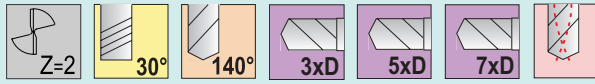


TOLERANCES

<i>d</i>	+.0000" - .0005" (+.0000 - .0127mm)	
<i>l1</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)
<i>l2</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)



TECH PAGES
332-333

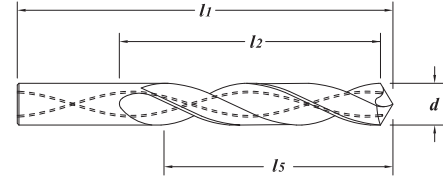
Series 1580KH, 1280KH, 1880KH

.1181" - .1540"
(3.000mm - 3.912mm)

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

BALIQ® ALTINOS Coating (AlTiN-based)

- High performance - high penetration solid submicron grain carbide drill
- Coolant through capabilities for high pressure coolant systems
- Extended tool life and greater surface finish through faster SFM rates
- Up to 70% faster than standard carbide drills
- 30° helix for better chip evacuation
- Honed cutting edge
- Live tooling recommended on lathe processes



3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	<i>d</i> † Diameter		<i>l1</i> Overall Length	<i>l2</i> Flute Length	<i>l5</i> Max Drill Depth	1-11	12-24	25-49	50-100
			Decimal	Metric							
22010			.1181	3.000	46	16	10	42.18	40.35	38.51	36.68
	25366		.1181	3.000	50	19	16	46.66	44.63	42.60	40.57
		26366		.1181	3.000	65	28	22	52.06	49.80	47.53
22015			.1200	#31 3.048	1-13/16"	5/8"	.382"	42.63	40.78	38.92	37.07
	25371		.1200	#31 3.048	2"	3/4"	.622"	47.02	44.98	42.93	40.89
		26371		.1200	#31 3.048	2-1/2"	1-1/8"	.862"	52.50	50.22	47.93
22020			.1250	1/8" 3.175	1-15/16"	11/16"	.398"	42.99	41.12	39.25	37.38
	25376		.1250	1/8" 3.175	2"	3/4"	.648"	47.41	45.35	43.29	41.23
		26376		.1250	1/8" 3.175	2-1/2"	1-1/8"	.898"	52.91	50.61	48.31
22025			.1285	#30 3.264	1-15/16"	11/16"	.409"	43.38	41.49	39.61	37.72
	25381		.1285	#30 3.264	2-1/4"	3/4"	.666"	47.83	45.75	43.67	41.59
		26381		.1285	#30 3.264	2-1/2"	1-1/8"	.923"	53.39	51.07	48.75
22030			.1360	#29 3.454	2-1/16"	3/4"	.433"	43.78	41.88	39.97	38.07
	25386		.1360	#29 3.454	2-1/4"	7/8"	.705"	48.19	46.09	44.00	41.90
		26386		.1360	#29 3.454	3"	1-1/4"	.977"	53.77	51.44	49.10
22035			.1378	3.500	52	19	11	44.23	42.31	40.38	38.46
	25391		.1378	3.500	57	22	18	48.55	46.44	44.33	42.22
		26391		.1378	3.500	75	32	25	54.20	51.84	49.49
22040			.1405	#28 3.569	2-1/16"	3/4"	.447"	44.63	42.69	40.75	38.81
	25396		.1405	#28 3.569	2-1/4"	7/8"	.728"	48.96	46.83	44.70	42.57
		26396		.1405	#28 3.569	3"	1-1/4"	1.009"	54.64	52.26	49.89
22045			.1406	9/64" 3.571	2-1/16"	3/4"	.447"	45.02	43.07	41.11	39.15
	25401		.1406	9/64" 3.571	2-1/4"	7/8"	.729"	49.38	47.23	45.09	42.94
		26401		.1406	9/64" 3.571	3"	1-1/4"	1.010"	55.10	52.70	50.31
22050			.1440	#27 3.658	2-1/16"	3/4"	.458"	45.43	43.45	41.48	39.50
	25406		.1440	#27 3.658	2-1/4"	7/8"	.746"	49.70	47.54	45.38	43.22
		26406		.1440	#27 3.658	3"	1-3/8"	1.034"	55.48	53.06	50.65
22055			.1470	#26 3.734	2-3/16"	13/16"	.468"	45.77	43.78	41.79	39.80
	25411		.1470	#26 3.734	2-1/4"	7/8"	.762"	50.13	47.95	45.77	43.59
		26411		.1470	#26 3.734	3"	1-3/8"	1.056"	55.94	53.50	51.07
22060			.1495	#25 3.797	2-3/16"	13/16"	.476"	46.24	44.23	42.22	40.21
	25416		.1495	#25 3.797	2-1/4"	15/16"	.775"	50.51	48.31	46.12	43.92
		26416		.1495	#25 3.797	3"	1-3/8"	1.074"	56.37	53.92	51.47
22065			.1520	#24 3.861	2-3/16"	13/16"	.484"	46.62	44.59	42.57	40.54
	25421		.1520	#24 3.861	2-1/4"	15/16"	.788"	50.86	48.65	46.44	44.23
		26421		.1520	#24 3.861	3"	1-1/2"	1.092"	56.76	54.30	51.83
22070			.1540	#23 3.912	2-3/16"	13/16"	.490"	47.02	44.98	42.93	40.89
	25426		.1540	#23 3.912	2-1/4"	15/16"	.798"	51.29	49.06	46.83	44.60
		26426		.1540	#23 3.912	3"	1-1/2"	1.106"	57.24	54.75	52.26

continued →

Series 1580KH, 1280KH, 1880KH (continued)

