

A very rigid drill for high performance metal removal at speeds of up to 30% above normal high-speed steel. Suitable for use in rigid machine set-ups at high feed rates, where depth of hole does not exceed 3 x D.

Size (in)	Decimal (mm)	Decimal Equiv.	Flute Length (mm)	Overall Length (mm)	Code No.	Price \$
	3.00	.1181	16	46	134-631	<b>8.10</b>
	3.10	.1220	18	49	134-632	<b>8.10</b>
1/8	3.17	.1250	18	49	134-633	<b>8.20</b>
	3.20	.1260	18	49	134-634	<b>8.20</b>
	3.30*	.1299	18	49	134-635	<b>8.20</b>
	3.40	.1339	20	52	134-636	<b>8.80</b>
	3.50*	.1378	20	52	134-637	<b>8.80</b>
9/64	3.57	.1406	20	52	134-638	<b>11.20</b>
	3.60	.1417	20	52	134-639	<b>11.20</b>
	3.70*	.1457	20	52	134-640	<b>11.20</b>
	3.80	.1496	22	55	134-641	<b>11.20</b>
	3.90*	.1535	22	55	134-642	<b>10.40</b>
5/32	3.97	.1562	22	55	134-643	<b>11.40</b>
	4.00	.1575	22	55	134-644	<b>11.40</b>
	4.10*	.1614	22	55	134-645	<b>12.50</b>
	4.20*	.1654	22	55	134-646	<b>12.50</b>
	4.30	.1693	24	58	134-647	<b>12.50</b>
11/64	4.37	.1719	24	58	134-648	<b>12.80</b>
	4.40	.1732	24	58	134-649	<b>12.80</b>
	4.50*	.1772	24	58	134-650	<b>12.80</b>
	4.60*	.1811	24	58	134-651	<b>12.90</b>
	4.70	.1850	24	58	134-652	<b>12.90</b>
3/16	4.76	.1875	26	62	134-653	<b>13.00</b>
	4.80	.1890	26	62	134-654	<b>13.00</b>
	4.90	.1929	26	62	134-655	<b>13.10</b>
	5.00*	.1969	26	62	134-656	<b>13.10</b>
	5.10*	.2008	26	62	134-657	<b>13.20</b>
13/64	5.16	.2031	26	62	134-658	<b>13.50</b>
	5.20	.2047	26	62	134-659	<b>13.50</b>
	5.30	.2087	26	62	134-660	<b>13.50</b>
	5.40	.2126	28	66	134-661	<b>13.00</b>
	5.50*	.2165	28	66	134-662	<b>13.50</b>
7/32	5.56	.2188	28	66	134-663	<b>13.00</b>
	5.60	.2205	28	66	134-664	<b>13.70</b>
	5.70	.2244	28	66	134-665	<b>13.70</b>
	5.80	.2283	28	66	134-666	<b>13.70</b>
	5.90	.2323	28	66	134-667	<b>13.70</b>
15/64	5.95	.2344	28	66	134-668	<b>13.30</b>
	6.00*	.2362	28	66	134-669	<b>13.30</b>

\* = Tap Drill sizes

Size (in)	Decimal (mm)	Decimal Equiv.	Flute Length (mm)	Overall Length (mm)	Code No.	Price \$
	6.10	.2402	32	70	134-670	<b>18.40</b>
	6.20	.2441	32	70	134-671	<b>18.50</b>
	6.30	.2480	32	70	134-672	<b>18.50</b>
1/4	6.35	.2500	32	70	134-673	<b>18.20</b>
	6.40	.2520	32	70	134-674	<b>18.20</b>
	6.50	.2559	32	70	134-675	<b>18.50</b>
	6.60*	.2598	32	70	134-676	<b>19.20</b>
	6.70	.2638	32	70	134-677	<b>19.20</b>
17/64	6.75	.2656	34	74	134-678	<b>19.80</b>
	6.80*	.2677	34	74	134-679	<b>19.80</b>
	6.90*	.2717	34	74	134-680	<b>19.80</b>
	7.00*	.2756	34	74	134-681	<b>19.80</b>
	7.10	.2795	34	74	134-682	<b>19.80</b>
9/32	7.14	.2812	34	74	134-683	<b>20.30</b>
	7.20	.2835	34	74	134-684	<b>20.30</b>
	7.30	.2874	34	74	134-685	<b>20.30</b>
	7.40	.2913	34	74	134-686	<b>20.30</b>
	7.50	.2953	34	74	134-687	<b>20.30</b>
19/64	7.54	.2969	37	79	134-688	<b>20.30</b>
	7.60	.2992	37	79	134-689	<b>20.90</b>
	7.70	.3031	37	79	134-690	<b>20.90</b>
	7.80	.3071	37	79	134-691	<b>20.90</b>
	7.90	.3110	37	79	134-692	<b>20.90</b>
5/16	7.94	.3125	37	79	134-693	<b>20.30</b>
	8.00*	.3150	37	79	134-694	<b>20.30</b>
	8.10	.3189	37	79	134-695	<b>25.00</b>
	8.20	.3228	37	79	134-696	<b>25.00</b>
	8.30	.3268	37	79	134-697	<b>25.00</b>
21/64	8.33	.3281	37	79	134-698	<b>25.00</b>
	8.40	.3307	37	79	134-699	<b>25.40</b>
	8.50*	.3346	37	79	134-700	<b>25.50</b>
	8.60	.3386	40	84	134-701	<b>26.00</b>
	8.70	.3425	40	84	134-702	<b>26.00</b>
11/32	8.73	.3438	40	84	134-703	<b>26.00</b>
	8.80	.3465	40	84	134-704	<b>26.30</b>
	8.90	.3504	40	84	134-705	<b>26.30</b>
	9.00	.3543	40	84	134-706	<b>26.30</b>
	9.10	.3583	40	84	134-707	<b>26.30</b>
23/64	9.13	.3594	40	84	134-708	<b>26.30</b>

