



Solid Carbide Drill

**Extreme High Performance Drilling
with Extended Tool Life**



Solid Carbide Drill

**Extreme High Performance Drilling
with
Extended tool life in a broad range of materials**

Features

- Advanced "Active Cut" Geometric Design
- Refined Critical Cut Zone Characteristics
- High-Efficiency Flute Profile
- "State-of-the-Art" Proprietary Coating
- Stable Low-Thrust Point Form
- Coolant-Fed
- Diameter Range - 3.0 mm to 20.0mm, 1/8" to 3/4"
- Regular (5x), & Long Flute Lengths (7x+)
- Engineered & Produced in the USA

Benefits

- Extended Tool Life
- Elevated Metal Removal Rates (MRR)
- Lower Cost Per Hole
- Improved Hole/Part Quality
- Increased Tool Reliability
- Network of Application & Technical Specialists
- Factory Reconditioning Service
- Ideal Platform for Modification or an Engineered "Special" Tool
- Compatibility to a Wide Range of Standard Toolholder Systems



Cutting Speed

Materials	Description	5 X D (sfm)	7 X D (sfm)	5 X D (meters per min.)	7 X D (meters per min.)
Low Carbon Steel	1018	450 - 500	425 - 475	135 - 150	130 - 145
Alloy Steel (up to 35 Rc)	4140	250 - 350	225 - 300	75 - 105	70 - 90
Alloy Steel (36 - 45 Rc)	4140	150 - 200	135 - 180	45 - 60	40 - 55
Austenetic Stainless Steel	304 / 316	175 - 250	150 - 225	50 - 75	45 - 65
High Temp Alloys	Inconel , Hastelloy, Waspelloy	80 - 120	70 - 110	25 - 35	20 - 30
Precipitation Hardened Stainless	17-4PH	125 - 175	100 - 150	35 - 50	30 - 45
Titanium	6AL-4V	190 - 240	175 - 225	55 - 70	50 - 65
Gray Cast Iron	A48 Class 20/G4000	400 - 500	375 - 475	120 - 150	110 - 140
Ductile Cast Iron	A536/60-40-18	450 - 500	425 - 475	135 - 150	130 - 145

Feed Rate (IPR)

Materials	Description	Drill Diameter (inch)							
		0.0312	0.0625	0.125	0.250	0.375	0.500	0.625	0.750
Low Carbon Steel	1018	.001 - .002	.002 - .003	.003 - .005	.005 - .007	.007 - .009	.008 - .010	.009 - .012	.010 - .014
Alloy Steel (up to 35 Rc)	4140	.001 - .002	.002 - .003	.003 - .005	.005 - .007	.007 - .009	.008 - .010	.009 - .012	.010 - .014
Alloy Steel (36 - 45 Rc)	4140	.0005 - .0010	.001 - .0015	.0015 - .0025	.003 - .005	.004 - .007	.005 - .008	.007 - .010	.008 - .011
Austenetic Stainless Steel	304 / 316	.001 - .002	.002 - .003	.003 - .005	.005 - .007	.007 - .009	.008 - .010	.009 - .012	.010 - .014
High Temp Alloys	Inconel , Hastelloy, Waspelloy	.0005 - .0015	.001 - .002	.0015 - .0035	.0025 - .0045	.004 - .006	.005 - .007	.006 - .008	.009 - .011
Precipitation Hardened Stainless	17-4PH	.0005 - .0015	.001 - .002	.0015 - .0035	.0025 - .0045	.004 - .006	.005 - .007	.006 - .008	.009 - .011
Titanium	6AL-4V	.0005 - .0015	.001 - .002	.0015 - .0035	.0025 - .0045	.004 - .006	.005 - .007	.006 - .008	.009 - .011
Gray Cast Iron	A48 Class 20/G4000	.001 - .002	.002 - .003	.003 - .005	.005 - .007	.007 - .009	.008 - .010	.009 - .012	.010 - .014
Ductile Cast Iron	A536/60-40-18	.001 - .002	.002 - .003	.003 - .005	.005 - .007	.007 - .009	.008 - .010	.009 - .012	.010 - .014

Feed Rate (mm/rev)

Materials	Description	Drill Diameter (mm)							
		0.8	1.5	3.0	6.0	10.0	12.0	16.0	20.0
Low Carbon Steel	1018	.025 - .050	.050 - .075	.075 - .100	.100 - .170	.170 - .225	.200 - .250	.225 - .300	.250 - .350
Alloy Steel (up to 35 Rc)	4140	.025 - .050	.050 - .075	.075 - .100	.100 - .170	.170 - .225	.200 - .250	.225 - .300	.250 - .350
Alloy Steel (36 - 45 Rc)	4140	.010 - .025	.025 - .040	.035 - .050	.075 - .120	.100 - .170	.120 - .200	.170 - .250	.200 - .275
Austenetic Stainless Steel	304 / 316	.025 - .050	.050 - .075	.075 - .100	.100 - .170	.170 - .225	.200 - .250	.225 - .300	.250 - .350
High Temp Alloys	Inconel , Hastelloy, Waspelloy	.010 - .030	.025 - .050	.035 - .085	.060 - .110	.100 - .150	.100 - .170	.150 - .200	.225 - .275
Precipitation Hardened Stainless	17-4PH	.010 - .030	.025 - .050	.035 - .085	.060 - .110	.100 - .150	.100 - .170	.150 - .200	.225 - .275
Titanium	6AL-4V	.010 - .030	.025 - .050	.035 - .085	.060 - .110	.100 - .150	.100 - .170	.150 - .200	.225 - .275
Gray Cast Iron	A48 Class 20/G4000	.025 - .050	.050 - .075	.075 - .100	.100 - .170	.170 - .225	.200 - .250	.225 - .300	.250 - .350
Ductile Cast Iron	A536/60-40-18	.025 - .050	.050 - .075	.075 - .100	.100 - .170	.170 - .225	.200 - .250	.225 - .300	.250 - .350