.1562" - .1935"
(3.967mm - 4.915mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	d^{\dagger} Diameter		l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth	1-11	12-24	25-49	50-100	
			Decimal	Metric								
22075			.1562	5/32"	3.967	2-3/16"	13/16"	.497"	47.40	45.34	43.28	41.22
	25431		.1562	5/32"	3.967	2-1/2"	15/16"	.809"	51.66	49.41	47.17	44.92
		26431	.1562	5/32"	3.967	3"	1-1/2"	1.122"	57.65	55.14	52.64	50.13
22080			.1570	#22	3.988	2-3/16"	13/16"	.500"	47.83	45.75	43.67	41.59
	25436		.1570	#22	3.988	2-1/2"	15/16"	.814"	52.01	49.75	47.49	45.23
		26436	.1570	#22	3.988	3"	1-1/2"	1.128"	58.05	55.53	53.00	50.48
22085			.1575		4.000	56	21	13	48.21	46.11	44.02	41.92
	25441		.1575		4.000	65	24	21	52.43	50.15	47.87	45.59
		26441	.1575		4.000	75	38	29	58.50	55.96	53.41	50.87
22090			.1590	#21	4.039	2-3/16"	13/16"	.506"	48.66	46.54	44.43	42.31
	25446		.1590	#21	4.039	2-1/2"	15/16"	.824"	52.79	50.49	48.20	45.90
		26446	.1590	#21	4.039	3"	1-1/2"	1.142"	58.88	56.32	53.76	51.20
22095			.1610	#20	4.089	2-3/16"	13/16"	.512"	49.05	46.92	44.78	42.65
	25451		.1610	#20	4.089	2-1/2"	15/16"	.834"	53.19	50.88	48.56	46.25
		26451	.1610	#20	4.089	3"	1-1/2"	1.156"	59.34	56.76	54.18	51.60
22100			.1660	#19	4.216	2-9/32"	15/16"	.528"	49.47	47.32	45.17	43.02
	25456		.1660	#19	4.216	2-1/2"	1"	.860"	53.59	51.26	48.93	46.60
		26456	.1660	#19	4.216	3"	1-1/2"	1.192"	59.80	57.20	54.60	52.00
22105			.1695	#18	4.305	2-9/32"	15/16"	.539"	49.88	47.71	45.54	43.37
	25461		.1695	#18	4.305	2-1/2"	1"	.878"	53.98	51.63	49.29	46.94
		26461	.1695	#18	4.305	3-1/2"	1-3/4"	1.217"	60.20	57.59	54.97	52.35
22110			.1719	11/64"	4.366	2-9/32"	15/16"	.547"	50.28	48.09	45.91	43.72
	25466		.1719	11/64"	4.366	2-1/2"	1"	.891"	54.35	51.99	49.62	47.26
		26466	.1719	11/64"	4.366	3-1/2"	1-3/4"	1.235"	60.63	57.99	55.36	52.72
22115			.1730	#17	4.394	2-9/32"	15/16"	.551"	50.69	48.49	46.28	44.08
	25471		.1730	#17	4.394	2-1/2"	1"	.897"	54.71	52.33	49.95	47.57
		26471	.1730	#17	4.394	3-1/2"	1-3/4"	1.243"	61.03	58.38	55.72	53.07
22120			.1770	#16	4.496	2-9/32"	15/16"	.563"	51.04	48.82	46.60	44.38
	25476		.1770	#16	4.496	2-1/2"	1"	.917"	55.11	52.71	50.32	47.92
		26476	.1770	#16	4.496	3-1/2"	1-3/4"	1.271"	61.51	58.84	56.16	53.49
22125			.1772		4.500	58	24	14	51.49	49.25	47.01	44.77
	25481		.1772		4.500	65	25	23	55.52	53.11	50.69	48.28
		26481	.1772		4.500	88	45	32	61.95	59.26	56.56	53.87
22130			.1800	#15	4.572	2-9/32"	15/16"	.573"	51.81	49.56	47.30	45.05
	25486		.1800	#15	4.572	2-3/4"	1"	.933"	55.89	53.46	51.03	48.60
		26486	.1800	#15	4.572	3-1/2"	1-3/4"	1.293"	62.35	59.64	56.93	54.22
22135			.1820	#14	4.623	2-9/32"	15/16"	.579"	52.31	50.04	47.76	45.49
	25491		.1820	#14	4.623	2-3/4"	1"	.913"	56.25	53.80	51.36	48.91
		26491	.1820	#14	4.623	3-1/2"	1-3/4"	1.307"	62.76	60.03	57.30	54.57
22140			.1850	#13	4.699	2-9/32"	15/16"	.589"	52.68	50.39	48.10	45.81
	25496		.1850	#13	4.699	2-3/4"	1-1/4"	.959"	56.65	54.19	51.72	49.26
		26496	.1850	#13	4.699	3-1/2"	1-3/4"	1.329"	63.20	60.46	57.71	54.96
22145			.1875	3/16"	4.763	2-13/32"	1"	.597"	53.11	50.80	48.49	46.18
	25501		.1875	3/16"	4.763	2-3/4"	1-1/4"	.972"	57.06	54.58	52.10	49.62
		26501	.1875	3/16"	4.763	4"	2"	1.347"	63.69	60.92	58.15	55.38
22150			.1890	#12	4.801	2-13/32"	1"	.601"	53.49	51.16	48.84	46.51
	25506		.1890	#12	4.801	2-3/4"	1-1/4"	.979"	57.42	54.92	52.43	49.93
		26506	.1890	#12	4.801	4"	2"	1.357"	64.07	61.28	58.50	55.71
22155			.1910	#11	4.851	2-13/32"	1"	.608"	53.98	51.63	49.29	46.94
	25511		.1910	#11	4.851	2-3/4"	1-1/4"	.990"	57.79	55.28	52.76	50.25
		26511	.1910	#11	4.851	4"	2"	1.372"	64.49	61.69	58.88	56.08
22160			.1935	#10	4.915	2-13/32"	1"	.616"	54.29	51.93	49.57	47.21
	25516		.1935	#10	4.915	2-3/4"	1-1/4"	1.003"	58.22	55.69	53.16	50.63
		26516	.1935	#10	4.915	4"	2"	1.390"	64.94	62.12	59.29	56.47

