

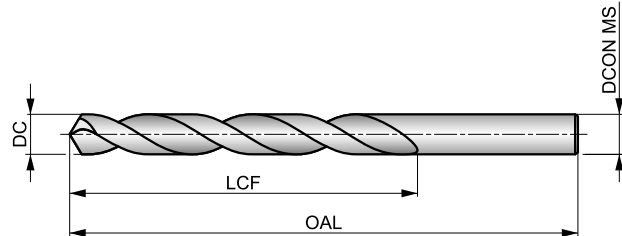


A100

DORMER

HSS Jobber Drill, Steam Tempered Finish

A great and versatile all-around drill with a 118° conventional point, which provides strength and is easy to regrind, making it very cost-effective. Usable for hand-held and machine drilling. Steam tempered finish retains cutting fluid and prevents chip tool welding. Suitable for many materials.



HSS	DIN 338	4×D
118°	ST	
20-35°	R	DC h8

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 175.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
33 H	37 H	38 H	28 H	25 F	22 E	19 F	15 F	13 E	11 F	10 E	8 D	21 E	17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
18 E	15 E	9 G	8 G	7 G	9 C	30 H	22 F	17 F	25 E	20 E	16 E	22 E	17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
13 E	20 E	15 E	11 E	10 E	8 E	23 E	17 E	13 E	33 J	25 J	17 I	42 H	37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
27 H	59 H	35 I	18 G	30 J	28 H	14 F	23 E	12 D	6 B	8 E	4 A	6 E	3 A
S4.1	S4.2												
5 E	2 A												

DC ≤ 1mm; 3/64"; N60. Bright.

Products from this series are also available in set. Please see A190, A191 or A199.

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100.2	—	0.20	0.0079	2.5	19.0	0.20
A100.25	—	0.25	0.0098	3.0	19.0	0.25
A100.3	—	0.30	0.0118	3.0	19.0	0.30
A100.32	—	0.32	0.0126	4.0	19.0	0.32
A100N80	N80	0.34	0.0135	4.0	19.0	0.34
A100.35	—	0.35	0.0138	4.0	19.0	0.35
A100N79	N79	0.37	0.0145	4.0	19.0	0.37
A100.38	—	0.38	0.0150	4.0	19.0	0.38
A1001/64	1/64	0.40	0.0156	5.0	20.0	0.40
A100.4	—	0.40	0.0157	5.0	20.0	0.40
A100N78	N78	0.41	0.0160	5.0	20.0	0.41
A100.42	—	0.42	0.0165	5.0	20.0	0.42
A100.45	—	0.45	0.0177	5.0	20.0	0.45
A100N77	N77	0.46	0.0180	5.0	20.0	0.46
A100.48	—	0.48	0.0189	5.0	20.0	0.48
A100.5	—	0.50	0.0197	6.0	22.0	0.50
A100N76	N76	0.51	0.0200	6.0	22.0	0.51
A100.52	—	0.52	0.0205	6.0	22.0	0.52
A100N75	N75	0.53	0.0210	6.0	22.0	0.53
A100.55	—	0.55	0.0217	7.0	24.0	0.55
A100N74	N74	0.57	0.0225	7.0	24.0	0.57
A100.58	—	0.58	0.0228	7.0	24.0	0.58

