10xD

Series 217

General Purpose

HSS, general purpose (Type N), taper length, 118° point, Form A web thinned >14.0mm dia., standard straight shank, RH helix

Cut / Shank Dia. = h8 tolerance range

Steam Oxide
>2.36 mm dia.

External Coolant

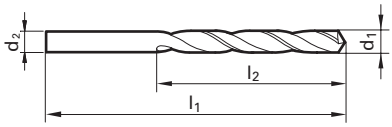
Straight Shank

Speeds & Feeds
information pg 339

Application Materials:

- General Steels/Brass
- Universal Steels
- Cast Iron





$d_1 = d_2$

Diameter (d1) Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm
0.0157	1/64		0.400	30.00	10.00
0.0173			0.440	30.00	10.00
0.0185			0.470	30.00	10.00
0.0197			0.500	32.00	12.00
0.0205			0.520	32.00	12.00
0.0217			0.550	35.00	15.00
0.0224		74	0.570	35.00	15.00
0.0236			0.600	35.00	15.00
0.0244			0.620	38.00	18.00
0.0256			0.650	38.00	18.00
0.0276			0.700	42.00	21.00
0.0287			0.730	42.00	21.00
0.0295			0.750	42.00	21.00
0.0299			0.760	46.00	25.00
0.0311	1/32	68	0.790	46.00	25.00
0.0315			0.800	46.00	25.00
0.0323			0.820	46.00	25.00
0.0335			0.850	46.00	25.00
0.0354			0.900	51.00	29.00
0.0362			0.920	51.00	29.00
0.0374			0.950	51.00	29.00
0.0382		62	0.970	56.00	33.00
0.0394			1.000	56.00	33.00
0.0402		60	1.020	56.00	33.00
0.0413			1.050	56.00	33.00
0.0421		58	1.070	60.00	37.00
0.0429		57	1.090	60.00	37.00
0.0433			1.100	60.00	37.00
0.0441			1.120	60.00	37.00
0.0453			1.150	60.00	37.00
0.0465		56	1.180	60.00	37.00
0.0469	3/64		1.190	65.00	41.00
0.0472			1.200	65.00	41.00
0.0492			1.250	65.00	41.00
0.0512			1.300	65.00	41.00
0.0520		55	1.320	65.00	41.00
0.0531			1.350	70.00	45.00
0.0551		54	1.400	70.00	45.00
0.0571			1.450	70.00	45.00
0.0591			1.500	70.00	45.00
0.0594		53	1.510	76.00	50.00
0.0610			1.550	76.00	50.00
0.0626	1/16		1.590	76.00	50.00
0.0630			1.600	76.00	50.00
0.0634		52	1.610	76.00	50.00
0.0650			1.650	76.00	50.00
0.0669		51	1.700	76.00	50.00
0.0689			1.750	80.00	53.00
0.0701		50	1.780	80.00	53.00
0.0709			1.800	80.00	53.00
0.0728		49	1.850	80.00	53.00
0.0748			1.900	80.00	53.00
0.0760		48	1.930	85.00	56.00
0.0768			1.950	85.00	56.00
0.0780	5/64		1.980	85.00	56.00
0.0787			2.000	85.00	56.00
0.0799			2.030	85.00	56.00
0.0807			2.050	85.00	56.00
0.0811		46	2.060	85.00	56.00
0.0819		45	2.080	85.00	56.00
0.0827			2.100	85.00	56.00
0.0846			2.150	90.00	59.00
0.0858		44	2.180	90.00	59.00
0.0866			2.200	90.00	59.00
0.0886			2.250	90.00	59.00
0.0890		43	2.260	90.00	59.00
0.0906			2.300	90.00	59.00
0.0913			2.320	90.00	59.00
0.0925			2.350	90.00	59.00
0.0933		42	2.370	95.00	62.00
0.0937	3/32		2.380	95.00	62.00
0.0945			2.400	95.00	62.00
0.0961		41	2.440	95.00	62.00
0.0965			2.450	95.00	62.00
