





































High-Performance Drill Recommendations

												
Series	5514	5510	8520	5515	5511	8521	609	5512	8522	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	RT100HF	RT100U	RT100U	RT100HF	GS200U 3-flute	RT100U	RT100HF	RT100C	HT800 / RT800WP	RT100T
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	F	Y	F	F	Y	S	F	Y	F	N	A
High speed steels	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Spring steels	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Hardened steels	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
Tool steels	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Alloyed heat-treatable	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
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 - 16.00	3.00 - 20.00	11.00 - 25.50	3.00 - 14.00
Sizes page	260	253	311	262	255	313	160	257	315	277	238	305

Material group	Examples
High speed steels	M1, M2, M3-1, M3-2, M4, M6, M7, M10, M30, M33, M34, M36, M41, M42, M43, M44, M46, M47, T1, T2, T4, T5, T6, T8, T15
Spring steels	5150, 5155, 6145, 6150, 9255
Hardened steels >48-60 Rc	Heat Treated Steels
Tool steels	A2, A3, A4, A5, A6, A8, A9, A10, O1, O2, O6, O7, A7, D2, D3, D4, D5, D7, H10, H11, H12, H13, H14, H19, H20, H21, H22, H23, H24, H25, H26, H41, H42, H43, L1, L3, W1, W2, W5
Alloyed Heat Treatable	1330, 1335, 1340, 1345, 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, 2340

