	E3302M3.0	367	001145	E3304M18.0	377
000020	E53041/8	378	0000465	A1001.7	80	001032	E3302M4.0	367	001146	E3304M20.0	377
000021	A100.2	78	0000472	A1001.75	80	001033	E3302M4.5	367	001147	E3304M25.0	377
000021	E53043/16	378	0000489	A1001.8	80	001034	E3302M5.0	367	0001158	A10015.5	84
000021	E53043/16	378	0000496	A1001.85	80	0001035	A10013.8	84	0001165	A10015.75	84
000022	E53041/4	378	0000502	A1001.9	80	001035	E3302M6.0	367	0001172	A10015/32	83
000023	E53045/16	378	0000519	A1001.95	80	001035	E3302M6.0	367	0001189	A10015/64	82
000024	E53043/8	378	0000526	A10010.0	83	001036	E3302M7.0	367	0001196	A10016.0	84
000025	E53047/16	378	0000533	A10010.1	83	001037	E3302M8.0	367	001200	EB33021/16	370
000026	E53041/2	378	0000540	A10010.2	83	001038	E3302M9.0	367	001202	A10016.5	84
000027	E53045/8	378	0000557	A10010.25	83	001039	E3302M10.0	367	001202	EB33023/32	370
000028	E53043/4	378	0000564	A10010.3	83	001040	E3302M11.0	367	001202	EB33023/32	370
000030	E5304V1/8	378	0000571	A10010.4	83	001041	E3302M12.0	367	001204	EB33021/8	370
000031	E5304V3/16	378	0000588	A10010.5	83	0001042	A10013.9	84	001206	EB33025/32	370
000032	E5304V1/4	378	0000595	A10010.6	83	001043	E3302M14.0	367	001208	EB33023/16	370
000033	E5304V5/16	378	0000601	A10010.7	83	001044	E3302M16.0	367	001210	EB33027/32	370
000034	E5304V3/8	378	0000618	A10010.75	83	001046	E3302M20.0	367	001212	EB33021/4	370
000035	E5304V7/16	378	0000625	A10010.8	83	001047	E3302M25.0	367	001216	EB33025/16	370
000036	E5304V1/2	378	0000632	A10010.9	83	001050	E33031/16	374	001217	EB33023/8	370
000037	E5304V5/8	378	0000649	A10011.0	83	001052	E33033/32	374	0001219	A1001/64	78
000038	A100.25	78	0000656	A10011.1	83	001054	E33031/8	374	001219	EB33021/2	370
000038	E5304V3/4	378	0000663	A10011.2	83	001056	E33035/32	374	001219	EB33021/2	370
000038	E5304V3/4	378	0000670	A10011.25	83	001058	E33033/16	374	0001226	A10017.0	84
000040	EB53021/8	372	0000687	A10011.3	83	0001059	A1001/32	79	001228	EB3302M2.0	371
000041	EB53023/16	372	0000694	A10011.4	83	001062	E33031/4	374	001229	EB3302M2.5	371
000042	EB53021/4	372	0000700	A10011.5	83	0001066	A10013/32	83	001230	EB3302M3.0	371
000043	EB53025/16	372	0000717	A10011.6	83	001066	E33035/16	374	001232	EB3302M4.0	371
000044	EB53023/8	372	0000724	A10011.7	83	001066	E33035/16	374	0001233	A10017.5	84
000045	A100.3	78	0000731	A10011.75	83	001067	E33033/8	374	001234	EB3302M5.0	371
000046	EB53021/2	372	0000748	A10011.8	83	001069	E33031/2	374	001235	EB3302M6.0	371
000047	EB53025/8	372	0000755	A10011.9	83	0001073	A10013/64	81	001236	EB3302M7.0	371
000052	A100.32	78	0000762	A10011/16	84	0001080	A1001/4	82	001237	EB3302M8.0	371
000062	EB53041/4	382	0000779	A10011/32	82	0001097	A10014.0	84	001238	EB3302M9.0	371
000064	EB53043/8	382	0000786	A1001/16	79	001100	E33041/16	376	001239	EB3302M10.0	371
000066	EB53041/2	382	0000793	A10011/64	81	001101	E33045/64	376	0001240	A10017/32	84
000067	EB53045/8	382	0000809	A1001/2	84	001102	E33043/32	376	001241	EB3302M12.0	371
000069	A100.35	78	0000816	A10012.0	83	0001103	A10014.25	84	001243	EB3302M16.0	371
000072	EB5304V1/4	382	0000823	A10012.1	83	001103	E33047/64	376	001245	EB3302M20.0	371
000074	EB5304V3/8	382	0000830	A10012.2	83	001103	E33047/64	376	0001257	A10017/64	82
000076	A100.38	78	0000847	A10012.25	83	001104	E33041/8	376	0001264	A1001/8	80
000076	EB5304V1/2	382	0000854	A10012.3	83	001105	E33049/64	376	0001271	A10018.0	84
000076	EB5304V1/2	382	0000861	A10012.4	83	001106	E33045/32	376	0001288	A10018.5	84
000077	EB5304V5/8	382	0000878	A10012.5	84	001107	E330411/64	376	0001295	A10019.0	84
000083	A100.4	78	0000885	A10012.6	84	001108	E33043/16	376	001300	EB33041/16	380
000090	A100.42	78	0000892	A10012.7	84	001109	E330413/64	376	0001301	A10019.5	84
000106	A100.45	78	0000908	A10012.75	84	0001110	A10014.5	84	001302	EB33043/32	380
000113	A100.48	79	0000915	A10012.8	84	001110	E33047/32	376	001304	EB33041/8	380
000120	A100.5	79	0000922	A10012.9	84	001110	E33047/32	376	001306	EB33045/32	380
000137	A100.52	79	0000939	A10013.0	84	001112	E33041/4	376	001308	EB33043/16	380
000144	A100.55	79	0000946	A10013.1	84	001116	E33045/16	376	001312	EB33041/4	380
000151	A100.58	79	0000953	A10013.2	84	001117	E33043/8	376	001316	EB33045/16	380
000168	A100.6	79	0000960	A10013.25	84	001118	E33047/16	376	001317	EB33043/8	380
000175	A100.62	79	0000977	A10013.3	84	001119	E33041/2	376	0001318	A10019/32	84
000182	A100.65	79	0000984	A10013.4	84	001120	E33049/16	376	001318	EB33047/16	380
000199	A100.68	79	0000991	A10013.5	84	001121	E33045/8	376	001318	EB33047/16	380
000205	A100.7	79	001000	E33021/16	366	001122	E330411/16	376	001319	EB33041/2	380
000212	A100.72	79	001001	E33025/64	366	001123	E33043/4	376	001321	EB33045/8	380
000229	A100.75	79	001002	E33023/32	366	001124	E33047/8	376	001323	EB33043/4	380
000236	A100.78	79	001004	A10013.6	84	001125	E33041	376	0001325	A10019/64	82
000243	A100.8	79	001004	E33021/8	366	0001127	A10014.75	84	001331	EB3304M12.0	381
000250	A100.82	79	001004	E33021/8	366	001128	E3304M2.0	377	0001332	A1002.0	80
000267	A100.85	79	001005	E33029/64	366	001129	E3304M2.5	377	001333	EB3304M10.0	381
000274	A100.88	79	001006	E33025/32	366	001130	E3304M3.0	377	001335	EB3304M8.0	381
000281	A100.9	79	001007	E330211/64	366	001131	E3304M3.5	377	001337	EB3304M6.0	381
000298	A100.92	79	001008	E33023/16	366	001132	E3304M4.0	377	001338	EB3304M5.0	381
000304	A100.95	79	001010	E33027/32	366	001133	E3304M4.5	377	001339	EB3304M4.5	381
000311	A100.98	79	0001011	A10013.7	84	0001134	A10015.0	84	001340	EB3304M4.0	381
000328	A1001.0	79	001012	E33021/4	366	001134	E3304M5.0	377	001342	EB3304M3.0	381
000335	A1001.05	79	001016	E33025/16	366	001134	E3304M5.0	377	001344	EB3304M2.0	381
000342	A1001.1	79	001017	E33023/8	366	001135	E3304M6.0	377	0001349	A1002.05	80
000359	A1001.15	79	001018	E33027/16	366	001136	E3304M7.0	377	0001356	A1002.1	80
000366	A1001.2	79	001019	E33021/2	366	001137	E3304M8.0	377	0001363	A1002.15	80
000373	A1001.25	79	001020	E33029/16	366	001138	E3304M9.0	377	0001370	A1002.2	80
000380	A1001.3	79	001021	E33025/8	366	001139	E3304M10.0	377	0001387	A1002.25	80
000397	A1001.35	79	001023	E33023/4	366	001140	E3304M11.0	377	0001394	A1002.3	80
000403	A1001.4	79	001025	E33021	366	0001141	A10015.25	84	0001400	A1002.35	80

EDP NUMBER INDEX - 001417 - 003512

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0001417	A1002.4	80	0002186	A1006.5	82	002694	E3304V1/8	376	003072	EB3304V3/32	380
0001424	A1002.45	80	0002193	A1006.6	82	002695	E3304V9/64	376	003074	EB3304V1/8	380
0001431	A1002.5	80	0002200	E43021/8	365	002696	E3304V5/32	376	003076	EB3304V5/32	380
0001448	A1002.55	80	0002201	E43025/32	365	002697	E3304V11/64	376	0003077	A1018.0	87
0001455	A1002.6	80	0002202	E43023/16	365	0002698	A1011.25	86	003078	EB3304V3/16	380
0001462	A1002.65	80	0002204	E43021/4	365	002698	E3304V3/16	376	003082	EB3304V1/4	380
0001479	A1002.7	80	0002206	E43025/16	365	002699	E3304V13/64	376	003083	EB3304V5/16	380
0001486	A1002.75	80	0002208	E43023/8	365	002700	E3304V7/32	376	0003084	A1018.5	87
0001493	A1002.8	80	0002209	A1006.7	82	002702	E3304V1/4	376	003084	EB3304V3/8	380
0001509	A1002.85	80	0002210	E43021/2	365	002703	E3304V5/16	376	003085	EB3304V7/16	380
0001516	A1002.9	80	0002216	A1006.75	82	0002704	A1011.3	86	003086	EB3304V1/2	380
0001523	A1002.95	80	0002223	A1006.8	82	002704	E3304V3/8	376	003088	EB3304V5/8	380
0001530	A1002.0	84	0002230	A1006.9	82	002705	E3304V7/16	376	003090	EB3304V3/4	380
0001547	A10021/32	84	0002247	A1007.0	82	002706	E3304V1/2	376	0003091	A1019.0	87
0001554	A10021/64	82	0002250	E43041/8	375	002707	E3304V9/16	376	003130	E6302V1/8	369
0001561	A10023/64	83	0002251	E43045/32	375	002708	E3304V5/8	376	003131	E6302V3/16	369
0001578	A10025/64	83	0002252	E43043/16	375	002709	E3304V11/16	376	003132	E6302V1/4	369
0001585	A10027/64	83	0002254	A1007.1	82	002710	E3304V3/4	376	003134	E6302V3/8	369
0001592	A10029/64	83	0002254	E43041/4	375	0002711	A1011.4	86	003136	E6302V1/2	369
0001608	A1003.0	80	0002254	E43041/4	375	002711	E3304V7/8	376	003165	E6304V1/8	383
0001615	A1003.1	80	0002256	E43045/16	375	002712	E3304V1	376	003166	E6304V3/16	383
0001622	A1003.15	80	0002258	E43043/8	375	0002728	A1011.5	86	003167	E6304V1/4	383
0001639	A1003.2	80	0002260	E43041/2	375	0002735	A1011.6	86	003168	E6304V5/16	383
0001646	A1003.25	80	0002261	A1007.2	82	0002742	A1011.7	86	003169	E6304V3/8	383
0001653	A1003.3	80	0002278	A1007.25	82	0002766	A1011.8	86	003170	E6304V7/16	383
0001660	A1003.4	80	0002285	A1007.3	82	0002773	A1011.9	86	003171	E6304V1/2	383
0001677	A1003.5	81	0002292	A1007.4	82	0002780	A10110.0	87	003172	E6304V5/8	383
0001684	A1003.6	81	0002308	A1007.5	82	0002797	A10112.0	87	003173	E6304V3/4	383
0001691	A1003.7	81	0002315	A1007.6	82	0002803	A1012.0	86	003174	E6304V1	383
0001707	A1003.75	81	0002322	A1007.7	82	0002810	A1012.1	86	003251	DCN0	191
0001714	A1003.8	81	0002339	A1007.75	82	0002827	A1012.2	86	003252	DCN1	191
0001721	A1003.9	81	0002346	A1007.8	82	0002834	A1012.3	86	003253	DCN2	191
0001738	A1003/16	81	0002353	A1007.9	82	0002841	A1012.4	86	003254	DCN3	191
0001745	A10031/64	83	0002360	A1007/16	83	0002850	E3302V11/16	366	003255	DCN4	191
0001752	A1003/32	80	0002377	A1007/32	81	002851	E3302V5/64	366	003256	DCN5	191
0001769	A10033/64	84	0002384	A1007/64	80	002852	E3302V3/32	366	003257	DCN6	191
0001776	A10035/64	84	0002391	A1008.0	82	002854	E3302V1/8	366	003332	DS901/8	187
0001783	A1003/64	79	0002407	A1008.1	82	002856	E3302V5/32	366	003334	DS903/16	187
0001790	A10037/64	84	0002414	A1008.2	82	0002858	A1012.5	86	003336	DS901/4	187
0001806	A1003/8	83	0002421	A1008.25	82	002858	E3302V3/16	366	003338	DS905/16	187
0001813	A10039/64	84	0002438	A1008.3	82	002860	E3302V7/32	366	003340	DS903/8	187
0001820	A1004.0	81	0002445	A1008.4	82	002862	E3302V1/4	366	003342	DS901/2	187
0001837	A1004.1	81	0002452	A1008.5	82	002863	E3302V5/16	366	003470	D33M.8	186
0001844	A1004.2	81	0002469	A1008.6	82	002864	E3302V3/8	366	003471	D33M.9	186
0001851	A1004.25	81	0002476	A1008.7	82	0002865	A1012.6	86	003472	D33M1.0	186
0001868	A1004.3	81	0002483	A1008.75	83	002865	E3302V7/16	366	003473	D33M1.5	186
0001868	A1004.3	81	0002490	A1008.8	83	002866	E3302V1/2	366	003474	D33M2.0	186
0001875	A1004.4	81	0002506	A1008.9	83	002867	E3302V9/16	366	003475	D33M2.05	186
0001875	A1004.4	81	0002513	A1009.0	83	002868	E3302V5/8	366	003476	D33M2.5	186
0001882	A1004.5	81	0002520	A1009.1	83	0002872	A1012.7	86	003477	D33M3.0	186
0001899	A1004.6	81	0002537	A1009.2	83	0002889	A1012.8	86	003478	D33M3.5	186
0001905	A1004.7	81	0002544	A1009.25	83	0002896	A1012.9	86	003479	D33M4.5	186
0001912	A1004.75	81	0002551	A1009.3	83	0002902	A1013.0	86	003480	D33M5.5	186
0001929	A1004.8	81	0002568	A1009.4	83	0002919	A1013.2	86	003481	D33M6.0	186
0001936	A1004.9	81	0002575	A1009.5	83	002920	E3303V1/16	374	003482	D33M6.5	186
0001943	A10041/64	84	0002582	A1009.6	83	002921	E3303V3/32	374	003483	D33M7.0	186
0001950	A10043/64	84	0002599	A1009.7	83	002922	E3303V1/8	374	003484	D33M7.5	186
0001967	A1005.0	81	0002605	A1009.75	83	002923	E3303V5/32	374	003485	D33M8.0	186
0001974	A1005.1	81	0002612	A1009.8	83	002924	E3303V3/16	374	003486	D33M8.5	186
0001981	A1005.2	81	0002629	A1009.9	83	0002926	A1013.3	86	003487	D33M9.0	186
0001998	A1005.25	81	002630	EB3302V1/16	370	002926	E3303V1/4	374	003488	D33M9.5	186
0002001	A1005.3	81	002634	EB3302V1/8	370	002927	E3303V5/16	374	003489	D33M10.5	186
0002018	A1005.4	81	0002636	A1009/16	84	002928	E3303V3/8	374	003490	D33M10.75	186
0002025	A1005.5	81	002638	EB3302V3/16	370	002930	E3303V1/2	374	003491	D33M11.0	186
0002032	A1005.6	81	002640	EB3302V7/32	370	0002933	A1013.5	86	003492	D33M11.5	186
0002049	A1005.7	81	002642	EB3302V1/4	370	0002940	A1013.8	86	003493	D33M12.0	186
0002056	A1005.75	81	0002643	A1009/32	82	0002957	A1014.0	86	003500	D33WN68	183
0002063	A1005.8	82	002643	EB3302V5/16	370	0002964	A1014.2	86	003501	D33F1/32	183
0002070	A1005.9	82	002643	EB3302V5/16	370	0002971	A1014.5	86	003502	D33WN67	183
0002087	A1005/16	82	002644	EB3302V3/8	370	0002988	A1014.8	86	003503	D33WN66	183
0002094	A1005/32	81	002646	EB3302V1/2	370	0002995	A1015.0	86	003504	D33WN65	183
0002100	A1005/64	80	0002650	A1009/64	81	0003008	A1015.1	86	003505	D33WN64	183
0002117	A1005/8	84	0002667	A1011.0	86	0003015	A1015.2	86	003506	D33WN63	183
0002124	A1006.0	82	0002674	A1011.1	86	0003022	A1015.5	87	003507	D33WN62	183
0002131	A1006.1	82	0002681	A1011.2	86	0003039	A1016.0	87	003508	D33WN61	183
0002148	A1006.2	82	002690	E3304V1/16	376	0003046	A1016.5	87	003509	D33WN60	183
0002155	A1006.25	82	002691	E3304V5/64	376	0003053	A1017.0	87	003510	D33WN59	183
0002162	A1006.3	82	002692	E3304V3/32	376	0003060	A1017.5	87	003511	D33WN58	183
0002179	A1006.4	82	002693	E3304V7/64	376	003070	EB3304V1/16	380	003512	D33WN57	183

EDP NUMBER INDEX - 003513 - 010001

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
003513	D33WN56	183	003598	D33LN	184	004801	E63023/16	369	0008140	A1083.3	98
003514	D33F3/64	183	003599	D33F5/16	185	004802	E63021/4	369	0008157	A1083.4	98
003515	D33WN55	183	003600	D33LO	185	004803	E63025/16	369	0008164	A1083.5	98
003516	D33WN54	183	003601	D33LP	185	004804	E63023/8	369	0008171	A1083.6	98
003517	D33WN53	183	003602	D33F21/64	185	004806	E63021/2	369	0008188	A1083.7	98
003518	D33F1/16	183	003603	D33LQ	185	004900	E63041/8	383	0008195	A1083.8	98
003519	D33WN52	183	003604	D33LR	185	004901	E63043/16	383	0008201	A1083.9	99
003520	D33WN51	183	003605	D33F11/32	185	004902	E63041/4	383	0008218	A1083/16	99
003521	D33WN50	183	003606	D33LS	185	004903	E63045/16	383	0008232	A1083/32	98
003522	D33WN49	183	003607	D33LT	185	004904	E63043/8	383	0008249	A1083/8	100
003523	D33WN48	183	003608	D33F23/64	185	004905	E63047/16	383	0008256	A1084.0	99
003524	D33F5/64	183	003609	D33LU	185	004906	E63041/2	383	0008263	A1084.1	99
003525	D33WN47	183	003610	D33F3/8	185	004907	E63045/8	383	0008270	A1084.2	99
003526	D33WN46	183	003611	D33LV	185	004908	E63043/4	379	0008287	A1084.3	99
003527	D33WN45	183	003612	D33LW	185	004909	E63041	379	0008294	A1084.4	99
003528	D33WN44	183	003613	D33F25/64	185	005400	EB63021/8	373	0008300	A1084.5	99
003529	D33WN43	183	003614	D33LX	185	005401	EB63023/16	373	0008317	A1084.6	99
003530	D33WN42	183	003615	D33LY	185	005402	EB63021/4	373	0008324	A1084.7	99
003531	D33F3/32	183	003616	D33F13/32	185	005403	EB63025/16	373	0008331	A1084.8	99
003532	D33WN41	183	003617	D33LZ	185	005404	EB63023/8	373	0008348	A1084.9	99
003533	D33WN40	184	003618	D33F27/64	185	005406	EB63021/2	373	0008355	A1085.0	99
003534	D33WN39	184	003619	D33F7/16	185	005700	EB63041/8	383	0008362	A1085.1	99
003535	D33WN38	184	003620	D33F29/64	185	005701	EB63043/16	383	0008379	A1085.2	99
003536	D33WN37	184	003621	D33F15/32	185	005702	EB63041/4	383	0008386	A1085.3	99
003537	D33WN36	184	003622	D33F31/64	185	005703	EB63045/16	383	0008393	A1085.4	99
003538	D33F7/64	184	003623	D33F1/2	185	005704	EB63043/8	383	0008409	A1085.5	99
003539	D33WN35	184	003624	D33M3	186	005706	EB63041/2	383	0008416	A1085.6	99
003540	D33WN34	184	003626	D33M4.0	186	005707	EB63045/8	383	0008423	A1085.7	99
003541	D33WN33	184	003630	D33M5.0	186	0007549	A1081.0	97	0008430	A1085.8	99
003542	D33WN32	184	003631	D33M10.0	186	0007556	A1081.1	97	0008447	A1085.9	99
003543	D33WN31	184	003700	EB6302V1/8	373	0007563	A1081.2	97	0008454	A1085/16	100
003544	D33F1/8	184	003701	EB6302V3/16	373	0007570	A1081.3	97	0008461	A1085/32	99
003545	D33WN30	184	003702	EB6302V1/4	373	0007587	A1081.4	98	0008478	A1085/64	98
003546	D33WN29	184	003703	EB6302V5/16	373	0007594	A1081.5	98	0008485	A1086.0	99
003547	D33WN28	184	003704	EB6302V3/8	373	0007600	A1081.6	98	0008492	A1086.1	99
003548	D33F9/64	184	003706	EB6302V1/2	373	0007617	A1081.7	98	0008508	A1086.2	99
003549	D33WN27	184	003745	EB6304V1/8	379	0007624	A1081.8	98	0008515	A1086.3	99
003550	D33WN26	184	003746	EB6304V3/16	379	0007631	A1081.9	98	0008522	A1086.4	99
003551	D33WN25	184	003747	EB6304V1/4	379	0007648	A10810.0	100	0008539	A1086.5	100
003552	D33WN24	184	003748	EB6304V5/16	379	0007655	A10810.2	100	0008546	A1086.6	100
003553	D33WN23	184	003749	EB6304V3/8	379	0007662	A10810.5	100	0008553	A1086.7	100
003554	D33F5/32	184	003751	EB6304V1/2	379	0007679	A10810.8	100	0008560	A1086.8	100
003555	D33WN22	184	003752	EB6304V5/8	379	0007686	A10811.0	100	0008577	A1086.9	100
003556	D33WN21	184	004325	E3304MV2.0	377	0007693	A10811.5	100	0008584	A1087.0	100
003557	D33WN20	184	004326	E3304MV2.5	377	0007709	A10811.8	100	0008591	A1087.1	100
003558	D33WN19	184	004327	E3304MV3.0	377	0007716	A10811/32	100	0008607	A1087.2	100
003559	D33WN18	184	004328	E3304MV3.5	377	0007723	A10811/16	98	0008614	A1087.3	100
003560	D33F11/64	184	004329	E3304MV4.0	377	0007730	A10811/64	99	0008621	A1087.4	100
003567	D33WN12	184	004330	E3304MV4.5	377	0007747	A10812.1	101	0008638	A1087.5	100
003568	D33WN11	184	004331	E3304MV5.0	377	0007754	A10812.0	101	0008645	A1087.6	100
003569	D33WN10	184	004332	E3304MV6.0	377	0007778	A10812.5	101	0008652	A1087.7	100
003570	D33WN9	184	004333	E3304MV7.0	377	0007785	A10812.8	101	0008669	A1087.8	100
003571	D33WN8	184	004334	E3304MV8.0	377	0007792	A10812.9	101	0008676	A1087.9	100
003572	D33WN7	184	004335	E3304MV9.0	377	0007808	A10813.0	101	0008683	A1087/16	100
003573	D33F13/64	184	004336	E3304MV10.0	377	0007815	A10813.5	101	0008690	A1087/32	99
003574	D33WN6	184	004337	E3304MV11.0	377	0007822	A10813/32	100	0008706	A1087/64	98
003575	D33WN5	184	004338	E3304MV12.0	377	0007839	A10813/64	99	0008713	A1088.0	100
003576	D33WN4	184	004339	E3304MV14.0	377	0007846	A10814.1	99	0008720	A1088.1	100
003577	D33WN3	184	004340	E3304MV16.0	377	0007853	A10814.0	101	0008737	A1088.2	100
003578	D33F7/32	184	004341	E3304MV18.0	377	0007860	A10814.5	101	0008744	A1088.3	100
003579	D33WN2	184	004342	E3304MV20.0	377	0007877	A10815.0	101	0008751	A1088.4	100
003580	D33WN1	184	004402	EB3302MV3.0	371	0007884	A10815.25	101	0008768	A1088.5	100
003581	D33LA	184	004404	EB3302MV4.0	371	0007891	A10815.5	101	0008775	A1088.6	100
003582	D33F15/64	184	004406	EB3302MV5.0	371	0007907	A10815/32	101	0008782	A1088.7	100
003583	D33LB	184	004407	EB3302MV6.0	371	0007921	A10816.0	101	0008799	A1088.8	100
003584	D33LC	184	004408	EB3302MV7.0	371	0007945	A1081/8	98	0008805	A1088.9	100
003585	D33LD	184	004409	EB3302MV8.0	371	0007969	A1082.0	98	0008812	A1089.0	100
003586	D33F1/4	184	004410	EB3302MV9.0	371	0007976	A1082.1	98	0008829	A1089.1	100
003587	D33LF	184	004411	EB3302MV10.0	371	0007983	A1082.2	98	0008836	A1089.2	100
003588	D33LG	184	004413	EB3302MV12.0	371	0007990	A1082.3	98	0008843	A1089.3	100
003589	D33F17/64	184	004750	EB3304MV2.0	381	0008003	A1082.4	98	0008850	A1089.4	100
003590	D33LH	184	004752	EB3304MV3.0	381	0008010	A1082.5	98	0008867	A1089.5	100
003591	D33LI	184	004754	EB3304MV4.0	381	0008027	A1082.6	98	0008874	A1089.6	100
003592	D33LJ	184	004756	EB3304MV5.0	381	0008034	A1082.7	98	0008881	A1089.7	100
003593	D33LK	184	004757	EB3304MV6.0	381	0008041	A1082.8	98	0008898	A1089.8	100
003594	D33F9/32	184	004759	EB3304MV8.0	381	0008058	A1082.9	98	0008904	A1089.9	100
003595	D33LL	184	004761	EB3304MV10.0	381	0008119	A1083.0	98	0008911	A1089/32	100
003596	D33LM	184	004763	EB3304MV12.0	381	0008126	A1083.1	98	0008928	A1089/64	98
003597	D33F19/64	184	004800	E63021/8	369	0008133	A1083.2	98	010001	R101/64	70

EDP NUMBER INDEX - 010002 - 013120

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
010002	R101/32	71	010212	R10B3/16	95	010512	R10H3/16	99	010913	L1013/64	85
010003	R103/64	71	010213	R10B13/64	95	010513	R10H13/64	99	010914	L107/32	85
010004	R101/16	71	010214	R10B7/32	95	010514	R10H7/32	99	0010914	R9501/2	19, 25, 28
010005	R105/64	71	010215	R10B15/64	95	010515	R10H15/64	99	010915	L1015/64	85
010006	R103/32	71	010216	R10B1/4	95	010516	R10H1/4	99	010916	L101/4	85
010007	R107/64	71	010217	R10B17/64	95	010517	R10H17/64	100	010917	L1017/64	85
010008	R101/8	71	010218	R10B9/32	95	010518	R10H9/32	100	010918	L109/32	85
010009	R109/64	71	010219	R10B19/64	95	010519	R10H19/64	100	010919	L1019/64	85
010010	R105/32	71	010220	R10B5/16	95	010520	R10H5/16	100	010920	L105/16	85
010011	R1011/64	71	010221	R10B21/64	95	010521	R10H21/64	100	010921	L1021/64	85
010012	R103/16	72	010222	R10B11/32	95	010522	R10H11/32	100	0010921	R95013.0	85
010013	R1013/64	72	010223	R10B23/64	95	010523	R10H23/64	100	010922	L1011/32	85
010014	R107/32	72	010224	R10B3/8	95	010524	R10H3/8	100	010923	L1023/64	85
010015	R1015/64	72	010225	R10B25/64	95	010525	R10H25/64	100	010924	L103/8	85
010016	R101/4	72	010226	R10B13/32	96	010526	R10H13/32	100	010925	L1025/64	85
010017	R1017/64	72	010227	R10B27/64	96	010527	R10H27/64	100	010926	L1013/32	85
010018	R109/32	72	010228	R10B7/16	96	010528	R10H7/16	100	010927	L1027/64	85
010019	R1019/64	72	010229	R10B29/64	96	010529	R10H29/64	101	010928	L107/16	85
010020	R105/16	72	010230	R10B15/32	96	010530	R10H15/32	101	010929	L1029/64	85
010021	R1021/64	72	010231	R10B31/64	96	010531	R10H31/64	101	010930	L1015/32	85
010022	R1011/32	72	010232	R10B1/2	96	010601	R10P1/64	70	010931	L1031/64	85
010023	R1023/64	72	010301	R10CO1/64	106	010602	R10P1/32	71	010932	L101/2	85
010024	R103/8	72	010302	R10CO1/32	106	010603	R10P3/64	71	0010938	R95033/64	19
010025	R1025/64	72	010303	R10CO3/64	106	010604	R10P1/16	71	0010945	R95017/32	19
010026	R1013/32	72	010304	R10CO11/16	107	010605	R10P5/64	71	0010952	R95013.5	19
010027	R1027/64	72	010305	R10CO5/64	107	010606	R10P3/32	71	0010969	R95035/64	19
010028	R107/16	72	010306	R10CO3/32	107	010607	R10P7/64	71	0010983	R95014.0	19
010029	R1029/64	72	010307	R10CO7/64	107	010608	R10P1/8	71	0011003	R9509/16	19
010030	R1015/32	72	010308	R10CO1/8	107	010609	R10P9/64	71	0011010	R95014.5	19
010031	R1031/64	72	010309	R10CO9/64	108	010610	R10P5/32	71	0011140	R95037/64	19
010032	R101/2	72	010310	R10CO5/32	108	010611	R10P11/64	71	0011201	R95015.0	19
010033	R1033/64	72	010311	R10CO11/64	108	010612	R10P3/16	72	0011218	R95019/32	19
010034	R1017/32	73	010312	R10CO3/16	108	010613	R10P13/64	72	0011232	R95039/64	19
010035	R1035/64	73	010313	R10CO13/64	108	010614	R10P7/32	72	0011362	R95015.5	20
010036	R109/16	73	010314	R10CO7/32	108	010615	R10P15/64	72	0011379	R9505/8	20
010037	R1037/64	73	010315	R10CO15/64	108	010616	R10P1/4	72	0011386	R95016.0	26, 29, 31
010038	R1019/32	73	010316	R10CO1/4	109	010617	R10P17/64	72	0011393	R95041/64	26, 29, 31
010039	R1039/64	73	010317	R10CO17/64	109	010618	R10P9/32	72	0011409	R95016.5	20
010040	R105/8	73	010318	R10CO9/32	109	010619	R10P19/64	72	0012161	R95021/32	20
010041	R1041/64	73	010319	R10CO19/64	109	010620	R10P5/16	72	0012185	R95017.0	20
010042	R1021/32	73	010320	R10CO5/16	109	010621	R10P21/64	72	0012215	R95043/64	26, 29, 32
010043	R1043/64	73	010321	R10CO21/64	109	010622	R10P11/32	72	0012239	R95011/16	20
010044	R1011/16	73	010322	R10CO11/32	109	010623	R10P23/64	72	0012253	R95017.5	20
010104	R10A1/16	91	010323	R10CO23/64	109	010624	R10P3/8	72	0012260	R95045/64	20
010105	R10A5/64	91	010324	R10CO3/8	109	010625	R10P25/64	72	0012277	R95018.0	20
010106	R10A3/32	91	010325	R10CO25/64	109	010626	R10P13/32	72	0012284	R95023/32	20
010107	R10A7/64	91	010326	R10CO13/32	109	010627	R10P27/64	72	0012307	R95018.5	20
010108	R10A1/8	91	010327	R10CO27/64	109	010628	R10P7/16	72	0012321	R95047/64	26, 29, 32
010109	R10A9/64	91	010328	R10CO7/16	110	010629	R10P29/64	72	0012338	R95019.0	26, 29, 32
010110	R10A5/32	92	010329	R10CO29/64	110	010630	R10P15/32	72	0012345	R9503/4	26, 29, 32
010111	R10A11/64	92	010330	R10CO15/32	110	010631	R10P31/64	72	0012376	R95049/64	20
010112	R10A3/16	92	010331	R10CO31/64	110	010632	R10P1/2	72	0012383	R95019.5	20
010113	R10A13/64	92	010332	R10CO1/2	110	010633	R10P33/64	72	0012406	R95025/32	20
010114	R10A7/32	92	010333	R10CO33/64	110	010634	R10P17/32	73	0012413	R95020.0	20
010115	R10A15/64	92	010334	R10CO17/32	110	010635	R10P35/64	73	0012437	R95051/64	20
010116	R10A1/4	92	010335	R10CO35/64	110	010636	R10P9/16	73	0012451	R95020.5	20
010117	R10A17/64	92	010336	R10CO9/16	110	010637	R10P37/64	73	0012468	R95013/16	20
010118	R10A9/32	92	010337	R10CO37/64	110	010638	R10P19/32	73	0012475	R95021.0	20
010119	R10A19/64	92	010338	R10CO19/32	110	010639	R10P39/64	73	0012536	R95053/64	26, 29, 32
010120	R10A5/16	92	010339	R10CO39/64	110	010640	R10P5/8	73	0012550	R95027/32	20
010121	R10A21/64	92	010340	R10CO5/8	110	010641	R10P41/64	73	0012574	R95021.5	26, 29, 32
010122	R10A11/32	92	010341	R10CO41/64	110	010642	R10P21/32	73	0012604	R95055/64	20
010123	R10A23/64	92	010342	R10CO21/32	110	010643	R10P43/64	73	0012628	R95022.0	20
010124	R10A3/8	92	010343	R10CO43/64	110	010644	R10P11/16	73	0012635	R9507/8	20
010126	R10A13/32	93	010344	R10CO11/16	110	0010860	R95015/32	19, 25, 28	0012642	R95057/64	20
010127	R10A27/64	93	0010396	E0212-56	234	0010877	R95012.0	19	0012666	R95023.0	20
010128	R10A7/16	93	0010419	E0215-40	234	0010884	R95031/64	19	0012673	R95029/32	20
010129	R10A29/64	93	0010440	E0232-56	248	010902	L101/32	85	0012680	R95059/64	20
010130	R10A15/32	93	0010471	E0235-40	248	010903	L103/64	85	0012703	R95015/16	20
010131	R10A31/64	93	010502	R10H1/32	97	010904	L101/16	85	0012727	R95024.0	27, 30, 32
010132	R10A1/2	93	010503	R10H3/64	97	010905	L105/64	85	0012741	R95061/64	27, 30, 32
010204	R10B1/16	94	010504	R10H1/16	98	010906	L103/32	85	0012772	R95031/32	27, 30, 32
010205	R10B5/64	94	010505	R10H5/64	98	010907	L107/64	85	0012819	R95025.0	27, 30, 32
010206	R10B3/32	94	010506	R10H3/32	98	0010907	R95012.5	19	0012826	R95063/64	27, 30, 32
010207	R10B7/64	94	010507	R10H7/64	98	010908	L101/8	85	0012833	R9501	27, 30, 32
010208	R10B1/8	94	010508	R10H1/8	98	010909	L109/64	85	0012840	R9501.1/64	27, 30, 32
010209	R10B9/64	94	010509	R10H9/64	98	010910	L105/32	85	0013090	R95026.0	27, 30, 32
010210	R10B5/32	95	010510	R10H5/32	99	010911	L1011/64	85	013115	QC21PM1.5	105
010211	R10B11/64	95	010511	R10H11/64	99	010912	L103/16	85	013120	QC21PM2.0	105

EDP NUMBER INDEX - 0013120 - 016089

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0013120	R9501.1/32	27, 30, 33	015020	R15T	72	015321	R15COU	109	016008	2A.8	79
013125	QC21PM2.5	105	015021	R15U	72	015322	R15COV	109	016009	2A.9	79
013130	QC21PM3.0	105	015022	R15V	72	015323	R15COW	109	016010	2A1.00	79
013135	QC21PM3.5	105	015023	R15W	72	015324	R15COX	109	016011	2A1.1	79
013140	QC21PM4.0	105	015024	R15X	72	015325	R15COY	109	016012	2A1.2	79
013145	QC21PM4.5	105	015025	R15Y	72	015326	R15COZ	109	016013	2A1.3	79
013150	QC21PM5.0	105	015026	R15Z	72	015601	R15PA	72	016014	2A1.4	79
013152	QC21PM5.2	105	015101	R15AA	92	015602	R15PB	72	016015	2A1.5	79
013155	QC21PM5.5	105	015102	R15AB	92	015603	R15PC	72	016016	2A1.6	79
013156	QC21PM5.6	105	015103	R15AC	92	015604	R15PD	72	016017	2A1.7	80
013160	QC21PM6.0	105	015104	R15AD	92	015605	R15PE	72	016018	2A1.8	80
013165	QC21PM6.5	105	015105	R15AE	92	015606	R15PF	72	016019	2A1.9	80
013168	QC21PM6.8	105	015106	R15AF	92	015607	R15PG	72	016020	2A2.0	80
013170	QC21PM7.0	105	015107	R15AG	92	015608	R15PH	72	016021	2A2.1	80
013175	QC21PM7.5	105	015108	R15AH	92	015609	R15PI	72	016022	2A2.2	80
013180	QC21PM8.0	105	015109	R15AI	92	015610	R15PJ	72	0016022	R96013.5	25, 28, 31
013182	QC21PM8.2	105	015110	R15AJ	92	015611	R15PK	72	016023	2A2.3	80
013185	QC21PM8.5	105	015111	R15AK	92	015612	R15PL	72	016024	2A2.4	80
013186	QC21PM8.6	105	015112	R15AL	92	015613	R15PM	72	016025	2A2.5	80
013190	QC21PM9.0	105	015113	R15AM	92	015614	R15PN	72	016026	2A2.6	80
013195	QC21PM9.5	105	015114	R15AN	92	015615	R15PO	72	016027	2A2.7	80
0013229	R9501.3/64	27, 30, 33	015115	R15AO	92	015616	R15PP	72	016029	2A2.9	80
0013243	R9501.1/16	27, 30, 33	015116	R15AP	92	015617	R15PQ	72	016030	2A3.0	80
0013267	R95027.0	27, 30, 33	015117	R15AQ	92	015618	R15PR	72	016031	2A3.1	80
0013274	R9501.5/64	27, 30, 33	015118	R15AR	92	015619	R15PS	72	016032	2A3.2	80
0013281	R9501.3/32	27, 30, 33	015119	R15AS	92	015620	R15PT	72	016033	2A3.3	80
0013304	R95028.0	27, 30, 33	015120	R15AT	92	015621	R15PU	72	016034	2A3.4	80
0013311	R9501.7/64	27, 30, 33	015121	R15AU	92	015622	R15PV	72	016035	2A3.5	81
0013328	R9501.1/8	27, 30, 33	015122	R15AV	92	015623	R15PW	72	016036	2A3.6	81
0013342	R9501.9/64	27, 30, 33	015123	R15AW	92	015624	R15PX	72	016037	2A3.7	81
0013366	R95029.0	27, 30, 33	015124	R15AX	93	015625	R15PY	72	0016039	R96035/64	25, 28, 31
0013380	R9501.5/32	27, 30, 33	015125	R15AY	93	015626	R15PZ	72	016040	2A4.0	81
0013427	R9501.11/64	27, 30, 33	015126	R15AZ	93	015804	QC21P1/16	102	016041	2A4.1	81
0013434	R95030.0	27, 30, 33	015201	R15BA	95	015805	QC21P5/64	102	016042	2A4.2	81
0013441	R9501.3/16	27, 30, 33	015202	R15BB	95	015806	QC21P3/32	102	016043	2A4.3	81
0013465	R95030.5	27, 30, 33	015203	R15BC	95	015807	QC21P7/64	102	016044	2A4.4	81
0013472	R96015/32	25, 28	015204	R15BD	95	015808	QC21P1/8	102	016045	2A4.5	81
0013489	R96012.0	25, 28	015205	R15BE	95	015809	QC21P9/64	102	016046	2A4.6	81
0013496	R96031/64	25, 28	015206	R15BF	95	015810	QC21P5/32	103	0016046	R96014.0	25, 28, 31
0013519	R96012.5	25, 28	015207	R15BG	95	015811	QC21P11/64	103	016048	2A4.8	81
0013526	R9601/2	25, 28	015208	R15BH	95	015812	QC21P3/16	103	016050	2A5.0	81
0013533	R96013.0	25, 28	015209	R15BI	95	015813	QC21P13/64	103	016051	2A5.1	81
0013540	R96033/64	25, 28	015210	R15BJ	95	015814	QC21P7/32	103	016052	2A5.2	81
0013557	R96017/32	25, 28	015211	R15BK	95	015815	QC21P15/64	103	016053	2A5.3	81
014900	QC21PM10.0	105	015212	R15BL	95	015816	QC21P1/4	103	0016053	R9609/16	25, 28, 31
014905	QC21PM10.5	105	015213	R15BM	95	015817	QC21P17/64	103	016054	2A5.4	81
014910	QC21PM11.0	105	015214	R15BN	95	015818	QC21P9/32	103	016055	2A5.5	81
014915	QC21PM11.5	105	015215	R15BO	95	015819	QC21P19/64	103	016056	2A5.6	81
014920	QC21PM12.0	105	015216	R15BP	95	015820	QC21P5/16	103	016057	2A5.7	81
014925	QC21PM12.5	105	015217	R15BQ	95	015821	QC21P21/64	103	016058	2A5.8	82
014930	QC21PM13.0	105	015218	R15BR	95	015822	QC21P11/32	103	016060	2A6.0	82
014935	QC21PM13.5	105	015219	R15BS	95	015823	QC21P23/64	103	0016060	R96014.5	25, 28, 31
014940	QC21PM14.0	105	015220	R15BT	95	015824	QC21P3/8	103	016061	2A6.1	82
014945	QC21PM14.5	105	015221	R15BU	95	015825	QC21P25/64	103	016062	2A6.2	82
014950	QC21PM15.0	105	015222	R15BV	95	015826	QC21P13/32	103	016063	2A6.3	82
014955	QC21PM15.5	105	015223	R15BW	95	015827	QC21P27/64	104	016064	2A6.4	82
014960	QC21PM16.0	105	015224	R15BX	95	015828	QC21P7/16	104	016065	2A6.5	82
014965	QC21PM16.5	105	015225	R15BY	96	015829	QC21P29/64	104	016066	2A6.6	82
014970	QC21PM17.0	105	015226	R15BZ	96	015830	QC21P15/32	104	016067	2A6.7	82
014975	QC21PM17.5	105	015301	R15COA	108	015831	QC21P31/64	104	016068	2A6.8	82
015001	R15A	72	015302	R15COB	108	015832	QC21P1/2	104	016070	2A7.0	82
015002	R15B	72	015303	R15COC	108	015833	QC21P33/64	104	016072	2A7.2	82
015003	R15C	72	015304	R15COD	108	015834	QC21P17/32	104	016073	2A7.3	82
015004	R15D	72	015305	R15COE	109	015835	QC21P35/64	104	016074	2A7.4	82
015005	R15E	72	015306	R15COF	109	015836	QC21P9/16	104	016075	2A7.5	82
015006	R15F	72	015307	R15COG	109	015837	QC21P37/64	104	016076	2A7.6	82
015007	R15G	72	015308	R15COH	109	015838	QC21P19/32	104	0016077	R96037/64	25, 28, 31
015008	R15H	72	015309	R15COI	109	015839	QC21P39/64	104	016078	2A7.8	82
015009	R15I	72	015310	R15COJ	109	015840	QC21P5/8	104	016079	2A7.9	82
015010	R15J	72	015311	R15COK	109	015841	QC21P41/64	104	016080	2A8.0	82
015011	R15K	72	015312	R15COL	109	015842	QC21P21/32	104	016081	2A8.1	82
015012	R15L	72	015313	R15COM	109	015843	QC21P43/64	104	016082	2A8.2	82
015013	R15M	72	015314	R15CON	109	015844	QC21P11/16	104	016084	2A8.4	82
015014	R15N	72	015315	R15COO	109	016002	2A.2	78	0016084	R96015.0	25, 28, 31
015015	R15O	72	015316	R15COP	109	016003	2A.3	78	016085	2A8.5	82
015016	R15P	72	015317	R15COQ	109	016004	2A.4	78	016086	2A8.6	82
015017	R15Q	72	015318	R15COR	109	016005	2A.5	79	016087	2A8.7	82
015018	R15R	72	015319	R15COS	109	016006	2A.6	79	016088	2A8.8	83
015019	R15S	72	015320	R15COT	109	016007	2A.7	79	016089	2A8.9	83

EDP NUMBER INDEX - 016090 - 018068

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
016090	2A9.0	83	016258	2A1.35	79	016447	2ACO4.7	108	017911	TS52N11	195
0016091	R96019/32	25, 28, 31	016259	2A1.45	79	016448	2ACO4.8	108	0017913	H85314.0	25
016093	2A9.3	83	016260	2A1.55	79	016450	2ACO5.0	108	017920	TS52N20	195
016094	2A9.4	83	016261	2A1.65	80	016451	2ACO5.1	108	017921	TS52N21	195
016095	2A9.5	83	016262	2A1.75	80	016452	2ACO5.2	108	017930	TS52N30	195
016096	2A9.6	83	016266	2A2.15	80	016453	2ACO5.3	108	017940	TS52N40	195
016097	2A9.7	83	016267	2A2.25	80	016455	2ACO5.5	108	017958	TS511/8	195
016098	2A9.8	83	016268	2A2.35	80	016456	2ACO5.6	108	017960	TS515/32	195
016099	2A9.9	83	016270	2A2.75	80	016457	2ACO5.7	108	017962	TS513/16	195
016100	2A10.0	83	016271	2A3.25	80	016459	2ACO5.9	108	017964	TS517/32	195
016102	2A10.2	83	016276	2A5.75	81	016460	2ACO6.0	108	017966	TS511/4	195
016103	2A10.3	83	016278	2A6.75	82	016461	2ACO6.1	108	018001	R18N1	72
016105	2A10.5	83	016279	2A7.25	82	016462	2ACO6.2	108	018002	R18N2	72
016106	2A10.6	83	016282	2A8.25	82	016463	2ACO6.3	108	018003	R18N3	72
0016107	R96039/64	26, 29, 31	016283	2A8.75	83	016464	2ACO6.4	109	018004	R18N4	72
016108	2A10.8	83	016300	2ACO10.0	109	016465	2ACO6.5	109	018005	R18N5	72
016109	2A10.9	83	016302	2ACO10.2	109	016466	2ACO6.6	109	018006	R18N6	72
016110	2A11.0	83	016305	2ACO10.5	109	016467	2ACO6.7	109	018007	R18N7	72
016112	2A11.2	83	016308	2ACO10.8	110	016468	2ACO6.8	109	018008	R18N8	72
016113	2A11.3	83	016310	2ACO11.0	110	016469	2ACO6.9	109	018009	R18N9	72
016114	2A11.4	83	016312	2ACO11.2	110	016470	2ACO7.0	109	018010	R18N10	72
0016114	R96015.5	26, 29, 31	016315	2ACO11.5	110	016471	2ACO7.1	109	018011	R18N11	72
016115	2A11.5	83	016318	2ACO11.8	110	016472	2ACO7.2	109	018012	R18N12	72
016117	2A11.7	83	016320	2ACO12.0	110	016473	2ACO7.3	109	018013	R18N13	72
016118	2A11.8	83	016322	2ACO12.2	110	016475	2ACO7.5	109	018014	R18N14	72
016120	2A12.0	83	016325	2ACO12.5	110	016478	2ACO7.8	109	018015	R18N15	72
016121	2A12.1	83	016330	2ACO13.0	110	016479	2ACO7.9	109	018016	R18N16	71
0016121	R9605/8	26, 29, 31	016355	2ACO1.05	106	016480	2ACO8.0	109	018017	R18N17	71
016122	2A12.2	83	016356	2ACO1.15	106	016482	2ACO8.2	109	018018	R18N18	71
016125	2A12.5	84	016357	2ACO1.25	107	016484	2ACO8.4	109	018019	R18N19	71
016128	2A12.8	84	016358	2ACO1.35	107	016485	2ACO8.5	109	018020	R18N20	71
016130	2A13.0	84	016359	2ACO1.45	107	016488	2ACO8.8	109	018021	R18N21	71
016135	2AB13.5	84	016360	2ACO1.55	107	016489	2ACO8.9	109	018022	R18N22	71
0016138	R96016.0	26, 29, 31	016361	2ACO1.65	107	016490	2ACO9.0	109	018023	R18N23	71
016140	2AB14.0	84	016362	2ACO1.75	107	016491	2ACO9.1	109	018024	R18N24	71
016145	2AB14.5	84	016363	2ACO1.85	107	016492	2ACO9.2	109	018025	R18N25	71
0016145	R96041/64	26, 29, 31	016364	2ACO1.95	107	016493	2ACO9.3	109	018026	R18N26	71
016150	2AB15.0	84	016365	2ACO2.05	107	016494	2ACO9.4	109	018027	R18N27	71
0016152	R96016.5	26, 29, 32	016368	2ACO2.35	107	016495	2ACO9.5	109	018028	R18N28	71
016155	2AB15.5	84	016371	2ACO3.25	107	016496	2ACO9.6	109	018029	R18N29	71
016160	2AB16.0	84	016372	2ACO3.75	108	016497	2ACO9.7	109	018030	R18N30	71
016165	2AB16.5	84	016373	2ACO4.25	108	016498	2ACO9.8	109	018031	R18N31	71
0016169	R96021/32	26, 29, 32	016375	2ACO5.25	108	0016503	R96017.5	26, 29, 32	018032	R18N32	71
016170	2AB17.0	84	016379	2ACO7.25	109	0016640	R96045/64	26, 29, 32	018033	R18N33	71
016175	2AB17.5	84	016410	2ACO1.0	106	0016664	R96018.0	26, 29, 32	018034	R18N34	71
0016176	R96017.0	26, 29, 32	016411	2ACO1.1	106	0016671	R96023/32	26, 29, 32	018035	R18N35	71
0016183	R96043/64	26, 29, 32	016412	2ACO1.2	107	0016688	R96018.5	26, 29, 32	018036	R18N36	71
0016190	R96011/16	26, 29, 32	016413	2ACO1.3	107	0016695	R96047/64	26, 29, 32	018037	R18N37	71
016215	2A.15	78	016414	2ACO1.4	107	0016817	R96019.0	26, 29, 32	018038	R18N38	71
16216	2A.16	78	016415	2ACO1.5	107	0016879	R9603/4	26, 29, 32	018039	R18N39	71
016217	2A.17	78	016416	2ACO1.6	107	0016886	R96049/64	26, 29, 32	018040	R18N40	71
016218	2A.18	78	016417	2ACO1.7	107	0016947	R96019.5	26, 29, 32	018041	R18N41	71
016219	2A.19	78	016418	2ACO1.8	107	0016954	R96025/32	26, 29, 32	018042	R18N42	71
016221	2A.21	78	016419	2ACO1.9	107	0017111	R96020.0	26, 29, 32	018043	R18N43	71
016222	2A.22	78	016420	2ACO2.0	107	0017128	R96051/64	26, 29, 32	018044	R18N44	71
016223	2A.23	78	016421	2ACO2.1	107	0017159	R96020.5	26, 29, 32	018045	R18N45	71
016224	2A.24	78	016422	2ACO2.2	107	0017166	R96021.0	26, 29, 32	018046	R18N46	71
016225	2A.25	78	016423	2ACO2.3	107	0017197	R96013/16	26, 29, 32	018047	R18N47	71
016226	2A.26	78	016424	2ACO2.4	107	0017203	R96053/64	26, 29, 32	018048	R18N48	71
016227	2A.27	78	016425	2ACO2.5	107	0017227	R96027/32	23	018049	R18N49	71
016228	2A.28	78	016426	2ACO2.6	107	0017234	R96021.5	23	018050	R18N50	71
016229	2A.29	78	016427	2ACO2.7	107	0017241	R96055/64	23	018051	R18N51	71
016232	2A.32	78	016428	2ACO2.8	107	0017258	R96022.0	23	018052	R18N52	71
016234	2A.34	78	016429	2ACO2.9	107	0017371	R9607/8	23	018053	R18N53	71
016235	2A.35	78	016430	2ACO3.0	107	0017401	R96057/64	23	018054	R18N54	71
016236	2A.36	78	016431	2ACO3.1	107	0017425	R96023.0	26, 29, 32	018055	R18N55	71
016238	2A.38	78	016432	2ACO3.2	107	0017432	R96029/32	23	018056	R18N56	71
016242	2A.42	78	016433	2ACO3.3	107	0017456	R96059/64	26, 30, 32	018057	R18N57	71
016244	2A.44	78	016434	2ACO3.4	107	0017562	R96015/16	27, 30, 32	018058	R18N58	71
016245	2A.45	78	016435	2ACO3.5	108	0017579	R96024.0	27, 30, 32	018059	R18N59	71
016246	2A.46	79	016436	2ACO3.6	108	0017586	R96061/64	27, 30, 32	018060	R18N60	71
016248	2A.48	79	016437	2ACO3.7	108	0017593	R96031/32	24	018061	R18N61	71
016250	2A.55	79	016438	2ACO3.8	108	0017722	R96025.0	24	018062	R18N62	71
016251	2A.65	79	016440	2ACO4.0	108	0017746	R96063/64	24	018063	R18N63	71
016252	2A.75	79	016441	2ACO4.1	108	0017753	R9601	27, 30, 32	018064	R18N64	71
016253	2A.85	79	016442	2ACO4.2	108	0017777	H85312.0	25	018065	R18N65	71
016254	2A.95	79	016443	2ACO4.3	108	0017791	H85312.5	25	018066	R18N66	71
016256	2A1.15	79	016444	2ACO4.4	108	0017906	H85313.0	25	018067	R18N67	71
016257	2A1.25	79	016445	2ACO4.5	108	017910	TS52N10	195	018068	R18N68	71

