

Tool material

HSS

Surface



P Steel • web thinning $\geq \varnothing 1.000$ • relieved cone • for use in automatic/capstan lathes • also for hand drilling machines

M Stainless steel

K Cast iron • thin materials

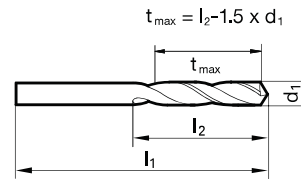
N Aluminum ○

S Titanium alloys

H Hardened steel

●=Optimal

○=Limited



Speeds and feeds information on pg. 479

Shank diameter = cut diameter

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0157	1/64	0.40	19.00	1.90	2.50	9002230004000
0.0197		0.50	20.00	2.25	3.00	9002230005000
0.0217		0.55	21.00	2.68	3.50	9002230005500
0.0236		0.60	21.00	2.60	3.50	9002230006000
0.0256		0.65	22.00	3.03	4.00	9002230006500
0.0260	#71	0.66	22.00	3.01	4.00	9002230006600
0.0276		0.70	23.00	3.45	4.50	9002230007000
0.0283		0.72	23.00	3.42	4.50	9002230007200
0.0295		0.75	23.00	3.38	4.50	9002230007500
0.0311	1/32 #68	0.79	24.00	3.82	5.00	9002230007900
0.0315		0.80	24.00	3.80	5.00	9002230008000
0.0323		0.82	24.00	3.77	5.00	9002230008200
0.0350	#65	0.89	25.00	4.17	5.50	9002230008900
0.0354		0.90	25.00	4.15	5.50	9002230009000
0.0374		0.95	25.00	4.08	5.50	9002230009500
0.0386		0.98	26.00	4.53	6.00	9002230009800
0.0394		1.00	26.00	4.50	6.00	9002230010000
0.0402	#60	1.02	26.00	4.47	6.00	9002230010200
0.0409	#59	1.04	26.00	4.44	6.00	9002230010400
0.0413		1.05	26.00	4.43	6.00	9002230010500
0.0421	#58	1.07	28.00	5.40	7.00	9002230010700
0.0429	#57	1.09	28.00	5.37	7.00	9002230010900
0.0433		1.10	28.00	5.35	7.00	9002230011000
0.0453		1.15	28.00	5.28	7.00	9002230011500
0.0465	#56	1.18	28.00	5.23	7.00	9002230011800
0.0469	3/64	1.19	30.00	6.22	8.00	9002230011900
0.0472		1.20	30.00	6.20	8.00	9002230012000
0.0492		1.25	30.00	6.13	8.00	9002230012500
0.0496		1.26	30.00	6.11	8.00	9002230012600
0.0504		1.28	30.00	6.08	8.00	9002230012800
0.0512		1.30	30.00	6.05	8.00	9002230013000
0.0520	#55	1.32	30.00	6.02	8.00	9002230013200
0.0531		1.35	32.00	6.98	9.00	9002230013500
0.0551	#54	1.40	32.00	6.90	9.00	9002230014000
0.0571		1.45	32.00	6.83	9.00	9002230014500
0.0591		1.50	32.00	6.75	9.00	9002230015000
0.0594	#53	1.51	34.00	7.74	10.00	9002230015100
0.0598		1.52	34.00	7.72	10.00	9002230015200
0.0610		1.55	34.00	7.68	10.00	9002230015500
0.0626	1/16	1.59	34.00	7.62	10.00	9002230015900
0.0630		1.60	34.00	7.60	10.00	9002230016000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.0634	#52	1.61	34.00	7.59	10.00	9002230016100
0.0650		1.65	34.00	7.53	10.00	9002230016500