Tolerances (inch)

Drill Dia. (h7)	Tolerance	Shank Dia. (h6)	Tolerance
.0000 - .1181	+0/-0.00039	.0000 - .1181	+0/-0.00024
.1182 - .2362	+0/-0.00047	.1182 - .2362	+0/-0.00031
.2363 - .3937	+0/-0.00059	.2363 - .3937	+0/-0.00035
.3938 - .7087	+0/-0.00071	.3938 - .7087	+0/-0.00043
.7088 - 1.181	+0/-0.00083	.7088 - 1.181	+0/-0.00051

Tolerances (mm)

Drill Dia. (h7)	Tolerance	Shank Dia. (h6)	Tolerance
0 - 3.0	+0/-0.010	0 - 3.0	+0/-0.006
3.01 - 6.0	+0/-0.012	3.01 - 6.0	+0/-0.008
6.01 - 10.0	+0/-0.015	6.01 - 10.0	+0/-0.009
10.01 - 18.0	+0/-0.018	10.01 - 18.0	+0/-0.011
18.01 - 30.0	+0/-0.021	18.01 - 30.0	+0/-0.013

Formulas (inch)

$$\text{Spindle speed (RPM)} = \frac{\text{SFM} \times 3.82}{\text{Drill Diameter}}$$

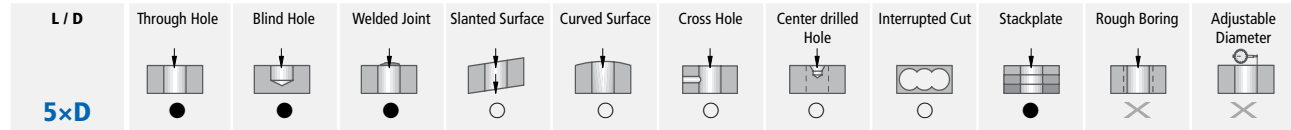
$$\text{Feed rate (IPM)} = \text{RPM} \times \text{IPR}$$

Formulas (metric)

$$\text{Spindle speed (RPM)} = \frac{\text{meters per min.} \times 318}{\text{Drill Diameter}}$$

$$\text{Feed rate (mm/min)} = \text{RPM} \times \text{mm/rev}$$

Coolant Carbide Drill Ø 0.1181" – 0.2570"

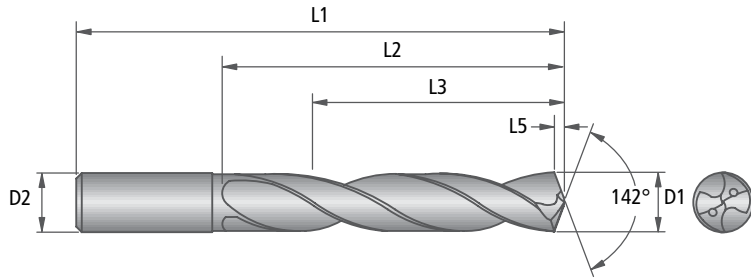


● highly recommended ● recommended ○ may be suitable X not recommended

Drilling 5 × D

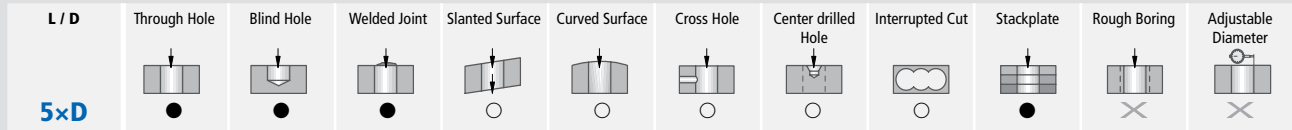
Features:

- Coolant fed, regular 5 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 20010	KC5 1181B 3.0MM			3.0	.1181		3.0		75		24		19		0.46
V90 20020	KC5 1200B #31		#31		.1200	1/8		3		1.125		.90		0.019	
V90 20030	KC5 1250B 1/8	1/8			.1250	1/8		3		1.125		.90		0.019	
V90 20040	KC5 1260B 3.2MM			3.2	.1260		4.0		80		32		26		0.50
V90 20050	KC5 1285B #30		#30		.1285	5/32		3.15		1.26		1.00		0.020	
V90 20060	KC5 1299B 3.3MM			3.3	.1299		4.0		80		32		26		0.51
V90 20070	KC5 1339B 3.4MM			3.4	.1339		4.0		80		32		26		0.53
V90 20080	KC5 1360B #29		#29		.1360	5/32		3.15		1.26		1.00		0.021	
V90 20090	KC5 1378B 3.5MM			3.5	.1378		4.0		80		32		26		0.54
V90 20100	KC5 1406B 9/64	9/64			.1406	5/32		3.15		1.26		1.00		0.022	
V90 20110	KC5 1457B 3.7MM			3.7	.1457		4.0		80		32		26		0.57
V90 20120	KC5 1496B 3.8MM			3.8	.1496		4.0		80		32		26		0.59
V90 20130	KC5 1562B 5/32	5/32			.1562	5/32		3.15		1.26		1.00		0.027	
V90 20140	KC5 1575B 4.0MM			4.0	.1575		4.0		80		32		26		0.62
V90 20150	KC5 1590B #21		#21		.1590	3/16		3.23		1.5		1.20		0.025	
V90 20160	KC5 1654B 4.2MM			4.2	.1654		5.0		82		38		30		0.65
V90 20170	KC5 1719B 11/64	11/64			.1719	3/16		3.23		1.5		1.20		0.027	
V90 20180	KC5 1772B 4.5MM			4.5	.1772		5.0		82		38		30		0.70
V90 20190	KC5 1811B 4.6MM			4.6	.1811		5.0		82		38		30		0.71
V90 20200	KC5 1875B 3/16	3/16			.1875	3/16		3.23		1.5		1.20		0.029	
V90 20210	KC5 1890B 4.8MM			4.8	.1890		5.0		82		38		30		0.74
V90 20220	KC5 1929B 4.9MM			4.9	.1929		5.0		82		38		30		0.76
V90 20230	KC5 1968B 5.0MM			5.0	.1968		5.0		82		38		30		0.77
V90 20240	KC5 2008B 5.1MM			5.1	.2008		6.0		82		40		32		0.79
V90 20250	KC5 2031B 13/64	13/64			.2031	15/64		3.23		1.58		1.26		0.031	
V90 20260	KC5 2047B 5.2MM			5.2	.2047		6.0		82		40		32		0.81
V90 20270	KC5 2087B 5.3MM			5.3	.2087		6.0		82		40		32		0.82
V90 20280	KC5 2126B 5.4MM			5.4	.2126		6.0		82		40		32		0.84
V90 20290	KC5 2165B 5.5MM			5.5	.2165		6.0		82		40		32		0.85
V90 20300	KC5 2187B 7/32	7/32			.2187	15/64		3.23		1.58		1.26		0.034	
V90 20310	KC5 2210B #2		#2		.2210	15/64		3.23		1.58		1.26		0.034	
V90 20320	KC5 2244B 5.7MM			5.7	.2244		6.0		82		40		32		0.88
V90 20330	KC5 2283B 5.8MM			5.8	.2283		6.0		82		40		32		0.90
V90 20340	KC5 2323B 5.9MM			5.9	.2323		6.0		82		40		32		0.91
V90 20350	KC5 2344B 15/64	15/64			.2344	15/64		3.23		1.58		1.26		0.036	
V90 20360	KC5 2362B 6.0MM			6.0	.2362		6.0		82		40		32		0.93
V90 20370	KC5 2402B 6.1MM			6.1	.2402		8.0		91		48		38		0.95
V90 20380	KC5 2420B C		C		.2420	1/4		3.3		1.74		1.39		0.037	
V90 20390	KC5 2441B 6.2MM			6.2	.2441		8.0		91		48		38		0.96
V90 20400	KC5 2460B D		D		.2460	1/4		3.3		1.74		1.39		0.038	
V90 20410	KC5 2480B 6.3MM			6.3	.2480		8.0		91		48		38		0.98
V90 20420	KC5 2500B 1/4	1/4			.2500	1/4		3.3		1.74		1.39		0.039	
V90 20430	KC5 2520B 6.4MM			6.4	.2520		8.0		91		48		38		0.99
V90 20440	KC5 2559B 6.5MM			6.5	.2559		8.0		91		48		38		1.01
V90 20450	KC5 2570B F		F		.2570	5/16		3.58		1.89		1.51		0.040	

Coolant Carbide Drill Ø 0.2610" – 0.4409"

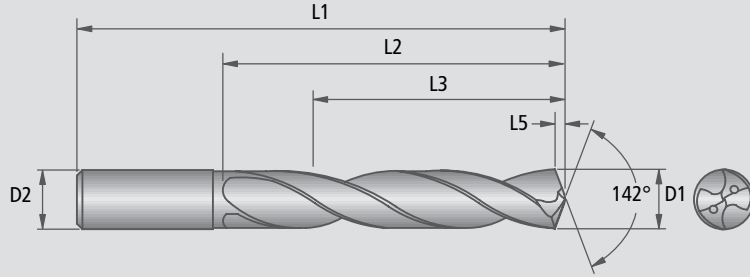


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Drilling 5 × D

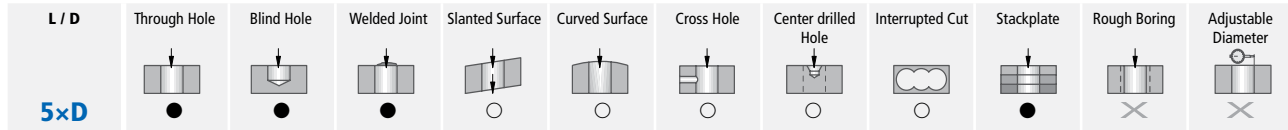
Features:

- Coolant fed, regular 5 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 20460	KC5 2610B G		G		.2610	5/16		3.58		1.89		1.51		0.040	
V90 20470	KC5 2656B 17/64	17/64			.2656	5/16		3.58		1.89		1.51		0.041	
V90 20480	KC5 2677B 6.8MM			6.8	.2677		8.0		91		48		38	1.05	
V90 20490	KC5 2717B 6.9MM			6.9	.2717		8.0		91		48		38	1.07	
V90 20500	KC5 2756B 7.0MM			7.0	.2756		8.0		91		48		38	1.08	
V90 20510	KC5 2812B 9/32	9/32			.2812	5/16		3.58		1.89		1.51		0.044	
V90 20520	KC5 2835B 7.2MM			7.2	.2835		8.0		91		48		38	1.12	
V90 20530	KC5 2913B 7.4MM			7.4	.2913		8.0		91		48		38	1.15	
V90 20540	KC5 2953B 7.5MM			7.5	.2953		8.0		91		48		38	1.16	
V90 20550	KC5 2969B 19/64	19/64			.2969	5/16		3.58		1.89		1.51		0.046	
V90 20560	KC5 2992B 7.6MM			7.6	.2992		8.0		91		48		38	1.18	
V90 20570	KC5 3031B 7.7MM			7.7	.3031		8.0		91		48		38	1.19	
V90 20580	KC5 3071B 7.8MM			7.8	.3071		8.0		91		48		38	1.21	
V90 20590	KC5 3125B 5/16	5/16			.3125	5/16		3.58		1.89		1.51		0.048	
V90 20600	KC5 3150B 8.0MM			8.0	.3150		8.0		91		48		38	1.24	
V90 20610	KC5 3189B 8.1MM			8.1	.3189		10.0		103		55		44	1.26	
V90 20620	KC5 3228B 8.2MM			8.2	.3228		10.0		103		55		44	1.27	
V90 20630	KC5 3268B 8.3MM			8.3	.3268		10.0		103		55		44	1.29	
V90 20640	KC5 3281B 21/64	21/64			.3281	25/64		4.06		2.17		1.74		0.051	
V90 20650	KC5 3320B Q		Q		.3320	25/64		4.06		2.17		1.74		0.051	
V90 20660	KC5 3346B 8.5MM			8.5	.3346		10.0		103		55		44	1.32	
V90 20670	KC5 3386B 8.6MM			8.6	.3386		10.0		103		55		44	1.33	
V90 20680	KC5 3438B 11/32	11/32			.3438	25/64		4.06		2.17		1.74		0.053	
V90 20690	KC5 3465B 8.8MM			8.8	.3465		10.0		103		55		44	1.36	
V90 20700	KC5 3504B 8.9MM			8.9	.3504		10.0		103		55		44	1.38	
V90 20710	KC5 3543B 9.0MM			9.0	.3543		10.0		103		55		44	1.39	
V90 20720	KC5 3594B 23/64	23/64			.3594	25/64		4.06		2.17		1.74		0.056	
V90 20730	KC5 3622B 9.2MM			9.2	.3622		10.0		103		55		44	1.43	
V90 20740	KC5 3642B 9.25MM			9.25	.3642		10.0		103		55		44	1.43	
V90 20750	KC5 3661B 9.3MM			9.3	.3661		10.0		103		55		44	1.44	
V90 20760	KC5 3701B 9.4MM			9.4	.3701		10.0		103		55		44	1.46	
V90 20770	KC5 3740B 9.5MM			9.5	.3740		10.0		103		55		44	1.47	
V90 20780	KC5 3750B 3/8	3/8			.3750	25/64		4.06		2.17		1.74		0.058	
V90 20790	KC5 3819B 9.7MM			9.7	.3819		10.0		103		55		44	1.50	
V90 20800	KC5 3858B 9.8MM			9.8	.3858		10.0		103		55		44	1.52	
V90 20810	KC5 3906B 25/64	25/64			.3906	25/64		4.06		2.17		1.74		0.061	
V90 20820	KC5 3937B 10.0MM			10.0	.3937		10.0		103		55		44	1.55	
V90 20830	KC5 4016B 10.2MM			10.2	.4016		12.0		120		60		48	1.58	
V90 20840	KC5 4062B 13/32	13/32			.4062	15/32		4.72		2.36		1.89		0.063	
V90 20850	KC5 4134B 10.5MM			10.50	.4134		12.0		120		60		48	1.63	
V90 20860	KC5 4219B 27/64	27/64			.4219	15/32		4.72		2.36		1.89		0.065	
V90 20870	KC5 4252B 10.8MM			10.80	.4252		12.0		120		60		48	1.67	
V90 20880	KC5 4331B 11.0MM			11.0	.4331		12.0		120		60		48	1.70	
V90 20890	KC5 4375B 7/16	7/16			.4375	15/32		4.72		2.6		2.08		0.068	
V90 20900	KC5 4409B 11.2MM			11.2	.4409		12.0		120		66		53	1.74	

