# 5xD

# Series 651

## 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

TiN coated

External Coolant

Straight Shank

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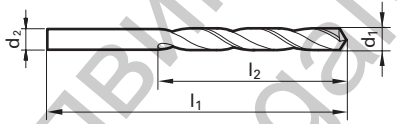
Application Materials:

- Universal Steels
- Cast Iron
- General Steels




$d_1 = d_2$

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.0079 | | 92 | 0.200 | 19.00 | 2.50 |
| 0.0098 | | 87 | 0.250 | 19.00 | 3.00 |
| 0.0110 | | 85 | 0.280 | 19.00 | 3.00 |
| 0.0118 | | | 0.300 | 19.00 | 3.00 |
| 0.0122 | | 83 | 0.310 | 19.00 | 4.00 |
| 0.0130 | | 81 | 0.330 | 19.00 | 4.00 |
| 0.0134 | | 80 | 0.340 | 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 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 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 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 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 |
| 0.0224 | | 74 | 0.570 | 24.00 | 7.00 |
| 0.0228 | | | 0.580 | 24.00 | 7.00 |
| 0.0232 | | | 0.590 | 24.00 | 7.00 |

*To order: Series number + mm, ex. 5518 3.000*

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# Series 651

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| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.0236 | | | 0.600 | 24.00 | 7.00 |
| 0.0240 | | 73 | 0.610 | 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 |
| 0.0268 | | | 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 |
| 0.0291 | | 69 | 0.740 | 28.00 | 9.00 |
| 0.0295 | | | 0.750 | 28.00 | 9.00 |
| 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 | | 66 | 0.840 | 30.00 | 10.00 |
| 0.0335 | | | 0.850 | 30.00 | 10.00 |
| 0.0339 | | | 0.860 | 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 |
| 0.0402 | | 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 |
| 0.0421 | | 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 |
| 0.0488 | | | 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 |
| 0.0504 | | | 1.280 | 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 |
| 0.0528 | | | 1.340 | 40.00 | 18.00 |
| 0.0531 | | | 1.350 | 40.00 | 18.00 |
| 0.0551 | | 54 | 1.400 | 40.00 | 18.00 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.0559 | | | 1.420 | 40.00 | 18.00 |
| 0.0563 | | | 1.430 | 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 |
| 0.0591 | | | 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 |
| 0.0618 | | | 1.570 | 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 |
