

5xD

Steam Oxide  
>2.36 mm dia.

External Coolant



Straight Shank

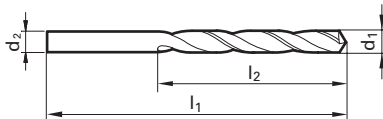
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## Series 205




## General Purpose

HSS, general purpose (Type N), jobber length, 118° point, Form A  
web thinned >2.36mm dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range

 $d_1 = d_2$ 

Application Materials:

-  General Steels / Brass
-  Universal Steels
-  Cast Iron

| Diameter (d1) |             |               |       |       |       |
|---------------|-------------|---------------|-------|-------|-------|
| Dec. inch     | Fract. inch | Wire / letter | mm    | l1 mm | l2 mm |
| 0.0083        |             | 91            | 0.210 | 19.00 | 2.50  |
| 0.0087        |             | 90            | 0.220 | 19.00 | 2.50  |
| 0.0091        |             | 89            | 0.230 | 19.00 | 2.50  |
| 0.0094        |             | 88            | 0.240 | 19.00 | 2.50  |
| 0.0098        |             | 87            | 0.250 | 19.00 | 3.00  |
| 0.0102        |             |               | 0.260 | 19.00 | 3.00  |
| 0.0106        |             | 86            | 0.270 | 19.00 | 3.00  |
| 0.0110        |             | 85            | 0.280 | 19.00 | 3.00  |
| 0.0114        |             | 84            | 0.290 | 19.00 | 3.00  |
| 0.0118        |             |               | 0.300 | 19.00 | 3.00  |
| 0.0122        |             | 83            | 0.310 | 19.00 | 4.00  |
| 0.0126        |             | 82            | 0.320 | 19.00 | 4.00  |
| 0.0130        |             | 81            | 0.330 | 19.00 | 4.00  |
| 0.0134        |             | 80            | 0.340 | 19.00 | 4.00  |
| 0.0138        |             |               | 0.350 | 19.00 | 4.00  |
| 0.0142        |             |               | 0.360 | 19.00 | 4.00  |
| 0.0146        |             | 79            | 0.370 | 19.00 | 4.00  |
| 0.0150        |             |               | 0.380 | 19.00 | 4.00  |
| 0.0154        |             |               | 0.390 | 20.00 | 5.00  |
| 0.0157        | 1/64        |               | 0.400 | 20.00 | 5.00  |
| 0.0161        |             | 78            | 0.410 | 20.00 | 5.00  |
| 0.0165        |             |               | 0.420 | 20.00 | 5.00  |
| 0.0169        |             |               | 0.430 | 20.00 | 5.00  |
| 0.0173        |             |               | 0.440 | 20.00 | 5.00  |
| 0.0177        |             |               | 0.450 | 20.00 | 5.00  |
| 0.0181        |             | 77            | 0.460 | 20.00 | 5.00  |
| 0.0185        |             |               | 0.470 | 20.00 | 5.00  |
| 0.0189        |             |               | 0.480 | 20.00 | 5.00  |
| 0.0193        |             |               | 0.490 | 22.00 | 6.00  |
| 0.0197        |             |               | 0.500 | 22.00 | 6.00  |
| 0.0201        |             | 76            | 0.510 | 22.00 | 6.00  |
| 0.0205        |             |               | 0.520 | 22.00 | 6.00  |
| 0.0209        |             | 75            | 0.530 | 22.00 | 6.00  |
| 0.0213        |             |               | 0.540 | 24.00 | 7.00  |
| 0.0217        |             |               | 0.550 | 24.00 | 7.00  |
| 0.0220        |             |               | 0.560 | 24.00 | 7.00  |
| 0.0224        |             | 74            | 0.570 | 24.00 | 7.00  |
| 0.0228        |             |               | 0.580 | 24.00 | 7.00  |
| 0.0232        |             |               | 0.590 | 24.00 | 7.00  |
| 0.0236        |             |               | 0.600 | 24.00 | 7.00  |
| 0.0240        |             | 73            | 0.610 | 26.00 | 8.00  |
| 0.0244        |             |               | 0.620 | 26.00 | 8.00  |
| 0.0248        |             |               | 0.630 | 26.00 | 8.00  |
| 0.0252        |             | 72            | 0.640 | 26.00 | 8.00  |
| 0.0256        |             |               | 0.650 | 26.00 | 8.00  |
| 0.0260        |             | 71            | 0.660 | 26.00 | 8.00  |
| 0.0264        |             |               | 0.670 | 26.00 | 8.00  |
| 0.0266        |             |               | 0.675 | 28.00 | 9.00  |
| 0.0268        |             |               | 0.680 | 28.00 | 9.00  |
| 0.0272        |             |               | 0.690 | 28.00 | 9.00  |
| 0.0276        |             |               | 0.700 | 28.00 | 9.00  |
| 0.0280        |             | 70            | 0.710 | 28.00 | 9.00  |
| 0.0283        |             |               | 0.720 | 28.00 | 9.00  |
| 0.0287        |             |               | 0.730 | 28.00 | 9.00  |

