TOLERANCES	
d_1	+.0000" –.0004" (+.000 –.010mm)
d_2	h6
l_1	+.125" –.125" (+3.175 –3.175mm)
l_2	+.125" –.125" (+3.175 –3.175mm)

Series 1550H,1250H,1850H



.0312" - .0354"
(0.792mm - 0.900mm)

Recommended for high nickel, high temperature alloys, cobalt-based alloys, stainless steels, and tool steels >40 Rc

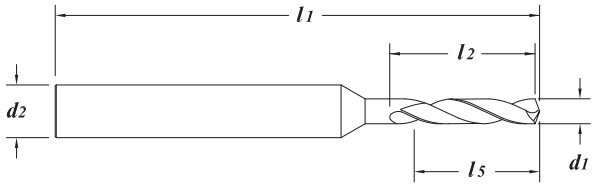
BALIQ® ALTINOS Coating (AlTiN-based)

High performance solid submicron grain carbide drill on 3mm or 1/8" diameter shank

30° helix for better chip evacuation

Live tooling recommended on lathe processes





3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal	d_1 † Diameter	d_1 † Diameter Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
00100			.0312	1/32"	0.792	1/8"	2"	5/32"	.099"
	00304		.0312	1/32"	0.792	1/8"	2"	15/64"	.162"
		00510	.0312	1/32"	0.792	1/8"	2"	7/16"	.380"
	00306		.0315		0.800	3.0	50	6.0	4
		00512	.0315		0.800	3.0	50	12.0	10
	00308		.0319		0.810	3.0	50	6.0	4
00106			.0320	#67	0.812	1/8"	2"	11/64"	.102"
	00310		.0320	#67	0.812	1/8"	2"	15/64"	.166"
		00516	.0320	#67	0.812	1/8"	2"	7/16"	.390"
		00518	.0323		0.820	3.0	50	12.0	10
00112			.0330	#66	0.838	1/8"	2"	11/64"	.105"
	00316		.0330	#66	0.838	1/8"	2"	15/64"	.171"
		00522	.0330	#66	0.838	1/8"	2"	7/16"	.402"
	00318		.0331		0.840	3.0	50	6.0	4
		00524	.0331		0.840	3.0	50	12.0	10
00116			.0335		0.850	3.0	50	4.5	3
		00526	.0335		0.850	3.0	50	12.0	10
	00322		.0339		0.860	3.0	50	6.5	4
		00528	.0339		0.860	3.0	50	13.0	10
00120			.0343		0.870	3.0	50	4.5	3
		00530	.0343		0.870	3.0	50	13.0	11
00122			.0346		0.880	3.0	50	4.5	3
00124			.0350	#65	0.890	3.0	50	4.5	3
	00328		.0350	#65	0.890	3.0	50	6.5	5
		00534	.0350	#65	0.890	3.0	50	13.0	11
	00330		.0354		0.900	3.0	50	6.5	5
		00536	.0354		0.900	3.0	50	13.0	11

continued →

Series 1550H,1250H,1850H *(continued)*

.0358" - .0465"
(0.910mm - 1.181mm)