Coolant Carbide Drill Ø 0.4527" – 0.7874"

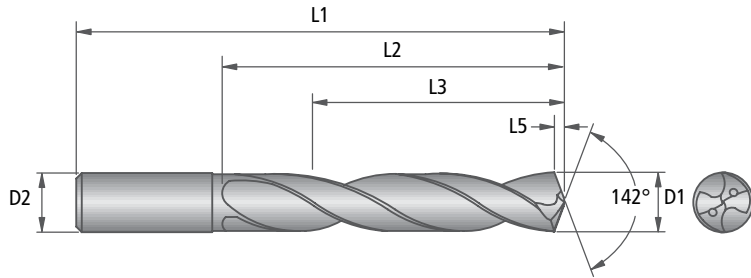


● highly recommended ● recommended ○ may be suitable ✕ not recommended

Drilling 5 × D

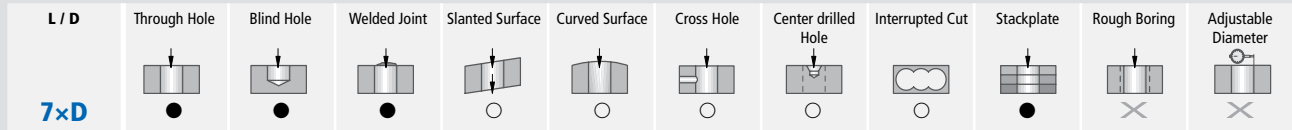
Features:

- Coolant fed, regular 5 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 20910	KC5 4527B 11.5MM			11.5	.4527		12.0	120		66		53		1.78	
V90 20920	KC5 4606B 11.7MM			11.7	.4606		12.0	120		66		53		1.81	
V90 20930	KC5 4646B 11.8MM			11.8	.4646		12.0	120		66		53		1.83	
V90 20940	KC5 4688B 15/32	15/32			.4688	15/32		4.72		2.6		2.08		0.073	
V90 20950	KC5 4724B 12.0MM			12.0	.4724		12.0	120		66		53		1.86	
V90 20960	KC5 4764B 12.1MM			12.1	.4764		14.0	126		72		58		1.87	
V90 20970	KC5 4844B 31/64	31/64			.4844	1/2		4.75		2.83		2.26		0.075	
V90 20980	KC5 4921B 12.5MM			12.5	.4921		14.0	126		72		58		1.94	
V90 20990	KC5 5000B 1/2	1/2			.5000	1/2		4.75		2.83		2.26		0.077	
V90 21000	KC5 5039B 12.8MM			12.8	.5039		14.0	126		72		58		1.98	
V90 21010	KC5 5079B 12.9MM			12.9	.5079		14.0	126		72		58		2.00	
V90 21020	KC5 5118B 13.0MM			13.0	.5118		14.0	126		72		58		2.01	
V90 21030	KC5 5156B 33/64	33/64			.5156	35/64		5.28		3.03		2.42		0.080	
V90 21040	KC5 5312B 17/32	17/32			.5312	35/64		5.28		3.03		2.42		0.082	
V90 21050	KC5 5315B 13.5MM			13.5	.5315		14.0	134		77		62		2.09	
V90 21060	KC5 5394B 13.7MM			13.7	.5394		14.0	134		77		62		2.12	
V90 21070	KC5 5469B 35/64	35/64			.5469	35/64		5.28		3.03		2.42		0.085	
V90 21080	KC5 5512B 14.0MM			14.0	.5512		14.0	134		77		62		2.17	
V90 21090	KC5 5625B 9/16	9/16			.5625	5/8		5.51		3.15		2.52		0.087	
V90 21100	KC5 5709B 14.5MM			14.5	.5709		16.0	140		80		64		2.25	
V90 21110	KC5 5787B 14.7MM			14.7	.5787		16.0	140		80		64		2.28	
V90 21120	KC5 5905B 15.0MM			15.0	.5905		16.0	140		80		64		2.32	
V90 21130	KC5 5938B 19/32	19/32			.5938	5/8		5.75		3.23		2.58		0.092	
V90 21140	KC5 6024B 15.3MM			15.3	.6024		16.0	146		82		66		2.37	
V90 21150	KC5 6102B 15.5MM			15.5	.6102		16.0	146		82		66		2.40	
V90 21160	KC5 6181B 15.7MM			15.7	.6181		16.0	146		82		66		2.43	
V90 21170	KC5 6250B 5/8	5/8			.6250	5/8		5.75		3.23		2.58		0.097	
V90 21180	KC5 6299B 16.0MM			16.0	.6299		16.0	146		82		66		2.48	
V90 21190	KC5 6331B 16.08MM			16.08	.6331		18.0	158		90		72		2.49	
V90 21200	KC5 6417B 16.3MM			16.3	.6417		18.0	158		90		72		2.53	
V90 21210	KC5 6496B 16.5MM			16.5	.6496		18.0	158		90		72		2.56	
V90 21220	KC5 6562B 21/31	21/32			.6562	45/64		6.22		3.54		2.83		0.102	
V90 21230	KC5 6693B 17.0MM			17.0	.6693		18.0	158		90		72		2.63	
V90 21240	KC5 6875B 11/16	11/16			.6875	45/64		6.22		3.74		3.00		0.107	
V90 21250	KC5 6890B 17.5MM			17.5	.6890		18.0	158		95		76		2.71	
V90 21260	KC5 7087B 18.0MM			18.0	.7087		18.0	158		95		76		2.79	
V90 21270	KC5 7283B 18.5MM			18.5	.7283		20.0	160		100		80		2.87	
V90 21280	KC5 7500B 3/4	3/4			.7500	3/4		6.3		3.94		3.15		0.116	
V90 21290	KC5 7543B 19.16MM			19.16	.7543		20.0	160		100		80		2.97	
V90 21300	KC5 7579B 19.25MM			19.25	.7579		20.0	160		100		80		2.98	
V90 21310	KC5 7598B 19.3MM			19.3	.7598		20.0	160		100		80		2.99	
V90 21320	KC5 7677B 19.5MM			19.5	.7677		20.0	160		100		80		3.02	
V90 21330	KC5 7874B 20.0MM			20.0	.7874		20.0	160		100		80		3.10	