0.0669	#51	1.70	34.00	7.45	10.00	9002230017000
0.0677		1.72	36.00	8.42	11.00	9002230017200
0.0685		1.74	36.00	8.39	11.00	9002230017400
0.0689		1.75	36.00	8.38	11.00	9002230017500
0.0701	#50	1.78	36.00	8.33	11.00	9002230017800
0.0709		1.80	36.00	8.30	11.00	9002230018000
0.0728	#49	1.85	36.00	8.23	11.00	9002230018500
0.0748		1.90	36.00	8.15	11.00	9002230019000
0.0760	#48	1.93	38.00	9.11	12.00	9002230019300
0.0768		1.95	38.00	9.08	12.00	9002230019500
0.0776		1.97	38.00	9.05	12.00	9002230019700
0.0780	5/64	1.98	38.00	9.03	12.00	9002230019800
0.0783	#47	1.99	38.00	9.02	12.00	9002230019900
0.0787		2.00	38.00	9.00	12.00	9002230020000
0.0807		2.05	38.00	8.93	12.00	9002230020500
0.0811	#46	2.06	38.00	8.91	12.00	9002230020600
0.0819	#45	2.08	38.00	8.88	12.00	9002230020800
0.0827		2.10	38.00	8.85	12.00	9002230021000
0.0835		2.12	38.00	8.82	12.00	9002230021200
0.0846		2.15	40.00	9.78	13.00	9002230021500
0.0858	#44	2.18	40.00	9.73	13.00	9002230021800
0.0866		2.20	40.00	9.70	13.00	9002230022000
0.0874		2.22	40.00	9.67	13.00	9002230022200
0.0886		2.25	40.00	9.63	13.00	9002230022500
0.0890	#43	2.26	40.00	9.61	13.00	9002230022600
0.0906		2.30	40.00	9.55	13.00	9002230023000
0.0925		2.35	40.00	9.48	13.00	9002230023500
0.0933	#42	2.37	43.00	10.45	14.00	9002230023700
0.0937	3/32	2.38	43.00	10.43	14.00	9002230023800
0.0945		2.40	43.00	10.40	14.00	9002230024000
0.0961	#41	2.44	43.00	10.34	14.00	9002230024400
0.0965		2.45	43.00	10.33	14.00	9002230024500
0.0976		2.48	43.00	10.28	14.00	9002230024800
0.0980	#40	2.49	43.00	10.27	14.00	9002230024900
0.0984		2.50	43.00	10.25	14.00	9002230025000
0.0996	#39	2.53	43.00	10.21	14.00	9002230025300
0.1004		2.55	43.00	10.18	14.00	9002230025500
0.1016	#38	2.58	43.00	10.13	14.00	9002230025800
0.1024		2.60	43.00	10.10	14.00	9002230026000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #	
inch	wire/ltr	mm					
0.1039	#37	2.64	43.00	10.04	14.00	9002230026400	
0.1043		2.65	43.00	10.03	14.00	9002230026500	
0.1063		2.70	46.00	11.95	16.00	9002230027000	
0.1067	#36	2.71	46.00	11.94	16.00	9002230027100	
0.1083		2.75	46.00	11.88	16.00	9002230027500	
0.1094	7/64	2.78	46.00	11.83	16.00	9002230027800	
0.1098	#35	2.79	46.00	11.82	16.00	9002230027900	
0.1102		2.80	46.00	11.80	16.00	9002230028000	
0.1110	#34	2.82	46.00	11.77	16.00	9002230028200	
0.1122		2.85	46.00	11.73	16.00	9002230028500	
0.1130	#33	2.87	46.00	11.70	16.00	9002230028700	
0.1142		2.90	46.00	11.65	16.00	9002230029000	
0.1150		2.92	46.00	11.62	16.00	9002230029200	
