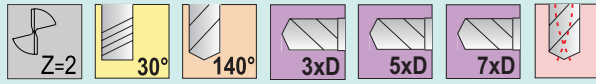


**TOLERANCES**

<i>d</i>	+.0000" - .0005" (+.0000 - .0127mm)	
<i>l1</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)
<i>l2</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)

**Series 1580KH, 1280KH, 1880KH**



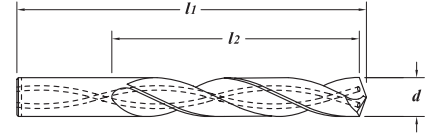
**TECH PAGES**  
328-329

.1181" - .1540"  
(3.000mm - 3.912mm)

Recommended for high nickel, high temperature alloys, cobalt-based alloys, stainless steels, and tool steels >40 Rc

**AlTiN-based Coating**

- High performance - high penetration solid submicron grain carbide drill
- Coolant through capabilities for high pressure coolant systems
- Extended tool life and greater surface finish through faster SFM rates
- Up to 70% faster than standard carbide drills
- 30° helix for better chip evacuation
- Honed cutting edge
- Live tooling recommended on lathe processes



**HIGH PERFORMANCE DRILLS**

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	<i>d</i> † Diameter		<i>l1</i> Overall Length	<i>l2</i> Flute Length
			Decimal	Metric		
22010			.1181	3.000	46	16
	25366		.1181	3.000	50	19
22015		26366	.1181	3.000	65	28
	25371		.1200	#31 3.048	1-13/16"	5/8"
		26371	.1200	#31 3.048	2"	3/4"
22020			.1250	1/8" 3.175	1-15/16"	11/16"
	25376		.1250	1/8" 3.175	2"	3/4"
		26376	.1250	1/8" 3.175	2-1/2"	1-1/8"
22025			.1285	#30 3.264	1-15/16"	11/16"
	25381		.1285	#30 3.264	2-1/4"	3/4"
		26381	.1285	#30 3.264	2-1/2"	1-1/8"
22030			.1360	#29 3.454	2-1/16"	3/4"
	25386		.1360	#29 3.454	2-1/4"	7/8"
		26386	.1360	#29 3.454	3"	1-1/4"
22035			.1378	3.500	52	19
	25391		.1378	3.500	57	22
		26391	.1378	3.500	75	32
22040			.1405	#28 3.569	2-1/16"	3/4"
	25396		.1405	#28 3.569	2-1/4"	7/8"
		26396	.1405	#28 3.569	3"	1-1/4"
22045			.1406	9/64" 3.571	2-1/16"	3/4"
	25401		.1406	9/64" 3.571	2-1/4"	7/8"
		26401	.1406	9/64" 3.571	3"	1-1/4"
22050			.1440	#27 3.658	2-1/16"	3/4"
	25406		.1440	#27 3.658	2-1/4"	7/8"
		26406	.1440	#27 3.658	3"	1-3/8"
22055			.1470	#26 3.734	2-3/16"	13/16"
	25411		.1470	#26 3.734	2-1/4"	7/8"
		26411	.1470	#26 3.734	3"	1-3/8"
22060			.1495	#25 3.797	2-3/16"	13/16"
	25416		.1495	#25 3.797	2-1/4"	15/16"
		26416	.1495	#25 3.797	3"	1-3/8"
22065			.1520	#24 3.861	2-3/16"	13/16"
	25421		.1520	#24 3.861	2-1/4"	15/16"
		26421	.1520	#24 3.861	3"	1-1/2"
22070			.1540	#23 3.912	2-3/16"	13/16"
	25426		.1540	#23 3.912	2-1/4"	15/16"
		26426	.1540	#23 3.912	3"	1-1/2"

Series 1580KH, 1280KH, 1880KH (continued)