| Diameter (d1) |             |               |       |       |       |
|---------------|-------------|---------------|-------|-------|-------|
| Dec. inch     | Fract. inch | Wire / letter | mm    | l1 mm | l2 mm |
| 0.0291        |             | 69            | 0.740 | 28.00 | 9.00  |
| 0.0295        |             |               | 0.750 | 28.00 | 9.00  |
| 0.0299        |             |               | 0.760 | 30.00 | 10.00 |
| 0.0303        |             |               | 0.770 | 30.00 | 10.00 |
| 0.0307        |             |               | 0.780 | 30.00 | 10.00 |
| 0.0311        | 1/32        | 68            | 0.790 | 30.00 | 10.00 |
| 0.0315        |             |               | 0.800 | 30.00 | 10.00 |
| 0.0319        |             | 67            | 0.810 | 30.00 | 10.00 |
| 0.0323        |             |               | 0.820 | 30.00 | 10.00 |
| 0.0327        |             |               | 0.830 | 30.00 | 10.00 |
| 0.0331        |             |               | 0.840 | 30.00 | 10.00 |
| 0.0335        |             |               | 0.850 | 30.00 | 10.00 |
| 0.0339        |             |               | 0.860 | 32.00 | 11.00 |
| 0.0343        |             |               | 0.870 | 32.00 | 11.00 |
| 0.0346        |             |               | 0.880 | 32.00 | 11.00 |
| 0.0350        |             | 65            | 0.890 | 32.00 | 11.00 |
| 0.0354        |             |               | 0.900 | 32.00 | 11.00 |
| 0.0358        |             | 64            | 0.910 | 32.00 | 11.00 |
| 0.0362        |             |               | 0.920 | 32.00 | 11.00 |
| 0.0366        |             |               | 0.930 | 32.00 | 11.00 |
| 0.0370        |             | 63            | 0.940 | 32.00 | 11.00 |
| 0.0374        |             |               | 0.950 | 32.00 | 11.00 |
| 0.0378        |             |               | 0.960 | 34.00 | 12.00 |
| 0.0382        |             | 62            | 0.970 | 34.00 | 12.00 |
| 0.0386        |             |               | 0.980 | 34.00 | 12.00 |
| 0.0390        |             | 61            | 0.990 | 34.00 | 12.00 |
| 0.0394        |             |               | 1.000 | 34.00 | 12.00 |
| 0.0398        |             |               | 1.010 | 34.00 | 12.00 |
| 0.0402        |             | 60            | 1.020 | 34.00 | 12.00 |
| 0.0406        |             |               | 1.030 | 34.00 | 12.00 |
| 0.0409        |             | 59            | 1.040 | 34.00 | 12.00 |
| 0.0413        |             |               | 1.050 | 34.00 | 12.00 |
| 0.0417        |             |               | 1.060 | 34.00 | 12.00 |
| 0.0421        |             | 58            | 1.070 | 36.00 | 14.00 |
| 0.0425        |             |               | 1.080 | 36.00 | 14.00 |
| 0.0429        |             | 57            | 1.090 | 36.00 | 14.00 |
| 0.0433        |             |               | 1.100 | 36.00 | 14.00 |
| 0.0437        |             |               | 1.110 | 36.00 | 14.00 |
| 0.0441        |             |               | 1.120 | 36.00 | 14.00 |
| 0.0445        |             |               | 1.130 | 36.00 | 14.00 |
| 0.0449        |             |               | 1.140 | 36.00 | 14.00 |
| 0.0453        |             |               | 1.150 | 36.00 | 14.00 |
| 0.0457        |             |               | 1.160 | 36.00 | 14.00 |
| 0.0461        |             |               | 1.170 | 36.00 | 14.00 |
| 0.0465        |             | 56            | 1.180 | 36.00 | 14.00 |
| 0.0469        | 3/64        |               | 1.190 | 38.00 | 16.00 |
| 0.0472        |             |               | 1.200 | 38.00 | 16.00 |
| 0.0476        |             |               | 1.210 | 38.00 | 16.00 |
| 0.0480        |             |               | 1.220 | 38.00 | 16.00 |
| 0.0484        |             |               | 1.230 | 38.00 | 16.00 |
| 0.0488        |             |               | 1.240 | 38.00 | 16.00 |
| 0.0492        |             |               | 1.250 | 38.00 | 16.00 |
| 0.0496        |             |               | 1.260 | 38.00 | 16.00 |
| 0.0500        |             |               | 1.270 | 38.00 | 16.00 |