EDP NUMBER INDEX - 018069 - 018608

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
018069	R18N69	70	018216	R18BN16	95	018338	R18CON38	107	018519	R18HN19	99
018070	R18N70	70	018217	R18BN17	95	018339	R18CON39	107	018520	R18HN20	99
018071	R18N71	70	018218	R18BN18	95	018340	R18CON40	107	0018521	H85517.0	29
018072	R18N72	70	018219	R18BN19	95	018341	R18CON41	107	018521	R18HN21	99
018073	R18N73	70	018220	R18BN20	95	018342	R18CON42	107	018522	R18HN22	99
018074	R18N74	70	018221	R18BN21	95	018343	R18CON43	107	018523	R18HN23	99
018075	R18N75	70	018222	R18BN22	95	018344	R18CON44	107	018524	R18HN24	99
018076	R18N76	70	018223	R18BN23	95	018345	R18CON45	107	018525	R18HN25	98
018077	R18N77	70	018224	R18BN24	95	018346	R18CON46	107	018526	R18HN26	98
018078	R18N78	70	018225	R18BN25	95	0018347	H85319.0	26	018527	R18HN27	98
018079	R18N79	70	018226	R18BN26	95	018347	R18CON47	107	018528	R18HN28	98
018080	R18N80	70	018227	R18BN27	94	018348	R18CON48	107	018529	R18HN29	98
018101	R18AN1	92	018228	R18BN28	94	018349	R18CON49	107	018530	R18HN30	98
018102	R18AN2	92	018229	R18BN29	94	018350	R18CON50	107	018531	R18HN31	98
018103	R18AN3	92	018230	R18BN30	94	018351	R18CON51	107	018532	R18HN32	98
018104	R18AN4	92	018231	R18BN31	94	018352	R18CON52	107	018533	R18HN33	98
018105	R18AN5	92	018232	R18BN32	94	018353	R18CON53	107	018534	R18HN34	98
018106	R18AN6	92	018233	R18BN33	94	0018354	H85320.0	26	018535	R18HN35	98
018107	R18AN7	92	018234	R18BN34	94	018354	R18CON54	107	018536	R18HN36	98
018108	R18AN8	92	018235	R18BN35	94	018355	R18CON55	107	018537	R18HN37	98
018109	R18AN9	92	018236	R18BN36	94	018356	R18CON56	106	0018538	H85518.0	29
018110	R18AN10	92	018237	R18BN37	94	018357	R18CON57	106	018538	R18HN38	98
018111	R18AN11	92	018238	R18BN38	94	018358	R18CON58	106	018539	R18HN39	98
018112	R18AN12	92	018239	R18BN39	94	018359	R18CON59	106	018540	R18HN40	98
018113	R18AN13	92	018240	R18BN40	94	018360	R18CON60	106	018541	R18HN41	98
018114	R18AN14	92	018241	R18BN41	94	0018361	H85321.0	26	018542	R18HN42	98
018115	R18AN15	92	018242	R18BN42	94	018361	R18CON61	106	018543	R18HN43	98
018116	R18AN16	92	018243	R18BN43	94	018362	R18CON62	106	018544	R18HN44	98
018117	R18AN17	92	018244	R18BN44	94	018363	R18CON63	106	0018545	H85519.0	29
018118	R18AN18	92	018245	R18BN45	94	018364	R18CON64	106	018545	R18HN45	98
018119	R18AN19	92	018246	R18BN46	94	018365	R18CON65	106	018546	R18HN46	98
018120	R18AN20	92	018247	R18BN47	94	018366	R18CON66	106	018547	R18HN47	98
018121	R18AN21	92	018248	R18BN48	94	018367	R18CON67	106	018548	R18HN48	98
018122	R18AN22	92	018249	R18BN49	94	018368	R18CON68	106	018549	R18HN49	98
018123	R18AN23	92	018250	R18BN50	94	018369	R18CON69	106	018550	R18HN50	98
018124	R18AN24	92	018251	R18BN51	94	018370	R18CON70	106	018551	R18HN51	98
018125	R18AN25	92	018252	R18BN52	94	018371	R18CON71	106	0018552	H85520.0	29
018126	R18AN26	92	0018293	H85315.0	25	018372	R18CON72	106	018552	R18HN52	98
018127	R18AN27	91	0018293	H85315.0	25	018373	R18CON73	106	018553	R18HN53	98
018128	R18AN28	91	018301	R18CON1	108	018374	R18CON74	106	018554	R18HN54	97
018129	R18AN29	91	018302	R18CON2	108	018375	R18CON75	106	018555	R18HN55	97
018130	R18AN30	91	018303	R18CON3	108	018376	R18CON76	106	018556	R18HN56	97
018131	R18AN31	91	018304	R18CON4	108	018377	R18CON77	106	018557	R18HN57	97
018132	R18AN32	91	018305	R18CON5	108	0018378	H85322.0	26	018558	R18HN58	97
018133	R18AN33	91	018306	R18CON6	108	018378	R18CON78	106	018559	R18HN59	97
018134	R18AN34	91	018307	R18CON7	108	018379	R18CON79	106	018560	R18HN60	97
018135	R18AN35	91	018308	R18CON8	108	018380	R18CON80	106	018561	R18HN61	97
018136	R18AN36	91	018309	R18CON9	108	0018385	H85323.0	26-27	018562	R18HN62	97
018137	R18AN37	91	018310	R18CON10	108	0018392	H85324.0	27	018563	R18HN63	97
018138	R18AN38	91	018311	R18CON11	108	0018408	H85325.0	27	018564	R18HN64	97
018139	R18AN39	91	018312	R18CON12	108	0018415	H85326.0	27	018565	R18HN65	97
018140	R18AN40	91	018313	R18CON13	108	0018422	H85327.0	27	018566	R18HN66	97
018141	R18AN41	91	018314	R18CON14	108	0018439	H85328.0	27	018567	R18HN67	97
018142	R18AN42	91	018315	R18CON15	108	0018446	H85329.0	27	018568	R18HN68	97
018143	R18AN43	91	0018316	H85316.0	26	0018453	H85330.0	27	0018569	H85521.0	29
018144	R18AN44	91	018316	R18CON16	108	0018460	H85512.0	28	018569	R18HN69	97
018145	R18AN45	91	018317	R18CON17	108	0018477	H85512.5	28	018570	R18HN70	97
018146	R18AN46	91	018318	R18CON18	108	0018484	H85513.0	28	018571	R18HN71	97
018147	R18AN47	91	018319	R18CON19	108	0018491	H85514.0	28	018572	R18HN72	97
018148	R18AN48	91	018320	R18CON20	108	018501	R18HN1	99	018573	R18HN73	97
018149	R18AN49	91	018321	R18CON21	108	018502	R18HN2	99	018574	R18HN74	97
018150	R18AN50	91	018322	R18CON22	108	018503	R18HN3	99	018575	R18HN75	97
018151	R18AN51	91	0018323	H85317.0	26	018504	R18HN4	99	0018576	H85522.0	29
018152	R18AN52	91	018323	R18CON23	108	018505	R18HN5	99	018576	R18HN76	97
018201	R18BN1	95	018324	R18CON24	108	018506	R18HN6	99	018577	R18HN77	97
018202	R18BN2	95	018325	R18CON25	108	0018507	H85515.0	28-29	018578	R18HN78	97
018203	R18BN3	95	018326	R18CON26	108	018507	R18HN7	99	018579	R18HN79	97
018204	R18BN4	95	018327	R18CON27	108	018508	R18HN8	99	018580	R18HN80	97
018205	R18BN5	95	018328	R18CON28	108	018509	R18HN9	99	0018583	H85523.0	29-30
018206	R18BN6	95	018329	R18CON29	107	018510	R18HN10	99	0018590	H85524.0	30
018207	R18BN7	95	0018330	H85318.0	26	018511	R18HN11	99	018601	R18PN1	72
018208	R18BN8	95	018330	R18CON30	107	018512	R18HN12	99	018602	R18PN2	72
018209	R18BN9	95	018331	R18CON31	107	018513	R18HN13	99	018603	R18PN3	72
018210	R18BN10	95	018332	R18CON32	107	0018514	H85516.0	29	018604	R18PN4	72
018211	R18BN11	95	018333	R18CON33	107	018514	R18HN14	99	018605	R18PN5	72
018212	R18BN12	95	018334	R18CON34	107	018515	R18HN15	99	0018606	H85525.0	30
018213	R18BN13	95	018335	R18CON35	107	018516	R18HN16	99	018606	R18PN6	72
018214	R18BN14	95	018336	R18CON36	107	018517	R18HN17	99	018607	R18PN7	72
018215	R18BN15	95	018337	R18CON37	107	018518	R18HN18	99	018608	R18PN8	72

EDP NUMBER INDEX - 018609 - 020056

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
018609	R18PN9	72	018681	R18PN81	70	019319	QC21PS	103	019880	QC21GM8.0	105
018610	R18PN10	72	0018682	H85816.0	31-32	019320	QC21PT	103	019882	QC21GM8.2	105
018611	R18PN11	72	018682	R18PN82	70	019321	QC21PU	103	019885	QC21GM8.5	105
018612	R18PN12	72	018683	R18PN83	70	019322	QC21PV	103	019886	QC21GM8.6	105
0018613	H85526.0	30	018684	R18PN84	70	019323	QC21PW	103	0019887	A12510.5X315	147
018613	R18PN13	72	018685	R18PN85	70	019324	QC21PX	103	019890	QC21GM9.0	105
018614	R18PN14	72	018686	R18PN86	70	019325	QC21PY	103	0019894	A12510.5X400	147
018615	R18PN15	72	018687	R18PN87	70	019326	QC21PZ	104	019895	QC21GM9.5	105
018616	R18PN16	71	018688	R18PN88	70	019401	QC21PN1	103	0019900	A12510.0X250	147
018617	R18PN17	71	018689	R18PN89	70	019402	QC21PN2	103	019900	QC21GM10.0	105
018618	R18PN18	71	018690	R18PN90	70	019403	QC21PN3	103	019905	QC21GM10.5	105
018619	R18PN19	71	018691	R18PN91	70	019404	QC21PN4	103	019910	QC21GM11.0	105
0018620	H85527.0	30	018692	R18PN92	70	019405	QC21PN5	103	0019917	A12510.0X315	147
018620	R18PN20	71	018693	R18PN93	70	019406	QC21PN6	103	019920	QC21GM12.0	105
018621	R18PN21	71	018694	R18PN94	70	019407	QC21PN7	103	0019924	A12510.0X400	147
018622	R18PN22	71	018695	R18PN95	70	019408	QC21PN8	103	019925	QC21GM12.5	105
018623	R18PN23	71	018696	R18PN96	70	019409	QC21PN9	103	019930	QC21GM13.0	105
018624	R18PN24	71	018697	R18PN97	70	019410	QC21PN10	103	0019931	A12511.0X250	147
018625	R18PN25	71	0018699	H85817.0	32	019411	QC21PN11	103	0019948	A12511.0X315	147
018626	R18PN26	71	0018705	H85818.0	32	019412	QC21PN12	103	0019955	A12511.0X400	147
018627	R18PN27	71	0018712	H85819.0	32	019413	QC21PN13	103	0019962	A12512.0X250	148
018628	R18PN28	71	0018729	H85820.0	32	019414	QC21PN14	103	0019979	A12512.0X315	148
018629	R18PN29	71	0018736	H85821.0	32	019415	QC21PN15	103	0019986	A12512.0X400	148
018630	R18PN30	71	0018743	H85822.0	32	019416	QC21PN16	103	0019993	A12513.0X315	148
018631	R18PN31	71	0018750	H85823.0	32	019417	QC21PN17	103	0020005	A12513.0X400	148
018632	R18PN32	71	0018767	H85824.0	32	019418	QC21PN18	103	020008	2091/8	160
018633	R18PN33	71	0018774	H85825.0	32	019419	QC21PN19	103	020009	2099/64	160
018634	R18PN34	71	0018781	H85826.0	32-33	019420	QC21PN20	103	020010	2095/32	160
018635	R18PN35	71	0018798	H85827.0	33	019421	QC21PN21	103	020011	20911/64	160
018636	R18PN36	71	0018804	H85828.0	33	019422	QC21PN22	103	020012	2093/16	160
0018637	H85528.0	30	0018811	H85829.0	33	019423	QC21PN23	103	0020012	A12514.0X315	148
018637	R18PN37	71	0018828	H85830.0	33	019424	QC21PN24	103	020013	20913/64	160
018638	R18PN38	71	0018835	H860N1	34	019425	QC21PN25	103	020014	2097/32	160
018639	R18PN39	71	0018842	H860N2	34	019426	QC21PN26	102	020015	20915/64	160
018640	R18PN40	71	0018859	H860N3	34	019427	QC21PN27	102	020016	2091/4	160
018641	R18PN41	71	0018866	H860N4	34	019428	QC21PN28	102	020017	20917/64	160
018642	R18PN42	71	0018873	H860N5	34	019429	QC21PN29	102	020018	2099/32	160
018643	R18PN43	71	0018880	H860N6	34	019430	QC21PN30	102	020019	20919/64	160
0018644	H85529.0	30	0018897	H861N1	34	019431	QC21PN31	102	020020	2095/16	160
018644	R18PN44	71	0018903	H861N2	34	019432	QC21PN32	102	020021	20921/64	160
018645	R18PN45	71	0018910	H861N3	34	019433	QC21PN33	102	020022	20911/32	160
018646	R18PN46	71	0018910	H861N3	34	019434	QC21PN34	102	020023	20923/64	160
018647	R18PN47	71	0018927	H861N4	34	019435	QC21PN35	102	020024	2093/8	160
018648	R18PN48	71	0018934	H861N5	34	019436	QC21PN36	102	020025	20925/64	160
018649	R18PN49	71	0018958	R9601.1/64	27, 30, 32	019437	QC21PN37	102	020026	20913/32	160
018650	R18PN50	71	0018965	R96026.0	27, 30, 32	019438	QC21PN38	102	020027	20927/64	160
0018651	H85530.0	30	0018972	R9601.1/32	27, 30, 33	019439	QC21PN39	102	020028	2097/16	160
018651	R18PN51	71	0018989	R9601.3/64	27, 30, 33	019440	QC21PN40	102	020029	20929/64	160
018652	R18PN52	71	0018996	R9601.1/16	27, 30, 33	019441	QC21PN41	102	0020029	A12514.0X400	148
018653	R18PN53	71	0019009	R96027.0	27, 30, 33	019442	QC21PN42	102	020030	20915/32	160
018654	R18PN54	71	0019016	R9601.5/64	27, 30, 33	019443	QC21PN43	102	020031	20931/64	160
018655	R18PN55	71	0019023	R9601.3/32	27, 30, 33	019444	QC21PN44	102	020032	2091/2	160
018656	R18PN56	71	0019030	R96028.0	27, 30, 33	019445	QC21PN45	102	020033	20933/64	160
018657	R18PN57	71	0019047	R9601.7/64	27, 30, 33	019446	QC21PN46	102	020034	20917/32	160
018658	R18PN58	71	0019054	R9601.1/8	27, 30, 33	019447	QC21PN47	102	020035	20935/64	160
018659	R18PN59	71	0019061	R9601.9/64	27, 30, 33	019448	QC21PN48	102	020036	2099/16	161
018660	R18PN60	71	0019078	R96029.0	27, 30, 33	019449	QC21PN49	102	0020036	A1252.2X160	145
018661	R18PN61	71	0019085	R9601.5/32	27, 30, 33	019450	QC21PN50	102	020037	20937/64	161
018662	R18PN62	71	0019092	R9601.11/64	24	019451	QC21PN51	102	020038	20919/32	161
018663	R18PN63	71	0019108	R96030.0	24	019452	QC21PN52	102	020039	20939/64	161
018664	R18PN64	71	0019115	R9601.3/16	24	019815	QC21GM1.5	105	020040	2095/8	161
018665	R18PN65	71	0019122	R96030.5	24	019820	QC21GM2.0	105	020041	20941/64	161
018666	R18PN66	71	019301	QC21PA	103	019825	QC21GM2.5	105	020042	20921/32	161
018667	R18PN67	71	019302	QC21PB	103	019830	QC21GM3.0	105	020043	20943/64	161
0018668	H85814.0	31	019303	QC21PC	103	0019832	A1251.4X160	145	0020043	A1252.5X125	145
018668	R18PN68	71	019304	QC21PD	103	019840	QC21GM4.0	105	020044	20911/16	161
018669	R18PN69	70	019306	QC21PF	103	0019849	A1251.5X125	145	020045	20945/64	161
018670	R18PN70	70	019307	QC21PG	103	019850	QC21GM5.0	105	020046	20923/32	161
018671	R18PN71	70	019308	QC21PH	103	019852	QC21GM5.2	105	020047	20947/64	161
018672	R18PN72	70	019309	QC21PI	103	019855	QC21GM5.5	105	020048	2093/4	161
018673	R18PN73	70	019310	QC21PJ	103	0019856	A1251.5X160	145	020049	20949/64	161
018674	R18PN74	70	019311	QC21PK	103	019856	QC21GM5.6	105	020050	20925/32	161
0018675	H85815.0	31	019312	QC21PL	103	019860	QC21GM6.0	105	0020050	A1252.5X160	145
018675	R18PN75	70	019313	QC21PM	103	0019863	A1251.8X160	145	020051	20951/64	161
018676	R18PN76	70	019314	QC21PN	103	019865	QC21GM6.5	105	020052	20913/16	161
018677	R18PN77	70	019315	QC21PO	103	019868	QC21GM6.8	105	020053	20953/64	161
018678	R18PN78	70	019316	QC21PP	103	0019870	A12510.5X250	147	020054	20927/32	161
018679	R18PN79	70	019317	QC21PQ	103	019870	QC21GM7.0	105	020055	20955/64	161
018680	R18PN80	70	019318	QC21PR	103	019875	QC21GM7.5	105	020056	2097/8	161

EDP NUMBER INDEX - 020057 - 024640

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
020057	20957/64	161	0020401	A1257.5X315	146	022010	HX105/32	89	022206	HX15F	89
020058	20929/32	161	0020418	A1257.0X200	146	022011	HX1011/64	89	022207	HX15G	89
020059	20959/64	161	0020425	A1257.0X250	146	022012	HX103/16	89	022208	HX15H	89
020060	20915/16	161	0020432	A1257.0X315	146	022013	HX1013/64	89	022209	HX15I	89
020061	20961/64	161	0020449	A1258.5X250	147	022014	HX107/32	89	022210	HX15J	89
020062	20931/32	161	0020456	A1258.5X315	147	022015	HX1015/64	89	022211	HX15K	89
020063	20963/64	161	0020463	A1258.0X250	147	022016	HX101/4	89	022212	HX15L	89
0020067	A1252.0X125	145	0020470	A1258.0X315	147	022018	HX109/32	89	022213	HX15M	89
0020074	A1252.0X160	145	0020487	A1258.0X400	147	022019	HX1019/64	89	022214	HX15N	89
0020081	A1253.3X160	145	0020494	A1259.5X250	147	022020	HX105/16	89	022215	HX15O	89
0020098	A1253.5X160	145	0020500	A1259.5X315	147	022021	HX1021/64	89	022216	HX15P	89
020100	2091	161	0020517	A1259.0X250	147	022022	HX1011/32	89	022217	HX15Q	89
020101	2091.1/64	161	0020524	A1259.0X315	147	022023	HX1023/64	89	022218	HX15R	89
020102	2091.1/32	161	0020531	A1259.0X400	147	022024	HX103/8	89	022219	HX15S	89
020103	2091.3/64	161	021316	209CO1/4	170	022025	HX1025/64	89	022220	HX15T	89
020104	2091.1/16	161	021318	209CO9/32	170	022026	HX1013/32	90	022221	HX15U	89
0020104	A1253.5X200	145	021320	209CO5/16	170	022027	HX1027/64	90	022222	HX15V	89
020105	2091.5/64	161	021322	209CO11/32	170	022028	HX107/16	90	022223	HX15W	89
020106	2091.3/32	161	021324	209CO3/8	170	022029	HX1029/64	90	022224	HX15X	89
020107	2091.7/64	161	021326	209CO13/32	170	022030	HX1015/32	90	022225	HX15Y	89
020108	2091.1/8	161	021327	209CO27/64	170	022031	HX1031/64	90	022226	HX15Z	90
020109	2091.9/64	161	021328	209CO7/16	170	022032	HX101/2	90	023032	S2091/2	160
020110	2091.5/32	161	021329	209CO29/64	170	022101	HX18N1	89	023033	S20933/64	160
020111	2091.11/64	161	021330	209CO15/32	170	022102	HX18N2	89	023034	S20917/32	160
0020111	A1253.5X250	145	021331	209CO31/64	170	022103	HX18N3	89	023035	S20935/64	160
020112	2091.3/16	161	021332	209CO1/2	170	022104	HX18N4	89	023036	S2099/16	160
020114	2091.7/32	161	021333	209CO33/64	170	022105	HX18N5	89	023051	S20951/64	161
020115	2091.15/64	161	021334	209CO17/32	170	022106	HX18N6	89	023052	S20913/16	161
020116	2091.1/4	161	021335	209CO35/64	170	022107	HX18N7	89	023053	S20953/64	161
020117	2091.17/64	161	021336	209CO9/16	170	022108	HX18N8	89	023054	S20927/32	161
020118	2091.9/32	161	021337	209CO37/64	170	022109	HX18N9	89	023056	S2097/8	161
020119	2091.19/64	161	021338	209CO19/32	170	022110	HX18N10	89	023058	S20929/32	161
020120	2091.5/16	161	021339	209CO39/64	170	022111	HX18N11	89	023106	S2091.3/32	161
020121	2091.21/64	161	021340	209CO5/8	170	022112	HX18N12	89	023107	S2091.7/64	161
020122	2091.11/32	161	021341	209CO41/64	170	022113	HX18N13	89	023108	S2091.1/8	161
020124	2091.3/8	162	021342	209CO21/32	170	022114	HX18N14	89	023109	S2091.9/64	161
020126	2091.13/32	162	021343	209CO43/64	170	022115	HX18N15	89	023110	S2091.5/32	161
020127	2091.27/64	162	021344	209CO11/16	170	022116	HX18N16	89	023111	S2091.11/64	161
020128	2091.7/16	162	021345	209CO45/64	170	022117	HX18N17	89	023112	S2091.3/16	161
0020128	A1253.0X160	145	021347	209CO47/64	170	022118	HX18N18	89	023113	S2091.13/64	161
020130	2091.15/32	162	021348	209CO23/32	170	022119	HX18N19	89	023114	S2091.7/32	161
020131	2091.31/64	162	021349	209CO49/64	170	022120	HX18N20	89	023116	S2091.1/4	161
020132	2091.1/2	162	021350	209CO3/4	170	022121	HX18N21	89	023133	S2091.33/64	162
020134	2091.17/32	162	021351	209CO51/64	170	022122	HX18N22	89	023134	S2091.17/32	162
0020135	A1253.0X200	145	021352	209CO25/32	170	022123	HX18N23	89	023135	S2091.35/64	162
020136	2091.9/16	162	021353	209CO53/64	170	022124	HX18N24	89	023136	S2091.9/16	162
020140	2091.5/8	162	021354	209CO13/16	170	022125	HX18N25	89	023138	S2091.19/32	162
0020142	A1253.0X250	145	021355	209CO27/32	171	022126	HX18N26	88	023139	S2091.39/64	162
020144	2091.11/16	162	021356	209CO7/8	171	022127	HX18N27	88	023140	S2091.5/8	162
020148	2091.3/4	162	021357	209CO55/64	171	022128	HX18N28	88	023142	S2091.21/32	162
020152	2091.13/16	162	021358	209CO57/64	171	022129	HX18N29	88	023144	S2091.11/16	162
020156	2091.7/8	162	021359	209CO29/32	171	022130	HX18N30	88	023147	S2091.47/64	162
0020159	A1254.5X160	146	021360	209CO15/16	171	022131	HX18N31	88	023148	S2091.3/4	162
020160	2091.15/16	162	021362	209CO59/64	171	022132	HX18N32	88	023150	S2091.25/32	162
0020166	A1254.5X200	146	021363	209CO61/64	171	022133	HX18N33	88	023152	S2091.13/16	162
0020173	A1254.5X250	146	021364	209CO31/32	171	022134	HX18N34	88	023156	S2091.7/8	162
0020180	A1254.5X315	146	021365	209CO63/64	171	022135	HX18N35	88	023160	S2091.15/16	162
0020197	A1254.0X160	146	021400	209CO1	171	022136	HX18N36	88	023162	S2091.31/32	162
020200	2092	162	021401	209CO1.1/64	171	022137	HX18N37	88	023200	S2092	162
0020203	A1254.0X200	146	021402	209CO1.1/32	171	022138	HX18N38	88	024532	T4001/2	439
0020210	A1254.0X250	146	021404	209CO1.1/16	171	022139	HX18N39	88	024534	T40017/32	439
0020227	A1254.0X315	146	021406	209CO1.3/32	171	022140	HX18N40	88	024536	T4009/16	439
0020234	A1255.5X200	146	021407	209CO1.7/64	171	022141	HX18N41	88	024540	T4005/8	439
0020241	A1255.5X250	146	021408	209CO1.1/8	171	022142	HX18N42	88	024542	T40021/32	439
0020258	A1255.5X315	146	021411	209CO1.11/64	171	022143	HX18N43	88	024548	T4003/4	439
0020265	A1255.0X160	146	021412	209CO1.3/16	171	022144	HX18N44	88	024550	T40025/32	439
0020272	A1255.0X200	146	021414	209CO1.7/32	171	022145	HX18N45	88	024556	T4007/8	439
0020289	A1255.0X250	146	021416	209CO1.1/4	171	022146	HX18N46	88	024600	T4001	439
0020296	A1255.0X315	146	021418	209CO1.9/32	171	022147	HX18N47	88	024602	T4001.1/32	439
0020302	A1255.0X400	146	021422	209CO1.11/32	171	022148	HX18N48	88	024604	T4001.1/16	439
0020319	A1256.5X200	146	021424	209CO1.3/8	171	022149	HX18N49	88	024608	T4001.1/8	439
0020326	A1256.5X250	146	021428	209CO1.7/16	171	022150	HX18N50	88	024610	T4001.5/32	439
0020333	A1256.5X315	146	021432	209CO1.1/2	171	022151	HX18N51	88	024616	T4001.1/4	439
0020340	A1256.0X200	146	022004	HX101/16	88	022152	HX18N52	88	024620	T4001.5/16	439
0020357	A1256.0X250	146	022005	HX105/64	88	022201	HX15A	89	024622	T4001.11/32	439
0020364	A1256.0X315	146	022006	HX103/32	88	022202	HX15B	89	024624	T4001.3/8	439
0020371	A1256.0X400	146	022007	HX107/64	88	022203	HX15C	89	024632	T4001.1/2	439
0020388	A1257.5X200	146	022008	HX101/8	88	022204	HX15D	89	024636	T4001.9/16	439
0020395	A1257.5X250	146	022009	HX109/64	88	022205	HX15E	89	024640	T4001.5/8	439

EDP NUMBER INDEX - 026050 - 0029817

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
026050	5ATS5.0	163	0028698	A100N	82	0029053	A100N41	80	0029206	A100N55	79
026055	5ATS5.5	163	0028704	A100N1	82	029054	2AB5.4	80	0029213	A100N56	79
026060	5ATS6.0	163	0028711	A100N10	81	029055	2AB5.5	80	0029220	A100N57	79
026065	5ATS6.5	163	0028728	A100N11	81	029056	2AB5.6	80	0029237	A100N58	79
026068	5ATS6.8	163	0028735	A100N12	81	0029057	2AB5.7	80	0029244	A100N59	79
026070	5ATS7.0	163	0028742	A100N13	81	029058	2AB5.8	80	0029251	A100N6	81
026075	5ATS7.5	163	0028759	A100N14	81	029060	2AB6.0	80	029256	2AB1.15	79
026080	5ATS8.0	163	0028766	A100N15	81	029060	2AB6.0	80	029257	2AB1.25	79
026085	5ATS8.5	163	0028773	A100N16	81	0029060	A100N42	80	029258	2AB1.35	79
026090	5ATS9.0	163	0028780	A100N17	81	029061	2AB6.1	80	029259	2AB1.45	79
026095	5ATS9.5	163	0028797	A100N18	81	029062	2AB6.2	80	029260	2AB1.55	79
026100	5ATS10.0	163	0028803	A100N19	81	029063	2AB6.3	80	029262	2AB1.75	80
026102	5ATS10.2	163	0028810	A100N2	81	029064	2AB6.4	80	029264	2AB1.95	80
026105	5ATS10.5	163	0028827	A100N20	81	029065	2AB6.5	80	029268	2AB2.35	79
026110	5ATS11.0	164	0028834	A100N21	81	029066	2AB6.6	80	029268	2AB2.35	79
026115	5ATS11.5	164	0028841	A100N22	81	029067	2AB6.7	80	0029268	A100N60	79
026120	5ATS12.0	164	0028858	A100N23	81	029068	2AB6.8	80	029271	2AB3.25	79
026122	5ATS12.2	164	0028865	A100N24	81	029070	2AB7.0	80	0029275	A100N61	79
026125	5ATS12.5	164	0028872	A100N25	81	029072	2AB7.2	80	029276	2AB5.75	79
026128	5ATS12.8	164	0028889	A100N26	81	029073	2AB7.3	80	029278	2AB6.75	79
026130	5ATS13.0	164	0028896	A100N27	81	029074	2AB7.4	80	029279	2AB7.25	79
026135	5ATS13.5	164	0028902	A100N28	81	029075	2AB7.5	80	029281	2AB7.85	79
026138	5ATS13.8	164	0028919	A100N29	80	029076	2AB7.6	80	029282	2AB8.25	79
026140	5ATS14.0	164	0028926	A100N3	81	0029077	A100N43	80	029282	2AB8.25	79
026142	5ATS14.25	164	0028933	A100N30	80	029078	2AB7.8	80	0029282	A100N62	79
026145	5ATS14.5	164	0028940	A100N31	80	029079	2AB7.9	80	029283	2AB8.75	79
026147	5ATS14.75	164	0028957	A100N32	80	029080	2AB8.0	80	0029299	A100N63	79
026150	5ATS15.0	164	0028964	A100N33	80	029081	2AB8.1	80	0029305	A100N64	79
026155	5ATS15.5	164	0028971	A100N34	80	029082	2AB8.2	80	0029312	A100N65	79
026157	5ATS15.75	164	0028988	A100N35	80	029084	2AB8.4	80	0029329	A100N66	79
026160	5ATS16.0	164	0028995	A100N36	80	029084	2AB8.4	80	0029336	A100N67	79
026165	5ATS16.5	164	0029008	A100N37	80	0029084	A100N44	80	0029343	A100N68	79
026170	5ATS17.0	164	029010	2AB1.0	79	029085	2AB8.5	80	0029350	A100N69	79
026175	5ATS17.5	164	029011	2AB1.1	79	029086	2AB8.6	80	0029367	A100N7	81
026180	5ATS18.0	164	029012	2AB1.2	79	029087	2AB8.7	80	0029374	A100N70	79
026185	5ATS18.5	164	029013	2AB1.3	79	029088	2AB8.8	80	0029381	A100N71	79
026190	5ATS19.0	164	029014	2AB1.4	79	029089	2AB8.9	80	0029398	A100N72	79
026195	5ATS19.5	164	029015	2AB1.5	79	029090	2AB9.0	80	0029404	A100N73	79
026200	5ATS20.0	164	029015	2AB1.5	79	0029091	A100N45	80	0029411	A100N74	79
026205	5ATS20.5	164	0029015	A100N38	79	029093	2AB9.3	80	0029428	A100N75	79
026210	5ATS21.0	164	029016	2AB1.6	79	029094	2AB9.4	80	0029435	A100N76	79
026215	5ATS21.5	164	029017	2AB1.7	80	029095	2AB9.5	80	0029442	A100N77	78
026220	5ATS22.0	164	029018	2AB1.8	80	029096	2AB9.6	80	0029459	A100N78	78
026225	5ATS22.5	164	029019	2AB1.9	80	029097	2AB9.7	80	0029466	A100N79	78
026230	5ATS23.0	165	029020	2AB2.0	80	029098	2AB9.8	80	0029473	A100N8	81
026235	5ATS23.5	165	029021	2AB2.1	80	029099	2AB9.9	80	0029480	A100N80	78
026240	5ATS24.0	165	029022	2AB2.2	80	029100	2AB10.0	80	0029497	A100N9	81
026245	5ATS24.5	165	029022	2AB2.2	80	029102	2AB10.2	80	0029503	A100O	82
026250	5ATS25.0	165	0029022	A100N39	80	029103	2AB10.3	80	0029510	A100P	82
026260	5ATS26.0	165	029023	2AB2.3	80	029105	2AB10.5	80	0029527	A100Q	82
026265	5ATS26.5	165	029024	2AB2.4	80	0029107	A100N46	80	0029534	A100R	82
026270	5ATS27.0	165	029025	2AB2.5	80	029108	2AB10.8	80	0029541	A100S	83
026280	5ATS28.0	165	029026	2AB2.6	80	029109	2AB10.9	80	0029558	A100T	83
026290	5ATS29.0	165	029027	2AB2.7	80	029110	2AB11.0	80	0029565	A100U	83
026300	5ATS30.0	165	029029	2AB2.9	80	029112	2AB11.2	80	0029572	A100V	83
026310	5ATS31.0	165	029030	2AB3.0	80	029113	2AB11.3	80	0029589	A100W	83
026320	5ATS32.0	165	029031	2AB3.1	80	029114	2AB11.4	80	0029596	A100X	83
026340	5ATS34.0	165	029032	2AB3.2	80	029114	2AB11.4	80	0029602	A100Y	83
026350	5ATS35.0	165	029033	2AB3.3	80	0029114	A100N47	80	0029619	A100Z	83
026360	5ATS36.0	165	029034	2AB3.4	80	029115	2AB11.5	80	0029626	A16010.0	182
026370	5ATS37.0	165	029035	2AB3.5	81	029117	2AB11.7	80	0029633	A16010.2	182
026380	5ATS38.0	165	029036	2AB3.6	81	029118	2AB11.8	80	0029640	A16010.5	182
026400	5ATS40.0	165	029037	2AB3.7	81	029120	2AB12.0	80	0029657	A16011.0	182
026420	5ATS42.0	165	0029039	A100N4	81	029121	2AB12.1	80	0029664	A16011.5	182
026440	5ATS44.0	165	029040	2AB4.0	81	029121	2AB12.1	80	0029671	A16012.0	182
026500	5ATS50.0	165	029041	2AB4.1	81	0029121	A100N48	80	0029688	A16013.0	182
0028568	A100A	82	029042	2AB4.2	81	029122	2AB12.2	80	0029695	A16014.0	182
0028575	A100B	82	029043	2AB4.3	81	029125	2AB12.5	80	0029701	A16015.0	182
0028582	A100C	82	029044	2AB4.4	81	029127	2AB12.7	80	0029718	A16016.0	182
0028599	A100D	82	029045	2AB4.5	81	029128	2AB12.8	80	0029725	A1604.0	182
0028605	A100E	82	029046	2AB4.6	80	029129	2AB12.9	80	0029732	A1604.5	182
0028612	A100F	82	029046	2AB4.6	80	029130	2AB13.0	80	0029749	A1605.0	182
0028629	A100G	82	0029046	A100N40	80	0029138	A100N49	80	0029756	A1605.5	182
0028636	A100H	82	029048	2AB4.8	80	0029145	A100N5	81	0029763	A1606.0	182
0028643	A100I	82	029050	2AB5.0	80	0029152	A100N50	80	0029770	A1606.5	182
0028650	A100J	82	029051	2AB5.1	80	0029169	A100N51	80	0029787	A1606.8	182
0028667	A100K	82	029052	2AB5.2	80	0029176	A100N52	80	0029794	A1607.0	182
0028674	A100L	82	029053	2AB5.3	80	0029183	A100N53	79	0029800	A1607.5	182
0028681	A100M	82	029053	2AB5.3	80	0029190	A100N54	79	0029817	A1608.0	182

EDP NUMBER INDEX - 0029824 - 0036358

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0029824	A1608.5	182	0032435	R96025.65	27, 30, 32	0033678	A35020.25	164	034427	D44427/64	181
0029831	A1609.0	182	032470	4ASMC04.7	130	0033685	A35020.5	164	034428	D4447/16	181
0029848	A1609.5	182	032480	4ASMC04.8	130	0033692	A35021.0	164	034429	D44429/64	181
0030134	A1701	173	032490	4ASMC04.9	130	0033708	A35021.5	164	034430	D44415/32	181
0030141	A17011/16	172	032500	4ASMC05.0	130	0033715	A35022.0	164	034431	D44431/64	181
0030165	A17013.0	172	032510	4ASMC05.1	130	0033722	A35022.5	164	034432	D4441/2	181
0030172	A17013.5	172	032550	4ASMC05.5	130	0033739	A35023.0	165	034502	D444B	180
0030189	A17013/16	173	032570	4ASMC05.7	130	0033746	A35023.5	165	034503	D444C	180
0030196	A17014.0	172	032600	4ASMC06.0	130	0033753	A35024.0	165	034505	D444E	180
0030202	A17014.5	172	032640	4ASMC06.4	130	0033760	A35024.5	165	034506	D444F	180
0030219	A17015.0	172	032650	4ASMC06.5	130	0033777	A35025.0	165	034507	D444G	180
0030226	A17015.5	172	032680	4ASMC06.8	130	0033784	A35025.5	165	034508	D444H	181
0030233	A17015/16	173	032700	4ASMC07.0	130	0033791	A35026.0	165	034509	D444I	181
0030240	A17016.0	172	032800	4ASMC08.0	130	0033807	A35026.5	165	034510	D444J	181
0030257	A17016.5	172	032850	4ASMC08.5	130	0033814	A35027.0	165	034511	D444K	181
0030264	A17017.0	172	032950	4ASMC09.5	130	0033821	A35027.5	165	034512	D444L	181
0030271	A17017.5	172	032980	4ASMC09.8	130	0033838	A35028.0	165	034514	D444N	181
0030288	A17045/64	172	033000	4ASMC10.0	130	0033845	A35029.0	165	034515	D444O	181
0030295	A17017/32	172	033002	4ASMC10.2	130	0033852	A35030.0	165	034516	D444P	181
0030301	A17018.0	172	033005	4ASMC10.5	130	0033869	A35030.5	165	034517	D444Q	181
0030318	A17018.5	172	0033043	H85331/64	25	0033876	A35031.0	165	034518	D444R	181
0030325	A17019.0	172	0033050	H8531/2	25	0033883	A35031.5	165	034519	D444S	181
0030332	A17019.5	172	0033067	H85317/32	25	0033890	A35032.0	165	034520	D444T	181
0030349	A17019/32	172	0033074	H8539/16	25	0033906	A35033.0	165	034521	D444U	181
0030356	A17020.0	172	0033081	H85339/64	25-26	0033913	A35034.0	165	034526	D444Z	181
0030363	A17021.0	173	0033081	H85339/64	25-26	0033920	A35035.0	165	034601	D444N1	180
0030370	A17021/32	172	0033098	H85341/64	26	0033937	A35036.0	165	034603	D444N3	180
0030387	A17022.0	173	0033104	H85311/16	26	0033944	A35037.0	165	034607	D444N7	180
0030394	A17023.0	173	033110	4ASMC11.0	130	0033951	A35038.0	165	034609	D444N9	180
0030400	A17023/32	172	0033111	H85323/32	26	0033968	A35039.0	165	034610	D444N10	180
0030417	A17024.0	173	033112	4ASMC11.2	130	0033975	A35040.0	165	034611	D444N11	180
0030424	A17025.0	173	033115	4ASMC11.5	130	0033982	A35041.0	165	034613	D444N13	180
0030431	A17025/32	172	0033128	H85349/64	26	0033999	A35042.0	165	034614	D444N14	180
0030448	A17027/32	173	0033135	H85351/64	26	0034002	A35043.0	165	034615	D444N15	180
0030455	A17031/32	173	0033142	H85327/32	26	0034019	A35044.0	165	034617	D444N17	180
0030462	A17034	172	0033159	H85357/64	26	0034026	A35045.0	165	034618	D444N18	180
0030479	A17041/64	172	0033166	H85359/64	26-27	0034033	A35046.0	165	034619	D444N19	180
0030486	A17051/64	173	0033173	H85331/32	27	0034040	A35047.0	165	034620	D444N20	180
0030493	A17057/64	173	0033180	H8531/64	27	0034057	A35048.0	165	034621	D444N21	180
0030509	A17058	172	0033197	H8531.3/64	27	0034071	A3505.0	163	034625	D444N25	180
0030516	A17078	173	033200	4ASMC12.0	130	0034088	A3505.5	163	034629	D444N29	180
0030523	A1709/16	172	0033210	H8531.3/32	27	0034095	H8551/2	28	034630	D444N30	180
0030547	A190201	201	0033227	H8531.1/8	27	0034101	A35050.0	165	034632	D444N32	180
0030554	A190202	201	0033234	H8531.11/64	27	0034118	A3506.0	163	0034699	H8559/16	28
0030561	A190203	201	0033241	A35010.0	163	0034125	A3506.7	28	0034705	H85539/64	28-29
0030578	A190204	201	0033265	A35010.2	163	0034132	H85517/32	163	0034712	H85541/64	29
0030585	A190206	201	0033289	A35010.5	163	034135	2A13.5	84	0034736	H85511/16	29
0030608	A191413	201	0033296	A35010.7	163	034140	2A14.0	84	0034743	H85523/32	29
0030615	A191419	201	0033319	A35011.0	163	034145	2A14.5	84	0034798	H85549/64	29
032230	4ASMC02.3	130	0033333	A35011.5	164	0034149	A3506.8	163	0034804	H85551/64	29
032250	4ASMC02.5	130	0033340	A35011.75	164	034150	2A15.0	84	0034811	H85527/32	29
0032268	R95015.24	19, 26, 29, 31	0033357	A35011.8	164	0034156	A3507.0	163	0034835	H85557/64	29
0032275	R95016.08	26, 29, 31	0033364	A35012.0	164	0034163	A3507.5	163	0034842	H85559/64	30
0032282	R95016.3	26, 29, 31	0033395	A35012.5	164	0034187	A3508.0	163	0034859	H85531/32	30
0032299	R95017.6	26, 29, 32	0033401	A35013.0	164	0034200	A3508.4	163	0034866	H8551.1/64	30
032300	4ASMC03.0	130	0033418	A35013.5	164	0034217	A3508.5	163	0034873	H8551.3/64	30
0032305	R95019.25	26, 29, 32	0033425	H8531.3/16	27	0034224	A3508.75	163	0034897	H8551.3/32	30
032310	4ASMC03.1	130	0033432	A35014.0	164	0034248	A3509.0	163	0034903	H8551.1/8	30
0032312	R95019.3	26, 29, 32	0033449	A35014.25	164	0034279	A3509.5	163	0034934	H8551.11/64	30
032320	4ASMC03.2	130	0033456	A35014.5	164	0034293	A3509.8	163	0034965	H8551.3/16	30
0032329	R95019.35	26, 29, 32	0033463	A35014.75	164	034408	D4441/8	180	0036174	A51010.0	57
032330	4ASMC03.3	130	0033470	A35015.0	164	034409	D4449/64	180	0036181	A51010.1	57
0032336	R95022.5	26, 29, 32	0033487	A35015.25	164	034410	D4445/32	180	0036198	A51010.2	57
032340	4ASMC03.4	130	0033494	A35015.5	164	034411	D44411/64	180	0036204	A51010.3	57
0032343	R95025.65	27, 30, 32	0033500	A35015.75	164	034412	D4443/16	180	0036211	A51010.4	57
032350	4ASMC03.5	130	0033517	A35016.0	164	034413	D44413/64	180	0036228	A51010.5	57
0032350	R96015.24	26, 29, 31	0033524	A35016.25	164	034414	D4447/32	180	0036235	A51010.6	57
032360	4ASMC03.6	130	0033531	A35016.5	164	034415	D44415/64	180	0036242	A51010.7	57
0032367	R96016.08	26, 29, 31	0033548	A35016.75	164	034416	D4441/4	180	0036259	A51010.8	57
032370	4ASMC03.7	130	0033555	A35017.0	164	034417	D44417/64	180	0036266	A51010.9	58
0032374	R96016.3	26, 29, 31	0033562	A35017.25	164	034418	D4449/32	181	0036273	A51011.0	58
0032381	R96017.6	26, 29, 32	0033579	A35017.5	164	034419	D44419/64	181	0036280	A51011.1	58
0032398	R96019.25	26, 29, 32	0033586	H85531/64	28	034420	D4445/16	181	0036297	A51011.2	58
032400	4ASMC04.0	130	0033593	A35018.0	164	034421	D44421/64	181	0036303	A51011.3	58
0032404	R96019.3	23	0033616	A35018.5	164	034422	D44411/32	181	0036310	A51011.4	58
032410	4ASMC04.1	130	0033623	A35019.0	164	034423	D44423/64	181	0036327	A51011.5	58
0032411	R96019.35	26, 29, 32	0033647	A35019.5	164	034424	D4443/8	181	0036334	A51011.6	58
032420	4ASMC04.2	130	0033654	A35019.75	164	034425	D44425/64	181	0036341	A51011.7	58
0032428	R96022.5	26, 29, 32	0033661	A35020.0	164	034426	D44413/32	181	0036358	A51011.8	58

EDP NUMBER INDEX - 036365 - 040309

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0036365	A51011.9	58	0037157	A5109.6	57	0038802	A52012.1	51	0039595	A5209.9	50
0036372	A51012.0	58	0037164	A5109.7	57	0038819	A52012.2	51	0039601	R96014.7	25, 28, 31
0036389	A51012.1	58	0037171	A5109.8	57	0038826	A52012.3	51	0039618	R96014.8	25, 28, 31
0036396	A51012.2	58	0037188	A5109.9	57	0038833	A52012.4	51	0039625	R96015.1	26, 29, 31
0036402	A51012.3	58	0037904	R95012.1	19, 25, 28	0038840	A52012.5	51	0039632	R96015.2	26, 29, 31
0036419	A51012.4	58	0037911	R95012.2	19, 25, 28	0038857	A52012.6	51	0039649	R96015.6	26, 29, 31
0036426	A51012.5	58	0037928	R95012.6	19, 25, 28	0038864	A52012.7	51	0039656	R96015.7	26, 29, 31
0036433	A51012.6	58	0037935	R95012.8	19, 25, 28	0038871	A52012.8	51	0039663	R96016.1	26, 29, 31
0036440	A51012.7	58	0037942	R95012.9	19, 25, 28	0038888	A52012.9	51	0039670	R96016.2	26, 29, 31
0036457	A51012.8	58	0037959	R95013.2	19, 25, 28	0038895	A52013.0	51	0039687	R96016.6	26, 29, 32
0036464	A51012.9	58	0037966	R95013.6	19, 25, 28, 31	0038901	A5203.0	49	0039694	R96016.7	26, 29, 32
0036471	A51013.0	58	0037973	R95013.7	19, 25, 28, 31	0038918	A5203.1	49	0039700	R96017.1	26, 29, 32
0036488	A51014.0	58	0037980	R95013.8	19, 25, 28, 31	0038925	A5203.2	49	0039717	R96017.2	26, 29, 32
0036495	A5103.0	56	0037997	R95014.1	19, 25, 28, 31	0038932	A5203.3	49	0039724	R96017.7	26, 29, 32
0036501	A5103.1	56	0038000	R95014.2	19, 25, 28, 31	0038949	A5203.4	49	0039731	R96018.1	26, 29, 32
0036518	A5103.2	56	0038017	R95014.6	19, 25, 28, 31	0038956	A5203.5	49	0039748	R96018.2	26, 29, 32
0036525	A5103.3	56	0038024	R95014.7	19, 25, 28, 31	0038963	A5203.6	49	0039755	R96018.6	26, 29, 32
0036532	A5103.4	56	0038031	R95014.8	19, 25, 28, 31	0038970	A5203.7	49	0039762	R96018.7	26, 29, 32
0036549	A5103.5	56	0038048	R95015.1	19, 26, 29, 31	0038987	A5203.8	49	0039779	R96018.9	26, 29, 32
0036556	A5103.6	56	0038055	R95015.2	19, 26, 29, 31	0038994	A5203.9	49	0039786	R96019.1	26, 29, 32
0036563	A5103.7	56	0038062	R95015.6	26, 29, 31	0039007	A5204.0	49	0039793	R96019.2	26, 29, 32
0036570	A5103.8	56	0038079	R95015.7	26, 29, 31	0039014	A5204.1	49	0039809	R96019.6	26, 29, 32
0036587	A5103.9	56	0038086	R95016.1	26, 29, 31	0039021	A5204.2	49	0039816	R96019.7	26, 29, 32
0036594	A5104.0	56	0038093	R95016.2	26, 29, 31	0039038	A5204.3	49	0039823	R96022.7	26, 29, 32
0036600	A5104.1	56	0038109	R95016.6	26, 29, 32	0039045	A5204.4	49	0039830	R96023.5	27, 30, 32
0036617	A5104.2	56	0038116	R95016.7	20	0039052	A5204.5	49	0039847	R96024.5	27, 30, 32
0036624	A5104.3	56	0038123	R95017.1	20	0039069	A5204.6	49	0039854	R96025.5	27, 30, 32
0036631	A5104.4	56	0038130	R95017.2	20	0039076	A5204.7	49	0039878	R96026.5	27, 30, 33
0036648	A5104.5	56	0038147	R95017.7	20	0039083	A5204.8	49	0039885	R96027.5	27, 30, 33
0036655	A5104.6	56	0038154	R95018.1	20	0039090	A5204.9	49	0039892	R96028.5	27, 30, 33
0036662	A5104.7	56	0038161	R95018.2	20	0039106	A5205.0	49	0039908	R96029.5	27, 30, 33
0036679	A5104.8	56	0038178	R95018.6	20	0039113	A5205.1	49	040003	R403/64	113
0036686	A5104.9	56	0038185	R95018.7	20	0039120	A5205.2	49	040004	R401/16	113
0036693	A5105.0	56	0038192	R95018.9	20	0039137	A5205.3	49	040005	R405/64	113
0036709	A5105.1	56	0038208	R95019.1	20	0039144	A5205.4	49	040006	R403/32	113
0036716	A5105.2	56	0038215	R95019.2	20	0039151	A5205.5	49	040007	R407/64	113
0036723	A5105.3	56	0038222	R95019.6	26, 29, 32	0039168	A5205.6	50	040008	R401/8	114
0036730	A5105.4	56	0038239	R95019.7	26, 29, 32	0039175	A5205.7	50	040009	R409/64	114
0036747	A5105.5	56	0038246	R95022.7	26, 29, 32	0039182	A5205.8	50	040010	R405/32	114
0036754	A5105.6	57	0038253	R95023.5	27, 30, 32	0039199	A5205.9	50	040011	R4011/64	114
0036761	A5105.7	57	0038260	R95024.5	27, 30, 32	0039205	A5206.0	50	040012	R403/16	114
0036778	A5105.8	57	0038277	R95025.5	27, 30, 32	0039212	A5206.1	50	040013	R4013/64	114
0036785	A5105.9	57	0038284	R95026.5	27, 30, 33	0039229	A5206.2	50	040014	R407/32	114
0036792	A5106.0	57	0038291	R95027.5	27, 30, 33	0039236	A5206.3	50	040015	R4015/64	114
0036808	A5106.1	57	0038307	R95028.5	27, 30, 33	0039243	A5206.4	50	040016	R401/4	114
0036815	A5106.2	57	0038314	R95029.5	27, 30, 33	0039250	A5206.5	50	040017	R4017/64	114
0036822	A5106.3	57	0038338	R96012.1	25, 28	0039267	A5206.6	50	040018	R409/32	114
0036839	A5106.4	57	0038376	R96012.2	25, 28	0039274	A5206.7	50	040019	R4019/64	114
0036846	A5106.5	57	0038413	R96012.6	25, 28	0039281	A5206.8	50	040020	R405/16	114
0036853	A5106.6	57	0038437	R96012.8	25, 28	0039298	A5206.9	50	040021	R4021/64	114
0036860	A5106.7	57	0038451	R96012.9	25, 28	0039304	A5207.0	50	040022	R4011/32	114
0036877	A5106.8	57	0038468	R96013.2	22	0039311	A5207.1	50	040023	R4023/64	115
0036884	A5106.9	57	0038499	R96013.6	22	0039328	A5207.2	50	040024	R403/8	115
0036891	A5107.0	57	0038529	R96013.7	25, 28, 31	0039335	A5207.3	50	040025	R4025/64	115
0036907	A5107.1	57	0038543	R96013.8	25, 28, 31	0039342	A5207.4	50	040026	R4013/32	115
0036914	A5107.2	57	0038567	R96014.1	25, 28, 31	0039359	A5207.5	50	040027	R4027/64	115
0036921	A5107.3	57	0038574	R96014.2	25, 28, 31	0039366	A5207.6	50	040028	R407/16	115
0036938	A5107.4	57	0038581	R96014.6	25, 28, 31	0039373	A5207.7	50	040029	R4029/64	115
0036945	A5107.5	57	0038598	A52010.0	50	0039380	A5207.8	50	040030	R4015/32	115
0036952	A5107.6	57	0038604	A52010.1	50	0039397	A5207.9	50	040031	R4031/64	115
0036969	A5107.7	57	0038611	A52010.2	50	0039403	A5208.0	50	040032	R401/2	115
0036976	A5107.8	57	0038628	A52010.3	50	0039410	A5208.1	50	040033	R4033/64	115
0036983	A5107.9	57	0038635	A52010.4	50	0039427	A5208.2	50	040034	R4017/32	115
0036990	A5108.0	57	0038642	A52010.5	50	0039434	A5208.3	50	040035	R4035/64	115
0037003	A5108.1	57	0038659	A52010.6	50	0039441	A5208.4	50	040036	R409/16	115
0037010	A5108.2	57	0038666	A52010.7	50	0039458	A5208.5	50	040037	R4037/64	115
0037027	A5108.3	57	0038673	A52010.8	50	0039465	A5208.6	50	040038	R4019/32	115
0037034	A5108.4	57	0038680	A52010.9	51	0039472	A5208.7	50	040039	R4039/64	115
0037041	A5108.5	57	0038697	A52011.0	51	0039489	A5208.8	50	040040	R405/8	115
0037058	A5108.6	57	0038703	A52011.1	51	0039496	A5208.9	50	040041	R4041/64	115
0037065	A5108.7	57	0038710	A52011.2	51	0039502	A5209.0	50	040042	R4021/32	115
0037072	A5108.8	57	0038727	A52011.3	51	0039519	A5209.1	50	040043	R4043/64	115
0037089	A5108.9	57	0038734	A52011.4	51	0039526	A5209.2	50	040044	R4011/16	115
0037096	A5109.0	57	0038741	A52011.5	51	0039533	A5209.3	50	040304	M40CO1/16	127
0037102	A5109.1	57	0038758	A52011.6	51	0039540	A5209.4	50	040305	M40CO5/64	127
0037119	A5109.2	57	0038765	A52011.7	51	0039557	A5209.5	50	040306	M40CO3/32	127
0037126	A5109.3	57	0038772	A52011.8	51	0039564	A5209.6	50	040307	M40CO7/64	127
0037133	A5109.4	57	0038789	A52011.9	51	0039571	A5209.7	50	040308	M40CO1/8	128
0037140	A5109.5	57	0038796	A52012.0	51	0039588	A5209.8	50	040309	M40CO9/64	128

