

- 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)	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$	
1.00	.0394	3	6	26	133-700	18.20	
1.10	.0433	3	7	28	133-701	20.70	
1.20	.0472	3	8	30	133-702	20.70	
1.30	.0512	3	8	30	133-703	20.70	
1.40	.0551	3	9	32	133-704	20.70	
1.50	.0591	3	9	32	133-705	18.00	
1.60	.0630	3	10	34	133-706	19.30	
1.70	.0669	3	10	34	133-707	20.70	
1.80	.0709	3	11	36	133-708	20.70	
1.90	.0748	3	11	36	133-709	20.70	
2.00	.0787	3	12	38	133-710	19.10	
2.10	.0827	3	13	40	133-711	21.80	
2.20	.0866	3	13	40	133-712	21.80	
2.30	.0906	3	13	40	133-713	21.80	
2.40	.0945	3	14	43	133-714	21.80	
2.50	.0984	3	14	43	133-715	19.10	
2.60	.1024	3	14	43	133-716	20.90	
2.70	.1063	3	16	46	133-717	20.90	
2.80	.1102	3	16	46	133-718	20.90	
2.90	.1142	3	16	46	133-719	20.90	
3.00	.1181	3	16	46	133-720	18.40	
3.10	.1220	4	18	49	133-721	22.30	
1/8	3.17	.1250	4	18	49	133-722	24.60
3.20	.1260	4	18	49	133-723	22.30	
3.30*	.1299	4	18	49	133-724	22.30	
3.40	.1339	4	20	52	133-725	22.30	
3.50*	.1378	4	20	52	133-726	22.30	
9/64	3.57	.1406	4	20	52	133-727	28.80
3.60	.1417	4	20	52	133-728	26.10	
3.70*	.1457	4	20	52	133-729	26.10	
3.80	.1496	4	22	55	133-730	23.90	
3.90*	.1535	4	22	55	133-731	26.10	
5/32	3.97	.1562	4	22	55	133-732	28.80
4.00	.1575	4	22	55	133-733	23.90	
4.10*	.1614	6	22	55	133-734	32.70	
4.20*	.1654	6	22	55	133-735	30.30	
4.30	.1693	6	24	58	133-736	32.70	
11/64	4.37	.1719	6	24	58	133-737	36.00
4.40	.1732	6	24	58	133-738	32.70	
4.50*	.1772	6	24	58	133-739	38.00	
4.60*	.1811	6	24	58	133-740	37.50	
4.70	.1850	6	24	58	133-741	37.50	
3/16	4.76	.1875	6	26	62	133-742	41.40
4.80	.1890	6	26	62	133-743	37.50	
4.90	.1929	6	26	62	133-744	37.50	
5.00*	.1969	6	26	62	133-745	34.30	
5.10*	.2008	6	26	62	133-746	34.30	
13/64	5.16	.2031	6	26	62	133-747	47.10
5.20	.2047	6	26	62	133-748	38.90	

