

EXPANDED!

Vol. 4



OSG

HY-PRO® CARB
Drills

3D, 5D & 8D* Carbide Drills
Solid & Coolant-Through Available!



**8D
ADDED!**

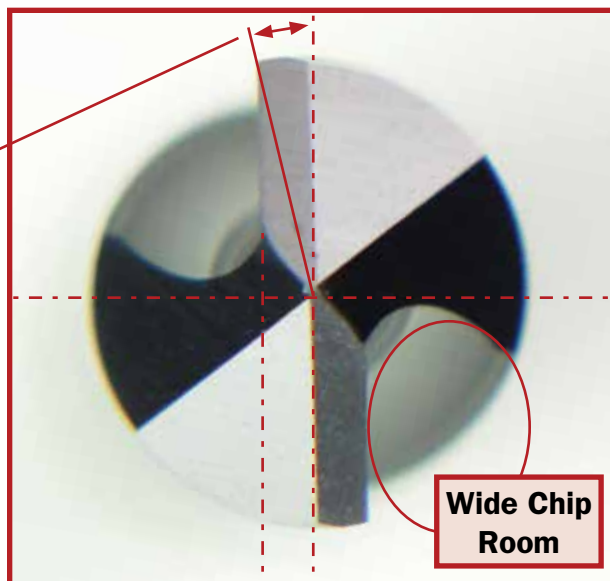
**Available as Coolant-Through Only*

3D, 5D & 8D Carbide Drills

Large Negative Radial Rake

Stronger Cutting Edge

Small Honing Amount



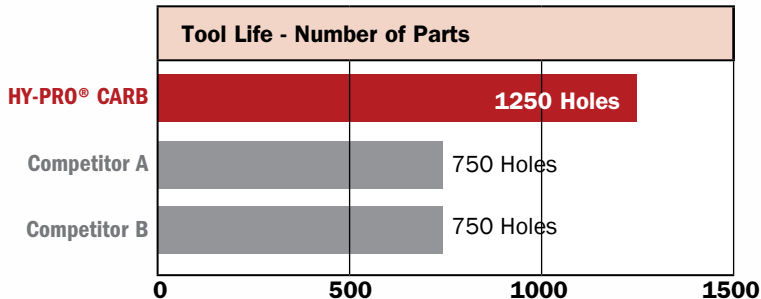
GOOD CHIP EVACUATION
"Small Chips!"



New Design Reduces Thrust Forces and Chip Size

The HY-PRO® CARB's unique flute geometry reduces thrust forces and chip size, enabling it to achieve 1.6 times the durability versus the competitors.

HY-PRO® CARB Drill Performance:	
Tool Ø:	3 mm
Material:	1050 Carbon Steel
Speed:	330 SFM
Feed:	0.0035 IPR
Depth:	12 mm (Through)

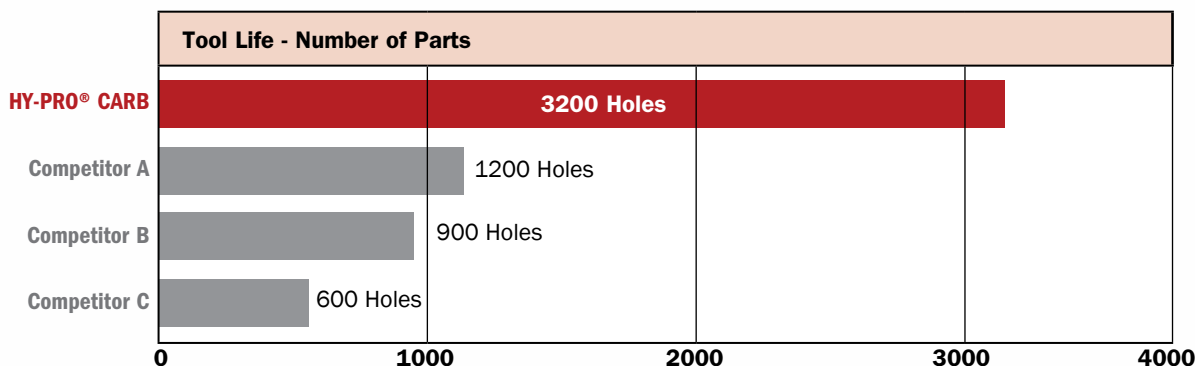
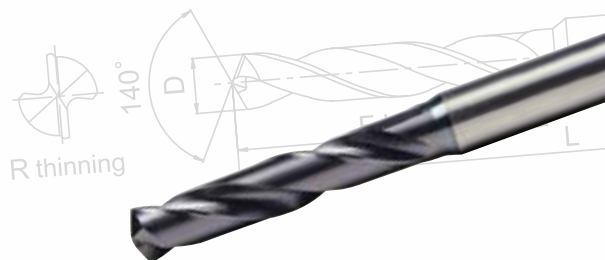


	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	1250	\$0.025	4	\$0.10	100%
Competitor A	750	\$0.030	4	\$0.12	120%
Competitor B	750	\$0.031	4	\$0.12	120%

Multi-Layered TiAlN Coating Resists Thermo-Cracking from Heat

The HY-PRO® CARB's multi-layered TiAlN coating resists thermo-cracking from heat, enabling it to achieve more than 5 times the tool life versus its competition.

HY-PRO® CARB Drill Performance:	
Tool Ø:	3 mm
Material:	4140 Alloy Steel (30 HRC)
Speed:	230 SFM
Feed:	0.0035 IPR
Depth:	12 mm (Through)

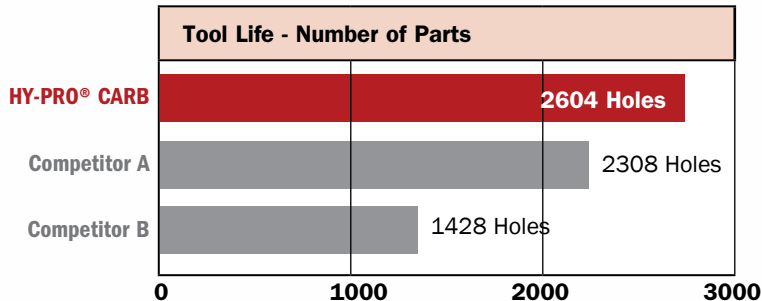


	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	3200	\$0.01	4	\$0.04	100%
Competitor A	1200	\$0.02	4	\$0.08	200%
Competitor B	900	\$0.06	4	\$0.24	600%
Competitor C	600	\$0.04	4	\$0.16	400%

Excels in 1050 Carbon Steel

Due to its low resistance edge form, the HY-PRO® CARB is able to achieve 1.8 times the performance versus its competition.