| Diameter (d1) |             |               |       |       |       |
|---------------|-------------|---------------|-------|-------|-------|
| Dec. inch     | Fract. inch | Wire / letter | mm    | l1 mm | l2 mm |
| 0.0504        |             |               | 1.280 | 38.00 | 16.00 |
| 0.0508        |             |               | 1.290 | 38.00 | 16.00 |
| 0.0512        |             |               | 1.300 | 38.00 | 16.00 |
| 0.0516        |             |               | 1.310 | 38.00 | 16.00 |
| 0.0520        |             | 55            | 1.320 | 38.00 | 16.00 |
| 0.0524        |             |               | 1.330 | 40.00 | 18.00 |
| 0.0528        |             |               | 1.340 | 40.00 | 18.00 |
| 0.0531        |             |               | 1.350 | 40.00 | 18.00 |
| 0.0535        |             |               | 1.360 | 40.00 | 18.00 |
| 0.0539        |             |               | 1.370 | 40.00 | 18.00 |
| 0.0543        |             |               | 1.380 | 40.00 | 18.00 |
| 0.0547        |             |               | 1.390 | 40.00 | 18.00 |
| 0.0551        |             | 54            | 1.400 | 40.00 | 18.00 |
| 0.0555        |             |               | 1.410 | 40.00 | 18.00 |
| 0.0559        |             |               | 1.420 | 40.00 | 18.00 |
| 0.0563        |             |               | 1.430 | 40.00 | 18.00 |
| 0.0567        |             |               | 1.440 | 40.00 | 18.00 |
| 0.0571        |             |               | 1.450 | 40.00 | 18.00 |
| 0.0575        |             |               | 1.460 | 40.00 | 18.00 |
| 0.0579        |             |               | 1.470 | 40.00 | 18.00 |
| 0.0583        |             |               | 1.480 | 40.00 | 18.00 |
| 0.0587        |             |               | 1.490 | 40.00 | 18.00 |
| 0.0591        |             |               | 1.500 | 40.00 | 18.00 |
| 0.0594        |             | 53            | 1.510 | 43.00 | 20.00 |
| 0.0598        |             |               | 1.520 | 43.00 | 20.00 |
| 0.0602        |             |               | 1.530 | 43.00 | 20.00 |
| 0.0606        |             |               | 1.540 | 43.00 | 20.00 |
| 0.0610        |             |               | 1.550 | 43.00 | 20.00 |
| 0.0614        |             |               | 1.560 | 43.00 | 20.00 |
| 0.0618        |             |               | 1.570 | 43.00 | 20.00 |
| 0.0622        |             |               | 1.580 | 43.00 | 20.00 |
| 0.0626        | 1/16        |               | 1.590 | 43.00 | 20.00 |
| 0.0630        |             |               | 1.600 | 43.00 | 20.00 |
| 0.0634        |             | 52            | 1.610 | 43.00 | 20.00 |
| 0.0638        |             |               | 1.620 | 43.00 | 20.00 |
| 0.0642        |             |               | 1.630 | 43.00 | 20.00 |
| 0.0646        |             |               | 1.640 | 43.00 | 20.00 |
| 0.0650        |             |               | 1.650 | 43.00 | 20.00 |
| 0.0654        |             |               | 1.660 | 43.00 | 20.00 |
| 0.0657        |             |               | 1.670 | 43.00 | 20.00 |
| 0.0661        |             |               | 1.680 | 43.00 | 20.00 |
| 0.0665        |             |               | 1.690 | 43.00 | 20.00 |
| 0.0669        |             | 51            | 1.700 | 43.00 | 20.00 |
| 0.0673        |             |               | 1.710 | 46.00 | 22.00 |
| 0.0677        |             |               | 1.720 | 46.00 | 22.00 |
| 0.0681        |             |               | 1.730 | 46.00 | 22.00 |
| 0.0685        |             |               | 1.740 | 46.00 | 22.00 |
| 0.0689        |             |               | 1.750 | 46.00 | 22.00 |
| 0.0693        |             |               | 1.760 | 46.00 | 22.00 |
| 0.0697        |             |               | 1.770 | 46.00 | 22.00 |
| 0.0701        |             | 50            | 1.780 | 46.00 | 22.00 |
| 0.0705        |             |               | 1.790 | 46.00 | 22.00 |
| 0.0709        |             |               | 1.800 | 46.00 | 22.00 |
| 0.0713        |             |               | 1.810 | 46.00 | 22.00 |