| 0.0646 | | | 1.640 | 43.00 | 20.00 |
| 0.0650 | | | 1.650 | 43.00 | 20.00 |
| 0.0661 | | | 1.680 | 43.00 | 20.00 |
| 0.0669 | | 51 | 1.700 | 43.00 | 20.00 |
| 0.0673 | | | 1.710 | 46.00 | 22.00 |
| 0.0681 | | | 1.730 | 46.00 | 22.00 |
| 0.0689 | | | 1.750 | 46.00 | 22.00 |
| 0.0697 | | | 1.770 | 46.00 | 22.00 |
| 0.0701 | | 50 | 1.780 | 46.00 | 22.00 |
| 0.0709 | | | 1.800 | 46.00 | 22.00 |
| 0.0717 | | | 1.820 | 46.00 | 22.00 |
| 0.0720 | | | 1.830 | 46.00 | 22.00 |
| 0.0724 | | | 1.840 | 46.00 | 22.00 |
| 0.0728 | | 49 | 1.850 | 46.00 | 22.00 |
| 0.0736 | | | 1.870 | 46.00 | 22.00 |
| 0.0748 | | | 1.900 | 46.00 | 22.00 |
| 0.0760 | | 48 | 1.930 | 49.00 | 24.00 |
| 0.0768 | | | 1.950 | 49.00 | 24.00 |
| 0.0772 | | | 1.960 | 49.00 | 24.00 |
| 0.0776 | | | 1.970 | 49.00 | 24.00 |
| 0.0780 | 5/64 | | 1.980 | 49.00 | 24.00 |
| 0.0783 | | 47 | 1.990 | 49.00 | 24.00 |
| 0.0787 | | | 2.000 | 49.00 | 24.00 |
| 0.0795 | | | 2.020 | 49.00 | 24.00 |
| 0.0799 | | | 2.030 | 49.00 | 24.00 |
| 0.0807 | | | 2.050 | 49.00 | 24.00 |
| 0.0811 | | 46 | 2.060 | 49.00 | 24.00 |
| 0.0819 | | 45 | 2.080 | 49.00 | 24.00 |
| 0.0827 | | | 2.100 | 49.00 | 24.00 |
| 0.0846 | | | 2.150 | 53.00 | 27.00 |
| 0.0858 | | 44 | 2.180 | 53.00 | 27.00 |
| 0.0866 | | | 2.200 | 53.00 | 27.00 |
| 0.0886 | | | 2.250 | 53.00 | 27.00 |
| 0.0890 | | 43 | 2.260 | 53.00 | 27.00 |
| 0.0906 | | | 2.300 | 53.00 | 27.00 |
| 0.0925 | | | 2.350 | 53.00 | 27.00 |
| 0.0933 | | 42 | 2.370 | 57.00 | 30.00 |
| 0.0937 | 3/32 | | 2.380 | 57.00 | 30.00 |
| 0.0945 | | | 2.400 | 57.00 | 30.00 |
| 0.0961 | | 41 | 2.440 | 57.00 | 30.00 |
| 0.0965 | | | 2.450 | 57.00 | 30.00 |
| 0.0980 | | 40 | 2.490 | 57.00 | 30.00 |
| 0.0984 | | | 2.500 | 57.00 | 30.00 |
| 0.0996 | | 39 | 2.530 | 57.00 | 30.00 |
| 0.1004 | | | 2.550 | 57.00 | 30.00 |
| 0.1016 | | 38 | 2.580 | 57.00 | 30.00 |
| 0.1024 | | | 2.600 | 57.00 | 30.00 |
| 0.1039 | | 37 | 2.640 | 57.00 | 30.00 |
| 0.1043 | | | 2.650 | 57.00 | 30.00 |
| 0.1063 | | | 2.700 | 61.00 | 33.00 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.1067 | | 36 | 2.710 | 61.00 | 33.00 |
| 0.1083 | | | 2.750 | 61.00 | 33.00 |
| 0.1094 | 7/64 | | 2.780 | 61.00 | 33.00 |
| 0.1098 | | 35 | 2.790 | 61.00 | 33.00 |
| 0.1102 | | | 2.800 | 61.00 | 33.00 |
| 0.1110 | | 34 | 2.820 | 61.00 | 33.00 |
| 0.1122 | | | 2.850 | 61.00 | 33.00 |
| 0.1130 | | 33 | 2.870 | 61.00 | 33.00 |
