

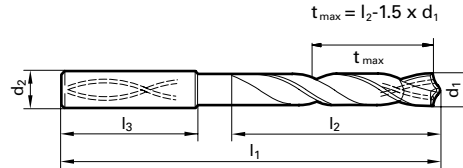
Tool material

Solid Carbide

Surface



- P** Steel ● web thinning $\geq \text{Ø } 3.000$ • facet point grinding • main cutting edge form straight • optimized cutting geometry • double margin
 - M** Stainless steel ○
 - K** Cast iron ● structural and case hardened steels • free-cutting steels, heat-treatable steels • alloyed steels up to 1200 N/mm² • cast materials • bronze, brass
 - N** Aluminum ○ • high-alloyed AlSi-alloys
 - S** Titanium alloys ○
 - H** Hardened steel ○
- =Optimal
○=Limited



For L3 dimensions per DIN 6537, please see page 468
Speeds and feeds information on pg. 576

Diameter (d ₁)			d ₂ mm	l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/tr	mm					
0.1181		3.00	6.00	90.00	45.50	50.00	9055250030000
0.1220		3.10	6.00	90.00	45.35	50.00	9055250031000
0.1248	1/8	3.17	6.00	90.00	45.25	50.00	9055250031700
0.1260		3.20	6.00	90.00	45.20	50.00	9055250032000
0.1280		3.25	6.00	90.00	45.13	50.00	9055250032500
0.1299		3.30	6.00	90.00	45.05	50.00	9055250033000
0.1339		3.40	6.00	90.00	44.90	50.00	9055250034000
0.1378		3.50	6.00	90.00	44.75	50.00	9055250035000
0.1406	9/64 #28	3.57	6.00	90.00	44.65	50.00	9055250035700
0.1417		3.60	6.00	90.00	44.60	50.00	9055250036000
0.1457		3.70	6.00	90.00	44.45	50.00	9055250037000
0.1496	#25	3.80	6.00	102.00	58.30	64.00	9055250038000
0.1535		3.90	6.00	102.00	58.15	64.00	9055250039000
0.1563	5/32	3.97	6.00	102.00	58.05	64.00	9055250039700
0.1575		4.00	6.00	102.00	58.00	64.00	9055250040000
0.1614		4.10	6.00	102.00	57.85	64.00	9055250041000
0.1654		4.20	6.00	102.00	57.70	64.00	9055250042000
0.1693	#18	4.30	6.00	102.00	57.55	64.00	9055250043000
0.1720	11/64	4.37	6.00	102.00	57.45	64.00	9055250043700
0.1732		4.40	6.00	102.00	57.40	64.00	9055250044000
0.1772	#16	4.50	6.00	102.00	57.25	64.00	9055250045000
0.1811		4.60	6.00	102.00	57.10	64.00	9055250046000
0.1831		4.65	6.00	102.00	57.03	64.00	9055250046500
0.1850		4.70	6.00	102.00	56.95	64.00	9055250047000
0.1874	3/16	4.76	6.00	116.00	70.86	78.00	9055250047600
0.1890		4.80	6.00	116.00	70.80	78.00	9055250048000
0.1929		4.90	6.00	116.00	70.65	78.00	9055250049000
0.1969		5.00	6.00	116.00	70.50	78.00	9055250050000
0.2008		5.10	6.00	116.00	70.35	78.00	9055250051000
0.2031	13/64	5.16	6.00	116.00	70.26	78.00	9055250051600
0.2047		5.20	6.00	116.00	70.20	78.00	9055250052000
0.2087		5.30	6.00	116.00	70.05	78.00	9055250053000
0.2126		5.40	6.00	116.00	69.90	78.00	9055250054000
0.2165		5.50	6.00	116.00	69.75	78.00	9055250055000
0.2189	7/32	5.56	6.00	116.00	69.66	78.00	9055250055600
0.2205		5.60	6.00	116.00	69.60	78.00	9055250056000
0.2244		5.70	6.00	116.00	69.45	78.00	9055250057000
0.2283		5.80	6.00	116.00	69.30	78.00	9055250058000
0.2323		5.90	6.00	116.00	69.15	78.00	9055250059000
0.2343	15/64	5.95	6.00	116.00	69.08	78.00	9055250059500
0.2362		6.00	6.00	116.00	69.00	78.00	9055250060000
0.2402		6.10	8.00	146.00	98.85	108.00	9055250061000