3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal		Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
	00332		.0358		0.910	3.0	50	6.5	5
00130			.0360	#64	0.914	1/8"	2"	3/16"	.115"
	00334		.0360	#64	0.914	1/8"	2"	1/4"	.187"
		00540	.0360	#64	0.914	1/8"	2"	1/2"	.439"
00134			.0366		0.930	3.0	50	5.0	3
00136			.0370	#63	0.940	3.0	50	5.0	3
	00340		.0370	#63	0.940	3.0	50	7.0	5
		00546	.0370	#63	0.940	3.0	50	14.0	11
00138			.0374		0.950	3.0	50	5.0	3
00142			.0380	#62	0.965	1/8"	2"	3/16"	.120"
	00346		.0380	#62	0.965	1/8"	2"	17/64"	.197"
		00552	.0380	#62	0.965	1/8"	2"	9/16"	.463"
		00556	.0386		0.980	3.0	50	14.0	12
00148			.0390	#61	0.990	3.0	50	5.0	3
		00558	.0390	#61	0.990	3.0	50	14.0	12
00150			.0394		1.000	3.0	50	5.0	3
	00354		.0394		1.000	3.0	50	7.0	5
		00560	.0394		1.000	3.0	50	14.0	12
00152			.0400	#60	1.016	1/8"	2"	13/64"	.127"
	00356		.0400	#60	1.016	1/8"	2"	9/32"	.207"
		00562	.0400	#60	1.016	1/8"	2"	9/16"	.487"
00154			.0410	#59	1.041	1/8"	2"	13/64"	.131"
	00358		.0410	#59	1.041	1/8"	2"	9/32"	.213"
		00564	.0410	#59	1.041	1/8"	2"	9/16"	.500"
00156			.0413		1.050	3.0	50	5.5	3
	00360		.0413		1.050	3.0	50	7.5	5
		00566	.0413		1.050	3.0	50	15.0	13
00158			.0420	#58	1.066	1/8"	2"	7/32"	.134"
	00362		.0420	#58	1.066	1/8"	2"	5/16"	.218"
00160			.0430	#57	1.092	1/8"	2"	7/32"	.137"
	00364		.0430	#57	1.092	1/8"	2"	5/16"	.223"
		00570	.0430	#57	1.092	1/8"	2"	9/16"	.524"
00162			.0433		1.100	3.0	50	5.5	4
	00366		.0433		1.100	3.0	50	8.0	6
		00572	.0433		1.100	3.0	50	16.0	13
00164			.0453		1.150	3.0	50	6.0	4
	00368		.0453		1.150	3.0	50	8.0	6
		00574	.0453		1.150	3.0	50	16.0	14
00166			.0465	#56	1.181	1/8"	2"	15/64"	.148"
	00370		.0465	#56	1.181	1/8"	2"	11/32"	.241"
		00576	.0465	#56	1.181	1/8"	2"	5/8"	.567"

† *Metric equivalents are for reference only*

3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal		Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
00168			.0469	3/64"	1.191	1/8"	2"	15/64"	.149"
	00372		.0469	3/64"	1.191	1/8"	2"	11/32"	.243"
		00578	.0469	3/64"	1.191	1/8"	2"	5/8"	.571"
00170			.0472		1.200	3.0	50	6.0	4
	00374		.0472		1.200	3.0	50	9.0	6
		00580	.0472		1.200	3.0	50	18.0	15
00172			.0492		1.250	3.0	50	6.5	4
	00376		.0492		1.250	3.0	50	9.0	6
		00582	.0492		1.250	3.0	50	18.0	15
00174			.0512		1.300	3.0	50	6.5	4
	00378		.0512		1.300	3.0	50	9.0	7
		00584	.0512		1.300	3.0	50	18.0	16
00176			.0520	#55	1.320	1/8"	2"	17/64"	.166"
	00380		.0520	#55	1.320	1/8"	2"	3/8"	.270"
		00586	.0520	#55	1.320	1/8"	2"	3/4"	.634"
00178			.0531		1.350	3.0	50	6.5	4
	00382		.0531		1.350	3.0	50	9.5	7
		00588	.0531		1.350	3.0	50	19.0	16
00180			.0550	#54	1.397	1/8"	2"	9/32"	.175"
	00384		.0550	#54	1.397	1/8"	2"	3/8"	.285"
		00590	.0550	#54	1.397	1/8"	2"	3/4"	.670"
00182			.0551		1.400	3.0	50	7.0	4
	00386		.0551		1.400	3.0	50	10.0	7
		00592	.0551		1.400	3.0	65	20.0	17
00184			.0571		1.450	3.0	50	7.0	5
	00388		.0571		1.450	3.0	50	10.5	8
		00594	.0571		1.450	3.0	65	21.0	18
00186			.0591		1.500	3.0	50	7.5	5
	00390		.0591		1.500	3.0	50	10.5	8
		00596	.0591		1.500	3.0	65	21.0	18
00188			.0595	#53	1.511	1/8"	2"	19/64"	.189"
	00392		.0595	#53	1.511	1/8"	2"	7/16"	.308"
		00598	.0595	#53	1.511	1/8"	2-1/2"	13/16"	.725"
00190			.0610		1.550	3.0	50	7.5	5
	00394		.0610		1.550	3.0	50	11.0	8
		00600	.0610		1.550	3.0	65	22.0	19
00192			.0625	1/16"	1.587	1/8"	2"	5/16"	.199"
	00396		.0625	1/16"	1.587	1/8"	2"	7/16"	.324"
		00602	.0625	1/16"	1.587	1/8"	2-1/2"	13/16"	.761"
00194			.0630		1.600	3.0	50	7.5	6
	00398		.0630		1.600	3.0	50	11.0	8
		00604	.0630		1.600	3.0	65	22.0	19
00196			.0635	#52	1.613	1/8"	2"	5/16"	.202"
	00400		.0635	#52	1.613	1/8"	2"	15/32"	.329"
		00606	.0635	#52	1.613	1/8"	2-1/2"	7/8"	.774"
00198			.0650		1.650	3.0	50	8.5	5
	00402		.0650		1.650	3.0	50	11.5	9
		00608	.0650		1.650	3.0	65	23.0	20
00200			.0669		1.700	3.0	50	8.5	5
	00404		.0669		1.700	3.0	50	11.5	9
		00610	.0669		1.700	3.0	65	23.0	21
00202			.0670	#51	1.702	1/8"	2"	11/32"	.213"
	00406		.0670	#51	1.702	1/8"	2"	15/32"	.347"
		00612	.0670	#51	1.702	1/8"	2-1/2"	7/8"	.816"
00204			.0689		1.750	3.0	50	9.0	6
	00408		.0689		1.750	3.0	50	12.0	9
		00614	.0689		1.750	3.0	65	24.0	21