| 0.1142 | | | 2.900 | 61.00 | 33.00 |
| 0.1161 | | 32 | 2.950 | 61.00 | 33.00 |
| 0.1181 | | | 3.000 | 61.00 | 33.00 |
| 0.1201 | | 31 | 3.050 | 65.00 | 36.00 |
| 0.1220 | | | 3.100 | 65.00 | 36.00 |
| 0.1240 | | | 3.150 | 65.00 | 36.00 |
| 0.1248 | 1/8 | | 3.170 | 65.00 | 36.00 |
| 0.1260 | | | 3.200 | 65.00 | 36.00 |
| 0.1280 | | | 3.250 | 65.00 | 36.00 |
| 0.1283 | | 30 | 3.260 | 65.00 | 36.00 |
| 0.1299 | | | 3.300 | 65.00 | 36.00 |
| 0.1319 | | | 3.350 | 65.00 | 36.00 |
| 0.1339 | | | 3.400 | 70.00 | 39.00 |
| 0.1358 | | 29 | 3.450 | 70.00 | 39.00 |
| 0.1378 | | | 3.500 | 70.00 | 39.00 |
| 0.1398 | | | 3.550 | 70.00 | 39.00 |
| 0.1406 | 9/64 | 28 | 3.570 | 70.00 | 39.00 |
| 0.1417 | | | 3.600 | 70.00 | 39.00 |
| 0.1437 | | | 3.650 | 70.00 | 39.00 |
| 0.1441 | | 27 | 3.660 | 70.00 | 39.00 |
| 0.1457 | | | 3.700 | 70.00 | 39.00 |
| 0.1469 | | 26 | 3.730 | 70.00 | 39.00 |
| 0.1476 | | | 3.750 | 70.00 | 39.00 |
| 0.1496 | | 25 | 3.800 | 75.00 | 43.00 |
| 0.1516 | | | 3.850 | 75.00 | 43.00 |
| 0.1520 | | 24 | 3.860 | 75.00 | 43.00 |
| 0.1535 | | | 3.900 | 75.00 | 43.00 |
| 0.1539 | | 23 | 3.910 | 75.00 | 43.00 |
| 0.1555 | | | 3.950 | 75.00 | 43.00 |
| 0.1563 | 5/32 | | 3.970 | 75.00 | 43.00 |
| 0.1571 | | 22 | 3.990 | 75.00 | 43.00 |
| 0.1575 | | | 4.000 | 75.00 | 43.00 |
| 0.1591 | | 21 | 4.040 | 75.00 | 43.00 |
| 0.1594 | | | 4.050 | 75.00 | 43.00 |
| 0.1610 | | 20 | 4.090 | 75.00 | 43.00 |
| 0.1614 | | | 4.100 | 75.00 | 43.00 |
| 0.1634 | | | 4.150 | 75.00 | 43.00 |
| 0.1654 | | | 4.200 | 75.00 | 43.00 |
| 0.1661 | | 19 | 4.220 | 75.00 | 43.00 |
| 0.1673 | | | 4.250 | 75.00 | 43.00 |
| 0.1693 | | 18 | 4.300 | 80.00 | 47.00 |
| 0.1713 | | | 4.350 | 80.00 | 47.00 |
| 0.1720 | 11/64 | | 4.370 | 80.00 | 47.00 |
| 0.1728 | | 17 | 4.390 | 80.00 | 47.00 |
| 0.1732 | | | 4.400 | 80.00 | 47.00 |
| 0.1752 | | | 4.450 | 80.00 | 47.00 |
| 0.1772 | | 16 | 4.500 | 80.00 | 47.00 |
| 0.1799 | | 15 | 4.570 | 80.00 | 47.00 |
| 0.1811 | | | 4.600 | 80.00 | 47.00 |
| 0.1819 | | 14 | 4.620 | 80.00 | 47.00 |
| 0.1831 | | | 4.650 | 80.00 | 47.00 |
| 0.1850 | | 13 | 4.700 | 80.00 | 47.00 |
| 0.1870 | | | 4.750 | 80.00 | 47.00 |
| 0.1874 | 3/16 | | 4.760 | 86.00 | 52.00 |
| 0.1890 | | 12 | 4.800 | 86.00 | 52.00 |
| 0.1909 | | 11 | 4.850 | 86.00 | 52.00 |
| 0.1929 | | | 4.900 | 86.00 | 52.00 |
| 0.1937 | | 10 | 4.920 | 86.00 | 52.00 |
| 0.1949 | | | 4.950 | 86.00 | 52.00 |