Size (in)	Decimal (mm)	Shank Dia. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$	
5.30	.2087	6	26	62	133-749	42.70	
5.40	.2126	6	28	66	133-750	42.70	
5.50*	.2165	6	28	66	133-751	38.90	
7/32	5.56	.2188	6	28	66	133-752	53.10
5.60	.2205	6	28	66	133-753	48.20	
5.70	.2244	6	28	66	133-754	48.20	
5.80	.2283	6	28	66	133-755	48.20	
5.90	.2323	6	28	66	133-756	48.20	
15/64	5.95	.2344	6	28	66	133-757	49.20
6.00*	.2362	6	28	66	133-758	43.60	
6.10	.2402	8	32	70	133-759	57.50	
6.20	.2441	8	32	70	133-760	57.50	
6.30	.2480	8	32	70	133-761	57.40	
1/4	6.35	.2500	8	32	70	133-762	57.90
6.40	.2520	8	32	70	133-763	57.50	
6.50	.2559	8	32	70	133-764	48.30	
6.60*	.2598	8	32	70	133-765	57.80	
6.70	.2638	8	32	70	133-766	57.80	
17/64	6.75	.2656	8	34	74	133-767	59.30
6.80*	.2677	8	34	74	133-768	58.40	
6.90*	.2717	8	34	74	133-769	58.40	
7.00*	.2756	8	34	74	133-770	55.70	
7.10	.2795	8	34	74	133-771	59.60	
9/32	7.14	.2812	8	34	74	133-772	60.70
7.20	.2835	8	34	74	133-773	59.60	
7.30	.2874	8	34	74	133-774	59.60	
7.40	.2913	8	34	74	133-775	59.60	
7.50	.2953	8	34	74	133-776	59.60	
19/64	7.54	.2969	8	37	79	133-777	62.40
7.60	.2992	8	37	79	133-778	65.40	
7.70	.3031	8	37	79	133-779	65.40	
7.80	.3071	8	37	79	133-780	65.40	
7.90	.3110	8	37	79	133-781	65.40	
5/16	7.94	.3125	8	37	79	133-782	66.30
8.00*	.3150	8	37	79	133-783	62.20	
8.10	.3189	10	37	79	133-784	77.20	
8.20	.3228	10	37	79	133-785	77.20	
8.30	.3268	10	37	79	133-786	77.20	
21/64	8.33	.3281	10	37	79	133-787	78.50
8.40	.3307	10	37	79	133-788	77.20	
8.50*	.3346	10	37	79	133-789	71.10	
8.60	.3386	10	40	84	133-790	71.10	
8.70	.3425	10	40	84	133-791	84.50	
11/32	8.73	.3438	10	40	84	133-792	86.30
8.80	.3465	10	40	84	133-793	84.50	
8.90	.3504	10	40	84	133-794	84.60	
9.00	.3543	10	40	84	133-795	73.30	
9.10	.3583	10	40	84	133-796	92.10	
23/64	9.13	.3594	10	40	84	133-797	94.10

* = Tap Drill sizes

ORANGE RING STUB DRILLS FOR STAINLESS STEEL



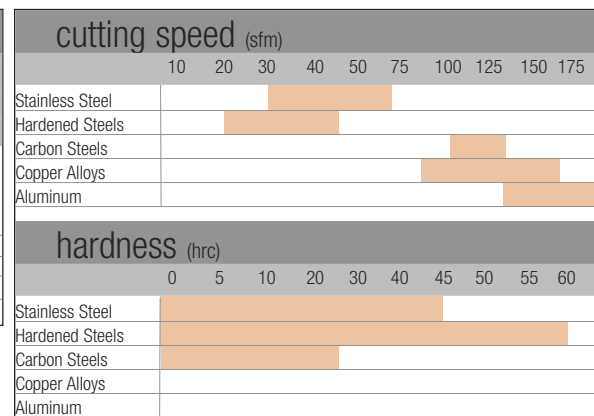
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Size (in)	Decimal (mm)	Shank Dia. Equiv. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$	
9.20	.3622	10	40	84	133-798	92.10	
9.30	.3661	10	40	84	133-799	92.10	
9.40*	.3701	10	40	84	133-800	92.10	
9.50	.3740	10	40	84	133-801	86.00	
3/8	9.52	.3750	10	43	89	133-802	104.10
	9.60	.3780	10	43	89	133-803	102.10
	9.70	.3819	10	43	89	133-804	102.10
	9.80	.3858	10	43	89	133-805	102.10
	9.90*	.3898	10	43	89	133-806	102.10
25/64	9.92	.3906	10	43	89	133-807	104.10
	10.00	.3937	10	43	89	133-808	88.70
	10.10	.3976	10	43	89	133-809	112.40
	10.20*	.4016	10	43	89	133-810	112.40
	10.30	.4055	10	43	89	133-811	112.40
13/32	10.32	.4063	10	43	89	133-812	114.60
	10.40	.4095	10	43	89	133-813	112.40
	10.50	.4134	10	43	89	133-814	104.40
	10.60	.4173	12	43	89	133-815	123.20
	10.70	.4213	12	47	95	133-816	123.20
27/64	10.72	.4220	12	47	95	133-817	123.20
	10.80*	.4252	12	47	95	133-818	123.20
	10.90	.4291	12	47	95	133-819	123.20
	11.00	.4331	12	47	95	133-820	109.00
7/16	11.11	.4374	12	47	95	133-822	138.10
	11.20	.4409	12	47	95	133-823	135.90
	11.30	.4449	12	47	95	133-824	135.90
	11.40	.4488	12	47	95	133-825	135.90
	11.50*	.4528	12	47	95	133-826	125.90
29/64	11.51	.4531	12	47	95	133-827	148.10
	11.60	.4567	12	47	95	133-828	145.80
	11.70	.4606	12	47	95	133-829	145.80
	11.80	.4646	12	47	95	133-830	145.80
	11.90	.4685	12	51	102	133-831	145.80
15/32	11.91	.4689	12	51	102	133-832	148.10
	12.00*	.4724	12	51	102	133-833	127.40
	12.10	.4764	12	51	102	133-834	156.90
	12.20*	.4803	12	51	102	133-835	156.80
31/64	12.30	.4882	12	51	102	133-836	156.80
	12.40	.4882	12	51	102	133-837	156.90