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100.6	—	0.60	0.0236	7.0	24.0	0.60
A100N73	N73	0.61	0.0240	8.0	26.0	0.61
A100.62	—	0.62	0.0244	8.0	26.0	0.62
A100N72	N72	0.64	0.0250	8.0	26.0	0.64
A100.65	—	0.65	0.0256	8.0	26.0	0.65
A100N71	N71	0.66	0.0260	8.0	26.0	0.66
A100.68	—	0.68	0.0268	9.0	28.0	0.68
A100.7	—	0.70	0.0276	9.0	28.0	0.70
A100N70	N70	0.71	0.0280	9.0	28.0	0.71
A100.72	—	0.72	0.0283	9.0	28.0	0.72
A100N69	N69	0.74	0.0292	9.0	28.0	0.74
A100.75	—	0.75	0.0295	9.0	28.0	0.75
A100.78	—	0.78	0.0307	10.0	30.0	0.78
A1001/32	1/32	0.79	0.0313	10.0	30.0	0.79
A100N68	N68	0.79	0.0310	10.0	30.0	0.79
A100.8	—	0.80	0.0315	10.0	30.0	0.80
A100N67	N67	0.81	0.0320	10.0	30.0	0.81
A100.82	—	0.82	0.0323	10.0	30.0	0.82
A100N66	N66	0.84	0.0330	10.0	30.0	0.84
A100.85	—	0.85	0.0335	10.0	30.0	0.85
A100.88	—	0.88	0.0346	11.0	32.0	0.88
A100N65	N65	0.89	0.0350	11.0	32.0	0.89



Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100.9	—	0.90	0.0354	11.0	32.0	0.90
A100N64	N64	0.91	0.0360	11.0	32.0	0.91
A100.92	—	0.92	0.0362	11.0	32.0	0.92
A100N63	N63	0.94	0.0370	11.0	32.0	0.94
A100.95	—	0.95	0.0374	11.0	32.0	0.95
A100N62	N62	0.97	0.0380	12.0	34.0	0.97
A100.98	—	0.98	0.0386	12.0	34.0	0.98
A100N61	N61	0.99	0.0390	12.0	34.0	0.99
A1001.0	—	1.00	0.0394	12.0	34.0	1.00
A100N60	N60	1.02	0.0400	12.0	34.0	1.02
A100N59	N59	1.04	0.0410	12.0	34.0	1.04
A1001.05	—	1.05	0.0413	12.0	34.0	1.05
A100N58	N58	1.07	0.0420	14.0	36.0	1.07
A100N57	N57	1.09	0.0430	14.0	36.0	1.09
A1001.1	—	1.10	0.0433	14.0	36.0	1.10
A1001.15	—	1.15	0.0453	14.0	36.0	1.15
A100N56	N56	1.18	0.0465	14.0	36.0	1.18
A1003/64	3/64	1.19	0.0469	16.0	38.0	1.19
A1001.2	—	1.20	0.0472	16.0	38.0	1.20
A1001.25	—	1.25	0.0492	16.0	38.0	1.25
A1001.3	—	1.30	0.0512	16.0	38.0	1.30
A100N55	N55	1.32	0.0520	16.0	38.0	1.32
A1001.35	—	1.35	0.0531	18.0	40.0	1.35
A1001.4	—	1.40	0.0551	18.0	40.0	1.40
A100N54	N54	1.40	0.0550	18.0	40.0	1.40
A1001.45	—	1.45	0.0571	18.0	40.0	1.45
A1001.5	—	1.50	0.0591	18.0	40.0	1.50
A100N53	N53	1.51	0.0595	20.0	43.0	1.51
A1001.55	—	1.55	0.0610	20.0	43.0	1.55
A1001/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1001.6	—	1.60	0.0630	20.0	43.0	1.60
A100N52	N52	1.61	0.0635	20.0	43.0	1.61
A1001.65	—	1.65	0.0650	20.0	43.0	1.65
A1001.7	—	1.70	0.0669	20.0	43.0	1.70
A100N51	N51	1.70	0.0670	22.0	46.0	1.70
A1001.75	—	1.75	0.0689	22.0	46.0	1.75
A100N50	N50	1.78	0.0700	22.0	46.0	1.78
A1001.8	—	1.80	0.0709	22.0	46.0	1.80
A1001.85	—	1.85	0.0728	22.0	46.0	1.85
A100N49	N49	1.85	0.0730	22.0	46.0	1.85
A1001.9	—	1.90	0.0748	22.0	46.0	1.90
A100N48	N48	1.93	0.0760	24.0	49.0	1.93
A1001.95	—	1.95	0.0768	24.0	49.0	1.95
A1005/64	5/64	1.98	0.0781	24.0	49.0	1.98
A100N47	N47	1.99	0.0785	24.0	49.0	1.99
A1002.0	—	2.00	0.0787	24.0	49.0	2.00
A1002.05	—	2.05	0.0807	24.0	49.0	2.05
A100N46	N46	2.06	0.0810	24.0	49.0	2.06
A100N45	N45	2.08	0.0820	24.0	49.0	2.08
A1002.1	—	2.10	0.0827	24.0	49.0	2.10
A1002.15	—	2.15	0.0846	27.0	53.0	2.15
A100N44	N44	2.18	0.0860	27.0	53.0	2.18
A1002.2	—	2.20	0.0866	27.0	53.0	2.20
A1002.25	—	2.25	0.0886	27.0	53.0	2.25
A100N43	N43	2.26	0.0890	27.0	53.0	2.26
A1002.3	—	2.30	0.0906	27.0	53.0	2.30
A1002.35	—	2.35	0.0925	27.0	53.0	2.35
A1003/32	3/32	2.38	0.0938	30.0	57.0	2.38
A100N42	N42	2.38	0.0935	30.0	57.0	2.38
A1002.4	—	2.40	0.0945	30.0	57.0	2.40
A100N41	N41	2.44	0.0960	30.0	57.0	2.44
A1002.45	—	2.45	0.0965	30.0	57.0	2.45