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# Series 651

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| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.1961 | | 9 | 4.980 | 86.00 | 52.00 |
| 0.1969 | | | 5.000 | 86.00 | 52.00 |
| 0.1988 | | | 5.050 | 86.00 | 52.00 |
| 0.1992 | | 8 | 5.060 | 86.00 | 52.00 |
| 0.2008 | | | 5.100 | 86.00 | 52.00 |
| 0.2012 | | 7 | 5.110 | 86.00 | 52.00 |
| 0.2031 | 13/64 | | 5.160 | 86.00 | 52.00 |
| 0.2039 | | 6 | 5.180 | 86.00 | 52.00 |
| 0.2047 | | | 5.200 | 86.00 | 52.00 |
| 0.2055 | | 5 | 5.220 | 86.00 | 52.00 |
| 0.2067 | | | 5.250 | 86.00 | 52.00 |
| 0.2087 | | | 5.300 | 86.00 | 52.00 |
| 0.2091 | | 4 | 5.310 | 93.00 | 57.00 |
| 0.2126 | | | 5.400 | 93.00 | 57.00 |
| 0.2130 | | 3 | 5.410 | 93.00 | 57.00 |
| 0.2146 | | | 5.450 | 93.00 | 57.00 |
| 0.2165 | | | 5.500 | 93.00 | 57.00 |
| 0.2189 | 7/32 | | 5.560 | 93.00 | 57.00 |
| 0.2205 | | | 5.600 | 93.00 | 57.00 |
| 0.2209 | | 2 | 5.610 | 93.00 | 57.00 |
| 0.2224 | | | 5.650 | 93.00 | 57.00 |
| 0.2244 | | | 5.700 | 93.00 | 57.00 |
| 0.2264 | | | 5.750 | 93.00 | 57.00 |
| 0.2280 | | 1 | 5.790 | 93.00 | 57.00 |
| 0.2283 | | | 5.800 | 93.00 | 57.00 |
| 0.2323 | | | 5.900 | 93.00 | 57.00 |
| 0.2339 | | A | 5.940 | 93.00 | 57.00 |
| 0.2343 | 15/64 | | 5.950 | 93.00 | 57.00 |
| 0.2362 | | | 6.000 | 93.00 | 57.00 |
| 0.2378 | | B | 6.040 | 101.00 | 63.00 |
| 0.2382 | | | 6.050 | 101.00 | 63.00 |
| 0.2402 | | | 6.100 | 101.00 | 63.00 |
| 0.2421 | | C | 6.150 | 101.00 | 63.00 |
| 0.2441 | | | 6.200 | 101.00 | 63.00 |
| 0.2461 | | D | 6.250 | 101.00 | 63.00 |
| 0.2480 | | | 6.300 | 101.00 | 63.00 |
| 0.2500 | 1/4 | E | 6.350 | 101.00 | 63.00 |
| 0.2520 | | | 6.400 | 101.00 | 63.00 |
| 0.2559 | | | 6.500 | 101.00 | 63.00 |
| 0.2571 | | F | 6.530 | 101.00 | 63.00 |
| 0.2598 | | | 6.600 | 101.00 | 63.00 |
| 0.2610 | | G | 6.630 | 101.00 | 63.00 |
| 0.2638 | | | 6.700 | 101.00 | 63.00 |
| 0.2657 | 17/64 | H | 6.750 | 109.00 | 69.00 |
| 0.2677 | | | 6.800 | 109.00 | 69.00 |
| 0.2697 | | | 6.850 | 109.00 | 69.00 |
| 0.2717 | | I | 6.900 | 109.00 | 69.00 |
| 0.2756 | | | 7.000 | 109.00 | 69.00 |
| 0.2768 | | J | 7.030 | 109.00 | 69.00 |
| 0.2795 | | | 7.100 | 109.00 | 69.00 |
| 0.2811 | 9/32 | K | 7.140 | 109.00 | 69.00 |
| 0.2835 | | | 7.200 | 109.00 | 69.00 |
| 0.2854 | | | 7.250 | 109.00 | 69.00 |
| 0.2874 | | | 7.300 | 109.00 | 69.00 |
| 0.2902 | | L | 7.370 | 109.00 | 69.00 |
| 0.2913 | | | 7.400 | 109.00 | 69.00 |
| 0.2933 | | | 7.450 | 109.00 | 69.00 |
| 0.2949 | | M | 7.490 | 109.00 | 69.00 |
| 0.2953 | | | 7.500 | 109.00 | 69.00 |
| 0.2969 | 19/64 | | 7.540 | 117.00 | 75.00 |
| 0.2992 | | | 7.600 | 117.00 | 75.00 |
| 0.3020 | | N | 7.670 | 117.00 | 75.00 |
| 0.3031 | | | 7.700 | 117.00 | 75.00 |
| 0.3051 | | | 7.750 | 117.00 | 75.00 |
| 0.3071 | | | 7.800 | 117.00 | 75.00 |