EDP NUMBER INDEX - 040310 - 041856

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
040310	M40CO5/32	128	040816	R40C1/4	120	041048	R41N48	113	041342	M41CON42	127
040311	M40CO11/64	128	040817	R40C17/64	120	041049	R41N49	113	041343	M41CON43	127
040312	M40CO3/16	128	040818	R40C9/32	120	041050	R41N50	113	041344	M41CON44	127
040313	M40CO13/64	128	040819	R40C19/64	120	041051	R41N51	113	041345	M41CON45	127
040314	M40CO7/32	128	040820	R40C5/16	120	041052	R41N52	113	041346	M41CON46	127
040315	M40CO15/64	128	040821	R40C21/64	120	041053	R41N53	113	041347	M41CON47	127
040316	M40CO1/4	128	040822	R40C11/32	120	041054	R41N54	113	041348	M41CON48	127
040317	M40CO17/64	128	040823	R40C23/64	121	041055	A53020.5	164	041349	M41CON49	127
040318	M40CO9/32	128	040824	R40C3/8	121	041055	R41N55	113	041350	M41CON50	127
040319	M40CO19/64	128	040825	R40C25/64	121	041056	R41N56	113	041351	M41CON51	127
040320	M40CO5/16	128	040826	R40C13/32	121	041057	R41N57	113	041352	M41CON52	127
040321	M40CO21/64	128	040827	R40C27/64	121	041058	R41N58	113	041353	M41CON53	127
040322	M40CO11/32	128	040828	R40C7/16	121	041059	R41N59	113	041354	M41CON54	127
040323	M40CO23/64	129	040829	A53013.5	164	041060	R41N60	113	041355	M41CON55	127
040324	M40CO3/8	129	040829	R40C29/64	121	041062	A53021.0	164	041356	M41CON56	127
040325	M40CO25/64	129	040830	R40C15/32	121	041079	A53021.5	164	041357	M41CON57	127
040326	M40CO13/32	129	040831	R40C31/64	121	041086	A53022.0	164	041358	M41CON58	127
040327	M40CO27/64	129	040832	R40C1/2	121	041093	A53022.5	164	041359	M41CON59	127
040328	M40CO7/16	129	040836	A53014.0	164	041109	A53023.0	165	041360	M41CON60	127
040329	M40CO29/64	129	040850	A53014.5	164	041116	A53023.5	165	041701	ATR41N1	196
040330	M40CO15/32	129	040874	A53015.0	164	041123	A53024.0	165	041702	ATR41N2	196
040331	M40CO31/64	129	040881	A53015.25	164	041130	A53024.5	165	041703	ATR41N3	196
040332	M40CO1/2	129	040898	A53015.5	164	041147	A53025.0	165	041704	ATR41N4	196
040545	R4045/64	115	040911	A53016.0	164	041154	A53025.5	165	041801	R41CN1	120
040546	R4023/32	115	040935	A53016.5	164	041161	A53026.0	165	041802	R41CN2	120
040547	R4047/64	115	040942	A53017.0	164	041178	A53026.5	165	041803	R41CN3	120
040548	R403/4	115	040966	A53017.5	164	041185	A53027.0	165	041804	R41CN4	120
040549	R4049/64	115	040980	A53018.0	164	041192	A53027.5	165	041805	R41CN5	120
040550	R4025/32	115	040997	A53018.5	164	041208	A53028.0	165	041806	R41CN6	120
040551	R4051/64	115	041001	R41N1	114	041215	A53028.5	165	041807	R41CN7	120
040552	R4013/16	115	041002	R41N2	114	041222	A53029.0	165	041808	R41CN8	120
040553	R4053/64	115	041003	R41N3	114	041239	A53029.5	165	041809	R41CN9	120
040554	R4027/32	115	041004	R41N4	114	041246	A53030.0	165	041810	R41CN10	120
040555	R4055/64	115	041005	R41N5	114	041253	A53031.0	165	041811	R41CN11	120
040556	R407/8	115	041006	R41N6	114	041260	A53032.0	165	041812	R41CN12	120
040557	R4057/64	115	041007	R41N7	114	041277	A5308.5	163	041813	R41CN13	120
040558	R4029/32	115	041008	R41N8	114	041284	A5309.0	163	041814	R41CN14	120
040559	R4059/64	115	041009	R41N9	114	041301	M41CON1	128	041815	R41CN15	120
040560	R4015/16	115	041010	R41N10	114	041302	M41CON2	128	041816	R41CN16	120
040561	R4061/64	115	041011	R41N11	114	041303	M41CON3	128	041817	R41CN17	120
040562	R4031/32	115	041012	R41N12	114	041304	M41CON4	128	041818	R41CN18	120
040563	R4063/64	115	041013	R41N13	114	041305	M41CON5	128	041819	R41CN19	120
040600	R401	115	041014	R41N14	114	041306	M41CON6	128	041820	R41CN20	120
040604	R401.1/16	115	041015	R41N15	114	041307	M41CON7	128	041821	R41CN21	120
040608	R401.1/8	115	041016	R41N16	114	041308	M41CON8	128	041822	R41CN22	120
040612	R401.3/16	115	041017	A53019.0	164	041309	M41CON9	128	041823	R41CN23	120
040616	R401.1/4	115	041017	R41N17	114	041310	M41CON10	128	041824	R41CN24	120
040620	R401.5/16	115	041018	R41N18	114	041311	M41CON11	128	041825	R41CN25	120
040624	R401.3/8	115	041019	R41N19	114	041312	M41CON12	128	041826	R41CN26	120
040628	R401.7/16	115	041020	R41N20	114	041313	M41CON13	128	041827	R41CN27	120
040632	R401.1/2	115	041021	R41N21	114	041314	M41CON14	128	041828	R41CN28	120
040636	R401.9/16	115	041022	R41N22	114	041315	M41CON15	128	041829	R41CN29	120
040640	R401.5/8	115	041023	R41N23	114	041316	M41CON16	128	041830	R41CN30	120
040648	R401.3/4	115	041024	A53019.5	164	041317	M41CON17	128	041831	R41CN31	120
040652	R401.13/16	115	041024	R41N24	114	041318	M41CON18	128	041832	R41CN32	120
040656	R401.7/8	115	041025	R41N25	114	041318	M41CON18	128	041833	R41CN33	119
040660	R401.15/16	115	041026	R41N26	114	041319	M41CON19	128	041834	R41CN34	119
040700	R402	115	041027	R41N27	114	041320	M41CON20	128	041835	R41CN35	119
0040713	A53010.0	163	041028	R41N28	114	041321	M41CON21	128	041836	R41CN36	119
0040720	A53010.2	163	041029	R41N29	114	041322	M41CON22	128	041837	R41CN37	119
0040737	A53010.5	163	041030	R41N30	114	041323	M41CON23	128	041838	R41CN38	119
0040744	A53011.0	164	041031	R41N31	114	041324	M41CON24	128	041839	R41CN39	119
0040751	A53011.5	164	041032	R41N32	113	041325	M41CON25	128	041840	R41CN40	119
0040768	A53011.75	164	041033	R41N33	113	041326	M41CON26	128	041841	R41CN41	119
0040775	A53012.0	164	041034	R41N34	113	041327	M41CON27	128	041842	R41CN42	119
0040799	A53012.5	164	041035	R41N35	113	041328	M41CON28	128	041843	R41CN43	119
040804	R40C1/16	119	041036	R41N36	113	041329	M41CON29	128	041844	R41CN44	119
040805	R40C5/64	119	041037	R41N37	113	041330	M41CON30	128	041845	R41CN45	119
040806	R40C3/32	119	041038	R41N38	113	041331	M41CON31	128	041846	R41CN46	119
040807	R40C7/64	119	041039	R41N39	113	041332	M41CON32	128	041847	R41CN47	119
040808	R40C1/8	120	041040	R41N40	113	041333	M41CON33	127	041848	R41CN48	119
040809	R40C9/64	120	041041	R41N41	113	041334	M41CON34	127	041849	R41CN49	119
040810	R40C5/32	120	041042	R41N42	113	041335	M41CON35	127	041850	R41CN50	119
040811	R40C11/64	120	041043	R41N43	113	041336	M41CON36	127	041851	R41CN51	119
0040812	A53013.0	164	041044	R41N44	113	041337	M41CON37	127	041852	R41CN52	119
040812	R40C3/16	120	041045	R41N45	113	041338	M41CON38	127	041853	R41CN53	119
040813	R40C13/64	120	041046	R41N46	113	041339	M41CON39	127	041854	R41CN54	119
040814	R40C7/32	120	041047	R41N47	113	041340	M41CON40	127	041855	R41CN55	119
040815	R40C15/64	120	0041048	A53020.0	164	041341	M41CON41	127	041856	R41CN56	119

EDP NUMBER INDEX - 041857 - 0047361

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
041857	R41CN57	119	0042519	R458N5	38	046100	4ASM1.0	122	0046753	A9004.8	62
041858	R41CN58	119	0042526	R458N4	38	046125	4ASM1.25	122	0046760	A9004.9	62
041859	R41CN59	119	0042533	R458N3	38	046130	4ASM1.3	122	0046777	A9005.0	62
041860	R41CN60	119	0042540	R458N2	38	046165	4ASM1.65	122	0046784	A9005.1	62
042001	R42A	114	0042557	R458N1	38	046200	4ASM2.0	122	046800	4ASM8.0	123
042002	R42B	114	0042694	R45810.8	39	046230	4ASM2.3	122	0046807	A90013/64	62
042003	R42C	114	0042694	R45810.8	39	046240	4ASM2.4	122	046810	4ASM8.1	123
042004	R42D	114	042801	R42CA	120	046250	4ASM2.5	122	0046814	A9005.2	62
042005	R42E	114	042802	R42CB	120	0046289	A9001.0	61	0046821	A9005.3	62
042006	R42F	114	042803	R42CC	120	0046296	A9001.1	61	0046838	A9005.4	62
042007	R42G	114	042804	R42CD	120	046300	4ASM3.0	122	046840	4ASM8.4	123
042008	R42H	114	042805	R42CE	120	0046302	A9001.2	61	0046845	A9005.5	62
042009	R42I	114	042806	R42CF	120	046310	4ASM3.1	122	046850	4ASM8.5	123
042010	R42J	114	042807	R42CG	120	0046319	A9001.3	61	0046852	A9007/32	62
042011	R42K	114	042808	R42CH	120	046320	4ASM3.2	122	0046869	A9005.6	62
042012	R42L	114	042809	R42CI	120	0046326	A9001.4	61	046870	4ASM8.7	123
042013	R42M	114	042810	R42CJ	120	046330	4ASM3.3	122	0046876	A9005.7	62
042014	R42N	114	042811	R42CK	120	0046333	A9001.5	61	0046883	A9005.8	62
042015	R42O	114	042812	R42CL	120	046340	4ASM3.4	122	0046890	A9005.9	62
042016	R42P	114	042813	R42CM	120	0046340	A9001/16	61	046900	4ASM9.0	123
042017	R42Q	114	042814	R42CN	120	046350	4ASM3.5	122	0046906	A90015/64	62
042018	R42R	114	042815	R42CO	120	0046357	A9001.6	61	046910	4ASM9.1	123
042019	R42S	114	042816	R42CP	120	0046364	A9001.7	61	0046913	A9006.0	62
042020	R42T	115	042817	R42CQ	120	046370	4ASM3.7	122	046920	4ASM9.2	123
042021	R42U	115	042818	R42CR	120	0046371	A9001.8	61	0046920	A9006.1	62
042022	R42V	115	042819	R42CS	120	0046388	A9001.9	61	046930	4ASM9.3	123
042023	R42W	115	042820	R42CT	121	0046395	A9005/64	61	0046937	A9006.2	62
042024	R42X	115	042821	R42CU	121	046400	4ASM4.0	122	0046944	A9006.3	62
042025	R42Y	115	042822	R42CV	121	0046401	A9002.0	61	046950	4ASM9.5	123
042026	R42Z	115	042823	R42CW	121	0046418	A9002.1	61	0046951	A9001/4	62
0042267	R458N30	37	042824	R42CX	121	046420	4ASM4.2	122	0046968	A9006.4	62
0042274	R458N29	37	042825	R42CY	121	0046425	A9002.2	61	046970	4ASM9.7	123
0042281	R458N28	37	042826	R42CZ	121	0046432	A9002.3	61	0046975	A9006.5	62
0042298	R458N27	37	0044988	A720.15	126	0046449	A9003/32	61	0046999	A9006.6	62
042301	M42COA	128	0044995	A720.18	126	046450	4ASM4.5	122	047000	4ASM10.0	123
042302	M42COB	128	0045008	A720.2	126	0046456	A9002.4	61	047002	4ASM10.2	123
042303	M42COC	128	0045015	A720.22	126	0046463	A9002.5	61	0047002	A9006.7	62
042304	M42COD	128	0045022	A720.25	126	0046470	A9002.6	61	047005	4ASM10.5	123
0042304	R458N26	37	0045039	A720.28	126	0046487	A9002.7	61	047008	4ASM10.8	123
042305	M42COE	128	0045046	A720.3	126	0046494	A9007/64	61	0047019	A90017/64	62
042306	M42COF	128	0045053	A720.35	126	046500	4ASM5.0	122	0047026	A9006.8	62
042307	M42COG	128	0045060	A720.38	126	0046500	A9002.8	61	0047033	A9006.9	62
042308	M42COH	128	0045077	A720.39	126	0046517	A9002.9	61	0047057	A9007.0	62
042309	M42COI	128	0045084	A720.4	126	0046524	A9003.0	61	0047064	A9007.1	62
042310	M42COJ	128	0045107	A720.45	126	0046531	A9003.1	61	0047071	A9009/32	62
042311	M42COK	128	0045114	A720.5	126	0046548	A9001/8	61	0047088	A9007.2	62
042312	M42COL	128	0045121	A720.6	126	046550	4ASM5.5	122	0047095	A9007.3	62
042313	M42COM	128	045610	TS18N10	195	0046555	A9003.2	61	0047101	A9007.4	62
042314	M42CON	128	045611	TS18N11	195	0046562	A9003.3	61	047110	4ASM11.0	123
042315	M42COO	128	045620	TS18N20	195	046570	4ASM5.7	122	047112	4ASM11.2	123
042316	M42COP	128	045621	TS18N21	195	0046579	A9003.4	62	047115	4ASM11.5	123
042317	M42COQ	128	045630	TS18N30	195	046580	4ASM5.8	122	047118	4ASM11.8	123
042318	M42COR	128	045640	TS18N40	195	0046586	A9003.5	62	0047118	A9007.5	62
042319	M42COS	128	045708	TS101/8	195	0046593	A9009/64	62	0047125	A90019/64	62
042320	M42COT	129	045710	TS105/32	195	046600	4ASM6.0	122	0047132	A9007.6	62
042321	M42COU	129	045712	TS103/16	195	0046609	A9003.6	62	0047149	A9007.7	62
042322	M42COV	129	045714	TS107/32	195	0046616	A9003.7	62	0047156	A9007.8	62
042323	M42COW	129	045716	TS101/4	195	046620	4ASM6.2	122	0047163	A9007.9	62
042324	M42COX	129	045810	TS41N10	195	0046623	A9003.8	62	0047170	A9005/16	62
042325	M42COY	129	045811	TS41N11	195	0046630	A9003.9	62	0047187	A9008.0	62
042326	M42COZ	129	045820	TS41N20	195	046640	4ASM6.4	122	0047194	A9008.1	62
0042328	R458N24	37	045830	TS41N30	195	0046647	A9005/32	62	047200	4ASM12.0	123
0042335	R458N23	37	045840	TS41N40	195	046650	4ASM6.5	122	0047200	A9008.2	62
0042342	R458N22	37	046033	M40CO33/64	129	0046654	A9004.0	62	0047217	A9008.3	62
0042359	R458N21	37	046034	M40CO17/32	129	046660	4ASM6.6	122	047220	4ASM12.2	123
0042366	R458N20	37	046035	M40CO35/64	129	0046661	A9004.1	62	0047224	A90021/64	62
0042373	R458N19	37	046036	M40CO9/16	129	0046678	A9004.2	62	0047231	A9008.4	62
0042380	R458N18	37	046037	M40CO37/64	129	046680	4ASM6.8	122	047250	4ASM12.5	123
0042397	R458N17	37	046038	M40CO19/32	129	0046685	A9004.3	62	0047255	A9008.5	62
0042403	R458N16	38	046039	M40CO39/64	129	046690	4ASM6.9	122	0047262	A9008.6	62
0042410	R458N15	38	046040	M40CO5/8	129	0046692	A90011/64	62	0047286	A9008.7	62
0042427	R458N14	38	046041	M40CO41/64	129	046700	4ASM7.0	122	0047293	A90011/32	63
0042441	R458N12	38	046042	M40CO21/32	129	0046708	A9004.4	62	0047309	A9008.8	63
0042458	R458N11	38	046043	M40CO43/64	129	0046715	A9004.5	62	0047316	A9008.9	63
0042465	R458N10	38	046044	M40CO11/16	129	046720	4ASM7.2	122	0047323	A9009.0	63
0042472	R458N9	38	046045	M40CO45/64	129	0046722	A9004.6	62	0047330	A9009.1	63
0042489	R458N8	38	046046	M40CO23/32	129	0046739	A9004.7	62	0047347	A90023/64	63
0042496	R458N7	38	046047	M40CO47/64	129	0046746	A9003/16	62	0047354	A9009.2	63
0042502	R458N6	38	046048	M40CO3/4	129	046750	4ASM7.5	122	0047361	A9009.3	63

EDP NUMBER INDEX - 0047378 - 050935

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0047378	A9009.4	63	0048191	A9016.7	62	0049051	B12113.0	437	050252	QC91GM5.2	140
0047385	A9009.5	63	0048207	A9016.8	62	0049068	B12114.0	437	050255	QC91GM5.5	140
0047392	A9003/8	63	0048214	A9016.9	62	0049075	B12115.0	437	050260	QC91GM6.0	140
0047408	A9009.6	63	0048221	A9017.0	62	0049082	B12116.0	437	050262	A9201.1	52
0047415	A9009.7	63	0048238	A9017.1	62	0049099	B12117.0	437	050265	QC91GM6.5	140
0047422	A9009.8	63	0048245	A9017.2	62	0049105	B12118.0	437	050270	QC91GM7.0	140
0047439	A9009.9	63	0048252	A9017.3	62	0049112	B12119.0	437	050280	QC91GM8.0	140
0047446	A90025/64	63	0048269	A9017.4	62	0049129	B12120.0	437	050285	QC91GM8.5	140
0047453	A90010.0	63	0048276	A9017.5	62	0049136	B12121.0	437	050286	QC91GM8.6	140
0047460	A90010.2	63	0048283	A9017.6	62	0049143	B12122.0	437	050290	QC91GM9.0	140
0047477	A90010.3	63	0048290	A9017.7	62	0049150	B12123.0	437	050300	QC91GM10.0	140
0047484	A90013/32	63	0048306	A9017.8	62	0049167	B12124.0	437	050305	QC91GM10.5	140
0047491	A90010.4	63	0048313	A9017.9	62	0049174	B12125.0	437	050309	A9201.2	52
0047507	A90010.5	63	0048320	A9018.0	62	0049181	B12126.0	437	050316	A9201.3	52
0047514	A90027/64	63	0048337	A9018.1	62	0049198	A90110.8	63	050320	QC91GM12.0	140
0047521	A90010.8	63	0048344	A9018.2	62	0049211	B12130.0	437	050323	A9201.4	52
0047538	A90011.0	63	0048351	A9018.3	62	0049235	A90111.0	63	050325	QC91GM12.5	140
0047545	A9007/16	63	0048368	A9018.4	62	0049280	A90111.5	63	050347	A9201.5	52
0047569	A90011.5	63	0048375	A9018.5	62	0049297	A90111.8	63	050392	B1701.51	420
0047576	A90029/64	63	0048382	A9018.6	62	0049303	A90112.0	63	050491	B1703.01	420
0047583	A90011.8	63	0048399	A9018.7	63	0049594	A90112.5	63	050590	B1708.51	421
0047590	A90015/32	63	0048405	A9018.8	63	0049617	B15710.0	430	050644	A9201/16	52
0047606	A90012.0	63	0048412	A9018.9	63	0049624	B15711.0	430	050668	A9201.6	52
0047620	A90031/64	63	0048429	A9019.0	63	0049631	B15712.0	430	050675	A9201.7	52
0047637	A90012.5	63	0048436	A9019.1	63	0049648	B1572.0	430	050682	A9201.8	52
0047644	A9001/2	63	0048443	A9019.2	63	0049655	A90113.0	63	050699	A9201.9	52
0047668	A90013.0	63	0048450	A9019.3	63	0049662	A90113.5	63	050705	A9205/64	52
0047675	A90013.5	63	0048467	A9019.4	63	0049679	B1574.0	430	050712	A9202.0	52
0047682	A90014.0	63	0048474	A9019.5	63	0049686	A90114.0	63	050729	A9202.1	52
0047699	A90014.5	63	0048481	A9019.6	63	0049693	B1575.0	430	050743	A9202.2	52
0047705	A90015.0	63	0048498	A9019.7	63	0049709	A90114.5	63	050750	A9202.3	52
0047712	A90015.5	63	0048504	A9019.8	63	0049716	B1576.0	430	050767	A9203/32	52
0047729	A90016.0	63	0048511	B10010.0	447	0049723	A90115.0	63	050781	A9202.4	52
0047736	A90017.0	63	0048528	B10011.0	447	0049730	B1577.0	430	050804	A9202.5	52
0047743	A90017.5	63	0048535	B10012.0	447	0049747	B1578.0	430	050811	A9202.6	52
0047750	A90018.0	63	0048542	B10013.0	447	0049754	B1579.0	430	050828	A9202.7	52
0047767	A90019.0	63	0048559	B10014.0	447	050015	QC91PM1.5	140	050835	A9207/64	52
0047774	A90020.0	63	0048566	B10015.0	447	050020	QC91PM2.0	140	050842	A9202.8	52
0047781	A9011.5	63	0048573	B10016.0	447	050025	QC91PM2.5	140	050859	A9202.9	52
0047798	A9012.0	61	0048580	B10017.0	447	050030	QC91PM3.0	140	050866	A9203.0	52
0047804	A9012.5	61	0048597	B10018.0	447	050035	QC91PM3.5	140	050873	A9203.1	52
0047811	A9012.6	61	0048603	B10019.0	447	050040	QC91PM4.0	140	050880	A9201/8	53
0047828	A9013.0	61	0048610	B1002.0	446	050045	QC91PM4.5	140	050897	A9203.2	53
0047835	A9013.1	61	0048627	A9019.9	63	050050	QC91PM5.0	140	050902	QC91GN2	139
0047842	A9013.2	61	0048634	B1002.5	446	050052	QC91PM5.2	140	050903	A9203.3	53
0047859	A9013.3	61	0048641	A90110.0	463	050055	QC91PM5.5	140	050903	QC91GN3	139
0047866	A9013.4	62	0048658	B10020.0	447	050060	QC91PM6.0	140	050904	QC91GN4	139
0047873	A9013.5	62	0048665	B10022.0	447	050065	QC91PM6.5	140	050904	QC91GN4	139
0047880	A9013.6	62	0048672	B10024.0	447	050068	QC91PM6.8	140	050904	QC91GN4	139
0047897	A9013.7	62	0048689	B10025.0	447	050070	QC91PM7.0	140	050905	QC91GN5	139
0047903	A9013.8	62	0048696	B10026.0	447	050080	QC91PM8.0	140	050906	QC91GN6	139
0047910	A9013.9	62	0048702	B10028.0	447	050082	QC91PM8.2	140	050907	QC91GN7	139
0047927	A9014.0	62	0048719	B1003.0	446	050085	QC91PM8.5	140	050908	QC91GN8	139
0047934	A9014.1	62	0048726	B1003.2	446	050086	QC91PM8.6	140	050909	QC91GN9	139
0047941	A9014.2	62	0048733	B1003.5	446	050090	QC91PM9.0	140	050910	A9203.4	53
0047958	A9014.3	62	0048740	B10030.0	447	050095	QC91PM9.5	140	050911	QC91GN11	139
0047965	A9014.4	62	0048757	B10032.0	447	050100	QC91PM10.0	140	050911	QC91GN11	139
0047972	A9014.5	62	0048764	B10034.0	447	050105	QC91PM10.5	140	050913	QC91GN13	139
0047989	A9014.6	62	0048771	B10035.0	447	050110	QC91PM11.0	140	050914	QC91GN14	139
0047996	A9014.7	62	0048788	B10036.0	447	050120	QC91PM12.0	140	050915	QC91GN15	139
0048009	A9014.8	62	0048795	B10038.0	447	050125	QC91PM12.5	140	050916	QC91GN16	139
0048016	A9014.9	62	0048801	B1004.0	446	050130	QC91PM13.0	140	050917	QC91GN17	139
0048023	A9015.0	62	0048818	B1004.5	446	050132	A90115.5	63	050918	QC91GN18	139
0048030	A9015.1	62	0048825	B10040.0	447	050135	QC91PM13.5	140	050919	QC91GN19	139
0048047	A9015.2	62	0048856	B10045.0	447	050140	QC91PM14.0	140	050920	QC91GN20	139
0048054	A9015.3	62	0048863	A90110.2	63	050150	QC91PM15.0	140	050921	QC91GN21	139
0048061	A9015.4	62	0048870	A90110.3	63	050155	QC91PM15.5	140	050924	QC91GN24	139
0048078	A9015.5	62	0048887	B1005.0	446	050160	QC91PM16.0	140	050925	QC91GN25	139
0048085	A9015.6	62	0048894	B1005.5	446	050170	A90116.0	63	050926	QC91GN26	138
0048092	A9015.7	62	0048900	B10050.0	447	050170	QC91PM17.0	140	050927	A9203.5	53
0048108	A9015.8	62	0048917	B1006.0	446	050215	QC91GM1.5	140	050928	QC91GN28	138
0048115	A9015.9	62	0048924	B1007.0	446	050217	A9201.0	52	050928	QC91GN28	138
0048122	A9016.0	62	0048931	B1008.0	446	050220	QC91GM2.0	140	050929	QC91GN29	138
0048139	A9016.1	62	0048948	B1009.0	447	050225	QC91GM2.5	140	050930	QC91GN30	138
0048146	A9016.2	62	0048955	A90110.4	63	050230	QC91GM3.0	140	050931	QC91GN31	138
0048153	A9016.3	62	0049013	A90110.5	63	050235	QC91GM3.5	140	050932	QC91GN32	138
0048160	A9016.4	62	0049020	B12110.0	437	050240	QC91GM4.0	140	050934	A9209/64	53
0048177	A9016.5	62	0049037	B12111.0	437	050245	QC91GM4.5	140	050934	QC91GN34	138
0048184	A9016.6	62	0049044	B12112.0	437	050250	QC91GM5.0	140	050935	QC91GN35	138

EDP NUMBER INDEX - 050936 - 052011

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
050936	QC91GN36	138	051049	R5149/64	133	051314	M51CO7/32	142	051510	R51FS5/32	137
050937	QC91GN37	138	051050	R5125/32	133	051314	M51CO7/32	142	0051511	A9207.7	53
050938	QC91GN38	138	051051	R5151/64	133	051315	M51CO15/64	142	051511	R51FS11/64	137
050939	QC91GN39	138	051052	R5113/16	133	051316	M51CO1/4	142	051512	R51FS3/16	137
050940	QC91GN40	138	051053	R5153/64	133	051317	M51CO17/64	142	051512	R51FS3/16	137
0050941	A9203.6	53	0051054	A9204.4	53	051318	M51CO9/32	142	051513	R51FS13/64	137
050941	QC91GN41	138	051054	R5127/32	133	051319	M51CO19/64	142	051514	R51FS7/32	137
050942	QC91GN42	138	051055	R5155/64	133	0051320	A9206.4	53	051515	R51FS15/64	137
050942	QC91GN42	138	051055	R5155/64	133	051320	M51CO5/16	142	051516	R51FS1/4	137
050943	QC91GN43	138	051056	R517/8	133	051321	M51CO21/64	142	051517	R51FS17/64	137
050944	QC91GN44	138	051057	R5157/64	133	051321	M51CO21/64	142	051518	R51FS9/32	137
050945	QC91GN45	138	051058	R5129/32	134	051322	M51CO11/32	142	051519	R51FS19/64	137
050946	QC91GN46	138	051059	R5159/64	134	051323	M51CO23/64	142	051520	R51FS5/16	137
050947	QC91GN47	138	051060	R5115/16	134	051324	M51CO3/8	142	051521	R51FS21/64	137
050949	QC91GN49	138	0051061	A9204.5	53	051325	M51CO25/64	142	051522	R51FS11/32	137
050950	QC91GN50	138	051061	R5161/64	134	051326	M51CO13/32	142	051523	R51FS23/64	137
050951	QC91GN51	138	051062	R5131/32	134	051327	M51CO27/64	142	051524	R51FS3/8	137
050952	QC91GN52	138	051062	R5131/32	134	051328	M51CO7/16	142	051525	R51FS25/64	137
0050958	A9203.7	53	051063	R5163/64	134	051329	M51CO29/64	142	051526	R51FS13/32	137
0050965	A9203.8	53	0051078	A9204.6	53	051330	M51CO15/32	142	051527	R51FS27/64	137
0050972	A9203.9	53	0051085	A9204.7	53	051331	M51CO31/64	142	0051528	A9207.8	53
0050989	A9205/32	53	0051092	A9203/16	53	051332	M51CO1/2	142	051528	R51FS7/16	137
051001	R511/64	131	051100	R511	134	051333	M51CO33/64	142	051529	R51FS29/64	137
051002	R511/32	131	051101	R511.7/64	134	051334	M51CO17/32	142	051529	R51FS29/64	137
051003	R513/64	131	051102	R511.1/32	134	051335	M51CO35/64	142	051530	R51FS15/32	137
051004	R511/16	131	051103	R511.3/64	134	051336	M51CO9/16	142	051531	R51FS31/64	137
051005	R515/64	132	051104	R511.1/16	134	0051337	A9206.5	53	051532	R51FS1/2	137
051006	R513/32	132	051105	R511.5/64	134	051337	M51CO37/64	142	0051535	A9207.9	53
051007	R517/64	132	051106	R511.3/32	134	051338	M51CO19/32	142	0051542	A9205/16	53
051008	R511/8	132	051107	R511.7/64	134	051338	M51CO19/32	142	0051566	A9208.0	53
0051009	A9204.0	53	0051108	A9204.8	53	051339	M51CO39/64	142	0051580	A9208.1	53
051009	R519/64	132	051108	R511.1/8	134	051340	M51CO5/8	142	0051603	A9208.2	53
051010	R515/32	132	051109	R511.9/64	134	051341	M51CO4/16	142	0051610	A9208.3	53
051011	R5111/64	132	051109	R511.9/64	134	051342	M51CO21/32	142	0051627	A92021/64	53
051012	R513/16	132	051110	R511.5/32	134	051343	M51CO43/64	142	0051634	A9208.4	54
051013	R5113/64	132	051111	R511.11/64	134	0051344	A9206.6	53	0051658	A9208.5	54
051014	R517/32	132	051112	R511.3/16	134	051344	M51CO11/16	142	0051665	A9208.6	54
051015	R5115/64	132	051113	R511.13/64	134	051345	M51CO45/64	142	0051672	A9208.7	54
0051016	A9204.1	53	051114	R511.7/32	134	051345	M51CO45/64	142	0051689	A92011/32	54
051016	R511/4	133	0051115	A9204.9	53	051346	M51CO23/32	142	0051702	A9208.8	54
051017	R5117/64	133	051115	R511.15/64	134	051347	M51CO47/64	142	0051719	A9208.9	54
051017	R5117/64	133	051116	R511.1/4	134	051348	M51CO3/4	142	0051726	A9209.0	54
051018	R519/32	133	051116	R511.1/4	134	051349	M51CO49/64	142	0051733	A9209.1	54
051019	R5119/64	133	051120	R511.5/16	134	051350	M51CO25/32	142	0051740	A92023/64	54
051020	R515/16	133	0051122	A9205.0	53	0051351	A9206.7	53	0051757	A9209.2	54
051021	R5121/64	133	051124	R511.3/8	134	051351	M51CO51/64	142	0051764	A9209.3	54
051022	R5111/32	133	051128	R511.7/16	134	051352	M51CO13/16	142	0051771	A9209.4	54
0051023	A9204.2	53	051132	R511.7/2	134	051352	M51CO13/16	142	0051788	A9209.5	54
051023	R5123/64	133	051136	R511.9/16	134	051353	M51CO53/64	142	0051795	A9203/8	54
051024	R513/8	133	0051139	A9205.1	53	051354	M51CO27/32	142	0051801	A9209.6	54
051024	R513/8	133	051140	R511.5/8	134	051355	M51CO55/64	142	0051818	A9209.7	54
051025	R5125/64	133	0051146	A92013/64	53	051356	M51CO7/8	142	0051825	A9209.8	54
051026	R5113/32	133	051148	R511.3/4	134	051357	M51CO57/64	142	0051832	A9209.9	54
051027	R5127/64	133	0051153	A9205.2	53	051358	M51CO29/32	142	0051849	A92025/64	54
051028	R517/16	133	0051160	A9205.3	53	051359	M51CO59/64	142	0051856	A92010.0	54
051029	R5129/64	133	0051177	A9205.4	53	051360	M51CO15/16	142	0051863	A92010.2	54
0051030	A9204.3	53	0051191	A9205.5	53	051361	M51CO61/64	142	0051870	A92010.3	54
051030	R5115/32	133	0051207	A9207/32	53	051362	M51CO31/32	142	0051887	A92013/32	54
051031	R5131/64	133	0051214	A9205.6	53	051363	M51CO63/64	142	0051900	A92010.5	54
051031	R5131/64	133	0051221	A9205.7	53	051364	M51CO1	142	0051917	A92027/64	54
051032	R511/2	133	0051238	A9205.8	53	0051368	A92017/64	53	0051924	A92010.8	54
051033	R5133/64	133	0051245	A9205.9	53	0051375	A9206.8	53	0051931	A92011.0	54
051034	R5117/32	133	0051269	A92015/64	53	0051382	A9206.9	53	0051948	A9207/16	54
051035	R5135/64	133	0051276	A9206.0	53	0051429	A9207.0	53	0051962	A92011.5	54
051036	R519/16	133	0051283	A9206.1	53	0051436	A9207.1	53	0051979	A92029/64	54
051037	R5137/64	133	0051290	A9206.2	53	0051443	A9209/32	53	0051986	A92011.8	54
051038	R5119/32	133	051304	M51CO1/16	141	0051450	A9207.2	53	0051993	A92015/32	54
051039	R5139/64	133	051305	M51CO5/64	141	0051467	A9207.3	53	052001	R52N1	132
051040	R515/8	133	0051306	A9206.3	53	0051474	A9207.4	53	052002	R52N2	132
051041	R5141/64	133	051306	M51CO3/32	141	0051481	A9207.5	53	052003	R52N3	132
051042	R5121/32	133	051307	M51CO7/64	141	0051498	A92019/64	53	052004	R52N4	132
051043	R5143/64	133	051307	M51CO7/64	141	0051504	A9207.6	53	052005	R52N5	132
051044	R5111/16	133	051308	M51CO1/8	141	051504	R51FS1/16	137	0052006	A92012.0	54
051045	R5145/64	133	051309	M51CO9/64	141	051505	R51FS5/64	137	052006	R52N6	132
051046	R5123/32	133	051310	M51CO5/32	141	051505	R51FS5/64	137	052007	R52N7	132
0051047	A92011/64	53	051311	M51CO11/64	141	051506	R51FS3/32	137	052008	R52N8	132
051047	R5147/64	133	051312	M51CO3/16	142	051507	R51FS7/64	137	052009	R52N9	132
051048	R513/4	133	0051313	A9201/4	53	051508	R51FS1/8	137	052010	R52N10	132
051048	R513/4	133	051313	M51CO13/64	142	051509	R51FS9/64	137	052011	R52N11	132

EDP NUMBER INDEX - 052012 - 053715

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
052012	R52N12	132	0052129	A92016.0	54	0052556	A9213.5	53	0053102	A9218.0	53
0052013	A92012.2	54	0052136	A92017.0	54	0052563	A9213.6	53	0053119	A9218.1	53
052013	R52N13	132	0052143	A92017.5	54	0052570	A9213.7	53	0053126	B41110.0	417
052014	R52N14	132	0052150	B3340	441	0052587	A9213.8	53	0053133	A9218.2	53
052015	R52N15	132	0052167	B33400	441	0052594	A9213.9	53	0053140	B41112.0	417
052016	R52N16	132	0052174	B334000	441	0052600	A9214.0	53	0053157	A9218.3	53
052017	R52N17	132	0052181	B3341	441	052604	CO500-121/16	158	0053164	B41114.0	417
052018	R52N18	132	0052198	B33410	441	052605	CO500-125/64	158	0053171	B41115.0	417
052019	R52N19	132	0052204	B33411	441	052606	CO500-123/32	158	0053188	B41116.0	417
0052020	A92031/64	54	0052211	B33412	441	052607	CO500-127/64	158	0053195	B4115.0	417
052020	R52N20	132	0052228	B3342	441	052608	CO500-121/8	158	0053201	B4116.0	417
052021	R52N21	132	0052235	B3343	441	052609	CO500-129/64	159	0053218	B4117.0	417
052022	R52N22	132	0052242	B3344	441	052610	CO500-125/32	159	0053225	B4118.0	417
052023	R52N23	132	0052259	B3345	441	052611	CO500-1211/64	159	0053232	B4119.0	417
052024	R52N24	132	0052266	B3346	441	052612	CO500-123/16	159	0053249	A9218.4	54
052025	R52N25	132	0052273	B3347	441	052613	CO500-1213/64	159	0053256	A9218.5	54
052026	R52N26	132	0052280	B3348	441	052614	CO500-127/32	159	0053263	A9218.6	54
052027	R52N27	132	0052297	B3349	441	052615	CO500-1215/64	159	0053270	A9218.7	54
052028	R52N28	132	052301	M52CON1	142	052616	CO500-121/4	159	0053287	A9218.8	54
052029	R52N29	132	052302	M52CON2	142	0052617	A9214.1	53	0053294	A9218.9	54
052030	R52N30	132	0052303	B3350BLADES	442	0052624	A9214.2	53	0053300	A9219.0	54
052031	R52N31	132	052303	M52CON3	142	0052631	A9214.3	53	0053317	A9219.1	54
052032	R52N32	132	052304	M52CON4	142	0052648	A9214.4	53	0053324	A9219.2	54
052033	R52N33	132	052305	M52CON5	142	0052655	A9214.5	53	0053331	A9219.3	54
052034	R52N34	132	052307	M52CON7	142	0052662	A9214.6	53	0053348	A9219.4	54
052035	R52N35	132	052308	M52CON8	142	0052679	A9214.7	53	0053355	A9219.5	54
052036	R52N36	132	052309	M52CON9	142	0052686	A9214.8	53	0053362	A9219.6	54
0052037	A92012.5	54	0052310	B33500BLADES	442	0052693	A9214.9	53	0053379	A9219.7	54
052037	R52N37	132	052310	M52CON10	142	0052709	A9215.0	53	0053386	A9219.8	54
052038	R52N38	132	052311	M52CON11	142	0052716	A9215.1	53	0053393	A9219.9	54
052039	R52N39	132	052312	M52CON12	142	0052723	A9215.2	53	0053409	A92110.0	54
052040	R52N40	132	052313	M52CON13	142	0052730	A9215.3	53	0053416	A92110.2	54
052041	R52N41	132	052314	M52CON14	141	0052747	A9215.4	53	0053423	A92110.3	54
052042	R52N42	132	052315	M52CON15	141	0052754	A9215.5	53	0053447	A92110.5	54
052043	R52N43	132	052316	M52CON16	141	0052761	A9215.6	53	0053454	A92110.8	54
0052044	A9201/2	54	052317	M52CON17	141	0052778	A9215.7	53	0053461	A92111.0	54
052044	R52N44	132	052318	M52CON18	141	0052785	A9215.8	53	0053485	A92111.5	54
052045	R52N45	132	052319	M52CON19	141	0052792	A9215.9	53	0053492	A92111.8	54
052046	R52N46	132	052320	M52CON20	141	052802	CO501-12N2	159	0053508	A92112.0	54
052047	R52N47	132	052321	M52CON21	141	0052808	A9216.0	53	0053522	A92112.5	54
052048	R52N48	132	052322	M52CON22	141	052810	CO501-12N10	159	0053546	A92113.0	54
052049	R52N49	132	052324	M52CON24	141	052811	CO501-12N11	159	0053553	A92113.5	54
052050	R52N50	132	052325	M52CON25	141	0052815	A9216.1	53	0053560	A92114.0	54
052051	R52N51	132	052326	M52CON26	141	052816	CO501-12N16	159	0053577	A92114.5	54
052052	R52N52	132	0052327	B335000BLADES	442	052819	CO501-12N19	159	0053584	A92115.0	54
052053	R52N53	131	052327	M52CON27	141	052820	CO501-12N20	159	0053591	A92115.5	54
052054	R52N54	131	052328	M52CON28	141	052821	CO501-12N21	159	053604	CO500-61/16	158
052055	R52N55	131	052329	M52CON29	141	0052822	A9216.2	53	053605	CO500-65/64	158
052056	R52N56	131	052330	M52CON30	141	052827	CO501-12N27	159	053606	CO500-63/32	158
052057	R52N57	131	052331	M52CON31	141	052829	CO501-12N29	159	0053607	A92116.0	54
052058	R52N58	131	052332	M52CON32	141	052830	CO501-12N30	158	053607	CO500-67/64	158
052059	R52N59	131	052333	M52CON33	141	0052839	A9216.3	53	053608	CO500-61/8	158
052060	R52N60	131	0052334	B3351BLADES	442	052840	CO501-12N40	158	053609	CO500-69/64	159
052061	R52N61	131	052334	M52CON34	141	0052846	A9216.4	53	053610	CO500-65/32	159
052062	R52N62	131	052335	M52CON35	141	0052853	A9216.5	53	053611	CO500-611/64	159
052063	R52N63	131	052336	M52CON36	141	0052860	A9216.6	53	053612	CO500-63/16	159
052064	R52N64	131	052339	M52CON39	141	0052877	A9216.7	53	053613	CO500-613/64	159
052065	R52N65	131	052340	M52CON40	141	0052884	A9216.8	53	0053614	A9401.0	64
052066	R52N66	131	0052341	B33510BLADES	442	0052891	A9216.9	53	053614	CO500-67/32	159
052067	R52N67	131	0052358	B33511BLADES	442	0052907	A9217.0	53	053615	CO500-615/64	159
0052068	A92013.0	54	0052365	B33512BLADES	442	0052914	A9217.1	53	053616	CO500-61/4	159
052068	R52N68	131	0052372	B3352BLADES	442	0052921	A9217.2	53	0053621	A9401.1	64
052069	R52N69	131	0052389	B3353BLADES	442	0052938	A9217.3	53	0053638	A9401.2	64
052070	R52N70	131	0052396	B3354BLADES	442	0052945	A9217.4	53	0053645	A9401.3	64
052071	R52N71	131	0052402	B3355BLADES	442	0052952	A9217.5	53	053701	CO501-6N1	159
052072	R52N72	131	0052419	B3356BLADES	442	0052969	A9217.6	53	053702	CO501-6N2	159
052073	R52N73	131	0052426	B3357BLADES	442	0052976	A9217.7	53	053703	CO501-6N3	159
052074	R52N74	131	0052433	B3358BLADES	442	0052983	B4001.0	415	053704	CO501-6N4	159
0052075	A92013.5	54	0052440	B3359BLADES	442	0052990	B4001.2	415	053705	CO501-6N5	159
052075	R52N75	131	0052457	A92018.0	54	0053003	B4001.4	415	053706	CO501-6N6	159
052076	R52N76	131	0052464	A92019.0	55	0053010	B4001.5	415	053707	CO501-6N7	159
052077	R52N77	131	0052471	A92020.0	55	0053027	B4001.6	415	053708	CO501-6N8	159
052078	R52N78	131	0052488	A9212.5	52	0053034	B4001.8	415	053709	CO501-6N9	159
052079	R52N79	131	0052495	A9212.6	52	0053041	B4002.0	415	053710	CO501-6N10	159
052080	R52N80	131	0052501	A9213.0	52	0053058	B4002.2	415	053711	CO501-6N11	159
0052082	A92014.0	54	0052518	A9213.1	52	0053065	B4002.5	415	053712	CO501-6N12	159
0052099	A92014.5	54	0052525	A9213.2	53	0053072	B4002.8	415	053713	CO501-6N13	159
0052105	A92015.0	54	0052532	A9213.3	53	0053089	A9217.8	53	053714	CO501-6N14	159
0052112	A92015.5	54	0052549	A9213.4	53	0053096	A9217.9	53	053715	CO501-6N15	159

EDP NUMBER INDEX - 053716 - 057938

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
053716	CO501-6N16	159	055024	R55X	133	056215	5ATL2.15	135	057200	5ATL20.0	136
053717	CO501-6N17	159	055025	R55Y	133	056220	5ATL2.2	135	057205	5ATL20.5	136
053718	CO501-6N18	159	055026	R55Z	133	0056226	A9404.1	65	057210	5ATL21.0	136
053719	CO501-6N19	159	0055465	A9403.1	64	056230	5ATL2.3	135	057215	5ATL21.5	136
053720	CO501-6N20	159	0055472	A9401/8	64	0056233	A9404.2	65	057220	5ATL22.0	136
053721	CO501-6N21	159	0055533	A9403.2	64	056240	5ATL2.4	135	057225	5ATL22.5	136
053722	CO501-6N22	159	0055540	A9403.3	64	056250	5ATL2.5	135	057230	5ATL23.0	136
053723	CO501-6N23	159	0055588	A9403.4	64	0056257	A9404.3	65	057235	5ATL23.5	136
053724	CO501-6N24	159	0055595	A9403.5	64	0056264	A94011/64	65	057240	5ATL24.0	136
053725	CO501-6N25	159	055608	QC0860P1/8	150	0056271	A9404.4	65	057245	5ATL24.5	136
053726	CO501-6N26	159	055609	QC0860P9/64	150	0056288	A9404.5	65	057250	5ATL25.0	136
053727	CO501-6N27	159	055610	QC0860P5/32	150	0056295	A9404.6	65	057255	5ATL25.5	136
053728	CO501-6N28	159	055611	QC0860P11/64	150	056300	5ATL3.0	135	057260	5ATL26.0	136
053729	CO501-6N29	159	055612	QC0860P3/16	150	0056301	A9404.7	65	057265	5ATL26.5	136
053730	CO501-6N30	159	055613	QC0860P13/64	150	056310	5ATL3.1	135	057270	5ATL27.0	136
053731	CO501-6N31	158	055614	QC0860P7/32	150	0056318	A9403/16	65	057280	5ATL28.0	136
053732	CO501-6N32	158	055615	QC0860P15/64	150	056320	5ATL3.2	135	057285	5ATL28.5	136
053734	CO501-6N34	158	055616	QC0860P1/4	150	056330	5ATL3.3	135	057290	5ATL29.0	136
053735	CO501-6N35	158	055617	QC0860P17/64	150	056340	5ATL3.4	135	057295	5ATL29.5	136
053736	CO501-6N36	158	0055618	A9409/64	64	056350	5ATL3.5	135	057300	5ATL30.0	136
053737	CO501-6N37	158	055618	QC0860P9/32	150	056360	5ATL3.6	135	057305	5ATL30.5	136
053738	CO501-6N38	158	055619	QC0860P19/64	150	056370	5ATL3.7	135	057310	5ATL31.0	136
053739	CO501-6N39	158	055620	QC0860P5/16	150	056380	5ATL3.8	135	057408	08601/8	143
053740	CO501-6N40	158	055621	QC0860P21/64	150	056400	5ATL4.0	135	057410	08605/32	143
053741	CO501-6N41	158	055622	QC0860P11/32	150	056420	5ATL4.2	135	057412	08603/16	143
053742	CO501-6N42	158	055623	QC0860P23/64	150	056430	5ATL4.3	135	057414	08607/32	143
053743	CO501-6N43	158	055624	QC0860P3/8	150	056450	5ATL4.5	135	057416	08601/4	143
053744	CO501-6N44	158	0055625	A9403.6	65	056460	5ATL4.6	135	057418	08609/32	143
053745	CO501-6N45	158	055625	QC0860P25/64	151	056480	5ATL4.8	135	057420	08605/16	143
053746	CO501-6N46	158	055626	QC0860P13/32	151	056500	5ATL5.0	136	057422	086011/32	143
053747	CO501-6N47	158	055627	QC0860P27/64	151	056550	5ATL5.5	136	057424	08603/8	143
053748	CO501-6N48	158	055628	QC0860P7/16	151	056560	5ATL5.6	136	057426	086013/32	143
053749	CO501-6N49	158	055629	QC0860P29/64	151	0056561	A9404.8	65	057428	08607/16	143
053750	CO501-6N50	158	055630	QC0860P15/32	151	056570	5ATL5.7	136	057430	086015/32	144
0053751	A9401.4	64	055631	QC0860P31/64	151	056600	5ATL6.0	136	057432	08601/2	144
053751	CO501-6N51	158	0055632	A9403.7	65	0056615	A9404.9	65	0057780	A9405.5	65
053752	CO501-6N52	158	055632	QC0860P1/2	151	056640	5ATL6.4	136	0057797	A9407/32	65
0053768	A9401.5	64	055904	QC91G1/16	138	0056646	A9405.0	65	0057810	A9405.6	65
0053775	A9401/16	64	055905	QC91G5/64	138	056650	5ATL6.5	136	0057827	A9405.7	65
0054253	A9401.6	64	055906	QC91G3/32	138	056680	5ATL6.8	136	0057834	A9405.8	65
0054260	A9401.7	64	055907	QC91G7/64	138	056720	5ATL7.2	136	0057841	A9405.9	65
0054383	A9401.8	64	055908	QC91G1/8	138	056750	5ATL7.5	136	0057858	A94015/64	65
0054390	A9401.9	64	055909	QC91G9/64	138	056770	5ATL7.0	136	0057865	A9406.0	65
0054406	A9405/64	64	055910	QC91G5/32	139	056780	5ATL7.8	136	0057872	A9406.1	65
0054604	A9402.0	64	055911	QC91G11/64	139	056800	5ATL8.0	136	057904	QC91P1/16	138
0054611	A9402.1	64	055912	QC91G3/16	139	056820	5ATL8.2	136	057905	QC91P5/64	138
0054628	A9402.2	64	055913	QC91G13/64	139	0056820	A9405.1	65	057906	QC91P3/32	138
0054710	A9402.3	64	055914	QC91G7/32	139	056850	5ATL8.5	136	057907	QC91P7/64	138
0054727	A9403/32	64	055915	QC91G15/64	139	0056882	A94013/64	65	057908	QC91P1/8	138
0054734	A9402.4	64	055916	QC91G1/4	139	056900	5ATL9.0	136	057909	QC91P9/64	138
0054789	A9402.5	64	055917	QC91G17/64	139	056920	5ATL9.2	136	057910	QC91P5/32	139
0054796	A9402.6	64	055918	QC91G9/32	139	056950	5ATL9.5	136	057911	QC91P11/64	139
0054802	A9402.7	64	055919	QC91G19/64	139	0056974	A9405.2	65	057912	QC91P3/16	139
0054833	A9407/64	64	055920	QC91G5/16	139	056980	5ATL9.8	136	057913	QC91P13/64	139
0054840	A9402.8	64	055921	QC91G21/64	139	0057001	A9405.3	65	057914	QC91P7/32	139
0054857	A9402.9	64	055922	QC91G11/32	139	0057056	A9405.4	65	057915	QC91P15/64	139
0054871	A9403.0	64	055924	QC91G3/8	139	057100	5ATL10.0	136	057916	QC91P1/4	139
055001	R55A	132	055925	QC91G25/64	139	057102	5ATL10.2	136	057917	QC91P17/64	139
055002	R55B	132	055926	QC91G13/32	139	057105	5ATL10.5	136	057918	QC91P9/32	139
055003	R55C	132	055927	QC91G27/64	139	057110	5ATL11.0	136	057919	QC91P19/64	139
055004	R55D	133	055928	QC91G7/16	139	057112	5ATL11.2	136	057920	QC91P5/16	139
055005	R55E	133	055929	QC91G29/64	139	057115	5ATL11.5	136	057921	QC91P21/64	139
055006	R55F	133	055932	QC91G1/2	139	057120	5ATL12.0	136	057922	QC91P11/32	139
055007	R55G	133	0056011	A9403.8	65	057125	5ATL12.5	136	057923	QC91P23/64	139
055009	R55I	133	0056028	A9403.9	65	057130	5ATL13.0	136	057924	QC91P3/8	139
055010	R55J	133	056100	5ATL1.0	135	057135	5ATL13.5	136	057925	QC91P25/64	139
055011	R55K	133	056120	5ATL1.2	135	057138	5ATL13.8	136	057926	QC91P13/32	139
055012	R55L	133	056125	5ATL1.25	135	057140	5ATL14.0	136	057927	QC91P27/64	139
055013	R55M	133	056130	5ATL1.3	135	057145	5ATL14.5	136	057928	QC91P7/16	139
055014	R55N	133	056140	5ATL1.4	135	057150	5ATL15.0	136	057929	QC91P29/64	139
055015	R55O	133	056150	5ATL1.5	135	057155	5ATL15.5	136	057930	QC91P15/32	139
055016	R55P	133	056160	5ATL1.6	135	057160	5ATL16.0	136	057931	QC91P31/64	139
055017	R55Q	133	0056165	A9405/32	65	057165	5ATL16.5	136	057932	QC91P1/2	139
055018	R55R	133	056170	5ATL1.7	135	057170	5ATL17.0	136	057933	QC91P33/64	139
055019	R55S	133	0056172	A9404.0	65	057175	5ATL17.5	136	057934	QC91P17/32	139
055020	R55T	133	056180	5ATL1.8	135	057180	5ATL18.0	136	057935	QC91P35/64	139
055021	R55U	133	056190	5ATL1.9	135	057185	5ATL18.5	136	057936	QC91P9/16	139
055022	R55V	133	056200	5ATL2.0	135	057190	5ATL19.0	136	057937	QC91P37/64	139
055023	R55W	133	056210	5ATL2.1	135	057195	5ATL19.5	136	057938	QC91P19/32	139

