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Deep Hole Parabolic Styles 120DH, 120DH-TN (120DHT)

Features/Benefits:

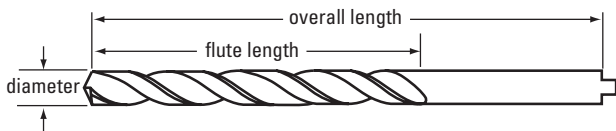
- Parabolic flute configuration with proprietary Convolute flute design offers wider flute space, dispersing chips away from the cutting edges more rapidly and increasing coolant flow.
- Engineered for deep-hole drilling up to 8 to 12 X diameter depth, depending on drill diameter.
- Manufactured from premium high-speed steel.
- 135° split point is self-centering, and uses reduced thrust for easier penetration.
- Tanged shank; see page 73 for tang specifications.
- TiN and bright finishes standard from stock; alternate coatings available as stock modifications.

Application Information:

- low carbon steel (TiN, bright)
- soft alloy steel (TiN, bright)
- aluminum (TiCN as a modification)
- non-ferrous materials (bright)

Surface Treatment Information

- Bright finish provides good chip ejection.
- Titanium-nitride (TiN) coating adds lubricity and hardness, enhancing chip flow, finished hole quality, and drill life.



INCH SIZES

Drill Diameter		Overall Length				Flute Length		Style 120DH	Style 120DH-TN
Fraction	Wire/Let	Decimal	mm	Inch	mm	Inch	mm	Bright	TiN
1/16		.0625	1.59	3.0000	76.20	2.0000	50.80	68804	55236
5/64		.0781	1.98	3.7500	95.25	2.2500	57.15	68805	55237
3/32		.0938	2.38	4.2500	107.95	2.2500	57.15	68806	55238
	41	.0960	2.44	4.6250	117.48	3.1250	79.38	68881	—
	40	.0980	2.49	4.6250	117.48	3.1250	79.38	68880	—
	38	.1015	2.58	4.6250	117.48	3.1250	79.38	68878	—
	37	.1040	2.64	4.6250	117.48	3.1250	79.38	68877	—
	36	.1065	2.71	4.6250	117.48	3.1250	79.38	68876	—
7/64		.1094	2.78	4.6250	117.48	3.1250	79.38	68807	55239
	33	.1130	2.87	5.1250	130.18	3.6250	92.08	68873	—
1/8		.1250	3.18	5.1250	130.18	3.3750	85.73	68808	55240
	30	.1285	3.26	5.3750	136.53	3.6250	92.08	68870	—
	29	.1360	3.45	5.3750	136.53	3.6250	92.08	68869	—
9/64		.1406	3.57	5.3750	136.53	3.6250	92.08	68809	55241
	26	.1470	3.73	5.3750	136.53	3.7500	95.25	68866	—
	25	.1495	3.80	5.3750	136.53	3.7500	95.25	68865	—
5/32		.1562	3.97	5.3750	136.53	3.7500	95.25	68810	55242

continued on next page

Deep Hole Parabolic (continued)
Styles 120DH, 120DH-TN (120DHT)

INCH SIZES

Drill Diameter		Decimal	mm	Inch	Overall Length		Flute Length		Style 120DH	Style 120DH-TN
Fraction	Wire/Let				mm	Inch	mm	Inch	mm	Bright
	21	.1590	4.04	5.7500	146.05	4.1250	104.78	68861	—	
	20	.1610	4.09	5.7500	146.05	4.1250	104.78	68860	—	
11/64		.1719	4.37	5.7500	146.05	4.1250	104.78	68811	55243	
	16	.1770	4.50	5.7500	146.05	4.1250	104.78	68856	—	
	15	.1800	4.57	5.7500	146.05	4.1250	104.78	68855	—	
3/16		.1875	4.76	5.7500	146.05	4.1250	104.78	68812	55244	
	10	.1935	4.91	6.0000	152.40	4.3750	111.13	68850	—	
	9	.1960	4.98	6.0000	152.40	4.3750	111.13	68849	—	
	7	.2010	5.11	6.0000	152.40	4.3750	111.13	68847	—	
13/64		.2031	5.16	6.0000	152.40	4.3750	111.13	68813	55245	
	3	.2130	5.41	6.0000	152.40	4.3750	111.13	68843	—	
7/32		.2188	5.56	6.0000	152.40	4.3750	111.13	68814	55246	
15/64		.2344	5.95	6.1250	155.58	4.8125	122.24	68815	55247	
1/4	E	.2500	6.35	6.1250	155.58	4.8125	122.24	68816	55248	
17/64		.2656	6.75	6.2500	158.75	5.0000	127.00	68817	55249	
9/32		.2812	7.14	6.2500	158.75	5.0000	127.00	68818	55250	
19/64		.2969	7.54	6.3750	161.93	5.1250	130.18	68819	55251	
5/16		.3125	7.94	6.3750	161.93	5.1250	130.18	68820	55252	
21/64		.3281	8.33	6.5000	165.10	5.2500	133.35	68821	55253	
11/32		.3438	8.73	6.5000	165.10	5.2500	133.35	68822	55254	
23/64		.3594	9.13	6.7500	171.45	5.3750	136.53	68823	55255	
3/8		.3750	9.53	6.7500	171.45	5.3750	136.53	68824	55256	
25/64		.3906	9.92	7.0000	177.80	5.6250	142.88	68825	55257	
13/32		.4062	10.32	7.0000	177.80	5.6250	142.88	68826	55258	
27/64		.4219	10.72	7.2500	184.15	5.6875	144.46	68827	55259	
7/16		.4375	11.11	7.2500	184.15	5.6875	144.46	68828	55260	
29/64		.4531	11.51	7.5000	190.50	5.7500	146.05	68829	55261	
15/32		.4688	11.91	7.5000	190.50	5.7500	146.05	68830	55262	
31/64		.4844	12.30	7.7500	196.85	5.7500	146.05	68831	55263	
1/2		.5000	12.70	7.7500	196.85	5.7500	146.05	68832	55264	
33/64		.5156	13.10	8.0000	203.20	6.0000	152.40	68833	55265	
17/32		.5312	13.49	8.0000	203.20	6.0000	152.40	68834	55266	
35/64		.5469	13.89	8.2500	209.55	6.2500	158.75	68835	55267	
9/16		.5625	14.29	8.2500	209.55	6.2500	158.75	68836	55268	
37/64		.5781	14.68	8.7500	222.25	6.5000	165.10	68837	55269	
19/32		.5938	15.08	8.7500	222.25	6.5000	165.10	68838	55270	
39/64		.6094	15.48	8.7500	222.25	6.5000	165.10	68839	55271	
5/8		.6250	15.88	8.7500	222.25	6.5000	165.10	68840	55272	

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