| 0.3110 | | | 7.900 | 117.00 | 75.00 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.3126 | 5/16 | | 7.940 | 117.00 | 75.00 |
| 0.3150 | | | 8.000 | 117.00 | 75.00 |
| 0.3161 | | O | 8.030 | 117.00 | 75.00 |
| 0.3189 | | | 8.100 | 117.00 | 75.00 |
| 0.3228 | | P | 8.200 | 117.00 | 75.00 |
| 0.3248 | | | 8.250 | 117.00 | 75.00 |
| 0.3268 | | | 8.300 | 117.00 | 75.00 |
| 0.3280 | 21/64 | | 8.330 | 117.00 | 75.00 |
| 0.3307 | | | 8.400 | 117.00 | 75.00 |
| 0.3319 | | Q | 8.430 | 117.00 | 75.00 |
| 0.3346 | | | 8.500 | 117.00 | 75.00 |
| 0.3386 | | | 8.600 | 125.00 | 81.00 |
| 0.3390 | | R | 8.610 | 125.00 | 81.00 |
| 0.3425 | | | 8.700 | 125.00 | 81.00 |
| 0.3437 | 11/32 | | 8.730 | 125.00 | 81.00 |
| 0.3445 | | | 8.750 | 125.00 | 81.00 |
| 0.3465 | | | 8.800 | 125.00 | 81.00 |
| 0.3480 | | S | 8.840 | 125.00 | 81.00 |
| 0.3484 | | | 8.850 | 125.00 | 81.00 |
| 0.3504 | | | 8.900 | 125.00 | 81.00 |
| 0.3543 | | | 9.000 | 125.00 | 81.00 |
| 0.3579 | | T | 9.090 | 125.00 | 81.00 |
| 0.3583 | | | 9.100 | 125.00 | 81.00 |
| 0.3594 | 23/64 | | 9.130 | 125.00 | 81.00 |
| 0.3622 | | | 9.200 | 125.00 | 81.00 |
| 0.3642 | | | 9.250 | 125.00 | 81.00 |
| 0.3661 | | | 9.300 | 125.00 | 81.00 |
| 0.3677 | | U | 9.340 | 125.00 | 81.00 |
| 0.3701 | | | 9.400 | 125.00 | 81.00 |
| 0.3740 | | | 9.500 | 125.00 | 81.00 |
| 0.3748 | 3/8 | | 9.520 | 133.00 | 87.00 |
| 0.3760 | | | 9.550 | 133.00 | 87.00 |
| 0.3772 | | V | 9.580 | 133.00 | 87.00 |
| 0.3780 | | | 9.600 | 133.00 | 87.00 |
| 0.3819 | | | 9.700 | 133.00 | 87.00 |
| 0.3839 | | | 9.750 | 133.00 | 87.00 |
| 0.3858 | | W | 9.800 | 133.00 | 87.00 |
| 0.3898 | | | 9.900 | 133.00 | 87.00 |
| 0.3906 | 25/64 | | 9.920 | 133.00 | 87.00 |
| 0.3937 | | | 10.000 | 133.00 | 87.00 |
| 0.3961 | | | 10.060 | 133.00 | 87.00 |
| 0.3969 | | X | 10.080 | 133.00 | 87.00 |
| 0.3976 | | | 10.100 | 133.00 | 87.00 |
| 0.4016 | | | 10.200 | 133.00 | 87.00 |
| 0.4035 | | | 10.250 | 133.00 | 87.00 |
| 0.4039 | | Y | 10.260 | 133.00 | 87.00 |
| 0.4055 | | | 10.300 | 133.00 | 87.00 |
| 0.4063 | 13/32 | | 10.320 | 133.00 | 87.00 |
| 0.4094 | | | 10.400 | 133.00 | 87.00 |
| 0.4130 | | Z | 10.490 | 133.00 | 87.00 |
| 0.4134 | | | 10.500 | 133.00 | 87.00 |
| 0.4154 | | | 10.550 | 133.00 | 87.00 |
| 0.4173 | | | 10.600 | 133.00 | 87.00 |
| 0.4213 | | | 10.700 | 142.00 | 94.00 |
| 0.4220 | 27/64 | | 10.720 | 142.00 | 94.00 |
| 0.4232 | | | 10.750 | 142.00 | 94.00 |
| 0.4252 | | | 10.800 | 142.00 | 94.00 |
| 0.4291 | | | 10.900 | 142.00 | 94.00 |
| 0.4331 | | | 11.000 | 142.00 | 94.00 |
| 0.4370 | | | 11.100 | 142.00 | 94.00 |
| 0.4374 | 7/16 | | 11.110 | 142.00 | 94.00 |
| 0.4409 | | | 11.200 | 142.00 | 94.00 |
| 0.4429 | | | 11.250 | 142.00 | 94.00 |
| 0.4449 | | | 11.300 | 142.00 | 94.00 |
| 0.4488 | | | 11.400 | 142.00 | 94.00 |
| 0.4528 | | | 11.500 | 142.00 | 94.00 |