Series 1580KH, 1280KH, 1880KH (continued)

.1960" - .2420"
(4.978mm - 6.147mm)

HIGH PERFORMANCE
DRILLS

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	d^+ Diameter		l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth	1-11	12-24	25-49	50-100	
			Decimal	Metric								
22165			.1960	#9	4.978	2-13/32"	1"	.624"	54.69	52.32	49.94	47.56
	25521		.1960	#9	4.978	3"	1-5/16"	1.016"	58.56	56.01	53.47	50.92
		26521	.1960	#9	4.978	4"	2"	1.408"	65.32	62.48	59.64	56.80
22170			.1969		5.000	61	25	16	55.00	52.61	50.22	47.83
	25526		.1969		5.000	75	33	26	58.96	56.40	53.83	51.27
		26526	.1969		5.000	100	50	36	65.78	62.92	60.06	57.20
22175			.1990	#8	5.055	2-13/32"	1"	.633"	55.51	53.10	50.68	48.27
	25531		.1990	#8	5.055	3"	1-5/16"	1.031"	59.26	56.68	54.11	51.53
		26531	.1990	#8	5.055	4"	2"	1.429"	66.11	63.24	60.36	57.49
22180			.2010	#7	5.105	2-13/32"	1"	.640"	55.67	53.25	50.83	48.41
	25536		.2010	#7	5.105	3"	1-5/16"	1.042"	59.52	56.94	54.35	51.76
		26536	.2010	#7	5.105	4"	2"	1.444"	66.41	63.53	60.64	57.75
22185			.2031	13/64"	5.159	2-13/32"	1"	.646"	56.04	53.60	51.17	48.73
	25541		.2031	13/64"	5.159	3"	1-5/16"	1.053"	59.96	57.35	54.75	52.14
		26541	.2031	13/64"	5.159	4"	2"	1.459"	66.91	64.00	61.09	58.18
22190			.2040	#6	5.182	2-13/32"	1"	.649"	56.43	53.98	51.52	49.07
	25546		.2040	#6	5.182	3"	1-3/8"	1.057"	60.41	57.78	55.16	52.53
		26546	.2040	#6	5.182	4"	2"	1.465"	67.39	64.46	61.53	58.60
22195			.2055	#5	5.220	2-13/32"	1"	.654"	56.82	54.35	51.88	49.41
	25551		.2055	#5	5.220	3"	1-3/8"	1.065"	60.80	58.16	55.51	52.87
		26551	.2055	#5	5.220	4"	2"	1.476"	67.85	64.90	61.95	59.00
22200			.2090	#4	5.309	2-13/32"	1"	.665"	57.19	54.70	52.22	49.73
	25556		.2090	#4	5.309	3"	1-3/8"	1.083"	61.23	58.56	55.90	53.24
		26556	.2090	#4	5.309	4"	2"	1.501"	68.30	65.33	62.36	59.39
22205			.2130	#3	5.410	2-5/8"	1-3/32"	.678"	57.57	55.07	52.56	50.06
	25561		.2130	#3	5.410	3"	1-3/8"	1.104"	61.62	58.94	56.26	53.58
		26561	.2130	#3	5.410	4"	2"	1.530"	68.76	65.77	62.78	59.79
22210			.2165		5.500	67	28	18	57.94	55.42	52.90	50.38
	25566		.2165		5.500	75	35	29	62.00	59.30	56.61	53.91
		26566	.2165		5.500	100	50	40	69.17	66.17	63.16	60.15
22215			.2188	7/32"	5.558	2-5/8"	1-3/32"	.696"	58.42	55.88	53.34	50.80
	25571		.2188	7/32"	5.558	3"	1-3/8"	1.134"	62.13	59.43	56.73	54.03
		26571	.2188	7/32"	5.558	4"	2"	1.571"	69.59	66.56	63.54	60.51
22220			.2210	#2	5.613	2-5/8"	1-3/32"	.703"	58.83	56.28	53.72	51.16
	25576		.2210	#2	5.613	3"	1-3/8"	1.145"	63.19	60.45	57.70	54.95
		26576	.2210	#2	5.613	4"	2"	1.587"	70.68	67.61	64.53	61.46
22225			.2280	#1	5.791	2-5/8"	1-3/32"	.726"	59.27	56.69	54.12	51.54
	25581		.2280	#1	5.791	3"	1-3/8"	1.182"	63.42	60.67	57.91	55.15
		26581	.2280	#1	5.791	4-1/8"	2-1/8"	1.638"	80.98	77.46	73.94	70.42
22230			.2340	A	5.944	2-5/8"	1-3/32"	.745"	59.70	57.10	54.51	51.91
	25586		.2340	A	5.944	3-1/4"	1-1/2"	1.213"	71.17	68.08	64.98	61.89
		26586	.2340	A	5.944	4-1/8"	2-1/8"	1.681"	85.50	81.79	78.07	74.35
22235			.2344	15/64"	5.954	2-5/8"	1-3/32"	.746"	60.13	57.52	54.90	52.29
	25591		.2344	15/64"	5.954	3-1/4"	1-1/2"	1.215"	71.30	68.20	65.10	62.00
		26591	.2344	15/64"	5.954	4-1/8"	2-1/8"	1.684"	85.63	81.91	78.18	74.46
22240			.2362		6.000	67	28	19	60.57	57.94	55.30	52.67
	25596		.2362		6.000	80	38	31	71.50	68.39	65.28	62.17
		26596	.2362		6.000	105	55	43	85.82	82.09	78.36	74.63
22245			.2380	B	6.045	2-3/4"	1-7/32"	.757"	63.97	61.19	58.41	55.63
	25601		.2380	B	6.045	3-1/4"	1-5/8"	1.233"	73.76	70.55	67.35	64.14
		26601	.2380	B	6.045	4-1/8"	2-1/8"	1.709"	89.07	85.20	81.32	77.45
22250			.2420	C	6.147	2-3/4"	1-7/32"	.770"	64.50	61.70	58.89	56.09
	25606		.2420	C	6.147	3-1/4"	1-5/8"	1.254"	74.11	70.88	67.66	64.44
		26606	.2420	C	6.147	4-1/4"	2-1/4"	1.738"	89.41	85.53	81.64	77.75

