

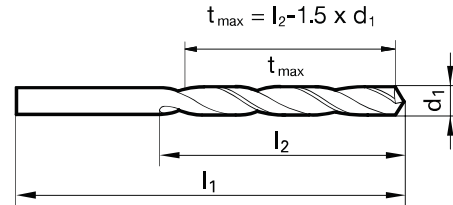
Tool material

HSS

Surface



- P** Steel ● web thinning $\geq \varnothing 1.000$ • relieved cone
 - M** Stainless steel
 - K** Cast iron ● alloyed/unalloyed steel and cast steel • grey cast iron, malleable and spheroidal iron • sintered powder metal, German silver and graphite
 - N** Aluminum ○
 - S** Titanium alloys
 - H** Hardened steel
- =Optimal
○=Limited



Speeds and feeds information on pg. 476

Shank diameter = cut diameter

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0079	#92	0.200	19.00	2.20	2.50	9002050002000
0.0083	#91	0.210	19.00	2.19	2.50	9002050002100
0.0087	#90	0.220	19.00	2.17	2.50	9002050002200
0.0091	#89	0.230	19.00	2.16	2.50	9002050002300
0.0094	#88	0.240	19.00	2.14	2.50	9002050002400
0.0098	#87	0.250	19.00	2.63	3.00	9002050002500
0.0102		0.260	19.00	2.61	3.00	9002050002600
0.0106	#86	0.270	19.00	2.60	3.00	9002050002700
0.0110	#85	0.280	19.00	2.58	3.00	9002050002800
0.0114	#84	0.290	19.00	2.57	3.00	9002050002900
0.0118		0.300	19.00	2.55	3.00	9002050003000
0.0122	#83	0.310	19.00	3.54	4.00	9002050003100
0.0126	#82	0.320	19.00	3.52	4.00	9002050003200
0.0130	#81	0.330	19.00	3.51	4.00	9002050003300
0.0134	#80	0.340	19.00	3.49	4.00	9002050003400
0.0138		0.350	19.00	3.48	4.00	9002050003500
0.0142		0.360	19.00	3.46	4.00	9002050003600
0.0146	#79	0.370	19.00	3.45	4.00	9002050003700
0.0150		0.380	19.00	3.43	4.00	9002050003800
0.0154		0.390	20.00	4.42	5.00	9002050003900
0.0157	1/64	0.400	20.00	4.40	5.00	9002050004000
0.0161	#78	0.410	20.00	4.39	5.00	9002050004100
0.0165		0.420	20.00	4.37	5.00	9002050004200
0.0169		0.430	20.00	4.36	5.00	9002050004300
0.0173		0.440	20.00	4.34	5.00	9002050004400
0.0177		0.450	20.00	4.33	5.00	9002050004500
0.0181	#77	0.460	20.00	4.31	5.00	9002050004600
0.0185		0.470	20.00	4.30	5.00	9002050004700
0.0189		0.480	20.00	4.28	5.00	9002050004800
0.0193		0.490	22.00	5.27	6.00	9002050004900
0.0197		0.500	22.00	5.25	6.00	9002050005000
0.0201	#76	0.510	22.00	5.24	6.00	9002050005100
0.0205		0.520	22.00	5.22	6.00	9002050005200
0.0209	#75	0.530	22.00	5.21	6.00	9002050005300
0.0213		0.540	24.00	6.19	7.00	9002050005400
0.0217		0.550	24.00	6.18	7.00	9002050005500
0.0220		0.560	24.00	6.16	7.00	9002050005600
0.0224	#74	0.570	24.00	6.15	7.00	9002050005700
0.0228		0.580	24.00	6.13	7.00	9002050005800
0.0232		0.590	24.00	6.12	7.00	9002050005900
0.0236		0.600	24.00	6.10	7.00	9002050006000
0.0240	#73	0.610	26.00	7.09	8.00	9002050006100
0.0244		0.620	26.00	7.07	8.00	9002050006200
0.0248		0.630	26.00	7.06	8.00	9002050006300

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #	
inch	wire/ltr	mm					
0.0252	#72	0.640	26.00	7.04	8.00	9002050006400	
0.0256		0.650	26.00	7.03	8.00	9002050006500	
0.0260	#71	0.660	26.00	7.01	8.00	9002050006600	
0.0264		0.670	26.00	7.00	8.00	9002050006700	
0.0268		0.680	28.00	7.98	9.00	9002050006800	
0.0272		0.690	28.00	7.97	9.00	9002050006900	
0.0276		0.700	28.00	7.95	9.00	9002050007000	
0.0280	#70	0.710	28.00	7.94	9.00	9002050007100	
0.0283		0.720	28.00	7.92	9.00	9002050007200	
0.0287		0.730	28.00	7.91	9.00	9002050007300	
0.0291	#69	0.740	28.00	7.89	9.00	9002050007400	
0.0295		0.750	28.00	7.88	9.00	9002050007500	
0.0299		0.760	30.00	8.86	10.00	9002050007600	
0.0303		0.770	30.00	8.85	10.00	9002050007700	
0.0307		0.780	30.00	8.83	10.00	9002050007800	
0.0311	1/32	#68	0.790	30.00	8.82	10.00	9002050007900
0.0315		0.800	30.00	8.80	10.00	9002050008000	
0.0319	#67	0.810	30.00	8.79	10.00	9002050008100	
0.0323		0.820	30.00	8.77	10.00	9002050008200	
0.0327		0.830	30.00	8.76	10.00	9002050008300	
0.0331	#66	0.840	30.00	8.74	10.00	9002050008400	
0.0335		0.850	30.00	8.73	10.00	9002050008500	
0.0339		0.860	32.00	9.71	11.00	9002050008600	
0.0343		0.870	32.00	9.70	11.00	9002050008700	
0.0346		0.880	32.00	9.68	11.00	9002050008800	
0.0350	#65	0.890	32.00	9.67	11.00	9002050008900	
0.0354		0.900	32.00	9.65	11.00	9002050009000	
0.0358	#64	0.910	32.00	9.64	11.00	9002050009100	
0.0362		0.920	32.00	9.62	11.00	9002050009200	
0.0366		0.930	32.00	9.61	11.00	9002050009300	
0.0370	#63	0.940	32.00	9.59	11.00	9002050009400	
0.0374		0.950	32.00	9.58	11.00	9002050009500	
0.0378		0.960	34.00	10.56	12.00	9002050009600	
0.0382	#62	0.970	34.00	10.55	12.00	9002050009700	
0.0386		0.980	34.00	10.53	12.00	9002050009800	
0.0390	#61	0.990	34.00	10.52	12.00	9002050009900	
0.0394		1.000	34.00	10.50	12.00	9002050010000	
0.0398		1.010	34.00	10.49	12.00	9002050010100	
0.0402	#60	1.020	34.00	10.47	12.00	9002050010200	
0.0406		1.030	34.00	10.46	12.00	9002050010300	
0.0409	#59	1.040	34.00	10.44	12.00	9002050010400	
0.0413		1.050	34.00	10.43	12.00	9002050010500	
0.0417		1.060	34.00	10.41	12.00	9002050010600	
0.0421	#58	1.070	36.00	12.40	14.00	9002050010700	