continued →

Series 1550H,1250H,1850H *(continued)*

.0700" - .0846"
(1.778mm - 2.150mm)



TOLERANCES	
d_1	+.0000" –.0004" (+.000 –.010mm)
d_2	h6
l_1	+.125" –.125" (+3.175 –3.175mm)
l_2	+.125" –.125" (+3.175 –3.175mm)

Recommended for high nickel, high temperature alloys, cobalt-based alloys, stainless steels, and tool steels >40 Rc

BALIQ® ALTINOS Coating (AlTiN-based)

High performance solid submicron grain carbide drill on 3mm or 1/8" diameter shank



3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal	Diameter	Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
00206			.0700	#50	1.778	1/8"	2"	23/64"	.223"
	00410		.0700	#50	1.778	1/8"	2"	1/2"	.363"
		00616	.0700	#50	1.778	1/8"	2-1/2"	1"	.853"
00208			.0709		1.800	3.0	50	9.0	6
	00412		.0709		1.800	3.0	50	13.0	9
		00618	.0709		1.800	3.0	65	26.0	22
00210			.0728		1.850	3.0	50	9.5	6
		00620	.0728		1.850	3.0	65	26.0	23
00212			.0730	#49	1.854	1/8"	2"	3/8"	.232"
	00416		.0730	#49	1.854	1/8"	2"	1/2"	.378"
		00622	.0730	#49	1.854	1/8"	2-1/2"	1"	.889"
00214			.0748		1.900	3.0	50	9.5	6
	00418		.0748		1.900	3.0	50	13.5	10
		00624	.0748		1.900	3.0	65	27.0	23
00216			.0760	#48	1.930	1/8"	2"	3/8"	.242"
	00420		.0760	#48	1.930	1/8"	2"	17/32"	.394"
		00626	.0760	#48	1.930	1/8"	2-1/2"	1-1/8"	.926"
00218			.0768		1.950	3.0	50	10.0	6
	00422		.0768		1.950	3.0	50	14.0	10
		00628	.0768		1.950	3.0	65	28.0	24
00220			.0781	5/64"	1.983	1/8"	2"	13/32"	.249"
	00424		.0781	5/64"	1.983	1/8"	2"	9/16"	.405"
		00630	.0781	5/64"	1.983	1/8"	2-1/2"	1-1/8"	.951"
00222			.0785	#47	1.994	1/8"	2"	13/32"	.250"
	00426		.0785	#47	1.994	1/8"	2"	9/16"	.407"
		00632	.0785	#47	1.994	1/8"	2-1/2"	1-1/8"	.956"
00224			.0787		2.000	3.0	50	10.0	6
	00428		.0787		2.000	3.0	50	14.0	10
		00634	.0787		2.000	3.0	65	28.0	24
00226			.0807		2.050	3.0	50	10.5	7
	00430		.0807		2.050	3.0	50	14.0	11
		00636	.0807		2.050	3.0	65	28.0	25
00228			.0810	#46	2.057	1/8"	2"	27/64"	.258"
	00432		.0810	#46	2.057	1/8"	2"	9/16"	.420"
		00638	.0810	#46	2.057	1/8"	2-1/2"	1-1/8"	.987"
00230			.0820	#45	2.083	1/8"	2"	27/64"	.261"
	00434		.0820	#45	2.083	1/8"	2"	9/16"	.425"
		00640	.0820	#45	2.083	1/8"	2-1/2"	1-1/8"	.999"
00232			.0827		2.100	3.0	50	10.5	7
	00436		.0827		2.100	3.0	50	14.5	11
		00642	.0827		2.100	3.0	65	29.0	26
00234			.0846		2.150	3.0	50	11.0	7
	00438		.0846		2.150	3.0	50	14.5	11
		00644	.0846		2.150	3.0	65	29.0	26