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100N40	N40	2.49	0.0980	30.0	57.0	2.49
A1002.5	—	2.50	0.0984	30.0	57.0	2.50
A100N39	N39	2.53	0.0995	30.0	57.0	2.53
A1002.55	—	2.55	0.1004	30.0	57.0	2.55
A100N38	N38	2.58	0.1015	30.0	57.0	2.58
A1002.6	—	2.60	0.1024	30.0	57.0	2.60
A100N37	N37	2.64	0.1040	30.0	57.0	2.64
A1002.65	—	2.65	0.1043	30.0	57.0	2.65
A1002.7	—	2.70	0.1063	33.0	61.0	2.70
A100N36	N36	2.71	0.1065	33.0	61.0	2.71
A1002.75	—	2.75	0.1083	33.0	61.0	2.75
A1007/64	7/64	2.78	0.1094	33.0	61.0	2.78
A100N35	N35	2.79	0.1100	33.0	61.0	2.79
A1002.8	—	2.80	0.1102	33.0	61.0	2.80
A100N34	N34	2.82	0.1110	33.0	61.0	2.82
A1002.85	—	2.85	0.1122	33.0	61.0	2.85
A100N33	N33	2.87	0.1130	33.0	61.0	2.87
A1002.9	—	2.90	0.1142	33.0	61.0	2.90
A1002.95	—	2.95	0.1161	33.0	61.0	2.95
A100N32	N32	2.95	0.1160	33.0	61.0	2.95
A1003.0	—	3.00	0.1181	33.0	61.0	3.00
A100N31	N31	3.05	0.1200	36.0	65.0	3.05
A1003.1	—	3.10	0.1220	36.0	65.0	3.10
A1003.15	—	3.15	0.1240	36.0	65.0	3.15
A1001/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1003.2	—	3.20	0.1260	36.0	65.0	3.20
A1003.25	—	3.25	0.1280	36.0	65.0	3.25
A100N30	N30	3.26	0.1285	36.0	65.0	3.26
A1003.3	—	3.30	0.1299	36.0	65.0	3.30
A1003.4	—	3.40	0.1339	39.0	70.0	3.40
A100N29	N29	3.45	0.1360	39.0	70.0	3.45
A1003.5	—	3.50	0.1378	39.0	70.0	3.50
A1009/64	9/64	3.57	0.1406	39.0	70.0	3.57
A100N28	N28	3.57	0.1405	39.0	70.0	3.57
A1003.6	—	3.60	0.1417	39.0	70.0	3.60
A100N27	N27	3.66	0.1440	39.0	70.0	3.66
A1003.7	—	3.70	0.1457	39.0	70.0	3.70
A100N26	N26	3.73	0.1470	39.0	70.0	3.73
A1003.75	—	3.75	0.1476	39.0	70.0	3.75
A1003.8	—	3.80	0.1496	43.0	75.0	3.80
A100N25	N25	3.80	0.1495	43.0	75.0	3.80
A100N24	N24	3.86	0.1520	43.0	75.0	3.86
A1003.9	—	3.90	0.1535	43.0	75.0	3.90
A100N23	N23	3.91	0.1540	43.0	75.0	3.91
A1005/32	5/32	3.97	0.1563	43.0	75.0	3.97
A100N22	N22	3.99	0.1570	43.0	75.0	3.99
A1004.0	—	4.00	0.1575	43.0	75.0	4.00
A100N21	N21	4.04	0.1590	43.0	75.0	4.04
A100N20	N20	4.09	0.1610	43.0	75.0	4.09
A1004.1	—	4.10	0.1614	43.0	75.0	4.10
A1004.2	—	4.20	0.1654	43.0	75.0	4.20
A100N19	N19	4.22	0.1660	43.0	75.0	4.22
A1004.25	—	4.25	0.1673	43.0	75.0	4.25
A1004.3	—	4.30	0.1693	47.0	80.0	4.30
A100N18	N18	4.31	0.1695	47.0	80.0	4.31
A10011/64	11/64	4.37	0.1719	47.0	80.0	4.37
A100N17	N17	4.39	0.1730	47.0	80.0	4.39
A1004.4	—	4.40	0.1732	47.0	80.0	4.40
A1004.5	—	4.50	0.1772	47.0	80.0	4.50
A100N16	N16	4.50	0.1770	47.0	80.0	4.50
A100N15	N15	4.57	0.1800	47.0	80.0	4.57
A1004.6	—	4.60	0.1811	47.0	80.0	4.60



Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100N14	N14	4.62	0.1820	47.0	80.0	4.62
A1004.7	—	4.70	0.1850	47.0	80.0	4.70
A100N13	N13	4.70	0.1850	47.0	80.0	4.70
A1004.75	—	4.75	0.1870	47.0	80.0	4.75
A1003/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1004.8	—	4.80	0.1890	52.0	86.0	4.80
A100N12	N12	4.80	0.1890	52.0	86.0	4.80
A100N11	N11	4.85	0.1910	52.0	86.0	4.85
A1004.9	—	4.90	0.1929	52.0	86.0	4.90
A100N10	N10	4.92	0.1935	52.0	86.0	4.92
A100N9	N9	4.98	0.1960	52.0	86.0	4.98
A1005.0	—	5.00	0.1969	52.0	86.0	5.00
A100N8	N8	5.06	0.1990	52.0	86.0	5.06
A1005.1	—	5.10	0.2008	52.0	86.0	5.10
A100N7	N7	5.11	0.2010	52.0	86.0	5.11
A10013/64	13/64	5.16	0.2031	52.0	86.0	5.16
A100N6	N6	5.18	0.2040	52.0	86.0	5.18
A1005.2	—	5.20	0.2047	52.0	86.0	5.20
A100N5	N5	5.22	0.2055	52.0	86.0	5.22
A1005.25	—	5.25	0.2067	52.0	86.0	5.25
A1005.3	—	5.30	0.2087	52.0	86.0	5.30
A100N4	N4	5.31	0.2090	57.0	93.0	5.31
A1005.4	—	5.40	0.2126	57.0	93.0	5.40
A100N3	N3	5.41	0.2130	57.0	93.0	5.41
A1005.5	—	5.50	0.2165	57.0	93.0	5.50
A1007/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1005.6	—	5.60	0.2205	57.0	93.0	5.60
A100N2	N2	5.61	0.2210	57.0	93.0	5.61
A1005.7	—	5.70	0.2244	57.0	93.0	5.70
A1005.75	—	5.75	0.2264	57.0	93.0	5.75
A100N1	1	5.79	0.2280	57.0	93.0	5.79
A1005.8	—	5.80	0.2283	57.0	93.0	5.80
A1005.9	—	5.90	0.2323	57.0	93.0	5.90
A100A	A	5.94	0.2340	57.0	93.0	5.94
A10015/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1006.0	—	6.00	0.2362	57.0	93.0	6.00
A100B	B	6.03	0.2380	63.0	101.0	6.03
A1006.1	—	6.10	0.2402	63.0	101.0	6.10
A100C	C	6.15	0.2420	63.0	101.0	6.15
A1006.2	—	6.20	0.2441	63.0	101.0	6.20
A1006.25	—	6.25	0.2461	63.0	101.0	6.25
A100D	D	6.25	0.2460	63.0	101.0	6.25
A1006.3	—	6.30	0.2480	63.0	101.0	6.30
A1001/4	1/4	6.35	0.2500	63.0	101.0	6.35
A100E	E	6.35	0.2500	63.0	101.0	6.35
A1006.4	—	6.40	0.2520	63.0	101.0	6.40
A1006.5	—	6.50	0.2559	63.0	101.0	6.50
A100F	F	6.53	0.2570	63.0	101.0	6.53
A1006.6	—	6.60	0.2598	63.0	101.0	6.60
A100G	G	6.63	0.2610	63.0	101.0	6.63
A1006.7	—	6.70	0.2638	63.0	101.0	6.70
A10017/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1006.75	—	6.75	0.2657	69.0	109.0	6.75
A100H	H	6.76	0.2660	69.0	109.0	6.76
A1006.8	—	6.80	0.2677	69.0	109.0	6.80
A1006.9	—	6.90	0.2717	69.0	109.0	6.90
A100I	I	6.91	0.2720	69.0	109.0	6.91
A1007.0	—	7.00	0.2756	69.0	109.0	7.00
A100J	J	7.04	0.2770	69.0	109.0	7.04
A1007.1	—	7.10	0.2795	69.0	109.0	7.10
A1009/32	9/32	7.14	0.2813	69.0	109.0	7.14
A100K	K	7.14	0.2810	69.0	109.0	7.14

