



# 5xD

  
 Steam Oxide  
 >2.36 mm dia.

  
 External Coolant

  
 Straight Shank

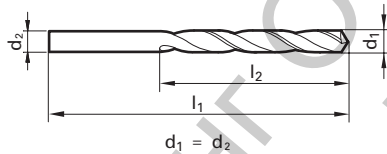
Speeds & Feeds  
 information pg 345

# Series 305




## General Purpose

Cobalt, 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



Application Materials:

-  Universal Steels
-  Hardened Materials
-  Cast Iron

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm
Dec. inch	Fract. inch				
0.0079		92	0.200	19.00	2.50
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
0.0098		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
0.0118			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
0.0146		79	0.370	19.00	4.00
0.0150			0.380	19.00	4.00
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)		Wire / letter	mm	l1 mm	l2 mm
Dec. inch	Fract. inch				
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
0.0232			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
0.0252		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
0.0268			0.680	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
0.0299			0.760	30.00	10.00
0.0303			0.770	30.00	10.00

Diameter (d1)		Wire / letter	mm	l1 mm	l2 mm
Dec. inch	Fract. inch				
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
0.0331		66	0.840	30.00	10.00
0.0335			0.850	30.00	10.00
0.0339			0.860	32.00	11.00
0.0343			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
0.0370		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
0.0390		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



# Series 305

Speeds & Feeds information pg 345

Twist Drills

Diameter (d1)			I1 mm	I2 mm
Dec. inch	Fract. inch	Wire / letter		
0.2500	1/4	E	6.350	63.00
0.2520			6.400	63.00
0.2539			6.450	63.00
0.2559			6.500	63.00
0.2571		F	6.530	63.00
0.2598			6.600	63.00
0.2610		G	6.630	63.00
0.2638			6.700	63.00
0.2657	17/64	H	6.750	69.00
0.2677			6.800	69.00
0.2717		I	6.900	69.00
0.2736			6.950	69.00
0.2756			7.000	69.00
0.2768		J	7.030	69.00
0.2776			7.050	69.00
0.2795			7.100	69.00
0.2811	9/32	K	7.140	69.00
0.2835			7.200	69.00
0.2854			7.250	69.00
0.2874			7.300	69.00
0.2902		L	7.370	69.00
0.2913			7.400	69.00
0.2949		M	7.490	69.00
0.2953			7.500	69.00
0.2969	19/64		7.540	75.00
0.2992			7.600	75.00
0.3020		N	7.670	75.00
0.3031			7.700	75.00
0.3051			7.750	75.00
0.3071			7.800	75.00
0.3110			7.900	75.00
0.3126	5/16		7.940	75.00
0.3150			8.000	75.00
0.3161		O	8.030	75.00
0.3189			8.100	75.00
0.3228		P	8.200	75.00
0.3248			8.250	75.00
0.3268			8.300	75.00
0.3280	21/64		8.330	75.00
0.3307			8.400	75.00
0.3319		Q	8.430	75.00
0.3346			8.500	75.00
0.3386			8.600	81.00
0.3390		R	8.610	81.00
0.3425			8.700	81.00
0.3437	11/32		8.730	81.00
0.3445			8.750	81.00
0.3465			8.800	81.00
0.3480		S	8.840	81.00
0.3504			8.900	81.00
0.3543			9.000	81.00

Diameter (d1)			I1 mm	I2 mm
Dec. inch	Fract. inch	Wire / letter		
0.3579		T	9.090	81.00
0.3583			9.100	81.00
0.3594	23/64		9.130	81.00
0.3622			9.200	81.00
0.3642			9.250	81.00
0.3661			9.300	81.00
0.3677		U	9.340	81.00
0.3701			9.400	81.00
0.3740			9.500	81.00
0.3748	3/8		9.520	87.00
0.3772		V	9.580	87.00
0.3780			9.600	87.00
0.3799			9.650	87.00
0.3819			9.700	87.00
0.3839			9.750	87.00
0.3858		W	9.800	87.00
0.3878			9.850	87.00
0.3898			9.900	87.00
0.3906	25/64		9.920	87.00
0.3937			10.000	87.00
0.3969		X	10.080	87.00
0.3976			10.100	87.00
0.4016			10.200	87.00
0.4039		Y	10.260	87.00
0.4055			10.300	87.00
0.4063	13/32		10.320	87.00
0.4094			10.400	87.00
0.4130		Z	10.490	87.00
0.4134			10.500	87.00
0.4173			10.600	87.00
0.4213			10.700	94.00
0.4220	27/64		10.720	94.00
0.4232			10.750	94.00
0.4252			10.800	94.00
0.4291			10.900	94.00
0.4331			11.000	94.00
0.4374	7/16		11.110	94.00
0.4409			11.200	94.00
0.4429			11.250	94.00
0.4449			11.300	94.00
0.4488			11.400	94.00
0.4528			11.500	94.00
0.4531	29/64		11.510	94.00
0.4567			11.600	94.00
0.4626			11.750	94.00
0.4646			11.800	94.00
0.4685			11.900	101.00
0.4689	15/32		11.910	101.00
0.4724			12.000	101.00
0.4764			12.100	101.00
0.4803			12.200	101.00

Diameter (d1)			I1 mm	I2 mm
Dec. inch	Fract. inch	Wire / letter		
0.4843	31/64		12.300	101.00
0.4882			12.400	101.00
0.4921			12.500	101.00
0.4961			12.600	101.00
0.5000	1/2		12.700	101.00
0.5039			12.800	101.00
0.5079			12.900	101.00
0.5118			13.000	101.00
0.5157	33/64		13.100	101.00
0.5197			13.200	101.00
0.5236			13.300	108.00
0.5311	17/32		13.490	108.00
0.5315			13.500	108.00
0.5354			13.600	108.00
0.5413			13.750	108.00
0.5433			13.800	108.00
0.5469	35/64		13.890	108.00
0.5512			14.000	108.00
0.5591			14.200	114.00
0.5626	9/16		14.290	114.00
0.5669			14.400	114.00
0.5709			14.500	114.00
0.5780	37/64		14.680	114.00
0.5807			14.750	114.00
0.5906			15.000	114.00
0.5945			15.100	120.00
0.6004			15.250	120.00
0.6024			15.300	120.00
0.6094	39/64		15.480	120.00
0.6102			15.500	120.00
0.6201			15.750	120.00
0.6248	5/8		15.870	120.00
0.6299			16.000	120.00
0.6496			16.500	125.00
0.6563	21/32		16.670	125.00
0.6693			17.000	125.00
0.6874	11/16		17.460	130.00
0.6890			17.500	130.00
0.7087			18.000	130.00
0.7283			18.500	135.00
0.7480			19.000	135.00
0.7677			19.500	140.00
0.7811	25/32		19.840	140.00
0.7874			20.000	140.00

### Alternative Drill Series:

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