0.1161	#32	2.95	46.00	11.58	16.00	9002230029500	
0.1169		2.97	46.00	11.55	16.00	9002230029700	
0.1181		3.00	46.00	11.50	16.00	9002230030000	
0.1201	#31	3.05	49.00	13.43	18.00	9002230030500	
0.1220		3.10	49.00	13.35	18.00	9002230031000	
0.1240		3.15	49.00	13.28	18.00	9002230031500	
0.1248	1/8	3.17	49.00	13.25	18.00	9002230031700	
0.1260		3.20	49.00	13.20	18.00	9002230032000	
0.1280		3.25	49.00	13.13	18.00	9002230032500	
0.1283	#30	3.26	49.00	13.11	18.00	9002230032600	
0.1299		3.30	49.00	13.05	18.00	9002230033000	
0.1319		3.35	49.00	12.98	18.00	9002230033500	
0.1339		3.40	52.00	14.90	20.00	9002230034000	
0.1358	#29	3.45	52.00	14.83	20.00	9002230034500	
0.1378		3.50	52.00	14.75	20.00	9002230035000	
0.1398		3.55	52.00	14.68	20.00	9002230035500	
0.1406	9/64	#28	3.57	52.00	14.65	20.00	9002230035700
0.1417		3.60	52.00	14.60	20.00	9002230036000	
0.1437		3.65	52.00	14.53	20.00	9002230036500	
0.1441	#27	3.66	52.00	14.51	20.00	9002230036600	
0.1457		3.70	52.00	14.45	20.00	9002230037000	
0.1469	#26	3.73	52.00	14.41	20.00	9002230037300	
0.1476		3.75	52.00	14.38	20.00	9002230037500	
0.1496	#25	3.80	55.00	16.30	22.00	9002230038000	
0.1516		3.85	55.00	16.23	22.00	9002230038500	
0.1520	#24	3.86	55.00	16.21	22.00	9002230038600	
0.1535		3.90	55.00	16.15	22.00	9002230039000	
0.1539	#23	3.91	55.00	16.14	22.00	9002230039100	
0.1555		3.95	55.00	16.08	22.00	9002230039500	
0.1563	5/32	3.97	55.00	16.05	22.00	9002230039700	
0.1571	#22	3.99	55.00	16.02	22.00	9002230039900	
0.1575		4.00	55.00	16.00	22.00	9002230040000	
0.1583		4.02	55.00	15.97	22.00	9002230040200	
0.1591	#21	4.04	55.00	15.94	22.00	9002230040400	
0.1610	#20	4.09	55.00	15.87	22.00	9002230040900	
0.1614		4.10	55.00	15.85	22.00	9002230041000	
0.1634		4.15	55.00	15.78	22.00	9002230041500	
0.1654		4.20	55.00	15.70	22.00	9002230042000	
0.1661	#19	4.22	55.00	15.67	22.00	9002230042200	
0.1673		4.25	55.00	15.63	22.00	9002230042500	
0.1693	#18	4.30	58.00	17.55	24.00	9002230043000	
0.1720	11/64	4.37	58.00	17.45	24.00	9002230043700	
0.1728	#17	4.39	58.00	17.42	24.00	9002230043900	
0.1732		4.40	58.00	17.40	24.00	9002230044000	
0.1752		4.45	58.00	17.33	24.00	9002230044500	
0.1772	#16	4.50	58.00	17.25	24.00	9002230045000	
0.1791		4.55	58.00	17.18	24.00	9002230045500	
0.1799	#15	4.57	58.00	17.15	24.00	9002230045700	
0.1811		4.60	58.00	17.10	24.00	9002230046000	
0.1819	#14	4.62	58.00	17.07	24.00	9002230046200	
0.1850	#13	4.70	58.00	16.95	24.00	9002230047000	