Size (in)	Decimal (mm)	Shank Dia. Equiv. (mm)	Flute Length (mm)	OAL (mm)	Code No.	Price \$	
	12.50*	.4961	12	51	102	133-838	144.40
	12.60	.4961	12	51	102	133-839	165.20
1/2	12.70	.5000	12	51	102	133-840	165.20
	12.80	.5039	12	51	102	133-841	165.20
	12.90	.5079	12	51	102	133-842	165.20
	13.00*	.5118	12	51	102	133-843	149.30
33/64	13.10	.5156	16	54	107	133-844	172.80
17/32	13.49	.5312	16	54	107	133-845	168.90
	13.50*	.5315	16	54	107	133-846	172.80
35/64	13.89	.5469	16	54	107	133-847	172.80
	14.00*	.5512	16	54	107	133-848	172.80
9/16	14.29	.5625	16	56	111	133-849	183.50
	14.50*	.5709	16	56	111	133-850	187.80
37/64	14.68	.5781	16	56	111	133-851	195.20
	15.00	.5906	16	56	111	133-852	195.20
19/32	15.08	.5938	16	58	115	133-853	147.37
39/64	15.48	.6094	16	58	115	133-854	240.20
	15.50*	.6102	16	58	115	133-855	245.70
5/8	15.87	.6250	16	58	115	133-856	240.20
	16.00	.6299	16	58	115	133-857	208.20
41/64	16.27	.6406	16	60	119	133-858	240.20
	16.50	.6496	20	60	119	133-859	220.50
21/32	16.67	.6562	20	60	119	133-860	240.20
	17.00	.6693	20	60	119	133-861	220.50
43/64	17.07	.6719	20	62	123	133-862	240.20
11/16	17.46	.6875	20	62	123	133-863	240.20
	17.50	.6890	20	62	123	133-864	244.40
45/64	17.86	.7031	20	62	123	133-865	240.20
	18.00	.7087	20	62	123	133-866	244.40
23/32	18.26	.7188	20	64	127	133-867	258.60
	18.50	.7283	20	64	127	133-868	264.50
47/64	18.65	.7344	20	64	127	133-869	268.40
	19.00	.7480	20	64	127	133-870	274.50
3/4	19.05	.7500	20	66	131	133-871	200.18
49/64	19.45	.7656	20	66	131	133-872	276.20
	19.50	.7677	20	66	131	133-873	282.60
25/32	19.84	.7812	20	66	131	133-874	276.20
	20.00	.7874	20	66	131	133-875	282.60

* = Tap Drill sizes

cutting conditions					
Materials				Hardness	Cutting Speed
Main Group	Sub-Group	Condition	(HRC)	(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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