Diameter (d ₁)			d ₂ mm	l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/tr	mm					
0.2441		6.20	8.00	146.00	98.70	108.00	9055250062000
0.2480		6.30	8.00	146.00	98.55	108.00	9055250063000
0.2500	1/4 E	6.35	8.00	146.00	98.48	108.00	9055250063500
0.2520		6.40	8.00	146.00	98.40	108.00	9055250064000
0.2559		6.50	8.00	146.00	98.25	108.00	9055250065000
0.2598		6.60	8.00	146.00	98.10	108.00	9055250066000
0.2638		6.70	8.00	146.00	97.95	108.00	9055250067000
0.2657	17/64 H	6.75	8.00	146.00	97.88	108.00	9055250067500
0.2677		6.80	8.00	146.00	97.80	108.00	9055250068000
0.2717		6.90	8.00	146.00	97.65	108.00	9055250069000
0.2756		7.00	8.00	146.00	97.50	108.00	9055250070000
0.2795		7.10	8.00	146.00	97.35	108.00	9055250071000
0.2811	9/32 K	7.14	8.00	146.00	97.29	108.00	9055250071400
0.2835		7.20	8.00	146.00	97.20	108.00	9055250072000
0.2874		7.30	8.00	146.00	97.05	108.00	9055250073000
0.2913		7.40	8.00	146.00	96.90	108.00	9055250074000
0.2953		7.50	8.00	146.00	96.75	108.00	9055250075000
0.2969	19/64	7.54	8.00	146.00	96.69	108.00	9055250075400
0.2992		7.60	8.00	146.00	96.60	108.00	9055250076000
0.3031		7.70	8.00	146.00	96.45	108.00	9055250077000
0.3071		7.80	8.00	146.00	96.30	108.00	9055250078000
0.3110		7.90	8.00	146.00	96.15	108.00	9055250079000
0.3126	5/16	7.94	8.00	146.00	96.09	108.00	9055250079400
0.3150		8.00	8.00	146.00	96.00	108.00	9055250080000
0.3189		8.10	10.00	162.00	107.85	120.00	9055250081000
0.3228		8.20	10.00	162.00	107.70	120.00	9055250082000
0.3268		8.30	10.00	162.00	107.55	120.00	9055250083000
0.3280	21/64	8.33	10.00	162.00	107.51	120.00	9055250083300
0.3307		8.40	10.00	162.00	107.40	120.00	9055250084000
0.3346		8.50	10.00	162.00	107.25	120.00	9055250085000
0.3386		8.60	10.00	162.00	107.10	120.00	9055250086000
0.3425		8.70	10.00	162.00	106.95	120.00	9055250087000
0.3437	11/32	8.73	10.00	162.00	106.91	120.00	9055250087300
0.3465		8.80	10.00	162.00	106.80	120.00	9055250088000
0.3504		8.90	10.00	162.00	106.65	120.00	9055250089000
0.3543		9.00	10.00	162.00	106.50	120.00	9055250090000
0.3583		9.10	10.00	162.00	106.35	120.00	9055250091000
0.3594	23/64	9.13	10.00	162.00	106.31	120.00	9055250091300
0.3622		9.20	10.00	162.00	106.20	120.00	9055250092000
0.3642		9.25	10.00	162.00	106.13	120.00	9055250092500
0.3661		9.30	10.00	162.00	106.05	120.00	9055250093000
0.3701		9.40	10.00	162.00	105.90	120.00	9055250094000