continued →

Series 1580KH, 1280KH, 1880KH (continued)

.2460" - .3125"
(6.248mm - 7.938mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	d^{\dagger} Diameter		l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth	1-11	12-24	25-49	50-100	
			Decimal	Metric								
22255	25611	26611	.2460	D	6.248	2-3/4"	1-7/32"	.783"	64.86	62.04	59.22	56.40
			.2460	D	6.248	3-1/4"	1-5/8"	1.275"	74.43	71.19	67.96	64.72
			.2460	D	6.248	4-1/4"	2-1/4"	1.767"	89.75	85.84	81.94	78.04
22260	25616	26616	.2500	1/4" / E	6.350	2-3/4"	1-7/32"	.796"	65.40	62.56	59.71	56.87
			.2500	1/4" / E	6.350	3-1/4"	1-5/8"	1.296"	74.75	71.50	68.25	65.00
			.2500	1/4" / E	6.350	4-1/4"	2-1/4"	1.796"	90.07	86.15	82.24	78.32
22265	25621	26621	.2559		6.500	70	31	21	66.47	63.58	60.69	57.80
			.2559		6.500	80	41	34	75.67	72.38	69.09	65.80
			.2559		6.500	105	58	47	91.01	87.05	83.10	79.14
22270	25626	26626	.2570	F	6.528	2-3/4"	1-7/32"	.818"	67.49	64.56	61.62	58.69
			.2570	F	6.528	3-1/4"	1-11/16"	1.332"	77.42	74.05	70.69	67.32
			.2570	F	6.528	4-3/8"	2-3/8"	1.846"	94.51	90.40	86.29	82.18
22275	25631	26631	.2610	G	6.629	2-3/4"	1-7/32"	.831"	68.52	65.54	62.56	59.58
			.2610	G	6.629	3-1/2"	1-11/16"	1.353"	78.37	74.97	71.56	68.15
			.2610	G	6.629	4-3/8"	2-3/8"	1.875"	95.48	91.33	87.18	83.03
22280	25636	26636	.2656	17/64"	6.746	2-15/16"	1-11/32"	.845"	69.58	66.55	63.53	60.50
			.2656	17/64"	6.746	3-1/2"	1-11/16"	1.376"	79.28	75.83	72.39	68.94
			.2656	17/64"	6.746	4-3/8"	2-3/8"	1.908"	96.40	92.21	88.02	83.83
22285	25641	26641	.2660	H	6.756	2-15/16"	1-11/32"	.846"	70.60	67.53	64.46	61.39
			.2660	H	6.756	3-1/2"	1-11/16"	1.378"	80.22	76.74	73.25	69.76
			.2660	H	6.756	4-3/8"	2-3/8"	1.910"	97.42	93.18	88.95	84.71
22290	25646	26646	.2720	I	6.909	2-15/16"	1-11/32"	.866"	71.63	68.52	65.40	62.29
			.2720	I	6.909	3-1/2"	1-11/16"	1.410"	80.33	76.84	73.34	69.85
			.2720	I	6.909	4-3/8"	2-3/8"	1.954"	97.51	93.27	89.03	84.79
22295	25651	26651	.2756		7.000	75	34	22	72.67	69.51	66.35	63.19
			.2756		7.000	88	43	36	81.24	77.70	74.17	70.64
			.2756		7.000	110	61	50	98.44	94.16	89.88	85.60
22300	25656	26656	.2770	J	7.036	2-15/16"	1-11/32"	.881"	73.67	70.47	67.26	64.06