HY-PRO® CARB Drill Performance:	
Tool Ø:	6 mm
Material:	1050 Carbon Steel
Speed:	330 SFM
Feed:	0.007 IPR
Depth:	20 mm (Through)

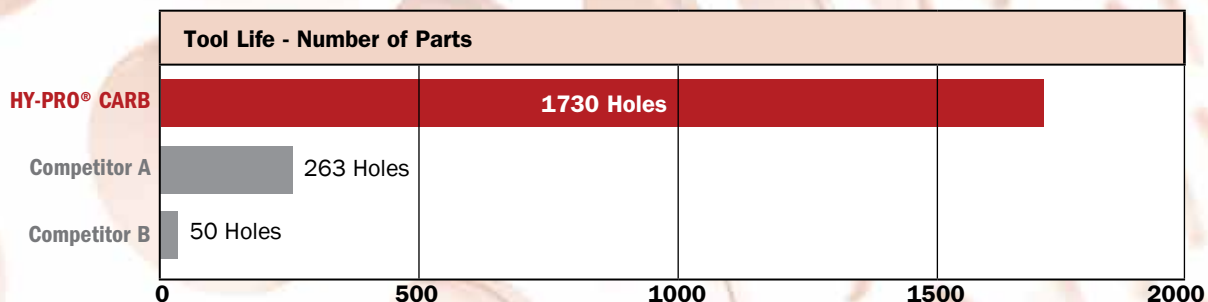


	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	2604	\$0.01	3	\$0.03	100%
Competitor A	2308	\$0.02	3	\$0.06	200%
Competitor B	1428	\$0.04	3	\$0.12	400%

Excellent Performance and Durability Even in 30 HRC!

HY-PRO® CARB Drill Performance:	
Tool Ø:	10 mm
Material:	4140 Alloy Steel (30 HRC)
Speed:	230 SFM
Feed:	0.001 IPR
Depth:	20 mm (Through)

Even in 4140 Alloy Steel (30 HRC), the HY-PRO® CARB is able to achieve more than **30 times** the durability versus its competition!

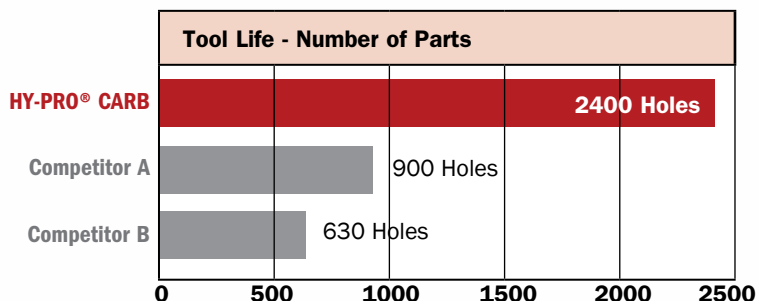


	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	1730	\$0.05	3	\$0.15	100%
Competitor A	263	\$0.39	3	\$1.17	780%
Competitor B	50	\$2.17	3	\$6.51	4340%

New Point and Flute Geometry Improves Performance

The HY-PRO® CARB's tool cost per hole is 5.6 times lower than the competition.

HY-PRO® CARB Drill Performance:	
Tool Ø:	10 mm
Material:	1050 Carbon Steel
Speed:	330 SFM
Feed:	0.001 IPR
Depth:	20 mm (Through)

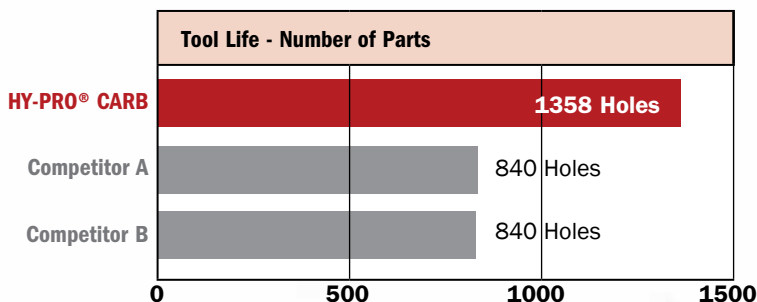


	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	2400	\$0.03	4	\$0.12	100%
Competitor A	900	\$0.11	4	\$0.44	367%
Competitor B	630	\$0.17	4	\$0.68	567%

Stable Performance and Long Tool Life

The HY-PRO® CARB's new flute design and multi-layered coating enable stable performance and long tool life.

HY-PRO® CARB Drill Performance:	
Tool Ø:	6 mm
Material:	4140 Alloy Steel
Speed:	230 SFM
Feed:	0.007 IPR
Depth:	20 mm (Through)



	Tool Life	Tool Cost Per Hole	Number of Holes Per Unit	Tool Cost Per Unit	Cost Ratio
OSG	1358	\$0.03	2	\$0.06	100%
Competitor A	840	\$0.05	2	\$0.10	167%
Competitor B	840	\$0.06	2	\$0.12	200%

3D, 5D & 8D Carbide Drills
Solid & Coolant-Through Available!

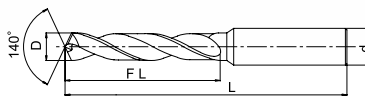
• Available as Coolant-Through Only

HY-PRO® CARB

Sub-Micrograin Carbide Drills

List HP243 EXPANDED*

3D, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
* HP243-0394	—	—	—	1.00	0.0394	7	35	3
* HP243-0433	—	—	—	1.10	0.0433	7	35	3
* HP243-0469	3/64	—	—	1.19	0.0469	8	35	3
* HP243-0472	—	—	—	1.20	0.0472	8	35	3
* HP243-0512	—	—	—	1.30	0.0512	8	35	3
* HP243-0551	—	—	—	1.40	0.0551	9	35	3
* HP243-0591	—	—	—	1.50	0.0591	9	40	3
* HP243-0626	1/16	—	—	1.59	0.0626	10	40	3
* HP243-0630	—	—	—	1.60	0.0630	10	40	3
* HP243-0669	—	—	—	1.70	0.0669	10	40	3
* HP243-0709	—	—	—	1.80	0.0709	11	40	3
* HP243-0748	—	—	—	1.90	0.0748	11	40	3
* HP243-0780	5/64	—	—	1.98	0.0780	13	45	3
* HP243-0787	—	—	—	2.00	0.0787	13	45	3
* HP243-0827	—	—	—	2.10	0.0827	13	45	3
* HP243-0866	—	—	—	2.20	0.0866	13	45	3
* HP243-0906	—	—	—	2.30	0.0906	13	45	3
* HP243-0937	3/32	—	—	2.38	0.0937	15	45	3
* HP243-0945	—	—	—	2.40	0.0945	15	45	3
* HP243-0984	—	—	—	2.50	0.0984	15	50	3
* HP243-1024	—	—	—	2.60	0.1024	15	50	3
* HP243-1063	—	—	—	2.70	0.1063	17	50	3
* HP243-1094	7/64	—	—	2.78	0.1094	17	50	3
* HP243-1102	—	—	—	2.80	0.1102	17	50	3
* HP243-1142	—	—	—	2.90	0.1142	17	50	3
HP243-1181	—	—	—	3.00	0.1181	20	62	6
HP243-1220	—	—	—	3.10	0.1220	20	62	6
HP243-1248	1/8	—	—	3.17	0.1248	20	62	6
HP243-1260	—	—	—	3.20	0.1260	20	62	6
HP243-1299	—	—	—	3.30	0.1299	20	62	6
HP243-1339	—	—	—	3.40	0.1339	20	62	6
HP243-1378	—	—	—	3.50	0.1378	20	62	6
* HP243-1406	9/64	—	—	3.57	0.1406	20	62	6
HP243-1417	—	—	—	3.60	0.1417	20	62	6
HP243-1457	—	—	—	3.70	0.1457	20	62	6
HP243-1496	—	25	—	3.80	0.1496	24	66	6
HP243-1535	—	—	—	3.90	0.1535	24	66	6
HP243-1563	5/32	—	—	3.97	0.1563	24	66	6
HP243-1575	—	—	—	4.00	0.1575	24	66	6
HP243-1610	—	20	—	4.09	0.1610	24	66	6
HP243-1614	—	—	—	4.10	0.1614	24	66	6
HP243-1654	—	—	—	4.20	0.1654	24	66	6
HP243-1693	—	—	—	4.30	0.1693	24	66	6
HP243-1720	11/64	—	—	4.37	0.1720	24	66	6
HP243-1732	—	—	—	4.40	0.1732	24	66	6
HP243-1772	—	16	—	4.50	0.1772	24	66	6
HP243-1811	—	—	—	4.60	0.1811	24	66	6
* HP243-1831	—	—	—	4.65	0.1831	24	66	6
HP243-1850	—	13	—	4.70	0.1850	24	66	6
HP243-1874	3/16	—	—	4.76	0.1874	28	66	6
HP243-1890	—	12	—	4.80	0.1890	28	66	6
HP243-1929	—	—	—	4.90	0.1929	28	66	6
HP243-1969	—	—	—	5.00	0.1969	28	66	6
HP243-2008	—	—	—	5.10	0.2008	28	66	6
HP243-2031	13/64	—	—	5.16	0.2031	28	66	6
HP243-2047	—	—	—	5.20	0.2047	28	66	6
HP243-2087	—	—	—	5.30	0.2087	28	66	6
HP243-2126	—	—	—	5.40	0.2126	28	66	6
HP243-2130	—	3	—	5.41	0.2130	28	66	6
HP243-2165	—	—	—	5.50	0.2165	28	66	6
HP243-2189	7/32	—	—	5.56	0.2189	28	66	6
HP243-2205	—	—	—	5.60	0.2205	28	66	6
HP243-2244	—	—	—	5.70	0.2244	28	66	6
HP243-2283	—	—	—	5.80	0.2283	28	66	6
HP243-2323	—	—	—	5.90	0.2323	28	66	6
HP243-2343	15/64	—	—	5.95	0.2343	28	66	6
HP243-2362	—	—	—	6.00	0.2362	28	66	6