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #	
inch	wire/ltr	mm					
0.1870		4.75	58.00	16.88	24.00	9002230047500	
0.1874	3/16	4.76	62.00	18.86	26.00	9002230047600	
0.1890	#12	4.80	62.00	18.80	26.00	9002230048000	
0.1909	#11	4.85	62.00	18.73	26.00	9002230048500	
0.1929		4.90	62.00	18.65	26.00	9002230049000	
0.1937	#10	4.92	62.00	18.62	26.00	9002230049200	
0.1961	#9	4.98	62.00	18.53	26.00	9002230049800	
0.1969		5.00	62.00	18.50	26.00	9002230050000	
0.1988		5.05	62.00	18.43	26.00	9002230050500	
0.1992	#8	5.06	62.00	18.41	26.00	9002230050600	
0.2008		5.10	62.00	18.35	26.00	9002230051000	
0.2012	#7	5.11	62.00	18.34	26.00	9002230051100	
0.2031	13/64	5.16	62.00	18.26	26.00	9002230051600	
0.2039	#6	5.18	62.00	18.23	26.00	9002230051800	
0.2047		5.20	62.00	18.20	26.00	9002230052000	
0.2055	#5	5.22	62.00	18.17	26.00	9002230052200	
0.2067		5.25	62.00	18.13	26.00	9002230052500	
0.2087		5.30	62.00	18.05	26.00	9002230053000	
0.2091	#4	5.31	66.00	20.04	28.00	9002230053100	
0.2106		5.35	66.00	19.98	28.00	9002230053500	
0.2126		5.40	66.00	19.90	28.00	9002230054000	
0.2130	#3	5.41	66.00	19.89	28.00	9002230054100	
0.2146		5.45	66.00	19.83	28.00	9002230054500	
0.2165		5.50	66.00	19.75	28.00	9002230055000	
5.5500		5.55	66.00	19.68	28.00	9002230055500	
0.2189	7/32	5.56	66.00	19.66	28.00	9002230055600	
0.2205		5.60	66.00	19.60	28.00	9002230056000	
0.2209	#2	5.61	66.00	19.59	28.00	9002230056100	
0.2244		5.70	66.00	19.45	28.00	9002230057000	
0.2264		5.75	66.00	19.38	28.00	9002230057500	
0.2280	#1	5.79	66.00	19.32	28.00	9002230057900	
0.2283		5.80	66.00	19.30	28.00	9002230058000	
0.2323		5.90	66.00	19.15	28.00	9002230059000	
0.2339	A	5.94	66.00	19.09	28.00	9002230059400	
0.2343	15/64	5.95	66.00	19.08	28.00	9002230059500	
0.2362		6.00	66.00	19.00	28.00	9002230060000	
0.2378	B	6.04	70.00	21.94	31.00	9002230060400	
0.2382		6.05	70.00	21.93	31.00	9002230060500	
0.2402		6.10	70.00	21.85	31.00	9002230061000	
0.2421	C	6.15	70.00	21.78	31.00	9002230061500	
0.2441		6.20	70.00	21.70	31.00	9002230062000	
0.2461	D	6.25	70.00	21.63	31.00	9002230062500	
0.2480		6.30	70.00	21.55	31.00	9002230063000	
0.2500	1/4	E	6.35	70.00	21.48	31.00	9002230063500
0.2520		6.40	70.00	21.40	31.00	9002230064000	
0.2559		6.50	70.00	21.25	31.00	9002230065000	
0.2571		6.53	70.00	21.21	31.00	9002230065300	
0.2598		6.60	70.00	21.10	31.00	9002230066000	
0.2610	G	6.63	70.00	21.06	31.00	9002230066300	
0.2638		6.70	70.00	20.95	31.00	9002230067000	
0.2657	17/64	H	6.75	74.00	23.88	34.00	9002230067500
0.2677		6.80	74.00	23.80	34.00	9002230068000	
0.2697		6.85	74.00	23.73	34.00	9002230068500	
0.2717	I	6.90	74.00	23.65	34.00	9002230069000	
0.2736		6.95	74.00	23.58	34.00	9002230069500	
0.2756		7.00	74.00	23.50	34.00	9002230070000	
0.2768	J	7.03	74.00	23.46	34.00	9002230070300	
0.2795		7.10	74.00	23.35	34.00	9002230071000	
0.2811	9/32	K	7.14	74.00	23.29	34.00	9002230071400
0.2835		7.20	74.00	23.20	34.00	9002230072000	
0.2854		7.25	74.00	23.13	34.00	9002230072500	
0.2874		7.30	74.00	23.05	34.00	9002230073000	
0.2902	L	7.37	74.00	22.95	34.00	9002230073700	
0.2913		7.40	74.00	22.90	34.00	9002230074000	