Coolant Carbide Drill Ø 0.1181" – 0.2570"

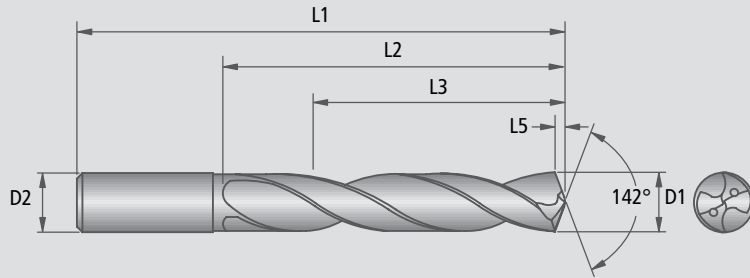


● highly recommended ● recommended ○ may be suitable ✕ not recommended

Drilling 7 × D

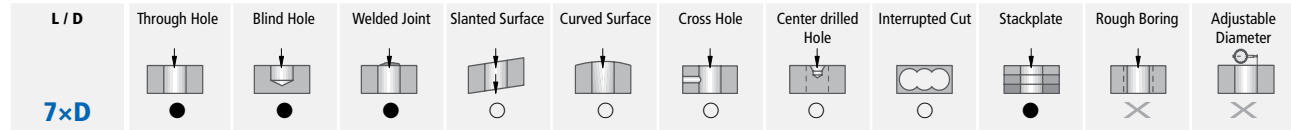
Features:

- Coolant fed, long 7 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 60010	KC7 1181B 3.0MM			3.0	.1181		3.0		81		33		26		0.46
V90 60020	KC7 1200B #31		#31		.1200	1/8		3.5		1.5		1.20		0.019	
V90 60030	KC7 1250B 1/8	1/8			.1250	1/8		3.5		1.5		1.20		0.019	
V90 60040	KC7 1260B 3.2MM			3.2	.1260		4.0		92		44		35		0.50
V90 60050	KC7 1285B #30		#30		.1285	5/32		3.625		1.75		1.40		0.020	
V90 60060	KC7 1299B 3.3MM			3.3	.1299		4.0		92		44		35		0.51
V90 60070	KC7 1339B 3.4MM			3.4	.1339		4.0		92		44		35		0.53
V90 60080	KC7 1360B #29		#29		.1360	5/32		3.625		1.75		1.40		0.021	
V90 60090	KC7 1378B 3.5MM			3.5	.1378		4.0		92		44		35		0.54
V90 60100	KC7 1406B 9/64	9/64			.1406	5/32		3.625		1.75		1.40		0.022	
V90 60110	KC7 1457B 3.7MM			3.7	.1457		4.0		92		44		35		0.57
V90 60120	KC7 1496B 3.8MM			3.8	.1496		4.0		92		44		35		0.59
V90 60130	KC7 1562B 5/32	5/32			.1562	5/32		3.625		1.75		1.40		0.027	
V90 60140	KC7 1575B 4.0MM			4.0	.1575		4.0		92		44		35		0.62
V90 60150	KC7 1590B #21		#21		.1590	3/16		3.94		1.75		1.40		0.025	
V90 60160	KC7 1654B 4.2MM			4.2	.1654		5.0		100		45		36		0.65
V90 60170	KC7 1719B 11/64	11/64			.1719	3/16		3.94		1.75		1.40		0.027	
V90 60180	KC7 1772B 4.5MM			4.5	.1772		5.0		100		45		36		0.70
V90 60190	KC7 1811B 4.6MM			4.6	.1811		5.0		100		45		36		0.71
V90 60200	KC7 1875B 3/16	3/16			.1875	3/16		3.94		1.75		1.40		0.029	
V90 60210	KC7 1890B 4.8MM			4.8	.1890		5.0		100		45		36		0.74
V90 60220	KC7 1929B 4.9MM			4.9	.1929		5.0		100		45		36		0.76
V90 60230	KC7 1968B 5.0MM			5.0	.1968		5.0		100		45		36		0.77
V90 60240	KC7 2008B 5.1MM			5.1	.2008		6.0		100		51		41		0.79
V90 60250	KC7 2031B 13/64	13/64			.2031	15/64		3.94		2		1.60		0.031	
V90 60260	KC7 2047B 5.2MM			5.2	.2047		6.0		100		51		41		0.81
V90 60270	KC7 2087B 5.3MM			5.3	.2087		6.0		100		51		41		0.82
V90 60280	KC7 2126B 5.4MM			5.4	.2126		6.0		100		51		41		0.84
V90 60290	KC7 2165B 5.5MM			5.5	.2165		6.0		100		51		41		0.85
V90 60300	KC7 2187B 7/32	7/32			.2187	15/64		3.94		2		1.60		0.034	
V90 60310	KC7 2210B #2		#2		.2210	15/64		3.94		2		1.60		0.034	
V90 60320	KC7 2244B 5.7MM			5.7	.2244		6.0		100		51		41		0.88
V90 60330	KC7 2283B 5.8MM			5.8	.2283		6.0		100		51		41		0.90
V90 60340	KC7 2323B 5.9MM			5.9	.2323		6.0		100		51		41		0.91
V90 60350	KC7 2344B 15/64	15/64			.2344	15/64		3.94		2		1.60		0.036	
V90 60360	KC7 2362B 6.0MM			6.0	.2362		6.0		100		51		41		0.93
V90 60370	KC7 2402B 6.1MM			6.1	.2402		8.0		109		60		48		0.95
V90 60380	KC7 2420B C		C		.2420	1/4		4.31		2.25		1.80		0.037	
V90 60390	KC7 2441B 6.2MM			6.2	.2441		8.0		109		60		48		0.96
V90 60400	KC7 2460B D		D		.2460	1/4		4.31		2.25		1.80		0.038	
V90 60410	KC7 2480B 6.3MM			6.3	.2480		8.0		109		60		48		0.98
V90 60420	KC7 2500B 1/4	1/4			.2500	1/4		4.31		2.25		1.80		0.039	
V90 60430	KC7 2520B 6.4MM			6.4	.2520		8.0		109		60		48		0.99
V90 60440	KC7 2559B 6.5MM			6.5	.2559		8.0		109		60		48		1.01
V90 60450	KC7 2570B F		F		.2570	5/16		4.31		2.375		1.90		0.040	