Packed: 1 pc. Available TiAlN coating only.



List HP243 (continued) **EXPANDED***



3D, Solid Carbide

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP243-2402	—	—	—	6.10	0.2402	34	79	8
HP243-2441	—	—	—	6.20	0.2441	34	79	8
HP243-2480	—	—	—	6.30	0.2480	34	79	8
HP243-2500	1/4	—	E	6.35	0.2500	34	79	8
HP243-2520	—	—	—	6.40	0.2520	34	79	8
HP243-2559	—	—	—	6.50	0.2559	34	79	8
HP243-2571	—	—	F	6.53	0.2571	34	79	8
HP243-2598	—	—	—	6.60	0.2598	34	79	8
HP243-2638	—	—	—	6.70	0.2638	34	79	8
HP243-2657	17/64	—	—	6.75	0.2657	34	79	8
HP243-2677	—	—	—	6.80	0.2677	34	79	8
HP243-2717	—	—	I	6.90	0.2717	34	79	8
HP243-2756	—	—	—	7.00	0.2756	34	79	8
HP243-2795	—	—	—	7.10	0.2795	41	79	8
HP243-2811	9/32	—	—	7.14	0.2811	41	79	8
HP243-2835	—	—	—	7.20	0.2835	41	79	8
HP243-2874	—	—	—	7.30	0.2874	41	79	8
HP243-2913	—	—	—	7.40	0.2913	41	79	8
HP243-2953	—	—	—	7.50	0.2953	41	79	8
HP243-2969	19/64	—	—	7.54	0.2969	41	79	8
HP243-2992	—	—	—	7.60	0.2992	41	79	8
HP243-3031	—	—	—	7.70	0.3031	41	79	8
HP243-3071	—	—	—	7.80	0.3071	41	79	8
HP243-3110	—	—	—	7.90	0.3110	41	79	8
HP243-3126	5/16	—	—	7.94	0.3126	41	79	8
HP243-3150	—	—	—	8.00	0.3150	41	79	8
HP243-3189	—	—	—	8.10	0.3189	47	89	10
HP243-3228	—	—	P	8.20	0.3228	47	89	10
HP243-3268	—	—	—	8.30	0.3268	47	89	10
HP243-3280	21/64	—	—	8.33	0.3280	47	89	10
HP243-3307	—	—	—	8.40	0.3307	47	89	10
HP243-3319	—	—	Q	8.43	0.3319	47	89	10
HP243-3346	—	—	—	8.50	0.3346	47	89	10
HP243-3386	—	—	—	8.60	0.3386	47	89	10
HP243-3425	—	—	—	8.70	0.3425	47	89	10
HP243-3437	11/32	—	—	8.73	0.3437	47	89	10
HP243-3465	—	—	—	8.80	0.3465	47	89	10
HP243-3504	—	—	—	8.90	0.3504	47	89	10
HP243-3543	—	—	—	9.00	0.3543	47	89	10
HP243-3583	—	—	—	9.10	0.3583	47	89	10
HP243-3594	23/64	—	—	9.13	0.3594	47	89	10
HP243-3622	—	—	—	9.20	0.3622	47	89	10
* HP243-3642	—	—	—	9.25	0.3642	47	89	10
HP243-3661	—	—	—	9.30	0.3661	47	89	10
HP243-3701	—	—	—	9.40	0.3701	47	89	10
HP243-3740	—	—	—	9.50	0.3740	47	89	10
HP243-3748	3/8	—	—	9.52	0.3748	47	89	10
HP243-3780	—	—	—	9.60	0.3780	47	89	10
HP243-3819	—	—	—	9.70	0.3819	47	89	10
HP243-3858	—	—	W	9.80	0.3858	47	89	10
HP243-3898	—	—	—	9.90	0.3898	47	89	10
HP243-3906	25/64	—	—	9.92	0.3906	47	89	10
HP243-3937	—	—	—	10.00	0.3937	47	89	10
HP243-3976	—	—	—	10.10	0.3976	55	102	12
HP243-4016	—	—	—	10.20	0.4016	55	102	12
HP243-4055	—	—	—	10.30	0.4055	55	102	12
HP243-4063	13/32	—	—	10.32	0.4063	55	102	12
HP243-4094	—	—	—	10.40	0.4094	55	102	12
HP243-4134	—	—	—	10.50	0.4134	55	102	12
HP243-4173	—	—	—	10.60	0.4173	55	102	12
HP243-4213	—	—	—	10.70	0.4213	55	102	12

Packed: 1 pc. Available TiAlN coating only.