.1562" - .1935"  
(3.967mm - 4.915mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	$d^{\dagger}$ Diameter		$l_1$ Overall Length	$l_2$ Flute Length	
			Decimal	Metric			
22075			.1562	5/32"	3.967	2-3/16"	13/16"
	25431		.1562	5/32"	3.967	2-1/2"	15/16"
		26431	.1562	5/32"	3.967	3"	1-1/2"
22080			.1570	#22	3.988	2-3/16"	13/16"
	25436		.1570	#22	3.988	2-1/2"	15/16"
		26436	.1570	#22	3.988	3"	1-1/2"
22085			.1575		4.000	56	21
	25441		.1575		4.000	65	24
		26441	.1575		4.000	75	38
22090			.1590	#21	4.039	2-3/16"	13/16"
	25446		.1590	#21	4.039	2-1/2"	15/16"
		26446	.1590	#21	4.039	3"	1-1/2"
22095			.1610	#20	4.089	2-3/16"	13/16"
	25451		.1610	#20	4.089	2-1/2"	15/16"
		26451	.1610	#20	4.089	3"	1-1/2"
22100			.1660	#19	4.216	2-9/32"	15/16"
	25456		.1660	#19	4.216	2-1/2"	1"
		26456	.1660	#19	4.216	3"	1-1/2"
22105			.1695	#18	4.305	2-9/32"	15/16"
	25461		.1695	#18	4.305	2-1/2"	1"
		26461	.1695	#18	4.305	3-1/2"	1-3/4"
22110			.1719	11/64"	4.366	2-9/32"	15/16"
	25466		.1719	11/64"	4.366	2-1/2"	1"
		26466	.1719	11/64"	4.366	3-1/2"	1-3/4"
22115			.1730	#17	4.394	2-9/32"	15/16"
	25471		.1730	#17	4.394	2-1/2"	1"
		26471	.1730	#17	4.394	3-1/2"	1-3/4"
22120			.1770	#16	4.496	2-9/32"	15/16"
	25476		.1770	#16	4.496	2-1/2"	1"
		26476	.1770	#16	4.496	3-1/2"	1-3/4"
22125			.1772		4.500	58	24
	25481		.1772		4.500	65	25
		26481	.1772		4.500	88	45
22130			.1800	#15	4.572	2-9/32"	15/16"
	25486		.1800	#15	4.572	2-3/4"	1"
		26486	.1800	#15	4.572	3-1/2"	1-3/4"
22135			.1820	#14	4.623	2-9/32"	15/16"
	25491		.1820	#14	4.623	2-3/4"	1"
		26491	.1820	#14	4.623	3-1/2"	1-3/4"
22140			.1850	#13	4.699	2-9/32"	15/16"
	25496		.1850	#13	4.699	2-3/4"	1-1/4"
		26496	.1850	#13	4.699	3-1/2"	1-3/4"
22145			.1875	3/16"	4.763	2-13/32"	1"
	25501		.1875	3/16"	4.763	2-3/4"	1-1/4"
		26501	.1875	3/16"	4.763	4"	2"
22150			.1890	#12	4.801	2-13/32"	1"
	25506		.1890	#12	4.801	2-3/4"	1-1/4"
		26506	.1890	#12	4.801	4"	2"
22155			.1910	#11	4.851	2-13/32"	1"
	25511		.1910	#11	4.851	2-3/4"	1-1/4"
		26511	.1910	#11	4.851	4"	2"
22160			.1935	#10	4.915	2-13/32"	1"
	25516		.1935	#10	4.915	2-3/4"	1-1/4"
		26516	.1935	#10	4.915	4"	2"

# Series 1580KH, 1280KH, 1880KH (continued)

.1960" - .2420"  
(4.978mm - 6.147mm)