# YELLOW RING STUB DRILLS

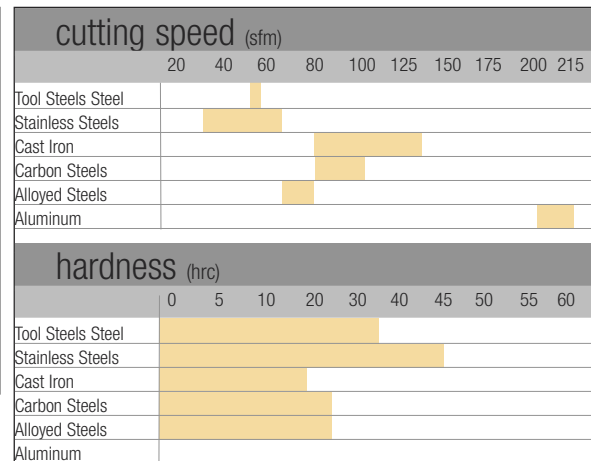


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Size (in)	Decimal (mm)	Decimal Equiv.	Flute Length (mm)	Overall Length (mm)	Code No.	Price \$
	9.20	.3622	40	84	134-709	<b>26.90</b>
	9.30	.3661	40	84	134-710	<b>26.90</b>
	9.40*	.3701	40	84	134-711	<b>26.90</b>
	9.50	.3740	40	84	134-712	<b>26.90</b>
3/8	9.52	.3750	43	89	134-713	<b>26.90</b>
	9.60	.3780	43	89	134-714	<b>29.40</b>
	9.70	.3819	43	89	134-715	<b>29.40</b>
	9.80	.3858	43	89	134-716	<b>29.40</b>
	9.90*	.3898	43	89	134-717	<b>29.60</b>
25/64	9.92	.3906	43	89	134-718	<b>29.60</b>
	10.00	.3937	43	89	134-719	<b>28.90</b>
	10.20*	.4016	43	89	134-721	<b>30.30</b>
13/32	10.32	.4063	43	89	134-723	<b>30.40</b>
	10.50	.4134	43	89	134-725	<b>30.70</b>
27/64	10.72	.4220	43	89	134-728	<b>30.70</b>
	10.80*	.4252	47	95	134-729	<b>31.90</b>
	11.00	.4331	47	95	134-731	<b>32.00</b>
7/16	11.11	.4374	47	95	134-733	<b>40.90</b>
	11.50*	.4528	47	95	134-737	<b>42.30</b>
29/64	11.51	.4531	47	95	134-738	<b>42.30</b>
	11.80	.4646	47	95	134-741	<b>42.70</b>
15/32	11.91	.4689	51	102	134-743	<b>44.80</b>
	12.00*	.4724	51	102	134-744	<b>44.00</b>
	12.20*	.4803	51	102	134-746	<b>45.20</b>
31/64	12.30	.4882	51	102	134-747	<b>45.20</b>
	12.50*	.4961	51	102	134-749	<b>46.10</b>
1/2	12.70	.5000	51	102	134-752	<b>45.90</b>

\* = Tap Drill sizes

cutting conditions				
Materials				Cutting Speed (SFM)
Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (SFM)
Tool Steels	A2, A6, L7, O1, O2, O6, M1, M2, D2, P20	Annealed	<32	50-55
Stainless Steel	200 Series, 300 Series, 400 Series, 400 Series	Annealed	<28	50-60
		Annealed	<28	30-60
		Annealed	<29	55-65
		Hardened	<45	50-60
Cast Iron	Soft, Hard, Malleable	-	<18	80-135
Carbon Steels	1020 thr 1060, 1090	Normalized	<22	80-100
Alloyed Steels	1435,4140,4615,5140	Normalized	<22	65-80
Aluminum	Alloys, Cast	-	-	200-215



**SPEEDS & FEEDS** Pg. 116