0.0980		40	2.490	95.00	62.00
0.0984			2.500	95.00	62.00
0.0996		39	2.530	95.00	62.00
0.1004			2.550	95.00	62.00
0.1016		38	2.580	95.00	62.00
0.1024			2.600	95.00	62.00
0.1031			2.620	95.00	62.00
0.1039		37	2.640	95.00	62.00
0.1043			2.650	95.00	62.00
0.1063			2.700	100.00	66.00
0.1067		36	2.710	100.00	66.00
0.1083			2.750	100.00	66.00
0.1094	7/64		2.780	100.00	66.00
0.1098		35	2.790	100.00	66.00
0.1102			2.800	100.00	66.00
0.1122			2.850	100.00	66.00
0.1130		33	2.870	100.00	66.00
0.1142			2.900	100.00	66.00
0.1161		32	2.950	100.00	66.00
0.1181			3.000	100.00	66.00
0.1201		31	3.050	106.00	69.00
0.1220			3.100	106.00	69.00
0.1240			3.150	106.00	69.00
0.1248	1/8		3.170	106.00	69.00
0.1260			3.200	106.00	69.00
0.1280			3.250	106.00	69.00
0.1283		30	3.260	106.00	69.00
0.1299			3.300	106.00	69.00
0.1319			3.350	106.00	69.00
0.1339			3.400	112.00	73.00
0.1358		29	3.450	112.00	73.00
0.1378			3.500	112.00	73.00
0.1398			3.550	112.00	73.00
0.1406	9/64	28	3.570	112.00	73.00
0.1417			3.600	112.00	73.00
0.1437			3.650	112.00	73.00
0.1441		27	3.660	112.00	73.00
0.1457			3.700	112.00	73.00
0.1476			3.750	112.00	73.00
0.1496		25	3.800	119.00	78.00
0.1516			3.850	119.00	78.00
0.1520		24	3.860	119.00	78.00
0.1535			3.900	119.00	78.00
0.1539		23	3.910	119.00	78.00
0.1555			3.950	119.00	78.00
0.1563	5/32		3.970	119.00	78.00
0.1571		22	3.990	119.00	78.00
0.1575			4.000	119.00	78.00
0.1591		21	4.040	119.00	78.00
0.1594			4.050	119.00	78.00
0.1610		20	4.090	119.00	78.00
0.1614			4.100	119.00	78.00
0.1634			4.150	119.00	78.00
0.1654			4.200	119.00	78.00
0.1661		19	4.220	119.00	78.00
0.1673			4.250	119.00	78.00
0.1693		18	4.300	126.00	82.00
0.1713			4.350	126.00	82.00
0.1720	11/64		4.370	126.00	82.00
0.1728		17	4.390	126.00	82.00
0.1732			4.400	126.00	82.00
0.1752			4.450	126.00	82.00
0.1772		16	4.500	126.00	82.00
0.1799		15	4.570	126.00	82.00
0.1811			4.600	126.00	82.00
0.1819		14	4.620	126.00	82.00
0.1831			4.650	126.00	82.00
0.1850		13	4.700	126.00	82.00
0.1870			4.750	126.00	82.00
0.1874	3/16		4.760	132.00	87.00
0.1890		12	4.800	132.00	87.00
0.1909		11	4.850	132.00	87.00
0.1929			4.900	132.00	87.00
0.1937		10	4.920	132.00	87.00
0.1949			4.950	132.00	87.00
0.1961		9	4.980	132.00	87.00
0.1969			5.000	132.00	87.00
0.1988			5.050	132.00	87.00
0.1992		8	5.060	132.00	87.00
0.2008			5.100	132.00	87.00
0.2012		7	5.110	132.00	87.00
0.2028			5.150	132.00	87.00
0.2031	13/64		5.160	132.00	87.00
0.2039		6	5.180	132.00	87.00
0.2047			5.200	132.00	87.00
0.2055		5	5.220	132.00	87.00
0.2067			5.250	132.00	87.00
0.2087			5.300	132.00	87.00