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0425		1.080	36.00	12.38	14.00	9002050010800
0.0429	#57	1.090	36.00	12.37	14.00	9002050010900
0.0433		1.100	36.00	12.35	14.00	9002050011000
0.0437		1.110	36.00	12.34	14.00	9002050011100
0.0441		1.120	36.00	12.32	14.00	9002050011200
0.0445		1.130	36.00	12.31	14.00	9002050011300
0.0449		1.140	36.00	12.29	14.00	9002050011400
0.0453		1.150	36.00	12.28	14.00	9002050011500
0.0457		1.160	36.00	12.26	14.00	9002050011600
0.0461		1.170	36.00	12.25	14.00	9002050011700
0.0465	#56	1.180	36.00	12.23	14.00	9002050011800
0.0469	3/64	1.190	38.00	14.22	16.00	9002050011900
0.0472		1.200	38.00	14.20	16.00	9002050012000
0.0476		1.210	38.00	14.19	16.00	9002050012100
0.0480		1.220	38.00	14.17	16.00	9002050012200
0.0484		1.230	38.00	14.16	16.00	9002050012300
0.0488		1.240	38.00	14.14	16.00	9002050012400
0.0492		1.250	38.00	14.13	16.00	9002050012500
0.0496		1.260	38.00	14.11	16.00	9002050012600
0.0500		1.270	38.00	14.10	16.00	9002050012700
0.0504		1.280	38.00	14.08	16.00	9002050012800
0.0508		1.290	38.00	14.07	16.00	9002050012900
0.0512		1.300	38.00	14.05	16.00	9002050013000
0.0516		1.310	38.00	14.04	16.00	9002050013100
0.0520	#55	1.320	38.00	14.02	16.00	9002050013200
0.0524		1.330	40.00	16.01	18.00	9002050013300
0.0528		1.340	40.00	15.99	18.00	9002050013400
0.0531		1.350	40.00	15.98	18.00	9002050013500
0.0535		1.360	40.00	15.96	18.00	9002050013600
0.0539		1.370	40.00	15.95	18.00	9002050013700
0.0543		1.380	40.00	15.93	18.00	9002050013800
0.0547		1.390	40.00	15.92	18.00	9002050013900
0.0551	#54	1.400	40.00	15.90	18.00	9002050014000
0.0555		1.410	40.00	15.89	18.00	9002050014100
0.0559		1.420	40.00	15.87	18.00	9002050014200
0.0563		1.430	40.00	15.86	18.00	9002050014300
0.0567		1.440	40.00	15.84	18.00	9002050014400
0.0571		1.450	40.00	15.83	18.00	9002050014500
0.0575		1.460	40.00	15.81	18.00	9002050014600
0.0579		1.470	40.00	15.80	18.00	9002050014700
0.0583		1.480	40.00	15.78	18.00	9002050014800
0.0587		1.490	40.00	15.77	18.00	9002050014900
0.0591		1.500	40.00	15.75	18.00	9002050015000
0.0594	#53	1.510	43.00	17.74	20.00	9002050015100
0.0598		1.520	43.00	17.72	20.00	9002050015200
0.0602		1.530	43.00	17.71	20.00	9002050015300
0.0606		1.540	43.00	17.69	20.00	9002050015400
0.0610		1.550	43.00	17.68	20.00	9002050015500
0.0614		1.560	43.00	17.66	20.00	9002050015600
0.0618		1.570	43.00	17.65	20.00	9002050015700
0.0622		1.580	43.00	17.63	20.00	9002050015800
0.0626	1/16	1.590	43.00	17.62	20.00	9002050015900
0.0630		1.600	43.00	17.60	20.00	9002050016000
0.0634	#52	1.610	43.00	17.59	20.00	9002050016100
0.0638		1.620	43.00	17.57	20.00	9002050016200
0.0642		1.630	43.00	17.56	20.00	9002050016300
0.0646		1.640	43.00	17.54	20.00	9002050016400
0.0650		1.650	43.00	17.53	20.00	9002050016500
0.0654		1.660	43.00	17.51	20.00	9002050016600
0.0657		1.670	43.00	17.50	20.00	9002050016700
0.0661		1.680	43.00	17.48	20.00	9002050016800
0.0665		1.690	43.00	17.47	20.00	9002050016900
0.0669	#51	1.700	43.00	17.45	20.00	9002050017000
0.0673		1.710	46.00	19.44	22.00	9002050017100