Stub Length

Stub Length

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.2933		7.45	74.00	22.83	34.00	9002230074500
0.2949	M	7.49	74.00	22.77	34.00	9002230074900
0.2953		7.50	74.00	22.75	34.00	9002230075000
0.2969	19/64	7.54	79.00	25.69	37.00	9002230075400
0.2992		7.60	79.00	25.60	37.00	9002230076000
0.3020	N	7.67	79.00	25.50	37.00	9002230076700
0.3031		7.70	79.00	25.45	37.00	9002230077000
0.3051		7.75	79.00	25.38	37.00	9002230077500
0.3071		7.80	79.00	25.30	37.00	9002230078000
0.3091		7.85	79.00	25.23	37.00	9002230078500
0.3110		7.90	79.00	25.15	37.00	9002230079000
0.3126	5/16	7.94	79.00	25.09	37.00	9002230079400
0.3150		8.00	79.00	25.00	37.00	9002230080000
0.3161	O	8.03	79.00	24.96	37.00	9002230080300
0.3169		8.05	79.00	24.93	37.00	9002230080500
0.3189		8.10	79.00	24.85	37.00	9002230081000
0.3209		8.15	79.00	24.78	37.00	9002230081500
0.3228	P	8.20	79.00	24.70	37.00	9002230082000
0.3248		8.25	79.00	24.63	37.00	9002230082500
0.3268		8.30	79.00	24.55	37.00	9002230083000
0.3280	21/64	8.33	79.00	24.51	37.00	9002230083300
0.3307		8.40	79.00	24.40	37.00	9002230084000
0.3319	Q	8.43	79.00	24.36	37.00	9002230084300
0.3346		8.50	79.00	24.25	37.00	9002230085000
0.3386		8.60	84.00	27.10	40.00	9002230086000
0.3390	R	8.61	84.00	27.09	40.00	9002230086100
0.3406		8.65	84.00	27.03	40.00	9002230086500
0.3425		8.70	84.00	26.95	40.00	9002230087000
0.3437	11/32	8.73	84.00	26.91	40.00	9002230087300
0.3445		8.75	84.00	26.88	40.00	9002230087500
0.3465		8.80	84.00	26.80	40.00	9002230088000
0.3480	S	8.84	84.00	26.74	40.00	9002230088400
0.3504		8.90	84.00	26.65	40.00	9002230089000
0.3524		8.95	84.00	26.58	40.00	9002230089500
0.3543		9.00	84.00	26.50	40.00	9002230090000
0.3579	T	9.09	84.00	26.37	40.00	9002230090900
0.3583		9.10	84.00	26.35	40.00	9002230091000
0.3594	23/64	9.13	84.00	26.31	40.00	9002230091300
0.3622		9.20	84.00	26.20	40.00	9002230092000
0.3642		9.25	84.00	26.13	40.00	9002230092500
0.3661		9.30	84.00	26.05	40.00	9002230093000
0.3677	U	9.34	84.00	25.99	40.00	9002230093400
0.3701		9.40	84.00	25.90	40.00	9002230094000
0.3740		9.50	84.00	25.75	40.00	9002230095000
0.3748	3/8	9.52	89.00	28.72	43.00	9002230095200
0.3772	V	9.58	89.00	28.63	43.00	9002230095800
0.3780		9.60	89.00	28.60	43.00	9002230096000
0.3799		9.65	89.00	28.53	43.00	9002230096500
0.3819		9.70	89.00	28.45	43.00	9002230097000
0.3839		9.75	89.00	28.38	43.00	9002230097500
0.3858	W	9.80	89.00	28.30	43.00	9002230098000
0.3898		9.90	89.00	28.15	43.00	9002230099000
0.3906	25/64	9.92	89.00	28.12	43.00	9002230099200
0.3937		10.00	89.00	28.00	43.00	9002230100000
0.3957		10.05	89.00	27.93	43.00	9002230100500
0.3969	X	10.08	89.00	27.88	43.00	9002230100800
0.3976		10.10	89.00	27.85	43.00	9002230101000
0.3996		10.15	89.00	27.78	43.00	9002230101500
0.4016		10.20	89.00	27.70	43.00	9002230102000
0.4035		10.25	89.00	27.63	43.00	9002230102500
0.4039	Y	10.26	89.00	27.61	43.00	9002230102600
0.4055		10.30	89.00	27.55	43.00	9002230103000
0.4063	13/32	10.32	89.00	27.52	43.00	9002230103200
0.4094		10.40	89.00	27.40	43.00	9002230104000