HIGH PERFORMANCE  
DRILLS

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	$d^+$ Diameter		$l_1$ Overall Length	$l_2$ Flute Length
			Decimal	Metric		
22165			.1960	#9	4.978	2-13/32"
	25521		.1960	#9	4.978	3"
		26521	.1960	#9	4.978	4"
22170			.1969		5.000	61
	25526		.1969		5.000	75
		26526	.1969		5.000	100
22175			.1990	#8	5.055	2-13/32"
	25531		.1990	#8	5.055	3"
		26531	.1990	#8	5.055	4"
22180			.2010	#7	5.105	2-13/32"
	25536		.2010	#7	5.105	3"
		26536	.2010	#7	5.105	4"
22185			.2031	13/64"	5.159	2-13/32"
	25541		.2031	13/64"	5.159	3"
		26541	.2031	13/64"	5.159	4"
22190			.2040	#6	5.182	2-13/32"
	25546		.2040	#6	5.182	3"
		26546	.2040	#6	5.182	4"
22195			.2055	#5	5.220	2-13/32"
	25551		.2055	#5	5.220	3"
		26551	.2055	#5	5.220	4"
22200			.2090	#4	5.309	2-13/32"
	25556		.2090	#4	5.309	3"
		26556	.2090	#4	5.309	4"
22205			.2130	#3	5.410	2-5/8"
	25561		.2130	#3	5.410	3"
		26561	.2130	#3	5.410	4"
22210			.2165		5.500	67
	25566		.2165		5.500	75
		26566	.2165		5.500	100
22215			.2188	7/32"	5.558	2-5/8"
	25571		.2188	7/32"	5.558	3"
		26571	.2188	7/32"	5.558	4"
22220			.2210	#2	5.613	2-5/8"
	25576		.2210	#2	5.613	3"
		26576	.2210	#2	5.613	4"
22225			.2280	#1	5.791	2-5/8"
	25581		.2280	#1	5.791	3"
		26581	.2280	#1	5.791	4-1/8"
22230			.2340	A	5.944	2-5/8"
	25586		.2340	A	5.944	3-1/4"
		26586	.2340	A	5.944	4-1/8"
22235			.2344	15/64"	5.954	2-5/8"
	25591		.2344	15/64"	5.954	3-1/4"
		26591	.2344	15/64"	5.954	4-1/8"
22240			.2362		6.000	67
	25596		.2362		6.000	80
		26596	.2362		6.000	105
22245			.2380	B	6.045	2-3/4"
	25601		.2380	B	6.045	3-1/4"
		26601	.2380	B	6.045	4-1/8"
22250			.2420	C	6.147	2-3/4"
	25606		.2420	C	6.147	3-1/4"
		26606	.2420	C	6.147	4-1/4"

Series 1580KH, 1280KH, 1880KH (continued)