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0677		1.720	46.00	19.42	22.00	9002050017200
0.0681		1.730	46.00	19.41	22.00	9002050017300
0.0685		1.740	46.00	19.39	22.00	9002050017400
0.0689		1.750	46.00	19.38	22.00	9002050017500
0.0693		1.760	46.00	19.36	22.00	9002050017600
0.0697		1.770	46.00	19.35	22.00	9002050017700
0.0701	#50	1.780	46.00	19.33	22.00	9002050017800
0.0705		1.790	46.00	19.32	22.00	9002050017900
0.0709		1.800	46.00	19.30	22.00	9002050018000
0.0713		1.810	46.00	19.29	22.00	9002050018100
0.0717		1.820	46.00	19.27	22.00	9002050018200
0.0720		1.830	46.00	19.26	22.00	9002050018300
0.0724		1.840	46.00	19.24	22.00	9002050018400
0.0728	#49	1.850	46.00	19.23	22.00	9002050018500
0.0732		1.860	46.00	19.21	22.00	9002050018600
0.0736		1.870	46.00	19.20	22.00	9002050018700
0.0740		1.880	46.00	19.18	22.00	9002050018800
0.0744		1.890	46.00	19.17	22.00	9002050018900
0.0748		1.900	46.00	19.15	22.00	9002050019000
0.0752		1.910	49.00	21.14	24.00	9002050019100
0.0756		1.920	49.00	21.12	24.00	9002050019200
0.0760	#48	1.930	49.00	21.11	24.00	9002050019300
0.0764		1.940	49.00	21.09	24.00	9002050019400
0.0768		1.950	49.00	21.08	24.00	9002050019500
0.0772		1.960	49.00	21.06	24.00	9002050019600
0.0776		1.970	49.00	21.05	24.00	9002050019700
0.0780	5/64	1.980	49.00	21.03	24.00	9002050019800
0.0783	#47	1.990	49.00	21.02	24.00	9002050019900
0.0787		2.000	49.00	21.00	24.00	9002050020000
0.0795		2.020	49.00	20.97	24.00	9002050020200
0.0799		2.030	49.00	20.96	24.00	9002050020300
0.0807		2.050	49.00	20.93	24.00	9002050020500
0.0811	#46	2.060	49.00	20.91	24.00	9002050020600
0.0815		2.070	49.00	20.90	24.00	9002050020700
0.0819	#45	2.080	49.00	20.88	24.00	9002050020800
0.0823		2.090	49.00	20.87	24.00	9002050020900
0.0827		2.100	49.00	20.85	24.00	9002050021000
0.0831		2.110	49.00	20.84	24.00	9002050021100
0.0839		2.130	53.00	23.81	27.00	9002050021300
0.0843		2.140	53.00	23.79	27.00	9002050021400
0.0846		2.150	53.00	23.78	27.00	9002050021500
0.0854		2.170	53.00	23.75	27.00	9002050021700
0.0858	#44	2.180	53.00	23.73	27.00	9002050021800
0.0866		2.200	53.00	23.70	27.00	9002050022000
0.0882		2.240	53.00	23.64	27.00	9002050022400
0.0886		2.250	53.00	23.63	27.00	9002050022500
0.0890	#43	2.260	53.00	23.61	27.00	9002050022600
0.0894		2.270	53.00	23.60	27.00	9002050022700
0.0902		2.290	53.00	23.57	27.00	9002050022900
0.0906		2.300	53.00	23.55	27.00	9002050023000
0.0913		2.320	53.00	23.52	27.00	9002050023200
0.0921		2.340	53.00	23.49	27.00	9002050023400
0.0925		2.350	53.00	23.48	27.00	9002050023500
0.0929		2.360	53.00	23.46	27.00	9002050023600
0.0933	#42	2.370	57.00	26.45	30.00	9002050023700
0.0937	3/32	2.380	57.00	26.43	30.00	9002050023800
0.0941		2.390	57.00	26.42	30.00	9002050023900
0.0945		2.400	57.00	26.40	30.00	9002050024000
0.0953		2.420	57.00	26.37	30.00	9002050024200
0.0957		2.430	57.00	26.36	30.00	9002050024300
0.0961	#41	2.440	57.00	26.34	30.00	9002050024400
0.0965		2.450	57.00	26.33	30.00	9002050024500
0.0969		2.460	57.00	26.31	30.00	9002050024600
0.0972		2.470	57.00	26.30	30.00	9002050024700