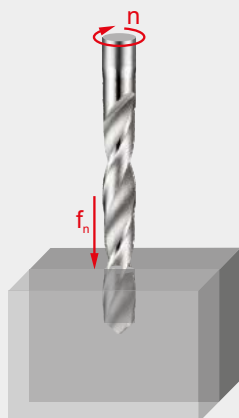
Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A1007.2	—	7.20	0.2835	69.0	109.0	7.20
A1007.25	—	7.25	0.2854	69.0	109.0	7.25
A1007.3	—	7.30	0.2874	69.0	109.0	7.30
A100L	L	7.37	0.2900	69.0	109.0	7.37
A1007.4	—	7.40	0.2913	69.0	109.0	7.40
A100M	M	7.49	0.2949	69.0	109.0	7.49
A1007.5	—	7.50	0.2953	69.0	109.0	7.50
A10019/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1007.6	—	7.60	0.2992	75.0	117.0	7.60
A100N	N	7.67	0.3020	75.0	117.0	7.67
A1007.7	—	7.70	0.3031	75.0	117.0	7.70
A1007.75	—	7.75	0.3051	75.0	117.0	7.75
A1007.8	—	7.80	0.3071	75.0	117.0	7.80
A1007.9	—	7.90	0.3110	75.0	117.0	7.90
A1005/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1008.0	—	8.00	0.3150	75.0	117.0	8.00
A1000	O	8.03	0.3160	75.0	117.0	8.03
A1008.1	—	8.10	0.3189	75.0	117.0	8.10
A1008.2	—	8.20	0.3228	75.0	117.0	8.20
A100P	P	8.20	0.3230	75.0	117.0	8.20
A1008.25	—	8.25	0.3248	75.0	117.0	8.25
A1008.3	—	8.30	0.3268	75.0	117.0	8.30
A10021/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1008.4	—	8.40	0.3307	75.0	117.0	8.40
A100Q	Q	8.43	0.3320	75.0	117.0	8.43
A1008.5	—	8.50	0.3346	75.0	117.0	8.50
A1008.6	—	8.60	0.3386	81.0	125.0	8.60
A100R	R	8.61	0.3390	81.0	125.0	8.61
A1008.7	—	8.70	0.3425	81.0	125.0	8.70
A10011/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1008.75	—	8.75	0.3445	81.0	125.0	8.75
A1008.8	—	8.80	0.3465	81.0	125.0	8.80
A100S	S	8.84	0.3480	81.0	125.0	8.84
A1008.9	—	8.90	0.3504	81.0	125.0	8.90
A1009.0	—	9.00	0.3543	81.0	125.0	9.00
A100T	T	9.09	0.3580	81.0	125.0	9.09
A1009.1	—	9.10	0.3583	81.0	125.0	9.10
A10023/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1009.2	—	9.20	0.3622	81.0	125.0	9.20
A1009.25	—	9.25	0.3642	81.0	125.0	9.25
A1009.3	—	9.30	0.3661	81.0	125.0	9.30
A100U	U	9.35	0.3680	81.0	125.0	9.35
A1009.4	—	9.40	0.3701	81.0	125.0	9.40
A1009.5	—	9.50	0.3740	81.0	125.0	9.50
A1003/8	3/8	9.52	0.3750	87.0	133.0	9.52
A100V	V	9.58	0.3770	87.0	133.0	9.58
A1009.6	—	9.60	0.3780	87.0	133.0	9.60
A1009.7	—	9.70	0.3819	87.0	133.0	9.70
A1009.75	—	9.75	0.3839	87.0	133.0	9.75
A1009.8	—	9.80	0.3858	87.0	133.0	9.80
A100W	W	9.80	0.3860	87.0	133.0	9.80
A1009.9	—	9.90	0.3898	87.0	133.0	9.90
A10025/64	25/64	9.92	0.3906	87.0	133.0	9.92
A10010.0	—	10.00	0.3937	87.0	133.0	10.00
A100X	X	10.08	0.3970	87.0	133.0	10.08
A10010.1	—	10.10	0.3976	87.0	133.0	10.10
A10010.2	—	10.20	0.4016	87.0	133.0	10.20
A10010.25	—	10.25	0.4035	87.0	133.0	10.25
A100Y	Y	10.26	0.4040	87.0	133.0	10.26
A10010.3	—	10.30	0.4055	87.0	133.0	10.30
A10013/32	13/32	10.32	0.4063	87.0	133.0	10.32
A10010.4	—	10.40	0.4094	87.0	133.0	10.40



Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A100Z	Z	10.49	0.4130	87.0	133.0	10.49
A10010.5	—	10.50	0.4134	87.0	133.0	10.50
A10010.6	—	10.60	0.4173	87.0	133.0	10.60
A10010.7	—	10.70	0.4213	94.0	142.0	10.70
A10027/64	27/64	10.72	0.4219	94.0	142.0	10.72
A10010.75	—	10.75	0.4232	94.0	142.0	10.75
A10010.8	—	10.80	0.4252	94.0	142.0	10.80
A10010.9	—	10.90	0.4291	94.0	142.0	10.90
A10011.0	—	11.00	0.4331	94.0	142.0	11.00
A10011.1	—	11.10	0.4370	94.0	142.0	11.10
A1007/16	7/16	11.11	0.4375	94.0	142.0	11.11
A10011.2	—	11.20	0.4409	94.0	142.0	11.20
A10011.25	—	11.25	0.4429	94.0	142.0	11.25
A10011.3	—	11.30	0.4449	94.0	142.0	11.30
A10011.4	—	11.40	0.4488	94.0	142.0	11.40
A10011.5	—	11.50	0.4528	94.0	142.0	11.50
A10029/64	29/64	11.51	0.4531	94.0	142.0	11.51
A10011.6	—	11.60	0.4567	94.0	142.0	11.60
A10011.7	—	11.70	0.4606	94.0	142.0	11.70
A10011.75	—	11.75	0.4626	94.0	142.0	11.75
A10011.8	—	11.80	0.4646	94.0	142.0	11.80
A10011.9	—	11.90	0.4685	101.0	151.0	11.90
A10015/32	15/32	11.91	0.4688	101.0	151.0	11.91
A10012.0	—	12.00	0.4724	101.0	151.0	12.00
A10012.1	—	12.10	0.4764	101.0	151.0	12.10
A10012.2	—	12.20	0.4803	101.0	151.0	12.20
A10012.25	—	12.25	0.4823	101.0	151.0	12.25
A10012.3	—	12.30	0.4843	101.0	151.0	12.30
A10031/64	31/64	12.30	0.4844	101.0	151.0	12.30
A10012.4	—	12.40	0.4882	101.0	151.0	12.40
A10012.5	—	12.50	0.4921	101.0	151.0	12.50
A10012.6	—	12.60	0.4961	101.0	151.0	12.60
A10012.7	—	12.70	0.5000	101.0	151.0	12.70
A1001/2	1/2	12.70	0.5000	101.0	151.0	12.70
A10012.75	—	12.75	0.5020	101.0	151.0	12.75
A10012.8	—	12.80	0.5039	101.0	151.0	12.80
A10012.9	—	12.90	0.5079	101.0	151.0	12.90
A10013.0	—	13.00	0.5118	101.0	151.0	13.00
A10033/64	33/64	13.10	0.5156	101.0	151.0	13.10