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.4130	Z	10.49	89.00	27.27	43.00	9002230104900
0.4134		10.50	89.00	27.25	43.00	9002230105000
0.4173		10.60	89.00	27.10	43.00	9002230106000
0.4213		10.70	95.00	30.95	47.00	9002230107000
0.4220	27/64	10.72	95.00	30.92	47.00	9002230107200
0.4232		10.75	95.00	30.88	47.00	9002230107500
0.4252		10.80	95.00	30.80	47.00	9002230108000
0.4291		10.90	95.00	30.65	47.00	9002230109000
0.4331		11.00	95.00	30.50	47.00	9002230110000
0.4370		11.10	95.00	30.35	47.00	9002230111000
0.4374	7/16	11.11	95.00	30.34	47.00	9002230111100
0.4409		11.20	95.00	30.20	47.00	9002230112000
0.4429		11.25	95.00	30.13	47.00	9002230112500
0.4449		11.30	95.00	30.05	47.00	9002230113000
0.4488		11.40	95.00	29.90	47.00	9002230114000
0.4528		11.50	95.00	29.75	47.00	9002230115000
0.4531	29/64	11.51	95.00	29.74	47.00	9002230115100
0.4567		11.60	95.00	29.60	47.00	9002230116000
0.4606		11.70	95.00	29.45	47.00	9002230117000
0.4626		11.75	95.00	29.38	47.00	9002230117500
0.4646		11.80	95.00	29.30	47.00	9002230118000
0.4685		11.90	102.00	33.15	51.00	9002230119000
0.4689	15/32	11.91	102.00	33.14	51.00	9002230119100
0.4724		12.00	102.00	33.00	51.00	9002230120000
0.4764		12.10	102.00	32.85	51.00	9002230121000
0.4783		12.15	102.00	32.78	51.00	9002230121500
0.4803		12.20	102.00	32.70	51.00	9002230122000
0.4823		12.25	102.00	32.63	51.00	9002230122500
0.4843	31/64	12.30	102.00	32.55	51.00	9002230123000
0.4882		12.40	102.00	32.40	51.00	9002230124000
0.4921		12.50	102.00	32.25	51.00	9002230125000
0.4961		12.60	102.00	32.10	51.00	9002230126000
0.5000	1/2	12.70	102.00	31.95	51.00	9002230127000
0.5020		12.75	102.00	31.88	51.00	9002230127500
0.5039		12.80	102.00	31.80	51.00	9002230128000
0.5079		12.90	102.00	31.65	51.00	9002230129000
0.5118		13.00	102.00	31.50	51.00	9002230130000
0.5157	33/64	13.10	102.00	31.35	51.00	9002230131000
0.5197		13.20	102.00	31.20	51.00	9002230132000
0.5217		13.25	107.00	34.13	54.00	9002230132500
0.5236		13.30	107.00	34.05	54.00	9002230133000
0.5276		13.40	107.00	33.90	54.00	9002230134000
0.5311	17/32	13.49	107.00	33.77	54.00	9002230134900
0.5315		13.50	107.00	33.75	54.00	9002230135000
0.5354		13.60	107.00	33.60	54.00	9002230136000
0.5394		13.70	107.00	33.45	54.00	9002230137000
0.5413		13.75	107.00	33.38	54.00	9002230137500
0.5433		13.80	107.00	33.30	54.00	9002230138000
0.5469	35/64	13.89	107.00	33.17	54.00	9002230138900
0.5472		13.90	107.00	33.15	54.00	9002230139000
0.5512		14.00	107.00	33.00	54.00	9002230140000
0.5551		14.10	111.00	34.85	56.00	9002230141000
0.5591		14.20	111.00	34.70	56.00	9002230142000
0.5610		14.25	111.00	34.63	56.00	9002230142500
0.5626	9/16	14.29	111.00	34.57	56.00	9002230142900
0.5669		14.40	111.00	34.40	56.00	9002230144000
0.5709		14.50	111.00	34.25	56.00	9002230145000
0.5748		14.60	111.00	34.10	56.00	9002230146000
0.5780	37/64	14.68	111.00	33.98	56.00	9002230146800
0.5807		14.75	111.00	33.88	56.00	9002230147500
0.5827		14.80	111.00	33.80	56.00	9002230148000
0.5866		14.90	111.00	33.65	56.00	9002230149000
0.5906		15.00	111.00	33.50	56.00	9002230150000
0.5937	19/32	15.08	115.00	35.38	58.00	9002230150800