Jobber Length

Jobber Length

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0976		2.480	57.00	26.28	30.00	9002050024800
0.0980	#40	2.490	57.00	26.27	30.00	9002050024900
0.0984		2.500	57.00	26.25	30.00	9002050025000
0.0988		2.510	57.00	26.24	30.00	9002050025100
0.0992		2.520	57.00	26.22	30.00	9002050025200
0.0996	#39	2.530	57.00	26.21	30.00	9002050025300
0.1000		2.540	57.00	26.19	30.00	9002050025400
0.1004		2.550	57.00	26.18	30.00	9002050025500
0.1012		2.570	57.00	26.15	30.00	9002050025700
0.1016	#38	2.580	57.00	26.13	30.00	9002050025800
0.1024		2.600	57.00	26.10	30.00	9002050026000
0.1031		2.620	57.00	26.07	30.00	9002050026200
0.1039	#37	2.640	57.00	26.04	30.00	9002050026400
0.1043		2.650	57.00	26.03	30.00	9002050026500
0.1051		2.670	61.00	29.00	33.00	9002050026700
0.1055		2.680	61.00	28.98	33.00	9002050026800
0.1063		2.700	61.00	28.95	33.00	9002050027000
0.1067	#36	2.710	61.00	28.94	33.00	9002050027100
0.1071		2.720	61.00	28.92	33.00	9002050027200
0.1075		2.730	61.00	28.91	33.00	9002050027300
0.1083		2.750	61.00	28.88	33.00	9002050027500
0.1087		2.760	61.00	28.86	33.00	9002050027600
0.1094	7/64	2.780	61.00	28.83	33.00	9002050027800
0.1098	#35	2.790	61.00	28.82	33.00	9002050027900
0.1102		2.800	61.00	28.80	33.00	9002050028000
0.1110	#34	2.820	61.00	28.77	33.00	9002050028200
0.1122		2.850	61.00	28.73	33.00	9002050028500
0.1130	#33	2.870	61.00	28.70	33.00	9002050028700
0.1134		2.880	61.00	28.68	33.00	9002050028800
0.1142		2.900	61.00	28.65	33.00	9002050029000
0.1146		2.910	61.00	28.64	33.00	9002050029100
0.1154		2.930	61.00	28.61	33.00	9002050029300
0.1161	#32	2.950	61.00	28.58	33.00	9002050029500
0.1165		2.960	61.00	28.56	33.00	9002050029600
0.1173		2.980	61.00	28.53	33.00	9002050029800
0.1177		2.990	61.00	28.52	33.00	9002050029900
0.1181		3.000	61.00	28.50	33.00	9002050030000
0.1185		3.010	65.00	31.49	36.00	9002050030100
0.1197		3.040	65.00	31.44	36.00	9002050030400
0.1201	#31	3.050	65.00	31.43	36.00	9002050030500
0.1209		3.070	65.00	31.40	36.00	9002050030700
0.1213		3.080	65.00	31.38	36.00	9002050030800
0.1220		3.100	65.00	31.35	36.00	9002050031000
0.1228		3.120	65.00	31.32	36.00	9002050031200
0.1232		3.130	65.00	31.31	36.00	9002050031300
0.1240		3.150	65.00	31.28	36.00	9002050031500
0.1244		3.160	65.00	31.26	36.00	9002050031600
0.1248	1/8	3.170	65.00	31.25	36.00	9002050031700
0.1252		3.180	65.00	31.23	36.00	9002050031800
0.1260		3.200	65.00	31.20	36.00	9002050032000
0.1268		3.220	65.00	31.17	36.00	9002050032200
0.1272		3.230	65.00	31.16	36.00	9002050032300
0.1280		3.250	65.00	31.13	36.00	9002050032500
0.1283	#30	3.260	65.00	31.11	36.00	9002050032600
0.1299		3.300	65.00	31.05	36.00	9002050033000
0.1307		3.320	65.00	31.02	36.00	9002050033200
0.1319		3.350	65.00	30.98	36.00	9002050033500
0.1339		3.400	70.00	33.90	39.00	9002050034000
0.1346		3.420	70.00	33.87	39.00	9002050034200
0.1358	#29	3.450	70.00	33.83	39.00	9002050034500
0.1378		3.500	70.00	33.75	39.00	9002050035000
0.1386		3.520	70.00	33.72	39.00	9002050035200
0.1398		3.550	70.00	33.68	39.00	9002050035500

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.1406	9/64 #28	3.570	70.00	33.65	39.00	9002050035700
0.1417		3.600	70.00	33.60	39.00	9002050036000
0.1421		3.610	70.00	33.59	39.00	9002050036100
0.1425		3.620	70.00	33.57	39.00	9002050036200
0.1437		3.650	70.00	33.53	39.00	9002050036500
0.1441	#27	3.660	70.00	33.51	39.00	9002050036600
0.1449		3.680	70.00	33.48	39.00	9002050036800
0.1457		3.700	70.00	33.45	39.00	9002050037000
0.1469	#26	3.730	70.00	33.41	39.00	9002050037300
0.1476		3.750	70.00	33.38	39.00	9002050037500
0.1496	#25	3.800	75.00	37.30	43.00	9002050038000
0.1504		3.820	75.00	37.27	43.00	9002050038200
0.1516		3.850	75.00	37.23	43.00	9002050038500
0.1520	#24	3.860	75.00	37.21	43.00	9002050038600
0.1535		3.900	75.00	37.15	43.00	9002050039000
0.1539	#23	3.910	75.00	37.14	43.00	9002050039100
0.1547		3.930	75.00	37.11	43.00	9002050039300
0.1555		3.950	75.00	37.08	43.00	9002050039500
0.1563	5/32	3.970	75.00	37.05	43.00	9002050039700
0.1571	#22	3.990	75.00	37.02	43.00	9002050039900
0.1575		4.000	75.00	37.00	43.00	9002050040000
0.1579		4.010	75.00	36.99	43.00	9002050040100
0.1591	#21	4.040	75.00	36.94	43.00	9002050040400
0.1594		4.050	75.00	36.93	43.00	9002050040500
0.1598		4.060	75.00	36.91	43.00	9002050040600
0.1610	#20	4.090	75.00	36.87	43.00	9002050040900
0.1614		4.100	75.00	36.85	43.00	9002050041000
0.1634		4.150	75.00	36.78	43.00	9002050041500
0.1654		4.200	75.00	36.70	43.00	9002050042000
0.1661	#19	4.220	75.00	36.67	43.00	9002050042200
0.1673		4.250	75.00	36.63	43.00	9002050042500
0.1681		4.270	80.00	40.60	47.00	9002050042700
0.1693	#18	4.300	80.00	40.55	47.00	9002050043000
0.1701		4.320	80.00	40.52	47.00	9002050043200
0.1713		4.350	80.00	40.48	47.00	9002050043500
0.1720	11/64	4.370	80.00	40.45	47.00	9002050043700
0.1728	#17	4.390	80.00	40.42	47.00	9002050043900
0.1732		4.400	80.00	40.40	47.00	9002050044000
0.1740		4.420	80.00	40.37	47.00	9002050044200
0.1752		4.450	80.00	40.33	47.00	9002050044500
0.1772	#16	4.500	80.00	40.25	47.00	9002050045000
0.1780		4.520	80.00	40.22	47.00	9002050045200
0.1783		4.530	80.00	40.21	47.00	9002050045300
0.1791		4.550	80.00	40.18	47.00	9002050045500
0.1799	#15	4.570	80.00	40.15	47.00	9002050045700
0.1811		4.600	80.00	40.10	47.00	9002050046000
0.1819	#14	4.620	80.00	40.07	47.00	9002050046200
0.1831		4.650	80.00	40.03	47.00	9002050046500
0.1850	#13	4.700	80.00	39.95	47.00	9002050047000
0.1870		4.750	80.00	39.88	47.00	9002050047500
0.1874	3/16	4.760	86.00	44.86	52.00	9002050047600
0.1890	#12	4.800	86.00	44.80	52.00	9002050048000
0.1902		4.830	86.00	44.76	52.00	9002050048300
0.1909	#11	4.850	86.00	44.73	52.00	9002050048500
0.1913		4.860	86.00	44.71	52.00	9002050048600
0.1929		4.900	86.00	44.65	52.00	9002050049000
0.1937	#10	4.920	86.00	44.62	52.00	9002050049200
0.1949		4.950	86.00	44.58	52.00	9002050049500
0.1961	#9	4.980	86.00	44.53	52.00	9002050049800
0.1969		5.000	86.00	44.50	52.00	9002050050000
0.1980		5.030	86.00	44.46	52.00	9002050050300
0.1988		5.050	86.00	44.43	52.00	9002050050500
0.1992	#8	5.060	86.00	44.41	52.00	9002050050600