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A10013.1	—	13.10	0.5157	101.0	151.0	13.10
A10013.2	—	13.20	0.5197	101.0	151.0	13.20
A10013.25	—	13.25	0.5217	108.0	160.0	13.25
A10013.3	—	13.30	0.5236	108.0	160.0	13.30
A10013.4	—	13.40	0.5276	108.0	160.0	13.40
A10017/32	17/32	13.49	0.5313	108.0	160.0	13.49
A10013.5	—	13.50	0.5315	108.0	160.0	13.50
A10013.6	—	13.60	0.5354	108.0	160.0	13.60
A10013.7	—	13.70	0.5394	108.0	160.0	13.70
A10013.75	—	13.75	0.5413	108.0	160.0	13.75
A10013.8	—	13.80	0.5433	108.0	160.0	13.80
A10035/64	35/64	13.89	0.5469	108.0	160.0	13.89
A10013.9	—	13.90	0.5472	108.0	160.0	13.90
A10014.0	—	14.00	0.5512	108.0	160.0	14.00
A10014.25	—	14.25	0.5610	114.0	169.0	14.25
A1009/16	9/16	14.29	0.5625	114.0	169.0	14.29
A10014.5	—	14.50	0.5709	114.0	169.0	14.50
A10037/64	37/64	14.68	0.5781	114.0	169.0	14.68
A10014.75	—	14.75	0.5807	114.0	169.0	14.75
A10015.0	—	15.00	0.5906	114.0	169.0	15.00
A10019/32	19/32	15.08	0.5938	120.0	178.0	15.08
A10015.25	—	15.25	0.6004	120.0	178.0	15.25
A10039/64	39/64	15.48	0.6094	120.0	178.0	15.48
A10015.5	—	15.50	0.6102	120.0	178.0	15.50
A10015.75	—	15.75	0.6201	120.0	178.0	15.75
A1005/8	5/8	15.88	0.6250	120.0	178.0	15.88
A10016.0	—	16.00	0.6299	120.0	178.0	16.00
A10041/64	41/64	16.27	0.6406	125.0	184.0	16.27
A10016.5	—	16.50	0.6496	125.0	184.0	16.50
A10021/32	21/32	16.67	0.6563	125.0	184.0	16.67
A10017.0	—	17.00	0.6693	125.0	184.0	17.00
A10043/64	43/64	17.07	0.6719	130.0	191.0	17.07
A10011/16	11/16	17.46	0.6875	130.0	191.0	17.46
A10017.5	—	17.50	0.6890	130.0	191.0	17.50
A10018.0	—	18.00	0.7087	130.0	191.0	18.00
A10018.5	—	18.50	0.7283	135.0	198.0	18.50
A10019.0	—	19.00	0.7480	135.0	198.0	19.00
A10019.5	—	19.50	0.7677	140.0	205.0	19.50
A10020.0	—	20.00	0.7874	140.0	205.0	20.00