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.5945		15.10	115.00	35.35	58.00	9002230151000
0.5984		15.20	115.00	35.20	58.00	9002230152000
0.6004		15.25	115.00	35.13	58.00	9002230152500
0.6063		15.40	115.00	34.90	58.00	9002230154000
0.6094	39/64	15.48	115.00	34.78	58.00	9002230154800
0.6102		15.50	115.00	34.75	58.00	9002230155000
0.6142		15.60	115.00	34.60	58.00	9002230156000
0.6181		15.70	115.00	34.45	58.00	9002230157000
0.6201		15.75	115.00	34.38	58.00	9002230157500
0.6220		15.80	115.00	34.30	58.00	9002230158000
0.6248	5/8	15.87	115.00	34.20	58.00	9002230158700
0.6299		16.00	115.00	34.00	58.00	9002230160000
0.6339		16.10	119.00	35.85	60.00	9002230161000
0.6358		16.15	119.00	35.78	60.00	9002230161500
0.6398		16.25	119.00	35.63	60.00	9002230162500
0.6406	41/64	16.27	119.00	35.60	60.00	9002230162700
0.6417		16.30	119.00	35.55	60.00	9002230163000
0.6496		16.50	119.00	35.25	60.00	9002230165000
0.6563	21/32	16.67	119.00	35.00	60.00	9002230166700
0.6594		16.75	119.00	34.88	60.00	9002230167500
0.6693		17.00	119.00	34.50	60.00	9002230170000
0.6720	43/64	17.07	123.00	36.40	62.00	9002230170700
0.6732		17.10	123.00	36.35	62.00	9002230171000
0.6791		17.25	123.00	36.13	62.00	9002230172500
0.6811		17.30	123.00	36.05	62.00	9002230173000
0.6874	11/16	17.46	123.00	35.81	62.00	9002230174600
0.6890		17.50	123.00	35.75	62.00	9002230175000
0.6929		17.60	123.00	35.60	62.00	9002230176000
0.6988		17.75	123.00	35.38	62.00	9002230177500
0.7031	45/64	17.86	123.00	35.21	62.00	9002230178600
0.7087		18.00	123.00	35.00	62.00	9002230180000
0.7126		18.10	127.00	36.85	64.00	9002230181000
0.7165		18.20	127.00	36.70	64.00	9002230182000
0.7185		18.25	127.00	36.63	64.00	9002230182500
0.7189	23/32	18.26	127.00	36.61	64.00	9002230182600
0.7283		18.50	127.00	36.25	64.00	9002230185000
0.7343	47/64	18.65	127.00	36.03	64.00	9002230186500
0.7382		18.75	127.00	35.88	64.00	9002230187500
0.7480		19.00	127.00	35.50	64.00	9002230190000
0.7500	3/4	19.05	131.00	37.43	66.00	9002230190500