			.2770	J	7.036	3-1/2"	1-11/16"	1.435"	85.34	81.63	77.92	74.21
			.2770	J	7.036	4-3/8"	2-3/8"	1.989"	103.42	98.92	94.43	89.93
22305	25661	26661	.2810	K	7.137	2-15/16"	1-11/32"	.894"	74.77	71.52	68.27	65.02
			.2810	K	7.137	3-1/2"	1-3/4"	1.456"	86.30	82.54	78.79	75.04
			.2810	K	7.137	4-7/16"	2-7/16"	2.018"	104.40	99.86	95.32	90.78
22310	25666	26666	.2812	9/32"	7.142	2-15/16"	1-11/32"	.895"	75.81	72.51	69.22	65.92
			.2812	9/32"	7.142	3-1/2"	1-3/4"	1.457"	87.23	83.44	79.64	75.85
			.2812	9/32"	7.142	4-7/16"	2-7/16"	2.020"	105.36	100.78	96.20	91.62
22315	25671	26671	.2900	L	7.366	2-15/16"	1-11/32"	.923"	76.82	73.48	70.14	66.80
			.2900	L	7.366	3-1/2"	1-3/4"	1.503"	87.62	83.81	80.00	76.19
			.2900	L	7.366	4-7/16"	2-7/16"	2.083"	105.77	101.17	96.57	91.97
22320	25676	26676	.2950	M	7.493	2-15/16"	1-11/32"	.939"	78.30	74.90	71.49	68.09
			.2950	M	7.493	3-3/4"	1-3/4"	1.529"	88.14	84.30	80.47	76.64
			.2950	M	7.493	4-7/16"	2-7/16"	2.119"	106.28	101.66	97.04	92.42
22325	25681	26681	.2953		7.500	75	34	24	78.30	74.90	71.49	68.09
			.2953		7.500	95	44	39	88.14	84.30	80.47	76.64
			.2953		7.500	115	66	54	106.28	101.66	97.04	92.42
22330	25686	26686	.2969	19/64"	7.541	3-3/32"	1-15/32"	.945"	78.97	75.54	72.10	68.67
			.2969	19/64"	7.541	3-3/4"	1-7/8"	1.539"	94.15	90.06	85.96	81.87
			.2969	19/64"	7.541	4-9/16"	2-9/16"	2.132"	114.75	109.76	104.77	99.78
22335	25691	26691	.3020	N	7.671	3-3/32"	1-15/32"	.961"	82.55	78.96	75.37	71.78
			.3020	N	7.671	3-3/4"	1-7/8"	1.565"	96.27	92.08	87.90	83.71
			.3020	N	7.671	4-9/16"	2-9/16"	2.169"	116.97	111.88	106.80	101.71
22340	25696	26696	.3125	5/16"	7.938	3-3/32"	1-15/32"	.994"	82.83	79.23	75.63	72.03
			.3125	5/16"	7.938	3-3/4"	1-7/8"	1.619"	96.49	92.29	88.10	83.90
			.3125	5/16"	7.938	4-11/16"	2-9/16"	2.244"	117.17	112.08	106.98	101.89

TOLERANCES

<i>d</i>	+.0000" - .0005" (+.0000 - .0127mm)	
<i>l1</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)
<i>l2</i>	≤ 1/8"	+.125" - .062" (+3.175 - 1.588mm)
	> 1/8"	+.125" - .125" (+3.175 - 3.175mm)



**TECH
PAGES
332-333**

Series 1580KH, 1280KH, 1880KH (continued)

.3150" - .3750"
(8.000mm - 9.525mm)

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

BALIQ® ALTINOS Coating (AlTiN-based)

