



High-Performance Drill Recommendations

Series	5514	5741	8510	5515	5744	8511	609	5512	5746	5525	4115 (Insert)	6509-6514
Length	3xD	3xD	3xD	5xD	5xD	5xD	5xD	7xD	7xD	12xD	3, 5, 7 x D	15xD - 40xD
Shank												
Style	RT100U	RT100US	RT100VA	RT100U	RT100US	RT100VA	GS200U 3-flute	RT100U	RT100US	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	F	a	a	F	a	a	S	F	a	F	a	A
Austenitic 300	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Martensitic 400	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Ph Stainless	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Size range mm	3.00 - 20.00	3.00 - 12.70	3.00 - 20.00	3.00 - 20.00	3.00 - 12.70	3.00 - 20.00	3.00 - 20.00	3.00 - 20.00	3.00 - 12.70	3.00 - 20.00	11.00 - 25.50	3.00 - 14.00
Sizes page	260	290	307	262	292	309	160	257	294	277	238	305-306

Material group	Examples
Stainless steels, sulphured	203 Ez, 303 Se, 303 Ma, 303 Pb, 303 PlusX, 430F Se, 416 Se, 416 PlusX, 420F, 420F Se, 440F, 440F Se
austenitic	201, 202, 301, 302B, 303, 304, 304L, 305, 308, 309, 309S, 310, 310S, 314, 316, 316L, 317, 321, 330, 347, 348, 384, 385, Nitronic 32, Nitronic 33, Nitronic 40, Nitronic 50, Nitronic 60, 17-7PH
martensitic	403, 405, 410, 414, 416, 420, 422, 430, 431, 440A, 440B, 440C, 446, 501, 502, 630, Greek Ascology