Diameter (d ₁)			l ₁ mm	t _{max} mm	l ₂ mm	EDP #
inch	wire/ltr	mm				
0.7520		19.10	131.00	37.35	66.00	9002230191000
0.7579		19.25	131.00	37.13	66.00	9002230192500
0.7657	49/64	19.45	131.00	36.83	66.00	9002230194500
0.7677		19.50	131.00	36.75	66.00	9002230195000
0.7776		19.75	131.00	36.38	66.00	9002230197500
0.7811	25/32	19.84	131.00	36.24	66.00	9002230198400
0.7874		20.00	131.00	36.00	66.00	9002230200000
0.7913		20.10	136.00	37.85	68.00	9002230201000
0.7969	51/64	20.24	136.00	37.64	68.00	9002230202400
0.8071		20.50	136.00	37.25	68.00	9002230205000
0.8126	13/16	20.64	136.00	37.04	68.00	9002230206400
0.8169		20.75	136.00	36.88	68.00	9002230207500
0.8189		20.80	136.00	36.80	68.00	9002230208000
0.8268		21.00	136.00	36.50	68.00	9002230210000
0.8280	53/64	21.03	136.00	36.46	68.00	9002230210300
0.8366		21.25	141.00	38.13	70.00	9002230212500
0.8437	27/32	21.43	141.00	37.86	70.00	9002230214300
0.8465		21.50	141.00	37.75	70.00	9002230215000
0.8661		22.00	141.00	37.00	70.00	9002230220000
0.8748	7/8	22.22	141.00	36.67	70.00	9002230222200
0.8858		22.50	146.00	38.25	72.00	9002230225000
0.8906	57/64	22.62	146.00	38.07	72.00	9002230226200
0.9055		23.00	146.00	37.50	72.00	9002230230000
0.9063	29/32	23.02	146.00	37.47	72.00	9002230230200
0.9220	59/64	23.42	146.00	36.87	72.00	9002230234200
0.9252		23.50	146.00	36.75	72.00	9002230235000
0.9374	15/16	23.81	151.00	39.29	75.00	9002230238100
0.9449		24.00	151.00	39.00	75.00	9002230240000
0.9532	61/64	24.21	151.00	38.69	75.00	9002230242100
0.9646		24.50	151.00	38.25	75.00	9002230245000
0.9689	31/32	24.61	151.00	38.09	75.00	9002230246100
0.9843	63/64	25.00	151.00	37.50	75.00	9002230250000
1.0000	1.0000	25.40	156.00	39.90	78.00	9002230254000
1.0311	1 1/32	26.19	156.00	38.72	78.00	9002230261900
1.0433		26.50	156.00	38.25	78.00	9002230265000
1.1024		28.00	162.00	39.00	81.00	9002230280000
1.1248	1 1/8	28.57	168.00	41.15	84.00	9002230285700
1.1563	1 5/32	29.37	168.00	39.95	84.00	9002230293700
1.1811		30.00	168.00	39.00	84.00	9002230300000
1.2500	1 1/4	31.75	180.00	42.38	90.00	9002230317500

Stub Length

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	-	≤ 150											
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	225	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al wrought alloys	-	≤ 200	225	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	≤ 180 ≤ 180	180	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Magnesium alloys	-	≤ 120											
Copper, low-alloyed	-	≤ 150	90	0.0015	0.004	0.0065	0.0080	0.0100	0.0100	0.0110			
Brass, short-chipping long-chipping	-	≤ 180 ≤ 180											
Bronze, short-chipping	-	≤ 180											
Bronze, long-chipping	≤ 25 ≤ 32	≤ 255 ≤ 301											
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			70	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110			

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	-	≤ 150											
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	0.0180		
Al wrought alloys	-	≤ 200	260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180	0.0180		
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	≤ 180 ≤ 180	205	0.002	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180	0.0180		
Magnesium alloys	-	≤ 120	295	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140	0.0160		
Copper, low-alloyed	-	≤ 150											
Brass, short-chipping long-chipping	-	≤ 180 ≤ 180	225	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140	0.0160		
Bronze, short-chipping	-	≤ 180	115	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090	0.0100		
Bronze, long-chipping	≤ 25 ≤ 32	≤ 255 ≤ 301											
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			55 90	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	0.0100 0.0125		