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.2008		5.100	86.00	44.35	52.00	9002050051000
0.2012	#7	5.110	86.00	44.34	52.00	9002050051100
0.2028		5.150	86.00	44.28	52.00	9002050051500
0.2031	13/64	5.160	86.00	44.26	52.00	9002050051600
0.2039	#6	5.180	86.00	44.23	52.00	9002050051800
0.2047		5.200	86.00	44.20	52.00	9002050052000
0.2055	#5	5.220	86.00	44.17	52.00	9002050052200
0.2067		5.250	86.00	44.13	52.00	9002050052500
0.2087		5.300	86.00	44.05	52.00	9002050053000
0.2091	#4	5.310	93.00	49.04	57.00	9002050053100
0.2106		5.350	93.00	48.98	57.00	9002050053500
0.2126		5.400	93.00	48.90	57.00	9002050054000
0.2130	#3	5.410	93.00	48.89	57.00	9002050054100
0.2146		5.450	93.00	48.83	57.00	9002050054500
0.2165		5.500	93.00	48.75	57.00	9002050055000
0.2185		5.550	93.00	48.68	57.00	9002050055500
0.2189	7/32	5.560	93.00	48.66	57.00	9002050055600
0.2205		5.600	93.00	48.60	57.00	9002050056000
0.2209	#2	5.610	93.00	48.59	57.00	9002050056100
0.2224		5.650	93.00	48.53	57.00	9002050056500
0.2244		5.700	93.00	48.45	57.00	9002050057000
0.2264		5.750	93.00	48.38	57.00	9002050057500
0.2280	#1	5.790	93.00	48.32	57.00	9002050057900
0.2283		5.800	93.00	48.30	57.00	9002050058000
0.2303		5.850	93.00	48.23	57.00	9002050058500
0.2323		5.900	93.00	48.15	57.00	9002050059000
0.2339	A	5.940	93.00	48.09	57.00	9002050059400
0.2343	15/64	5.950	93.00	48.08	57.00	9002050059500
0.2350		5.970	93.00	48.05	57.00	9002050059700
0.2354		5.980	93.00	48.03	57.00	9002050059800
0.2362		6.000	93.00	48.00	57.00	9002050060000
0.2374		6.030	101.00	53.96	63.00	9002050060300
0.2378	B	6.040	101.00	53.94	63.00	9002050060400
0.2382		6.050	101.00	53.93	63.00	9002050060500
0.2402		6.100	101.00	53.85	63.00	9002050061000
0.2421	C	6.150	101.00	53.78	63.00	9002050061500
0.2441		6.200	101.00	53.70	63.00	9002050062000
0.2449		6.220	101.00	53.67	63.00	9002050062200
0.2461	D	6.250	101.00	53.63	63.00	9002050062500
0.2480		6.300	101.00	53.55	63.00	9002050063000
0.2500	1/4	6.350	101.00	53.48	63.00	9002050063500
0.2520		6.400	101.00	53.40	63.00	9002050064000
0.2539		6.450	101.00	53.33	63.00	9002050064500
0.2559		6.500	101.00	53.25	63.00	9002050065000
0.2571		6.530	101.00	53.21	63.00	9002050065300
0.2579		6.550	101.00	53.18	63.00	9002050065500
0.2598		6.600	101.00	53.10	63.00	9002050066000
0.2610	G	6.630	101.00	53.06	63.00	9002050066300
0.2618		6.650	101.00	53.03	63.00	9002050066500
0.2638		6.700	101.00	52.95	63.00	9002050067000
0.2657	17/64	6.750	109.00	58.88	69.00	9002050067500
0.2661		6.760	109.00	58.86	69.00	9002050067600
0.2677		6.800	109.00	58.80	69.00	9002050068000
0.2697		6.850	109.00	58.73	69.00	9002050068500
0.2717	I	6.900	109.00	58.65	69.00	9002050069000
0.2736		6.950	109.00	58.58	69.00	9002050069500
0.2756		7.000	109.00	58.50	69.00	9002050070000
0.2768	J	7.030	109.00	58.46	69.00	9002050070300
0.2776		7.050	109.00	58.43	69.00	9002050070500
0.2795		7.100	109.00	58.35	69.00	9002050071000
0.2811	9/32	7.140	109.00	58.29	69.00	9002050071400
0.2815		7.150	109.00	58.28	69.00	9002050071500
0.2835		7.200	109.00	58.20	69.00	9002050072000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.2854		7.250	109.00	58.13	69.00	9002050072500
0.2874		7.300	109.00	58.05	69.00	9002050073000
0.2894		7.350	109.00	57.98	69.00	9002050073500
0.2902	L	7.370	109.00	57.95	69.00	9002050073700
0.2913		7.400	109.00	57.90	69.00	9002050074000
0.2933		7.450	109.00	57.83	69.00	9002050074500
0.2949	M	7.490	109.00	57.77	69.00	9002050074900
0.2953		7.500	109.00	57.75	69.00	9002050075000
0.2969	19/64	7.540	117.00	63.69	75.00	9002050075400
0.2972		7.550	117.00	63.68	75.00	9002050075500
0.2992		7.600	117.00	63.60	75.00	9002050076000
0.3012		7.650	117.00	63.53	75.00	9002050076500
0.3020	N	7.670	117.00	63.50	75.00	9002050076700
0.3031		7.700	117.00	63.45	75.00	9002050077000
0.3051		7.750	117.00	63.38	75.00	9002050077500
0.3071		7.800	117.00	63.30	75.00	9002050078000
0.3091		7.850	117.00	63.23	75.00	9002050078500
0.3110		7.900	117.00	63.15	75.00	9002050079000
0.3126	5/16	7.940	117.00	63.09	75.00	9002050079400
0.3130		7.950	117.00	63.08	75.00	9002050079500
0.3142		7.980	117.00	63.03	75.00	9002050079800
0.3150		8.000	117.00	63.00	75.00	9002050080000
0.3161	O	8.030	117.00	62.96	75.00	9002050080300
0.3169		8.050	117.00	62.93	75.00	9002050080500
0.3189		8.100	117.00	62.85	75.00	9002050081000
0.3201		8.130	117.00	62.81	75.00	9002050081300
0.3209		8.150	117.00	62.78	75.00	9002050081500
0.3228	P	8.200	117.00	62.70	75.00	9002050082000
0.3248		8.250	117.00	62.63	75.00	9002050082500
0.3268		8.300	117.00	62.55	75.00	9002050083000
0.3280	21/64	8.330	117.00	62.51	75.00	9002050083300
0.3287		8.350	117.00	62.48	75.00	9002050083500
0.3307		8.400	117.00	62.40	75.00	9002050084000
0.3319	Q	8.430	117.00	62.36	75.00	9002050084300
0.3327		8.450	117.00	62.33	75.00	9002050084500
0.3346		8.500	117.00	62.25	75.00	9002050085000
0.3366		8.550	125.00	68.18	81.00	9002050085500
0.3386		8.600	125.00	68.10	81.00	9002050086000
0.3390	R	8.610	125.00	68.09	81.00	9002050086100
0.3406		8.650	125.00	68.03	81.00	9002050086500
0.3425		8.700	125.00	67.95	81.00	9002050087000
0.3437	11/32	8.730	125.00	67.91	81.00	9002050087300
0.3445		8.750	125.00	67.88	81.00	9002050087500
0.3465		8.800	125.00	67.80	81.00	9002050088000
0.3480	S	8.840	125.00	67.74	81.00	9002050088400
0.3484		8.850	125.00	67.73	81.00	9002050088500
0.3504		8.900	125.00	67.65	81.00	9002050089000
0.3524		8.950	125.00	67.58	81.00	9002050089500
0.3543		9.000	125.00	67.50	81.00	9002050090000
0.3563		9.050	125.00	67.43	81.00	9002050090500
0.3579	T	9.090	125.00	67.37	81.00	9002050090900
0.3583		9.100	125.00	67.35	81.00	9002050091000
0.3594	23/64	9.130	125.00	67.31	81.00	9002050091300
0.3602		9.150	125.00	67.28	81.00	9002050091500
0.3622		9.200	125.00	67.20	81.00	9002050092000
0.3642		9.250	125.00	67.13	81.00	9002050092500
0.3661		9.300	125.00	67.05	81.00	9002050093000
0.3677	U	9.340	125.00	66.99	81.00	9002050093400
0.3681		9.350	125.00	66.98	81.00	9002050093500
0.3701		9.400	125.00	66.90	81.00	9002050094000
0.3720		9.450	125.00	66.83	81.00	9002050094500
0.3740		9.500	125.00	66.75	81.00	9002050095000
0.3748	3/8	9.520	133.00	72.72	87.00	9002050095200