High performance - high penetration solid submicron grain carbide drill



**HIGH PERFORMANCE
DRILLS**

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	<i>d</i> † Diameter		<i>l1</i> Overall Length	<i>l2</i> Flute Length	<i>l5</i> Max Drill Depth	1-11	12-24	25-49	50-100
			Decimal	Metric							
22345	25701	26701	.3150	8.000	79	37	25	84.39	80.72	77.05	73.38
			.3150	8.000	95	48	41	100.54	96.17	91.80	87.43
			.3150	8.000	120	69	57	121.37	116.09	110.82	105.54
22350	25706	26706	.3160	O 8.026	3-3/32"	1-15/32"	1.006"	84.39	80.72	77.05	73.38
			.3160	O 8.026	3-3/4"	1-7/8"	1.638"	101.46	97.05	92.64	88.23
			.3160	O 8.026	4-11/16"	2-11/16"	2.270"	123.42	118.05	112.69	107.32
22355	25711	26711	.3230	P 8.204	3-3/32"	1-15/32"	1.028"	85.00	81.30	77.61	73.91
			.3230	P 8.204	3-3/4"	2-3/32"	1.674"	101.73	97.31	92.88	88.46
			.3230	P 8.204	4-11/16"	2-11/16"	2.320"	123.68	118.31	112.93	107.55
22360	25716	26716	.3281	21/64" 8.334	3-3/32"	1-15/32"	1.044"	86.60	82.83	79.07	75.30
			.3281	21/64" 8.334	4"	2-3/32"	1.700"	102.40	97.94	93.49	89.04
			.3281	21/64" 8.334	4-11/16"	2-11/16"	2.356"	124.37	118.97	113.56	108.15
22365	25721	26721	.3320	Q 8.433	3-3/32"	1-15/32"	1.056"	88.14	84.30	80.47	76.64
			.3320	Q 8.433	4"	2-3/32"	1.720"	102.98	98.51	94.03	89.55
			.3320	Q 8.433	4-15/16"	2-15/16"	2.384"	124.99	119.56	114.12	108.69
22370	25726	26726	.3346	8.500	79	37	27	88.49	84.65	80.80	76.95
			.3346	8.500	100	53	44	103.52	99.02	94.52	90.02
			.3346	8.500	125	75	61	125.53	120.08	114.62	109.16
22375	25731	26731	.3390	R 8.611	3-5/16"	1-9/16"	1.079"	90.87	86.92	82.97	79.02
			.3390	R 8.611	4"	2-3/32"	1.757"	106.92	102.27	97.62	92.97
			.3390	R 8.611	4-15/16"	2-15/16"	2.435"	131.47	125.75	120.04	114.32
22380	25736	26736	.3438	11/32" 8.733	3-5/16"	1-9/16"	1.094"	92.87	88.84	84.80	80.76
			.3438	11/32" 8.733	4"	2-3/16"	1.782"	109.55	104.79	100.02	95.26
			.3438	11/32" 8.733	4-15/16"	2-15/16"	2.470"	134.26	128.43	122.59	116.75
22385	25741	26741	.3480	S 8.839	3-5/16"	1-9/16"	1.107"	95.94	91.77	87.60	83.43
			.3480	S 8.839	4"	2-3/16"	1.803"	112.03	107.16	102.29	97.42
			.3480	S 8.839	5"	3"	2.499"	136.82	130.87	124.92	118.97
22390	25746	26746	.3543	9.000	84	40	29	98.39	94.12	89.84	85.56
			.3543	9.000	100	56	47	112.49	107.60	102.71	97.82
			.3543	9.000	125	77	65	137.32	131.35	125.38	119.41
22395	25751	26751	.3580	T 9.093	3-5/16"	1-9/16"	1.139"	102.26	97.81	93.37	88.92
			.3580	T 9.093	4-1/4"	2-9/32"	1.855"	114.62	109.64	104.65	99.67
			.3580	T 9.093	5"	3"	2.571"	144.35	138.07	131.80	125.52
22400	25756	26756	.3594	23/64" 9.129	3-5/16"	1-9/16"	1.144"	102.88	98.41	93.93	89.46
			.3594	23/64" 9.129	4-1/4"	2-9/32"	1.862"	115.06	110.06	105.05	100.05
			.3594	23/64" 9.129	5"	3"	2.581"	144.85	138.56	132.26	125.96
22405	25761	26761	.3680	U 9.347	3-5/16"	1-9/16"	1.171"	104.43	99.89	95.35	90.81
			.3680	U 9.347	4-1/4"	2-9/32"	1.907"	121.96	116.66	111.35	106.05
			.3680	U 9.347	5"	3"	2.643"	153.26	146.60	139.93	133.27
22410	25766	26766	.3740	9.500	84	40	30	105.27	100.69	96.12	91.54
			.3740	9.500	105	58	49	122.56	117.23	111.90	106.57
			.3740	9.500	130	80	68	154.22	147.51	140.81	134.10
22415	25771	26771	.3750	3/8" 9.525	3-1/2"	1-11/16"	1.193"	105.92	101.31	96.71	92.10
			.3750	3/8" 9.525	4-1/4"	2-3/8"	1.943"	125.59	120.13	114.67	109.21
			.3750	3/8" 9.525	5-1/8"	3-1/8"	2.693"	158.29	151.40	144.52	137.64

continued →

Series 1580KH, 1280KH, 1880KH (continued)

.3770" - .4921"
(9.576mm - 12.500mm)