EDP NUMBER INDEX - 057940 - 059032

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
057940	QC91P5/8	139	058146	501-6N46	153	058325	QC41P25/64	125	0058800	A94010.5	66
057942	QC91P21/32	139	058147	501-6N47	153	058326	QC41P13/32	125	058803	R89CON3	112
057944	QC91P11/16	139	058148	501-6N48	153	058327	QC41P27/64	125	058805	R89CON5	112
058003	500-63/64	153	058149	501-6N49	153	058328	QC41P77/16	125	058806	R89CON6	112
058004	500-61/16	153	058150	501-6N50	153	058329	QC41P29/64	125	058807	R89CON7	112
058005	500-65/64	153	058151	501-6N51	153	058330	QC41P15/32	125	058808	R89CON8	112
058006	500-63/32	153	058152	501-6N52	153	058331	QC41P31/64	125	058809	R89CON9	112
058007	500-67/64	153	0058152	A9406.3	65	058332	QC41P1/2	125	058810	R89CON10	112
058008	500-61/8	154	058153	501-6N53	153	058333	QC41P33/64	125	058811	R89CON11	112
058009	500-69/64	154	058154	501-6N54	153	058334	QC41P17/32	125	058812	R89CON12	112
058010	500-65/32	154	058155	501-6N55	153	058335	QC41P35/64	125	058813	R89CON13	111
058011	500-611/64	154	058156	501-6N56	153	058336	QC41P9/16	125	058816	R89CON16	111
058012	500-63/16	154	058157	501-6N57	153	058337	QC41P37/64	125	0058817	A94027/64	66
058013	500-613/64	154	058158	501-6N58	153	058338	QC41P19/32	125	058820	R89CON20	111
058014	500-67/32	154	058159	501-6N59	153	058340	QC41P5/8	125	058821	R89CON21	111
058015	500-615/64	154	058160	501-6N60	153	0058343	A9407.6	65	058822	R89CON22	111
058016	500-61/4	154	0058169	A9401/4	65	058344	QC41P11/16	125	058824	R89CON24	111
058017	500-617/64	154	0058176	A9406.4	65	0058350	A9407.7	65	058825	R89CON25	111
058018	500-69/32	154	0058183	A9406.5	65	0058374	A9407.8	65	058826	R89CON26	111
058019	500-619/64	154	0058190	A9406.6	65	0058381	A9407.9	65	058827	R89CON27	111
058020	500-65/16	154	058201	502-6A	154	0058398	A9405/16	65	058829	R89CON29	111
058021	500-621/64	154	058202	502-6B	154	0058404	A9408.0	65	058830	R89CON30	111
058022	500-611/32	154	058203	502-6C	154	0058411	A9408.1	65	0058831	A94011.0	66
058023	500-623/64	155	058204	502-6D	154	0058435	A9408.2	65	058831	R89CON31	111
058024	500-63/8	155	058205	502-6E	154	0058442	A9408.3	65	058836	R89CON36	111
058025	500-625/64	155	058206	502-6F	154	0058473	A94021/64	65	058839	R89CON39	111
058026	500-613/32	155	0058206	A9406.7	65	0058503	A9408.4	65	058840	R89CON40	111
058027	500-627/64	155	058207	502-6G	154	0058510	A9408.5	65	058841	R89CON41	111
058028	500-67/16	155	058208	502-6H	154	0058558	A9408.6	65	058842	R89CON42	111
058029	500-629/64	155	058209	502-6I	154	0058572	A9408.7	65	058843	R89CON43	111
058030	500-615/32	155	058210	502-6J	154	0058589	A94011/32	65	058844	R89CON44	111
058031	500-631/64	155	058211	502-6K	154	0058596	A9408.8	65	058845	R89CON45	111
058032	500-61/2	155	058212	502-6L	154	0058602	A9408.9	66	058846	R89CON46	111
058101	501-6N1	154	058213	502-6M	154	0058626	A9409.0	66	058849	R89CON49	111
058102	501-6N2	154	0058213	A94017/64	65	0058633	A9409.1	66	058850	R89CON50	111
058103	501-6N3	154	058214	502-6N	154	0058640	A94023/64	66	058851	R89CON51	111
058104	501-6N4	154	058215	502-6O	154	0058657	A9409.2	66	058852	R89CON52	111
058105	501-6N5	154	058216	502-6P	154	0058664	A9409.3	66	0058855	A9407/16	66
058106	501-6N6	154	058217	502-6Q	154	0058671	A9409.4	66	0058862	A94011.2	66
058107	501-6N7	154	058218	502-6R	154	0058688	A9409.5	66	0058886	A94011.5	66
058108	501-6N8	154	058219	502-6S	154	0058695	A9403/8	66	0058893	A94029/64	66
058109	501-6N9	154	058220	502-6T	155	0058701	A9409.6	66	0058909	A94011.8	66
058110	501-6N10	154	0058220	A9406.8	65	058704	R88CO1/16	111	0058916	A94015/32	66
058111	501-6N11	154	058221	502-6U	155	058705	R88CO5/64	111	0058923	A94012.0	66
058112	501-6N12	154	058222	502-6V	155	058706	R88CO3/32	111	0058930	A94012.2	66
058113	501-6N13	154	058223	502-6W	155	058707	R88CO7/64	111	0058978	A94031/64	66
058114	501-6N14	154	058224	502-6X	155	058708	R88CO1/8	111	0058985	A94012.5	66
058115	501-6N15	154	058225	502-6Y	155	058709	R88CO9/64	111	0058992	A9401/2	66
058116	501-6N16	154	058226	502-6Z	155	058710	R88CO5/32	111	059003	500-123/64	156
058117	501-6N17	154	0058237	A9406.9	65	058711	R88CO11/64	111	059004	500-121/16	156
058118	501-6N18	154	0058244	A9407.0	65	058712	R88CO3/16	112	059005	500-125/64	156
058119	501-6N19	154	0058251	A9407.1	65	058713	R88CO13/64	112	059006	500-123/32	156
058120	501-6N20	154	0058268	A9409/32	65	058714	R88CO7/32	112	059007	500-127/64	156
058121	501-6N21	154	0058275	A9407.2	65	058715	R88CO15/64	112	059008	500-121/8	156
058122	501-6N22	154	0058282	A9407.3	65	058716	R88CO1/4	112	059009	500-129/64	156
058123	501-6N23	154	0058299	A9407.4	65	058717	R88CO17/64	112	059010	500-125/32	156
058124	501-6N24	154	058304	QC41P1/16	124	0058718	A9409.7	66	059011	500-1211/64	157
058125	501-6N25	154	0058305	A9407.5	65	058718	R88CO9/32	112	059012	500-123/16	157
058126	501-6N26	154	058305	QC41P5/64	124	058719	R88CO19/64	112	0059012	A94013.0	66
058127	501-6N27	154	058306	QC41P3/32	124	058720	R88CO5/16	112	059013	500-1213/64	157
058128	501-6N28	154	058307	QC41P7/64	124	058721	R88CO21/64	112	059014	500-127/32	157
058129	501-6N29	154	058308	QC41P1/8	124	058722	R88CO11/32	112	059015	500-1215/64	157
058130	501-6N30	154	058309	QC41P9/64	124	058723	R88CO23/64	112	059016	500-121/4	157
058131	501-6N31	154	058310	QC41P5/32	124	058724	R88CO3/8	112	059017	500-1217/64	157
058132	501-6N32	154	058311	QC41P11/64	124	0058725	A9409.8	66	059018	500-129/32	157
058133	501-6N33	154	0058312	A94019/64	65	058725	R88CO25/64	112	059019	500-1219/64	157
058134	501-6N34	153	058312	QC41P3/16	125	058726	R88CO13/32	112	059020	500-125/16	157
058135	501-6N35	153	058313	QC41P13/64	125	058727	R88CO27/64	112	059021	500-1221/64	157
058136	501-6N36	153	058314	QC41P7/32	125	058728	R88CO7/16	112	059022	500-1211/32	157
058137	501-6N37	153	058315	QC41P15/64	125	058729	R88CO29/64	112	059023	500-1223/64	157
058138	501-6N38	153	058316	QC41P1/4	125	058730	R88CO15/32	112	059024	500-123/8	157
058139	501-6N39	153	058317	QC41P17/64	125	058731	R88CO31/64	112	059025	500-1225/64	157
058140	501-6N40	153	058318	QC41P9/32	125	0058732	A9409.9	66	059026	500-1213/32	157
058141	501-6N41	153	058319	QC41P19/64	125	058732	R88CO1/2	112	059027	500-1227/64	157
058142	501-6N42	153	058320	QC41P5/16	125	0058749	A94025/64	66	059028	500-127/16	157
058143	501-6N43	153	058321	QC41P21/64	125	0058756	A94010.0	66	059029	500-1229/64	157
058144	501-6N44	153	058322	QC41P11/32	125	0058763	A94010.2	66	059030	500-1215/32	157
058145	501-6N45	153	058323	QC41P23/64	125	0058770	A94010.3	66	059031	500-1231/64	157
0058145	A9406.2	65	058324	QC41P3/8	125	0058787	A94013/32	66	059032	500-121/2	157

EDP NUMBER INDEX - 059043 - 0060476

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0059043	A94033/64	66	0059289	A94017.5	66	059546	151123/32	148	059764	18131	149
0059050	A94017/32	66	0059296	A94045/64	66	059548	15113/4	148	0059838	A9413.5	52
0059067	A94013.5	66	0059302	A94018.0	66	059550	151125/32	148	0059944	A9413.6	65
0059081	A94014.0	66	0059326	A94023/32	66	059552	151113/16	148	0059968	A9413.7	65
059101	501-12N1	157	0059333	A94047/64	66	059554	15117/8	149	0059982	A9413.8	65
059103	501-12N3	157	0059340	A94019.0	66	059556	151115/16	149	060001	QC41PN1	125
059104	501-12N4	157	0059357	A9403/4	66	059558	15111	149	060002	QC41PN2	125
059105	501-12N5	157	0059364	A94020.0	66	059608	12901/8	143	060003	QC41PN3	125
059107	501-12N7	157	0059371	A9411.0	64	059609	12909/64	143	060004	QC41PN4	125
059109	501-12N9	157	0059388	A9411.5	64	059610	12905/32	143	060005	QC41PN5	125
059110	501-12N10	157	0059401	A9412.0	52	059611	129011/64	143	060006	QC41PN6	125
059111	501-12N11	157	059401	QC91PN1	139	059612	12903/16	143	060007	QC41PN7	125
0059111	A9409/16	66	059402	QC91PN2	139	059613	129013/64	143	060008	QC41PN8	125
059112	501-12N12	157	059403	QC91PN3	139	059614	12907/32	143	060009	QC41PN9	125
059113	501-12N13	157	059404	QC91PN4	139	059615	129015/64	143	060010	QC41PN10	125
059116	501-12N16	157	059405	QC91PN5	139	059616	12901/4	143	060011	QC41PN11	125
059117	501-12N17	157	059406	QC91PN6	139	059617	129017/64	143	060012	QC41PN12	125
059118	501-12N18	157	059407	QC91PN7	139	059618	12909/32	143	060013	QC41PN13	125
059119	501-12N19	156	059408	QC91PN8	139	059619	129019/64	143	060014	QC41PN14	125
059120	501-12N20	156	059409	QC91PN9	139	059620	12905/16	143	060015	QC41PN15	125
059121	501-12N21	156	059410	QC91PN10	139	059621	129021/64	143	060016	QC41PN16	124
059122	501-12N22	156	059411	QC91PN11	139	059622	129011/32	143	060017	QC41PN17	124
059123	501-12N23	156	059412	QC91PN12	139	059623	129023/64	143	060018	QC41PN18	124
059125	501-12N25	156	059413	QC91PN13	139	059624	12903/8	143	060019	QC41PN19	124
059126	501-12N26	156	059414	QC91PN14	139	059625	129025/64	143	060020	QC41PN20	124
059127	501-12N27	156	059415	QC91PN15	139	059626	129013/32	143	060021	QC41PN21	124
0059128	A94014.5	66	059416	QC91PN16	139	059627	129027/64	143	060022	QC41PN22	124
059129	501-12N29	156	059417	QC91PN17	139	059628	12907/16	143	060023	QC41PN23	124
059130	501-12N30	156	0059418	A9412.5	52	059629	129029/64	144	060024	QC41PN24	124
059131	501-12N31	156	059418	QC91PN18	139	059630	129015/32	144	060025	QC41PN25	124
059136	501-12N36	156	059419	QC91PN19	139	059631	129031/64	144	060026	QC41PN26	124
059137	501-12N37	156	059420	QC91PN20	139	059632	12901/2	144	060027	QC41PN27	124
059140	501-12N40	156	059421	QC91PN21	139	059633	129033/64	144	060028	QC41PN28	124
059141	501-12N41	156	059422	QC91PN22	139	059634	129017/32	144	060029	QC41PN29	124
059142	501-12N42	156	059423	QC91PN23	139	059635	129035/64	144	060030	QC41PN30	124
059143	501-12N43	156	059424	QC91PN24	139	059636	12909/16	144	060031	QC41PN31	124
059144	501-12N44	156	059425	QC91PN25	139	059637	129037/64	144	060032	QC41PN32	124
059145	501-12N45	156	059426	QC91PN26	138	059638	129019/32	144	060033	QC41PN33	124
059146	501-12N46	156	059427	QC91PN27	138	059639	129039/64	144	060034	QC41PN34	124
059147	501-12N47	156	059428	QC91PN28	138	059640	12905/8	144	060035	QC41PN35	124
059148	501-12N48	156	059429	QC91PN29	138	059642	129021/32	144	060036	QC41PN36	124
059149	501-12N49	156	059430	QC91PN30	138	059644	129011/16	144	060037	QC41PN37	124
059150	501-12N50	156	059431	QC91PN31	138	059646	129023/32	144	060038	QC41PN38	124
0059166	A94037/64	66	0059432	A9413.0	52	059648	12903/4	144	060039	QC41PN39	124
0059180	A94015.0	66	059432	QC91PN32	138	0059654	A9413.3	52	060040	QC41PN40	124
059201	502-12A	157	059433	QC91PN33	138	0059661	A9413.4	52	0060216	A9413.9	65
059202	502-12B	157	059434	QC91PN34	138	059716	18131/4	146	0060223	A9414.0	65
059203	502-12C	157	059435	QC91PN35	138	059717	181317/64	146	060308	QC1290P/18	150
0059203	A94019/32	66	059436	QC91PN36	138	059718	18139/32	146	060309	QC1290P9/64	150
059204	502-12D	157	059437	QC91PN37	138	059719	181319/64	147	060310	QC1290P5/32	150
059205	502-12E	157	059438	QC91PN38	138	059720	18135/16	147	060311	QC1290P11/64	150
059206	502-12F	157	059439	QC91PN39	138	059721	181321/64	147	060312	QC1290P3/16	150
059207	502-12G	157	059440	QC91PN40	138	059722	181311/32	147	060313	QC1290P13/64	150
059208	502-12H	157	059441	QC91PN41	138	059723	181323/64	147	060314	QC1290P7/32	150
059209	502-12I	157	059442	QC91PN42	138	059724	18133/8	147	0060315	A9414.1	65
059210	502-12J	157	059443	QC91PN43	138	059725	181325/64	147	060315	QC1290P15/64	150
0059210	A94015.5	66	059444	QC91PN44	138	059726	181313/32	147	060316	QC1290P1/4	150
059211	502-12K	157	059445	QC91PN45	138	059727	181327/64	147	060317	QC1290P17/64	150
059212	502-12L	157	059446	QC91PN46	138	059728	18137/16	147	060318	QC1290P9/32	150
059213	502-12M	157	059447	QC91PN47	138	059729	181329/64	147	060319	QC1290P19/64	150
059214	502-12N	157	059448	QC91PN48	138	059730	181315/32	148	060320	QC1290P5/16	150
059215	502-12O	157	0059449	A9413.1	52	059731	181331/64	148	060321	QC1290P21/64	150
059216	502-12P	157	059449	QC91PN49	138	059732	18131/2	148	0060322	A9414.2	65
059217	502-12Q	157	059450	QC91PN50	138	059733	181333/64	148	060322	QC1290P11/32	150
059218	502-12R	157	059451	QC91PN51	138	059734	181317/32	148	060323	QC1290P23/64	150
059219	502-12S	157	059452	QC91PN52	138	059735	181335/64	148	060324	QC1290P3/8	151
059220	502-12T	157	0059463	A9413.2	52	059736	18139/16	148	060325	QC1290P25/64	151
059221	502-12U	157	059512	15113/16	146	059737	181337/64	148	060326	QC1290P13/32	151
059222	502-12V	157	059516	15111/4	146	059738	181319/32	148	060327	QC1290P27/64	151
059223	502-12W	157	059520	15115/16	147	059739	181339/64	148	060328	QC1290P7/16	151
059224	502-12X	157	059522	151111/32	147	059740	18135/8	148	060330	QC1290P15/32	151
059225	502-12Y	157	059524	15113/8	147	059742	181321/32	148	060332	QC1290P1/2	151
059226	502-12Z	157	059528	15117/16	147	059744	181311/16	148	0060377	A9414.3	65
0059227	A9405/8	66	059532	15111/2	148	059746	181323/32	148	0060384	A9414.4	65
0059234	A94016.0	66	059534	151117/32	148	059748	18133/4	148	0060414	A9414.5	65
0059241	A94016.5	66	059536	15119/16	148	059750	181325/32	148	0060421	A9414.6	65
0059258	A94021/32	66	059540	15115/8	148	059752	181313/16	149	0060445	A9414.7	65
0059265	A94017.0	66	059542	151121/32	148	059756	18137/8	149	0060452	A9414.8	65
0059272	A94011/16	66	059544	151111/16	148	059760	181315/16	149	0060476	A9414.9	65

EDP NUMBER INDEX - 0060490 - 091266

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0060490	A9415.0	65	061429	QC41GN29	124	080522	QC21GN22	103	087905	SPS-901	188
0060513	A9415.1	65	061430	QC41GN30	124	080523	QC21GN23	103	087906	SPSG-901/4	188
0060605	A9415.2	65	061431	QC41GN31	124	080524	QC21GN24	103	087907	SPSG-903/8	188
0060612	A9415.3	65	061432	QC41GN32	124	080525	QC21GN25	103	087908	SPSG-901/2	188
0060674	A9415.4	65	061433	QC41GN33	124	080526	QC21GN26	102	087909	SPSG-905/8	188
0060681	A9415.5	65	061434	QC41GN34	124	080527	QC21GN27	102	087910	SPSG-903/4	188
0060728	A9415.6	65	0061435	A94110.2	66	080528	QC21GN28	102	087911	SPSG-901	188
0060735	A9415.7	65	061435	QC41GN35	124	080529	QC21GN29	102	087912	SPR-901/4	189
0060766	A9415.8	65	061436	QC41GN36	124	080530	QC21GN30	102	087913	SPR-903/8	189
0060773	A9415.9	65	061437	QC41GN37	124	080531	QC21GN31	102	087914	SPR-901/2	189
0060797	A9416.0	65	061438	QC41GN38	124	080532	QC21GN32	102	087915	SPR-905/8	189
0060889	A9416.1	65	061439	QC41GN39	124	080533	QC21GN33	102	087916	SPR-903/4	189
0060940	A9416.2	65	061440	QC41GN40	124	080534	QC21GN34	102	087917	SPR-901	189
0060995	A9416.3	65	0061442	A94110.3	66	080535	QC21GN35	102	087918	SPRG-901/4	189
0061022	A9416.4	65	0061466	A94110.5	66	080536	QC21GN36	102	087919	SPRG-903/8	189
0061046	A9416.5	65	0061480	A94111.0	66	080537	QC21GN37	102	087920	SPRG-901/2	189
0061053	A9416.6	65	0061497	A94111.2	66	080538	QC21GN38	102	087921	SPRG-905/8	189
0061091	A9416.7	65	0061633	A94111.5	66	080539	QC21GN39	102	087922	SPRG-903/4	189
0061107	A9416.8	65	0061657	A94111.8	66	080540	QC21GN40	102	087923	SPRG-901	189
0061114	A9416.9	65	0061688	A94112.0	66	080541	QC21GN41	102	087924	SPL-901/4	190
0061121	A9417.0	65	0061718	A94112.2	66	080542	QC21GN42	102	087925	SPL-903/8	190
0061138	A9417.1	65	0061749	A94112.5	66	080543	QC21GN43	102	087926	SPL-901/2	190
0061145	A9417.2	65	0061817	A94113.0	66	080544	QC21GN44	102	087927	SPL-905/8	190
0061152	A9417.3	65	0061848	A94113.5	66	080545	QC21GN45	102	087928	SPL-903/4	190
0061169	A9417.4	65	0061862	A94114.0	66	080546	QC21GN46	102	087929	SPL-901	190
0061176	A9417.5	65	0061886	A94114.5	66	080547	QC21GN47	102	087930	SPLG-901/4	190
0061183	A9417.6	65	0061909	A94115.0	66	080548	QC21GN48	102	087931	SPLG-903/8	190
0061190	A9417.7	65	0061916	A94115.5	66	080549	QC21GN49	102	087932	SPLG-901/2	190
0061206	A9417.8	65	0061930	A94116.0	66	080550	QC21GN50	102	087934	SPLG-903/4	190
0061213	A9417.9	65	062304	QC41G1/16	124	080551	QC21GN51	102	087935	SPLG-901	190
0061220	A9418.0	65	062305	QC41G5/64	124	080552	QC21GN52	102	087950	SPS-1201/4	188
0061237	A9418.1	65	062306	QC41G3/32	124	081704	QC21G1/16	102	087951	SPS-1203/8	188
0061244	A9418.2	65	062307	QC41G7/64	124	081705	QC21G5/64	102	087952	SPS-1201/2	188
0061251	A9418.3	65	062308	QC41G1/8	124	081706	QC21G3/32	102	087953	SPS-1205/8	188
0061268	A9418.4	65	062309	QC41G9/64	124	081707	QC21G7/64	102	087954	SPS-1203/4	188
0061275	A9418.5	65	062310	QC41G5/32	124	081708	QC21G1/8	102	087955	SPS-1201	188
0061282	A9418.6	65	062311	QC41G11/64	124	081709	QC21G9/64	102	087956	SPSG-1201/4	188
0061299	A9418.7	65	062312	QC41G3/16	125	081710	QC21G5/32	103	087957	SPSG-1203/8	188
0061305	A9418.8	65	062313	QC41G13/64	125	081711	QC21G11/64	103	087958	SPSG-1201/2	188
0061312	A9418.9	66	062314	QC41G7/32	125	081712	QC21G3/16	103	087959	SPSG-1205/8	188
0061329	A9419.0	66	062315	QC41G15/64	125	081713	QC21G13/64	103	087960	SPSG-1203/4	188
0061336	A9419.1	66	062316	QC41G1/4	125	081714	QC21G7/32	103	087961	SPSG-1201	188
0061343	A9419.2	66	062317	QC41G17/64	125	081715	QC21G15/64	103	087962	SPR-1201/4	189
0061350	A9419.3	66	062318	QC41G9/32	125	081716	QC21G1/4	103	087963	SPR-1203/8	189
0061367	A9419.4	66	062319	QC41G19/64	125	081717	QC21G17/64	103	087964	SPR-1201/2	189
0061374	A9419.5	66	062320	QC41G5/16	125	081718	QC21G9/32	103	087965	SPR-1205/8	189
0061381	A9419.6	66	062321	QC41G21/64	125	081719	QC21G19/64	103	087966	SPR-1203/4	189
0061398	A9419.7	66	062322	QC41G11/32	125	081720	QC21G5/16	103	087967	SPR-1201	189
061401	QC41GN1	125	062323	QC41G23/64	125	081721	QC21G21/64	103	087968	SPRG-1201/4	189
061402	QC41GN2	125	062324	QC41G3/8	125	081722	QC21G11/32	103	087969	SPRG-1203/8	189
061403	QC41GN3	125	062325	QC41G25/64	125	081723	QC21G23/64	103	087970	SPRG-1201/2	189
061404	A9419.8	66	062326	QC41G13/32	125	081724	QC21G3/8	103	087974	SPL-1201/4	190
061404	QC41GN4	125	062327	QC41G27/64	125	081725	QC21G25/64	103	087975	SPL-1203/8	190
061405	QC41GN5	125	062328	QC41G7/16	125	081726	QC21G13/32	103	087976	SPL-1201/2	190
061406	QC41GN6	125	062329	QC41G29/64	125	081727	QC21G27/64	104	087977	SPL-1205/8	190
061407	QC41GN7	125	062330	QC41G15/32	125	081728	QC21G7/16	104	087980	SPLG-1201/4	190
061408	QC41GN8	125	062331	QC41G31/64	125	081729	QC21G29/64	104	087981	SPLG-1203/8	190
061409	QC41GN9	125	062332	QC41G1/2	125	081730	QC21G15/32	104	087982	SPLG-1201/2	190
061410	QC41GN10	125	080501	QC21GN1	103	081731	QC21G31/64	104	090101	C60R18PSET	198
0061411	A9419.9	66	080502	QC21GN2	103	081732	QC21G1/2	104	090123	C115COMBPSET	199
061411	QC41GN11	125	080503	QC21GN3	103	0085189	E201M10	243	090126	C26R15PSET	199
061412	QC41GN12	125	080504	QC21GN4	103	0085196	E201M4	243	090154	C29R51SET	213
061413	QC41GN13	125	080505	QC21GN5	103	0085202	E201M5	243	090161	C20R18PSET	198
061414	QC41GN14	125	080506	QC21GN6	103	0085219	E201M6	243	090162	C29R10PSET	197
061415	QC41GN15	125	080507	QC21GN7	103	0085226	E201M8	243	090163	C15R10PSET	197
061416	QC41GN16	124	080508	QC21GN8	103	0087268	E252M10	243	090170	C29R40SET	209
061417	QC41GN17	124	080509	QC21GN9	103	0087275	E252M12	243	090173	C26R42SET	209
061418	QC41GN18	124	080510	QC21GN10	103	0087282	E252M14	243	090174	C60R41SET	209
061419	QC41GN19	124	080511	QC21GN11	103	0087299	E252M16	243	090231	C33R56SET	214
061420	QC41GN20	124	080512	QC21GN12	103	0087305	E252M18	243	090290	C29R10COSET	207
061421	QC41GN21	124	080513	QC21GN13	103	0087312	E252M20	243	090291	C15R10COSET	197
061422	QC41GN22	124	080514	QC21GN14	103	0087329	E252M22	243	090292	C26R15COSET	207
061423	QC41GN23	124	080515	QC21GN15	103	0087336	E252M24	243	090328	C8R56COSET	214
061424	QC41GN24	124	080516	QC21GN16	103	0087343	E252M8	243	090556	C8R56SET	214
061425	QC41GN25	124	080517	QC21GN17	103	087900	SPS-901/4	188	090558	C8R57SET	214
061426	QC41GN26	124	080518	QC21GN18	103	087901	SPS-903/8	188	090600	C60R18COSET	207
061427	QC41GN27	124	080519	QC21GN19	103	087902	SPS-901/2	188	091010	C29HX10SET	206
0061428	A94110.0	66	080520	QC21GN20	103	087903	SPS-905/8	188	091264	R581	178
061428	QC41GN28	124	080521	QC21GN21	103	087904	SPS-903/4	188	091266	R581.1/32	178

EDP NUMBER INDEX - 091268 - 096789

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
091268	R581.1/16	178	091535	R5735/64	176	0093924	E500M1.7NO2	270	0095072	E501M4NO2	278
091270	R581.3/32	178	091536	R579/16	176	0093931	E500M1.7NO3	270	0095089	E501M4NO3	278
091272	R581.1/8	178	091537	R5737/64	176	0093948	E500M1.8NO2	270	0095096	E501M5NO2	278
091274	R581.5/32	178	091540	R575/8	176	0093955	E500M1.8NO3	270	0095102	E501M5NO3	278
091276	R581.3/16	178	091541	R5741/64	176	0093979	E500M10NO2	270	0095119	E501M6NO2	278
091278	R581.7/32	178	091542	R5721/32	176	0093986	E500M10NO3	270	0095126	E501M6NO3	278
091280	R581.1/4	178	091543	R5743/64	176	0094006	E500M11NO2	270	0095133	E501M8NO2	278
091282	R581.9/32	178	091544	R5711/16	176	0094013	E500M11NO3	270	0095140	E501M8NO3	278
091284	R581.5/16	178	091545	R5745/64	176	0094037	E500M12NO2	270	0096079	E513M10X1.25NO3	272
091286	R581.11/32	178	091546	R5723/32	176	0094044	E500M12NO3	270	0096086	E513M10X1.0NO3	272
091288	R581.3/8	178	091547	R5747/64	176	0094051	E500M12NO6	270	0096093	E513M11X1.0NO2	272
091290	R581.13/32	178	091548	R573/4	176	0094075	E500M14NO2	270	0096109	E513M11X1.0NO3	272
091292	R581.7/16	178	091549	R5749/64	176	0094082	E500M14NO3	270	0096116	E513M12X1.25NO3	272
091294	R581.15/32	178	091551	R5751/64	176	0094105	E500M16NO2	270	0096123	E513M12X1.25NO7	272
091296	R581.1/2	178	091553	R5753/64	176	0094112	E500M16NO3	270	0096130	E513M12X1.5NO2	272
091298	R581.9/16	178	091555	R5755/64	176	0094136	E500M18NO2	270	0096147	E513M12X1.5NO3	272
091300	R581.5/8	178	091556	R577/8	176	0094143	E500M18NO3	270	0096154	E513M12X1.0NO3	272
091302	R581.11/16	178	091557	R5757/64	176	0094167	E500M2.2NO2	270	0096161	E513M14X1.25NO3	272
091304	R581.3/4	178	091561	R5761/64	176	0094174	E500M2.2NO3	270	0096178	E513M14X1.5NO3	272
091306	R581.13/16	178	091562	R5731/32	176	0094198	E500M2.3NO2	270	0096185	E513M14X1.0NO3	272
091308	R581.7/8	178	091563	R5763/64	176	0094204	E500M2.3NO3	270	0096192	E513M15X1.5NO2	272
091310	R581.15/16	178	091564	R571	176	0094228	E500M2.5NO2	270	0096208	E513M15X1.5NO3	272
091312	R582	178	091565	R571.1/64	176	0094235	E500M2.5NO3	270	0096222	E513M16X1.5NO3	272
091433	R5633/64	174	091567	R571.3/64	176	0094259	E500M2NO1	270	0096239	E513M16X1.5NO7	272
091434	R5617/32	174	091568	R571.1/16	176	0094266	E500M2NO2	270	0096246	E513M16X1.0NO3	272
091435	R5635/64	174	091569	R571.5/64	176	0094273	E500M2NO3	270	0096253	E513M16X1.0NO7	272
091436	R569/16	174	091570	R571.3/32	176	0094297	E500M2NO3	270	0096260	E513M18X1.5NO3	273
091437	R5637/64	174	091571	R571.7/64	176	0094310	E500M22NO2	271	0096277	E513M18X1.0NO2	273
091438	R5619/32	174	091572	R571.1/8	176	0094327	E500M22NO3	271	0096284	E513M18X1.0NO3	273
091440	R565/8	174	091573	R571.9/64	176	0094341	E500M24NO2	271	0096291	E513M18X1.0NO7	273
091441	R5641/64	174	091575	R571.11/64	177	0094358	E500M24NO3	271	0096307	E513M18X2.0NO2	273
091442	R5621/32	174	091576	R571.3/16	177	0094365	E500M27NO2	271	0096314	E513M18X2.0NO3	273
091443	R5643/64	174	091577	R571.13/64	177	0094372	E500M27NO3	271	0096321	E513M18X2.0NO7	273
091444	R5611/16	174	091579	R571.15/64	177	0094402	E500M3.5NO1	270	0096338	E513M20X1.5NO3	273
091445	R5645/64	174	091580	R571.1/4	177	0094419	E500M3.5NO2	270	0096345	E513M20X1.0NO2	273
091446	R5623/32	174	091582	R571.5/16	177	0094426	E500M3.5NO3	270	0096352	E513M20X1.0NO3	273
091447	R5647/64	174	091583	R571.3/8	177	0094440	E500M3NO2	270	0096369	E513M20X1.0NO7	273
091448	R563/4	174	091584	R571.7/16	177	0094457	E500M3NO3	270	0096376	E513M20X2.0NO2	273
091449	R5649/64	174	091585	R571.1/2	177	0094464	E500M3NO6	270	0096383	E513M20X2.0NO3	273
091450	R5625/32	174	091586	R571.1/32	176	0094488	E500M30NO2	270	0096390	E513M22X1.5NO3	273
091451	R5651/64	174	091587	R571.5/32	176	0094495	E500M30NO3	270	0096406	E513M22X1.0NO2	273
091452	R5613/16	174	091588	R571.7/32	177	0094525	E500M33NO3	270	0096413	E513M22X1.0NO3	273
091453	R5653/64	174	091589	R571.9/32	177	0094549	E500M36NO2	271	0096420	E513M22X2.0NO2	273
091454	R5627/32	174	091592	R571.11/32	177	0094556	E500M36NO3	271	0096437	E513M22X2.0NO3	273
091455	R5655/64	174	091595	R571.13/32	177	0094587	E500M39NO3	271	0096444	E513M22X2.0NO7	273
091456	R567/8	174	091598	R571.15/32	177	0094617	E500M4.5NO2	270	0096451	E513M24X1.5NO3	273
091457	R5657/64	174	092333	R56CO33/64	179	0094624	E500M4.5NO3	270	0096468	E513M24X1.5NO7	273
091458	R5629/32	174	092334	R56CO17/32	179	0094648	E500M4NO2	270	0096475	E513M24X1.0NO2	273
091459	R5659/64	174	092335	R56CO35/64	179	0094655	E500M4NO3	270	0096482	E513M24X1.0NO3	273
091460	R5615/16	174	092336	R56CO9/16	179	0094662	E500M4NO6	270	0096499	E513M24X2.0NO2	273
091461	R5661/64	174	092337	R56CO37/64	179	0094686	E500M42NO3	271	0096505	E513M24X2.0NO3	273
091462	R5631/32	174	092338	R56CO19/32	179	0094709	E500M45NO3	271	0096512	E513M25X1.5NO3	273
091463	R5663/64	174	092339	R56CO39/64	179	0094730	E500M48NO3	271	0096529	E513M26X1.5NO2	273
091464	R561	174	092340	R56CO5/8	179	0094761	E500M5NO2	270	0096536	E513M26X1.5NO3	273
091465	R561.1/64	174	092341	R56CO41/64	179	0094778	E500M5NO3	270	0096543	E513M28X1.5NO2	273
091467	R561.3/64	175	092342	R56CO21/32	179	0094792	E500M52NO3	271	0096550	E513M28X1.5NO3	273
091468	R561.1/16	175	092343	R56CO43/64	179	0094808	E500M6NO1	270	0096567	E513M3X.35NO3	272
091469	R561.5/64	175	092344	R56CO11/16	179	0094815	E500M6NO2	270	0096574	E513M30X1.5NO2	273
091470	R561.3/32	175	092345	R56CO45/64	179	0094822	E500M6NO3	270	0096581	E513M30X1.5NO3	273
091471	R561.7/64	175	092346	R56CO23/32	179	0094846	E500M7NO3	270	0096598	E513M32X1.5NO3	273
091472	R561.1/8	175	092347	R56CO47/64	179	0094853	E500M7NO6	270	0096604	E513M33X2.0NO2	273
091473	R561.9/64	175	092348	R56CO3/4	179	0094877	E500M8NO2	270	0096611	E513M33X2.0NO3	273
091474	R561.11/64	175	092349	R56CO49/64	179	0094884	E500M8NO3	270	0096628	E513M35X1.5NO2	273
091475	R561.13/64	175	092350	R56CO25/32	179	0094891	E500M8NO6	270	0096635	E513M35X1.5NO3	273
091476	R561.3/16	175	092351	R56CO51/64	179	0094914	E500M9NO3	270	0096642	E513M36X2.0NO3	273
091477	R561.15/64	175	092352	R56CO13/16	179	0094938	E501M10NO2	278	0096659	E513M36X3.0NO2	273
091479	R561.9/32	175	092353	R56CO53/64	179	0094945	E501M10NO3	278	0096666	E513M36X3.0NO3	273
091480	R561.1/4	175	092354	R56CO27/32	179	0094952	E501M12NO2	278	0096673	E513M39X3.0NO3	273
091482	R561.5/16	175	092355	R56CO55/64	179	0094969	E501M12NO3	278	0096680	E513M4X.5NO3	272
091483	R561.3/8	175	092356	R56CO7/8	179	0094976	E501M14NO2	278	0096697	E513M40X1.5NO3	273
091484	R561.7/16	175	092357	R56CO57/64	179	0094983	E501M14NO3	278	0096703	E513M42X1.5NO3	273
091485	R561.1/2	175	092358	R56CO29/32	179	0094990	E501M16NO2	278	0096710	E513M45X1.5NO3	273
091486	R561.1/32	174	092359	R56CO59/64	179	0095003	E501M16NO3	278	0096727	E513M5X.5NO2	272
091487	R561.5/32	175	092360	R56CO15/16	179	0095010	E501M18NO3	278	0096734	E513M5X.5NO3	272
091488	R561.7/32	175	092361	R56CO61/64	179	0095027	E501M20NO2	278	0096741	E513M5X.5NO7	272
091492	R561.13/32	175	092362	R56CO31/32	179	0095034	E501M20NO3	278	0096758	E513M50X1.5NO3	273
091495	R561.15/32	175	092363	R56CO63/64	179	0095041	E501M24NO3	278	0096765	E513M6X.75NO3	272
091497	R561.11/32	175	092364	R56CO1	174	0095058	E501M3NO2	278	0096772	E513M6X.75NO7	272
091533	R5733/64	176	0093900	E500M1.6NO3	270	0095065	E501M3NO3	278	0096789	E513M7X.75NO2	272

EDP NUMBER INDEX - 0096796 - 0121986

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0096796	E513M7X.75NO3	272	0100011	E7121/2	315	0108949	G13834.0	468	0115893	R5109.2	42
0096802	E513M8X.75NO3	272	0100028	E7121/4	315	0108956	G13837.0	468	0115909	R5109.3	42
0096819	E513M8X.75NO7	272	0100035	E7121/8	315	0108963	G13840.0	468	0115916	R5109.5	42
0096826	E513M8X1.0NO3	272	0100042	E7123/4	315	0108970	G13850.0	468	0115923	R52010.0	36
0096833	E513M9X1.0NO3	272	0100059	E7123/8	315	0108987	G13863.0	468	0115930	R52010.2	36
097601	76HAN1	192	0104996	F201M10	342	0108994	G13880.0	468	0115947	R52010.4	36
097602	76HAN2	192	0105009	F201M12	342	0109038	G14910	460	0115954	R52010.5	36
097603	76HAN3	192	0105016	F201M14	342	0109045	G14915	460	0115961	R52011.0	36
097604	76HAN4	192	0105023	F201M16	342	0109052	G14920	460	0115978	R52011.5	36
097605	76HAN5	192	0105030	F201M4	342	0109069	G14925	460	0115985	R52012.0	36
097606	76HAN6	192	0105047	F201M5	342	0109076	G14930	460	0115992	R52012.5	36
097607	76HAN7	192	0105054	F201M6	342	0109083	G14935	460	0116005	R52013.0	36
097608	76HAN8	192	0105061	F201M8	342	0109090	G14940	460	0116012	R52014.0	36
097610	76HAN0	192	0105528	F302M10	345	0109106	G1495	460	0116029	R52014.5	36
097620	76HAN00	192	0105535	F302M11	345	0109113	G14950	460	0116036	R52015.0	36
097630	76HAN000	192	0105542	F302M12	345	0109502	G33825.0	468	0116043	R52016.0	36
0099193	E5471.1/2NO2	318	0105559	F302M14	345	0109519	G33831.0	468	0116050	R52016.5	36
0099209	E5471.1/2NO3	318	0105566	F302M16	345	0109526	G33837.0	468	0116067	R5203.0	35
0099216	E5471.1/4NO2	318	0105573	F302M18	345	0109533	G33840.0	468	0116074	R5203.1	35
0099223	E5471.1/4NO3	318	0105580	F302M20	345	0109540	G33850.0	468	0116081	R5203.2	35
0099254	E5471NO3	318	0105597	F302M22	345	0109557	G33863.0	468	0116098	R5203.3	35
0099261	E5471/2NO3	318	0105603	F302M24	345	0109632	G56010.0	461	0116104	R5203.4	35
0099278	E5471/4NO3	318	0105610	F302M27	345	0109649	G56010.4	461	0116111	R5203.5	35
0099285	E5471/8NO3	318	0105627	F302M3	345	0109656	G56012.4	461	0116128	R5203.6	35
0099292	E5472NO3	318	0105634	F302M30	345	0109663	G56016.5	461	0116135	R5203.7	35
0099308	E5473/4NO3	318	0105641	F302M33	345	0109670	G56020.5	461	0116142	R5203.8	35
0099315	E5473/8NO3	318	0105658	F302M36	345	0109687	G56025.0	461	0116159	R5203.9	35
0099322	E5475/8NO2	318	0105672	F302M4	345	0109694	G5606.3	461	0116166	R5204.0	35
0099339	E5475/8NO3	318	0105719	F302M5	345	0111604	L1101	348	0116173	R5204.1	35
0099353	E5477/8NO2	318	0105733	F302M6	345	0111611	L1102A	348	0116180	R5204.2	35
0099360	E5477/8NO3	318	0105740	F302M7	345	0111628	L1102B	348	0116197	R5204.3	35
0099445	E5501	317	0105757	F302M8	345	0111635	L1103	348	0116203	R5204.4	35
0099452	E5501.1/2	317	0108260	G13212.5	466	0111642	L1104	348	0116210	R5204.5	35
0099469	E5501.1/4	317	0108277	G13216.0	466	0111659	L1105F	348	0116227	R5204.6	35
0099476	E5501/2	317	0108284	G13220.0	466	0111666	L1105	348	0116234	R5204.7	35
0099483	E5501/4	317	0108291	G1328.0	466	0111673	L1106F	348	0116241	R5204.8	35
0099490	E5501/8	317	0108444	G13512.5	458	0111680	L1106	348	0116258	R5204.9	35
0099506	E5502	317	0108451	G13516.0	458	0111697	L1107F	348	0116265	R5205.0	35
0099513	E5503/4	317	0108468	G13520.0	458	0111703	L1107	348	0116272	R5205.1	35
0099520	E5503/8	317	0108475	G13525.0	458	0111710	L1108F	348	0116289	R5205.2	35
099701	C21R10COSET	207	0108482	G1356.3	458	0111727	L1108	348	0116296	R5205.3	35
099705	C114COMBCSET	208	0108499	G1358.0	458	0111734	L1109F	348	0116302	R5205.4	35
099706	C115COMBCSET	208	0108505	G13610.0	461	0111741	L1109	348	0116319	R5205.5	35
0099834	E7101	305	0108512	G13610.4	461	0111758	L11010F	348	0116326	R5205.6	35
0099841	E7101.1/2	305	0108529	G13611.5	461	0111765	L11010	348	0116333	R5205.7	35
0099858	E7101.1/4	305	0108536	G13612.4	461	0115558	R51010.0	42	0116340	R5205.8	35
0099865	E7101/2	305	0108543	G13613.4	461	0115565	R51010.2	42	0116357	R5205.9	35
0099872	E7101/4	305	0108550	G13615.0	461	0115572	R51010.4	42	0116364	R5206.0	35
0099889	E7101/8	305	0108567	G13616.5	461	0115589	R51010.5	42	0116371	R5206.1	35
0099896	E7102	305	0108574	G13619.0	461	0115596	R51011.0	42	0116388	R5206.2	36
0099902	E7103/4	305	0108581	G13620.5	461	0115602	R51011.5	42	0116395	R5206.3	36
099903	C29R40COSET	211	0108598	G13623.0	461	0115619	R51012.0	42	0116401	R5206.4	36
0099919	E7103/8	305	0108604	G13625.0	461	0115626	R51013.0	42	0116418	R5206.5	36
0099926	E7111	311	0108611	G13626.0	461	0115633	R51014.0	42	0116425	R5206.8	36
099930	C60R41COSET	211	0108628	G13628.0	461	0115640	R51014.25	42	0116432	R5206.9	36
0099933	E7111/2	311	0108635	G13630.0	461	0115657	R5103.0	41	0116449	R5207.0	36
099935	C29L10SET	204	0108642	G13631.0	461	0115664	R5103.3	41	0116456	R5207.3	36
0099940	E7111/4	311	0108659	G1364.3	461	0115671	R5103.4	41	0116463	R5207.4	36
099944	C13R10COSET	207	0108666	G1365.0	461	0115688	R5103.5	41	0116470	R5207.5	36
099955	C15L10SET	204	0108673	G1365.3	461	0115695	R5104.0	41	0116487	R5207.8	36
0099957	E7111/8	311	0108680	G1365.8	461	0115701	R5104.1	41	0116494	R5208.0	36
099960	C60M41COSET	212	0108697	G1366.0	461	0115718	R5104.2	41	0116500	R5208.5	36
099961	C26M42COSET	212	0108703	G1366.3	461	0115725	R5104.3	41	0116517	R5209.0	36
099962	C29M40COSET	212	0108710	G1367.0	461	0115732	R5104.5	41	0116524	R5209.2	36
0099964	E7113/4	311	0108727	G1367.3	461	0115749	R5104.9	41	0116531	R5209.3	36
0099971	E7113/8	311	0108734	G1368.0	461	0115756	R5105.0	41	0116548	R5209.5	36
099976	C60R18SET	198	0108741	G1368.3	461	0115763	R5105.1	41	0121863	A17029/32	173
099977	C29R10SET	197	0108758	G1369.4	461	0115770	R5105.5	41	0121870	A17033/64	172
099978	C15R10SET	197	0108765	G13716.0	467	0115787	R5106.0	41	0121887	A17035/64	172
099981	C20R18SET	198	0108772	G13720.0	467	0115794	R5106.5	41	0121894	A17037/64	172
099982	C115COMBSET	200	0108789	G13725.0	467	0115800	R5106.8	41	0121900	A17039/64	172
099983	C26R15SET	199	0108796	G13731.5	467	0115817	R5106.9	41	0121917	A17043/64	172
099985	C502ABSET	201	0108802	G13740.0	467	0115824	R5107.0	41	0121924	A17047/64	172
099987	C252ASET	201	0108819	G13750.0	467	0115831	R5107.3	41	0121931	A17049/64	172
099988	C252ABSET	201	0108826	G13763.0	467	0115848	R5107.4	41	0121948	A17053/64	173
0099988	E7121	315	0108833	G13780.0	467	0115855	R5107.5	41	0121955	A17055/64	173
099990	C114COMBSET	200	0108895	G13825.0	468	0115862	R5108.0	42	0121962	A17059/64	173
0099995	E7121.1/4	315	0108925	G13830.0	468	0115879	R5108.5	42	0121979	A17061/64	173
0100004	E7121/16	315	0108932	G13831.0	468	0115886	R5109.0	42	0121986	A17063/64	173

