

- Features Endmill shank-h6 tol.

For CNC Stainless Steel drilling with a CNC generated profile flute shape, providing greater chip space for fast, efficient chip evacuation. The 120° split four facet drill point is designed for minimal burr generation on breakthrough and 40° helix produces an aggressive wedge angle for free cutting. Common shanks to h6 tolerance ensure accurate, straight holes.

Size (in)	Decimal (mm)	Decimal Equiv.	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$
	3.00	.1181	3	33	61	134-850	19.70
	3.10	.1220	4	36	65	134-851	24.00
1/8	3.17	.1250	4	36	65	134-852	26.50
	3.20	.1260	4	36	65	134-853	24.00
	3.30*	.1299	4	36	65	134-854	23.90
	3.40	.1339	4	39	70	134-855	24.00
	3.50*	.1378	4	39	70	134-856	23.90
9/64	3.57	.1406	4	39	70	134-857	31.20
	3.60	.1417	4	39	70	134-858	28.10
	3.70*	.1457	4	39	70	134-859	28.10
	3.80	.1496	4	43	75	134-860	25.70
	3.90*	.1535	4	43	75	134-861	28.10
5/32	3.97	.1562	4	43	75	134-862	31.20
	4.00	.1575	6	43	75	134-863	25.70
	4.10*	.1614	6	43	75	134-864	35.40
	4.20*	.1654	6	43	75	134-865	32.70
	4.30	.1693	6	47	80	134-866	35.40
11/64	4.37	.1719	6	47	80	134-867	38.90
	4.40	.1732	6	47	80	134-868	35.40
	4.50*	.1772	6	47	80	134-869	32.70
	4.60*	.1811	6	47	80	134-870	40.50
	4.70	.1850	6	47	80	134-871	40.50
3/16	4.76	.1875	6	52	86	134-872	44.90
	4.80	.1890	6	52	86	134-873	40.50
	4.90	.1929	6	52	86	134-874	40.50
	5.00*	.1969	6	52	86	134-875	37.30
	5.10*	.2008	6	52	86	134-876	37.30
13/64	5.16	.2031	6	52	86	134-877	50.80
	5.20	.2047	6	52	86	134-878	41.70
	5.30	.2087	6	52	86	134-879	46.10
	5.40	.2126	6	57	93	134-880	46.10
	5.50*	.2165	6	57	93	134-881	41.70
7/32	5.56	.2188	6	57	93	134-882	57.80
	5.60	.2205	6	57	93	134-883	51.90
	5.70	.2244	6	57	93	134-884	51.90
	5.80	.2283	6	57	93	134-885	51.90
	5.90	.2323	6	57	93	134-886	51.90
15/64	5.95	.2344	6	57	93	134-887	55.30
	6.00*	.2362	6	57	93	134-888	47.20
	6.10	.2402	8	63	101	134-889	62.40
	6.20	.2441	8	63	101	134-890	62.40
	6.30	.2480	8	63	101	134-891	62.40
1/4	6.35	.2500	8	63	101	134-892	65.90
	6.40	.2520	8	63	101	134-893	62.40
	6.50	.2559	8	63	101	134-894	57.10
	6.60*	.2598	8	63	101	134-895	62.70

Size (in)	Decimal (mm)	Decimal Equiv.	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$
	6.70	.2638	8	63	101	134-896	62.80
17/64	6.75	.2656	8	69	109	134-897	66.20
	6.80*	.2677	8	69	109	134-898	66.20
	6.90*	.2717	8	69	109	134-899	66.20
	7.00*	.2756	8	69	109	134-900	59.90
	7.10	.2795	8	69	109	134-901	64.60
9/32	7.14	.2812	8	69	109	134-902	68.10
	7.20	.2835	8	69	109	134-903	64.60
	7.30	.2874	8	69	109	134-904	64.60
	7.40	.2913	8	69	109	134-905	64.60
	7.50	.2953	8	69	109	134-906	64.60
19/64	7.54	.2969	8	75	117	134-907	75.10
	7.60	.2992	8	75	117	134-908	71.10
	7.70	.3031	8	75	117	134-909	71.10
	7.80	.3071	8	75	117	134-910	71.10
	7.90	.3110	8	75	117	134-911	71.10
5/16	7.94	.3125	8	75	117	134-912	75.10
	8.00*	.3150	8	75	117	134-913	67.50
	8.10	.3189	10	75	117	134-914	84.30
	8.20	.3228	10	75	117	134-915	84.30
	8.30	.3268	10	75	117	134-916	84.30
21/64	8.33	.3281	10	75	117	134-917	88.70
	8.40	.3307	10	75	117	134-918	84.30
	8.50*	.3346	10	75	117	134-919	88.70
	8.60	.3386	10	81	125	134-920	79.80
	8.70	.3425	10	81	125	134-921	93.90
11/32	8.73	.3438	10	81	125	134-922	99.40
	8.80	.3465	10	81	125	134-923	93.90
	8.90	.3504	10	81	125	134-924	93.90
	9.00	.3543	10	81	125	134-925	81.60
	9.10	.3583	10	81	125	134-926	102.60
23/64	9.13	.3594	10	81	125	134-927	108.10
	9.20	.3622	10	81	125	134-928	102.60
	9.30	.3661	10	81	125	134-929	102.60
	9.40*	.3701	10	81	125	134-930	102.60
	9.50	.3740	10	81	125	134-931	95.20
3/8	9.52	.3750	10	87	133	134-932	119.50
	9.60	.3780	10	87	133	134-933	113.10
	9.70	.3819	10	87	133	134-934	113.10
	9.80	.3858	10	87	133	134-935	113.10
	9.90*	.3898	10	87	133	134-936	113.10
25/64	9.92	.3906	10	87	133	134-937	119.50
	10.00	.3937	10	87	133	134-938	98.60
	10.10	.3976	10	87	133	134-939	124.10
	10.20*	.4016	10	87	133	134-940	123.90