continued on next page

Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP243		☐	☒	☒	☒		☐	☐	☐	☐					

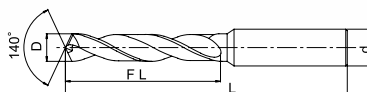
☐ good ☒ best

HY-PRO® CARB

Sub-Micrograin Carbide Drills

List HP243 (continued) **EXPANDED***

3D, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP243-4220	27/64	—	—	10.72	0.4220	55	102	12
HP243-4252	—	—	—	10.80	0.4252	55	102	12
HP243-4291	—	—	—	10.90	0.4291	55	102	12
HP243-4331	—	—	—	11.00	0.4331	55	102	12
HP243-4370	—	—	—	11.10	0.4370	55	102	12
HP243-4374	7/16	—	—	11.11	0.4374	55	102	12
HP243-4409	—	—	—	11.20	0.4409	55	102	12
HP243-4449	—	—	—	11.30	0.4449	55	102	12
HP243-4488	—	—	—	11.40	0.4488	55	102	12
HP243-4528	—	—	—	11.50	0.4528	55	102	12
HP243-4531	29/64	—	—	11.51	0.4531	55	102	12
HP243-4567	—	—	—	11.60	0.4567	55	102	12
HP243-4606	—	—	—	11.70	0.4606	55	102	12
HP243-4646	—	—	—	11.80	0.4646	55	102	12
HP243-4685	—	—	—	11.90	0.4685	55	102	12
HP243-4689	15/32	—	—	11.91	0.4689	55	102	12
HP243-4724	—	—	—	12.00	0.4724	55	102	12
HP243-4764	—	—	—	12.10	0.4764	60	107	14
HP243-4803	—	—	—	12.20	0.4803	60	107	14
HP243-4843	31/64	—	—	12.30	0.4843	60	107	14
HP243-4882	—	—	—	12.40	0.4882	60	107	14
HP243-4921	—	—	—	12.50	0.4921	60	107	14
HP243-4961	—	—	—	12.60	0.4961	60	107	14
HP243-5000	1/2	—	—	12.70	0.5000	60	107	14
HP243-5039	—	—	—	12.80	0.5039	60	107	14
HP243-5079	—	—	—	12.90	0.5079	60	107	14
HP243-5118	—	—	—	13.00	0.5118	60	107	14
HP243-5157	33/64	—	—	13.10	0.5157	60	107	14
HP243-5197	—	—	—	13.20	0.5197	60	107	14
HP243-5236	—	—	—	13.30	0.5236	60	107	14
HP243-5276	—	—	—	13.40	0.5276	60	107	14
HP243-5311	17/32	—	—	13.49	0.5311	60	107	14
HP243-5315	—	—	—	13.50	0.5315	60	107	14
* HP243-5394	—	—	—	13.70	0.5394	60	107	14
HP243-5512	—	—	—	14.00	0.5512	60	107	14
HP243-5626	9/16	—	—	14.29	0.5626	65	115	16
HP243-5709	—	—	—	14.50	0.5709	65	115	16
HP243-5780	37/64	—	—	14.68	0.5780	65	115	16
* HP243-5787	—	—	—	14.70	0.5787	65	115	16
HP243-5906	—	—	—	15.00	0.5906	65	115	16
HP243-5937	19/32	—	—	15.08	0.5937	65	115	16
HP243-6102	—	—	—	15.50	0.6102	65	115	16
* HP243-6181	—	—	—	15.70	0.6181	65	115	16
HP243-6248	5/8	—	—	15.87	0.6248	65	115	16
HP243-6299	—	—	—	16.00	0.6299	65	115	16
HP243-6496	—	—	—	16.50	0.6496	73	123	18
HP243-6563	21/32	—	—	16.67	0.6563	73	123	18
HP243-6693	—	—	—	17.00	0.6693	73	123	18
HP243-6890	—	—	—	17.50	0.6890	73	123	18
HP243-7087	—	—	—	18.00	0.7087	73	123	18
HP243-7283	—	—	—	18.50	0.7283	79	131	20
HP243-7480	—	—	—	19.00	0.7480	79	131	20
HP243-7500	3/4	—	—	19.05	0.7500	79	131	20
HP243-7677	—	—	—	19.50	0.7677	79	131	20
HP243-7874	—	—	—	20.00	0.7874	79	131	20

Packed: 1 pc. Available TiAIN coating only.



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP243		☐	☒	☒	☒		☐	☐	☐	☐					

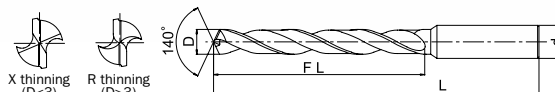
○ good ○ best

List HP245 **EXPANDED***

5D, Solid Carbide



m7 Cutting Diameter Tolerance



EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
* HP245-0394	—	—	—	1.00	0.0394	9	38	3
* HP245-0433	—	—	—	1.10	0.0433	9	38	3
* HP245-0469	3/64	—	—	1.19	0.0469	11	38	3
* HP245-0472	—	—	—	1.20	0.0472	11	38	3
* HP245-0512	—	—	—	1.30	0.0512	11	38	3
* HP245-0551	—	—	—	1.40	0.0551	12	38	3
* HP245-0591	—	—	—	1.50	0.0591	12	45	3
* HP245-0626	1/16	—	—	1.59	0.0626	14	45	3
* HP245-0630	—	—	—	1.60	0.0630	14	45	3
* HP245-0669	—	—	—	1.70	0.0669	14	45	3
* HP245-0709	—	—	—	1.80	0.0709	16	45	3
* HP245-0748	—	—	—	1.90	0.0748	16	45	3
* HP245-0780	5/64	—	—	1.98	0.0780	18	50	3
* HP245-0787	—	—	—	2.00	0.0787	18	50	3
* HP245-0827	—	—	—	2.10	0.0827	18	50	3
* HP245-0866	—	—	—	2.20	0.0866	20	52	3
* HP245-0906	—	—	—	2.30	0.0906	20	52	3
* HP245-0937	3/32	—	—	2.38	0.0937	22	52	3
* HP245-0945	—	—	—	2.40	0.0945	22	52	3
* HP245-0984	—	—	—	2.50	0.0984	22	56	3
* HP245-1024	—	—	—	2.60	0.1024	22	56	3
* HP245-1063	—	—	—	2.70	0.1063	23	56	3
* HP245-1094	7/64	—	—	2.78	0.1094	23	56	3
* HP245-1102	—	—	—	2.80	0.1102	23	56	3
* HP245-1142	—	—	—	2.90	0.1142	23	56	3
HP245-1181	—	—	—	3.00	0.1181	28	66	6
HP245-1220	—	—	—	3.10	0.1220	28	66	6
HP245-1248	1/8	—	—	3.17	0.1248	28	66	6
HP245-1260	—	—	—	3.20	0.1260	28	66	6
HP245-1299	—	—	—	3.30	0.1299	28	66	6
HP245-1339	—	—	—	3.40	0.1339	28	66	6
HP245-1378	—	—	—	3.50	0.1378	28	66	6
* HP245-1406	9/64	—	—	3.57	0.1406	28	66	6
HP245-1417	—	—	—	3.60	0.1417	28	66	6
HP245-1457	—	—	—	3.70	0.1457	28	66	6
HP245-1496	—	25	—	3.80	0.1496	36	74	6
HP245-1535	—	—	—	3.90	0.1535	36	74	6
HP245-1563	5/32	—	—	3.97	0.1563	36	74	6
HP245-1575	—	—	—	4.00	0.1575	36	74	6
HP245-1610	—	20	—	4.09	0.1610	36	74	6
HP245-1614	—	—	—	4.10	0.1614	36	74	6
HP245-1654	—	—	—	4.20	0.1654	36	74	6
HP245-1693	—	—	—	4.30	0.1693	36	74	6
HP245-1720	11/64	—	—	4.37	0.1720	36	74	6
HP245-1732	—	—	—	4.40	0.1732	36	74	6
HP245-1772	—	16	—	4.50	0.1772	36	74	6
HP245-1811	—	—	—	4.60	0.1811	36	74	6
* HP245-1831	—	—	—	4.65	0.1831	36	74	6
HP245-1850	—	13	—	4.70	0.1850	36	74	6
HP245-1874	3/16	—	—	4.76	0.1874	44	82	6
HP245-1890	—	12	—	4.80	0.1890	44	82	6
HP245-1929	—	—	—	4.90	0.1929	44	82	6
HP245-1969	—	—	—	5.00	0.1969	44	82	6
HP245-2008	—	—	—	5.10	0.2008	44	82	6
HP245-2031	13/64	—	—	5.16	0.2031	44	82	6
HP245-2047	—	—	—	5.20	0.2047	44	82	6