EDP NUMBER INDEX - 0122198 - 0136621

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0122198	B1573.0	430	0129883	B17010.98	422	0134429	R45315.8	45	0135211	R45816.5	40
0122297	C3463.0	396	0129890	B17010.99	422	0134436	R45317.8	45	0135228	R45817.0	40
0122303	C3464.0	396	0129906	B17011.0	422	0134443	R45319.8	45	0135235	R45817.5	40
0122310	C3465.0	396	0129913	B17011.01	422	0134450	R4544.4	43	0135242	B1706.49	421
0122327	C3466.0	396	0129920	B17011.02	422	0134467	R4544.8	43	0135259	B1706.5	421
0122440	E500M2.6NO3	270	0129937	B17011.03	422	0134474	R4544.9	43	0135266	B17010.5	421
0122457	E500M56NO3	271	0129944	B17011.04	422	0134481	R4545.2	43	0135273	R45817.8	40
0122464	E500M1NO3	270	0129951	B17011.05	422	0134498	R4546.2	44	0135280	R45818.0	40
0122471	E500M1.2NO3	270	0130384	B17011.49	422	0134504	R4546.4	44	0135297	R45818.5	40
0122488	E500M1.4NO3	270	0130391	B17011.5	422	0134511	R4547.7	44	0135303	B1706.51	421
0122495	E501M22NO3	278	0130407	B17011.51	422	0134528	R4547.9	44	0135310	B1706.52	421
0122501	E504M5NO3	283	0130414	B17011.52	422	0134535	R4548.2	44	0135327	R45819.0	40
0122518	E504M6NO3	283	0130865	B17011.98	422	0134542	R4548.4	44	0135334	R45819.5	40
0122525	E504M8NO3	283	0130872	B17011.99	422	0134559	R4548.9	44	0135341	R45819.8	40
0122532	E504M10NO3	283	0130889	B17012.0	422	0134566	R4549.4	44	0135358	R45820.0	40
0122556	E504M4NO3	283	0130896	B1702.0	420	0134573	R4549.7	44	0135709	EP00M3	237
0122563	E504M3NO3	283	0130902	B1702.01	420	0134580	R4549.9	44	0135716	EP00M3DIN376	237
0123003	E513M30X2.0NO3	273	0130919	B1702.02	420	0134597	R45411.4	44	0135723	EP00M3.5	237
0123010	E513M27X1.5NO3	273	0130926	B1702.03	420	0134603	R45411.6	45	0135730	EP00M4	237
0123027	E513M5X.75NO3	272	0130933	B1702.04	420	0134610	R45412.8	45	0135747	EP00M4DIN376	237
0123034	E513M6X.5NO3	272	0130940	B1702.05	420	0134627	R45413.8	45	0135754	EP00M4.5	237
0123041	E513M27X2.0NO3	273	0131367	B1702.49	420	0134634	R45414.8	45	0135761	B1706.98	421
0123058	E513M8X.5NO3	272	0131374	B1702.5	420	0134641	R45415.8	45	0135778	B1706.99	421
0123065	E513M10X.75NO3	272	0131381	B1702.51	420	0134658	R45416.5	45	0135785	B1707.0	421
0123072	E513M11X.75NO3	272	0131398	B1702.52	420	0134665	R45417.0	45	0135792	B1707.01	421
0124079	E7111.1/2	311	0131848	B1702.98	420	0134672	R45417.5	45	0135808	B1707.02	421
0126233	C34610.0	396	0131855	B1702.99	420	0134689	R45417.8	45	0135815	B1707.03	421
0126240	C34611.0	396	0131862	B1703.0	420	0134696	R45418.0	45	0135822	B1707.04	421
0126257	C34612.0	396	0131879	B1703.02	420	0134702	R45418.5	45	0135839	B1707.05	421
0126264	C34613.0	396	0131886	B1703.03	420	0134719	R45419.0	45	0135846	EP00M5	237
0126271	C34614.0	396	0131893	B1703.04	420	0134726	R45419.5	45	0135853	EP00M5DIN376	237
0126288	C34615.0	396	0131909	B1703.05	420	0134733	R45419.8	45	0135860	EP00M6	237
0126295	C34616.0	396	0132302	B1703.49	420	0134740	R45420.0	45	0135877	EP00M6DIN376	237
0126301	C34618.0	396	0132319	B1703.5	421	0134757	B1705.98	421	0135884	EP00M7	237
0126318	C34620.0	396	0132326	B1703.51	421	0134764	B1705.99	421	0135891	EP00M8	237
0126325	C3467.0	396	0132333	B1703.52	421	0134771	B1706.0	421	0135907	EP00M8DIN376	237
0126332	C3468.0	396	0132784	B1703.98	421	0134788	B1706.01	421	0135914	EP00M10	237
0126349	C3469.0	396	0132791	B1703.99	421	0134795	B1706.02	421	0135921	EP00M10DIN376	237
0127513	E650M10	325	0132807	B1704.0	421	0134801	B1706.03	421	0135938	EP00M12	237
0127520	E650M12	325	0132814	B1704.01	421	0134818	B1706.04	421	0135945	EP00M14	237
0127537	E650M14	325	0132821	B1704.02	421	0134825	B1706.05	421	0135952	EP00M16	237
0127544	E650M16	325	0132838	B1704.03	421	0134832	R4574.4	37	0135969	EP00M18	237
0127551	E650M4	325	0132845	B1704.04	421	0134849	R4574.8	38	0135976	EP00M20	237
0127568	E650M5	325	0132852	B1704.05	421	0134856	R4575.2	38	0135983	EP00M22	237
0127575	E650M6	325	0133286	B1704.49	421	0134863	R4576.2	38	0135990	EP00M24	237
0127582	E650M8	325	0133293	B1704.5	421	0134870	R4576.4	38	0136003	EP00M27	237
0127711	G5608.0	461	0133309	B1704.51	421	0134887	R4576.7	38	0136010	EP00M30	237
0127728	G5608.3	461	0133316	B1704.52	421	0134894	R4577.7	38	0136119	EP01M3	237
0127735	G56031.0	461	0133767	B1704.98	421	0134900	R4577.9	38	0136126	EP01M3DIN376	237
0127957	B170.98	420	0133774	B1704.99	421	0134917	R4578.2	38	0136133	EP01M3.5	237
0127964	B170.99	420	0133781	B1705.0	421	0134924	R4578.4	38	0136140	EP01M4	237
0127971	B1701.0	420	0133798	B1705.01	421	0134931	R4578.9	39	0136157	EP01M4DIN376	237
0127988	B1701.01	420	0133804	B1705.02	421	0134948	R4579.4	39	0136164	EP01M4.5	237
0127995	B1701.02	420	0133811	B1705.03	421	0134955	R4579.9	39	0136171	EP01M5	237
0128008	B1701.03	420	0133828	B1705.04	421	0134962	R45711.4	39	0136188	EP01M5DIN376	237
0128015	B1701.04	420	0133835	B1705.05	421	0134979	R45711.6	39	0136195	EP01M6	237
0128022	B1701.05	420	0134191	R4534.4	43	0134986	R45712.8	39	0136201	EP01M6DIN376	237
0128459	B1701.49	420	0134207	R4534.8	43	0134993	R45713.8	39	0136218	EP01M7	237
0128466	B1701.5	420	0134214	R4534.9	43	0135006	R45714.8	39	0136225	EP01M8	237
0128473	B1701.52	420	0134221	R4535.2	43	0135013	R4584.4	37	0136232	EP01M8DIN376	237
0128725	G40010.4	454	0134238	R4536.2	44	0135020	R4584.7	38	0136249	EP01M10	237
0128732	G40012.4	454	0134245	R4536.4	44	0135037	R4584.8	38	0136256	EP01M10DIN376	237
0128749	G40016.5	454	0134252	R4536.7	44	0135044	R4584.9	38	0136263	EP01M12	237
0128756	G40020.5	454	0134269	B1705.49	421	0135051	R4585.2	38	0136270	B1707.49	421
0128763	G40025.0	454	0134276	B1705.5	421	0135068	R4586.2	38	0136287	B1707.5	421
0128770	G40031.0	454	0134283	B1705.51	421	0135075	R4586.4	38	0136294	B1707.51	421
0128787	G4006.3	454	0134290	B1705.52	421	0135082	R4586.7	38	0136300	B1707.52	421
0128794	G4008.3	454	0134306	R4537.7	44	0135099	R4587.7	38	0136317	EP01M14	237
0128916	B1701.98	420	0134313	R4537.9	44	0135105	R4587.9	38	0136324	EP01M16	237
0128923	B1701.99	420	0134320	R4538.2	44	0135112	R4588.2	38	0136331	EP01M18	237
0128930	B17010.0	422	0134337	R4538.4	44	0135129	R4588.4	38	0136348	EP01M20	237
0128947	B17010.01	422	0134344	R4538.9	44	0135136	R4589.4	39	0136355	EP01M22	237
0128954	B17010.02	422	0134351	R4539.4	44	0135143	R4589.7	39	0136362	EP01M24	237
0128961	B17010.03	422	0134368	R4539.9	44	0135150	R4589.9	39	0136379	EP01M27	237
0128978	B17010.04	422	0134375	R45311.4	44	0135167	R45811.4	39	0136386	EP01M30	237
0128985	B17010.05	422	0134382	R45311.6	45	0135174	R45811.6	39	0136591	EX00M3	251
0129463	B17010.49	422	0134399	R45312.8	45	0135181	R45812.8	39	0136607	EX00M3.5	251
0129470	B17010.51	422	0134405	R45313.8	45	0135198	R45813.8	39	0136614	EX00M4	251
0129487	B17010.52	422	0134412	R45314.8	45	0135204	R45815.8	39	0136621	EX00M5	251

EDP NUMBER INDEX - 0136638 - 0149744

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0136638	EX00M6	251	0137420	EP10M12X1.0	238	0139950	E500M1.6NO2	270	0148563	A9763.7X165	67
0136645	EX00M6DIN376	251	0137437	EP10M12X1.25	238	0139967	E500M7NO2	270	0148570	A9764.0X175	68
0136652	EX00M7	251	0137444	EP10M12X1.5	238	0140314	B1006.5	446	0148587	A9764.5X185	68
0136669	EX00M8	251	0137451	EP10M14X1.0	238	0140321	B1007.5	446	0148594	A9765.0X195	68
0136676	EX00M8DIN376	251	0137468	EP10M14X1.25	238	0140338	B1008.5	447	0148600	A9765.5X205	68
0136683	EX00M10	251	0137475	EP10M14X1.5	238	0140345	B1009.5	447	0148617	A9766.0X205	68
0136690	EX00M10DIN376	251	0137482	EP10M16X1.0	238	0140352	B15713.0	430	0148624	A9766.5X215	68
0136706	EX00M12	251	0137499	EP10M16X1.5	238	0140369	B15714.0	430	0148631	A9767.0X225	68
0136713	EX00M14	251	0137505	EP10M18X1.0	238	0140376	B15715.0	430	0148648	A9767.5X225	68
0136720	EX00M16	251	0137512	EP10M18X1.5	238	0140383	B15716.0	430	0148655	A9768.0X240	68
0136737	EX00M18	251	0137529	EP10M20X1.0	238	0140390	B15717.0	430	0148662	A9768.5X240	68
0136744	EX00M20	251	0137536	EP10M20X1.5	238	0140406	B15718.0	430	0148679	A9769.0X250	68
0136751	B1707.98	421	0137543	EP10M22X1.5	238	0140413	B15719.0	430	0148686	A9769.5X250	69
0136768	B1707.99	421	0137550	EP10M24X1.5	238	0140420	B15720.0	430	0148693	A97610.0X265	69
0136775	B1708.01	421	0137567	EP10M24X2.0	238	0140819	B33413	441	0148709	A9773.0X190	67
0136782	B1708.02	421	0137574	EP10M25X1.5	238	0140826	B33414	441	0148716	A9773.5X210	67
0136799	B1708.03	421	0137581	EP10M26X1.5	238	0140833	B33415	441	0148723	A9774.0X220	68
0136805	B1708.04	421	0137598	EP10M27X1.5	238	0140840	B33416	441	0148730	A9774.5X235	68
0136812	B1708.05	421	0137604	EP10M27X2.0	238	0144152	B4003.0	415	0148747	A9775.0X245	68
0136829	EX00M22	251	0137611	EP10M28X1.5	238	0144169	B4003.2	415	0148754	A9775.5X260	68
0136836	EX00M24	251	0137628	EP10M30X1.5	238	0144176	B4003.5	415	0148761	A9776.0X260	68
0136843	EX00M27	251	0137635	EP10M30X2.0	238	0144183	B4004.0	415	0148778	A9776.5X275	68
0136850	EX00M30	251	0137642	EP11M4X.5	238	0144190	B4004.5	415	0148785	A9777.0X290	68
0136867	EX00M33	251	0137659	EP11M5X.5	238	0144206	B4005.0	415	0148792	A9777.5X290	68
0136874	EX00M36	251	0137666	EP11M6X.75	238	0144213	B4005.5	415	0148808	A9778.0X305	68
0136881	EX00M39	251	0137673	EP11M8X.75	238	0144220	B4006.0	415	0148815	A9778.5X305	68
0136898	EX00M42	251	0137680	EP11M8X1.0	238	0144237	B4006.5	415	0148822	A9779.0X320	69
0136904	EX00M48	251	0137697	EP11M10X.75	238	0144244	B4007.0	415	0148839	A9779.5X320	69
0136911	EX00M52	251	0137703	EP11M10X1.0	238	0144251	B4008.0	415	0148846	A97710.0X340	69
0136928	EX00M56	251	0137710	EP11M10X1.25	238	0144268	B4009.0	415	0148853	A9783.5X265	67
0136935	EX00M64	251	0137727	EP11M12X1.0	238	0144275	B40010.0	415	0148860	A9784.0X280	68
0136942	EX01M3	251	0137734	B1708.98	421	0144282	B40012.0	415	0148877	A9784.5X295	68
0136959	B1708.0	421	0137741	B1708.99	421	0144299	B40014.0	415	0148884	A9785.0X315	68
0136966	EX01M3.5	251	0137758	B1709.0	421	0144305	B40016.0	415	0148891	A9785.5X330	68
0136973	EX01M4	251	0137765	B1709.01	422	0144312	B40018.0	415	0148907	A9786.0X330	68
0136980	EX01M5	251	0137772	B1709.02	422	0144329	B40020.0	415	0148914	A9786.5X350	68
0136997	EX01M6	251	0137789	B1709.03	422	0144336	B41117.0	417	0148921	A9787.0X370	68
0137000	EX01M6DIN376	251	0137796	B1709.04	422	0144343	B41118.0	417	0148938	A9787.5X370	68
0137017	EX01M7	251	0137802	B1709.05	422	0144350	B41119.0	417	0148945	A9788.0X390	68
0137024	EX01M8	251	0137819	EP11M12X1.25	238	0144367	B41120.0	417	0148952	A9788.5X390	68
0137031	EX01M8DIN376	251	0137826	EP11M12X1.5	238	0144374	B41122.0	417	0148969	A9789.0X410	69
0137048	EX01M10	251	0137833	EP11M14X1.0	238	0144381	B41124.0	417	0148976	A9789.5X410	69
0137055	EX01M10DIN376	251	0137840	EP11M14X1.25	238	0144398	B41125.0	417	0148983	A97810.0X430	69
0137062	EX01M12	251	0137857	EP11M14X1.5	238	0144404	B41126.0	417	0148990	R5103.2	41
0137079	EX01M14	251	0137864	EP11M16X1.0	238	0144411	B41130.0	417	0149003	R5108.7	42
0137086	EX01M16	251	0137871	EP11M16X1.5	238	0144589	B33513BLADES	442	0149027	A10111.0	87
0137093	EX01M18	251	0137888	EP11M18X1.0	238	0144596	B33514BLADES	442	0149133	A19131M	201
0137109	EX01M20	251	0137895	EP11M18X1.5	238	0144602	B33515BLADES	442	0149270	G1426.3	462
0137116	EX01M22	251	0137901	EP11M20X1.0	238	0144619	B33516BLADES	442	0149287	G14210.4	462
0137123	EX01M24	251	0137918	EP11M20X1.5	238	0144626	B33500NUT	442	0149294	G14212.4	462
0137130	EX01M27	251	0137925	EP11M22X1.5	238	0144633	B33500NUT	442	0149300	G14216.5	462
0137147	EX01M30	251	0137932	EP11M24X1.5	238	0144640	B33500NUT	442	0149317	G14220.5	462
0137154	EX01M33	251	0137949	EP11M24X2.0	238	0144657	B3351NUT	442	0149324	G14225.0	462
0137161	EX01M36	251	0137956	EP11M25X1.5	238	0144664	B3352NUT	442	0149331	G14231.0	462
0137178	EX01M39	251	0137963	EP11M26X1.5	238	0144671	B3353NUT	442	0149348	G1546.3	459
0137185	EX01M42	251	0137970	EP11M27X1.5	238	0144688	B3354NUT	442	0149355	G1548.3	459
0137192	EX01M48	251	0137987	EP11M27X2.0	238	0144695	B3355NUT	442	0149362	G15410.4	459
0137208	EX01M52	251	0137994	EP11M28X1.5	238	0144701	B3356NUT	442	0149379	G15412.4	459
0137215	EX01M56	251	0138007	EP11M30X1.5	238	0144718	B3357NUT	442	0149386	G15416.5	459
0137222	EX01M64	251	0138014	EP11M30X2.0	238	0144725	B3358NUT	442	0149393	G15420.5	459
0137239	EP00M2	237	0138236	B1709.49	422	0144732	B3359NUT	442	0149409	G15425.0	459
0137246	EP00M2.5	237	0138243	B1709.5	422	0144749	B33510NUT	442	0149546	G3356.3	458
0137253	EP01M2	237	0138250	B1709.51	422	0144756	B33511NUT	442	0149553	G3358.0	458
0137260	B1708.49	421	0138267	B1709.52	422	0144763	B33512NUT	442	0149560	G33510.0	458
0137277	B1708.5	421	0138588	EP401/8	261	0144770	B33513NUT	442	0149577	G33512.5	458
0137284	B1708.52	421	0138595	EP401/4	261	0144787	B33514NUT	442	0149584	G33516.0	458
0137291	EP01M2.5	237	0138601	EP403/8	261	0144794	B33515NUT	442	0149591	G33520.0	458
0137307	EX00M2	251	0138618	EP401/2	261	0144800	B33516NUT	442	0149607	G33525.0	458
0137314	EX00M2.5	251	0138625	EP405/8	261	0144817	G13510.0	458	0149645	EP417/8	261
0137321	EX01M2	251	0138632	EP403/4	261	0147054	EP413/4	261	0149652	EP411	261
0137338	EX01M2.5	251	0138649	EP407/8	261	0148433	A53033.0	165	0149669	EX10M4X.50	252
0137345	EP10M4X.5	238	0138656	EP401	261	0148457	A53035.0	165	0149676	EX10M5X.50	252
0137352	EP10M5X.5	238	0138663	EP411/8	261	0148471	A53040.0	165	0149683	EX10M6X.75	252
0137369	EP10M6X.75	238	0138670	EP411/4	261	0148501	A9762.0X125	67	0149690	EX10M8X.75	252
0137376	EP10M8X.75	238	0138687	EP413/8	261	0148518	A9762.2X135	67	0149706	EX10M8X1.0	252
0137383	EP10M8X1.0	238	0138694	EP411/2	261	0148525	A9762.5X140	67	0149713	EX10M10X.75	252
0137390	EP10M10X.75	238	0138700	EP415/8	261	0148532	A9763.0X150	67	0149720	EX10M10X1.0	252
0137406	EP10M10X1.0	238	0138717	B1709.98	422	0148549	A9763.3X155	67	0149737	EX10M10X1.25	252
0137413	EP10M10X1.25	238	0138724	B1709.99	422	0148556	A9763.5X165	67	0149744	EX10M12X1.0	252

EDP NUMBER INDEX - 0149751 - 0168370

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0149751	EX10M12X1.25	252	0152119	E500M9NO2	270	0155486	E513M14X1.5NO7	272	0159446	E5503/8NO7	317
0149768	EX10M12X1.5	252	0152225	E500M33NO2	270	0155509	E513M14X1.0NO7	272	0159460	E5501/2NO7	317
0149775	EX10M14X1.0	252	0152232	E500M39NO2	270	0155516	E513M12X1.5NO7	272	0159484	E5503/4NO7	317
0149782	EX10M14X1.25	252	0152249	E500M42NO2	270	0155523	E513M12X1.0NO7	272	0159491	E7101/16NO3	305
0149799	EX10M14X1.5	252	0152256	E500M45NO2	270	0155530	E513M10X1.25NO7	272	0159507	EX217/16	247
0149805	EX10M16X1.0	252	0152263	E500M48NO2	270	0155547	E513M10X1.0NO7	272	0159514	EX211/2	247
0149812	EX10M16X1.5	252	0152447	E501M24NO2	278	0155554	E513M8X1.0NO7	272	0159552	EX215/8	247
0149829	EX10M18X1.0	252	0152454	E513M4X.5NO2	272	0155561	E513M4X.5NO7	272	0159576	EX213/4	247
0149836	EX10M18X1.5	252	0152461	E513M6X.75NO2	272	0155578	E513M32X1.5NO2	273	0159590	EX217/8	247
0149843	EX10M20X1.0	252	0152478	E513M8X.75NO2	272	0155660	E513M50X1.5NO2	273	0159644	E513M9X1.0NO1	272
0149850	EX10M20X1.5	252	0152485	E513M8X1.0NO2	272	0155677	E513M45X1.5NO2	273	0159651	E513M11X1.0NO1	272
0149867	EX10M22X1.5	252	0152492	E513M10X1.0NO2	272	0155684	E513M42X1.5NO2	273	0159828	E501M3NO1	278
0149874	EX10M24X1.5	252	0152508	E513M10X1.25NO2	272	0155691	E513M40X1.5NO2	273	0159835	E501M4NO1	278
0149881	EX10M24X2.0	252	0152515	E513M12X1.0NO2	272	0155721	E513M30X2.0NO2	273	0159859	E501M6NO1	278
0149898	EX10M25X1.5	252	0152522	E513M12X1.25NO2	272	0155738	E513M27X1.5NO2	273	0159866	E501M8NO1	278
0149904	EX10M26X1.5	252	0152539	E513M14X1.0NO2	272	0155745	E513M24X2.0NO7	273	0159873	E501M10NO1	278
0149911	EX10M27X1.5	252	0152546	E513M14X1.25NO2	272	0155752	E513M9X1.0NO2	272	0159880	E501M12NO1	278
0149928	EX10M27X2.0	252	0152553	E513M14X1.5NO2	272	0156728	E513M5X.5NO1	272	0159897	E501M14NO1	278
0149935	EX10M28X1.5	252	0152560	E513M16X1.0NO2	272	0156735	E500M2.6NO1	270	0159903	E501M16NO1	278
0149942	EX10M30X1.5	252	0152577	E513M16X1.5NO2	272	0156742	E500M2.6NO2	270	0159910	E501M20NO1	278
0149959	EX10M30X2.0	252	0152584	E513M18X1.5NO2	273	0156766	E513M4X.5NO1	272	0159927	E500M3X.6NO1	270
0149966	EX11M4X.50	252	0152591	E513M20X1.5NO2	273	0156773	E513M5X.75NO2	272	0159934	E500M3X.6NO2	270
0149973	EX11M5X.50	252	0152607	E513M22X1.5NO2	273	0156780	E513M6X.5NO1	272	0159941	E500M3X.6NO3	270
0149980	EX11M6X.75	252	0152614	E513M24X1.5NO2	273	0156797	E513M6X.5NO2	272	0159958	E500M5X.9NO1	270
0149997	EX11M8X.75	252	0152621	E513M25X1.5NO2	273	0156803	E513M6X.75NO1	272	0159965	E500M5X.9NO2	270
0150009	EX11M8X1.0	252	0152638	E513M36X2.0NO2	273	0156810	E513M14X1.0NO1	272	0159972	E500M5X.9NO3	270
0150016	EX11M10X.75	252	0152645	E513M39X3.0NO2	273	0156827	E513M14X1.25NO1	272	0159996	E500M5.5X.9NO1	270
0150023	EX11M10X1.0	252	0152980	E500M14NO1	270	0156834	E513M14X1.25NO6	272	0160008	E500M5.5X.9NO2	270
0150030	EX11M10X1.25	252	0153246	E500M10NO1	270	0156841	E513M14X1.5NO1	272	0160015	E500M5.5X.9NO3	270
0150047	EX11M12X1.0	252	0154298	E500M48NO1	271	0156858	E513M14X1.5NO6	272	0160039	E513M3X.35NO1	272
0150054	EX11M12X1.25	252	0154304	E500M45NO1	271	0156865	E513M16X1.0NO1	272	0160046	E513M3X.35NO2	272
0150061	EX11M12X1.5	252	0154311	E500M42NO1	271	0156872	E513M16X1.5NO1	272	0160053	E513M7X.75NO1	272
0150078	EX11M14X1.0	252	0154328	E500M39NO1	271	0156889	E513M16X1.5NO6	272	0160060	E513M8X.5NO1	272
0150085	EX11M14X1.25	252	0154335	E500M36NO1	271	0156896	E513M18X1.0NO1	273	0160077	E513M8X.5NO2	272
0150092	EX11M14X1.5	252	0154342	E500M33NO1	271	0156902	E513M18X1.5NO1	273	0160084	E513M10X.75NO1	272
0150108	EX11M16X1.0	252	0154359	E500M30NO1	271	0156919	E513M18X1.5NO6	273	0160091	E513M10X.75NO2	272
0150115	EX11M16X1.5	252	0154366	E500M27NO1	271	0156926	E513M18X2.0NO1	273	0160107	E513M11X.75NO1	272
0150122	EX11M18X1.0	252	0154397	E500M24NO6	271	0156933	E513M20X1.0NO1	273	0160114	E513M11X.75NO2	272
0150139	EX11M18X1.5	252	0154403	E500M24NO1	271	0156940	E513M20X1.5NO1	273	0160152	E500M11NO1	270
0150146	EX11M20X1.0	252	0154427	E500M22NO6	271	0156957	E513M20X1.5NO6	273	0160169	E500M1NO2	270
0150153	EX11M20X1.5	252	0154434	E500M22NO1	271	0156964	E513M20X2.0NO1	273	0160176	E500M1.2NO1	270
0150160	EX11M22X1.5	252	0154458	E500M20NO6	270	0156971	E513M22X1.5NO1	273	0160183	E500M1.2NO2	270
0150177	EX11M24X1.5	252	0154465	E500M20NO1	270	0156988	E513M22X2.0NO1	273	0160190	E500M1.4NO1	270
0150184	EX11M24X2.0	252	0154489	E500M18NO6	270	0156995	E513M24X1.5NO1	273	0160206	E500M1.4NO2	270
0150191	EX11M25X1.5	252	0154496	E500M18NO1	270	0157008	E513M24X2.0NO1	273	0160213	E500M4X.75NO1	270
0150207	EX11M26X1.5	252	0154519	E500M16NO6	270	0157015	E513M25X1.5NO1	273	0160220	E500M4X.75NO2	270
0150214	EX11M27X1.5	252	0154526	E500M16NO1	270	0157022	E513M25X1.5NO6	273	0160237	E500M4X.75NO3	270
0150221	EX11M27X2.0	252	0154540	E500M14NO6	270	0157039	E513M32X1.5NO1	273	0160244	E500M2X.45NO1	270
0150238	EX11M28X1.5	252	0154564	E500M12NO1	270	0157046	E513M5X.75NO1	272	0160251	E500M2X.45NO2	270
0150245	EX11M30X1.5	252	0154588	E500M11NO6	270	0157053	E513M8X.75NO1	272	0160268	E500M5X.9NO3	270
0150252	EX11M30X2.0	252	0154595	E500M11NO1	270	0157060	E513M8X1.0NO1	272	0161463	E7211/8	305
0150269	EX204-40	247	0154618	E500M10NO6	270	0157077	E513M10X1.0NO1	272	0161470	E7211/4	305
0150276	EX205-40	247	0154632	E500M9NO6	270	0157084	E513M10X1.0NO6	272	0161487	E7213/8	305
0150283	EX206-32	247	0154649	E500M9NO1	270	0157091	E513M10X1.25NO1	272	0161494	E7211/2	305
0150290	EX208-32	247	0154663	E500M8NO1	270	0157107	E513M10X1.25NO6	272	0161500	E7213/4	305
0150306	EX2010-24	247	0154687	E500M7NO1	270	0157114	E513M12X1.0NO1	272	0161517	E7211	305
0150313	EX2012-24	247	0154700	E500M6NO6	270	0157121	E513M12X1.25NO1	272	0164747	F201M3	342
0150320	EX201/4	247	0154724	E500M5NO6	270	0157138	E513M12X1.25NO6	272	0164754	F201M18	342
0150337	EX205/16	247	0154731	E500M5NO1	270	0157145	E513M12X1.5NO1	272	0164761	F201M20	342
0150344	EX203/8	247	0154755	E500M4.5NO6	270	0157152	E513M12X1.5NO6	272	0165607	E201M3	243
0150351	EX207/16	247	0154762	E500M4.5NO1	270	0157169	E5471/8NO1	318	0167861	E650M3	325
0150368	EX201/2	247	0154786	E500M4NO1	270	0157176	E5471/8NO2	318	0168059	G1424.8	462
0150375	EX205/8	247	0154809	E500M3.5NO6	270	0157190	E5471/4NO1	318	0168066	G1425.0	462
0150382	EX203/4	247	0154823	E500M3NO1	270	0157206	E5471/4NO2	318	0168073	G1426.0	462
0150399	EX207/8	247	0154847	E500M2.5NO6	270	0157220	E5473/8NO1	318	0168080	G1427.0	462
0150405	EX201	247	0154854	E500M2.5NO1	270	0157237	E5473/8NO2	318	0168097	G1427.3	462
0150412	EX214-40	247	0154885	E500M2.3NO1	270	0157251	E5471/2NO1	318	0168103	G1428.0	462
0150429	EX215-40	247	0154915	E500M2.2NO1	270	0157268	E5471/2NO2	318	0168110	G14210.0	462
0150436	EX216-32	247	0154939	E500M2NO6	270	0157282	E5475/8NO1	318	0168127	G14211.5	462
0150443	EX218-32	247	0154960	E500M1.8NO1	270	0157299	E5473/4NO1	318	0168134	G14215.0	462
0150450	EX2110-24	247	0154991	E500M1.7NO6	270	0157305	E5477/8NO1	318	0168141	G14219.0	462
0150467	EX2112-24	247	0155004	E500M1.7NO1	270	0157312	E5471NO1	318	0168158	G14223.0	462
0150474	EX211/4	247	0155028	E500M1.6NO6	270	0157329	E5471NO2	318	0168318	EX211	247
0150627	EX215/16	247	0155035	E500M1.6NO1	270	0157336	E5471.1/4NO1	318	0168325	EX308-36	247
0150658	G1428.3	462	0155431	E513M22X1.5NO7	273	0157343	E5471.1/2NO1	318	0168332	EX3010-32	247
0150719	E500M20NO2	270	0155448	E513M22X1.0NO7	273	0157367	E5472NO1	318	0168349	EX301/4	247
0150740	E513M25X1.5NO7	273	0155455	E513M20X2.0NO7	273	0157374	E5472NO2	318	0168356	EX305/16	247
0150757	E5473/4NO2	318	0155462	E513M20X1.5NO7	273	0159408	E5501/8NO7	317	0168363	EX303/8	247
0151945	EX213/8	247	0155479	E513M18X1.5NO7	273	0159422	E5501/4NO7	317	0168370	EX307/16	247

EDP NUMBER INDEX - 0168387 - 0181843

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0168387	EX301/2	247	0171325	A5207/32	49	0174067	A1259/32X250	146	0180105	B10033.0	447
0168394	EX305/8	247	0171332	A52015/64	50	0174074	A1259/32X315	146	0180112	B10037.0	447
0168400	EX303/4	247	0171349	A5201/4	50	0174081	A1255/16X200	147	0180129	B10039.0	447
0168417	EX307/8	247	0171356	A52017/64	50	0174098	A1255/16X250	147	0180808	B9011.5	429
0168424	EX301	247	0171363	A5209/32	50	0174104	A1255/16X315	147	0180815	B9011/16	429
0168431	EX318-36	247	0171370	A52019/64	50	0174111	A1255/16X400	147	0180822	B9012.0	429
0168448	EX3110-32	247	0171387	A5205/16	50	0174128	A1255/16X500	147	0180839	B9013/32	429
0168455	EX311/4	247	0171394	A52021/64	50	0174135	A12521/64X315	147	0180846	B9012.5	429
0168462	EX315/16	247	0171400	A52011/32	50	0174142	A12511/32X250	147	0180853	B9013.0	429
0168479	EX313/8	247	0171417	A52023/64	50	0174159	A12511/32X315	147	0180860	B9011/8	429
0168486	EX317/16	247	0171424	A5203/8	50	0174166	A12511/32X400	147	0180877	B9013.5	429
0168493	EX311/2	247	0171431	A52025/64	50	0174180	A12523/64X315	147	0180891	B9015/32	429
0168509	EX315/8	247	0171448	A52013/32	50	0174197	A1253/8X250	147	0180907	B9014.0	429
0168516	EX313/4	247	0171455	A52027/64	50	0174203	A1253/8X315	147	0180921	B9014.5	429
0168523	EX317/8	247	0171462	A5207/16	51	0174210	A1253/8X400	147	0180938	B9013/16	429
0168530	EX311	247	0171479	A52029/64	51	0174227	A1253/8X500	147	0180945	B9015.0	429
0168547	EX401/8	263	0171486	A52015/32	51	0174234	A12513/32X250	147	0180952	B90113/64	429
0168554	EX401/4	263	0171493	A52031/64	51	0174241	A12513/32X315	147	0180969	B9015.5	429
0168561	EX403/8	263	0171509	A5201/2	51	0174265	A1257/16X250	147	0180976	B9017/32	429
0168578	EX401/2	263	0172728	A1701.1/32	173	0174272	A1257/16X315	147	0180983	B90115/64	429
0168585	EX405/8	263	0172735	A1701.1/16	173	0174289	A1257/16X400	147	0180990	B9016.0	429
0168592	EX403/4	263	0172759	A1701.1/8	173	0174296	A12515/32X250	147	0181003	B9011/4	429
0168608	EX407/8	263	0172766	A1701.5/32	173	0174302	A12515/32X315	148	0181010	B9017.0	429
0168615	EX401	263	0172773	A1701.3/16	173	0174319	A1251/2X250	148	0181027	B9019/32	429
0168622	EX401.1/8	263	0172780	A1701.7/32	173	0174326	A1251/2X315	148	0181034	B9015/16	429
0168639	EX401.1/4	263	0172797	A1701.1/4	173	0174333	A1251/2X400	148	0181041	B9018.0	429
0168646	EX401.1/2	263	0172803	A1701.5/16	173	0174340	A1251/2X500	148	0181065	B9019.0	429
0168653	EX411/8	263	0172810	A1701.3/8	173	0179413	A1903	201	0181072	B9013/8	429
0168660	EX411/4	263	0172827	A1701.7/16	173	0179437	A19012	201	0181089	B90110.0	429
0168677	EX413/8	263	0172834	A1701.1/2	173	0179451	A19018	201	0181102	B90111.0	429
0168684	EX411/2	263	0172988	A225BS1	193	0179468	A19020	201	0181119	B9017/16	429
0168691	EX415/8	263	0172995	A225BS2	193	0179482	A190209	201	0181126	B90112.0	429
0168707	EX413/4	263	0173008	A225BS3	193	0179499	A19161-80	201	0181133	B9011/2	429
0168714	EX417/8	263	0173015	A225BS4	193	0179598	B1001/16	446	0181140	B1011/8	435
0168721	EX411	263	0173022	A225BS5	193	0179604	B1005/64	446	0181164	B1013/16	435
0168738	EX411.1/8	263	0173039	A225BS5A	193	0179611	B1003/32	446	0181188	B1011/4	435
0168745	EX411.1/4	263	0173046	A225BS6	193	0179628	B1007/64	446	0181201	B1015/16	435
0168752	EX411.1/2	263	0173053	A225BS7	193	0179635	B1001/8	446	0181225	B1013/8	435
0168769	E000M1/2	239	0173657	A1251/16X125	145	0179642	B1009/64	446	0181249	B1017/16	435
0168776	E000M2	239	0173664	A1251/16X160	145	0179659	B1005/32	446	0181263	B1011/2	435
0168783	E000M2.5	239	0173671	A1255/64X125	145	0179666	B10011/64	446	0181287	B1019/16	435
0168790	E001M1.6	239	0173688	A1255/64X160	145	0179673	B1003/16	446	0181300	B1015/8	435
0168806	E001M2	239	0173695	A1253/32X125	145	0179680	B10013/64	446	0181348	B1013/4	436
0168813	E001M2.5	239	0173701	A1253/32X160	145	0179697	B1007/32	446	0181362	B10113/16	436
0168820	E002M2	253	0173718	A1257/64X125	145	0179703	B10015/64	446	0181386	B1017/8	436
0168837	E002M2.5	253	0173725	A1257/64X160	145	0179710	B1001/4	446	0181423	B1011	436
0168844	E003M2	253	0173732	A1251/8X160	145	0179727	B10017/64	446	0181447	B1011.1/8	436
0168851	E003M2.5	253	0173749	A1251/8X200	145	0179734	B1009/32	446	0181461	B1011.1/4	436
0168974	A5101/8	56	0173756	A1251/8X250	145	0179741	B10019/64	446	0181485	B1011.3/8	436
0168981	A5109/64	56	0173763	A1251/8X315	145	0179758	B1005/16	446	0181508	B1011.1/2	436
0168998	A5105/32	56	0173770	A1259/64X160	145	0179765	B10021/64	447	0181522	B1011.3/4	436
0169001	A51011/64	56	0173787	A1259/64X200	145	0179772	B10011/32	447	0181546	B1012	436
0169018	A5103/16	56	0173794	A1255/32X160	145	0179789	B10023/64	447	0181560	B1013.0	435
0169025	A51013/64	56	0173800	A1255/32X200	146	0179796	B1003/8	447	0181577	B1013.5	435
0169032	A5107/32	56	0173817	A1255/32X250	146	0179802	B10025/64	447	0181584	B1014.0	435
0169049	A51015/64	57	0173824	A1255/32X315	146	0179819	B10013/32	447	0181591	B1014.5	435
0169056	A5101/4	57	0173831	A12511/64X160	146	0179826	B1007/16	447	0181607	B1015.0	435
0169063	A51017/64	57	0173848	A12511/64X200	146	0179840	B1001/2	447	0181614	B1015.5	435
0169070	A5109/32	57	0173855	A1253/16X160	146	0179857	B10017/32	447	0181621	B1016.0	435
0169087	A51019/64	57	0173862	A1253/16X200	146	0179864	B1009/16	447	0181638	B1016.5	435
0169094	A5105/16	57	0173879	A1253/16X250	146	0179871	B10019/32	447	0181645	B1017.0	435
0169100	A51021/64	57	0173886	A1253/16X315	146	0179888	B1005/8	447	0181669	B1018.0	435
0169117	A51011/32	57	0173893	A1253/16X400	146	0179895	B10011/16	447	0181676	B1018.5	435
0169124	A51023/64	57	0173909	A12513/64X200	146	0179901	B1003/4	447	0181683	B1019.0	435
0169131	A5103/8	57	0173916	A12513/64X250	146	0179925	B10013/16	447	0181690	B1019.5	435
0169148	A51025/64	57	0173923	A12513/64X315	146	0179949	B1007/8	447	0181706	B10110.0	435
0169155	A51013/32	57	0173930	A1257/32X200	146	0179970	B1001	447	0181713	B10110.5	435
0169162	A51027/64	57	0173947	A1257/32X250	146	0179987	B1001.5	446	0181720	B10111.0	435
0169179	A5107/16	58	0173954	A1257/32X315	146	0179994	B1001.6	446	0181744	B10112.0	435
0169186	A51029/64	58	0173961	A12515/64X200	146	0180006	B10010.5	447	0181751	B10112.5	435
0169193	A51015/32	58	0173978	A12515/64X250	146	0180013	B10011.5	447	0181768	B10113.0	435
0169209	A51031/64	58	0173985	A1251/4X200	146	0180020	B10012.5	447	0181775	B10113.5	435
0169216	A5101/2	58	0173992	A1251/4X250	146	0180037	B10013.5	447	0181782	B10114.0	435
0171264	A5201/8	49	0174005	A1251/4X315	146	0180044	B10014.5	447	0181799	B10114.5	435
0171271	A5209/64	49	0174012	A1251/4X400	146	0180051	B10021.0	447	0181805	B10115.0	435
0171288	A5205/32	49	0174029	A1251/4X500	146	0180068	B10023.0	447	0181812	B10115.5	435
0171295	A52011/64	49	0174036	A12517/64X200	146	0180075	B10027.0	447	0181829	B10116.0	436
0171301	A5203/16	49	0174043	A12517/64X250	146	0180082	B10029.0	447	0181836	B10116.5	436
0171318	A52013/64	49	0174050	A1259/32X200	146	0180099	B10031.0	447	0181843	B10117.0	436

EDP NUMBER INDEX - 0181850 - 0241035

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0181850	B10118.0	436	0206812	F3203/8X1.1/2	338	0212332	A92041/64	54	0216897	R52011.2	36
0181867	B10119.0	436	0206843	F3207/16X1.5/16	339	0212349	A92016.5	54	0216903	R52013.5	36
0181874	B10120.0	436	0206850	F3207/16X1.1/2	339	0212356	A92021/32	54	0216910	R52014.2	36
0181881	B10121.0	436	0206867	F3201/2X1.5/16	339	0212363	A92016.75	54	0216927	R52014.25	36
0181898	B10122.0	436	0206874	F3201/2X1.1/2	339	0212370	A92043/64	54	0216934	R52015.1	36
0181904	B10123.0	436	0206881	F3201/2X2	339	0212387	A92011/16	54	0217887	G2361	469
0181911	B10124.0	436	0206904	F3209/16X1.1/2	339	0212394	A92045/64	54	0218013	L11013/16	348
0181928	B10125.0	436	0206928	F3205/8X1.1/2	339	0212400	A92023/32	54	0218020	L1101INCH	348
0181935	B10126.0	436	0206935	F3205/8X2	339	0212417	A92018.5	54	0218037	L1101.5/16	348
0181942	B10127.0	436	0206959	F3203/4X1.1/2	339	0212424	A92047/64	54	0218044	L1101.1/2	348
0181959	B10128.0	436	0206966	F3203/4X2	339	0212431	A9203/4	55	0218051	L1102INCH	348
0181966	B10129.0	436	0206973	F3207/8X2	339	0212448	A92049/64	55	0218068	L1102.1/4	348
0181973	B10130.0	436	0206980	F3201X2	339	0212455	A92019.5	55	0218075	L1103INCH	348
0181980	B10131.0	436	0206997	F3201.1/8X3	339	0212462	A92025/32	55	0218082	L1104INCH	348
0181997	B10132.0	436	0207000	F3201.1/4X3	339	0212509	A9212.7	52	0234006	A245N1	120
0182017	B10134.0	436	0207307	F3304-48X13/16	338	0212523	A9217/64	52	0234013	A245N10	120
0182024	B10135.0	436	0207314	F3305-44X13/16	338	0212561	A9212.9	52	0234020	A245N11	120
0182031	B10136.0	436	0207338	F3306-40X13/16	338	0212592	A9211/8	53	0234099	A245N18	120
0182048	B10137.0	436	0207352	F3308-36X13/16	338	0212622	A9219/64	53	0234105	A245N19	120
0182055	B10138.0	436	0207376	F33010-32X13/16	338	0212677	A9215/32	53	0234112	A245N2	120
0182062	B10139.0	436	0207383	F33010-32X1	338	0214398	A1259/64X315	145	0234129	A245N20	120
0182079	B10140.0	436	0207390	F33012-28X13/16	338	0214404	A12511/64X315	146	0234136	A245N21	120
0182086	B10141.0	436	0207413	F33014X13/16	338	0214442	A12515/64X315	146	0234150	A245N23	120
0182093	B10142.0	436	0207420	F33014X1	338	0214466	A12517/64X500	146	0234167	A245N24	120
0182109	B10143.0	436	0207444	F33014X1.1/2	338	0214473	A1259/32X500	146	0234174	A245N25	120
0182116	B10144.0	436	0207451	F3305/16X1	338	0214480	A12519/64X315	145	0234181	A245N26	120
0182123	B10145.0	436	0207468	F3305/16X1.5/16	338	0214497	A12519/64X500	147	0234198	A245N27	120
0182130	B10146.0	436	0207475	F3305/16X1.1/2	338	0214503	A12521/64X500	147	0234204	A245N28	120
0182147	B10147.0	436	0207482	F3303/8X1	338	0214510	A12511/32X500	147	0234211	A245N29	120
0182154	B10148.0	436	0207499	F3303/8X1.5/16	338	0214527	A12523/64X500	147	0234235	A245N30	120
0182178	B10150.0	436	0207505	F3303/8X1.1/2	338	0214534	A12525/64X315	147	0234242	A245N31	120
0182277	B3011/16	448	0207512	F3307/16X1	339	0214541	A12525/64X500	147	0234341	A245N40	119
0182284	B3015/64	448	0207529	F3307/16X1.5/16	339	0214558	A12513/32X500	147	0234440	A245N5	120
0182291	B3013/32	448	0207536	F3307/16X1.1/2	339	0214565	A12527/64X315	147	0234570	A245N7	120
0182307	B3017/64	448	0207543	F33012X1.5/16	339	0214589	A1257/16X500	147	0234587	A245N8	120
0182314	B3011/8	448	0207550	F33012X1.1/2	339	0214596	A12529/64X315	147	0234594	A245N9	120
0182321	B3019/64	448	0207574	F3309/16X1.5/16	339	0214602	A12529/64X500	147	0234792	A24511/64	120
0182338	B3015/32	448	0207581	F3309/16X1.1/2	339	0214619	A12515/32X500	148	0234846	A24513/64	120
0182345	B30111/64	448	0207604	F3305/8X1.1/2	339	0214626	A12531/64X315	148	0234853	A2451/4	120
0182352	B3013/16	448	0207611	F3305/8X2	339	0214633	A12531/64X500	148	0234907	A24517/64	120
0182369	B3017/32	448	0207635	F3303/4X1.1/2	339	0214640	A12533/64X315	148	0234914	A2451/8	120
0182376	B3011/4	448	0207642	F3303/4X2	339	0214657	A12533/64X500	148	0235003	A24525/64	121
0182383	B3019/32	448	0207659	F3307/8X2	339	0214664	A12517/32X315	148	0235041	A24529/64	121
0182390	B3015/16	448	0207666	F3301X2	339	0214671	A12517/32X500	148	0235065	A2453/16	120
0182406	B30111/32	448	0207673	F3301.1/8X3	339	0214688	A12535/64X315	148	0235140	A2453/8	121
0182413	B3013/8	448	0207680	F3301.1/4X3	339	0214695	A12535/64X500	148	0235218	A2455/16	120
0182420	B30113/32	448	0207703	F3301.1/2X3	339	0214701	A1259/16X315	148	0235232	A2455/32	120
0182437	B3017/16	448	0209325	F3701/8X1	341	0214718	A1259/16X500	148	0235331	A2457/32	120
0182444	B3011/2	448	0209332	F37014X1.5/16	341	0214725	A12537/64X315	148	0235379	A2459/32	120
0206331	F312M8X.75	346	0209349	F3703/8X1.1/2	341	0214749	A12519/32X315	148	0235386	A2459/64	120
0206348	F312M8X1.0	346	0209356	F3701/2X2	341	0214756	A12519/32X500	148	0235447	A245F	120
0206379	F312M10X1.0	346	0209363	F3705/8X2	341	0214763	A12539/64X315	148	0238288	A1701.7/64	173
0206386	F312M10X1.25	346	0209370	F3703/4X2	341	0214770	A12539/64X500	148	0238301	A1701.9/64	173
0206393	F312M12X1.0	346	0209387	F3707/8X2.1/4	341	0214787	A1255/8X315	148	0239216	A217N1	193
0206409	F312M12X1.25	346	0209394	F3701X2.1/4	341	0214794	A1255/8X500	148	0239223	A217N2	193
0206416	F312M12X1.5	346	0209400	F3701.1/4X3	341	0214800	A12521/32X315	148	0239230	A217N3	193
0206430	F312M14X1.5	346	0209417	F3701.1/2X4	341	0214817	A12511/32X500	148	0239247	A217N4	193
0206454	F312M16X1.5	346	0210666	R5201/8	35	0214824	A12511/16X315	148	0239254	A217N5	193
0206461	F312M18X1.5	346	0210741	R5201/4	36	0214831	A12511/16X500	148	0239261	A217N6	193
0206485	F312M20X1.5	346	0210789	R5205/16	36	0214848	A12523/32X315	148	0239278	A217N7	193
0206508	F312M22X1.5	346	0210826	R5203/8	36	0214855	A12523/32X500	148	0239285	A217N8	193
0206522	F312M24X1.5	346	0210864	R5207/16	36	0214862	A1253/4X315	148	0239292	A218N1	193
0206539	F312M24X2.0	346	0210901	R5201/2	36	0214879	A1253/4X500	148	0239308	A218N2	193
0206614	F3204-40X13/16	338	0210925	R5205/8	36	0214886	A12525/32X500	148	0239315	A218N3	193
0206621	F3205-40X13/16	338	0211427	A9203/64	52	0214893	A12513/16X500	148	0239322	A218N4	193
0206645	F3206-32X13/16	338	0211434	A9201.25	52	0214909	A1257/8X500	149	0239339	A218N5	193
0206669	F3208-32X13/16	338	0211458	A9201.35	52	0214916	A12515/16X500	149	0239346	A218N6	193
0206676	F3208-32X1	338	0211489	A9201.55	52	0214923	A1251X500	149	0239353	A218N7	193
0206683	F32010-24X13/16	338	0211502	A9201.75	52	0216781	R5103.7	41	0239360	A218N8	193
0206690	F32010-24X1	338	0211571	A9202.15	52	0216798	R5104.6	41	0240410	A2431/4X6	152
0206706	F32012-24X13/16	338	0211601	A9202.35	52	0216804	R5104.7	41	0240434	A2431/8X6	152
0206720	F32014X13/16	338	0212257	A92033/64	54	0216811	R5105.6	41	0240441	A2433/16X6	152
0206737	F32014X1	338	0212264	A92035/64	54	0216828	R5105.7	41	0240458	A2433/32X6	152
0206744	F32014X1.5/16	338	0212271	A9209/16	54	0216835	R5109.4	42	0240465	A2435/32X6	152
0206751	F32014X1.1/2	338	0212288	A92037/64	54	0216842	R51010.3	42	0240816	A243N10X6	152
0206768	F3205/16X1	338	0212295	A92014.75	54	0216859	R51011.2	42	0240823	A243N11X6	152
0206782	F3205/16X1.1/2	338	0212301	A92019/32	54	0216866	R5208.7	36	0240922	A243N20X6	152
0206799	F3203/8X1	338	0212318	A92039/64	54	0216873	R5209.4	36	0240939	A243N21X6	152
0206805	F3203/8X1.5/16	338	0212325	A9205/8	54	0216880	R52010.3	36	0241035	A243N30X6	152