* = Tap Drill sizes

ORANGE RING JOBBER DRILLS FOR STAINLESS STEEL



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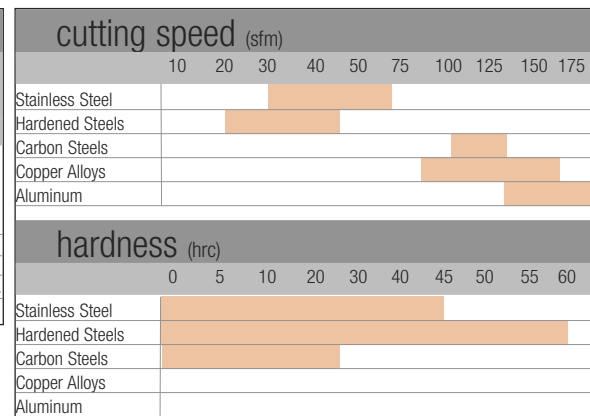
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Size (in)	Decimal (mm)	Decimal Equiv.	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$
13/32	10.30	.4055	10	87	133	134-941	124.10
	10.32	.4063	10	87	133	134-942	131.10
	10.40	.4095	10	87	133	134-943	124.10
	10.50	.4134	10	87	133	134-944	115.70
	10.60	.4173	12	87	133	134-945	134.60
27/64	10.70	.4213	12	94	142	134-946	134.60
	10.72	.4220	12	94	142	134-947	142.70
	10.80*	.4252	12	94	142	134-948	134.40
	10.90	.4291	12	94	142	134-949	134.40
7/16	11.00	.4331	12	94	142	134-950	119.00
	11.11	.4374	12	94	142	134-952	156.70
	11.20	.4410	12	94	142	134-953	148.30
	11.30	.4449	12	94	142	134-954	148.30
	11.40	.4488	12	94	142	134-955	148.30
29/64	11.50*	.4528	12	94	142	134-956	137.40
	11.51	.4531	12	94	142	134-957	168.60

Size (in)	Decimal (mm)	Decimal Equiv.	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$
15/32	11.60	.4567	12	94	142	134-958	158.70
	11.70	.4606	12	94	142	134-959	158.70
	11.80	.4646	12	94	142	134-960	158.70
	11.90	.4685	12	94	142	134-961	161.30
	11.91	.4689	12	101	151	134-962	171.10
31/64	12.00*	.4724	12	101	151	134-963	141.40
	12.10	.4764	12	101	151	134-964	173.70
	12.20*	.4803	12	101	151	134-965	173.70
	12.30	.4882	12	101	151	134-966	173.70
1/2	12.40	.4921	12	101	151	134-967	173.70
	12.50*	.4961	12	101	151	134-968	161.60
	12.60	.4961	12	101	151	134-969	182.70
	12.70	.5000	12	101	151	134-970	182.70
	12.80	.5039	12	101	151	134-971	182.70
1/2	12.90	.5079	12	101	151	134-972	182.70
	13.00*	.5118	12	101	151	134-973	164.90

* = Tap Drill sizes

cutting conditions				
Materials				Cutting Speed (SFM)
Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (SFM)
Stainless Steel	200 Series,	Annealed	<28	40-60
	300 Series,	Annealed	<28	30-60
	400 Series	Annealed	<29	55-65
	400 Series	Hardened	<45	50-70
Precipitation Hardened	S13800	Hardened	<60	20-45
Carbon Steels	Low, Mild	Normalized	<25	100-135
Copper Alloys	-	-	-	80-165 Per Rev.
Aluminum	Alloys	-	-	130-330



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