

















































High-Performance Drill Recommendations

| |  |  |  |  |  |  |  |  |  |  |  |  |
|--------------------------------|---|---|---|---|---|---|---|---|---|---|---|---|
| Series | 5514 | 5510 | 2477 | 5515 | 5511 | 2479 | 609 | 5512 | 4044 | 5525 | 4112 (Insert) | 6509 - 6514 |
| Length | 3xD | 3xD | 3xD | 5xD | 5xD | 5xD | 5xD | 7xD | 7xD | 12xD | 3, 5, 7 x D | 15xD - 40xD |
| Shank |  |  |  |  |  |  |  |  |  |  |  |  |
| Style | RT100U | RT100U | RT100X | RT100U | RT100U | RT100X | GS200U 3-flute | RT100U | RT100X | RT100C | HT800 / RT800WP | RT 100 T |
| Point Angle | 140° | 140° | 140° | 140° | 140° | 140° | 150° | 140° | 140° | 140° | 140° | 135° |
| Coolant Fed |  |  |  |  |  |  |  |  |  |  |  |  |
| Substrate | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide | Carbide |
| Surface Finish |  |  |  |  |  |  |  |  |  |  |  |  |
| Unalloyed case hardened steels | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |
| Alloyed case hardened steels | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | |
| Alloyed heat-treatable steels | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |
| Nitriding steels | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | |
| Size Range (mm) | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 3.00 - 20.00 | 11.00 - 25.50 | 3.00 - 14.00 |
| Sizes page | 260 | 253 | 226 | 262 | 255 | 228 | 160 | 257 | 250 | 277 | 238 | 305-306 |

| Material group | Examples |
|--------------------------------|--|
| Unalloyed case hardened steels | 1005, 1006, 1008, 1009, 1010, 1011, 1012, 1013, 1015, 1016, 1017, 1018, 1019, 1020, 1021, 1022, 1023, 1025, 1026, 1029, 1030, 1033, 1035, 1037, 1038, 1039, 1040, 1042, 1043, 1044, 1045, 1046, 1049, 1050, 1053, 1055, 1059, 1060, 1064, 1065, 1069, 1070, 1071, 1074, 1075, 1078, 1080, 1084, 1085, 1086, 1090, 1095 |
| Alloyed case hardened steels | 2317, 2512, 2515, 2517, 3115, 3120, 3215, 3220, 3312, 3316, 3325, 4012, 4023, 4024, 4027, 4028, 4118, 4119, 4125, 4317, 4320, 4419, 4422, 4427, 4608, 4615, 4617, 4620, 4621, 4626, 4718, 4720, 4815, 4817, 4820, 5015, 5115, 5117, 5120, 6115, 6118, 6120, 6125, 8115, 8615, 8617, 8620, 8622, 8625, 8627, 8720, 8822, 9310, 9315, 9317 |
| Alloyed heat-treatable steels | 1330, 1335, 1340, 1345, 2340, 3140, 3145, 3150, 3230, 3240, 3335, 3340, 3435, 3450, 4032, 4037, 4063, 4130, 4135, 4137, 4140, 4142, 4145, 4147, 4150, 4161, 4337, 4340, 4640, 5045, 5046, 5060, 5130, 5132, 5135, 5140, 5145, 5157, 5150, 5155, 5160, 6130, 6135, 6140, 6145, 6150, 7140, 6145, 6150, 7140, 8630, 8632, 8635, 8637, 8640, 8642, 8645, 8650, 8650, 8660, 8735, 8740, 8742, 9250, 9254, 9255, 9260, 9262, 9840, 9850 |
| Nitriding steels | 1132, 1137, 1138, 1139, 1140, 1141, 1144, 1145, 1146, 1151 |