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Speeds & Feeds information pg 339

Diameter (d1)					
Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm
0.2091		4	5.310	139.00	91.00
0.2106			5.350	139.00	91.00
0.2126			5.400	139.00	91.00
0.2130		3	5.410	139.00	91.00
0.2146			5.450	139.00	91.00
0.2165			5.500	139.00	91.00
0.2185			5.550	139.00	91.00
0.2189	7/32		5.560	139.00	91.00
0.2205			5.600	139.00	91.00
0.2209		2	5.610	139.00	91.00
0.2224			5.650	139.00	91.00
0.2244			5.700	139.00	91.00
0.2264			5.750	139.00	91.00
0.2280		1	5.790	139.00	91.00
0.2283			5.800	139.00	91.00
0.2303			5.850	139.00	91.00
0.2323			5.900	139.00	91.00
0.2343	15/64		5.950	139.00	91.00
0.2362			6.000	139.00	91.00
0.2402			6.100	148.00	97.00
0.2421		C	6.150	148.00	97.00
0.2441			6.200	148.00	97.00
0.2461		D	6.250	148.00	97.00
0.2480			6.300	148.00	97.00
0.2500	1/4	E	6.350	148.00	97.00
0.2520			6.400	148.00	97.00
0.2559			6.500	148.00	97.00
0.2598			6.600	148.00	97.00
0.2638			6.700	148.00	97.00
0.2657	17/64	H	6.750	156.00	102.00
0.2677			6.800	156.00	102.00
0.2717		I	6.900	156.00	102.00
0.2756			7.000	156.00	102.00
0.2795			7.100	156.00	102.00
0.2811	9/32	K	7.140	156.00	102.00
0.2835			7.200	156.00	102.00
0.2854			7.250	156.00	102.00
0.2874			7.300	156.00	102.00
0.2913			7.400	156.00	102.00
0.2953			7.500	156.00	102.00
0.2969	19/64		7.540	165.00	109.00
0.2992			7.600	165.00	109.00
0.3031			7.700	165.00	109.00
0.3051			7.750	165.00	109.00
0.3071			7.800	165.00	109.00
0.3110			7.900	165.00	109.00
0.3126	5/16		7.940	165.00	109.00
0.3150			8.000	165.00	109.00
0.3189			8.100	165.00	109.00
0.3228		P	8.200	165.00	109.00
0.3248			8.250	165.00	109.00
0.3268			8.300	165.00	109.00
0.3280	21/64		8.330	165.00	109.00
0.3307			8.400	165.00	109.00
0.3346			8.500	165.00	109.00
0.3386			8.600	175.00	115.00