EDP NUMBER INDEX - 0241141 - 0351000

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0241141	A243N40X6	152	0338995	E65412-28	324	0347416	A9773/32	67	0349632	E0715/16NO2	275
0241844	A221N0	194	0339008	E6541/4	324	0347935	A9763/16	68	0349649	E0715/16NO3	275
0241851	A221N00	194	0339015	E6543/8	324	0348284	E0618-32NO1	275	0349656	E0715/16NO6	275
0241868	A221N1	194	0339022	E6545/16	324	0348291	E0616-32NO1	275	0349663	E0713/8NO1	275
0241875	A221N2	194	0339039	E6545/8	324	0348307	E0616-32NO2	275	0349670	E0713/8NO2	275
0241882	A221N3	194	0339046	E6547/16	324	0348314	E0616-32NO3	275	0349687	E0713/8NO3	275
0241899	A221N4	194	0339053	E6548-36	324	0348321	E0616-32NO6	275	0349694	E0713/8NO6	275
0241905	A221N5	194	0343111	E513M3.5X.35NO3	272	0348338	E0618-32NO2	275	0349700	E0717/16NO1	275
0241912	A221N6	194	0343128	E513M9X.75NO3	272	0348345	E0618-32NO3	275	0349717	E0717/16NO2	275
0241929	A221N7	194	0343135	E513M10X.5NO3	272	0348352	E0618-32NO6	275	0349724	E0717/16NO3	275
0241936	A221N8	194	0343142	E513M11X1.25NO3	272	0348369	E06110-24NO1	275	0349731	E0717/16NO6	275
0252345	B1221	431	0343166	E513M12X.75NO3	272	0348376	E06110-24NO2	275	0349748	E0711/2NO1	275
0252352	B1221.1/16	431	0343173	E513M13X1.5NO3	272	0348383	E06110-24NO3	275	0349755	E0711/2NO2	275
0252369	B12211/16	431	0343203	E513M16X1.25NO3	272	0348390	E06110-24NO6	275	0349762	E0711/2NO3	275
0252376	B1221/2	431	0343302	E513M36X1.5NO3	273	0348406	E06112-24NO1	275	0349779	E0711/2NO6	275
0252383	B12213/16	431	0343319	E513M42X3.0NO3	273	0348413	E06112-24NO2	275	0349786	E0719/16NO1	275
0252390	B12215/16	431	0343333	E513M48X1.5NO3	273	0348420	E06112-24NO3	275	0349793	E0719/16NO2	275
0252406	B1223/4	431	0343340	E513M48X2.0NO3	273	0348437	E06112-24NO6	275	0349809	E0719/16NO3	275
0252413	B1225/8	431	0343357	E513M48X3.0NO3	273	0348444	E0611/4NO1	275	0349816	E0719/16NO6	275
0252420	B1227/8	431	0344750	G2362	469	0348451	E0611/4NO2	275	0349823	E0715/8NO1	275
0252437	B1229/16	431	0345245	R5103.9	41	0348468	E0611/4NO3	275	0349830	E0715/8NO2	275
0273197	E65110-24	324	0345252	R5106.6	41	0348475	E0611/4NO6	275	0349847	E0715/8NO3	275
0273203	E6511/2	324	0345269	R5107.8	41	0348482	E0615/16NO1	275	0349854	E0715/8NO6	275
0273210	E65112-24	324	0345276	R5107.9	42	0348499	E0615/16NO2	275	0349861	E0713/4NO1	275
0273227	E6511/4	324	0345283	R5108.8	42	0348505	E0615/16NO3	275	0349878	E0713/4NO2	275
0273234	E6513/8	324	0345290	R5109.9	42	0348512	E0615/16NO6	275	0349885	E0713/4NO3	275
0273241	E6515/16	324	0345306	R51010.8	42	0348529	E0613/8NO1	275	0349892	E0717/8NO1	275
0273258	E6515/8	324	0346402	R5206.6	36	0348536	E0613/8NO2	275	0349908	E0717/8NO2	275
0273265	E6517/16	324	0346419	R5206.7	36	0348543	E0613/8NO3	275	0349915	E0717/8NO3	275
0273272	E6518-32	324	0346426	R5207.1	36	0348550	E0613/8NO6	275	0349922	E0717/8NO6	275
0273289	E6519/16	324	0346433	R5207.2	36	0348567	E0617/16NO1	275	0349939	E0711X12NO1	275
0279717	A9762.3X135	67	0346440	R5207.6	36	0348574	E0617/16NO2	275	0349946	E0711X12NO2	275
0279724	A9762.1X125	67	0346457	R5207.7	36	0348581	E0617/16NO3	275	0349953	E0711X12NO3	275
0279731	A9762.4X140	67	0346464	R5207.9	36	0348598	E0617/16NO6	275	0349977	E0711X14NO1	275
0279748	A9762.6X140	67	0346471	R5208.1	36	0348604	E0611/2NO1	275	0349984	E0711X14NO2	275
0279755	A9762.7X150	67	0346488	R5208.2	36	0348611	E0611/2NO2	275	0349991	E0711X14NO3	275
0279762	A9762.8X150	67	0346495	R5208.3	36	0348628	E0611/2NO3	275	0350577	A0023.0	80
0279779	A9762.9X150	67	0346501	R5208.4	36	0348635	E0611/2NO6	275	0350584	A0023.1	80
0279786	A9763.1X155	67	0346518	R5208.6	36	0348642	E0619/16NO2	275	0350591	A0021/8	80
0279793	A9763.2X155	67	0346525	R5208.8	36	0348659	E0619/16NO3	275	0350607	A0023.2	80
0279809	A9763.4X165	67	0346532	R5208.9	36	0348666	E0619/16NO6	275	0350614	A0023.3	80
0279816	A9763.6X165	67	0346549	R5209.1	36	0348673	E0615/8NO1	275	0350621	A0023.4	80
0279823	A9763.8X175	68	0346556	R5209.6	36	0348680	E0615/8NO2	275	0350638	A0023.5	81
0279830	A9763.9X175	68	0346563	R5209.7	36	0348697	E0615/8NO3	275	0350645	A0029/64	83
0279847	A9764.1X175	68	0346570	R5209.8	36	0348703	E0615/8NO6	275	0350652	A0023.6	81
0279854	A9764.2X175	68	0346587	R5209.9	36	0348710	E0613/4NO1	275	0350669	A0023.7	81
0279861	A9764.3X185	68	0346778	R52010.1	36	0348727	E0613/4NO2	275	0350676	A0023.8	81
0279878	A9764.4X185	68	0347072	A9761/8	67	0348734	E0613/4NO3	275	0350683	A0023.9	81
0279885	A9764.6X185	68	0347089	A9765/32	68	0348741	E0613/4NO6	275	0350690	A0025/32	81
0279892	A9764.7X185	68	0347096	A9761/4	68	0348758	E0617/8NO1	275	0350706	A0024.0	81
0279908	A9764.8X195	68	0347102	A9765/16	68	0348765	E0617/8NO2	275	0350713	A0024.1	81
0279915	A9764.9X195	68	0347119	A97611/32	68	0348772	E0617/8NO3	275	0350720	A0024.2	81
0279922	A9765.1X195	68	0347126	A9763/8	69	0348789	E0617/8NO6	275	0350737	A0024.3	81
0279939	A9765.2X195	68	0347133	A97610.5	69	0348796	E0617/8NO6	275	0350737	A0024.3	81
0279946	A9765.3X195	68	0347140	A97611.0	69	0348796	E0611NO1	275	0350744	A00211/64	81
0279953	A9765.4X205	68	0347157	A97611.5	69	0348802	E0611NO2	275	0350751	A0024.4	81
0279960	A9765.6X205	68	0347164	A97612.0	69	0348802	E0611NO2	275	0350768	A0024.5	81
0279977	A9765.7X205	68	0347171	A97612.5	69	0348819	E0611NO3	275	0350775	A0024.6	81
0279984	A9765.8X205	68	0347188	A9761/2	69	0349427	E0716-40NO1	275	0350782	A0024.7	81
0279991	A9765.9X205	68	0347195	A97613.0	69	0349434	E0716-40NO2	275	0350799	A0023/16	81
0280003	A9766.1X215	68	0347201	A97614.0	69	0349441	E0716-40NO3	275	0350805	A0024.8	81
0280010	A9766.2X215	68	0347218	A9771/8	67	0349458	E0716-40NO6	275	0350812	A0024.9	81
0280027	A9766.3X215	68	0347225	A9773/16	68	0349465	E0718-36NO1	275	0350829	A0025.0	81
0280034	A9766.4X215	68	0347232	A9771/4	68	0349472	E0718-36NO2	275	0350836	A0025.1	81
0280041	A9766.6X215	68	0347249	A97711/32	68	0349489	E0718-36NO3	275	0350843	A00213/64	81
0280058	A9766.7X215	68	0347256	A97710.5	69	0349496	E0718-36NO6	275	0350850	A0025.2	81
0280065	A9766.8X225	68	0347263	A97711.0	69	0349502	E07110-32NO1	275	0350867	A0025.3	81
0280072	A9766.9X225	68	0347270	A97711.5	69	0349519	E07110-32NO2	275	0350874	A0025.4	81
0286012	A92111/64	53	0347287	A97712.0	69	0349526	E07110-32NO3	275	0350881	A0025.5	81
0297247	E6531	326	0347294	A97712.5	69	0349533	E07110-32NO6	275	0350898	A0027/32	81
0297261	E6531/2	326	0347300	A97713.0	69	0349540	E07112-28NO1	275	0350911	A0025.7	81
0297278	E6531/4	326	0347317	A97714.0	69	0349557	E07112-28NO2	275	0350928	A0025.8	82
0297285	E6531/8	326	0347324	A9783.0	67	0349564	E07112-28NO3	275	0350935	A0025.9	82
0297292	E6533/4	326	0347331	A9781/4	68	0349571	E07112-28NO6	275	0350959	A0026.0	82
0297308	E6533/8	326	0347362	A9761.5	67	0349588	E0711/4NO1	275	0350966	A0026.1	82
0308523	A28718	205	0347379	A9767/16	69	0349595	E0711/4NO2	275	0350973	A0026.2	82
0335635	A9213/16	53	0347386	A9771.5	67	0349601	E0711/4NO3	275	0350980	A0026.3	82
0338971	E65410-32	324	0347393	A9771/16	67	0349618	E0711/4NO6	275	0350997	A0021/4	82
0338988	E6541/2	324	0347409	A9772.0	67	0349625	E0715/16NO1	275	0351000	A0026.4	82

EDP NUMBER INDEX - 0351017 - 0388204

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0351017	A0026.5	82	0351833	E0619/16NO1	275	0354643	C24716.0	404	0376874	A0021.9	80
0351024	A0026.6	82	0351932	E0713/4NO6	275	0354650	C24718.0	404	0376881	A0021/16	79
0351031	A0026.7	82	0353165	C1101.0	384	0354667	C2472.0	403	0376898	A0022.2	80
0351055	A0026.8	82	0353172	C1101.5	384	0354674	C2472.5	403	0376904	A0022.3	80
0351062	A0026.9	82	0353189	C1101.8	384	0354681	C24720.0	404	0376911	A0022.4	80
0351079	A0027.0	82	0353196	C11010.0	385	0354698	C24722.0	404	0376928	A0023/64	79
0351086	A0027.1	82	0353202	C11010.5	385	0354704	C24725.0	404	0376935	A0025/64	80
0351093	A0029/32	82	0353219	C11011.0	385	0354711	C24728.0	404	0380802	R5101/8	41
0351109	A0027.2	82	0353226	C11012.0	385	0354728	C2473.0	403	0380949	R5103/16	41
0351116	A0027.3	82	0353233	C11013.0	385	0354735	C2473.5	403	0380963	R5105/16	42
0351123	A0027.4	82	0353240	C11014.0	385	0354742	C24730.0	404	0380987	R5107/16	42
0351130	A0027.5	82	0353257	C11015.0	385	0354759	C24732.0	404	0381021	R5101/2	42
0351147	A00219/64	82	0353264	C11016.0	385	0354766	C2474.0	403	0381038	R5101/4	41
0351154	A0027.6	82	0353271	C11017.0	385	0354773	C2474.5	403	0381045	R5103/8	42
0351161	A0027.7	82	0353288	C11018.0	385	0354780	C2475.0	403	0384497	A00214.0	84
0351178	A0027.8	82	0353295	C11019.0	385	0354797	C2475.5	403	0384824	E620M3	320
0351185	A0027.9	82	0353301	C1102.0	384	0354803	C2476.0	403	0384831	E620M4	320
0351192	A0025/16	82	0353318	C1102.5	384	0354810	C2476.5	403	0384848	E620M5	320
0351208	A0028.0	82	0353325	C1102.8	384	0354827	C2477.0	403	0384855	E620M6	320
0351215	A0028.1	82	0353332	C11020.0	385	0354834	C2477.5	403	0384862	E620M8	320
0351222	A0028.2	82	0353349	C11022.0	385	0354841	C2478.0	403	0384879	E620M10	320
0351239	A0028.3	82	0353356	C11025.0	385	0354858	C2478.5	403	0384886	E620M12	320
0351246	A00221/64	82	0353363	C11028.0	385	0354865	C2479.0	403	0384893	E620M14	320
0351253	A0028.4	82	0353370	C1103.0	384	0354872	C2479.5	403	0384909	E620M16	320
0351260	A0028.5	82	0353387	C1103.5	384	0354889	C27310.0	405	0384916	E621M3	320
0351277	A0028.6	82	0353394	C1103.8	384	0354896	C27311.0	405	0384923	E621M4	320
0351291	A00211/32	82	0353400	C11030.0	385	0354902	C27312.0	405	0384930	E621M5	320
0351307	A0028.8	83	0353417	C11032.0	385	0354919	C27313.0	405	0384947	E621M6	320
0351314	A0028.9	83	0353424	C1104.0	384	0354926	C27314.0	405	0384954	E621M8	320
0351321	A0029.0	83	0353431	C1104.5	384	0354933	C27315.0	405	0384961	E621M10	320
0351338	A0029.1	83	0353448	C1104.8	384	0354940	C27316.0	405	0384978	E621M12	320
0351352	A0029.2	83	0353455	C1105.0	384	0354957	C27318.0	405	0384985	E621M14	320
0351369	A0029.3	83	0353462	C1105.5	384	0354964	C2732.0	405	0384992	E621M16	320
0351376	A0029.4	83	0353479	C1105.75	384	0354971	C2732.5	405	0385180	A00213.1	84
0351383	A0029.5	83	0353486	C1106.0	384	0354988	C27320.0	405	0385197	A00213.3	84
0351390	A0023/8	83	0353493	C1106.5	384	0354995	C27322.0	405	0385203	A00213.6	84
0351406	A0029.6	83	0353509	C1107.0	384	0355008	C27325.0	405	0385210	A00213.7	84
0351413	A0029.7	83	0353516	C1107.5	384	0355015	C27328.0	406	0385227	A00213.8	84
0351420	A0029.8	83	0353523	C1108.0	384	0355022	C2733.0	405	0385234	A00214.25	84
0351437	A0029.9	83	0353530	C1108.5	384	0355039	C2733.5	405	0385241	A00214.5	84
0351444	A00225/64	83	0353547	C1109.0	384	0355046	C27330.0	406	0385258	A00214.75	84
0351451	A00210.0	83	0353554	C1109.5	385	0355053	C27332.0	406	0385265	A00215.0	84
0351468	A00210.1	83	0353561	C12310.0	390	0355060	C2734.0	405	0385272	A00215.25	84
0351475	A00210.2	83	0353578	C12311.0	390	0355077	C2734.5	405	0385289	A00215.5	84
0351482	A00210.3	83	0353585	C12312.0	390	0355084	C2735.0	405	0385296	A00215.75	84
0351499	A00213/32	83	0353592	C12313.0	390	0355091	C2735.5	405	0385302	A00216.0	84
0351505	A00210.4	83	0353608	C12314.0	390	0355107	C2736.0	405	0385319	A00217/32	84
0351512	A00210.5	83	0353615	C12315.0	391	0355114	C2737.0	405	0385326	A00219/32	84
0351529	A00210.6	83	0353622	C12316.0	391	0355121	C2738.0	405	0385333	A00233/64	84
0351536	A00210.7	83	0353639	C12318.0	391	0355138	C2739.0	405	0385340	A00235/64	84
0351543	A00227/64	83	0353646	C1232.0	390	0372555	G17110.4	464	0385357	A00237/64	84
0351550	A00210.8	83	0353653	C1232.5	390	0372562	G17112.4	464	0385364	A00239/64	84
0351567	A00210.9	83	0353660	C12320.0	391	0372579	G17116.5	464	0385371	A0025/8	84
0351574	A00211.0	83	0353677	C12322.0	391	0372586	G17120.5	464	0385388	A0029/16	84
0351581	A00211.1	83	0353691	C12325.0	391	0372593	G17125.0	464	0385418	A095201	203
0351598	A0027/16	83	0353714	C1233.0	390	0372609	G1716.3	464	0385425	A095202	203
0351604	A00211.2	83	0353721	C1233.5	390	0372616	G1718.3	464	0385432	A095203	203
0351611	A00211.3	83	0353738	C12330.0	391	0375907	A2441/4X6	152	0385449	A095204	203
0351628	A00211.4	83	0353745	C12332.0	391	0375914	A2441/8X6	152	0385494	A00213.9	84
0351635	A00211.5	83	0353752	C12336.0	391	0375921	A2443/16X6	152	0385524	A00213.2	84
0351642	A00229/64	83	0353769	C1234.0	390	0375938	A2445/32X6	152	0385531	A00213.4	84
0351659	A00211.6	83	0353776	C1234.5	390	0376041	A0022.0	80	0385548	A00213.5	84
0351666	A00211.7	83	0353783	C12340.0	391	0376058	A0022.1	80	0385562	A095209	203
0351673	A00211.8	83	0353790	C1235.0	390	0376065	A0022.5	80	0385579	A00213.25	84
0351680	A00211.9	83	0353806	C1235.5	390	0376072	A0022.6	80	0385586	A00213.75	84
0351697	A00215/32	83	0353813	C1236.0	390	0376089	A0022.7	80	0388112	E0611.1/8NO1	275
0351703	A00212.0	83	0353820	C1236.5	390	0376096	A0022.8	80	0388112	E0611.1/8NO1	275
0351710	A00212.1	83	0353837	C1237.0	390	0376102	A0022.9	80	0388129	E0611.1/8NO2	275
0351727	A00212.2	83	0353844	C1237.5	390	0376119	A0023/32	80	0388136	E0611.1/8NO3	275
0351734	A00212.3	83	0353851	C1238.0	390	0376126	A0027/64	80	0388143	E0611.1/4NO1	275
0351741	A00231/64	83	0353868	C1238.5	390	0376782	A0021.0	79	0388143	E0611.1/4NO1	275
0351758	A00212.4	83	0353875	C1239.0	390	0376799	A0021.1	79	0388150	E0611.1/4NO2	275
0351765	A00212.5	84	0353882	C1239.5	390	0376805	A0021.2	79	0388167	E0611.1/4NO3	275
0351772	A00212.6	84	0354582	C24710.0	403	0376812	A0021.3	79	0388174	E0611.3/8NO1	275
0351789	A0021/2	84	0354599	C24711.0	403	0376829	A0021.4	79	0388174	E0611.3/8NO1	275
0351796	A00212.7	84	0354605	C24712.0	403	0376836	A0021.5	79	0388181	E0611.3/8NO2	275
0351802	A00212.8	84	0354612	C24713.0	403	0376843	A0021.6	79	0388198	E0611.3/8NO3	275
0351819	A00212.9	84	0354629	C24714.0	403	0376850	A0021.7	80	0388204	E0611.1/2NO1	275
0351826	A00213.0	84	0354636	C24715.0	403	0376867	A0021.8	80	0388204	E0611.1/2NO1	275

EDP NUMBER INDEX - 0388211 - 0567616

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0388211	E0611.1/2NO2	275	0418208	A34521.0	167	0419830	A34541.0	167	0421796	B48112.00	419
0388228	E0611.1/2NO3	275	0418215	A34521/32	166	0419847	A34542.0	167	0421802	B48112.01	419
0388235	E0711.1/8NO1	275	0418222	A34522.0	167	0419854	A34545.0	167	0421819	B48112.02	419
0388235	E0711.1/8NO1	275	0418239	A34524.0	167	0419861	A34548.0	167	0421826	B48112.03	419
0388242	E0711.1/8NO2	275	0418246	A34525.0	167	0419878	A34550.0	167	0421833	B48112.04	419
0388259	E0711.1/8NO3	275	0418253	A34526.0	167	0419885	A95210.0	168	0421840	B48112.05	419
0388266	E0711.1/4NO1	275	0418260	A34527.0	167	0419892	A95210.5	168	0421857	B4812.00	418
0388266	E0711.1/4NO1	275	0418277	A34528.0	167	0419908	A95211.0	168	0421864	B4812.01	418
0388273	E0711.1/4NO2	275	0418284	A34529/64	166	0419915	A95211.5	168	0421871	B4812.02	418
0388280	E0711.1/4NO3	275	0418291	A3453/4	167	0419922	A95212.0	168	0421888	B4812.03	418
0388297	E0711.3/8NO1	275	0418307	A3453/8	166	0419939	A95212.5	168	0421895	B4812.48	418
0388297	E0711.3/8NO1	275	0418314	A34530.0	167	0419946	A95213.5	168	0421901	B4812.49	418
0388303	E0711.3/8NO2	275	0418321	A34537/64	166	0419953	A95214.0	168	0421918	B4812.50	418
0388310	E0711.3/8NO3	275	0418338	A34539/64	166	0419960	A95214.5	168	0421925	B4812.51	418
0388327	E0711.1/2NO1	275	0418345	A34541/64	166	0419977	A95215.0	168	0421932	B4812.52	418
0388327	E0711.1/2NO1	275	0418352	A3455/8	166	0419984	A95215.5	168	0421949	B4812.53	418
0388334	E0711.1/2NO2	275	0418369	A3457/16	166	0419991	A95216.5	168	0421956	B4812.97	418
0388341	E0711.1/2NO3	275	0418376	A3457/8	167	0420003	A95217.0	168	0421963	B4812.98	418
0388907	E6516-32	324	0418383	A3458.0	166	0420010	A95217.5	169	0421970	B4812.99	418
0390795	A55310.0	59	0418390	A3458.5	166	0420027	A95218.0	169	0421987	B4813.00	418
0390801	A55310.2	59	0418406	A3459.0	166	0420034	A95218.5	169	0421994	B4813.01	418
0390818	A55310.3	59	0418413	A3459/16	166	0420041	A95219.0	169	0422007	B4813.02	418
0390825	A55310.5	59	0418420	A95110.0	168	0420058	A95219.5	169	0422014	B4813.03	418
0390849	A55311.0	59	0418437	A95111.0	168	0420065	A95220.0	169	0422021	B4813.97	418
0390856	A55311.3	59	0418444	A95112.0	168	0420072	A95221.0	169	0422038	B4813.98	418
0390863	A55311.5	59	0418451	A95112.5	168	0420089	A95222.0	169	0422045	B4813.99	419
0390870	A55312.0	59	0418468	A95113.0	168	0420096	A95223.0	169	0422052	B4814.00	419
0390887	A55312.5	59	0418475	A95113.5	168	0420102	A95224.0	169	0422069	B4814.01	419
0390894	A55313.0	59	0418482	A95114.0	168	0420119	A95225.0	169	0422076	B4814.02	419
0390924	A55313.5	59	0418499	A95114.5	168	0420126	A95226.0	169	0422083	B4814.03	419
0390948	A55314.0	59	0418505	A95115.0	168	0420133	A95227.0	169	0422090	B4814.97	419
0390955	A55314.25	59	0418512	A95115.5	168	0420140	A95228.0	169	0422106	B4814.98	419
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0390986	A55315.0	59	0418536	A95116.5	168	0420164	A95230.0	169	0422120	B4815.00	419
0391006	A55315.25	59	0418543	A95117.0	168	0420171	A34510.5	166	0422137	B4815.01	419
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0391037	A55316.0	60	0418567	A95118.0	169	0420195	A95216.0	168	0422151	B4815.03	419
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0391112	A55318.0	60	0418611	A95121.0	169	0421116	B44114.0	414	0422205	B4816.01	419
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0391198	A55320.0	60	0418642	A95124.0	169	0421147	B44117.0	414	0422236	B4817.97	419
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0391242	A5535.5	59	0418673	A95127.0	169	0421178	B44120.0	414	0422267	B4818.00	419
0391280	A5536.0	59	0418680	A95128.0	169	0421185	B44210.0	416	0422274	B4818.01	419
0391297	A5536.3	59	0418697	A95129.0	169	0421192	B44212.0	416	0422281	B4818.02	419
0391303	A5536.5	59	0418703	A95130.0	169	0421208	B44214.0	416	0422298	B4818.03	419
0391327	A5536.8	59	0419540	A3451.1/2	167	0421215	B44215.0	416	0422304	B4818.04	419
0391334	A5536.9	59	0419557	A3451.3/4	167	0421222	B44216.0	416	0422311	B4819.97	419
0391341	A5537.0	59	0419564	A34511.5	166	0421239	B44217.0	416	0422328	B4819.98	419
0391365	A5537.4	59	0419571	A34512.5	166	0421246	B44218.0	416	0422335	B4819.99	419
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0391402	A5538.0	59	0419601	A34515.5	166	0421567	B4810.98	418	0423585	A95231.0	169
0391419	A5538.5	59	0419618	A34516.5	166	0421574	B4810.99	418	0423592	A95232.0	169
0391426	A5538.7	59	0419625	A34517.5	166	0421581	B4811.00	418	0423608	A95233.0	169
0391433	A5539.0	59	0419632	A34518.5	167	0421598	B4811.01	418	0423615	A95238.0	169
0391457	A5539.5	59	0419649	A34519.5	167	0421604	B4811.02	418	0423622	A95240.0	169
0392331	A095206	203	0419656	A34520.5	167	0421611	B4811.03	418	0423639	A9528.0	168
0418031	A3451	167	0419663	A34521.5	167	0421628	B4811.48	418	0423646	A9528.5	168
0418048	A3451.1/4	167	0419670	A34522.5	167	0421635	B4811.49	418	0423653	A9529.0	168
0418055	A3451/2	166	0419687	A34523.0	167	0421642	B4811.50	418	0423660	A95234.0	169
0418062	A34510.0	166	0419694	A34523.5	167	0421659	B4811.51	418	0423677	A95235.0	169
0418079	A34511.0	166	0419700	A34524.5	167	0421666	B4811.52	418	0423912	A217SET	193
0418086	A34511/16	166	0419717	A34525.5	167	0421673	B4811.53	418	0423929	A218SET	193
0418093	A34512.0	166	0419724	A34526.5	167	0421680	B4811.98	418	0423936	A221SET	194
0418109	A34513.0	166	0419731	A34529.0	167	0421697	B4811.99	418	0426296	B1223/8	431
0418116	A34513/32	166	0419748	A34531.0	167	0421703	B48110.00	419	0426302	B44113.0	414
0418123	A34514.0	166	0419755	A34532.0	167	0421710	B48110.01	419	0426319	B44219.0	416
0418130	A34515.0	166	0419762	A34534.0	167	0421727	B48110.02	419	0441336	A92113/64	53
0418147	A34516.0	166	0419779	A34535.0	167	0421734	B48110.03	419	0566961	A720.16	126
0418154	A34517.0	166	0419786	A34536.0	167	0421741	B48110.04	419	0566978	A720.27	126
0418161	A34517/32	166	0419793	A34537.0	167	0421758	B48110.05	419	0567586	E000M3	239
0418178	A34518.0	167	0419809	A34538.0	167	0421765	B48111.97	419	0567593	E000M3.5	239
0418185	A34519.0	167	0419816	A34539.0	167	0421772	B48111.98	419	0567609	E000M4	239
0418192	A34520.0	167	0419823	A34540.0	167	0421789	B48111.99	419	0567616	E000M5	239

EDP NUMBER INDEX - 0567623 - 0578742

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0567623	E000M6	239	0568859	E013M10X1.0	253	0571217	A012F	76	0572009	A01221/64	76
0567630	E000M8	239	0568866	E013M10X1.25	253	0571224	A012G	76	0572016	A01223/64	76
0567647	E000M10	239	0568873	E013M12X1.0	253	0571231	A012H	76	0572023	A01225/64	76
0567654	E000M12	239	0568880	E013M12X1.25	253	0571248	A012I	76	0572030	A01227/64	76
0567661	E000M14	239	0568897	E013M12X1.5	253	0571255	A012J	76	0572047	A01229/64	76
0567678	E000M16	239	0568903	E013M14X1.5	253	0571262	A012K	76	0572054	A0123/16	75
0567685	E000M18	240	0568910	E013M16X1.0	253	0571279	A012L	76	0572061	A0123/32	77
0567692	E000M20	240	0568927	E013M16X1.5	253	0571286	A012M	76	0572078	A0123/8	76
0567708	E000M22	240	0568934	E013M18X1.5	253	0571293	A012N	76	0572085	A01231/64	77
0567715	E000M24	240	0568941	E013M20X1.5	253	0571309	A012N1	76	0572092	A01233/64	77
0567722	E001M3	239	0568958	E013M22X1.5	253	0571316	A012N10	75	0572108	A01235/64	77
0567739	E001M3.5	239	0569108	E0214-40	234	0571323	A012N11	75	0572115	A01237/64	77
0567746	E001M4	239	0569115	E0216-32	234	0571330	A012N12	75	0572122	A01239/64	77
0567753	E001M5	239	0569122	E0218-32	234	0571347	A012N13	75	0572139	A0125/16	76
0567760	E001M6	239	0569139	E02110-24	234	0571354	A012N14	75	0572146	A0125/32	75
0567777	E001M8	239	0569146	E02112-24	234	0571361	A012N15	75	0572153	A0125/8	77
0567784	E001M10	239	0569153	E0211/4	234	0571378	A012N16	75	0572160	A0127/16	76
0567791	E001M12	239	0569160	E0215/16	234	0571385	A012N17	75	0572177	A0127/32	76
0567807	E001M14	239	0569177	E0213/8	234	0571392	A012N18	75	0572184	A0127/64	76
0567814	E001M16	239	0569184	E0217/16	234	0571408	A012N19	75	0572191	A0129/16	77
0567821	E001M18	240	0569191	E0211/2	234	0571415	A012N2	76	0572207	A0129/32	76
0567845	E001M22	240	0569207	E0215/8	234	0571422	A012N20	75	0572214	A0129/64	75
0567852	E001M24	240	0569214	E0213/4	234	0571439	A012N21	75	0573433	C11011.5	385
0567869	E002M3	253	0569221	E0217/8	234	0571446	A012N22	75	0573440	C11011.7	385
0567883	E002M4	253	0569238	E0211	234	0571453	A012N23	75	0573457	C11012.5	385
0567890	E002M5	253	0569382	E0234-40	248	0571460	A012N24	75	0573464	C11013.7	385
0567906	E002M6	253	0569399	E0236-32	248	0571477	A012N25	75	0573471	C11015.7	385
0567913	E002M8	253	0569405	E0238-32	248	0571484	A012N26	75	0573488	C11024.0	385
0567920	E002M10	253	0569412	E02310-24	248	0571491	A012N27	75	0573495	C1107.75	384
0567937	E002M12	253	0569429	E02312-24	248	0571507	A012N28	75	0573501	C1109.7	385
0567944	E002M14	253	0569436	E0231/4	248	0571514	A012N29	75	0573952	A0121/64	74
0567951	E002M16	253	0569443	E0235/16	248	0571521	A012N3	76	0573969	A0121/32	74
0567968	E002M18	253	0569450	E0233/8	248	0571538	A012N30	75	0573976	A0123/64	74
0567975	E002M20	253	0569467	E0237/16	248	0571545	A012N31	75	0573983	A012N53	74
0567982	E002M22	253	0569474	E0231/2	248	0571552	A012N32	75	0573990	A012N54	74
0567999	E002M24	253	0569481	E0235/8	248	0571569	A012N33	75	0574003	A012N55	74
0568002	E003M3	253	0569498	E0233/4	248	0571576	A012N34	75	0574010	A012N56	74
0568026	E003M4	253	0569504	E0237/8	248	0571583	A012N35	75	0574027	A012N57	74
0568033	E003M5	253	0569511	E0231	248	0571590	A012N36	75	0574034	A012N58	74
0568040	E003M6	253	0569641	E0318-36	234	0571606	A012N37	75	0574041	A012N59	74
0568057	E003M8	253	0569658	E03110-32	234	0571613	A012N38	75	0574058	A012N60	74
0568064	E003M10	253	0569665	E0311/4	234	0571620	A012N39	75	0574065	A012N61	74
0568071	E003M12	253	0569672	E0315/16	234	0571637	A012N4	76	0574072	A012N62	74
0568088	E003M14	253	0569689	E0313/8	234	0571644	A012N40	75	0574089	A012N63	74
0568095	E003M16	253	0569696	E0317/16	234	0571651	A012N41	75	0574096	A012N64	74
0568101	E003M18	253	0569702	E0311/2	234	0571668	A012N42	75	0574102	A012N65	74
0568118	E003M20	253	0569719	E0319/16	234	0571675	A012N43	75	0574119	A012N66	74
0568125	E003M22	253	0569726	E0315/8	234	0571682	A012N44	75	0574126	A012N67	74
0568132	E003M24	253	0569733	E0313/4	234	0571699	A012N45	75	0574133	A012N68	74
0568385	E011M4X.5	239	0569740	E0317/8	234	0571705	A012N46	75	0574140	A012N69	74
0568392	E011M5X.5	239	0569757	E0311	234	0571712	A012N5	76	0574157	A012N70	74
0568408	E011M6X.5	239	0569818	E0411/8	262	0571729	A012N6	76	0574164	A012N71	74
0568415	E011M6X.75	239	0569825	E0411/4	262	0571736	A012N7	76	0574171	A012N72	74
0568422	E011M8X.75	239	0569832	E0413/8	262	0571743	A012N8	75	0574188	A012N73	74
0568439	E011M8X1.0	239	0569849	E0411/2	262	0571750	A012N9	75	0574195	A012N74	74
0568446	E011M10X1.0	239	0569856	E0413/4	262	0571767	A012O	76	0574201	A012N75	74
0568453	E011M10X1.25	239	0569917	E0431/8	264	0571774	A012P	76	0574218	A012N76	74
0568460	E011M12X1.0	239	0569924	E0431/4	264	0571781	A012Q	76	0574225	A012N77	74
0568477	E011M12X1.25	239	0569931	E0433/8	264	0571798	A012R	76	0574232	A012N78	74
0568484	E011M12X1.5	239	0569948	E0431/2	264	0571804	A012S	76	0574249	A012N79	74
0568491	E011M14X1.0	239	0569955	E0433/4	264	0571811	A012T	76	0574256	A012N80	74
0568507	E011M14X1.25	239	0570081	E0338-36	248	0571828	A012U	76	0574317	A09718	198
0568514	E011M14X1.5	239	0570098	E03310-32	248	0571835	A012V	76	0574324	A09712	198
0568521	E011M16X1.0	239	0570104	E0331/4	248	0571842	A012W	76	0574331	A09714	198
0568538	E011M16X1.5	239	0570111	E0335/16	248	0571859	A012X	76	0574348	A09720	198
0568545	E011M18X1.0	240	0570128	E0333/8	248	0571866	A012Y	76	0574355	A09760	198
0568552	E011M18X1.5	240	0570135	E0337/16	248	0571873	A012Z	76	0574362	A09730	198
0568569	E011M20X1.0	240	0570142	E0331/2	248	0571880	A0121/2	77	0578636	A0121/16	75
0568576	E011M20X1.5	240	0570159	E0339/16	248	0571897	A0121/8	75	0578643	A0125/64	75
0568583	E011M20X2.0	240	0570166	E0335/8	248	0571903	A01211/32	76	0578650	A012N47	75
0568590	E011M22X1.5	240	0570173	E0333/4	248	0571910	A01211/64	76	0578667	A012N48	75
0568606	E011M24X1.5	240	0570180	E0337/8	248	0571927	A01213/32	76	0578674	A012N49	75
0568613	E011M24X2.0	240	0570197	E0331	248	0571934	A01213/64	75	0578681	A012N50	75
0568798	E013M4X.5	253	0571125	A0121/4	76	0571941	A01215/32	76	0578698	A012N51	75
0568804	E013M5X.5	253	0571163	A012A	76	0571958	A01215/64	76	0578704	A012N52	75
0568811	E013M6X.5	253	0571170	A012B	76	0571965	A01217/32	77	0578711	A01211/16	77
0568828	E013M6X.75	253	0571187	A012C	76	0571972	A01217/64	76	0578728	A01221/32	77
0568835	E013M8X.75	253	0571194	A012D	76	0571989	A01219/32	77	0578735	A01223/32	77
0568842	E013M8X1.0	253	0571200	A012E	76	0571996	A01219/64	76	0578742	A01245/64	77

EDP NUMBER INDEX - 0578759 - 0600214

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0578759	A0123/4	77	0581322	E0261/4H11	231	0582282	E0367/8	232	0589205	A0224.0	117
0578766	A01247/64	77	0581339	E0261/43FL	231	0582299	E0361-12	232	0589212	A0224.1	117
0580301	E005M4	236	0581346	E0265/16	231	0582305	E0361-14	232	0589229	A0224.2	117
0580318	E005M43FL	236	0581353	E0265/16H11	231	0582312	E03710-32	246	0589236	A0224.3	117
0580325	E005M5	236	0581360	E0265/163FL	231	0582329	E0371/4	246	0589243	A0224.4	117
0580332	E005M53FL	236	0581377	E0263/8	231	0582336	E0375/16	246	0589250	A0224.5	117
0580349	E005M6	236	0581384	E0263/8H11	231	0582343	E0373/8	246	0589267	A0224.6	117
0580356	E005M63FL	236	0581391	E0263/83FL	231	0582350	E0377/16	246	0589274	A0224.7	117
0580363	E005M8	236	0581407	E0267/16	231	0582367	E0371/2	246	0589281	A0224.8	117
0580370	E005M83FL	236	0581414	E0261/2	232	0582374	E0379/16	246	0589298	A0224.9	117
0580387	E005M10	236	0581421	E0261/2H11	232	0582381	E0375/8	246	0589304	A0225.0	117
0580394	E005M103FL	236	0581438	E0261/23FL	232	0582398	E0373/4	246	0589311	A0225.1	117
0580400	E005M12	236	0581445	E0269/16	232	0582404	E0377/8	246	0589328	A0225.2	117
0580417	E005M123FL	236	0581452	E0265/8H11	232	0582428	E0371-14	246	0589335	A0225.3	117
0580424	E005M14	236	0581469	E0265/8	232	0582435	E03810-32	246	0589342	A0225.4	117
0580431	E005M16	236	0581476	E0263/4	232	0582442	E0381/4	246	0589359	A0225.5	117
0580448	E005M18	236	0581483	E0267/8	232	0582459	E0385/16	246	0589366	A0225.6	117
0580455	E005M20	236	0581490	E0261	232	0582466	E0383/8	246	0589373	A0225.7	117
0580462	E006M4	236	0581506	E0276-32	246	0582473	E0387/16	246	0589380	A0225.8	117
0580479	E006M5	236	0581513	E0278-32	246	0582480	E0381/2	246	0589397	A0225.9	117
0580486	E006M53FL	236	0581520	E02710-24	246	0582497	E0389/16	246	0589403	A0225/16	117
0580493	E006M6	236	0581537	E02712-24	246	0582503	E0385/8	246	0589410	A0225/32	117
0580509	E006M63FL	236	0581544	E0271/4	246	0582510	E0383/4	246	0589427	A0225/8	118
0580516	E006M8	236	0581551	E0275/16	246	0582527	E0387/8	246	0589434	A0226.0	117
0580523	E006M10	236	0581568	E0273/8	246	0582541	E0381-14	246	0589441	A0226.1	117
0580530	E006M103FL	236	0581575	E0277/16	246	0583180	E006M43FL	236	0589458	A0226.2	117
0580547	E006M12	236	0581582	E0271/2	246	0583197	E006M83FL	236	0589465	A0226.3	117
0580554	E006M123FL	236	0581599	E0279/16	246	0583203	E0262-56	231	0589472	A0226.4	117
0580561	E006M14	236	0581605	E0275/8	246	0588697	A0223.0	117	0589489	A0226.5	117
0580578	E006M16	236	0581612	E0273/4	246	0588703	A0221/2	117	0589496	A0226.6	117
0580585	E006M18	236	0581629	E0277/8	246	0588710	A0221/4	118	0589502	A0226.7	117
0580592	E006M20	236	0581636	E0271	246	0588727	A0221/8	117	0589519	A0226.8	117
0580608	E007M4	250	0581643	E0284-40	246	0588734	A02210.0	118	0589526	A0226.9	117
0580615	E007M5	250	0581650	E0285-40	246	0588741	A02210.1	118	0589533	A0227.0	117
0580622	E007M6	250	0581667	E0286-32	246	0588758	A02210.2	118	0589540	A0227.1	117
0580639	E007M8	250	0581674	E0288-32	246	0588765	A02210.3	118	0589557	A0227.2	117
0580646	E007M10	250	0581681	E02810-24	246	0588772	A02210.4	118	0589564	A0227.3	117
0580653	E007M12	250	0581698	E02812-24	246	0588789	A02210.5	118	0589571	A0227.4	117
0580677	E007M16	250	0581704	E0281/4	246	0588796	A02210.6	118	0589588	A0227.5	117
0580707	E008M4	250	0581711	E0285/16	246	0588802	A02210.7	118	0589595	A0227.6	117
0580714	E008M5	250	0581728	E0283/8	246	0588819	A02210.8	118	0589601	A0227.7	117
0580721	E008M6	250	0581735	E0283/8H5	246	0588826	A02210.9	118	0589618	A0227.8	117
0580738	E008M8	250	0581742	E0287/16	246	0588833	A02211.0	118	0589625	A0227.9	117
0580745	E008M10	250	0581759	E0281/2	246	0588840	A02211.1	118	0589632	A0227/16	117
0580752	E008M12	250	0581766	E0289/16	246	0588857	A02211.2	118	0589649	A0227/32	117
0580769	E008M14	250	0581773	E0285/8	246	0588864	A02211.3	118	0589656	A0228.0	117
0580776	E008M16	250	0581780	E0283/4	246	0588871	A02211.5	118	0589663	A0228.1	117
0580790	E008M20	250	0581797	E0287/8	246	0588888	A02211.6	118	0589670	A0228.2	117
0580950	E016M8X1.0	236	0581803	E0281	246	0588895	A02211.7	118	0589687	A0228.3	117
0580967	E016M10X1.0	236	0581957	E0356-40	231	0588901	A02211.8	118	0589694	A0228.4	118
0580974	E016M14X1.5	236	0581964	E0358-36	231	0588918	A02211.9	118	0589700	A0228.5	118
0581032	E018M8X1.0	250	0581971	E03510-32	231	0588925	A02211/32	118	0589717	A0228.6	118
0581049	E018M10X1.0	250	0581995	E0351/4	231	0588932	A02211/64	117	0589724	A0228.7	118
0581056	E018M14X1.5	250	0582008	E0351/43FL	231	0588949	A02212.0	118	0589731	A0228.8	118
0581070	E0256-32	231	0582015	E0355/16	231	0588956	A02212.1	118	0589748	A0228.9	118
0581087	E0258-32	231	0582022	E0355/163FL	231	0588963	A02212.2	118	0589755	A0229.0	118
0581094	E02510-24	231	0582039	E0353/8	231	0588970	A02212.5	118	0589762	A0229.1	118
0581100	E02512-24	231	0582046	E0353/83FL	231	0588987	A02213.0	118	0589779	A0229.2	118
0581117	E0251/4	231	0582053	E0357/163FL	231	0588994	A02213.5	118	0589786	A0229.3	118
0581124	E0251/43FL	231	0582060	E0351/2	231	0589007	A02213/32	118	0589793	A0229.4	118
0581131	E0255/16	231	0582077	E0351/23FL	232	0589014	A02213/64	117	0589809	A0229.5	118
0581148	E0255/163FL	231	0582084	E0359/16	232	0589021	A02214.0	118	0589816	A0229.6	118
0581155	E0253/8	231	0582091	E0355/8	232	0589038	A02214.5	118	0589823	A0229.7	118
0581162	E0253/83FL	231	0582107	E0353/4	232	0589045	A02215.0	118	0589830	A0229.8	118
0581179	E0257/16	231	0582114	E0357/8	232	0589052	A02215.5	118	0589847	A0229.9	118
0581186	E0251/2	232	0582138	E0351-14	232	0589069	A02215/64	117	0589854	A0229/16	118
0581193	E0251/23FL	232	0582145	E03610-32	231	0589076	A02216.0	118	0589861	A0229/32	117
0581209	E0259/16	232	0582152	E03612-28	231	0589083	A0223.1	117	0589878	A0229/64	117
0581216	E0255/8	232	0582169	E0361/4	231	0589090	A0223.2	117	0600115	A0222.0	116
0581223	E0253/4	232	0582176	E0361/43FL	231	0589106	A0223.25	117	0600122	A0222.1	116
0581230	E0257/8	232	0582183	E0365/16	231	0589113	A0223.3	117	0600139	A0222.2	116
0581247	E0251	232	0582190	E0365/163FL	231	0589120	A0223.4	117	0600146	A0222.25	116
0581254	E0264-40	231	0582206	E0363/8	231	0589137	A0223.5	117	0600153	A0222.3	116
0581261	E0265-40	231	0582220	E0367/163FL	231	0589144	A0223.6	117	0600160	A0222.4	116
0581278	E0266-32	231	0582237	E0361/2	231	0589151	A0223.7	117	0600177	A0222.5	116
0581285	E0268-32	231	0582244	E0361/23FL	232	0589168	A0223.8	117	0600184	A0222.6	116
0581292	E02610-24	231	0582251	E0369/16	232	0589175	A0223.9	117	0600191	A0222.65	116
0581308	E02612-24	231	0582268	E0365/8	232	0589182	A0223/16	117	0600207	A0222.7	116
0581315	E0261/4	231	0582275	E0363/4	232	0589199	A0223/8	118	0600214	A0222.8	116

EDP NUMBER INDEX - 0600221 - 0624425

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0600221	A0222.9	116	0614266	R45410.3	44	0615058	R4577.5	38	0623640	R45311/64	43
0600238	A0223/32	116	0614273	R45410.4	44	0615065	R4578.0	38	0623657	R45313/32	44
0600245	A0227/64	116	0614280	R45410.5	44	0615072	R4578.5	38	0623664	R45313/64	43
0600382	A022.5	116	0614297	R45411.0	44	0615089	R4578.6	38	0623671	R45315/32	45
0600399	A022.6	116	0614303	R45411.2	44	0615096	R4578.7	38	0623688	R45315/64	44
0600405	A022.7	116	0614310	R45411.5	45	0615102	R4579.0	39	0623695	R45317/32	45
0600412	A022.8	116	0614327	R45412.0	45	0615119	R4579.3	39	0623701	R45317/64	44
0600429	A022.9	116	0614334	R45412.2	45	0615126	R4579.5	39	0623718	R45319/32	45
0600436	A0221.0	116	0614341	R45412.5	45	0615133	R45810.0	39	0623725	R45319/64	44
0600443	A0221.1	116	0614358	R45413.0	45	0615140	R45810.2	39	0623732	R45321/32	45
0600450	A0221.2	116	0614365	R45413.5	45	0615157	R45810.3	39	0623749	R45321/64	44
0600467	A0221.3	116	0614372	R45414.0	45	0615164	R45810.4	39	0623756	R45323/32	45
0600474	A0221.4	116	0614389	R45414.25	45	0615171	R45810.5	39	0623763	R45323/64	44
0600481	A0221.5	116	0614396	R45414.5	45	0615188	R45811.0	39	0623770	R45325/64	44
0600498	A0221.6	116	0614402	R45415.0	45	0615195	R45811.2	39	0623787	R45327/64	44
0600504	A0221.7	116	0614419	R45415.5	45	0615201	R45811.5	39	0623794	R45329/64	45
0600511	A0221.8	116	0614426	R45416.0	45	0615218	R45812.0	39	0623800	R4533/16	43
0600528	A0221.9	116	0614433	R4543.0	43	0615225	R45812.2	39	0623817	R4533/4	45
0600535	A0221/16	116	0614440	R4543.3	43	0615232	R45812.5	39	0623824	R4533/8	44
0600542	A0221/32	116	0614457	R4543.4	43	0615249	R45813.0	39	0623831	R45331/64	45
0600559	A0223/64	116	0614464	R4543.5	43	0615256	R45813.5	39	0623848	R45333/64	45
0600566	A0225/64	116	0614471	R4544.0	43	0615263	R45814.0	39	0623855	R45335/64	45
0605356	A0023.25	80	0614488	R4544.2	43	0615270	R45814.25	39	0623862	R45337/64	45
0609309	C27340.0	406	0614495	R4544.3	43	0615287	R45814.5	39	0623879	R45339/64	45
0609316	C24717.0	404	0614501	R4544.5	43	0615294	R45815.0	39	0623886	R45341/64	45
0609323	C24719.0	404	0614518	R4545.0	43	0615300	R45815.5	39	0623893	R45343/64	45
0609330	C24721.0	404	0614525	R4545.1	43	0615317	R45816.0	39	0623909	R45345/64	45
0609347	C24723.0	404	0614532	R4545.5	43	0615324	R4583.0	37	0623916	R45347/64	45
0609354	C24724.0	404	0614549	R4546.0	44	0615331	R4583.3	37	0623923	R4535/16	44
0609361	C24726.0	404	0614556	R4546.5	44	0615348	R4583.4	37	0623930	R4535/32	43
0609378	C24736.0	404	0614563	R4546.7	44	0615355	R4583.5	37	0623947	R4535/8	45
0609385	C24740.0	404	0614570	R4546.8	44	0615362	R4584.0	37	0623954	R4537/16	44
0612057	A720.17	126	0614587	R4546.9	44	0615379	R4584.2	37	0623961	R4537/32	43
0612064	A720.55	126	0614594	R4547.0	44	0615386	R4584.3	37	0623978	R4539/16	45
0612071	A720.62	126	0614600	R4547.4	44	0615393	R4584.5	38	0623985	R4539/32	44
0612088	A720.65	126	0614617	R4547.5	44	0615409	R4585.0	38	0623992	R4539/64	43
0612101	A720.75	126	0614624	R4548.0	44	0615416	R4585.1	38	0624005	R4541/2	44
0612125	A720.85	126	0614631	R4548.5	44	0615423	R4585.5	38	0624012	R4541/4	45
0612149	A720.95	126	0614648	R4548.6	44	0615430	R4586.0	38	0624029	R4541/8	43
0612163	A7201.05	126	0614655	R4548.7	44	0615447	R4586.5	38	0624036	R45411/16	45
0613870	R45310.0	44	0614662	R4549.0	44	0615454	R4586.8	38	0624043	R45411/32	44
0613887	R45310.2	44	0614679	R4549.3	44	0615461	R4586.9	38	0624050	R45411/64	43
0613894	R45310.3	44	0614686	R4549.5	44	0615478	R4587.0	38	0624067	R45413/32	44
0613900	R45310.5	44	0614693	R45710.0	39	0615485	R4587.4	38	0624074	R45413/64	43
0613917	R45311.0	44	0614709	R45710.2	39	0615492	R4587.5	38	0624081	R45415/32	45
0613924	R45311.2	44	0614716	R45710.3	39	0615508	R4588.0	38	0624098	R45415/64	44
0613931	R45311.5	45	0614723	R45710.4	39	0615515	R4588.5	38	0624104	R45417/32	45
0613948	R45312.0	45	0614730	R45710.5	39	0615522	R4588.6	38	0624111	R45417/64	44
0613955	R45312.2	45	0614747	R45711.0	39	0615539	R4588.7	38	0624128	R45419/32	45
0613962	R45312.5	45	0614754	R45711.2	39	0615546	R4589.0	39	0624135	R45419/64	44
0613979	R45313.0	45	0614761	R45711.5	39	0615553	R4589.3	39	0624142	R45421/32	45
0613986	R45313.5	45	0614778	R45712.0	39	0615560	R4589.5	39	0624159	R45421/64	44
0613993	R45314.0	45	0614785	R45712.2	39	0615577	A720.7	126	0624166	R45423/32	45
0614006	R45314.25	45	0614792	R45712.5	39	0615584	A720.8	126	0624173	R45423/64	44
0614013	R45314.5	45	0614808	R45713.0	39	0615591	A720.9	126	0624180	R45425/64	44
0614020	R45315.0	45	0614815	R45713.5	39	0615607	A7201.0	126	0624197	R45427/64	44
0614037	R45315.5	45	0614822	R45714.0	39	0615614	A7201.1	126	0624203	R45429/64	45
0614044	R45316.0	45	0614839	R45714.25	39	0615621	A7201.2	126	0624210	R4543/16	43
0614051	R4533.0	43	0614846	R45714.5	39	0615638	A7201.3	126	0624227	R4543/4	45
0614068	R4533.4	43	0614853	R45715.0	39	0615645	A7201.4	126	0624234	R4543/8	44
0614075	R4533.5	43	0614860	R45715.5	39	0616116	R4536.8	44	0624241	R45431/64	45
0614082	R4534.0	43	0614877	R45716.0	39	0616123	R4539.3	44	0624258	R45433/64	45
0614099	R4534.3	43	0614884	R4573.0	37	0616130	R45310.4	44	0624265	R45435/64	45
0614105	R4534.5	43	0614891	R4573.3	37	0616147	R4533.3	43	0624272	R45437/64	45
0614112	R4535.0	43	0614907	R4573.4	37	0616154	R4534.2	43	0624289	R45439/64	45
0614129	R4535.1	43	0614914	R4573.5	37	0616161	R4537.4	44	0624296	R45441/64	45
0614136	R4535.5	43	0614921	R4574.0	37	0616178	R4538.6	44	0624302	R45443/64	45
0614143	R4536.0	44	0614938	R4574.2	37	0616185	A088200S	210	0624319	R45445/64	45
0614150	R4536.5	44	0614945	R4574.3	37	0621929	C1101	385	0624326	R45447/64	45
0614167	R4536.9	44	0614952	R4574.5	38	0622032	R45814.8	39	0624333	R4545/16	44
0614174	R4537.0	44	0614969	R4575.0	38	0622049	R45715.8	39	0624340	R4545/32	43
0614181	R4537.5	44	0614976	R4575.1	38	0622056	R45718.8	40	0624357	R4545/8	45
0614198	R4538.0	44	0614983	R4575.5	38	0622063	R45719.8	40	0624364	R4547/16	44
0614204	R4538.5	44	0614990	R4576.0	38	0622070	R4574.9	38	0624371	R4547/32	43
0614211	R4538.7	44	0615003	R4576.5	38	0623596	R4531/2	45	0624388	R4549/16	45
0614228	R4539.0	44	0615010	R4576.8	38	0623602	R4531/4	44	0624395	R4549/32	44
0614235	R4539.5	44	0615027	R4576.9	38	0623619	R4531/8	43	0624401	R4549/64	43
0614242	R45410.0	44	0615034	R4577.0	38	0623626	R45311/16	45	0624418	R4571/2	39
0614259	R45410.2	44	0615041	R4577.4	38	0623633	R45311/32	44	0624425	R4571/4	38

