

5xD

Series 206

Application Materials:

Twist Drills



Bright Finish



External Coolant



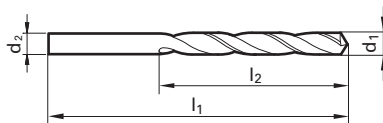
Straight Shank

Speeds & Feeds
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Low Helix

HSS, Low Helix (Type H), jobber length, 118° point, Form A web thinned >14.0mm dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range



$$d_1 = d_2$$



General Steels/
Brass

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.0079		92	0.200	19.00	2.50	9002060002000
0.0094		88	0.240	19.00	2.50	9002060002400
0.0098		87	0.250	19.00	3.00	9002060002500
0.0118			0.300	19.00	3.00	9002060003000
0.0134		80	0.340	19.00	4.00	9002060003400
0.0138			0.350	19.00	4.00	9002060003500
0.0157	1/64		0.400	20.00	5.00	9002060004000
0.0161		78	0.410	20.00	5.00	9002060004100
0.0177			0.450	20.00	5.00	9002060004500
0.0181		77	0.460	20.00	5.00	9002060004600
0.0197			0.500	22.00	6.00	9002060005000
0.0201		76	0.510	22.00	6.00	9002060005100
0.0209		75	0.530	22.00	6.00	9002060005300
0.0217			0.550	24.00	7.00	9002060005500
0.0224		74	0.570	24.00	7.00	9002060005700
0.0236			0.600	24.00	7.00	9002060006000
0.0244			0.620	26.00	8.00	9002060006200
0.0256			0.650	26.00	8.00	9002060006500
0.0260		71	0.660	26.00	8.00	9002060006600
0.0276			0.700	28.00	9.00	9002060007000
0.0283			0.720	28.00	9.00	9002060007200
0.0287			0.730	28.00	9.00	9002060007300
0.0291		69	0.740	28.00	9.00	9002060007400
0.0295			0.750	28.00	9.00	9002060007500
0.0299			0.760	30.00	10.00	9002060007600
0.0303			0.770	30.00	10.00	9002060007700
0.0311	1/32	68	0.790	30.00	10.00	9002060007900
0.0315			0.800	30.00	10.00	9002060008000
0.0319		67	0.810	30.00	10.00	9002060008100
0.0327			0.830	30.00	10.00	9002060008300
0.0331		66	0.840	30.00	10.00	9002060008400
0.0335			0.850	30.00	10.00	9002060008500
0.0339			0.860	32.00	11.00	9002060008600
0.0343			0.870	32.00	11.00	9002060008700
0.0346			0.880	32.00	11.00	9002060008800
0.0350		65	0.890	32.00	11.00	9002060008900
0.0354			0.900	32.00	11.00	9002060009000
0.0358		64	0.910	32.00	11.00	9002060009100
0.0366			0.930	32.00	11.00	9002060009300
0.0374			0.950	32.00	11.00	9002060009500
0.0378			0.960	34.00	12.00	9002060009600
0.0382		62	0.970	34.00	12.00	9002060009700
0.0390		61	0.990	34.00	12.00	9002060009900
0.0394			1.000	34.00	12.00	9002060010000
0.0402		60	1.020	34.00	12.00	9002060010200
0.0409		59	1.040	34.00	12.00	9002060010400
0.0413			1.050	34.00	12.00	9002060010500
0.0433			1.100	36.00	14.00	9002060011000
0.0453			1.150	36.00	14.00	9002060011500
0.0465		56	1.180	36.00	14.00	9002060011800
0.0469	3/64		1.190	38.00	16.00	9002060011900
0.0472			1.200	38.00	16.00	9002060012000
0.0480			1.220	38.00	16.00	9002060012200
0.0492			1.250	38.00	16.00	9002060012500
0.0500			1.270	38.00	16.00	9002060012700

Dec. inch	Diameter (d1)		l1 mm	l2 mm	EDP #	
	Fract. inch	Wire / letter				
0.0504			1.280	38.00	16.00	9002060012800
0.0512			1.300	38.00	16.00	9002060013000
0.0520		55	1.320	38.00	16.00	9002060013200
0.0524			1.330	40.00	18.00	9002060013300
0.0531			1.350	40.00	18.00	9002060013500
0.0539			1.370	40.00	18.00	9002060013700
0.0551		54	1.400	40.00	18.00	9002060014000
0.0563			1.430	40.00	18.00	9002060014300
0.0567			1.440	40.00	18.00	9002060014400
0.0571			1.450	40.00	18.00	9002060014500
0.0579			1.470	40.00	18.00	9002060014700
0.0591			1.500	40.00	18.00	9002060015000
0.0602			1.530	43.00	20.00	9002060015300
0.0606			1.540	43.00	20.00	9002060015400
0.0610			1.550	43.00	20.00	9002060015500
0.0626	1/16		1.590	43.00	20.00	9002060015900
0.0630			1.600	43.00	20.00	9002060016000
0.0638			1.620	43.00	20.00	9002060016200
0.0650			1.650	43.00	20.00	9002060016500
0.0657			1.670	43.00	20.00	9002060016700
0.0669		51	1.700	43.00	20.00	9002060017000
0.0677			1.720	46.00	22.00	9002060017200
0.0681			1.730	46.00	22.00	9002060017300
0.0689			1.750	46.00	22.00	9002060017500
0.0701		50	1.780	46.00	22.00	9002060017800
0.0709			1.800	46.00	22.00	9002060018000
0.0728		49	1.850	46.00	22.00	9002060018500
0.0748			1.900	46.00	22.00	9002060019000
0.0756			1.920	49.00	24.00	9002060019200
0.0768			1.950	49.00	24.00	9002060019500
0.0780	5/64		1.980	49.00	24.00	9002060019800
0.0787			2.000	49.00	24.00	9002060020000
0.0795			2.020	49.00	24.00	9002060020200
0.0807			2.050	49.00	24.00	9002060020500
0.0811		46	2.060	49.00	24.00	9002060020600
0.0815			2.070	49.00	24.00	9002060020700
0.0827			2.100	49.00	24.00	9002060021000
0.0846			2.150	53.00	27.00	9002060021500
0.0858		44	2.180	53.00	27.00	9002060021800
0.0866			2.200	53.00	27.00	9002060022000
0.0886			2.250	53.00	27.00	9002060022500
0.0894			2.270	53.00	27.00	9002060022700
0.0906			2.300	53.00	27.00	9002060023000
0.0925			2.350	53.00	27.00	9002060023500
0.0937	3/32		2.380	57.00	30.00	9002060023800
0.0945			2.400	57.00	30.00	9002060024000
0.0965			2.450	57.00	30.00	9002060024500
0.0972			2.470	57.00	30.00	9002060024700
0.0984			2.500	57.00	30.00	9002060025000
0.0996		39	2.530	57.00	30.00	9002060025300
0.1004			2.550	57.00	30.00	9002060025500
0.1012			2.570	57.00	30.00	9002060025700
0.1024			2.600	57.00	30.00	9002060026000
0.1035			2.630	57.00	30.00	9002060026300
0.1039		37	2.640	57.00	30.00	9002060026400