Packed: 1 pc. Available TiAIN coating only.

continued on next page **HPC**

Work Material													
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials	
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy
HP245		○	○	○	○		○	○	○	○			

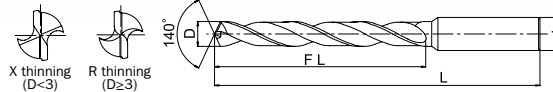
○ good ○ best

List HP245 (continued) **EXPANDED***

5D, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029



EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP245-2087	—	—	—	5.30	0.2087	44	82	6
HP245-2126	—	—	—	5.40	0.2126	44	82	6
HP245-2130	—	3	—	5.41	0.2130	44	82	6
HP245-2165	—	—	—	5.50	0.2165	44	82	6
HP245-2189	7/32	—	—	5.56	0.2189	44	82	6
HP245-2205	—	—	—	5.60	0.2205	44	82	6
HP245-2244	—	—	—	5.70	0.2244	44	82	6
HP245-2283	—	—	—	5.80	0.2283	44	82	6
HP245-2323	—	—	—	5.90	0.2323	44	82	6
HP245-2343	15/64	—	—	5.95	0.2343	44	82	6
HP245-2362	—	—	—	6.00	0.2362	44	82	6
HP245-2402	—	—	—	6.10	0.2402	53	91	8
HP245-2441	—	—	—	6.20	0.2441	53	91	8
HP245-2480	—	—	—	6.30	0.2480	53	91	8
HP245-2500	1/4	—	E	6.35	0.2500	53	91	8
HP245-2520	—	—	—	6.40	0.2520	53	91	8
HP245-2559	—	—	—	6.50	0.2559	53	91	8
HP245-2571	—	—	F	6.53	0.2571	53	91	8
HP245-2598	—	—	—	6.60	0.2598	53	91	8
HP245-2638	—	—	—	6.70	0.2638	53	91	8
HP245-2657	17/64	—	—	6.75	0.2657	53	91	8
HP245-2677	—	—	—	6.80	0.2677	53	91	8
HP245-2717	—	—	I	6.90	0.2717	53	91	8
HP245-2756	—	—	—	7.00	0.2756	53	91	8
HP245-2795	—	—	—	7.10	0.2795	53	91	8
HP245-2811	9/32	—	—	7.14	0.2811	53	91	8
HP245-2835	—	—	—	7.20	0.2835	53	91	8
HP245-2874	—	—	—	7.30	0.2874	53	91	8
HP245-2913	—	—	—	7.40	0.2913	53	91	8
HP245-2953	—	—	—	7.50	0.2953	53	91	8
HP245-2969	19/64	—	—	7.54	0.2969	53	91	8
HP245-2992	—	—	—	7.60	0.2992	53	91	8
HP245-3031	—	—	—	7.70	0.3031	53	91	8
HP245-3071	—	—	—	7.80	0.3071	53	91	8
HP245-3110	—	—	—	7.90	0.3110	53	91	8
HP245-3126	5/16	—	—	7.94	0.3126	53	91	8
HP245-3150	—	—	—	8.00	0.3150	53	91	8
HP245-3189	—	—	—	8.10	0.3189	61	103	10
HP245-3228	—	—	P	8.20	0.3228	61	103	10
HP245-3268	—	—	—	8.30	0.3268	61	103	10
HP245-3280	21/64	—	—	8.33	0.3280	61	103	10
HP245-3307	—	—	—	8.40	0.3307	61	103	10
HP245-3319	—	—	Q	8.43	0.3319	61	103	10
HP245-3346	—	—	—	8.50	0.3346	61	103	10
HP245-3386	—	—	—	8.60	0.3386	61	103	10
HP245-3425	—	—	—	8.70	0.3425	61	103	10
HP245-3437	11/32	—	—	8.73	0.3437	61	103	10
HP245-3465	—	—	—	8.80	0.3465	61	103	10
HP245-3504	—	—	—	8.90	0.3504	61	103	10
HP245-3543	—	—	—	9.00	0.3543	61	103	10
HP245-3583	—	—	—	9.10	0.3583	61	103	10
HP245-3594	23/64	—	—	9.13	0.3594	61	103	10
HP245-3622	—	—	—	9.20	0.3622	61	103	10
* HP245-3642	—	—	—	9.25	0.3642	61	103	10
HP245-3661	—	—	—	9.30	0.3661	61	103	10
HP245-3701	—	—	—	9.40	0.3701	61	103	10
HP245-3740	—	—	—	9.50	0.3740	61	103	10
HP245-3748	3/8	—	—	9.52	0.3748	61	103	10
HP245-3780	—	—	—	9.60	0.3780	61	103	10
HP245-3819	—	—	—	9.70	0.3819	61	103	10
HP245-3858	—	—	W	9.80	0.3858	61	103	10
HP245-3898	—	—	—	9.90	0.3898	61	103	10
HP245-3906	25/64	—	—	9.92	0.3906	61	103	10
HP245-3937	—	—	—	10.00	0.3937	61	103	10
HP245-3976	—	—	—	10.10	0.3976	71	118	12
HP245-4016	—	—	—	10.20	0.4016	71	118	12

Packed: 1 pc. Available TiAIN coating only.



List HP245 (continued)