.2460" - .3125"  
(6.248mm - 7.938mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	$d^{\dagger}$ Diameter		$l_1$ Overall Length	$l_2$ Flute Length	
			Decimal	Metric			
22255	25611		.2460	D	6.248	2-3/4"	1-7/32"
			.2460	D	6.248	3-1/4"	1-5/8"
	26611	.2460	D	6.248	4-1/4"	2-1/4"	
22260	25616		.2500	1/4" / E	6.350	2-3/4"	1-7/32"
			.2500	1/4" / E	6.350	3-1/4"	1-5/8"
	26616	.2500	1/4" / E	6.350	4-1/4"	2-1/4"	
22265	25621		.2559		6.500	70	31
			.2559		6.500	80	41
	26621	.2559		6.500	105	58	
22270	25626		.2570	F	6.528	2-3/4"	1-7/32"
			.2570	F	6.528	3-1/4"	1-11/16"
	26626	.2570	F	6.528	4-3/8"	2-3/8"	
22275	25631		.2610	G	6.629	2-3/4"	1-7/32"
			.2610	G	6.629	3-1/2"	1-11/16"
	26631	.2610	G	6.629	4-3/8"	2-3/8"	
22280	25636		.2656	17/64"	6.746	2-15/16"	1-11/32"
			.2656	17/64"	6.746	3-1/2"	1-11/16"
	26636	.2656	17/64"	6.746	4-3/8"	2-3/8"	
22285	25641		.2660	H	6.756	2-15/16"	1-11/32"
			.2660	H	6.756	3-1/2"	1-11/16"
	26641	.2660	H	6.756	4-3/8"	2-3/8"	
22290	25646		.2720	I	6.909	2-15/16"	1-11/32"
			.2720	I	6.909	3-1/2"	1-11/16"
	26646	.2720	I	6.909	4-3/8"	2-3/8"	
22295	25651		.2756		7.000	75	34
			.2756		7.000	88	43
	26651	.2756		7.000	110	61	
22300	25656		.2770	J	7.036	2-15/16"	1-11/32"
			.2770	J	7.036	3-1/2"	1-11/16"
	26656	.2770	J	7.036	4-3/8"	2-3/8"	
22305	25661		.2810	K	7.137	2-15/16"	1-11/32"
			.2810	K	7.137	3-1/2"	1-3/4"
	26661	.2810	K	7.137	4-7/16"	2-7/16"	
22310	25666		.2812	9/32"	7.142	2-15/16"	1-11/32"
			.2812	9/32"	7.142	3-1/2"	1-3/4"
	26666	.2812	9/32"	7.142	4-7/16"	2-7/16"	
22315	25671		.2900	L	7.366	2-15/16"	1-11/32"
			.2900	L	7.366	3-1/2"	1-3/4"
	26671	.2900	L	7.366	4-7/16"	2-7/16"	
22320	25676		.2950	M	7.493	2-15/16"	1-11/32"
			.2950	M	7.493	3-3/4"	1-3/4"
	26676	.2950	M	7.493	4-7/16"	2-7/16"	
22325	25681		.2953		7.500	75	34
			.2953		7.500	95	44
	26681	.2953		7.500	115	66	
22330	25686		.2969	19/64"	7.541	3-3/32"	1-15/32"
			.2969	19/64"	7.541	3-3/4"	1-7/8"
	26686	.2969	19/64"	7.541	4-9/16"	2-9/16"	
22335	25691		.3020	N	7.671	3-3/32"	1-15/32"
			.3020	N	7.671	3-3/4"	1-7/8"
	26691	.3020	N	7.671	4-9/16"	2-9/16"	
22340	25696		.3125	5/16"	7.938	3-3/32"	1-15/32"
			.3125	5/16"	7.938	3-3/4"	1-7/8"
	26696	.3125	5/16"	7.938	4-11/16"	2-9/16"	

**TOLERANCES**

<i>d</i>	+.0000" - .0005" (+.0000 - .0127mm)	
<i>l1</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)
<i>l2</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)

**Series 1580KH, 1280KH, 1880KH (continued)**



.3150" - .3750"  
(8.000mm - 9.525mm)

Recommended for high nickel, high temperature alloys, cobalt-based alloys, stainless steels, and tool steels >40 Rc

**AlTiN-based Coating**

High performance - high penetration solid submicron grain carbide drill



HIGH PERFORMANCE DRILLS

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	<i>d</i> † Diameter		<i>l1</i> Overall Length	<i>l2</i> Flute Length
			Decimal	Metric		
22345	25701	26701	.3150	8.000	79	37
			.3150	8.000	95	48
				.3150	8.000	120
22350	25706	26706	.3160	O 8.026	3-3/32"	1-15/32"
			.3160	O 8.026	3-3/4"	1-7/8"
				.3160	O 8.026	4-11/16"
22355	25711	26711	.3230	P 8.204	3-3/32"	1-15/32"
			.3230	P 8.204	3-3/4"	2-3/32"
				.3230	P 8.204	4-11/16"
22360	25716	26716	.3281	21/64" 8.334	3-3/32"	1-15/32"
			.3281	21/64" 8.334	4"	2-3/32"
				.3281	21/64" 8.334	4-11/16"
22365	25721	26721	.3320	Q 8.433	3-3/32"	1-15/32"
			.3320	Q 8.433	4"	2-3/32"
				.3320	Q 8.433	4-15/16"
22370	25726	26726	.3346	8.500	79	37
			.3346	8.500	100	53
				.3346	8.500	125
22375	25731	26731	.3390	R 8.611	3-5/16"	1-9/16"
			.3390	R 8.611	4"	2-3/32"
				.3390	R 8.611	4-15/16"
22380	25736	26736	.3438	11/32" 8.733	3-5/16"	1-9/16"
			.3438	11/32" 8.733	4"	2-3/16"
				.3438	11/32" 8.733	4-15/16"
22385	25741	26741	.3480	S 8.839	3-5/16"	1-9/16"
			.3480	S 8.839	4"	2-3/16"
				.3480	S 8.839	5"
22390	25746	26746	.3543	9.000	84	40
			.3543	9.000	100	56
				.3543	9.000	125
22395	25751	26751	.3580	T 9.093	3-5/16"	1-9/16"
			.3580	T 9.093	4-1/4"	2-9/32"
				.3580	T 9.093	5"
22400	25756	26756	.3594	23/64" 9.129	3-5/16"	1-9/16"
			.3594	23/64" 9.129	4-1/4"	2-9/32"
				.3594	23/64" 9.129	5"
22405	25761	26761	.3680	U 9.347	3-5/16"	1-9/16"
			.3680	U 9.347	4-1/4"	2-9/32"
				.3680	U 9.347	5"
22410	25766	26766	.3740	9.500	84	40
			.3740	9.500	105	58
				.3740	9.500	130
22415	25771	26771	.3750	3/8" 9.525	3-1/2"	1-11/16"
			.3750	3/8" 9.525	4-1/4"	2-3/8"
				.3750	3/8" 9.525	5-1/8"