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	d^{\dagger} Diameter		l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth	1-11	12-24	25-49	50-100	
			Decimal	Metric								
22420			.3770	V	9.576	3-1/2"	1-11/16"	1.200"	109.99	105.20	100.42	95.64
	25776		.3770	V	9.576	4-1/4"	2-3/8"	1.954"	126.01	120.53	115.05	109.57
		26776	.3770	V	9.576	5-1/8"	3-1/8"	2.708"	160.78	153.79	146.80	139.81
22425			.3860	W	9.804	3-1/2"	1-11/16"	1.228"	111.91	107.04	102.18	97.31
	25781		.3860	W	9.804	4-1/2"	2-3/8"	2.000"	127.39	121.85	116.31	110.77
		26781	.3860	W	9.804	5-1/8"	3-1/8"	2.772"	161.33	154.32	147.30	140.29
22430			.3906	25/64"	9.921	3-1/2"	1-11/16"	1.243"	113.31	108.38	103.46	98.53
	25786		.3906	25/64"	9.921	4-1/2"	2-3/8"	2.024"	128.34	122.76	117.18	111.60
		26786	.3906	25/64"	9.921	5-1/4"	3-1/4"	2.805"	162.31	155.25	148.20	141.14
22435			.3937		10.000	89	43	32	113.71	108.77	103.82	98.88
	25791		.3937		10.000	115	60	52	129.51	123.88	118.25	112.62
		26791	.3937		10.000	135	83	72	165.51	158.31	151.12	143.92
22440			.3970	X	10.084	3-1/2"	1-11/16"	1.263"	114.71	109.73	104.74	99.75
	25796		.3970	X	10.084	4-1/2"	2-1/2"	2.057"	133.92	128.10	122.27	116.45
		26796	.3970	X	10.084	5-1/4"	3-1/4"	2.851"	169.20	161.84	154.49	147.13
22445			.4040	Y	10.262	3-1/2"	1-11/16"	1.286"	115.49	110.47	105.45	100.43
	25801		.4040	Y	10.262	4-1/2"	2-9/16"	2.094"	134.52	128.67	122.82	116.97
		26801	.4040	Y	10.262	5-3/8"	3-3/8"	2.902"	172.55	165.04	157.54	150.04
22450			.4062	13/32"	10.317	3-1/2"	1-11/16"	1.293"	119.04	113.86	108.69	103.51
	25806		.4062	13/32"	10.317	4-1/2"	2-9/16"	2.105"	137.10	131.14	125.18	119.22
		26806	.4062	13/32"	10.317	5-3/8"	3-3/8"	2.917"	173.52	165.98	158.43	150.89
22455			.4130	Z	10.490	3-1/2"	1-11/16"	1.314"	120.14	114.92	109.69	104.47
	25811		.4130	Z	10.490	4-1/2"	2-5/8"	2.140"	139.25	133.20	127.14	121.09
		26811	.4130	Z	10.490	5-3/8"	3-3/8"	2.966"	176.40	168.73	161.06	153.39
22460			.4134		10.500	89	43	33	120.14	114.92	109.69	104.47
	25816		.4134		10.500	115	67	54	139.25	133.20	127.14	121.09
		26816	.4134		10.500	135	86	75	176.40	168.73	161.06	153.39
22465			.4219	27/64"	10.716	3-3/4"	1-13/16"	1.343"	121.27	116.00	110.72	105.45
	25821		.4219	27/64"	10.716	4-1/2"	2-11/16"	2.186"	141.22	135.08	128.94	122.80
		26821	.4219	27/64"	10.716	5-7/16"	3-7/16"	3.030"	178.60	170.83	163.07	155.30
22470			.4331		11.000	95	46	35	130.16	124.50	118.84	113.18
	25826		.4331		11.000	115	68	57	146.30	139.94	133.58	127.22
		26826	.4331		11.000	135	88	79	185.51	177.44	169.38	161.31
22475			.4375	7/16"	11.113	3-3/4"	1-13/16"	1.392"	130.16	124.50	118.84	113.18
	25831		.4375	7/16"	11.113	4-3/4"	2-13/16"	2.267"	149.26	142.77	136.28	129.79
		26831	.4375	7/16"	11.113	5-7/16"	3-7/16"	3.142"	189.47	181.24	173.00	164.76
22480			.4528		11.500	95	46	37	139.73	133.65	127.58	121.50
	25836		.4528		11.500	120	71	60	154.59	147.87	141.15	134.43
		26836	.4528		11.500	140	91	83	196.20	187.67	179.14	170.61
22485			.4531	29/64"	11.509	3-3/4"	1-13/16"	1.442"	139.73	133.65	127.58	121.50
	25841		.4531	29/64"	11.509	4-3/4"	2-7/8"	2.348"	159.88	152.93	145.98	139.03
		26841	.4531	29/64"	11.509	5-9/16"	3-13/16"	3.254"	202.34	193.55	184.75	175.95
22490			.4688	15/32"	11.908	4"	1-15/16"	1.492"	146.81	140.43	134.04	127.66
	25846		.4688	15/32"	11.908	4-3/4"	2-7/8"	2.429"	163.53	156.42	149.31	142.20
		26846	.4688	15/32"	11.908	5-9/16"	3-13/16"	3.367"	207.40	198.39	189.37	180.35
22495			.4724		12.000	102	49	38	147.25	140.84	134.44	128.04
	25851		.4724		12.000	120	73	62	167.05	159.79	152.52	145.26
		26851	.4724		12.000	140	98	86	212.73	203.48	194.23	184.98
22500			.4844	31/64"	12.304	4"	1-15/16"	1.541"	156.25	149.46	142.66	135.87
	25856		.4844	31/64"	12.304	5-5/16"	3"	2.510"	174.28	166.71	159.13	151.55
		26856	.4844	31/64"	12.304	5-9/16"	3-13/16"	3.479"	218.26	208.77	199.28	189.79
22505			.4921		12.500	102	49	40	164.69	157.53	150.37	143.21
	25861		.4921		12.500	135	76	65	187.07	178.94	170.80	162.67
		26861	.4921		12.500	150	102	90	219.47	209.92	200.38	190.84

Series 1580KH, 1280KH, 1880KH (continued)

.5000" - .6299"
(12.700mm - 16.000mm)