EDP NUMBER INDEX - 0624432 - 0635483

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0624432	R4571/8	37	0625224	R4589/64	37	0626030	R45716.5	40	0633069	A92117/64	53
0624449	R45711/16	40	0625248	R45310.1	44	0626047	R45717.0	40	0633106	A9219/32	53
0624456	R45711/32	39	0625255	R45310.6	44	0626054	R45717.5	40	0633137	A92119/64	53
0624463	R45711/64	37	0625262	R45311.8	45	0626061	R45718.0	40	0633151	A9215/16	53
0624470	R45713/32	39	0625286	R45312.7	45	0626078	R45718.5	40	0633175	A92121/64	53
0624487	R45713/64	38	0625293	R45315.1	45	0626085	R45719.0	40	0633205	A92111/32	54
0624494	R45715/32	39	0625309	R45316.5	45	0626092	R45719.5	40	0633236	A92123/64	54
0624500	R45715/64	38	0625316	R45317.0	45	0626108	R45720.0	40	0633250	A9213/8	54
0624517	R45717/32	39	0625323	R45317.5	45	0626115	R4573.1	37	0633274	A92125/64	54
0624524	R45717/64	38	0625330	R45318.0	45	0626122	R4573.2	37	0633304	A92113/32	54
0624531	R45719/32	39	0625347	R45318.5	45	0626139	R4573.6	37	0633328	A92127/64	54
0624548	R45719/64	38	0625354	R45319.0	45	0626146	R4573.7	37	0633342	A9217/16	54
0624555	R45721/32	40	0625361	R45319.5	45	0626160	R4573.9	37	0633366	A92129/64	54
0624562	R45721/64	38	0625378	R45320.0	45	0626177	R4574.05	37	0633373	A92115/32	54
0624579	R45723/32	40	0625385	R4533.1	43	0626184	R4574.1	37	0633380	A92131/64	54
0624586	R45723/64	39	0625392	R4533.2	43	0626191	R4574.6	38	0633397	A9211/2	54
0624593	R45725/64	39	0625408	R4533.6	43	0626214	R4575.05	38	0633410	A92133/64	54
0624609	R45727/64	39	0625415	R4533.7	43	0626221	R4575.6	38	0633427	A92135/64	54
0624616	R45729/64	39	0625422	R4533.8	43	0626238	R4575.7	38	0633434	A9219/16	54
0624623	R4573/16	38	0625439	R4534.05	43	0626245	R4575.8	38	0633441	A92137/64	54
0624630	R4573/4	40	0625446	R4534.1	43	0626252	R4576.05	38	0633458	A92114.75	54
0624647	R4573/8	39	0625453	R4534.6	43	0626269	R4576.1	38	0633465	A92119/32	54
0624654	R45731/64	39	0625460	R4534.7	43	0626276	R4576.3	38	0633472	A92139/64	54
0624661	R45733/64	39	0625477	R4535.05	43	0626283	R4576.6	38	0633489	A9215/8	54
0624678	R45735/64	39	0625484	R4535.6	44	0626290	R4577.1	38	0633540	A9003/64	61
0624685	R45737/64	39	0625491	R4535.7	44	0626306	R4577.3	38	0633557	A9001.25	61
0624692	R45739/64	39	0625507	R4535.8	44	0626313	R4577.6	38	0633601	A9001.55	61
0624708	R45741/64	39	0625514	R4536.05	44	0626320	R4577.8	38	0633625	A9001.75	61
0624715	R45743/64	40	0625521	R4536.1	44	0626337	R4578.05	38	0633694	A9002.15	61
0624722	R45745/64	40	0625538	R4536.3	44	0626344	R4578.8	39	0634318	A90033/64	63
0624739	R45747/64	40	0625545	R4536.6	44	0626351	R4579.1	39	0634325	A90035/64	63
0624746	R4575/16	38	0625552	R4537.1	44	0626368	R4579.6	39	0634332	A9009/16	63
0624753	R4575/32	37	0625569	R4537.3	44	0626375	R4579.8	39	0634349	A90037/64	63
0624760	R4575/8	39	0625576	R4537.6	44	0626382	R45810.1	38	0634363	A90019/32	63
0624777	R4577/16	39	0625583	R4537.8	44	0626399	R45810.6	38	0634370	A90039/64	63
0624784	R4577/32	38	0625590	R4538.05	44	0626405	R45811.8	38	0634387	A9005/8	63
0624791	R4579/16	39	0625606	R4538.1	44	0626412	R45812.1	38	0634394	A90041/64	63
0624807	R4579/32	38	0625613	R4538.8	44	0626429	R45812.7	38	0634400	A90016.5	63
0624814	R4579/64	37	0625620	R4539.1	44	0626436	R45815.1	38	0634417	A90021/32	63
0624821	R4581/2	39	0625637	R4539.6	44	0626443	R4583.1	37	0634431	A90043/64	63
0624838	R4581/4	38	0625644	R4539.8	44	0626450	R4583.2	37	0634448	A90011/16	63
0624845	R4581/8	37	0625651	R45410.1	44	0626467	R4583.6	37	0634455	A90045/64	63
0624852	R45811/16	40	0625668	R45410.6	44	0626474	R4583.7	37	0634462	A90023/32	63
0624869	R45811/32	39	0625675	R45411.8	45	0626498	R4583.8	37	0634479	A90018.5	63
0624876	R45811/64	37	0625682	R45412.1	45	0626504	R4583.9	37	0634486	A90047/64	63
0624883	R45813/32	39	0625699	R45412.7	45	0626511	R4584.1	37	0634493	A9003/4	63
0624890	R45813/64	38	0625705	R45415.1	45	0626528	R4584.6	38	0634509	A90049/64	63
0624906	R45815/32	39	0625712	R4543.1	43	0626535	R4585.6	38	0634516	A90019.5	63
0624913	R45815/64	38	0625729	R4543.2	43	0626542	R4585.7	38	0634523	A90025/32	63
0624920	R45817/32	39	0625736	R4543.6	43	0626559	R4585.8	38	0634547	A90011.55	61
0624937	R45817/64	38	0625743	R4543.7	43	0626566	R4586.1	38	0634554	A9011/16	61
0624944	R45819/32	39	0625750	R4543.8	43	0626573	R4586.3	38	0634561	A9011.6	61
0624951	R45819/64	38	0625767	R4543.9	43	0626580	R4586.6	38	0634592	A9011.75	61
0624968	R45821/32	40	0625774	R4544.1	43	0626597	R4587.1	38	0634615	A9011.8	61
0624975	R45821/64	38	0625781	R4544.6	43	0626603	R4587.3	38	0634639	A9011.9	61
0624982	R45823/32	40	0625798	R4544.7	43	0626610	R4587.6	38	0634653	A9015/64	61
0624999	R45823/64	39	0625804	R4545.6	44	0626627	R4587.8	38	0634691	A9012.1	61
0625002	R45825/64	39	0625811	R4545.7	44	0626634	R4588.1	38	0634707	A9012.15	61
0625019	R45827/64	39	0625828	R4545.8	44	0626641	R4588.8	39	0634752	A9013/32	61
0625026	R45829/64	39	0625835	R4546.1	44	0626658	R4589.1	39	0634769	A9012.4	61
0625033	R4583/16	38	0625842	R4546.3	44	0626665	R4589.6	39	0634820	A9012.7	61
0625040	R4583/4	40	0625859	R4546.6	44	0626672	R4589.8	39	0634844	A9017/64	61
0625057	R4583/8	39	0625866	R4547.1	44	0626689	R4578.1	39	0634882	A9012.9	61
0625064	R45831/64	39	0625873	R4547.3	44	0628911	R4533.9	44	0634912	A9011/8	61
0625071	R45833/64	39	0625880	R4547.6	44	0628942	C11017.7	385	0634943	A9019/64	62
0625088	R45835/64	39	0625897	R4547.8	44	0628959	C11019.7	385	0634998	A9015/32	63
0625095	R45837/64	39	0625903	R4548.1	44	0628966	C11021.7	385	0635056	A90111/64	62
0625101	R45839/64	39	0625910	R4548.8	44	0628973	C11024.7	385	0635094	A9013/16	62
0625118	R45841/64	39	0625927	R4549.1	44	0628980	C11026.0	385	0635155	A90113/64	62
0625125	R45843/64	40	0625934	R4549.6	44	0628997	C11036.0	385	0635209	A9017/32	62
0625132	R45845/64	40	0625941	R4549.8	44	0629000	C11040.0	385	0635247	A90115/64	62
0625149	R45847/64	40	0625958	R45710.05	39	0629017	C11045.0	385	0635285	A9011/4	62
0625156	R4585/16	38	0625965	R45710.1	39	0629024	C11050.0	385	0635315	A90117/64	62
0625163	R4585/32	37	0625972	R45710.6	39	0629031	C1106.75	384	0635353	A9019/32	62
0625170	R4585/8	39	0625989	R45711.8	39	0629055	R4539.7	44	0635384	A90119/64	62
0625187	R4587/16	39	0625996	R45712.05	39	0629062	R4579.7	39	0635407	A9015/16	62
0625194	R4587/32	38	0626009	R45712.1	39	0632956	A9217/32	53	0635421	A90121/64	62
0625200	R4589/16	39	0626016	R45712.7	39	0632994	A92115/64	53	0635452	A90111/32	63
0625217	R4589/32	38	0626023	R45715.1	39	0633038	A9211/4	53	0635483	A90123/64	63

EDP NUMBER INDEX - 0635506 - 1010351

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
0635506	A9013/8	63	0640029	C1231/8	390	1010091	15001/2X13H2NO3	266	1010247	15083/8X24NO3	276
0635520	A90125/64	63	0640036	C1235/32	390	1010092	15001/2X13H3NO3	266	1010248	15087/16X14NO2	276
0635551	A90113/32	63	0640043	C1233/16	390	1010093	15001/2X13H5NO3	266	1010250	15087/16X20NO2	276
0635575	A90127/64	63	0640050	C1231/4	390	1010094	15001/2X20H3NO1	266	1010252	15081/2X13NO2	276
0635599	A9017/16	63	0640067	C1235/16	390	1010097	15001/2X20H3NO2	266	1010253	15081/2X13NO3	276
0635612	A90129/64	63	0640074	C1233/8	390	1010101	15001/2X20H3NO3	266	1010254	15081/2X20NO2	276
0635629	A90115/32	63	0640081	C1231/2	390	1010103	15009/16X12H3NO1	266	1010256	15991/4X20NO2	281
0635636	A90131/64	63	0640098	C1239/16	390	1010106	15009/16X12H3NO2	266	1010257	15991/4X20NO3	281
0635650	A90133/64	63	0640104	C1235/8	391	1010108	15009/16X12H3NO3	266	1010260	15995/16X18NO2	281
0635667	A90135/64	63	0640111	C1233/4	391	1010110	15009/16X18H3NO1	266	1010261	15995/16X18NO3	281
0635674	A9019/16	63	0640128	C1231	391	1010113	15009/16X18H3NO2	266	1010263	15995/16X24NO3	281
0635681	A90137/64	63	0640142	C2471/8	403	1010116	15009/16X18H3NO3	266	1010264	15993/8X16NO2	281
0635704	A90119/32	63	0640159	C2473/16	403	1010118	15005/8X11H3NO1	266	1010265	15993/8X16NO3	281
0635711	A90139/64	63	0640166	C2471/4	403	1010121	15005/8X11H3NO2	266	1010266	15993/8X24NO2	281
0635728	A9015/8	63	0640173	C2475/16	403	1010123	15005/8X11H3NO3	266	1010267	15993/8X24NO3	281
0635735	A9403/64	64	0640180	C2473/8	403	1010125	15005/8X18H3NO1	266	1010271	15997/16X20NO3	281
0635742	A94035/64	66	0640197	C2471/2	403	1010128	15005/8X18H3NO2	266	1010272	15991/2X13NO2	281
0635759	A94039/64	66	0640203	C2479/16	403	1010131	15005/8X18H3NO3	266	1010273	15991/2X13NO3	281
0635766	A94041/64	66	0640210	C2475/8	403	1010139	15003/4X10H3NO1	266	1010274	15991/2X20NO2	281
0635773	A94043/64	66	0640227	C2473/4	404	1010142	15003/4X10H3NO2	266	1010275	15991/2X20NO3	281
0635780	A94049/64	66	0640234	C2477/8	404	1010144	15003/4X10H3NO3	266	1010279	15999/16X18NO3	281
0635797	A94025/32	66	0640241	C2471	404	1010146	15003/4X16H3NO1	266	1010280	15995/8X11NO2	281
0635803	A9413/64	64	0640258	C24750.0	404	1010149	15003/4X16H3NO2	266	1010281	15995/8X11NO3	281
0635810	A9411/16	64	0640265	C2731/8	405	1010152	15003/4X16H3NO3	266	1010285	15993/4X10NO3	281
0635827	A9415/64	64	0640272	C2733/16	405	1010154	15007/8X9H4NO1	266	1010286	15993/4X16NO2	281
0635834	A9413/32	64	0640289	C2731/4	405	1010157	15007/8X9H4NO2	266	1010287	15993/4X16NO3	281
0635841	A9417/64	64	0640296	C2733/8	405	1010159	15007/8X9H4NO3	266	1010288	1599M14NO2	282
0635858	A9411/8	64	0640302	C2731/2	405	1010160	15007/8X14H4NO1	266	1010290	15851/4X20H12FLNO2	285
0635865	A9419/64	64	0640319	C2735/8	405	1010163	15007/8X14H4NO2	266	1010291	15851/4X20H22FLNO2	285
0635872	A9415/32	66	0640326	C2733/4	405	1010166	15007/8X14H4NO3	266	1010292	15851/4X20H32FLNO2	285
0635889	A94111/64	65	0640340	C2731	406	1010167	15001X8H4NO1	267	1010293	15851/4X20H52FLNO2	285
0635896	A9413/16	65	1010001	15001/4X20H1NO1	266	1010170	15001X8H4NO2	267	1010294	15851/4X20H32FLNO3	285
0635902	A94113/64	65	1010002	15001/4X20H2NO1	266	1010172	15001X8H4NO3	267	1010295	15851/4X20H33FLNO2	285
0635919	A9417/32	65	1010003	15001/4X20H3NO1	266	1010173	15001X12H4NO1	267	1010296	15851/4X20H53FLNO2	285
0635926	A94115/64	65	1010004	15001/4X20H1NO2	266	1010174	15001X12H4NO2	267	1010298	15851/4X28H22FLNO2	285
0635933	A9411/4	65	1010005	15001/4X20H2NO2	266	1010175	15001X12H4NO3	267	1010299	15851/4X28H32FLNO2	285
0635940	A94117/64	65	1010006	15001/4X20H3NO2	266	1010176	15001X14H4NO1	267	1010300	15851/4X28H42FLNO2	285
0635957	A9419/32	65	1010007	15001/4X20H5NO2	266	1010178	15001X14H4NO2	267	1010301	15851/4X28H32FLNO3	285
0635964	A94119/64	65	1010008	15001/4X20H1NO3	266	1010181	15001X14H4NO3	267	1010302	15851/4X28H23FLNO2	285
0635971	A9415/16	65	1010009	15001/4X20H2NO3	266	1010182	15001.1/8X7H4NO1	267	1010303	15851/4X28H43FLNO2	285
0635988	A94121/64	65	1010010	15001/4X20H3NO3	266	1010183	15001.1/8X7H4NO2	267	1010304	15855/16X18H12FLNO2	285
0635995	A94111/32	65	1010011	15001/4X20H5NO3	266	1010184	15001.1/8X7H4NO3	267	1010305	15855/16X18H22FLNO2	285
0636008	A94123/64	66	1010014	15001/4X28H3NO1	266	1010185	15001.1/8X12H4NO1	267	1010306	15855/16X18H32FLNO2	285
0636015	A9413/8	66	1010016	15001/4X28H2NO2	266	1010186	15001.1/8X12H4NO2	267	1010307	15855/16X18H52FLNO2	285
0636022	A94125/64	66	1010017	15001/4X28H3NO2	266	1010187	15001.1/8X12H4NO3	267	1010308	15855/16X18H32FLNO3	285
0636039	A94113/32	66	1010018	15001/4X28H4NO2	266	1010188	15001.1/4X7H4NO1	267	1010309	15855/16X18H33FLNO2	285
0636046	A94127/64	66	1010020	15001/4X28H2NO3	266	1010189	15001.1/4X7H4NO2	267	1010310	15855/16X18H53FLNO2	285
0636053	A9417/16	66	1010021	15001/4X28H3NO3	266	1010190	15001.1/4X7H4NO3	267	1010313	15855/16X24H32FLNO2	285
0636060	A94129/64	66	1010022	15001/4X28H4NO3	266	1010191	15001.1/4X12H4NO1	267	1010315	15855/16X24H32FLNO3	285
0636077	A94115/32	66	1010024	15005/16X18H2NO1	266	1010192	15001.1/4X12H4NO2	267	1010316	15855/16X24H23FLNO2	285
0636084	A94131/64	66	1010025	15005/16X18H3NO1	266	1010193	15001.1/4X12H4NO3	267	1010317	15855/16X24H43FLNO2	285
0636091	A9411/2	66	1010027	15005/16X18H2NO2	266	1010194	15001.3/8X6H4NO1	267	1010318	15853/8X16H13FLNO2	286
0636107	A94133/64	66	1010028	15005/16X18H3NO2	266	1010195	15001.3/8X6H4NO2	267	1010319	15853/8X16H23FLNO2	286
0636114	A94135/64	66	1010031	15005/16X18H2NO3	266	1010196	15001.3/8X6H4NO3	267	1010320	15853/8X16H33FLNO2	286
0636121	A9419/16	66	1010032	15005/16X18H3NO3	266	1010197	15001.3/8X12H4NO1	267	1010321	15853/8X16H53FLNO2	286
0636138	A94137/64	66	1010036	15005/16X24H3NO1	266	1010198	15001.3/8X12H4NO2	267	1010324	15853/8X24H33FLNO2	286
0636145	A94119/32	66	1010039	15005/16X24H3NO2	266	1010199	15001.3/8X12H4NO3	267	1010325	15853/8X24H43FLNO2	286
0636152	A94139/64	66	1010043	15005/16X24H3NO3	266	1010200	15001.1/2X6H4NO1	267	1010327	15857/16X14H23FLNO2	286
0636169	A9415/8	66	1010046	15003/8X16H2NO1	266	1010201	15001.1/2X6H4NO2	267	1010328	15857/16X14H33FLNO2	286
0639795	C1101/16	384	1010047	15003/8X16H3NO1	266	1010202	15001.1/2X6H4NO3	267	1010329	15857/16X14H53FLNO2	286
0639801	C1103/32	384	1010049	15003/8X16H2NO2	266	1010203	15001.1/2X12H4NO1	267	1010331	15857/16X20H23FLNO2	286
0639818	C1101/8	384	1010050	15003/8X16H3NO2	266	1010204	15001.1/2X12H4NO2	267	1010332	15857/16X20H33FLNO2	286
0639825	C1103/16	384	1010051	15003/8X16H5NO2	266	1010205	15001.1/2X12H4NO3	267	1010334	15851/2X13H13FLNO2	286
0639832	C1101/4	384	1010053	15003/8X16H2NO3	266	1010206	15951/4X20NO2	276	1010335	15851/2X13H23FLNO2	286
0639849	C1105/16	384	1010054	15003/8X16H3NO3	266	1010207	15951/4X20NO3	276	1010336	15851/2X13H33FLNO2	286
0639856	C1103/8	385	1010055	15003/8X16H5NO3	266	1010208	15951/4X28NO2	276	1010337	15851/2X13H53FLNO2	286
0639863	C11013/32	385	1010058	15003/8X24H3NO1	266	1010209	15951/4X28NO3	276	1010338	15851/2X20H13FLNO2	286
0639870	C1107/16	385	1010061	15003/8X24H3NO2	266	1010210	15951/16X18NO2	276	1010339	15851/2X20H23FLNO2	286
0639887	C1101/2	385	1010065	15003/8X24H3NO3	266	1010211	15955/16X18NO3	276	1010340	15851/2X20H33FLNO2	286
0639894	C11017/32	385	1010067	15007/16X14H3NO1	266	1010216	15081/4X20NO2	276	1010341	15851/2X20H53FLNO2	286
0639900	C1109/16	385	1010070	15007/16X14H3NO2	266	1010219	15081/4X20NO3	276	1010342	15855/8X11H33FLNO2	286
0639917	C1105/8	385	1010074	15007/16X14H3NO3	266	1010223	15081/4X28NO2	276	1010343	15855/8X11H53FLNO2	286
0639924	C11011/16	385	1010076	15007/16X20H3NO1	266	1010230	15085/16X18NO2	276	1010344	15853/4X10H33FLNO2	286
0639931	C1103/4	385	1010079	15007/16X20H3NO2	266	1010233	15085/16X18NO3	276	1010345	15853/4X10H53FLNO2	286
0639948	C1107/8	385	1010083	15007/16X20H3NO3	266	1010236	15085/16X24NO2	276	1010346	15861/4X202FLNO2	295
0639962	C1101.1/8	385	1010085	15001/2X13H3NO1	266	1010237	15085/16X24NO3	276	1010347	15861/4X202FLNO3	295
0639979	C1101.1/4	385	1010087	15001/2X13H2NO2	266	1010240	15083/8X16NO2	276	1010348	15861/4X203FLNO2	295
0639986	C11035.0	385	1010088	15001/2X13H3NO2	266	1010243	15083/8X16NO3	276	1010349	15861/4X203FLNO3	295
0640012	C1231/16	390	1010089	15001/2X13H5NO2	266	1010246	15083/8X24NO2	276	1010350	15861/4X282FLNO2	295
									1010351	15861/4X282FLNO3	295

EDP NUMBER INDEX - 1010352 - 1010920

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1010352	15861/4X283FLNO2	295	1010502	157810-32H2	319	1010644	15284-40H23FLNO1	265	1010767	152812-24H34FLNO2	266
1010353	15861/4X283FLNO3	295	1010506	15781/4X20H2	319	1010645	15284-40H13FLNO2	265	1010768	152812-24H34FLNO3	266
1010354	15865/16X183FLNO2	295	1010507	15781/4X20H3	319	1010646	15284-40H23FLNO2	265	1010769	152812-28H34FLNO1	266
1010355	15865/16X183FLNO3	295	1010508	15781/4X28H2	319	1010647	15284-40H13FLNO3	265	1010771	152812-28H34FLNO2	266
1010356	15865/16X243FLNO2	295	1010509	15781/4X28H3	319	1010648	15284-40H23FLNO3	265	1010772	152812-28H34FLNO3	266
1010357	15865/16X243FLNO3	295	1010518	15411/16X27	304	1010650	15284-40H22FLNO2	265	1010775	1534NR0-80H1NO2	289
1010358	15863/8X163FLNO2	295	1010519	15411/8X27	304	1010652	15284-40H22FLNO3	265	1010776	1534NR0-80H2NO2	289
1010359	15863/8X163FLNO3	295	1010520	15411/4X18	304	1010653	15284-48H23FLNO1	265	1010778	1534NR0-80H2NO3	289
1010360	15863/8X243FLNO2	295	1010521	15413/8X18	304	1010655	15284-48H23FLNO2	265	1010779	1534NR1-64H1NO2	289
1010361	15863/8X243FLNO3	295	1010522	15411/2X14	304	1010656	15284-48H23FLNO3	265	1010780	1534NR1-64H2NO2	289
1010362	15867/16X143FLNO2	295	1010523	15413/4X14	304	1010660	15285-40H23FLNO1	265	1010783	1534NR1-72H1NO2	289
1010363	15867/16X143FLNO3	295	1010524	15411X11.1/2	304	1010662	15285-40H23FLNO2	265	1010784	1534NR1-72H2NO2	289
1010366	15861/2X133FLNO2	295	1010525	15411.1/4X11.1/2	304	1010664	15285-40H23FLNO3	265	1010787	1534NR2-56H1NO2	289
1010367	15861/2X133FLNO3	295	1010526	15411.1/2X11.1/2	304	1010669	15285-44H23FLNO1	265	1010788	1534NR2-56H2NO2	289
1010368	15861/2X203FLNO2	295	1010527	15412X11.1/2	304	1010671	15285-44H23FLNO2	265	1010790	1534NR2-56H2NO3	289
1010369	15861/2X203FLNO3	295	1010528	15411/8X27X.0313	304	1010672	15285-44H23FLNO3	265	1010791	1534NR2-64H1NO2	289
1010375	U15111/4	321	1010529	15431/16X27	312	1010675	15286-32H13FLNO1	265	1010792	1534NR2-64H2NO2	289
1010376	U15115/16	321	1010530	15431/8X27	312	1010676	15286-32H23FLNO1	265	1010796	1534NR3-48H2NO2	289
1010377	U15113/8	321	1010531	15431/4X18	312	1010677	15286-32H33FLNO1	265	1010798	1534NR3-48H2NO3	289
1010378	U15111/2	321	1010532	15433/8X18	312	1010678	15286-32H13FLNO2	265	1010799	1534NR3-56H1NO2	289
1010379	15191/4X20X6	322	1010533	15431/2X14	312	1010679	15286-32H23FLNO2	265	1010800	1534NR3-56H2NO2	289
1010380	15191/4X20X8	322	1010534	15433/4X14	312	1010680	15286-32H33FLNO2	265	1010803	1534NR4-36H2NO2	289
1010381	15195/16X18X6	322	1010535	15431X11.1/2	312	1010681	15286-32H13FLNO3	265	1010804	1534NR4-40H1NO2	289
1010382	15195/16X18X8	322	1010539	15431/8X27X0.313	312	1010682	15286-32H23FLNO3	265	1010805	1534NR4-40H2NO2	289
1010383	15193/8X16X6	322	1010551	15681/8X27	310	1010683	15286-32H33FLNO3	265	1010807	1534NR4-40H2NO3	289
1010384	15193/8X16X8	322	1010552	15681/4X18	310	1010685	15286-32H22FLNO2	265	1010809	1534NR4-48H2NO2	289
1010385	15193/8X16X10	322	1010553	15683/8X18	310	1010686	15286-32H23FLNO2	265	1010811	1534NR4-48H2NO3	289
1010388	15191/2X13X6	322	1010554	15681/2X14	310	1010688	15286-32H22FLNO3	265	1010813	1534NR5-40H2NO2	289
1010389	15191/2X13X8	322	1010555	15683/4X14	310	1010689	15286-32H23FLNO3	265	1010815	1534NR5-40H2NO3	289
1010390	15191/2X13X10	322	1010556	15681X11.1/2	310	1010690	15286-40H23FLNO1	265	1010817	1534NR5-44H2NO2	289
1010392	15195/8X11X6	322	1010557	15681.1/4X11.1/2	310	1010692	15286-40H23FLNO2	265	1010818	1534NR6-32H1NO2	289
1010393	15195/8X11X8	322	1010558	15681.1/2X11.1/2	310	1010693	15286-40H23FLNO3	265	1010819	1534NR6-32H2NO2	289
1010394	15195/8X11X10	322	1010560	15681/8X27X0.313	310	1010697	15288-32H24FLNO1	266	1010820	1534NR6-32H3NO2	289
1010396	15193/4X10X10	322	1010561	15671/8X27	314	1010698	15288-32H34FLNO1	266	1010822	1534NR6-32H2NO3	289
1010398	15881/4X20NO2	296	1010562	15671/4X18	314	1010699	15288-32H14FLNO2	266	1010823	1534NR6-32H3NO3	289
1010399	15881/4X20NO3	296	1010563	15673/8X18	314	1010700	15288-32H24FLNO2	266	1010825	1534NR6-40H2NO2	289
1010400	15881/4X28NO2	296	1010564	15671/2X14	314	1010701	15288-32H34FLNO2	266	1010827	1534NR6-40H2NO3	289
1010401	15881/4X28NO3	296	1010565	15673/4X14	314	1010703	15288-32H24FLNO3	266	1010828	1534NR8-32H1NO2	290
1010402	15885/16X18NO2	296	1010566	15671X11.1/2	314	1010704	15288-32H34FLNO3	266	1010829	1534NR8-32H2NO2	290
1010403	15885/16X18NO3	296	1010570	15671/8X27X0.313	314	1010706	15288-32H22FLNO2	266	1010830	1534NR8-32H3NO2	290
1010404	15885/16X24NO2	296	1010581	15421/8X27	316	1010707	15288-32H23FLNO2	266	1010832	1534NR8-32H2NO3	290
1010405	15885/16X24NO3	296	1010582	15421/4X18	316	1010709	15288-32H22FLNO3	266	1010833	1534NR8-32H3NO3	290
1010406	15883/8X16NO2	296	1010583	15423/8X18	316	1010710	15288-32H32FLNO3	266	1010835	1534NR8-36H2NO2	290
1010407	15883/8X16NO3	296	1010584	15421/2X14	316	1010712	15288-32H23FLNO2	266	1010837	1534NR10-24H1NO2	290
1010408	15883/8X24NO2	296	1010585	15423/4X14	316	1010713	15288-32H33FLNO2	266	1010838	1534NR10-24H2NO2	290
1010409	15883/8X24NO3	296	1010586	15421X11.1/2	316	1010715	15288-32H23FLNO3	266	1010839	1534NR10-24H3NO2	290
1010410	15887/16X14NO2	296	1010587	15421/8X27X0.313	316	1010716	15288-32H33FLNO3	266	1010841	1534NR10-24H2NO3	290
1010411	15887/16X14NO3	296	1010588	15921/8X27	316	1010717	15288-36H24FLNO1	266	1010842	1534NR10-24H3NO3	290
1010412	15887/16X20NO2	296	1010589	15921/4X18	316	1010719	15288-36H24FLNO2	266	1010843	1534NR10-32H1NO2	290
1010413	15887/16X20NO3	296	1010590	15923/8X18	316	1010720	15288-36H24FLNO3	266	1010844	1534NR10-32H2NO2	290
1010414	15881/2X13NO2	296	1010591	15921/2X14	316	1010724	152810-24H24FLNO1	266	1010845	1534NR10-32H3NO2	290
1010415	15881/2X13NO3	296	1010592	15921/8X27X0.313	316	1010725	152810-24H34FLNO1	266	1010847	1534NR10-32H2NO3	290
1010416	15881/2X20NO2	296	1010593	15280-80H12FLNO1	265	1010726	152810-24H14FLNO2	266	1010848	1534NR10-32H3NO3	290
1010417	15881/2X20NO3	296	1010594	15280-80H12FLNO2	265	1010727	152810-24H24FLNO2	266	1010853	1534NR12-28H3NO2	290
1010419	15724-40H2NO2	319	1010595	15280-80H22FLNO2	265	1010728	152810-24H34FLNO2	266	1010877	15936-32	294
1010421	15724-40H2NO3	319	1010596	15280-80H12FLNO3	265	1010730	152810-24H24FLNO3	266	1010879	15938-32	294
1010427	15726-32H3NO2	319	1010597	15280-80H22FLNO3	265	1010731	152810-24H34FLNO3	266	1010881	159310-24	294
1010429	15726-32H3NO3	319	1010598	15281-64H12FLNO1	265	1010733	152810-24H22FLNO2	266	1010883	159310-32	294
1010435	15728-32H3NO2	319	1010599	15281-64H12FLNO2	265	1010734	152810-24H32FLNO2	266	1010887	15874-40NO2	296
1010437	15728-32H3NO3	319	1010601	15281-64H12FLNO3	265	1010736	152810-24H22FLNO3	266	1010888	15874-40NO3	296
1010438	157210-24H2NO2	319	1010603	15281-72H12FLNO1	265	1010737	152810-24H32FLNO3	266	1010891	15876-32NO2	296
1010440	157210-24H2NO3	319	1010604	15281-72H12FLNO2	265	1010739	152810-24H23FLNO2	266	1010892	15876-32NO3	296
1010442	157210-32H2NO2	319	1010606	15281-72H12FLNO3	265	1010740	152810-24H33FLNO2	266	1010895	15878-32NO2	296
1010443	157210-32H3NO2	319	1010608	15282-56H13FLNO1	265	1010743	152810-24H33FLNO3	266	1010896	15878-32NO3	296
1010444	157210-32H2NO3	319	1010609	15282-56H23FLNO1	265	1010745	152810-32H24FLNO1	266	1010897	158710-24NO2	296
1010445	157210-32H3NO3	319	1010610	15282-56H13FLNO2	265	1010746	152810-32H34FLNO1	266	1010898	158710-24NO3	296
1010451	15721/4X20H3NO2	319	1010611	15282-56H23FLNO2	265	1010748	152810-32H24FLNO2	266	1010899	158710-32NO2	296
1010453	15721/4X20H3NO3	319	1010612	15282-56H13FLNO3	265	1010749	152810-32H34FLNO2	266	1010900	158710-32NO3	296
1010456	15721/4X28H3NO3	319	1010613	15282-56H23FLNO3	265	1010751	152810-32H24FLNO3	266	1010905	15824-40NO2	295
1010458	15725/16X18H3NO2	319	1010615	15282-56H22FLNO2	265	1010752	152810-32H34FLNO3	266	1010906	15824-40NO3	295
1010466	15723/8X16H3NO2	319	1010617	15282-56H22FLNO3	265	1010754	152810-32H22FLNO2	266	1010909	15826-32NO2	295
1010468	15723/8X16H3NO3	319	1010625	15283-48H23FLNO1	265	1010755	152810-32H32FLNO2	266	1010910	15826-32NO3	295
1010474	15727/16X14H3NO2	319	1010627	15283-48H23FLNO2	265	1010757	152810-32H22FLNO3	266	1010913	15828-32NO2	295
1010482	15721/2X13H3NO2	319	1010629	15283-48H23FLNO3	265	1010758	152810-32H32FLNO3	266	1010914	15828-32NO3	295
1010491	15784-40H2	319	1010631	15283-48H22FLNO2	265	1010760	152810-32H23FLNO2	266	1010915	158210-24NO2	295
1010494	15786-32H2	319	1010634	15283-56H23FLNO1	265	1010761	152810-32H33FLNO2	266	1010916	158210-24NO3	295
1010495	15786-32H3	319	1010636	15283-56H23FLNO2	265	1010763	152810-32H23FLNO3	266	1010917	158210-32NO2	295
1010498	15788-32H2	319	1010637	15283-56H23FLNO3	265	1010764					

EDP NUMBER INDEX - 1010921 - 1013066

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1010921	15491/16X27	313	1011065	1500S1.1/4X12	267	1011835	1500L1X12	274	1012844	1585NR3/8X16H53FLNO2	291
1010922	15481/8X27	309	1011066	1500S1.3/8X6	267	1011838	1500L1X14	274	1012847	1585NR3/8X24H33FLNO2	291
1010923	15491/8X27	313	1011067	1500S1.3/8X12	267	1012256	1599M6NO2	282	1012849	1585NR7/16X14H23FLNO2	291
1010924	15481/8X27X0.313	309	1011068	1500S1.1/2X6	267	1012258	1599M8NO2	282	1012850	1585NR7/16X14H33FLNO2	291
1010925	15491/8X27X0.313	313	1011069	1500S1.1/2X12	267	1012260	1599M10NO2	282	1012851	1585NR7/16X14H53FLNO2	291
1010926	15481/4X18	309	1011070	15923/4X14	316	1012262	1599M12NO2	282	1012853	1585NR7/16X20H33FLNO2	291
1010927	15491/4X18	313	1011071	1534NR12-24H3NO2	290	1012266	1599M6NO3	282	1012856	1585NR1/2X13H23FLNO2	291
1010928	15483/8X18	309	1011072	1534NR12-24H3NO3	290	1012268	1599M8NO3	282	1012857	1585NR1/2X13H33FLNO2	291
1010929	15493/8X18	313	1011073	1528S2-64H2	265	1012270	1599M10NO3	282	1012858	1585NR1/2X13H53FLNO2	291
1010930	15481/2X14	309	1011074	1528S3-56H2	265	1012272	1599M12NO3	282	1012861	1585NR1/2X20H33FLNO2	291
1010931	15491/2X14	313	1011075	1528S4-48H2	265	1012276	1599M6	282	1012863	1585NR5/8X11H33FLNO2	291
1010932	15483/4X14	309	1011076	1528S5-44H2	265	1012278	1599M8	282	1012864	1585NR5/8X11H53FLNO2	291
1010933	15493/4X14	313	1011102	16344-40	287	1012280	1599M10	282	1012865	1585NR3/4X10H33FLNO2	291
1010934	15481X11.1/2	309	1011104	16346-32	287	1012282	1599M12	282	1012866	1585NR3/4X10H53FLNO2	291
1010937	15906-32NO2	297	1011105	16348-32	287	1012356	15345-40H2NO2	284	1012867	1585NR5/8X18H33FLNO2	291
1010938	15906-32NO3	297	1011106	163410-32	287	1012357	15345-40H2NO3	284	1012868	1585NR3/4X16H33FLNO2	291
1010940	15906-40NO3	297	1011256	16001/4X20NO2	281	1012358	15345-44H2NO2	284	1012870	15451/8X27	308
1010945	159010-24NO2	297	1011257	16001/4X20NO3	281	1012359	15346-32H1NO2	284	1012871	15451/4X18	308
1010946	159010-24NO3	297	1011258	16001/4X28NO2	281	1012360	15346-32H2NO2	284	1012872	15453/8X18	308
1010947	159010-32NO2	297	1011259	16001/4X28NO3	281	1012361	15346-32H3NO2	284	1012873	15451/2X14	308
1010948	159010-32NO3	297	1011261	16005/16X18NO3	281	1012363	15346-32H2NO3	284	1012874	15453/4X14	308
1010953	15911/4X20NO2	297	1011262	16005/16X24NO2	281	1012364	15346-32H3NO3	284	1012875	15451X11.1/2	308
1010954	15911/4X20NO3	297	1011263	16005/16X24NO3	281	1012366	15346-40H2NO2	284	1012879	15451/8X27X0.313	308
1010955	15911/4X28NO2	297	1011264	16003/8X16NO2	281	1012367	15346-40H2NO3	284	1012890	1785NRM1.6	292
1010956	15911/4X28NO3	297	1011265	16003/8X16NO3	281	1012368	15348-32H1NO2	284	1012891	1785NRM2	292
1010957	15915/16X18NO2	297	1011266	16003/8X24NO2	281	1012369	15348-32H2NO2	284	1012893	1785NRM2.5	292
1010958	15915/16X18NO3	297	1011267	16003/8X24NO3	281	1012370	15348-32H3NO2	284	1012896	1785NRM3	292
1010961	15913/8X16NO2	297	1011268	16007/16X14NO2	281	1012372	15348-32H2NO3	284	1012897	1785NRM3.5	292
1010962	15913/8X16NO3	297	1011269	16007/16X14NO3	281	1012373	15348-32H3NO3	284	1012898	1785NRM4	292
1010965	15917/16X14NO2	297	1011270	16007/16X20NO2	281	1012375	15348-36H2NO2	284	1012899	1785NRM4.5	292
1010966	15917/16X14NO3	297	1011271	16007/16X20NO3	281	1012377	153410-24H2NO2	284	1012900	1785NRM5	292
1010969	15911/2X13NO2	297	1011273	16001/2X13NO3	281	1012378	153410-24H3NO2	284	1012901	1785NRM6	292
1010970	15911/2X13NO3	297	1011274	16001/2X20NO2	281	1012379	153410-24H2NO3	284	1012902	1785NRM7	292
1010999	1528S0-80H1	265	1011275	16001/2X20NO3	281	1012380	153410-24H3NO3	284	1012903	1785NRM8	292
1011000	1528S1-64H1	265	1011276	16009/16X12NO2	281	1012381	153410-32H1NO2	284	1012904	1785NRM10	292
1011001	1528S1-72H1	265	1011277	16009/16X12NO3	281	1012382	153410-32H2NO2	284	1012905	1785NRM12	292
1011003	1528S2-56H2	265	1011279	16009/16X18NO3	281	1012383	153410-32H3NO2	284	1012906	1785NRM14	292
1011005	1528S3-48H2	265	1011280	16005/8X11NO2	281	1012385	153410-32H2NO3	284	1012907	1785NRM16	292
1011006	1528S4-36H2	265	1011281	16005/8X11NO3	281	1012386	153410-32H3NO3	284	1012909	1785NRM20	292
1011008	1528S4-40H2	265	1011285	16003/4X10NO3	281	1012388	153412-28H3NO2	284	1012920	1788M3X.5NO2	298
1011010	1528S5-40H2	265	1011287	16003/4X16NO3	281	1012389	153412-24H3NO2	284	1012923	1788M4X.7NO2	298
1011012	1528S6-32H2	265	1011748	15001/4	279	1012659	1785M2	288	1012925	1788M5X.8NO2	298
1011013	1528S6-32H3	265	1011749	15005/16	279	1012662	1785M2.5	288	1012926	1788M6X1.0NO2	298
1011014	1528S6-40H2	265	1011750	15003/8	279	1012664	1785M3	288	1012928	1788M8X1.25NO2	298
1011016	1528S8-32H2	265	1011752	15001/2	279	1012666	1785M3.5	288	1012930	1788M10X1.5NO2	298
1011017	1528S8-32H3	265	1011753	15005/8	279	1012668	1785M4	288	1012932	1788M12X1.75NO2	298
1011018	1528S8-36H2	265	1011754	15851/4	294	1012669	1785M4.5	288	1012940	1788M3X.5NO3	298
1011020	1528S10-24H2	265	1011755	15855/16	294	1012672	1785M5	288	1012943	1788M4X.7NO3	298
1011021	1528S10-24H3	265	1011756	15853/8	294	1012674	1785M6	288	1012945	1788M5X.8NO3	298
1011023	1528S10-32H2	265	1011757	15857/16	294	1012676	1785M7	288	1012946	1788M6X1.0NO3	298
1011024	1528S10-32H3	265	1011758	15851/2	294	1012678	1785M8	288	1012948	1788M8X1.25NO3	298
1011025	1528S12-24H3	265	1011759	15855/8	294	1012680	1785M9	288	1012950	1788M10X1.5NO3	298
1011026	1528S12-28H3	265	1011760	15441/16X27	307	1012682	1785M10	288	1012952	1788M12X1.75NO3	298
1011029	1500S1/4X20	266	1011761	15441/8X27	307	1012685	1785M11	288	1013037	19854-40	244
1011032	1500S1/4X28	266	1011762	15441/4X18	307	1012686	1785M12	288	1013038	19854-48	244
1011035	1500S5/16X18	266	1011763	15443/8X18	307	1012689	1785M14	288	1013039	19855-40	244
1011038	1500S5/16X24	266	1011764	15441/2X14	307	1012693	1785M16	288	1013040	19855-44	244
1011041	1500S3/8X16	266	1011765	15443/4X14	307	1012696	1785M18	288	1013041	19856-32	244
1011044	1500S3/8X24	266	1011766	15441X11.1/2	307	1012699	153412-24H3NO3	284	1013042	19856-40	244
1011045	1500S7/16X14	266	1011767	15441.1/4X11.1/2	307	1012774	15855/8X18H33FLNO2	286	1013043	19858-32	244
1011046	1500S7/16X20	266	1011772	1500L1/4X20	274	1012775	15853/4X16H33FLNO2	286	1013044	19858-36	244
1011047	1500S1/2X13	266	1011775	1500L1/4X28	274	1012813	1585NR1/4X20H12FLNO2	291	1013045	198510-24	244
1011048	1500S1/2X20	266	1011778	1500L5/16X18	274	1012814	1585NR1/4X20H22FLNO2	291	1013046	198510-32	244
1011049	1500S9/16X12	266	1011781	1500L5/16X24	274	1012815	1585NR1/4X20H32FLNO2	291	1013049	19851/4X20	244
1011050	1500S9/16X18	266	1011784	1500L3/8X16	274	1012816	1585NR1/4X20H52FLNO2	291	1013050	19851/4X28	244
1011051	1500S5/8X11	266	1011787	1500L3/8X24	274	1012817	1585NR1/4X20H32FLNO3	291	1013051	19855/16X18	244
1011052	1500S5/8X18	266	1011790	1500L7/16X14	274	1012818	1585NR1/4X20H33FLNO2	291	1013052	19855/16X24	244
1011053	1500S11/16X11	266	1011793	1500L7/16X20	274	1012820	1585NR1/4X28H12FLNO2	291	1013053	19853/8X16	244
1011054	1500S11/16X16	266	1011796	1500L1/2X13	274	1012821	1585NR1/4X28H22FLNO2	291	1013054	19853/8X24	244
1011055	1500S3/4X10	266	1011799	1500L1/2X20	274	1012822	1585NR1/4X28H32FLNO2	291	1013055	19857/16X14	244
1011056	1500S3/4X16	266	1011802	1500L9/16X12	274	1012824	1585NR1/4X28H32FLNO3	291	1013056	19857/16X20	244
1011057	1500S7/8X9	266	1011805	1500L9/16X18	274	1012828	1585NR5/16X18H22FLNO2	291	1013057	19851/2X13	244
1011058	1500S7/8X14	266	1011808	1500L5/8X11	274	1012829	1585NR5/16X18H32FLNO2	291	1013058	19851/2X20	244
1011059	1500S1X8	267	1011811	1500L5/8X18	274	1012830	1585NR5/16X18H52FLNO2	291	1013059	19859/16X12	244
1011060	1500S1X12	267	1011820	1500L3/4X10	274	1012831	1585NR5/16X18H33FLNO3	291	1013060	19859/16X18	244
1011061	1500S1X14	267	1011823	1500L3/4X16	274	1012832	1585NR5/16X18H33FLNO2	291	1013061	19855/8X11	244
1011062	1500S1.1/8X7	267	1011826	1500L7/8X9	274	1012836	1585NR5/16X24H32FLNO2	291	1013062	19855/8X18	244
1011063	1500S1.1/8X12	267	1011829	1500L7/8X14	274	1012842	1585NR3/8X16H23FLNO2	291	1013065	19853/4X10	244
1011064	1500S1.1/4X7	267	1011832	1500L1X8	274	1012843	1585NR3/8X16H33FLNO2	291	1013066	19853/4X16	244

EDP NUMBER INDEX - 1013067 - 1410133

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1013067	19857/8X9	244	1050336	1585A1/2X13	286	1110104	19943/8X24	323	1310400	1580M3X.5NO2	300
1013068	19857/8X14	244	1050340	1585A1/2X20	286	1110110	19947/16X14	323	1310401	1580M3X.5NO3	300
1013069	19851X8	244	1050342	1585A5/8X11	286	1110114	19947/16X20	323	1310402	1580M4X.7NO2	300
1013310	15051.1/8NO1	280	1050344	1585A3/4X10	286	1110120	19941/2X13	323	1310403	1580M4X.7NO3	300
1013311	15051.1/8NO2	280	1052775	1585A3/4X16	286	1110124	19941/2X20	323	1310404	1580M5X.8NO2	300
1013312	15051.1/8NO3	280	1052869	1545A1/16	308	1310004	15802-56H2NO3	299	1310405	1580M5X.8NO3	300
1013313	15051.1/4NO1	280	1052870	1545A1/8	308	1310005	15802-56H3NO3	299	1310406	1580M6X1.0NO2	300
1013314	15051.1/4NO2	280	1052871	1545A1/4	308	1310012	15804-40H3NO2	299	1310407	1580M6X1.0NO3	300
1013315	15051.1/4NO3	280	1052872	1545A3/8	308	1310014	15804-40H3NO3	299	1310408	1580M8X1.25NO2	300
1013316	15051.3/8NO1	280	1052873	1545A1/2	308	1310015	15804-40H5NO3	299	1310409	1580M8X1.25NO3	300
1013317	15051.3/8NO2	280	1052874	1545A3/4	308	1310022	15805-40H3NO3	299	1310410	1580M10X1.5NO2	300
1013318	15051.3/8NO3	280	1060006	TN15001/4X20NO2	269	1310028	15806-32H3NO2	299	1310411	1580M10X1.5NO3	300
1013319	15051.1/2NO1	280	1060017	TN15001/4X28NO2	269	1310029	15806-32H5NO2	299	1310412	1580M12X1.75NO2	300
1013320	15051.1/2NO2	280	1060028	TN15005/16X18NO2	269	1310031	15806-32H3NO3	299	1310413	1580M12X1.75NO3	300
1013321	15051.1/2NO3	280	1060039	TN15005/16X24NO2	269	1310038	15808-32H3NO2	299	1310500	3300M3X.5NO2	302
1013322	15051.5/8NO1	280	1060050	TN15003/8X16NO2	269	1310039	15808-32H5NO2	299	1310501	3300M3X.5NO3	302
1013323	15051.5/8NO2	280	1060061	TN15003/8X24NO2	269	1310041	15808-32H3NO3	299	1310502	3300M4X.7NO2	302
1013324	15051.5/8NO3	280	1060070	TN15007/16X14NO2	269	1310042	15808-32H5NO3	299	1310503	3300M4X.7NO3	302
1013325	15051.3/4NO1	280	1060079	TN15007/16X20NO2	269	1310048	158010-24H4NO2	299	1310504	3300M5X.8NO2	302
1013326	15051.3/4NO2	280	1060088	TN15001/2X13NO2	269	1310051	158010-24H4NO3	299	1310505	3300M5X.8NO3	302
1013327	15051.3/4NO3	280	1060092	TN15001/2X13NO3	269	1310055	158010-32H6NO2	299	1310506	3300M6X1.0NO2	302
1013328	15051.7/8NO1	280	1060097	TN15001/2X20NO2	269	1310057	158010-32H4NO3	299	1310507	3300M6X1.0NO3	302
1013329	15051.7/8NO2	280	1060121	TN15005/8X11NO2	269	1310058	158010-32H6NO3	299	1310508	3300M8X1.25NO2	302
1013330	15051.7/8NO3	280	1060123	TN15005/8X11NO3	269	1310068	15801/4X20H4NO2	299	1310509	3300M8X1.25NO3	302
1013331	15052NO1	280	1060131	TN15005/8X18NO3	269	1310069	15801/4X20H6NO2	299	1310510	3300M10X1.5NO2	302
1013332	15052NO2	280	1060144	TN15003/4X10NO3	269	1310071	15801/4X20H4NO3	299	1310511	3300M10X1.5NO3	302
1013333	15052NO3	280	1060152	TN15003/4X16NO3	269	1310074	15801/4X28H4NO2	299	1321002	3306E4-40X4H3	303
1020002	1534NE4-40X4	293	1060157	TN15007/8X9NO2	269	1310076	15801/4X28H4NO3	299	1321004	3306E4-40X4H5	303
1020004	1534NE6-32X4	293	1060292	TN15851/4-20H32FL	285	1310078	15805/16X18H5NO2	299	1321006	3306E6-32X4H3	303
1020006	1534NE6-32X6	293	1060293	TN15851/4-20H52FL	285	1310080	15805/16X18H5NO3	299	1321014	3306E8-32X4H3	303
1020008	1534NE8-32X4	293	1060295	TN15851/4-20H33FL	285	1310081	15805/16X18H7NO3	299	1321022	3306E10-24X4H4	303
1020010	1534NE8-32X6	293	1060296	TN15851/4-20H53FL	285	1310082	15805/16X24H5NO2	299	1321030	3306E10-32X4H4	303
1020012	1534NE10-24X4	293	1060299	TN15851/4-28H32FL	285	1310086	15803/8X16H5NO2	299	1321038	3306E1/4X20X4H4	303
1020014	1534NE10-24X6	293	1060306	TN15855/16-18H32FL	285	1310088	15803/8X16H5NO3	299	1321062	3306E5/16X18X4H5	303
1020016	1534NE10-32X4	293	1060309	TN15855/16-18H33FL	285	1310092	15803/8X24H5NO3	299	1410016	20104-40X13/16	334
1020018	1534NE10-32X6	293	1060310	TN15855/16-18H53FL	285	1310110	33000-80H2NO3	301	1410022	20105-40X13/16	334
1020020	1534NE1/4X20X4	293	1060313	TN15855/16-24H32FL	285	1310111	33001-64H2NO3	301	1410026	20106-32X13/16	334
1020022	1534NE1/4X20X6	293	1060320	TN15853/8-16H33FL	286	1310112	33001-72H2NO3	301	1410027	20106-32X1	334
1020024	1534NE1/4X28X4	293	1060321	TN15853/8-16H53FL	286	1310113	33002-56H2NO3	301	1410032	20108-32X13/16	334
1020026	1534NE1/4X28X6	293	1060324	TN15853/8-24H33FL	286	1310114	33002-56H3NO3	301	1410033	20108-32X1	334
1020028	1534NE5/16X18X4	293	1060328	TN15857/16-14H33FL	286	1310121	33004-40H3NO2	301	1410038	201010-24X13/16	334
1020030	1534NE5/16X18X6	293	1060332	TN15857/16-20H33FL	286	1310122	33004-40H5NO2	301	1410039	201010-24X1	334
1020032	1534NE5/16X24X4	293	1060336	TN15851/2-13H33FL	286	1310123	33004-40H3NO3	301	1410041	201010-32X13/16	334
1020034	1534NE5/16X24X6	293	1060340	TN15851/2-20H33FL	286	1310131	33005-40H3NO3	301	1410042	201010-32X1	334
1020036	1534NE3/8X16X4	293	1060519	TN15411/8	304	1310132	33005-40H5NO3	301	1410044	201012-24X13/16	334
1020038	1534NE3/8X16X6	293	1060520	TN15411/4	304	1310137	33006-32H3NO2	301	1410047	201012-28X13/16	334
1020040	1534NE3/8X24X4	293	1060521	TN15413/8	304	1310138	33006-32H5NO2	301	1410063	20101/4X20X13/16	334
1020042	1534NE3/8X24X6	293	1060522	TN15411/2	304	1310140	33006-32H3NO3	301	1410064	20101/4X20X1	334
1020044	1534NE7/16X14X6	293	1060523	TN15413/4	304	1310141	33006-32H5NO3	301	1410066	20101/4X20X1.1/2	334
1020046	1534NE7/16X20X6	293	1060530	TN15431/8	312	1310147	33008-32H3NO2	301	1410069	20101/4X28X1	334
1020048	1534NE1/2X13X6	293	1060531	TN15431/4	312	1310148	33008-32H5NO2	301	1410071	20101/4X28X1.1/2	334
1020050	1534NE1/2X20X6	293	1060532	TN15433/8	312	1310150	33008-32H3NO3	301	1410077	20101/4X32X1	334
1050006	1500A1/4X20	268	1060533	TN15431/2	312	1310151	33008-32H5NO3	301	1410079	20105/16X18X13/16	334
1050021	1500A1/4X28	268	1060534	TN15433/4	312	1310157	330010-24H4NO2	301	1410080	20105/16X18X1	334
1050028	1500A5/16X18	268	1060805	TN15344-40	284	1310158	330010-24H6NO2	301	1410082	20105/16X18X1.1/2	334
1050039	1500A5/16X24	268	1062361	TN15346-32	284	1310160	330010-24H4NO3	301	1410083	20105/16X18X2	334
1050050	1500A3/8X16	268	1062370	TN15348-32	284	1310161	330010-24H6NO3	301	1410085	20105/16X24X1	334
1050061	1500A3/8X24	268	1062378	TN153410-24	284	1310163	330010-32H4NO2	301	1410087	20105/16X24X1.1/2	334
1050070	1500A7/16X14	268	1062383	TN153410-32	284	1310164	330010-32H6NO2	301	1410090	20105/16X32X1	334
1050079	1500A7/16X20	268	1062389	TN153412-24	284	1310166	330010-32H4NO3	301	1410093	20103/8X16X1	334
1050088	1500A1/2X13	268	1062668	TN1785M4	288	1310167	330010-32H6NO3	301	1410095	20103/8X16X1.1/2	334
1050097	1500A1/2X20	268	1062672	TN1785M5	288	1310169	330012-24H4NO2	301	1410096	20103/8X16X2	334
1050106	1500A9/16X12	268	1062674	TN1785M6	288	1310177	33001/4X20H4NO2	301	1410097	20103/8X24X1	334
1050113	1500A9/16X18	268	1062678	TN1785M8	288	1310178	33001/4X20H6NO2	301	1410099	20103/8X24X1.1/2	334
1050121	1500A5/8X11	268	1062682	TN1785M10	288	1310180	33001/4X20H4NO3	301	1410101	20107/16X14X1	334
1050128	1500A5/8X18	268	1062686	TN1785M12	288	1310181	33001/4X20H6NO3	301	1410103	20107/16X14X1.1/2	334
1050142	1500A3/4X10	268	1110010	19944-40	323	1310183	33001/4X28H4NO2	301	1410105	20107/16X20X1	334
1050149	1500A3/4X16	268	1110020	19945-40	323	1310185	33001/4X28H4NO3	301	1410107	20107/16X20X1.1/2	334
1050157	1500A7/8X9	268	1110030	19946-32	323	1310187	33005/16X18H5NO2	301	1410110	20101/2X13X1.1/2	335
1050163	1500A7/8X14	268	1110040	19948-32	323	1310188	33005/16X18H7NO2	301	1410111	20101/2X13X2	335
1050170	1500A1X8	268	1110050	199410-24	323	1310189	33005/16X18H5NO3	301	1410114	20101/2X20X1.1/2	335
1050292	1585A1/4X20	285	1110054	199410-32	323	1310190	33005/16X18H7NO3	301	1410117	20109/16X12X1.1/2	335
1050299	1585A1/4X28	285	1110060	199412-24	323	1310195	33003/8X16H5NO2	301	1410120	20109/16X18X1.1/2	335
1050306	1585A5/16X18	285	1110064	199412-28	323	1310196	33003/8X16H7NO2	301	1410123	20105/8X11X1.1/2	335
1050313	1585A5/16X24	285	1110080	19941/4X20	323	1310197	33003/8X16H5NO3	301	1410124	20105/8X11X2	335
1050320	1585A3/8X16	286	1110084	19941/4X28	323	1310198	33003/8X16H7NO3	301	1410126	20105/8X18X1.1/2	335
1050324	1585A3/8X24	286	1110090	19945/16X18	323	1310200	33003/8X24H7NO2	301	1410127	20105/8X18X2	335
1050328	1585A7/16X14	286	1110094	19945/16X24	323	1310202	33003/8X24H7NO3	301	1410131	20103/4X10X2	335
1050332	1585A7/16X20	286	1110100	19943/8X16	323	1310211	33001/2X13H5NO2	301	1410133	20103/4X16X2	335