Series 1580KH, 1280KH, 1880KH (continued)

.3770" - .4921"  
(9.576mm - 12.500mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	$d^{\dagger}$ Diameter		$l_1$ Overall Length	$l_2$ Flute Length	
			Decimal	Metric			
22420			.3770	V	9.576	3-1/2"	1-11/16"
	25776		.3770	V	9.576	4-1/4"	2-3/8"
		26776	.3770	V	9.576	5-1/8"	3-1/8"
22425			.3860	W	9.804	3-1/2"	1-11/16"
	25781		.3860	W	9.804	4-1/2"	2-3/8"
		26781	.3860	W	9.804	5-1/8"	3-1/8"
22430			.3906	25/64"	9.921	3-1/2"	1-11/16"
	25786		.3906	25/64"	9.921	4-1/2"	2-3/8"
		26786	.3906	25/64"	9.921	5-1/4"	3-1/4"
22435			.3937		10.000	89	43
	25791		.3937		10.000	115	60
		26791	.3937		10.000	135	83
22440			.3970	X	10.084	3-1/2"	1-11/16"
	25796		.3970	X	10.084	4-1/2"	2-1/2"
		26796	.3970	X	10.084	5-1/4"	3-1/4"
22445			.4040	Y	10.262	3-1/2"	1-11/16"
	25801		.4040	Y	10.262	4-1/2"	2-9/16"
		26801	.4040	Y	10.262	5-3/8"	3-3/8"
22450			.4062	13/32"	10.317	3-1/2"	1-11/16"
	25806		.4062	13/32"	10.317	4-1/2"	2-9/16"
		26806	.4062	13/32"	10.317	5-3/8"	3-3/8"
22455			.4130	Z	10.490	3-1/2"	1-11/16"
	25811		.4130	Z	10.490	4-1/2"	2-5/8"
		26811	.4130	Z	10.490	5-3/8"	3-3/8"
22460			.4134		10.500	89	43
	25816		.4134		10.500	115	67
		26816	.4134		10.500	135	86
22465			.4219	27/64"	10.716	3-3/4"	1-13/16"
	25821		.4219	27/64"	10.716	4-1/2"	2-11/16"
		26821	.4219	27/64"	10.716	5-7/16"	3-7/16"
22470			.4331		11.000	95	46
	25826		.4331		11.000	115	68
		26826	.4331		11.000	135	88
22475			.4375	7/16"	11.113	3-3/4"	1-13/16"
	25831		.4375	7/16"	11.113	4-3/4"	2-13/16"
		26831	.4375	7/16"	11.113	5-7/16"	3-7/16"
22480			.4528		11.500	95	46
	25836		.4528		11.500	120	71
		26836	.4528		11.500	140	91
22485			.4531	29/64"	11.509	3-3/4"	1-13/16"
	25841		.4531	29/64"	11.509	4-3/4"	2-7/8"
		26841	.4531	29/64"	11.509	5-9/16"	3-13/16"
22490			.4688	15/32"	11.908	4"	1-15/16"
	25846		.4688	15/32"	11.908	4-3/4"	2-7/8"
		26846	.4688	15/32"	11.908	5-9/16"	3-13/16"
22495			.4724		12.000	102	49
	25851		.4724		12.000	120	73
		26851	.4724		12.000	140	98
22500			.4844	31/64"	12.304	4"	1-15/16"
	25856		.4844	31/64"	12.304	5-5/16"	3"
		26856	.4844	31/64"	12.304	5-9/16"	3-13/16"
22505			.4921		12.500	102	49
	25861		.4921		12.500	135	76
		26861	.4921		12.500	150	102