HIGH PERFORMANCE
DRILLS

3xD (1580KH) EDP#	5xD (1280KH) EDP#	7xD (1880KH) EDP#	d^+ Diameter		l_1 Overall Length	l_2 Flute Length	l_5 Max Drill Depth	1-11	12-24	25-49	50-100	
			Decimal	Metric								
22510			.5000	1/2"	12.700	4"	1-15/16"	1.591"	165.73	158.52	151.32	144.11
	25866		.5000	1/2"	12.700	5-3/8"	3-1/16"	2.591"	188.84	180.63	172.42	164.21
		26866	.5000	1/2"	12.700	6"	4"	3.591"	220.26	210.68	201.11	191.53
22515			.5118		13.000	107	53	41	183.95	175.96	167.96	159.96
	25871		.5118		13.000	135	78	67	214.15	204.84	195.53	186.22
		26871	.5118		13.000	150	102	93	230.59	220.56	210.54	200.51
22520			.5156	33/64"	13.096	4-7/32"	2-3/32"	1.641"	188.31	180.13	171.94	163.75
	25876		.5156	33/64"	13.096	5-3/8"	3-1/8"	2.672"	223.22	213.51	203.81	194.10
		26876	.5156	33/64"	13.096	6"	4"	3.703"	240.29	229.85	219.40	208.95
22525			.5312	17/32"	13.492	4-7/32"	2-3/32"	1.690"	192.63	184.25	175.88	167.50
	25881		.5312	17/32"	13.492	5-11/16"	3-5/16"	2.753"	226.81	216.95	207.09	197.23
		26881	.5312	17/32"	13.492	6-1/8"	4-1/8"	3.815"	244.19	233.57	222.96	212.34
22530			.5315		13.500	110	56	43	196.98	188.42	179.85	171.29
	25886		.5315		13.500	145	84	70	230.31	220.30	210.28	200.27
		26886	.5315		13.500	155	105	97	247.96	237.18	226.40	215.62
22535			.5469	35/64"	13.891	4-5/16"	2-7/32"	1.740"	201.28	192.53	183.78	175.03
	25891		.5469	35/64"	13.891	5-13/16"	3-3/8"	2.834"	242.93	232.36	221.80	211.24
		26891	.5469	35/64"	13.891	6-1/8"	4-1/8"	3.928"	255.71	244.60	233.48	222.36
22540			.5512		14.000	110	56	45	205.65	196.71	187.77	178.83
	25896		.5512		14.000	145	86	73	246.49	235.77	225.06	214.34
		26896	.5512		14.000	155	105	101	259.49	248.20	236.92	225.64
22545			.5625	9/16"	14.288	4-9/16"	2-15/32"	1.790"	227.68	217.78	207.88	197.98
	25901		.5625	9/16"	14.288	5-15/16"	3-1/2"	2.915"	265.56	254.01	242.47	230.92
		26901	.5625	9/16"	14.288	6-1/4"	4-3/8"	4.040"	280.15	267.97	255.79	243.61
22550			.5709		14.500	116	63	46	231.98	221.89	211.81	201.72
	25906		.5709		14.500	150	89	75	267.66	256.03	244.39	232.75
		26906	.5709		14.500	160	109	104	282.37	270.09	257.82	245.54
22555			.5781	37/64"	14.684	4-15/16"	2-9/16"	1.840"	236.12	225.85	215.59	205.32
	25911		.5781	37/64"	14.684	6"	3-1/2"	2.996"	268.40	256.73	245.06	233.39
		26911	.5781	37/64"	14.684	6-1/4"	4-3/8"	4.152"	283.13	270.82	258.51	246.20
22560			.5906		15.000	125	65	48	240.45	230.00	219.54	209.09
	25916		.5906		15.000	150	90	78	271.88	260.06	248.24	236.42
		26916	.5906		15.000	160	112	108	286.81	274.34	261.87	249.40
22565			.5938	19/32"	15.083	4-15/16"	2-9/16"	1.890"	241.78	231.26	220.75	210.24
	25921		.5938	19/32"	15.083	6"	3-9/16"	3.077"	278.97	266.84	254.71	242.58
		26921	.5938	19/32"	15.083	6-3/8"	4-3/8"	4.265"	294.26	281.47	268.67	255.88
22570			.6094	39/64"	15.479	5-1/16"	2-13/16"	1.939"	242.97	232.41	221.84	211.28
	25926		.6094	39/64"	15.479	6-3/16"	3-11/16"	3.158"	313.95	300.30	286.65	273.00
		26926	.6094	39/64"	15.479	6-7/16"	4-7/16"	4.377"	331.13	316.73	302.34	287.94
22575			.6102		15.500	129	71	49	244.24	233.62	223.00	212.38
	25931		.6102		15.500	160	94	80	314.81	301.13	287.44	273.75
		26931	.6102		15.500	165	113	111	332.07	317.64	303.20	288.76
22580			.6250	5/8"	15.875	5-1/4"	3-1/8"	1.989"	245.44	234.77	224.10	213.43
	25936		.6250	5/8"	15.875	6-5/16"	3-3/4"	3.239"	323.50	309.43	295.37	281.30
		26936	.6250	5/8"	15.875	6-9/16"	4-9/16"	4.489"	341.26	326.43	311.59	296.75
22585			.6299		16.000	133	79	51	251.39	240.46	229.53	218.60
	25941		.6299		16.000	160	95	83	327.74	313.49	299.24	284.99
		26941	.6299		16.000	165	117	115	345.74	330.70	315.67	300.64