EXPANDED*



5D, Solid Carbide

m7 Cutting Diameter Tolerance

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP245-4055	—	—	—	10.30	0.4055	71	118	12
HP245-4063	13/32	—	—	10.32	0.4063	71	118	12
HP245-4094	—	—	—	10.40	0.4094	71	118	12
HP245-4134	—	—	—	10.50	0.4134	71	118	12
HP245-4173	—	—	—	10.60	0.4173	71	118	12
HP245-4213	—	—	—	10.70	0.4213	71	118	12
HP245-4220	27/64	—	—	10.72	0.4220	71	118	12
HP245-4252	—	—	—	10.80	0.4252	71	118	12
HP245-4291	—	—	—	10.90	0.4291	71	118	12
HP245-4331	—	—	—	11.00	0.4331	71	118	12
HP245-4370	—	—	—	11.10	0.4370	71	118	12
HP245-4374	7/16	—	—	11.11	0.4374	71	118	12
HP245-4409	—	—	—	11.20	0.4409	71	118	12
HP245-4449	—	—	—	11.30	0.4449	71	118	12
HP245-4488	—	—	—	11.40	0.4488	71	118	12
HP245-4528	—	—	—	11.50	0.4528	71	118	12
HP245-4531	29/64	—	—	11.51	0.4531	71	118	12
HP245-4567	—	—	—	11.60	0.4567	71	118	12
HP245-4606	—	—	—	11.70	0.4606	71	118	12
HP245-4646	—	—	—	11.80	0.4646	71	118	12
HP245-4685	—	—	—	11.90	0.4685	71	118	12
HP245-4689	15/32	—	—	11.91	0.4689	71	118	12
HP245-4724	—	—	—	12.00	0.4724	71	118	12
HP245-4764	—	—	—	12.10	0.4764	77	124	14
HP245-4803	—	—	—	12.20	0.4803	77	124	14
HP245-4843	31/64	—	—	12.30	0.4843	77	124	14
HP245-4882	—	—	—	12.40	0.4882	77	124	14
HP245-4921	—	—	—	12.50	0.4921	77	124	14
HP245-4961	—	—	—	12.60	0.4961	77	124	14
HP245-5000	1/2	—	—	12.70	0.5000	77	124	14
HP245-5039	—	—	—	12.80	0.5039	77	124	14
HP245-5079	—	—	—	12.90	0.5079	77	124	14
HP245-5118	—	—	—	13.00	0.5118	77	124	14
HP245-5157	33/64	—	—	13.10	0.5157	77	124	14
HP245-5197	—	—	—	13.20	0.5197	77	124	14
HP245-5236	—	—	—	13.30	0.5236	77	124	14
* HP245-5394	—	—	—	13.70	0.5394	77	124	14
HP245-5276	—	—	—	13.40	0.5276	77	124	14
HP245-5311	17/32	—	—	13.49	0.5311	77	124	14
HP245-5315	—	—	—	13.50	0.5315	77	124	14
HP245-5512	—	—	—	14.00	0.5512	77	124	14
HP245-5626	9/16	—	—	14.29	0.5626	83	133	16
HP245-5709	—	—	—	14.50	0.5709	83	133	16
HP245-5780	37/64	—	—	14.68	0.5780	83	133	16
* HP245-5787	—	—	—	14.70	0.5787	83	133	16
HP245-5906	—	—	—	15.00	0.5906	83	133	16
HP245-5937	19/32	—	—	15.08	0.5937	83	133	16
HP245-6102	—	—	—	15.50	0.6102	83	133	16
* HP245-6181	—	—	—	15.70	0.6181	83	133	16
HP245-6248	5/8	—	—	15.87	0.6248	83	133	16
HP245-6299	—	—	—	16.00	0.6299	83	133	16
HP245-6496	—	—	—	16.50	0.6496	93	143	18
HP245-6563	21/32	—	—	16.67	0.6563	93	143	18
HP245-6693	—	—	—	17.00	0.6693	93	143	18
HP245-6890	—	—	—	17.50	0.6890	93	143	18
HP245-7087	—	—	—	18.00	0.7087	93	143	18
HP245-7283	—	—	—	18.50	0.7283	101	153	20
HP245-7480	—	—	—	19.00	0.7480	101	153	20
HP245-7500	3/4	—	—	19.05	0.7500	101	153	20
HP245-7677	—	—	—	19.50	0.7677	101	153	20
HP245-7874	—	—	—	20.00	0.7874	101	153	20

Packed: 1 pc. Available TiAIN coating only.



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP245		☐	☒	☒	☒		☐	☐	☐	☐					

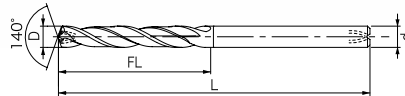
☐ good ☒ best

HY-PRO® CARB

Sub-Micrograin Carbide Coolant-Through Drills

List HP253 EXPANDED*

3D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance

3<D≤6 +0.004 +0.016

6<D≤10 +0.006 +0.021

10<D≤18 +0.007 +0.025

18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP253-1181	—	—	—	3.00	0.1181	20	62	6
HP253-1220	—	—	—	3.10	0.1220	20	62	6
HP253-1248	1/8	—	—	3.17	0.1248	20	62	6
HP253-1260	—	—	—	3.20	0.1260	20	62	6
HP253-1299	—	—	—	3.30	0.1299	20	62	6
HP253-1339	—	—	—	3.40	0.1339	20	62	6
HP253-1378	—	—	—	3.50	0.1378	20	62	6
HP253-1406	9/64	—	—	3.57	0.1406	20	62	6
HP253-1417	—	—	—	3.60	0.1417	20	62	6
HP253-1457	—	—	—	3.70	0.1457	20	62	6
HP253-1496	—	25	—	3.80	0.1496	24	66	6
HP253-1535	—	—	—	3.90	0.1535	24	66	6
HP253-1563	5/32	—	—	3.97	0.1563	24	66	6
HP253-1575	—	—	—	4.00	0.1575	24	66	6
* HP253-1610	—	20	—	4.09	0.1610	24	66	6
HP253-1614	—	—	—	4.10	0.1614	24	66	6
HP253-1654	—	—	—	4.20	0.1654	24	66	6
HP253-1693	—	—	—	4.30	0.1693	24	66	6
HP253-1720	11/64	—	—	4.37	0.1720	24	66	6
HP253-1732	—	—	—	4.40	0.1732	24	66	6
HP253-1772	—	16	—	4.50	0.1772	24	66	6
HP253-1811	—	—	—	4.60	0.1811	24	66	6
HP253-1831	—	—	—	4.65	0.1831	24	66	6
HP253-1850	—	13	—	4.70	0.1850	24	66	6
HP253-1874	3/16	—	—	4.76	0.1874	28	66	6
HP253-1890	—	12	—	4.80	0.1890	28	66	6
HP253-1929	—	—	—	4.90	0.1929	28	66	6
HP253-1969	—	—	—	5.00	0.1969	28	66	6
HP253-2008	—	—	—	5.10	0.2008	28	66	6
HP253-2031	13/64	—	—	5.16	0.2031	28	66	6
HP253-2047	—	—	—	5.20	0.2047	28	66	6
HP253-2087	—	—	—	5.30	0.2087	28	66	6
HP253-2126	—	—	—	5.40	0.2126	28	66	6
* HP253-2130	—	3	—	5.41	0.2130	28	66	6
HP253-2165	—	—	—	5.50	0.2165	28	66	6
HP253-2189	7/32	—	—	5.56	0.2189	28	66	6
HP253-2205	—	—	—	5.60	0.2205	28	66	6
HP253-2244	—	—	—	5.70	0.2244	28	66	6
HP253-2283	—	—	—	5.80	0.2283	28	66	6
HP253-2323	—	—	—	5.90	0.2323	28	66	6
HP253-2343	15/64	—	—	5.95	0.2343	28	66	6
HP253-2362	—	—	—	6.00	0.2362	28	66	6
HP253-2402	—	—	—	6.10	0.2402	34	79	8
HP253-2441	—	—	—	6.20	0.2441	34	79	8
HP253-2480	—	—	—	6.30	0.2480	34	79	8
HP253-2500	1/4	—	E	6.35	0.2500	34	79	8
HP253-2520	—	—	—	6.40	0.2520	34	79	8
HP253-2559	—	—	—	6.50	0.2559	34	79	8
* HP253-2571	—	—	F	6.53	0.2571	34	79	8
HP253-2598	—	—	—	6.60	0.2598	34	79	8
HP253-2638	—	—	—	6.70	0.2638	34	79	8
HP253-2657	17/64	—	—	6.75	0.2657	34	79	8
HP253-2677	—	—	—	6.80	0.2677	34	79	8
HP253-2717	—	—	I	6.90	0.2717	34	79	8
HP253-2756	—	—	—	7.00	0.2756	34	79	8
HP253-2795	—	—	—	7.10	0.2795	41	79	8
HP253-2811	9/32	—	—	7.14	0.2811	41	79	8
HP253-2835	—	—	—	7.20	0.2835	41	79	8
HP253-2874	—	—	—	7.30	0.2874	41	79	8
HP253-2913	—	—	—	7.40	0.2913	41	79	8
HP253-2953	—	—	—	7.50	0.2953	41	79	8
HP253-2969	19/64	—	—	7.54	0.2969	41	79	8
HP253-2992	—	—	—	7.60	0.2992	41	79	8

Packed: 1 pc. Available TiAlN coating only.