Coolant Carbide Drill Ø 0.2610" – 0.4409"

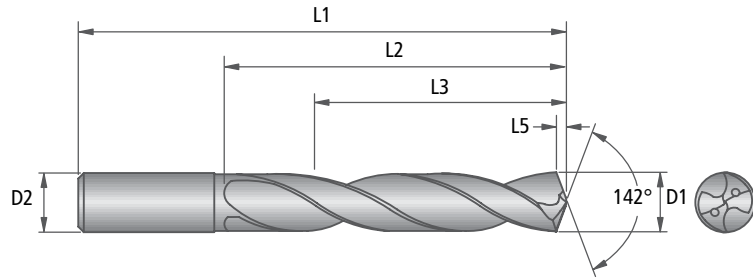


● highly recommended ● recommended ○ may be suitable ✕ not recommended

Drilling 7 × D

Features:

- Coolant fed, long 7 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 60460	KC7 2610B G		G		.2610	5/16		4.31		2.375		1.90		0.040	
V90 60470	KC7 2656B 17/64	17/64			.2656	5/16		4.31		2.375		1.90		0.041	
V90 60480	KC7 2677B 6.8MM			6.8	.2667		8.0		109		60		48	1.05	
V90 60490	KC7 2717B 6.9MM			6.9	.2717		8.0		109		60		48	1.07	
V90 60500	KC7 2756B 7.0MM			7.0	.2756		8.0		109		60		48	1.08	
V90 60510	KC7 2812B 9/32	9/32			.2812	5/16		4.625		2.75		2.20		0.044	
V90 60520	KC7 2835B 7.2MM			7.2	.2835		8.0		118		70		56	1.12	
V90 60530	KC7 2913B 7.4MM			7.4	.2913		8.0		118		70		56	1.15	
V90 60540	KC7 2953B 7.5MM			7.5	.2953		8.0		118		70		56	1.16	
V90 60550	KC7 2969B 19/64	19/64			.2969	5/16		4.625		2.75		2.20		0.046	
V90 60560	KC7 2992B 7.6MM			7.6	.2992		8.0		118		70		56	1.18	
V90 60570	KC7 3031B 7.7MM			7.7	.3031		8.0		118		70		56	1.19	
V90 60580	KC7 3071B 7.8MM			7.8	.3071		8.0		118		70		56	1.21	
V90 60590	KC7 3125B 5/16	5/16			.3125	5/16		4.625		2.75		2.20		0.048	
V90 60600	KC7 3150B 8.0MM			8.0	.3150		8.0		118		70		56	1.24	
V90 60610	KC7 3189B 8.1MM			8.1	.3189		10.0		127		80		64	1.26	
V90 60620	KC7 3228B 8.2MM			8.2	.3228		10.0		127		80		64	1.27	
V90 60630	KC7 3268B 8.3MM			8.3	.32678		10.0		127		80		64	1.29	
V90 60640	KC7 3281B 21/64	21/64			.3281	25/64		5		3.15		2.52		0.051	
V90 60650	KC7 3320B Q		Q		.3320	25/64		5		3.15		2.52		0.051	
V90 60660	KC7 3346B 8.5MM			8.5	.3346		10.0		127		80		64	1.32	
V90 60670	KC7 3386B 8.6MM			8.6	.3386		10.0		127		80		64	1.33	
V90 60680	KC7 3438B 11/32	11/32			.3438	25/64		5		3.15		2.52		0.053	
V90 60690	KC7 3465B 8.8MM			8.8	.3465		10.0		127		80		64	1.36	
V90 60700	KC7 3504B 8.9MM			8.9	.3504		10.0		127		80		64	1.38	
V90 60710	KC7 3543B 9.0MM			9.0	.3543		10.0		127		80		64	1.39	
V90 60720	KC7 3594B 23/64	23/64			.3594	25/64		5.312		3.34		2.67		0.056	
V90 60730	KC7 3622B 9.2MM			9.2	.3622		10.0		136		85		68	1.43	
V90 60740	KC7 3642B 9.25MM			9.25	.3642		10.0		136		85		68	1.43	
V90 60750	KC7 3661B 9.3MM			9.3	.3661		10.0		136		85		68	1.44	
V90 60760	KC7 3701B 9.4MM			9.4	.3701		10.0		136		85		68	1.46	