Jobber Length

Jobber Length

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.3760		9.550	133.00	72.68	87.00	9002050095500
0.3772	V	9.580	133.00	72.63	87.00	9002050095800
0.3780		9.600	133.00	72.60	87.00	9002050096000
0.3799		9.650	133.00	72.53	87.00	9002050096500
0.3819		9.700	133.00	72.45	87.00	9002050097000
0.3839		9.750	133.00	72.38	87.00	9002050097500
0.3858	W	9.800	133.00	72.30	87.00	9002050098000
0.3878		9.850	133.00	72.23	87.00	9002050098500
0.3898		9.900	133.00	72.15	87.00	9002050099000
0.3906	25/64	9.920	133.00	72.12	87.00	9002050099200
0.3917		9.950	133.00	72.08	87.00	9002050099500
0.3937		10.000	133.00	72.00	87.00	9002050100000
0.3953		10.040	133.00	71.94	87.00	9002050100400
0.3969	X	10.080	133.00	71.88	87.00	9002050100800
0.3976		10.100	133.00	71.85	87.00	9002050101000
0.3996		10.150	133.00	71.78	87.00	9002050101500
0.4016		10.200	133.00	71.70	87.00	9002050102000
0.4035		10.250	133.00	71.63	87.00	9002050102500
0.4039	Y	10.260	133.00	71.61	87.00	9002050102600
0.4055		10.300	133.00	71.55	87.00	9002050103000
0.4063	13/32	10.320	133.00	71.52	87.00	9002050103200
0.4075		10.350	133.00	71.48	87.00	9002050103500
0.4094		10.400	133.00	71.40	87.00	9002050104000
0.4130	Z	10.490	133.00	71.27	87.00	9002050104900
0.4134		10.500	133.00	71.25	87.00	9002050105000
0.4173		10.600	133.00	71.10	87.00	9002050106000
0.4213		10.700	142.00	77.95	94.00	9002050107000
0.4220	27/64	10.720	142.00	77.92	94.00	9002050107200
0.4232		10.750	142.00	77.88	94.00	9002050107500
0.4252		10.800	142.00	77.80	94.00	9002050108000
0.4291		10.900	142.00	77.65	94.00	9002050109000
0.4331		11.000	142.00	77.50	94.00	9002050110000
0.4350		11.050	142.00	77.43	94.00	9002050110500
0.4370		11.100	142.00	77.35	94.00	9002050111000
0.4374	7/16	11.110	142.00	77.34	94.00	9002050111100
0.4390		11.150	142.00	77.28	94.00	9002050111500
0.4409		11.200	142.00	77.20	94.00	9002050112000
0.4429		11.250	142.00	77.13	94.00	9002050112500
0.4449		11.300	142.00	77.05	94.00	9002050113000
0.4469		11.350	142.00	76.98	94.00	9002050113500
0.4488		11.400	142.00	76.90	94.00	9002050114000
0.4528		11.500	142.00	76.75	94.00	9002050115000
0.4531	29/64	11.510	142.00	76.74	94.00	9002050115100
0.4567		11.600	142.00	76.60	94.00	9002050116000
0.4606		11.700	142.00	76.45	94.00	9002050117000
0.4626		11.750	142.00	76.38	94.00	9002050117500
0.4646		11.800	142.00	76.30	94.00	9002050118000
0.4685		11.900	151.00	83.15	101.00	9002050119000
0.4689	15/32	11.910	151.00	83.14	101.00	9002050119100
0.4724		12.000	151.00	83.00	101.00	9002050120000
0.4744		12.050	151.00	82.93	101.00	9002050120500
0.4764		12.100	151.00	82.85	101.00	9002050121000
0.4803		12.200	151.00	82.70	101.00	9002050122000
0.4823		12.250	151.00	82.63	101.00	9002050122500
0.4843	31/64	12.300	151.00	82.55	101.00	9002050123000
0.4882		12.400	151.00	82.40	101.00	9002050124000
0.4921		12.500	151.00	82.25	101.00	9002050125000
0.4961		12.600	151.00	82.10	101.00	9002050126000
0.4980		12.650	151.00	82.03	101.00	9002050126500
0.5000	1/2	12.700	151.00	81.95	101.00	9002050127000
0.5020		12.750	151.00	81.88	101.00	9002050127500
0.5039		12.800	151.00	81.80	101.00	9002050128000
0.5059		12.850	151.00	81.73	101.00	9002050128500
0.5079		12.900	151.00	81.65	101.00	9002050129000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.5118		13.000	151.00	81.50	101.00	9002050130000
0.5157	33/64	13.100	151.00	81.35	101.00	9002050131000
0.5197		13.200	151.00	81.20	101.00	9002050132000
0.5217		13.250	160.00	88.13	108.00	9002050132500
0.5236		13.300	160.00	88.05	108.00	9002050133000
0.5276		13.400	160.00	87.90	108.00	9002050134000
0.5311	17/32	13.490	160.00	87.77	108.00	9002050134900
0.5315		13.500	160.00	87.75	108.00	9002050135000
0.5354		13.600	160.00	87.60	108.00	9002050136000
0.5394		13.700	160.00	87.45	108.00	9002050137000
0.5413		13.750	160.00	87.38	108.00	9002050137500
0.5433		13.800	160.00	87.30	108.00	9002050138000
0.5469	35/64	13.890	160.00	87.17	108.00	9002050138900
0.5472		13.900	160.00	87.15	108.00	9002050139000
0.5512		14.000	160.00	87.00	108.00	9002050140000