| Diameter (d1) Dec. inch | Fract. inch | Wire / letter | mm | l1 mm | l2 mm |
|---|---|---|---|---|---|
| 0.4531 | 29/64 | | 11.510 | 142.00 | 94.00 |
| 0.4587 | | | 11.650 | 142.00 | 94.00 |
| 0.4606 | | | 11.700 | 142.00 | 94.00 |
| 0.4646 | | | 11.800 | 142.00 | 94.00 |
| 0.4689 | 15/32 | | 11.910 | 151.00 | 101.00 |
| 0.4724 | | | 12.000 | 151.00 | 101.00 |
| 0.4764 | | | 12.100 | 151.00 | 101.00 |
| 0.4803 | | | 12.200 | 151.00 | 101.00 |
| 0.4843 | 31/64 | | 12.300 | 151.00 | 101.00 |
| 0.4882 | | | 12.400 | 151.00 | 101.00 |
| 0.4921 | | | 12.500 | 151.00 | 101.00 |
| 0.4961 | | | 12.600 | 151.00 | 101.00 |
| 0.5000 | 1/2 | | 12.700 | 151.00 | 101.00 |
| 0.5039 | | | 12.800 | 151.00 | 101.00 |
| 0.5079 | | | 12.900 | 151.00 | 101.00 |
| 0.5118 | | | 13.000 | 151.00 | 101.00 |
| 0.5157 | 33/64 | | 13.100 | 151.00 | 101.00 |
| 0.5197 | | | 13.200 | 151.00 | 101.00 |
| 0.5217 | | | 13.250 | 160.00 | 108.00 |
| 0.5311 | 17/32 | | 13.490 | 160.00 | 108.00 |
| 0.5315 | | | 13.500 | 160.00 | 108.00 |
| 0.5394 | | | 13.700 | 160.00 | 108.00 |
| 0.5433 | | | 13.800 | 160.00 | 108.00 |
| 0.5469 | 35/64 | | 13.890 | 160.00 | 108.00 |
| 0.5472 | | | 13.900 | 160.00 | 108.00 |
| 0.5512 | | | 14.000 | 160.00 | 108.00 |
| 0.5591 | | | 14.200 | 169.00 | 114.00 |
| 0.5610 | | | 14.250 | 169.00 | 114.00 |
| 0.5626 | 9/16 | | 14.290 | 169.00 | 114.00 |
| 0.5709 | | | 14.500 | 169.00 | 114.00 |
| 0.5748 | | | 14.600 | 169.00 | 114.00 |
| 0.5780 | 37/64 | | 14.680 | 169.00 | 114.00 |
| 0.5807 | | | 14.750 | 169.00 | 114.00 |
| 0.5827 | | | 14.800 | 169.00 | 114.00 |
| 0.5906 | | | 15.000 | 169.00 | 114.00 |
| 0.5937 | 19/32 | | 15.080 | 178.00 | 120.00 |
| 0.6004 | | | 15.250 | 178.00 | 120.00 |
| 0.6094 | 39/64 | | 15.480 | 178.00 | 120.00 |
| 0.6102 | | | 15.500 | 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 |
| 0.6299 | | | 16.000 | 178.00 | 120.00 |
| 0.6594 | | | 16.750 | 184.00 | 125.00 |
| 0.6693 | | | 17.000 | 184.00 | 125.00 |
| 0.6890 | | | 17.500 | 191.00 | 130.00 |
| 0.7087 | | | 18.000 | 191.00 | 130.00 |
| 0.7283 | | | 18.500 | 198.00 | 135.00 |
| 0.7480 | | | 19.000 | 198.00 | 135.00 |

**Alternative Drill Series:**

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#657 Cobalt, Ti, 5xD, 130 pt, TiN
#305 Cobalt, GP, 5xD, 118 pt, Oxide
#530 PM Cobalt, GT500, 5xD, 130 pt, FIREX

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