† *Metric equivalents are for reference only*

3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal	#/"	Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
00236			.0860	#44	2.184	1/8"	2"	7/16"	.274"
	00440		.0860	#44	2.184	1/8"	2"	19/32"	.446"
		00646	.0860	#44	2.184	1/8"	2-1/2"	1-3/16"	1.048"
00238			.0866		2.200	3.0	50	11.0	7
	00442		.0866		2.200	3.0	50	15.5	11
		00648	.0866		2.200	3.0	65	31.0	27
00240			.0886		2.250	3.0	50	11.5	7
00242			.0890	#43	2.260	1/8"	2"	29/64"	.283"
	00446		.0890	#43	2.260	1/8"	2"	5/8"	.461"
		00652	.0890	#43	2.260	1/8"	2-1/2"	1-1/4"	1.084"
00244			.0906		2.300	3.0	50	11.5	7
	00448		.0906		2.300	3.0	50	16.0	12
		00654	.0906		2.300	3.0	65	32.0	28
00246			.0925		2.350	3.0	50	12.0	7
	00450		.0925		2.350	3.0	50	16.0	12
		00656	.0925		2.350	3.0	65	32.0	29
00248			.0935	#42	2.375	1/8"	2"	31/64"	.298"
	00452		.0935	#42	2.375	1/8"	2"	21/32"	.485"
		00658	.0935	#42	2.375	1/8"	3"	1-5/16"	1.139"
00250			.0938	3/32"	2.382	1/8"	2"	31/64"	.299"
	00454		.0938	3/32"	2.382	1/8"	2"	21/32"	.486"
		00660	.0938	3/32"	2.382	1/8"	3"	1-5/16"	1.143"
00252			.0945		2.400	3.0	50	12.0	8
	00456		.0945		2.400	3.0	50	17.0	12
		00662	.0945		2.400	3.0	75	34.0	29
00254			.0960	#41	2.438	1/8"	2"	31/64"	.306"
	00458		.0960	#41	2.438	1/8"	2"	43/64"	.498"
		00664	.0960	#41	2.438	1/8"	3"	1-11/32"	1.170"
00256			.0965		2.450	3.0	50	12.5	8
00258			.0980	#40	2.489	1/8"	2"	1/2"	.312"
	00462		.0980	#40	2.489	1/8"	2"	11/16"	.508"
		00668	.0980	#40	2.489	1/8"	3"	1-3/8"	1.194"
00260			.0984		2.500	3.0	50	12.5	8
	00464		.0984		2.500	3.0	50	17.5	13
		00670	.0984		2.500	3.0	75	35.0	30
00262			.0995	#39	2.527	1/8"	2"	1/2"	.317"
	00466		.0995	#39	2.527	1/8"	2"	11/16"	.516"
		00672	.0995	#39	2.527	1/8"	3"	1-3/8"	1.212"
00264			.1004		2.550	3.0	50	13.0	8
	00468		.1004		2.550	3.0	50	17.5	13
		00674	.1004		2.550	3.0	75	35.0	31
00266			.1015	#38	2.578	1/8"	2"	17/32"	.323"
	00470		.1015	#38	2.578	1/8"	2"	45/64"	.526"
		00676	.1015	#38	2.578	1/8"	3"	1-13/32"	1.237"
00268			.1024		2.600	3.0	50	13.0	8
	00472		.1024		2.600	3.0	50	18.0	13
		00678	.1024		2.600	3.0	75	36.0	32
00270			.1040	#37	2.641	1/8"	2"	17/32"	.331"
	00474		.1040	#37	2.641	1/8"	2"	23/32"	.539"
		00680	.1040	#37	2.641	1/8"	3"	1-7/16"	1.267"
00272			.1043		2.650	3.0	50	13.5	8
	00476		.1043		2.650	3.0	50	18.5	14
		00682	.1043		2.650	3.0	75	37.0	32