0.5551		14.100	169.00	92.85	114.00	9002050141000
0.5591		14.200	169.00	92.70	114.00	9002050142000
0.5610		14.250	169.00	92.63	114.00	9002050142500
0.5626	9/16	14.290	169.00	92.57	114.00	9002050142900
0.5630		14.300	169.00	92.55	114.00	9002050143000
0.5669		14.400	169.00	92.40	114.00	9002050144000
0.5709		14.500	169.00	92.25	114.00	9002050145000
0.5748		14.600	169.00	92.10	114.00	9002050146000
0.5780	37/64	14.680	169.00	91.98	114.00	9002050146800
0.5787		14.700	169.00	91.95	114.00	9002050147000
0.5807		14.750	169.00	91.88	114.00	9002050147500
0.5827		14.800	169.00	91.80	114.00	9002050148000
0.5846		14.850	169.00	91.73	114.00	9002050148500
0.5866		14.900	169.00	91.65	114.00	9002050149000
0.5906		15.000	169.00	91.50	114.00	9002050150000
0.5937	19/32	15.080	178.00	97.38	120.00	9002050150800
0.5945		15.100	178.00	97.35	120.00	9002050151000
0.5984		15.200	178.00	97.20	120.00	9002050152000
0.6004		15.250	178.00	97.13	120.00	9002050152500
0.6024		15.300	178.00	97.05	120.00	9002050153000
0.6063		15.400	178.00	96.90	120.00	9002050154000
0.6094	39/64	15.480	178.00	96.78	120.00	9002050154800
0.6102		15.500	178.00	96.75	120.00	9002050155000
0.6142		15.600	178.00	96.60	120.00	9002050156000
0.6181		15.700	178.00	96.45	120.00	9002050157000
0.6201		15.750	178.00	96.38	120.00	9002050157500
0.6220		15.800	178.00	96.30	120.00	9002050158000
0.6248	5/8	15.870	178.00	96.20	120.00	9002050158700
0.6260		15.900	178.00	96.15	120.00	9002050159000
0.6299		16.000	178.00	96.00	120.00	9002050160000
0.6339		16.100	184.00	100.85	125.00	9002050161000
0.6378		16.200	184.00	100.70	125.00	9002050162000
0.6398		16.250	184.00	100.63	125.00	9002050162500
0.6406	41/64	16.270	184.00	100.60	125.00	9002050162700
0.6417		16.300	184.00	100.55	125.00	9002050163000
0.6457		16.400	184.00	100.40	125.00	9002050164000
0.6496		16.500	184.00	100.25	125.00	9002050165000
0.6535		16.600	184.00	100.10	125.00	9002050166000
0.6563	21/32	16.670	184.00	100.00	125.00	9002050166700
0.6575		16.700	184.00	99.95	125.00	9002050167000
0.6594		16.750	184.00	99.88	125.00	9002050167500
0.6614		16.800	184.00	99.80	125.00	9002050168000
0.6654		16.900	184.00	99.65	125.00	9002050169000
0.6693		17.000	184.00	99.50	125.00	9002050170000
0.6720	43/64	17.070	191.00	104.40	130.00	9002050170700
0.6772		17.200	191.00	104.20	130.00	9002050172000
0.6791		17.250	191.00	104.13	130.00	9002050172500
0.6811		17.300	191.00	104.05	130.00	9002050173000
0.6850		17.400	191.00	103.90	130.00	9002050174000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.6874	11/16	17.460	191.00	103.81	130.00	9002050174600
0.6890		17.500	191.00	103.75	130.00	9002050175000
0.6929		17.600	191.00	103.60	130.00	9002050176000
0.6969		17.700	191.00	103.45	130.00	9002050177000
0.6988		17.750	191.00	103.38	130.00	9002050177500
0.7008		17.800	191.00	103.30	130.00	9002050178000
0.7031	45/64	17.860	191.00	103.21	130.00	9002050178600
0.7047		17.900	191.00	103.15	130.00	9002050179000
0.7087		18.000	191.00	103.00	130.00	9002050180000
0.7126		18.100	198.00	107.85	135.00	9002050181000
0.7165		18.200	198.00	107.70	135.00	9002050182000
0.7185		18.250	198.00	107.63	135.00	9002050182500
0.7189	23/32	18.260	198.00	107.61	135.00	9002050182600
0.7205		18.300	198.00	107.55	135.00	9002050183000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.7244		18.400	198.00	107.40	135.00	9002050184000
0.7283		18.500	198.00	107.25	135.00	9002050185000
0.7343	47/64	18.650	198.00	107.03	135.00	9002050186500
0.7382		18.750	198.00	106.88	135.00	9002050187500
0.7402		18.800	198.00	106.80	135.00	9002050188000
0.7480		19.000	198.00	106.50	135.00	9002050190000
0.7500	3/4	19.050	205.00	111.43	140.00	9002050190500
0.7520		19.100	205.00	111.35	140.00	9002050191000
0.7559		19.200	205.00	111.20	140.00	9002050192000
0.7579		19.250	205.00	111.13	140.00	9002050192500
0.7677		19.500	205.00	110.75	140.00	9002050195000
0.7717		19.600	205.00	110.60	140.00	9002050196000
0.7776		19.750	205.00	110.38	140.00	9002050197500
0.7811	25/32	19.840	205.00	110.24	140.00	9002050198400