EDP NUMBER INDEX - 1410135- 3210447

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
1410135	20107/8X9X2	335	1410260	20251X12	343	1716738	1675M20X2.5	235	3210118	47041/4X3/32	474
1410137	20107/8X14X2	335	1410261	20251X14	343	1717510	16781/4X20	245	3210119	47043/16X5/32	474
1410140	20101X8X3	335	1410262	20251.1/8X7	343	1717512	16781/4X28	245	3210120	47047/32X5/32	474
1410142	20101X12X3	335	1410263	20251.1/8X12	343	1717514	16785/16X18	245	3210121	47041/4X5/32	474
1410144	20101X14X3	335	1410264	20251.1/4X7	343	1717518	16783/8X16	245	3210122	47049/32X5/32	474
1410145	20101.1/8X7X3	335	1410265	20251.1/4X12	343	1717530	16787/16X14	245	3210123	47045/16X5/32	474
1410147	20101.1/4X7X3	335	1410266	20251.3/8X6	343	1717532	16787/16X20	245	3210124	47043/8X5/32	474
1410148	20101.1/4X12X3	335	1410267	20251.3/8X12	343	1717534	16781/2X13	245	3210125	47041/4X3/16	474
1410149	20101.3/8X6X3	335	1410268	20251.1/2X6	343	1717538	16785/8X11	245	3210126	47045/16X3/16	474
1410151	20101.1/2X6X3	335	1410269	20251.1/2X12	343	1717542	16783/4X10	245	3210127	47043/8X3/16	474
1410152	20101.1/2X12X3	335	1410270	20251/8X27	343	1717546	16781X8	245	3210128	47047/16X3/16	474
1410153	25105-40X13/16	336	1410271	20251/4X18	343	1717704	1679M6X1.0	249	3210129	47041/2X3/16	474
1410154	25105-44X13/16	336	1410272	20253/8X18	343	1717706	1679M8X1.25	249	3210130	47049/16X3/16	474
1410157	25106-40X13/16	336	1410273	20251/2X14	343	1717708	1679M10X1.25	249	3210131	47045/8X3/16	474
1410159	25108-32X13/16	336	1410274	20253/4X14	343	1717710	1679M10X1.5	249	3210132	47045/16X1/4	475
1410160	25108-32X1	336	1410275	20251X11.1/2	343	1717722	1679M12X1.75	249	3210133	47043/8X1/4	475
1410161	25108-36X13/16	336	1410573	2710M2X.4X13/16	340	1717726	1679M14X2.0	249	3210134	47047/16X1/4	475
1410163	251010-24X13/16	336	1410575	2710M2.5X.45X13/16	340	1717730	1679M16X2.0	249	3210135	47041/2X1/4	475
1410164	251010-24X1	336	1410577	2710M3X.5X13/16	340	1717734	1679M18X2.5	249	3210136	47049/16X1/4	475
1410165	251010-32X13/16	336	1410579	2710M4X.7X13/16	340	1717738	1679M20X2.5	249	3210137	47045/8X1/4	475
1410166	251010-32X1	336	1410580	2710M4.5X.75X13/16	340	1717742	1679M24X3.0	249	3210138	47041/16X1/4	475
1410167	251012-24X13/16	336	1410581	2710M5X.8X1	340	1810007	46001/8	445	3210139	47043/4X1/4	475
1410169	251012-28X13/16	336	1410582	2710M6X1.0X1	340	1810008	46001/4	445	3210140	47043/16X1/4	475
1410172	251011/4X20X1	336	1410584	2710M8X1.25X1	340	1810009	46003/8	445	3210142	47043/8X5/16	475
1410173	251011/4X20X1.1/2	336	1410585	2710M9X1.25X1	340	1810010	46001/2	445	3210143	47047/16X5/16	475
1410174	251011/4X28X13/16	336	1410586	2710M10X1.5X1	340	1810011	46003/4	445	3210144	47041/2X5/16	475
1410175	251011/4X28X1	336	1410588	2710M12X1.75X1.1/2	340	1810012	46001	445	3210145	47049/16X5/16	475
1410176	251011/4X28X1.1/2	336	1410589	2710M14X2.0X1.1/2	340	1810017	3850N8	328	3210146	47045/8X5/16	475
1410178	25105/16X18X1	336	1410590	2710M16X2.0X1.1/2	340	1810018	3850N9	328	3210147	47041/16X5/16	475
1410179	25105/16X18X1.1/2	336	1410591	2710M18X2.5X2	340	1810019	3850N10	328	3210148	47043/4X5/16	475
1410180	25105/16X24X13/16	336	1410592	2710M20X2.5X2	340	1810020	3850N11	328	3210149	47041/3/16X5/16	475
1410181	25105/16X24X1	336	1410609	2325M6X1.0	344	1810021	3850N12	328	3210151	47041/5/16X5/16	475
1410182	25105/16X24X1.1/2	336	1410611	2325M8X1.25	344	1810022	3850N14	328	3210152	47041X5/16	475
1410183	25103/8X16X1	336	1410612	2325M9X1.25	344	1810034	1301D14	347	3210155	47047/16X3/8	475
1410184	25103/8X16X1.1/2	336	1410613	2325M10X1.5	344	1810042	1301D2	347	3210156	47041/2X3/8	475
1410185	25103/8X24X1	336	1410615	2325M12X1.75	344	1810043	1301D3	347	3210157	47049/16X3/8	475
1410186	25103/8X24X1.1/2	336	1410616	2325M14X2.0	344	1810053	8007200	347	3210158	47045/8X3/8	475
1410187	25107/16X14X1	336	1410618	2325M16X2.0	344	1810096	1301D6	347	3210159	47041/16X3/8	475
1410188	25107/16X14X1.1/2	336	1410619	2325M8X2.5	344	1810372	1215T0	327	3210160	47043/4X3/8	475
1410189	25107/16X20X1	336	1410620	2325M18X1.5	344	1810373	1215T1	327	3210161	47041/3/16X3/8	475
1410190	25107/16X20X1.1/2	336	1410621	2325M20X2.5	344	1810374	1215T2	327	3210162	47047/8X3/8	475
1410191	251011/2X13X1.1/2	336	1410630	2710M12X1.75X1	340	1910501	19004OZ	478	3210163	47041/5/16X3/8	475
1410192	251011/2X20X1.1/2	336	1712221	16414-40H3	256	1910502	190016OZLT	478	3210173	47049/16X7/16	475
1410193	25109/16X12X1.1/2	337	1712223	16414-40H5	256	1910503	19001GALLT	478	3210175	47041/16X7/16	475
1410194	25109/16X18X1.1/2	336	1712233	16416-32H3	256	1910504	19005GALP	478	3210176	47043/4X7/16	475
1410195	25105/8X11X1.1/2	337	1712235	16416-32H5	256	1910505	190055GAL	478	3210177	47041/3/16X7/16	475
1410197	25105/8X18X1.1/2	337	1712239	16418-32H3	256	1910506	19005GALD	478	3210178	47047/8X7/16	475
1410199	25103/4X10X2	337	1712241	16418-32H5	256	1910509	19002OZ	478	3210179	47041/5/16X7/16	475
1410200	25103/4X16X2	337	1712254	164110-24H6	256	1910512	19001ZOZ	478	3210180	47041X7/16	475
1410201	25107/8X9X2	337	1712258	164110-32H4	256	1930502	190016OZ	478	3210195	47049/16X1/2	475
1410202	25107/8X14X2	337	1712260	164110-32H6	256	1930503	19001GAL	478	3210202	47041X1/2	475
1410203	20101/8X27X1	334	1712264	16411/4X20H4	256	1950501	19001LB	478	3210210	47041.1/2X1/2	475
1410204	20101/8X27X1.1/2	334	1712266	16411/4X20H6	256	3210001	1800N1	477	3210249	47041/8X1/8	474
1410205	20101/4X18X1.1/2	335	1712270	16411/4X28H4	256	3210002	1800N2	477	3210251	47045/32X1/8	474
1410206	20101/4X18X2	335	1712272	16411/4X28H6	256	3210003	1800N3	477	3210255	47043/16X1/8	474
1410207	20103/8X18X1.1/2	335	1712277	16415/16X18H5	256	3210004	1800N4	477	3210258	47047/32X1/8	474
1410208	20103/8X18X2	335	1712279	16415/16X18H7	256	3210005	1800N5	477	3210259	47041/4X1/8	474
1410209	20101/2X14X2	335	1712285	16415/16X24H7	256	3210006	1800N6	477	3210261	47049/32X1/8	474
1410239	20251/4X20	343	1712289	16413/8X16H5	256	3210007	1800N7	477	3210262	47045/16X1/8	474
1410240	20251/4X28	343	1712291	16413/8X16H7	256	3210008	1800N8	477	3210263	47043/8X1/8	474
1410241	20255/16X18	343	1712297	16413/8X24H7	256	3210009	1800N9	477	3210264	47047/16X1/8	474
1410242	20255/16X24	343	1712301	16411/2X13H5	256	3210010	1800N10	477	3210265	47041/2X1/8	474
1410243	20253/8X16	343	1712304	16411/2X13H8	256	3210011	1800N11	477	3210281	47043/16X3/16	474
1410244	20253/8X24	343	1713051	1671M3X.5	257	3210012	1800N12	477	3210284	47047/32X3/16	474
1410245	20257/16X14	343	1713052	1671M4X.7	257	3210013	1815SET	477	3210287	47049/32X3/16	474
1410246	20257/16X20	343	1713053	1671M5X.8	257	3210014	1816SET	477	3210296	47041/3/16X3/16	474
1410247	20251/2X13	343	1713054	1671M6X1.0	257	3210046	4111-2	479	3210297	47047/8X3/16	475
1410248	20251/2X20	343	1713055	1671M8X1.0	257	3210047	4111-3	479	3210300	47041/4X1/4	475
1410249	20259/16X12	343	1713056	1671M8X1.25	257	3210048	4111-4	479	3210302	47049/32X1/4	475
1410250	20259/16X18	343	1713057	1671M10X1.5	257	3210050	4112-3	479	3210314	47041X1/4	475
1410251	20255/8X11	343	1716510	16741/4X20	230	3210051	4112-4	479	3210338	430N1	479
1410252	20255/8X18	343	1716512	16741/4X28	230	3210053	4113-4	479	3210339	430N2	479
1410253	202511/16X11	343	1716514	16745/16X18	230	3210054	4113-5	479	3210340	430N3	479
1410254	202511/16X16	343	1716518	16743/8X16	230	3210055	4114-5	479	3210341	430N4	479
1410255	20253/4X10	343	1716534	16741/2X13	230	3210057	4115-6	479	3210342	430N5	479
1410256	20253/4X16	343	1716538	16745/8X11	230	3210114	47041/8X3/32	474	3210444	47041/32X3/16	474
1410257	20257/8X9	343	1716542	16743/4X10	230	3210115	47045/32X3/32	474	3210445	47041/3/32X3/16	474
1410258	20257/8X14	343	1716722	1675M12X1.75	235	3210116	47043/16X3/32	474	3210446	47041/5/32X3/16	474
1410259	20251X8	343	1716730	1675M16X2.0	235	3210117	47047/32X3/32	474	3210447	47041/7/32X1/4	475

EDP NUMBER INDEX - 4111502 - 5011097

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
4111502	229CSET	329	5010221	4533N52	423	5010612	4533.2510	424	5010719	453329/32	426
4710588	46021/2X60	457	5010228	4533N51	423	5010619	4533F	424	5010720	453359/64	426
4710589	46025/8X60	457	5010234	4533N50	423	5010622	4533G	424	5010721	453315/16	426
4710590	46023/4X60	457	5010240	4533N49	423	5010623	453317/64	424	5010722	453361/64	426
4710591	46027/8X60	457	5010246	4533N48	423	5010624	4533H	424	5010723	453331/32	426
4710592	46021X60	457	5010251	45335/64	423	5010626	4533I	424	5010724	453363/64	426
4710593	46021/2X82	457	5010252	4533N47	423	5010627	4533J	424	5010725	45331	426
4710594	46025/8X82	457	5010257	4533N46	423	5010628	4533K	424	5010726	45331.1/16	426
4710595	46023/4X82	457	5010259	4533N45	423	5010629	45339/32	424	5010727	45331.1/8	426
4710596	46027/8X82	457	5010267	4533N44	423	5010630	4533L	425	5010728	45331.3/16	426
4710597	46021X82	457	5010273	4533N43	423	5010631	4533M	425	5010729	45331.1/4	426
4710790	46033/8X60	455	5010282	4533N42	423	5010632	453319/64	425	5010731	45331.3/8	426
4710791	46031/2X60	455	5010283	45333/32	423	5010633	4533N	425	5010733	45331.1/2	426
4710793	46033/4X60	455	5010288	4533N41	423	5010636	4533.3105	425	5010734	45361/4	433
4710794	46031X60	455	5010292	4533N40	423	5010638	4533.3115	425	5010735	45369/32	433
4710795	46031.1/4X60	455	5010295	4533N39	423	5010639	4533.3120	425	5010736	45365/16	433
4710796	46031.1/2X60	455	5010299	4533N38	423	5010640	45335/16	425	5010737	453611/32	433
4710797	46031/4X82	455	5010304	4533N37	423	5010642	4533.3135	425	5010738	45363/8	433
4710798	46033/8X82	455	5010309	4533N36	423	5010645	4533O	425	5010739	453613/32	433
4710799	46031/2X82	455	5010316	45337/64	423	5010647	4533P	425	5010740	45367/16	433
4710800	46035/8X82	455	5010318	4533N35	423	5010648	453321/64	425	5010742	45361/2	433
4710801	46033/4X82	455	5010320	4533N34	423	5010649	4533Q	425	5010744	45369/16	433
4710802	46031X82	455	5010324	4533N33	423	5010650	4533R	425	5010746	45365/8	433
4710803	46031.1/4X82	455	5010330	4533N32	424	5010651	453311/32	425	5010748	453611/16	433
4710804	46031.1/2X82	455	5010338	4533N31	424	5010652	4533S	425	5010750	45363/4	433
4710805	46031/4X90	455	5010344	4533.1230	424	5010653	4533T	425	5010752	453613/16	433
4710806	46033/8X90	455	5010346	4533.1240	424	5010654	453323/64	425	5010754	45367/8	433
4710807	46031/2X90	455	5010349	4533.1247	424	5010655	4533U	425	5010756	453615/16	433
4710808	46035/8X90	455	5010350	45331/8	424	5010658	4533.3730	425	5010758	45361	433
4710809	46033/4X90	455	5010354	4533.1260	424	5010659	4533.3740	425	5010778	45317/16	427
4710810	46031X90	455	5010359	4533N30	424	5010660	4533.3745	425	5010780	45311/2	427
4710811	46031.1/4X90	455	5010374	4533N29	424	5010661	45333/8	425	5010782	45319/16	427
4710812	46031.1/2X90	455	5010383	4533N28	424	5010662	4533.3760	425	5010784	45315/8	427
5010054	45351/16	428	5010384	45339/64	424	5010663	4533V	425	5010788	45313/4	427
5010055	45355/64	428	5010391	4533N27	424	5010665	4533W	425	5010792	45317/8	427
5010056	45353/32	428	5010397	4533N26	424	5010666	453325/64	425	5010796	45311	427
5010057	45357/64	428	5010402	4533N25	424	5010667	4533X	425	5010804	45311.1/4	427
5010058	45351/8	428	5010407	4533N24	424	5010668	4533Y	425	5010807	45311.7/16	427
5010060	45355/32	428	5010411	4533N23	424	5010670	453313/32	425	5010812	45311.3/4	427
5010061	453511/64	428	5010416	45335/32	424	5010671	4533Z	425	5010822	45321/2	434
5010062	45353/16	428	5010418	4533N22	424	5010672	453327/64	425	5010826	45325/8	434
5010063	453513/64	428	5010422	4533N21	424	5010673	4533.4355	425	5010828	453211/16	434
5010064	45357/32	428	5010426	4533N20	424	5010674	4533.4365	425	5010830	45323/4	434
5010066	45351/4	428	5010436	4533N19	424	5010675	4533.4370	425	5010834	45327/8	434
5010067	453517/64	428	5010443	4533N18	424	5010676	45337/16	425	5010838	45321	434
5010068	45359/32	428	5010448	453311/64	424	5010677	4533.4385	425	5010842	45321.1/8	434
5010070	45355/16	428	5010451	4533N17	424	5010678	453329/64	425	5010846	45321.1/4	434
5010072	453511/32	428	5010459	4533N16	424	5010679	453315/32	425	5010848	45321.3/8	434
5010074	45353/8	428	5010465	4533N15	424	5010680	453331/64	425	5010850	45321.1/2	434
5010075	453525/64	428	5010469	4533N14	424	5010681	4533.4980	425	5010852	45321.5/8	434
5010076	453513/32	428	5010475	4533N13	424	5010682	4533.4990	425	5010854	45321.3/4	434
5010078	45357/16	428	5010476	4533.1855	424	5010683	4533.4995	425	5010928	45001/8	440
5010081	453531/64	428	5010478	4533.1865	424	5010684	45331/2	425	5010930	45003/16	440
5010082	45351/2	428	5010479	4533.1870	424	5010685	4533.5010	425	5010932	45001/4	440
5010083	453517/32	428	5010480	45333/16	424	5010690	453333/64	425	5010934	45005/16	440
5010084	45359/16	428	5010482	4533.1885	424	5010691	453317/32	425	5010936	45003/8	440
5010086	45355/8	428	5010483	4533N12	424	5010692	453335/64	425	5010938	45007/16	440
5010088	453511/16	428	5010487	4533N11	424	5010693	45339/16	425	5010940	45001/2	440
5010090	45353/4	428	5010492	4533N10	424	5010694	453337/64	425	5010942	45009/16	440
5010094	45357/8	428	5010498	4533N9	424	5010695	453319/32	425	5010944	45005/8	440
5010098	45351	428	5010504	4533N8	424	5010696	453339/64	425	5010948	45003/4	440
5010142	45375/16	433	5010508	4533N7	424	5010698	45335/8	425	5010950	45007/8	440
5010144	45373/8	433	5010513	453313/64	424	5010700	453341/64	425	5010952	45001	440
5010148	45371/2	433	5010515	4533N6	424	5010701	453321/32	425	5011055	45797/16	438
5010152	45375/8	433	5010518	4533N5	424	5010702	453343/64	425	5011056	45791/2	438
5010156	45373/4	433	5010525	4533N4	424	5010703	453311/16	425	5011057	45799/16	438
5010158	453713/16	433	5010533	4533N3	424	5010704	453345/64	425	5011058	45795/8	438
5010160	45377/8	433	5010545	45337/32	424	5010705	453323/32	425	5011059	457911/16	438
5010164	45371	433	5010550	4533N2	424	5010706	453347/64	425	5011060	45793/4	438
5010173	4533N60	423	5010564	4533N1	424	5010708	45333/4	425	5011061	457913/16	438
5010175	4533N59	423	5010576	4533A	424	5010710	453349/64	425	5011062	45797/8	438
5010177	4533N58	423	5010577	453315/64	424	5010711	453325/32	425	5011063	457915/16	438
5010179	4533N57	423	5010585	4533B	424	5010712	453351/64	425	5011064	45791	438
5010186	4533N56	423	5010593	4533C	424	5010713	453313/16	425	5011065	45791.1/16	438
5010187	45333/64	423	5010602	4533D	424	5010714	453353/64	425	5011093	46081/4X60	456
5010198	4533N55	423	5010606	4533.2480	424	5010715	453327/32	426	5011094	46083/8X60	456
5010204	4533N54	423	5010608	4533.2490	424	5010716	453355/64	426	5011095	46081/2X60	456
5010213	4533N53	423	5010609	4533.2495	424	5010717	45337/8	426	5011096	46085/8X60	456
5010219	45331/16	423	5010610	45331/4	424	5010718	453357/64	426	5011097	46083/4X60	456

EDP NUMBER INDEX - 5011098 - 6210117

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
5011098	46081/4X82	456	5110073	9451/4	402	5110608	9803/4	393	5210080	90081/2	400
5011099	46083/8X82	456	5110074	9455/16	402	5110609	9801	393	5210082	90083/4	400
5011100	46081/2X82	456	5110075	9453/8	402	5110613	9811/4	394	5210089	90091/4	399
5011101	46085/8X82	456	5110076	9451/2	402	5110614	9815/16	394	5210090	90093/8	399
5011102	46083/4X82	456	5110077	9455/8	402	5110615	9813/8	394	5210091	90091/2	399
5011103	46081/4X90	456	5110078	94511/16	402	5110617	9811/2	394	5210092	90095/8	399
5011104	46083/8X90	456	5110079	9453/4	402	5110619	9813/4	394	5210093	90093/4	399
5011105	46081/2X90	456	5110080	9457/8	402	5110633	9631/8	389	5210094	90097/8	399
5011106	46085/8X90	456	5110081	9451	402	5110634	9633/16	389	5210095	90091	399
5011107	46083/4X90	456	5110162	9481/8	401	5110635	9631/4	389	5270014	TC90021/4	397
5011108	46081/4X100	456	5110163	9483/16	401	5110636	9635/16	389	5270015	TC90025/16	397
5011109	46083/8X100	456	5110164	9481/4	401	5110637	9633/8	389	5270016	TC90023/8	397
5011110	46081/2X100	456	5110165	9485/16	401	5110638	9631/2	389	5270017	TC90027/16	397
5011111	46085/8X100	456	5110166	9483/8	401	5110639	9635/8	389	5270018	TC90021/2	397
5011112	46083/4X100	456	5110167	9481/2	401	5110640	9633/4	389	5270020	TC90025/8	397
5011129	4587N0	443	5110168	9485/8	401	5110641	9631	389	5270021	TC90023/4	397
5011130	4587N1	443	5110169	9483/4	401	5110660	9601/8X4	409	5270023	TC90021	397
5011131	4587N2	443	5110221	9301/8X3/8	395	5110661	9603/16X4	409	5270028	TC90031/4	398
5011132	4587N3	443	5110222	9303/16X3/8	395	5110662	9601/4X4	409	5270029	TC90035/16	398
5011133	4587N4	443	5110223	9301/4X3/8	395	5110663	9605/16X4	409	5270030	TC90033/8	398
5011134	4587N5	443	5110224	9305/16X3/8	395	5110664	9603/8X4	409	5270031	TC90037/16	398
5011135	4587N6	443	5110225	9303/8X3/8	395	5110665	9601/2X4	409	5270032	TC90031/2	398
5011136	4587N7	443	5110226	9307/16X3/8	395	5110666	9605/8X4	409	5270034	TC90035/8	398
5011137	4587N8	443	5110228	9301/2X1/2	395	5110667	9603/4X4	409	5270035	TC90033/4	398
5011138	4587N9	443	5110229	9309/16X1/2	395	5110669	9601X4	409	5270036	TC90037/8	398
5011139	4587N10	443	5110232	9305/8X5/8	395	5110686	8831/16	407	5270037	TC90031	398
5011146	4591N0	444	5110233	9303/4X5/8	395	5110687	8833/32	407	6210031	47021/4	470
5011147	4591N1	444	5110235	9301X5/8	395	5110688	8831/8	407	6210032	47029/32	470
5011148	4591N2	444	5110237	9301X1	395	5110689	8835/32	407	6210033	47025/16	470
5011149	4591N3	444	5110302	9201/8X3/8	387	5110690	8833/16	407	6210034	470211/32	470
5011150	4591N4	444	5110303	9203/16X3/8	387	5110691	8831/4	407	6210035	47023/8	470
5011151	4591N5	444	5110304	9201/4X3/8	387	5110692	8835/16	407	6210036	470213/32	470
5011152	4591N6	444	5110305	9205/16X3/8	387	5110693	8833/8	407	6210037	47027/16	470
5011153	4591N7	444	5110306	9203/8X3/8	387	5110694	8837/16	407	6210038	470215/32	470
5011154	4591N8	444	5110307	9207/16X3/8	387	5110695	8831/2	407	6210039	47021/2	470
5011155	4591N9	444	5110308	9201/2X3/8	387	5110696	9303/4X3/4	395	6210041	47029/16	470
5011156	4591N10	444	5110309	9201/2X1/2	387	5110700	9059/16X1/2	392	6210042	470219/32	470
5011157	45887/0	432	5110310	9209/16X1/2	387	5110701	9055/8X1/2	392	6210043	47025/8	470
5011158	45886/0	432	5110311	9205/8X1/2	387	5110702	9053/4X1/2	392	6210045	470211/16	470
5011159	45885/0	432	5110312	92011/16X1/2	387	5110708	9203/4X3/4	387	6210047	47023/4	470
5011160	45884/0	432	5110313	9203/4X1/2	387	5110709	9207/8X3/4	387	6210048	470225/32	470
5011161	45883/0	432	5110314	9205/8X5/8	387	5110710	9201X3/4	387	6210049	470213/16	470
5011162	45882/0	432	5110315	92011/16X5/8	387	5110711	9403/4X3/4	408	6210050	470227/32	470
5011164	4588N1	432	5110316	9203/4X5/8	387	5110712	9407/8X3/4	408	6210051	47027/8	470
5011165	4588N2	432	5110317	92013/16X5/8	387	5110713	9401X3/4	408	6210055	47021	470
5011166	4588N3	432	5110318	9207/8X5/8	387	5110715	920K1/8	388	6210065	47022	470
5011167	4588N4	432	5110319	92015/16X5/8	387	5110716	920K3/16	388	6210066	47031/4	473
5011168	4588N5	432	5110320	9201X5/8	387	5110717	920K1/4	388	6210068	47035/16	473
5011169	4588N6	432	5110321	9207/8X7/8	387	5110718	920K5/16	388	6210070	47033/8	473
5011170	4588N7	432	5110323	9201X7/8	387	5110719	920K3/8	388	6210072	47037/16	473
5011171	4588N8	432	5110326	9201X1	387	5110720	920K1/2	388	6210074	47031/2	473
5011172	4588N9	432	5110327	9201.1/8X1	387	5110721	920K5/8	388	6210076	47039/16	473
5011173	4588N10	432	5110328	9201.1/4X1	387	5110722	920K3/4	388	6210078	47035/8	473
5011202	4533E	424	5110330	9201.1/2X1	387	5110723	920K7/8	388	6210080	470311/16	473
5011204	45313/8	427	5110331	9201.1/4X1.1/4	387	5110724	920K1	388	6210082	47033/4	473
5011206	45323/8	434	5110332	9201.1/2X1.1/4	387	5111714	9201.1/8X3/4	387	6210084	470313/16	473
5110001	9401/8X3/8	408	5110364	9231/8	386	5111717	9201.1/2X3/4	387	6210085	47037/8	473
5110002	9403/16X3/8	408	5110365	9235/32	386	5210014	90021/4	397	6210086	470315/16	473
5110003	9401/4X3/8	408	5110366	9233/16	386	5210015	90025/16	397	6210087	47031	473
5110004	9405/16X3/8	408	5110368	9231/4	386	5210016	90023/8	397	6210088	47031.1/16	473
5110005	9403/8X3/8	408	5110369	9239/32	386	5210017	90027/16	397	6210089	47031.1/8	473
5110006	9407/16X3/8	408	5110370	9235/16	386	5210018	90021/2	397	6210090	47031.3/16	473
5110007	9401/2X3/8	408	5110372	9233/8	386	5210019	90029/16	397	6210091	47031.1/4	473
5110008	9401/2X1/2	408	5110373	92313/32	386	5210020	90025/8	397	6210092	47031.5/16	473
5110009	9409/16X1/2	408	5110374	9237/16	386	5210021	90023/4	397	6210093	47031.3/8	473
5110010	9405/8X1/2	408	5110376	9231/2	386	5210022	90027/8	397	6210094	47031.1/2	473
5110011	94011/16X1/2	408	5110378	9235/8	386	5210023	90021	397	6210095	47031.5/8	473
5110012	9403/4X1/2	408	5110380	9233/4	386	5210028	90031/4	398	6210096	47031.3/4	473
5110013	9405/8X5/8	408	5110390	9051/8X3/8	392	5210029	90035/16	398	6210097	47031.7/8	473
5110014	94011/16X5/8	408	5110391	9053/16X3/8	392	5210030	90033/8	398	6210098	47032	473
5110015	9403/4X5/8	408	5110392	9051/4X3/8	392	5210031	90037/16	398	6210099	47032.1/8	473
5110016	94013/16X5/8	408	5110393	9055/16X3/8	392	5210032	90031/2	398	6210100	47032.1/4	473
5110017	9407/8X5/8	408	5110394	9053/8X3/8	392	5210033	90039/16	398	6210107	47051/4	471
5110019	9401X5/8	408	5110395	9057/16X1/2	392	5210034	90035/8	398	6210109	47055/16	471
5110020	9407/8X7/8	408	5110396	9051/2X1/2	392	5210035	90033/4	398	6210111	47053/8	471
5110022	9401X7/8	408	5110602	9801/4	393	5210036	90037/8	398	6210113	47057/16	471
5110025	9401X1	408	5110603	9805/16	393	5210037	90031	398	6210115	47051/2	471
5110071	9451/8	402	5110604	9803/8	393	5210078	90081/4	400	6210116	470517/32	471
5110072	9453/16	402	5110606	9801/2	393	5210079	90083/8	400	6210117	47059/16	471

EDP NUMBER INDEX - 6210118 - 46305902

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
6210118	470519/32	471	46104538	R9501.15/32	21	46204822	1630AP5/8X18	254	46204912	1676AP8X32	245
6210119	47055/8	471	46104539	R95037.5	21	46204823	1630AP6X32	254	46204913	1677APM10X1.25	249
6210120	470521/32	471	46104540	R95038.0	21	46204824	1630AP7/16X14	254	46204914	1677APM10X1.5	249
6210121	470511/16	471	46104541	R9501.1/2	21	46204825	1630AP7/16X20	254	46204915	1677APM12X1.5	249
6210123	47053/4	471	46104542	R95038.5	21	46204826	1630AP7/8X14	254	46204916	1677APM12X1.75	249
6210124	470525/32	471	46104543	R9501.17/32	21	46204827	1630AP7/8X9	254	46204917	1677APM14X1.5	249
6210125	470513/16	471	46104544	R95039.0	21	46204828	1630AP8X32	254	46204918	1677APM14X2.0	249
6210126	47057/8	471	46104545	R95039.5	21	46204829	1659APM10X1.5	242	46204920	1677APM16X2.0	249
6210127	470515/16	471	46104546	R9501.9/16	21	46204831	1659APM12X1.75	242	46204921	1677APM18X1.5	249
6210128	47051	471	46104547	R95040.0	21	46204832	1659APM3X.5	242	46204922	1677APM18X2.5	249
6210137	47061/4	471	46104548	R95041.0	21	46204833	1659APM4X.7	242	46204923	1677APM20X1.5	249
6210139	47065/16	471	46104549	R9501.5/8	21	46204834	1659APM5X.8	242	46204924	1677APM20X2.5	249
6210140	470611/32	471	46104550	R95042.0	21	46204835	1659APM6X1.0	242	46204926	1677APM24X3.0	249
6210141	47063/8	471	46111405	H85332.0	27	46204837	1659APM8X1.25	242	46204927	1677APM4X.7	249
6210142	470613/32	471	46111406	H85333.5	27	46204838	1660APM10X1.5	255	46204928	1677APM5X.8	249
6210143	47067/16	471	46111407	H85335.0	27	46204840	1660APM12X1.75	255	46204929	1677APM6X1.0	249
6210144	470615/32	471	46111408	H85336.5	27	46204841	1660APM3X.5	255	46204930	1677APM8X1.25	249
6210145	47061/2	471	46111409	H85338.0	27	46204842	1660APM4X.7	255	46204932	16787/8X9	245
6210146	470617/32	471	46111410	H85339.5	27	46204843	1660APM5X.8	255	46204933	1681AP1/2X13	258
6210147	47069/16	471	46111411	H85341.0	27	46204844	1660APM6X1.0	255	46204934	1681AP1/2X20	258
6210151	470611/16	471	46111412	H85342.5	27	46204846	1660APM8X1.25	255	46204935	1681AP1/4X20	258
6210153	47063/4	471	46111413	H85532.0	30	46204847	1672AP1/2X13	230	46204936	1681AP1/4X28	258
6210155	470613/16	471	46111414	H85533.5	30	46204848	1672AP1/2X20	230	46204937	1681AP10X24	258
6210157	47067/8	471	46111415	H85535.0	30	46204849	1672AP1/4X20	230	46204938	1681AP10X32	258
6210161	47061	471	46111416	H85536.5	30	46204850	1672AP1/4X28	230	46204940	1681AP1X8	258
6310293	7073/16	480	46111417	H85538.0	30	46204851	1672AP10X24	230	46204941	1681AP3/4X10	258
6310294	7071/4	480	46111418	H85539.5	30	46204852	1672AP10X32	230	46204942	1681AP3/4X16	258
6310295	7075/16	480	46111419	H85541.0	30	46204854	1672AP1X0X8	230	46204943	1681AP3/8X16	258
6310296	7073/8	480	46111420	H85542.5	30	46204855	1672AP3/4X10	230	46204944	1681AP3/8X24	258
6310297	7077/16	480	46111421	H85832.0	33	46204856	1672AP3/4X16	230	46204945	1681AP4X40	258
6310298	7071/2	480	46111422	H85833.5	33	46204857	1672AP3/8X16	230	46204946	1681AP5/16X18	258
6310299	7075/8	480	46111423	H85835.0	33	46204858	1672AP3/8X24	230	46204947	1681AP5/16X24	258
6310300	7073/4	480	46111424	H85836.5	33	46204859	1672AP4X40	230	46204948	1681AP5/8X11	258
6310302	7071	480	46111425	H85838.0	33	46204860	1672AP5/16X18	230	46204950	1681AP6X32	258
6310305	7573/16	480	46111426	H85839.5	33	46204861	1672AP5/16X24	230	46204951	1681AP7/16X14	258
6310306	7571/4	480	46111427	H85841.0	33	46204862	1672AP5/8X11	230	46204952	1681AP7/16X20	258
6310307	7575/16	480	46111428	H85842.5	33	46204863	1672AP5/8X18	230	46204953	1681AP7/8X14	258
6310308	7573/8	480	46196635	E000TINM3	239	46204864	1672AP6X32	230	46204954	1681AP7/8X9	258
6310309	7577/16	480	46196636	E000TINM4	239	46204865	1672AP7/16X14	230	46204955	1681AP8X32	258
6310310	7571/2	480	46196637	E000TINM5	239	46204866	1672AP7/16X20	230	46204956	1687APM10X1.25	260
6310311	7575/8	480	46196638	E000TINM6	239	46204868	1672AP7/8X9	230	46204957	1687APM10X1.5	260
6310312	7573/4	480	46196639	E000TINM8	239	46204869	1672AP8X32	230	46204958	1687APM12X1.5	260
6310314	7571	480	46196690	E000TINM10	239	46204870	1673APM10X1.25	235	46204959	1687APM12X1.75	260
6310317	7273/16	480	46196691	E000TINM12	239	46204871	1673APM10X1.5	235	46204960	1687APM14X1.5	260
6310318	7271/4	480	46196692	E000TINM16	239	46204872	1673APM12X1.5	235	46204961	1687APM14X2.0	260
6310319	7275/16	480	46196693	E000TINM20	240	46204873	1673APM12X1.75	235	46204962	1687APM16X1.5	260
6310320	7273/8	480	46204754	1629AP1/2X13	241	46204874	1673APM14X1.5	235	46204963	1687APM16X2.0	260
6310321	7277/16	480	46204755	1629AP1/2X20	241	46204875	1673APM14X2.0	235	46204967	1687APM20X2.5	260
6310322	7271/2	480	46204756	1629AP1/4X20	241	46204876	1673APM16X1.5	235	46204970	1687APM4X.7	260
6310323	7275/8	480	46204757	1629AP1/4X28	241	46204877	1673APM16X2.0	235	46204971	1687APM5X.8	260
6310324	7273/4	480	46204758	1629AP10X24	241	46204878	1673APM18X1.5	235	46204972	1687APM6X1.0	260
6310326	7271	480	46204759	1629AP10X32	241	46204881	1673APM20X2.5	235	46204973	1687APM8X1.25	260
8110601	65411/8	306	46204791	1629AP1X8	241	46204882	1673APM24X2.0	235	46204974	1691AP1/2X13	259
8110602	65411/4	306	46204792	1629AP3/4X10	241	46204883	1673APM24X3.0	235	46204975	1691AP1/2X20	259
8110603	65413/8	306	46204794	1629AP3/8X16	241	46204884	1673APM4X.7	235	46204976	1691AP1/4X20	259
8110604	65411/2	306	46204795	1629AP3/8X24	241	46204885	1673APM5X.8	235	46204979	1691AP1X8	259
8110605	65413/4	306	46204796	1629AP4X40	241	46204886	1673APM6X1.0	235	46204980	1691AP3/4X10	259
8110606	65411	306	46204797	1629AP5/16X18	241	46204887	1673APM8X1.25	235	46204982	1691AP3/8X16	259
8110607	65411.1/4	306	46204798	1629AP5/16X24	241	46204890	1676AP1/2X13	245	46204983	1691AP3/8X24	259
8110608	65411.1/2	306	46204799	1629AP5/8X11	241	46204891	1676AP1/2X20	245	46204984	1691AP5/16X18	259
8110609	65412	306	46204800	1629AP5/8X18	241	46204892	1676AP1/4X20	245	46204985	1691AP5/16X24	259
46073789	A9011/2	63	46204801	1629AP6X32	241	46204893	1676AP1/4X28	245	46204986	1691AP5/8X11	259
46104481	R9501.7/32	21	46204804	1629AP7/8X9	241	46204894	1676AP10X24	245	46204989	1691AP7/16X20	259
46104482	R95031.0	21	46204805	1629AP8X32	241	46204895	1676AP10X32	245	46204991	1697APM10X1.5	260
46104483	R9501.1/4	21	46204806	1630AP1/2X13	254	46204897	1676AP1X0X8	245	46204993	1697APM12X1.75	260
46104484	R95032.0	21	46204807	1630AP1/2X20	254	46204898	1676AP3/4X10	245	46204997	1697APM16X2.0	260
46104485	R95032.5	21	46204808	1630AP1/4X20	254	46204899	1676AP3/4X16	245	46205000	1697APM20X1.5	260
46104486	R9501.19/64	21	46204809	1630AP1/4X28	254	46204900	1676AP3/8X16	245	46205004	1697APM6X1.0	260
46104487	R95033.0	21	46204810	1630AP10X24	254	46204901	1676AP3/8X24	245	46205005	1697APM8X1.25	260
46104488	R95033.5	21	46204811	1630AP10X32	254	46204902	1676AP4X40	245	46205008	1673APM8X1.0	235
46104489	R95034.0	21	46204813	1630AP1X8	254	46204903	1676AP5/16X18	245	46205009	1673APM12X1.25	235
46104530	R9501.11/32	21	46204814	1630AP3/4X10	254	46204904	1676AP5/16X24	245	46205010	1677APM8X1.0	249
46104531	R95034.5	21	46204815	1630AP3/4X16	254	46204905	1676AP5/8X11	245	46260354	H861N6	34
46104532	R9501.3/8	21	46204816	1630AP3/8X16	254	46204906	1676AP5/8X18	245	46262132	46081X60	456
46104533	R95035.0	21	46204817	1630AP3/8X24	254	46204907	1676AP6X32	245	46262133	46081X82	456
46104534	R95036.0	21	46204818	1630AP4X40	254	46204908	1676AP7/16X14	245	46262134	46081X90	456
46104535	R9501.27/64	21	46204819	1630AP5/16X18	254	46204909	1676AP7/16X20	245	46262135	46081X100	456
46104536	R95036.5	21	46204820	1630AP5/16X24	254	46204910	1676AP7/8X14	245	46305901	A108N10	99
46104537	R95037.0	21	46204821	1630AP5/8X11	254	46204911	1676AP7/8X9	245	46305902	A10815/64	99

EDP NUMBER INDEX - 46305903 - 46719109

EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #	EDP#	E-Code	Page #
46305903	A10817/64	100	46524905	A012S17/64	76	46612329	S406HA3/16	362	46719034	R4597.1	47
46305904	A10819/64	100	46524906	A012S9/32	76	46612330	S406HA1/4	362	46719035	R4599/32	47
46305905	A10821/64	100	46524907	A012S19/64	76	46612331	S406HA5/16	362	46719036	R4597.2	47
46305906	A10823/64	100	46524908	A012S5/16	76	46612332	S406HA3/8	362	46719037	R4597.3	47
46305907	A10825/64	100	46524909	A012S21/64	76	46612333	S406HA7/16	362	46719038	R4597.4	47
46305908	A10827/64	100	46524910	A012S11/32	76	46612334	S406HA1/2	362	46719039	R4597.5	47
46305909	A10829/64	101	46524911	A012S23/64	76	46612335	S406HA9/16	362	46719040	R45919/64	47
46305920	A10831/64	101	46524912	A012S3/8	76	46612336	S406HA5/8	362	46719041	R4597.6	47
46371643	1681AP12X24	258	46524913	A012S25/64	76	46612337	S406HA3/4	362	46719042	R4597.7	47
46381760	G5706.3	463	46524914	A012S13/32	76	46612338	S406HA1	362	46719043	R4597.8	47
46381761	G5708.3	463	46524915	A012S27/64	76	46612339	S406HB3/8	363	46719044	R4597.9	47
46381762	G57010.4	463	46524916	A012S7/16	76	46612340	S406HB7/16	363	46719045	R4595/16	47
46381763	G57012.4	463	46524917	A012S29/64	76	46612341	S406HB1/2	363	46719046	R4598.0	47
46381764	G57016.5	463	46524918	A012S15/32	76	46612342	S406HB9/16	363	46719047	R4598.1	47
46381765	G57020.5	463	46524919	A012S31/64	77	46612343	S406HB5/8	363	46719048	R4598.2	47
46381766	G57025.0	463	46524920	A012S1/2	77	46612344	S406HB3/4	363	46719049	R4598.3	47
46381767	G57031.0	463	46612209	S400HA1/16	356	46612345	S406HB1	363	46719050	R45921/64	47
46381768	G6006.3	465	46612260	S400HA3/32	356	46660543	S405HA1/4XR.020	361	46719051	R4598.4	47
46381769	G6008.3	465	46612261	S400HA1/8	356	46660544	S405HA5/16XR.020	361	46719052	R4598.5	47
46381770	G60010.4	465	46612262	S400HA3/16	356	46660545	S405HA3/8XR.020	361	46719053	R4598.6	47
46381771	G60012.4	465	46612263	S400HA1/4	356	46660546	S405HA3/8XR.030	361	46719054	R4598.7	47
46381772	G60015.0	465	46612264	S400HA5/16	356	46660547	S405HA1/2XR.020	361	46719055	R45911/32	47
46381773	G60016.5	465	46612265	S400HA3/8	356	46660548	S405HA1/2XR.030	361	46719056	R4598.8	47
46381774	G60020.5	465	46612266	S400HA1/2x1	356	46660549	S405HA5/8XR.030	361	46719057	R4598.9	47
46381775	G60025.0	465	46612267	S400HA1/2x2	356	46660550	S405HA5/8XR.060	361	46719058	R4599.0	47
46521338	G2363	469	46612268	S400HA5/8	356	46660551	S405HA3/4XR.030	361	46719059	R4599.1	47
46524831	A002S2.0	80	46612269	S400HA3/4x1.1/2	356	46660552	S405HA3/4XR.060	361	46719060	R45923/64	47
46524832	A002S2.5	80	46612270	S400HA3/4x3	356	46660553	S405HA3/4XR.090	361	46719061	R4599.2	47
46524833	A002S3.0	80	46612271	S401HA5/32	357	46718973	R4593.0	46	46719062	R4599.3	47
46524834	A002S1/8	80	46612272	S401HA1/4	357	46718974	R4593.1	46	46719063	R4599.4	47
46524835	A002S3.2	80	46612273	S401HA5/16	357	46718975	R4591/8	46	46719064	R4599.5	47
46524836	A002S3.3	81	46612274	S401HA3/8	357	46718976	R4593.2	46	46719065	R4593/8	47
46524837	A002S3.5	81	46612275	S401HA1/2	357	46718977	R4593.3	46	46719066	R4599.6	47
46524838	A002S5/32	83	46612276	S401HA5/8	357	46718978	R4593.4	46	46719067	R4599.7	47
46524839	A002S4.0	81	46612277	S401HA3/4	357	46718979	R4593.5	46	46719068	R4599.8	47
46524860	A002S4.1	81	46612278	S402HA1/4x2.1/4	358	46718980	R4599/64	46	46719069	R4599.9	47
46524861	A002S4.2	81	46612279	S402HA3/8x2.1/4	358	46718981	R4593.6	46	46719070	R45925/64	47
46524862	A002S4.5	81	46612280	S402HA1/2x2.1/4	358	46718982	R4593.7	46	46719071	R45910.1	47
46524863	A002S3/16	81	46612281	S402HA5/8x2.1/4	358	46718983	R4593.8	46	46719072	R45910.2	47
46524864	A002S5.0	81	46612282	S402HA3/4x2.1/4	358	46718984	R4593.9	46	46719073	R45910.3	47
46524865	A002S13/64	81	46612283	S402HA1x2.1/4	358	46718985	R4595/32	46	46719074	R45913/32	47
46524866	A002S5.5	81	46612284	S402HA1/2x3.1/4	358	46718986	R4594.0	46	46719075	R45910.4	47
46524867	A002S7/32	81	46612285	S402HA1/2x4	358	46718987	R4594.1	46	46719076	R45910.5	47
46524868	A002S6.0	82	46612286	S402HA5/8x3.1/4	358	46718988	R4594.2	46	46719077	R45927/64	47
46524869	A002S1/4	82	46612287	S402HA5/8x4.1/4	358	46718989	R4594.3	46	46719078	R45910.8	47
46524870	A002S6.5	82	46612288	S402HA3/4x3.1/4	358	46719000	R45911/64	46	46719079	R45911.0	47
46524871	A002S17/64	82	46612289	S402HA3/4x4.1/4	358	46719001	R4594.4	46	46719080	R4597/16	47
46524872	A002S6.8	82	46612290	S402HA1x3.1/4	358	46719002	R4594.5	46	46719081	R45911.2	47
46524873	A002S7.0	82	46612291	S402HA1x4.1/4	358	46719003	R4594.6	46	46719082	R45911.3	48
46524874	A002S7.5	82	46612292	S403HA1/8	359	46719004	R4594.7	46	46719083	R45911.5	48
46524875	A002S5/16	82	46612293	S403HA3/16	359	46719005	R4593/16	46	46719084	R45929/64	48
46524876	A002S8.0	82	46612294	S403HA1/4	359	46719006	R4594.8	46	46719085	R45911.8	48
46524877	A002S8.2	82	46612295	S403HA5/16	359	46719007	R4594.9	46	46719086	R45915/32	48
46524878	A002S8.5	82	46612296	S403HA3/8	359	46719008	R4595.0	46	46719087	R45912.0	48
46524879	A002S9.0	83	46612297	S403HA7/16	359	46719009	R4595.1	46	46719088	R45912.2	48
46524880	A002S9.5	83	46612298	S403HA1/2	359	46719010	R45913/64	46	46719089	R45931/64	48
46524881	A002S3/8	83	46612299	S403HA5/8	359	46719011	R4595.2	46	46719090	R45912.5	48
46524882	A002S10.0	83	46612300	S403HA3/4	359	46719012	R4595.3	46	46719091	R4591/2	48
46524883	A002S10.2	83	46612301	S403HA1	359	46719013	R4595.4	46	46719092	R45912.8	48
46524884	A002S10.5	83	46612302	S404HA1/2xR.060	360	46719014	R4595.5	46	46719093	R45913.0	48
46524885	A002S11.0	83	46612303	S404HA5/8xR.060	360	46719015	R4597/32	46	46719094	R45933/64	48
46524886	A002S11.5	83	46612304	S404HA3/4xR.060	360	46719016	R4595.6	47	46719095	R45917/32	48
46524887	A002S12.0	83	46612305	S404HA1xR.060	360	46719017	R4595.7	47	46719096	R45913.5	48
46524888	A002S12.5	84	46612306	S404HA1/2xR.120	360	46719018	R4595.8	47	46719097	R45935/64	48
46524889	A002S1/2	84	46612307	S404HA5/8xR.120	360	46719019	R4595.9	47	46719098	R45914.0	48
46524890	A002S13.0	84	46612308	S404HA3/4xR.120	360	46719020	R45915/64	47	46719099	R45914.25	48
46524892	A012S1/16	74	46612309	S404HA1xR.120	360	46719021	R4596.0	47	46719100	R4599/16	48
46524893	A012S5/64	75	46612317	S407HA1/8	364	46719022	R4596.1	47	46719101	R45914.5	48
46524894	A012S3/32	75	46612318	S407HA3/16	364	46719023	R4596.2	47	46719102	R45937/64	48
46524895	A012S7/64	75	46612319	S407HA1/4	364	46719024	R4596.3	47	46719103	R45915.0	48
46524896	A012S1/8	75	46612320	S407HA5/16	364	46719025	R4591/4	47	46719104	R45919/32	48
46524897	A012S9/64	75	46612321	S407HA3/8	364	46719026	R4596.4	47	46719105	R45915.1	48
46524898	A012S5/32	75	46612322	S407HA7/16	364	46719027	R4596.5	47	46719106	R45939/64	48
46524899	A012S11/64	75	46612323	S407HA1/2	364	46719028	R4596.6	47	46719107	R45915.5	48
46524900	A012S3/16	75	46612324	S407HA9/16	364	46719029	R4596.7	47	46719108	R4595/8	48
46524901	A012S13/64	75	46612325	S407HA5/8	364	46719030	R45917/64	47	46719109	R45916.0	48
46524902	A012S7/32	76	46612326	S407HA3/4	364	46719031	R4596.8	47			
46524903	A012S15/64	76	46612327	S407HA1	364	46719032	R4596.9	47			
46524904	A012S1/4	76	46612328	S406HA1/8	362	46719033	R4597.0	47			

NOTES

PRODUCT WARRANTY

Precision Dormer, LLC ("The Company").

The Company warrants to original equipment manufacturers, distributors and industrial and commercial users of its products that each new product manufactured by The Company shall be free from material defects and workmanship for one year after delivery by The Company. The Company's exclusive obligation under this warranty is limited to furnishing a replacement for, or at its option, repairing or issuing credit for, any product which is, within one year from the date of delivery by The Company, returned freight prepaid to the plant designated by a representative of The Company and which upon inspection is determined by The Company to be materially defective in material or workmanship.

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