Diameter (d1)					
Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm
0.3425			8.700	175.00	115.00
0.3437	11/32		8.730	175.00	115.00
0.3445			8.750	175.00	115.00
0.3465			8.800	175.00	115.00
0.3504			8.900	175.00	115.00
0.3543			9.000	175.00	115.00
0.3583			9.100	175.00	115.00
0.3594	23/64		9.130	175.00	115.00
0.3622			9.200	175.00	115.00
0.3642			9.250	175.00	115.00
0.3661			9.300	175.00	115.00
0.3701			9.400	175.00	115.00
0.3740			9.500	175.00	115.00
0.3748	3/8		9.520	184.00	121.00
0.3780			9.600	184.00	121.00
0.3819			9.700	184.00	121.00
0.3839			9.750	184.00	121.00
0.3858		W	9.800	184.00	121.00
0.3898			9.900	184.00	121.00
0.3906	25/64		9.920	184.00	121.00
0.3937			10.000	184.00	121.00
0.3976			10.100	184.00	121.00
0.4016			10.200	184.00	121.00
0.4035			10.250	184.00	121.00
0.4055			10.300	184.00	121.00
0.4063	13/32		10.320	184.00	121.00
0.4094			10.400	184.00	121.00
0.4134			10.500	184.00	121.00
0.4173			10.600	184.00	121.00
0.4213			10.700	195.00	128.00
0.4220	27/64		10.720	195.00	128.00
0.4232			10.750	195.00	128.00
0.4252			10.800	195.00	128.00
0.4291			10.900	195.00	128.00
0.4331			11.000	195.00	128.00
0.4374	7/16		11.110	195.00	128.00
0.4409			11.200	195.00	128.00
0.4429			11.250	195.00	128.00
0.4449			11.300	195.00	128.00
0.4488			11.400	195.00	128.00
0.4528			11.500	195.00	128.00
0.4531	29/64		11.510	195.00	128.00
0.4567			11.600	195.00	128.00
0.4626			11.750	195.00	128.00
0.4646			11.800	195.00	128.00
0.4689	15/32		11.910	205.00	134.00
0.4724			12.000	205.00	134.00
0.4764			12.100	205.00	134.00
0.4803			12.200	205.00	134.00
0.4823			12.250	205.00	134.00
0.4843	31/64		12.300	205.00	134.00
0.4921			12.500	205.00	134.00
0.5000	1/2		12.700	205.00	134.00
0.5020			12.750	205.00	134.00
0.5039			12.800	205.00	134.00
0.5118			13.000	205.00	134.00

Diameter (d1)					
Dec. inch	Fract. inch	Wire / letter	mm	l1 mm	l2 mm
0.5157	33/64		13.100	205.00	134.00
0.5197			13.200	205.00	134.00
0.5311	17/32		13.490	214.00	140.00
0.5315			13.500	214.00	140.00
0.5413			13.750	214.00	140.00
0.5433			13.800	214.00	140.00
0.5469	35/64		13.890	214.00	140.00
0.5512			14.000	214.00	140.00
0.5591			14.200	220.00	144.00
0.5610			14.250	220.00	144.00
0.5626	9/16		14.290	220.00	144.00
0.5709			14.500	220.00	144.00
0.5780	37/64		14.680	220.00	144.00
0.5906			15.000	220.00	144.00
0.5937	19/32		15.080	227.00	149.00
0.6004			15.250	227.00	149.00
0.6063			15.400	227.00	149.00
0.6094	39/64		15.480	227.00	149.00
0.6102			15.500	227.00	149.00
0.6248	5/8		15.870	227.00	149.00
0.6299			16.000	227.00	149.00
0.6406	41/64		16.270	235.00	154.00
0.6496			16.500	235.00	154.00
0.6563	21/32		16.670	235.00	154.00
0.6693			17.000	235.00	154.00
0.6720	43/64		17.070	241.00	158.00
0.6874	11/16		17.460	241.00	158.00
0.6890			17.500	241.00	158.00
0.7087			18.000	241.00	158.00
0.7185			18.250	247.00	162.00
0.7189	23/32		18.260	247.00	162.00
0.7283			18.500	247.00	162.00
0.7343	47/64		18.650	247.00	162.00
0.7480			19.000	247.00	162.00
0.7500	3/4		19.050	254.00	166.00
0.7677			19.500	254.00	166.00
0.7811	25/32		19.840	254.00	166.00
0.7874			20.000	254.00	166.00
0.8071			20.500	261.00	171.00
0.8126	13/16		20.640	261.00	171.00
0.8169			20.750	261.00	171.00
0.8268			21.000	261.00	171.00
0.8465			21.500	268.00	176.00
0.8661			22.000	268.00	176.00
0.8748	7/8		22.220	268.00	176.00
0.9374	15/16		23.810	282.00	185.00
0.9449			24.000	282.00	185.00
0.9843	63/64		25.000	282.00	185.00

Alternative Drill Series:

#667 HSS, GP, 10xD, 118 pt, TiN
#317 Cobalt, GP, 10xD, 118 pt, Oxide
#617 Cobalt, Ti, 10xD, 130 pt, Bright
#669 Cobalt, Ti, 10xD, 130 pt, TiN

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

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