List HP253 (continued) **EXPANDED***

3D, Coolant-Through, Solid Carbide



EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP253-3031	—	—	—	7.70	0.3031	41	79	8
HP253-3071	—	—	—	7.80	0.3071	41	79	8
HP253-3110	—	—	—	7.90	0.3110	41	79	8
HP253-3126	5/16	—	—	7.94	0.3126	41	79	8
HP253-3150	—	—	—	8.00	0.3150	41	79	8
HP253-3189	—	—	—	8.10	0.3189	47	89	10
HP253-3228	—	—	P	8.20	0.3228	47	89	10
HP253-3268	—	—	—	8.30	0.3268	47	89	10
HP253-3280	21/64	—	—	8.33	0.3280	47	89	10
HP253-3307	—	—	—	8.40	0.3307	47	89	10
* HP253-3319	—	—	Q	8.43	0.3319	47	89	10
HP253-3346	—	—	—	8.50	0.3346	47	89	10
HP253-3386	—	—	—	8.60	0.3386	47	89	10
HP253-3425	—	—	—	8.70	0.3425	47	89	10
HP253-3437	11/32	—	—	8.73	0.3437	47	89	10
HP253-3465	—	—	—	8.80	0.3465	47	89	10
HP253-3504	—	—	—	8.90	0.3504	47	89	10
HP253-3543	—	—	—	9.00	0.3543	47	89	10
HP253-3583	—	—	—	9.10	0.3583	47	89	10
HP253-3594	23/64	—	—	9.13	0.3594	47	89	10
HP253-3622	—	—	—	9.20	0.3622	47	89	10
HP253-3642	—	—	—	9.25	0.3642	47	89	10
HP253-3661	—	—	—	9.30	0.3661	47	89	10
HP253-3701	—	—	—	9.40	0.3701	47	89	10
HP253-3740	—	—	—	9.50	0.3740	47	89	10
HP253-3748	3/8	—	—	9.52	0.3748	47	89	10
HP253-3780	—	—	—	9.60	0.3780	47	89	10
HP253-3819	—	—	—	9.70	0.3819	47	89	10
HP253-3858	—	—	W	9.80	0.3858	47	89	10
HP253-3898	—	—	—	9.90	0.3898	47	89	10
HP253-3906	25/64	—	—	9.92	0.3906	47	89	10
HP253-3937	—	—	—	10.00	0.3937	47	89	10
HP253-3976	—	—	—	10.10	0.3976	55	102	12
HP253-4016	—	—	—	10.20	0.4016	55	102	12
HP253-4055	—	—	—	10.30	0.4055	55	102	12
HP253-4063	13/32	—	—	10.32	0.4063	55	102	12
HP253-4094	—	—	—	10.40	0.4094	55	102	12
HP253-4134	—	—	—	10.50	0.4134	55	102	12
HP253-4173	—	—	—	10.60	0.4173	55	102	12
HP253-4213	—	—	—	10.70	0.4213	55	102	12
* HP253-4220	27/64	—	—	10.72	0.4220	55	102	12
HP253-4252	—	—	—	10.80	0.4252	55	102	12
HP253-4291	—	—	—	10.90	0.4291	55	102	12
HP253-4331	—	—	—	11.00	0.4331	55	102	12
HP253-4370	—	—	—	11.10	0.4370	55	102	12
HP253-4374	7/16	—	—	11.11	0.4374	55	102	12
HP253-4409	—	—	—	11.20	0.4409	55	102	12
HP253-4449	—	—	—	11.30	0.4449	55	102	12
HP253-4488	—	—	—	11.40	0.4488	55	102	12
HP253-4528	—	—	—	11.50	0.4528	55	102	12
* HP253-4531	29/64	—	—	11.51	0.4531	55	102	12
HP253-4567	—	—	—	11.60	0.4567	55	102	12
HP253-4606	—	—	—	11.70	0.4606	55	102	12
HP253-4646	—	—	—	11.80	0.4646	55	102	12
HP253-4685	—	—	—	11.90	0.4685	55	102	12
HP253-4689	15/32	—	—	11.91	0.4689	55	102	12
HP253-4724	—	—	—	12.00	0.4724	55	102	12
* HP253-4764	—	—	—	12.10	0.4764	60	107	14

Packed: 1 pc. Available TiAIN coating only.

continued on next page **HPC**

Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP253		☐	☒	☒	☒		☐	☐	☐	☐					

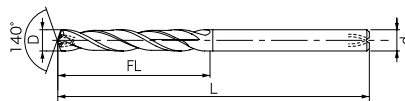
○ good ○ best

HY-PRO® CARB

Sub-Micrograin Carbide Coolant-Through Drills

List HP253 (continued) **EXPANDED***

3D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
* HP253-4803	—	—	—	12.20	0.4803	60	107	14
* HP253-4843	31/64	—	—	12.30	0.4843	60	107	14
* HP253-4882	—	—	—	12.40	0.4882	60	107	14
HP253-4921	—	—	—	12.50	0.4921	60	107	14
* HP253-4961	—	—	—	12.60	0.4961	60	107	14
HP253-5000	1/2	—	—	12.70	0.5000	60	107	14
* HP253-5039	—	—	—	12.80	0.5039	60	107	14
* HP253-5079	—	—	—	12.90	0.5079	60	107	14
HP253-5118	—	—	—	13.00	0.5118	60	107	14
* HP253-5157	33/64	—	—	13.10	0.5157	60	107	14
* HP253-5197	—	—	—	13.20	0.5197	60	107	14
* HP253-5236	—	—	—	13.30	0.5236	60	107	14
* HP253-5276	—	—	—	13.40	0.5276	60	107	14
* HP253-5311	17/32	—	—	13.49	0.5311	60	107	14
HP253-5315	—	—	—	13.50	0.5315	60	107	14
HP253-5394	—	—	—	13.70	0.5394	60	107	14
HP253-5512	—	—	—	14.00	0.5512	60	107	14
HP253-5626	9/16	—	—	14.29	0.5626	65	115	16
HP253-5709	—	—	—	14.50	0.5709	65	115	16
* HP253-5780	37/64	—	—	14.68	0.5780	65	115	16
HP253-5787	—	—	—	14.70	0.5787	65	115	16
HP253-5906	—	—	—	15.00	0.5906	65	115	16
* HP253-5937	19/32	—	—	15.08	0.5937	65	115	15
HP253-6102	—	—	—	15.50	0.6102	65	115	16
HP253-6181	—	—	—	15.70	0.6181	65	115	16
HP253-6248	5/8	—	—	15.87	0.6248	65	115	16
HP253-6299	—	—	—	16.00	0.6299	65	115	16
HP253-6496	—	—	—	16.50	0.6496	73	123	18
* HP253-6563	21/32	—	—	16.67	0.6563	73	123	18
HP253-6693	—	—	—	17.00	0.6693	73	123	18
HP253-6890	—	—	—	17.50	0.6890	73	123	18
HP253-7087	—	—	—	18.00	0.7087	73	123	18
HP253-7283	—	—	—	18.50	0.7283	79	131	20
HP253-7480	—	—	—	19.00	0.7480	79	131	20
HP253-7500	3/4	—	—	19.05	0.7500	79	131	20
HP253-7677	—	—	—	19.50	0.7677	79	131	20
HP253-7874	—	—	—	20.00	0.7874	79	131	20

