EDP #	Size mm	Decimal Equivalent	Flute Length	Neck Length	Overall Length	Shank Diameter
		Dc	ℓ	L1	L	Ds
0788822	1.31	0.0516	16.2	20.3	45	3
0788839	1.32	0.0520				
0788845	1.33	0.0524				
0788851	1.34	0.0528				
0788868	1.35	0.0531				
0788874	1.36	0.0535	16.8	20.8		
0788880	1.37	0.0539				
0788897	1.38	0.0543				
0788902	1.39	0.0547				
0788919	1.40	0.0551				
0788925	1.41	0.0555	17.4	21.3		
0788931	1.42	0.0559				
0788948	1.43	0.0563				
0788954	1.44	0.0567				
0788960	1.45	0.0571				
0788977	1.46	0.0575	18.0	21.8		
0788983	1.47	0.0579				
0788990	1.48	0.0583				
0789004	1.49	0.0587				
0789010	1.50	0.0591				
0789027	1.51	0.0594	18.6	22.3	50	
0789033	1.52	0.0598				
0789040	1.53	0.0602				
0789056	1.54	0.0606				
0789062	1.55	0.0610				
0789079	1.56	0.0614	19.2	22.8		
0789085	1.57	0.0618				
0789091	1.58	0.0622				
0789107	1.59	0.0626				
0789113	1.60	0.0630				
0789120	1.61	0.0634	19.8	23.3		
0789136	1.62	0.0638				
0789142	1.63	0.0642				
0789159	1.64	0.0646				
0789165	1.65	0.0650				

EDP #	Size mm	Decimal Equivalent	Flute Length	Neck Length	Overall Length	Shank Diameter
		Dc	ℓ	L1	L	Ds
0789171	1.66	0.0654	20.4	23.8	50	3
0789188	1.67	0.0657				
0789194	1.68	0.0661				
0789200	1.69	0.0665				
0789216	1.70	0.0669				
0789222	1.71	0.0673	21.0	24.3		
0789239	1.72	0.0677				
0789245	1.73	0.0681				
0789251	1.74	0.0685				
0789268	1.75	0.0689				
0789274	1.76	0.0693	21.6	24.8		
0789280	1.77	0.0697				
0789297	1.78	0.0701				
0789302	1.79	0.0705				
0789319	1.80	0.0709				
0789325	1.81	0.0713	22.2	25.3		
0789331	1.82	0.0717				
0789348	1.83	0.0720				
0789354	1.84	0.0724				
0789360	1.85	0.0728				
0789377	1.86	0.0732	22.8	25.9		
0789383	1.87	0.0736				
0789390	1.88	0.0740				
0789405	1.89	0.0744				
0789411	1.90	0.0748				
0789428	1.91	0.0752	23.4	26.4		
0789434	1.92	0.0756				
0789440	1.93	0.0760				
0789457	1.94	0.0764				
0789463	1.95	0.0768				
0789470	1.96	0.0772	23.9	26.8		
0789486	1.97	0.0776				
0789492	1.98	0.0780				
0789508	1.99	0.0783				

*Tolerance of diameter is 0 to -0.009mm.
**Point angle is 120° for diameters 0.50 to 1.09mm or less and 135° for diameters over 1.09 to 1.99mm.

LIST 9880 Standard Wet Cutting Conditions

Work Material	Carbon Steel, Cast Iron (200 HB)		Alloy Steel (20 - 30 HRC)		Mold Steel (30 - 40 HRC)		Hardened Steel (40 - 55 HRC)		Ductile Cast Iron		Stainless Steel		PH Stainless		Aluminum Alloy	
Drill Diam. mm	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
0.5	25500	0.0012	19100	0.0008	15900	0.0008	12750	0.0008	12600	0.0008	5600	0.0007	5600	0.0007	30000	0.0012
1	15000	0.0024	9900	0.0016	8500	0.0016	7500	0.0016	9900	0.0016	4200	0.0011	4200	0.0009	25000	0.0024
1.1	15000	0.0026	9900	0.0017	8500	0.0017	7500	0.0017	9900	0.0017	4100	0.0012	4100	0.0010	25000	0.0026
1.6	11940	0.0038	7900	0.0025	7000	0.0025	6000	0.0025	7900	0.0025	4000	0.0013	3200	0.0012	20000	0.0038
1.9	10050	0.0045	6700	0.0030	5900	0.0030	5030	0.0030	6700	0.0030	3350	0.0015	2700	0.0015	16760	0.0045

1. Adjust cutting condition according to the rigidity of the machine and work holding
2. If the machine you are using has rotation limitations, reduce the rotation and feed rate by the same ratio.
3. Wet condition refers to drilling with water soluble content.
4. In non-water coluble coolant, reduce the rotation and feed rate by 20%.
5. Please use pecking regardless of the hole depth.
6. Retract plane for pecking should return to the top of the hole.
7. Recommended peck increment is 0.2-0.5 x Dc.
8. Direct flood coolant along the work piece and not directly at the drill.