# Series 205

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| Diameter (d1) |             |               |        |        |        |
|---------------|-------------|---------------|--------|--------|--------|
| Dec. inch     | Fract. inch | Wire / letter | mm     | I1 mm  | I2 mm  |
| 0.5846        |             |               | 14.850 | 169.00 | 114.00 |
| 0.5866        |             |               | 14.900 | 169.00 | 114.00 |
| 0.5906        |             |               | 15.000 | 169.00 | 114.00 |
| 0.5937        | 19/32       |               | 15.080 | 178.00 | 120.00 |
| 0.5945        |             |               | 15.100 | 178.00 | 120.00 |
| 0.5984        |             |               | 15.200 | 178.00 | 120.00 |
| 0.6004        |             |               | 15.250 | 178.00 | 120.00 |
| 0.6024        |             |               | 15.300 | 178.00 | 120.00 |
| 0.6063        |             |               | 15.400 | 178.00 | 120.00 |
| 0.6094        | 39/64       |               | 15.480 | 178.00 | 120.00 |
| 0.6102        |             |               | 15.500 | 178.00 | 120.00 |
| 0.6142        |             |               | 15.600 | 178.00 | 120.00 |
| 0.6181        |             |               | 15.700 | 178.00 | 120.00 |
| 0.6201        |             |               | 15.750 | 178.00 | 120.00 |
| 0.6220        |             |               | 15.800 | 178.00 | 120.00 |
| 0.6248        | 5/8         |               | 15.870 | 178.00 | 120.00 |
| 0.6260        |             |               | 15.900 | 178.00 | 120.00 |
| 0.6299        |             |               | 16.000 | 178.00 | 120.00 |
| 0.6339        |             |               | 16.100 | 184.00 | 125.00 |
| 0.6378        |             |               | 16.200 | 184.00 | 125.00 |
| 0.6398        |             |               | 16.250 | 184.00 | 125.00 |
| 0.6406        | 41/64       |               | 16.270 | 184.00 | 125.00 |
| 0.6417        |             |               | 16.300 | 184.00 | 125.00 |
| 0.6457        |             |               | 16.400 | 184.00 | 125.00 |
| 0.6496        |             |               | 16.500 | 184.00 | 125.00 |
| 0.6535        |             |               | 16.600 | 184.00 | 125.00 |