Jobber Length

Series # 205

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	- 32	150 301	100 80	0.0017 0.0015	0.005 0.004	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100	0.0125 0.0100	0.0140 0.0110			
Free-cutting steels	25 32	255 301	100 80	0.0017 0.0015	0.005 0.004	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100	0.0125 0.0100	0.0140 0.0110			
Unalloyed heat-treatable steels	20 25 32	220 255 301	100 80	0.0015 0.0015	0.004 0.004	0.0065 0.0065	0.0080 0.0080	0.0100 0.0100	0.0100 0.0100	0.0110 0.0110			
Alloyed heat-treatable steels	32 43	301 402											
Unalloyed case hardened steels	25	255	100	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Alloyed case hardened steels	32 43	301 402											
Nitriding steels	32 43	301 402											
Tool steels	25 43	255 402	50	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
High speed steels	43	402											
Spring steels	38	354											
Hardened steels	48 66	460 -											
Stainless steels, sulphured austenitic martensitic	28 36 46	273 337 435											
Cast iron	23 38	242 354	100 80	0.0017 0.0017	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Spheroidal graphite iron and malleable cast iron	23 38	242 354	90 65	0.0017 0.0017	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Chilled cast iron	38	354											
New cast materials GGV	20 32	220 301											
New cast materials ADI	32 43	301 402											
Special alloys	54	549											
Ti and Ti-alloys	25 43	255 402											
Aluminium and Al-alloys	-	120											
Al wrought alloys	-	200											
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	180 180	205 130	0.0020 0.0017	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125	0.0160 0.0125	0.0180 0.0140			
Magnesium alloys	-	120	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Copper, low-alloyed	-	150	100	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110			
Brass, short-chipping long-chipping	- -	180 180	205 130	0.0015 0.0015	0.0040 0.0040	0.0065 0.0065	0.0080 0.0080	0.0100 0.0100	0.0100 0.0100	0.0110 0.0110			
Bronze, short-chipping	-	180	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
Bronze, long-chipping	25 32	255 301	90 80	0.0012 0.0012	0.0030 0.0030	0.0050 0.0050	0.0065 0.0065	0.0080 0.0080	0.0080 0.0080	0.0090 0.0090			
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			50 80	0.0012 0.0015	0.0030 0.0040	0.0050 0.0065	0.0065 0.0080	0.0080 0.0100	0.0080 0.0100	0.0090 0.0110			

Series # 206

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	- 32	150 301											
Free-cutting steels	25 32	255 301											
Unalloyed heat-treatable steels	20 25 32	220 255 301											
Alloyed heat-treatable steels	32 43	301 402											
Unalloyed case hardened steels	25	255											
Alloyed case hardened steels	32 43	301 402											
Nitriding steels	32 43	301 402											
Tool steels	25 43	255 402											
High speed steels	43	402											
Spring steels	38	354											
Hardened steels	48 66	460 -											
Stainless steels, sulphured austenitic martensitic	28 36 46	273 337 435											
Cast iron	23 38	242 354											
Spheroidal graphite iron and malleable cast iron	23 38	242 354											
Chilled cast iron	38	354											
New cast materials GGV	20 32	220 301											
New cast materials ADI	32 43	301 402											
Special alloys	54	549											
Ti and Ti-alloys	25 43	255 402											
Aluminium and Al-alloys	-	120	260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al wrought alloys	-	200	260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	180 180	205 130	0.0020 0.0017	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125	0.0160 0.0125	0.0180 0.0140			
Magnesium alloys	-	120	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Copper, low-alloyed	-	150	100	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110			
Brass, short-chipping long-chipping	- -	180 180	205 130	0.0017 0.0017	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Bronze, short-chipping	-	180	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
Bronze, long-chipping	25 32	255 301	90 80	0.0012 0.0012	0.0030 0.0030	0.0050 0.0050	0.0065 0.0065	0.0080 0.0080	0.0080 0.0080	0.0090 0.0090			
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			50 80	0.0012 0.0015	0.0030 0.0040	0.0050 0.0065	0.0065 0.0080	0.0080 0.0100	0.0080 0.0100	0.0090 0.0110			