continued →

Series 1550H,1250H,1850H *(continued)*

.1063" - .1250"
(2.700mm - 3.175mm)

3xD (1550H) EDP#	5xD (1250H) EDP#	12xD (1850H) EDP#	d_1 † Diameter Decimal		Metric	d_2 Shank Diameter	l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth
00274			.1063		2.700	3.0	50	13.5	9
	00478		.1063		2.700	3.0	50	19.0	14
		00684	.1063		2.700	3.0	75	38.0	33
00276			.1065	#36	2.705	1/8"	2"	17/32"	.339"
	00480		.1065	#36	2.705	1/8"	2"	3/4"	.552"
		00686	.1065	#36	2.705	1/8"	3"	1-1/2"	1.297"
00278			.1083		2.750	3.0	50	14.0	9
	00482		.1083		2.750	3.0	50	19.5	14
		00688	.1083		2.750	3.0	75	39.0	34
00280			.1094	7/64"	2.778	1/8"	2"	9/16"	.348"
	00484		.1094	7/64"	2.778	1/8"	2"	49/64"	.567"
		00690	.1094	7/64"	2.778	1/8"	3"	1-9/16"	1.333"
00282			.1100	#35	2.794	1/8"	2"	9/16"	.350"
	00486		.1100	#35	2.794	1/8"	2"	49/64"	.570"
		00692	.1100	#35	2.794	1/8"	3"	1-9/16"	1.340"
00284			.1102		2.800	3.0	50	14.0	9
	00488		.1102		2.800	3.0	50	19.5	15
		00694	.1102		2.800	3.0	75	39.0	34
00286			.1110	#34	2.819	1/8"	2"	9/16"	.353"
	00490		.1110	#34	2.819	1/8"	2"	25/32"	.575"
		00696	.1110	#34	2.819	1/8"	3"	1-5/8"	1.352"
00288			.1122		2.850	3.0	50	14.5	9
		00698	.1122		2.850	3.0	75	40.0	35
00290			.1130	#33	2.870	1/8"	2"	19/32"	.356"
	00494		.1130	#33	2.870	1/8"	2"	51/64"	.586"
		00700	.1130	#33	2.870	1/8"	3"	1-5/8"	1.377"
00292			.1142		2.900	3.0	50	14.5	9
	00496		.1142		2.900	3.0	50	20.0	15
		00702	.1142		2.900	3.0	75	40.0	35
00294			.1160	#32	2.946	1/8"	2"	19/32"	.369"
	00498		.1160	#32	2.946	1/8"	2"	13/16"	.601"
		00704	.1160	#32	2.946	1/8"	3"	1-5/8"	1.413"
00296			.1161		2.950	3.0	50	15.0	9
		00706	.1161		2.950	3.0	75	42.0	36
00298			.1181		3.000	3.0	50	15.0	10
	00502		.1181		3.000	3.0	50	21.0	16
		00708	.1181		3.000	3.0	75	42.0	37
00300			.1200	#31	3.048	1/8"	2"	5/8"	.382"
	00504		.1200	#31	3.048	1/8"	2"	7/8"	.622"
		00710	.1200	#31	3.048	1/8"	3"	1-3/4"	1.462"
00302			.1250	1/8"	3.175	1/8"	2"	5/8"	.398"
	00506		.1250	1/8"	3.175	1/8"	2"	7/8"	.648"
		00712	.1250	1/8"	3.175	1/8"	3"	1-3/4"	1.523"

† *Metric equivalents are for reference only*