| Diameter (d1) |             |               |        |        |        |
|---------------|-------------|---------------|--------|--------|--------|
| Dec. inch     | Fract. inch | Wire / letter | mm     | I1 mm  | I2 mm  |
| 0.6563        | 21/32       |               | 16.670 | 184.00 | 125.00 |
| 0.6575        |             |               | 16.700 | 184.00 | 125.00 |
| 0.6594        |             |               | 16.750 | 184.00 | 125.00 |
| 0.6614        |             |               | 16.800 | 184.00 | 125.00 |
| 0.6654        |             |               | 16.900 | 184.00 | 125.00 |
| 0.6693        |             |               | 17.000 | 184.00 | 125.00 |
| 0.6720        | 43/64       |               | 17.070 | 191.00 | 130.00 |
| 0.6732        |             |               | 17.100 | 191.00 | 130.00 |
| 0.6772        |             |               | 17.200 | 191.00 | 130.00 |
| 0.6791        |             |               | 17.250 | 191.00 | 130.00 |
| 0.6811        |             |               | 17.300 | 191.00 | 130.00 |
| 0.6850        |             |               | 17.400 | 191.00 | 130.00 |
| 0.6874        | 11/16       |               | 17.460 | 191.00 | 130.00 |
| 0.6890        |             |               | 17.500 | 191.00 | 130.00 |
| 0.6929        |             |               | 17.600 | 191.00 | 130.00 |
| 0.6969        |             |               | 17.700 | 191.00 | 130.00 |
| 0.6988        |             |               | 17.750 | 191.00 | 130.00 |
| 0.7008        |             |               | 17.800 | 191.00 | 130.00 |
| 0.7031        | 45/64       |               | 17.860 | 191.00 | 130.00 |
| 0.7047        |             |               | 17.900 | 191.00 | 130.00 |
| 0.7087        |             |               | 18.000 | 191.00 | 130.00 |
| 0.7126        |             |               | 18.100 | 198.00 | 135.00 |
| 0.7165        |             |               | 18.200 | 198.00 | 135.00 |
| 0.7185        |             |               | 18.250 | 198.00 | 135.00 |
| 0.7189        | 23/32       |               | 18.260 | 198.00 | 135.00 |
| 0.7205        |             |               | 18.300 | 198.00 | 135.00 |

| Diameter (d1) |             |               |        |        |        |
|---------------|-------------|---------------|--------|--------|--------|
| Dec. inch     | Fract. inch | Wire / letter | mm     | I1 mm  | I2 mm  |
| 0.7244        |             |               | 18.400 | 198.00 | 135.00 |
| 0.7283        |             |               | 18.500 | 198.00 | 135.00 |
| 0.7323        |             |               | 18.600 | 198.00 | 135.00 |
| 0.7343        | 47/64       |               | 18.650 | 198.00 | 135.00 |
| 0.7382        |             |               | 18.750 | 198.00 | 135.00 |
| 0.7402        |             |               | 18.800 | 198.00 | 135.00 |
| 0.7441        |             |               | 18.900 | 198.00 | 135.00 |
| 0.7480        |             |               | 19.000 | 198.00 | 135.00 |
| 0.7500        | 3/4         |               | 19.050 | 205.00 | 140.00 |
| 0.7520        |             |               | 19.100 | 205.00 | 140.00 |
| 0.7559        |             |               | 19.200 | 205.00 | 140.00 |
| 0.7579        |             |               | 19.250 | 205.00 | 140.00 |
| 0.7638        |             |               | 19.400 | 205.00 | 140.00 |
| 0.7677        |             |               | 19.500 | 205.00 | 140.00 |
| 0.7717        |             |               | 19.600 | 205.00 | 140.00 |
| 0.7776        |             |               | 19.750 | 205.00 | 140.00 |
| 0.7811        | 25/32       |               | 19.840 | 205.00 | 140.00 |
| 0.7874        |             |               | 20.000 | 205.00 | 140.00 |

**Alternative Drill Series:**

- #651 HSS, GP, 5xD, 118 pt, TiN
- #305 Cobalt, GP, 5xD, 118 pt, Oxide
- #732 Carbide, GP, 5xD, 130 pt, Bright
- #5523 Cobalt, GU500, 5xD, 118 pt, Bright
- #5519 Cobalt, GU500, 5xD, 118 pt, TiN