# Series 1580KH, 1280KH, 1880KH (continued)

.5000" - .6299"  
(12.700mm - 16.000mm)

HIGH PERFORMANCE  
DRILLS

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	$d$ † Diameter		$l_1$ Overall Length	$l_2$ Flute Length	
			Decimal	Metric			
22510	25866		.5000	1/2"	12.700	4"	1-15/16"
			.5000	1/2"	12.700	5-3/8"	3-1/16"
	26866	.5000	1/2"	12.700	6"	4"	
22515	25871		.5118		13.000	107	53
			.5118		13.000	135	78
	26871	.5118		13.000	150	102	
22520	25876		.5156	33/64"	13.096	4-7/32"	2-3/32"
			.5156	33/64"	13.096	5-3/8"	3-1/8"
	26876	.5156	33/64"	13.096	6"	4"	
22525	25881		.5312	17/32"	13.492	4-7/32"	2-3/32"
			.5312	17/32"	13.492	5-11/16"	3-5/16"
	26881	.5312	17/32"	13.492	6-1/8"	4-1/8"	
22530	25886		.5315		13.500	110	56
			.5315		13.500	145	84
	26886	.5315		13.500	155	105	
22535	25891		.5469	35/64"	13.891	4-5/16"	2-7/32"
			.5469	35/64"	13.891	5-13/16"	3-3/8"
	26891	.5469	35/64"	13.891	6-1/8"	4-1/8"	
22540	25896		.5512		14.000	110	56
			.5512		14.000	145	86
	26896	.5512		14.000	155	105	
22545	25901		.5625	9/16"	14.288	4-9/16"	2-15/32"
			.5625	9/16"	14.288	5-15/16"	3-1/2"
	26901	.5625	9/16"	14.288	6-1/4"	4-3/8"	
22550	25906		.5709		14.500	116	63
			.5709		14.500	150	89
	26906	.5709		14.500	160	109	
22555	25911		.5781	37/64"	14.684	4-15/16"	2-9/16"
			.5781	37/64"	14.684	6"	3-1/2"
	26911	.5781	37/64"	14.684	6-1/4"	4-3/8"	
22560	25916		.5906		15.000	125	65
			.5906		15.000	150	90
	26916	.5906		15.000	160	112	
22565	25921		.5938	19/32"	15.083	4-15/16"	2-9/16"
			.5938	19/32"	15.083	6"	3-9/16"
	26921	.5938	19/32"	15.083	6-3/8"	4-3/8"	
22570	25926		.6094	39/64"	15.479	5-1/16"	2-13/16"
			.6094	39/64"	15.479	6-3/16"	3-11/16"
	26926	.6094	39/64"	15.479	6-7/16"	4-7/16"	
22575	25931		.6102		15.500	129	71
			.6102		15.500	160	94
	26931	.6102		15.500	165	113	
22580	25936		.6250	5/8"	15.875	5-1/4"	3-1/8"
			.6250	5/8"	15.875	6-5/16"	3-3/4"
	26936	.6250	5/8"	15.875	6-9/16"	4-9/16"	
22585			.6299		16.000	133	79
	25941		.6299		16.000	160	95
		26941	.6299		16.000	165	117