V90 60770	KC7 3740B 9.5MM			9.5	.3740		10.0		136		85		68	1.47	
V90 60780	KC7 3750B 3/8	3/8			.3750	25/64		5.312		3.34		2.67		0.058	
V90 60790	KC7 3819B 9.7MM			9.7	.3819		10.0		136		85		68	1.50	
V90 60800	KC7 3858B 9.8MM			9.8	.3858		10.0		136		85		68	1.52	
V90 60810	KC7 3906B 25/64	25/64			.3906	25/64		5.312		3.34		2.67		0.061	
V90 60820	KC7 3937B 10.0MM			10.0	.3937		10.0		136		85		68	1.55	
V90 60830	KC7 4016B 10.2MM			10.2	.4016		12.0		149		93		74	1.58	
V90 60840	KC7 4062B 13/32	13/32			.4062	15/32		5.875		3.625		2.90		0.063	
V90 60850	KC7 4134B 10.50MM			10.50	.4134		12.0		149		93		74	1.63	
V90 60860	KC7 4219B 27/64	27/64			.4219	15/32		5.875		3.625		2.90		0.065	
V90 60870	KC7 4252B 10.8MM			10.8	.4252		12.0		149		93		74	1.67	
V90 60880	KC7 4331B 11.0MM			11.0	.4331		12.0		149		93		74	1.70	
V90 60890	KC7 4375B 7/16	7/16			.4375	15/32		6.1		4		3.20		0.068	
V90 60900	KC7 4409B 11.2MM			11.2	.4409		12.0		155		102		82	1.74	

Coolant Carbide Drill Ø 0.4527" – 0.5000"



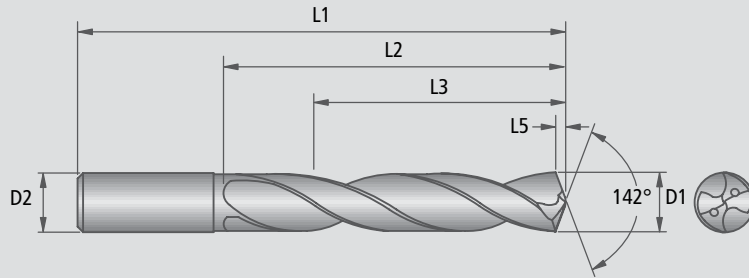
L / D	Through Hole	Blind Hole	Welded Joint	Slanted Surface	Curved Surface	Cross Hole	Center drilled Hole	Interrupted Cut	Stackplate	Rough Boring	Adjustable Diameter
7xD											
	●	●	●	○	○	○	○	○	●	×	×

● highly recommended ● recommended ○ may be suitable × not recommended

Drilling 7 × D

Features:

- Coolant fed, long 7 X D
- Designed for high performance drilling in a broad range of materials
- 30° Helix Angle
- Boutique coated



Order No.	Description	Diameter				Shank		OAL		Flute Length		Drill Length		Point Length	
		D1				D2		L1		L2		L3 Ref.		L5	
		Fraction	Wire/ Letter	mm	Decimal	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm
V90 60910	KC7 4527B 11.5MM			11.5	.4527		12.0		155		102		82		1.78
V90 60920	KC7 4606B 11.7MM			11.7	.4606		12.0		155		102		82		1.81
V90 60930	KC7 4646B 11.8MM			11.8	.4646		12.0		155		102		82		1.83
V90 60940	KC7 4688B 15/32	15/32			.4688	15/32		6.1		4		3.20		0.073	
V90 60950	KC7 4724B 12.0MM			12.0	.4724		12.0		155		102		82		1.86
V90 60960	KC7 4844B 31/64	31/64			.4844	1/2		6.299		4.312		3.45		0.075	
V90 60970	KC7 5000B 1/2	1/2			.5000	1/2		6.299		4.312		3.45		0.077	

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