12xD Drills

Diameter (d ₁)			d ₂ mm	l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm					
0.3740		9.50	10.00	162.00	105.75	120.00	9055250095000
0.3748	3/8	9.52	10.00	162.00	105.72	120.00	9055250095200
0.3780		9.60	10.00	162.00	105.60	120.00	9055250096000
0.3819		9.70	10.00	162.00	105.45	120.00	9055250097000
0.3858		9.80	10.00	162.00	105.30	120.00	9055250098000
0.3898		9.90	10.00	162.00	105.15	120.00	9055250099000
0.3906	25/64	9.92	10.00	162.00	105.12	120.00	9055250099200
0.3937		10.00	10.00	162.00	105.00	120.00	9055250100000
0.3976		10.10	12.00	204.00	140.85	156.00	9055250101000
0.4016		10.20	12.00	204.00	140.70	156.00	9055250102000
0.4055		10.30	12.00	204.00	140.55	156.00	9055250103000
0.4063	13/32	10.32	12.00	204.00	140.52	156.00	9055250103200
0.4134		10.50	12.00	204.00	140.25	156.00	9055250105000
0.4173		10.60	12.00	204.00	140.10	156.00	9055250106000
0.4213		10.70	12.00	204.00	139.95	156.00	9055250107000
0.4220	27/64	10.72	12.00	204.00	139.92	156.00	9055250107200
0.4252		10.80	12.00	204.00	139.80	156.00	9055250108000
0.4291		10.90	12.00	204.00	139.65	156.00	9055250109000
0.4331		11.00	12.00	204.00	139.50	156.00	9055250110000
0.4374	7/16	11.11	12.00	204.00	139.34	156.00	9055250111100
0.4528		11.50	12.00	204.00	138.75	156.00	9055250115000
0.4531	29/64	11.51	12.00	204.00	138.74	156.00	9055250115100
0.4689	15/32	11.91	12.00	204.00	138.14	156.00	9055250119100

Diameter (d ₁)			d ₂ mm	l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm					
0.4724		12.00	12.00	204.00	138.00	156.00	9055250120000
0.4843	31/64	12.30	14.00	230.00	163.55	182.00	9055250123000
0.4921		12.50	14.00	230.00	163.25	182.00	9055250125000
0.5000	1/2	12.70	14.00	230.00	162.95	182.00	9055250127000
0.5118		13.00	14.00	230.00	162.50	182.00	9055250130000
0.5311	17/32	13.49	14.00	230.00	161.77	182.00	9055250134900
0.5315		13.50	14.00	230.00	161.75	182.00	9055250135000
0.5469	35/64	13.89	14.00	230.00	161.17	182.00	9055250138900
0.5512		14.00	14.00	230.00	161.00	182.00	9055250140000
0.5709		14.50	16.00	260.00	186.25	208.00	9055250145000
0.5906		15.00	16.00	260.00	185.50	208.00	9055250150000
0.6094	39/64	15.48	16.00	260.00	184.78	208.00	9055250154800
0.6102		15.50	16.00	260.00	184.75	208.00	9055250155000
0.6299		16.00	16.00	260.00	184.00	208.00	9055250160000
0.6496		16.50	18.00	285.00	209.25	234.00	9055250165000
0.6693		17.00	18.00	285.00	208.50	234.00	9055250170000
0.6890		17.50	18.00	285.00	207.75	234.00	9055250175000
0.7087		18.00	18.00	285.00	207.00	234.00	9055250180000
0.7283		18.50	20.00	310.00	230.25	258.00	9055250185000
0.7480		19.00	20.00	310.00	229.50	258.00	9055250190000
0.7500	3/4	19.05	20.00	310.00	229.43	258.00	9055250190500
0.7677		19.50	20.00	310.00	228.75	258.00	9055250195000
0.7874		20.00	20.00	310.00	228.00	258.00	9055250200000

Pilot drilling

It is recommended to utilize a pilot drill for the series 5525 deep hole drill. Use series 5510, or similar drill with m7 diameter tolerance and 140° point, to drill a minimum of 1xD deep. Then enter the pilot hole with the deep hole drill at max. 300RPM and 20IPM stopping shy of the bottom of the pilot hole. Start high pressure coolant and increase RPM to recommended operating speed. Drill at recommended feed rate to hole depth without pecking. Slow to max. 300RPM before retracting.