DRILLING FEED RATE CHART



Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 25\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 46J, "J" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

		ø DC [mm]																		
		0.15	0.50	1.00	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	100.00
Feed rates	A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
	B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
	C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
	D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
	E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
	F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
	G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
	H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
	I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
	J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
	K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
	L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
	M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
	N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
	S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
	T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
	U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
	V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
	W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
	X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
	Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
	Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–



WMG (WORK MATERIAL GROUP)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900
		P3.3			260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900
P4.2		Hardened and tempered		26 – 39 HRC	> 900 ≤ 1240	
P4.3				39 – 45 HRC	> 1240 ≤ 1450	
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520
		M1.2			160 – 220 HB	> 520 ≤ 700
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750
		M3.2			200 – 260 HB	> 750 ≤ 870
		M3.3			260 – 300 HB	> 870 ≤ 1040
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990
		M4.2		Precipitation hardening austenitic stainless steel	300 – 380 HB	≤ 1320
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190
		K1.2		Ferritic-pearlitic or pearlitic	180 – 240 HB	> 190 ≤ 310
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190
		K4.2			< 240 HB	≤ 740
K4.3				< 280 HB	> 840 ≤ 980	
K4.4		Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)		280 – 320 HB	> 980 ≤ 1130	
K4.5				320 – 360 HB	> 1130 ≤ 1280	
K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	
	K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	
	K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240
		N1.2		Half hard tempered	60 – 100 HB	> 240 ≤ 400
		N1.3		Full hard tempered	100 – 150 HB	> 400 ≤ 590
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240
		N2.2			75 – 90 HB	> 240 ≤ 270
		N2.3			90 – 140 HB	> 270 ≤ 440
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–
		N3.2		Short-chip copper-alloys with good to moderate machining properties	–	–
		N3.3		Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties	–	–
	N4	N4.1	Thermoplastic polymers		–	–
N4.2		Thermosetting polymers		–	–	
N4.3		Reinforced polymers or composites		–	–	
N5	N5.1	Graphite		–	–	
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660
		S1.2			200 – 280 HB	> 660 ≤ 950
		S1.3			280 – 360 HB	> 950 ≤ 1200
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690
		S2.2			200 – 280 HB	> 690 ≤ 970
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940
		S3.2			280 – 360 HB	> 940 ≤ 1200
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800
S4.2				240 – 320 HB	> 800 ≤ 1070	
H	H1	H1.1	Chilled cast iron		< 440 HB	–
	H2	H2.1	Hardened cast iron		< 55 HRC	–
		H2.2			> 55 HRC	–
	H3	H3.1	Hardened steel <55 HRC		< 51 HRC	–
		H3.2			51 – 55 HRC	–
H4	H4.1	Hardened steel >55 HRC		55 – 59 HRC	–	
H4.2			> 59 HRC	–		