Packed: 1 pc. Available TiAIN coating only.

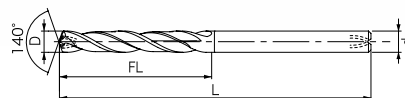


Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP253		☐	☒	☒	☒		☐	☐	☐	☐					

☐ good ☒ best

List HP255 **EXPANDED***

5D, Coolant-Through, Solid Carbide



EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP255-1181	—	—	—	3.00	0.1181	28	66	6
HP255-1220	—	—	—	3.10	0.1220	28	66	6
HP255-1248	1/8	—	—	3.17	0.1248	28	66	6
HP255-1260	—	—	—	3.20	0.1260	28	66	6
HP255-1299	—	—	—	3.30	0.1299	28	66	6
HP255-1339	—	—	—	3.40	0.1339	28	66	6
HP255-1378	—	—	—	3.50	0.1378	28	66	6
HP255-1406	9/64	—	—	3.57	0.1406	28	66	6
HP255-1417	—	—	—	3.60	0.1417	28	66	6
HP255-1457	—	—	—	3.70	0.1457	28	66	6
HP255-1496	—	25	—	3.80	0.1496	36	74	6
HP255-1535	—	—	—	3.90	0.1535	36	74	6
HP255-1563	5/32	—	—	3.97	0.1563	36	74	6
HP255-1575	—	—	—	4.00	0.1575	36	74	6
* HP255-1610	—	20	—	4.09	0.1610	36	74	6
HP255-1614	—	—	—	4.10	0.1614	36	74	6
HP255-1654	—	—	—	4.20	0.1654	36	74	6
HP255-1693	—	—	—	4.30	0.1693	36	74	6
HP255-1720	11/64	—	—	4.37	0.1720	36	74	6
HP255-1732	—	—	—	4.40	0.1732	36	74	6
HP255-1772	—	16	—	4.50	0.1772	36	74	6
HP255-1811	—	—	—	4.60	0.1811	36	74	6
HP255-1831	—	—	—	4.65	0.1831	36	74	6
HP255-1850	—	13	—	4.70	0.1850	36	74	6
HP255-1874	3/16	—	—	4.76	0.1874	44	82	6
HP255-1890	—	12	—	4.80	0.1890	44	82	6
HP255-1929	—	—	—	4.90	0.1929	44	82	6
HP255-1969	—	—	—	5.00	0.1969	44	82	6
HP255-2008	—	—	—	5.10	0.2008	44	82	6
HP255-2031	13/64	—	—	5.16	0.2031	44	82	6
HP255-2047	—	—	—	5.20	0.2047	44	82	6
HP255-2087	—	—	—	5.30	0.2087	44	82	6
HP255-2126	—	—	—	5.40	0.2126	44	82	6
* HP255-2130	—	3	—	5.41	0.2130	44	82	6
HP255-2165	—	—	—	5.50	0.2165	44	82	6
HP255-2189	7/32	—	—	5.56	0.2189	44	82	6
HP255-2205	—	—	—	5.60	0.2205	44	82	6
HP255-2244	—	—	—	5.70	0.2244	44	82	6
HP255-2283	—	—	—	5.80	0.2283	44	82	6
HP255-2323	—	—	—	5.90	0.2323	44	82	6
HP255-2343	15/64	—	—	5.95	0.2343	44	82	6
HP255-2362	—	—	—	6.00	0.2362	44	82	6
HP255-2402	—	—	—	6.10	0.2402	53	91	8
HP255-2441	—	—	—	6.20	0.2441	53	91	8
HP255-2480	—	—	—	6.30	0.2480	53	91	8
HP255-2500	1/4	—	E	6.35	0.2500	53	91	8
HP255-2520	—	—	—	6.40	0.2520	53	91	8
HP255-2559	—	—	—	6.50	0.2559	53	91	8
* HP255-2571	—	—	F	6.53	0.2571	53	91	8
HP255-2598	—	—	—	6.60	0.2598	53	91	8
HP255-2638	—	—	—	6.70	0.2638	53	91	8
HP255-2657	17/64	—	—	6.75	0.2657	53	91	8
HP255-2677	—	—	—	6.80	0.2677	53	91	8

Packed: 1 pc. Available TiAlN coating only.

continued on next page



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP255		☐	☒	☒	☒		☐	☐	☐	☐					

☐ good ☒ best

HY-PRO® CARB

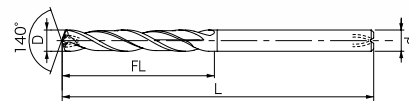
Sub-Micrograin Carbide Coolant-Through Drills

List HP255 (continued)

EXPANDED*



5D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP255-2717	—	—	I	6.90	0.2717	53	91	8
HP255-2756	—	—	—	7.00	0.2756	53	91	8
HP255-2795	—	—	—	7.10	0.2795	53	91	8
HP255-2811	9/32	—	—	7.14	0.2811	53	91	8
HP255-2835	—	—	—	7.20	0.2835	53	91	8
HP255-2874	—	—	—	7.30	0.2874	53	91	8
HP255-2913	—	—	—	7.40	0.2913	53	91	8
HP255-2953	—	—	—	7.50	0.2953	53	91	8
HP255-2969	19/64	—	—	7.54	0.2969	53	91	8
HP255-2992	—	—	—	7.60	0.2992	53	91	8
HP255-3031	—	—	—	7.70	0.3031	53	91	8
HP255-3071	—	—	—	7.80	0.3071	53	91	8
HP255-3110	—	—	—	7.90	0.3110	53	91	8
HP255-3126	5/16	—	—	7.94	0.3126	53	91	8
HP255-3150	—	—	—	8.00	0.3150	53	91	8
HP255-3189	—	—	—	8.10	0.3189	61	103	10
HP255-3228	—	—	P	8.20	0.3228	61	103	10
HP255-3268	—	—	—	8.30	0.3268	61	103	10
HP255-3280	21/64	—	—	8.33	0.3280	61	103	10
HP255-3307	—	—	—	8.40	0.3307	61	103	10
* HP255-3319	—	—	Q	8.43	0.3319	61	103	10
HP255-3346	—	—	—	8.50	0.3346	61	103	10
HP255-3386	—	—	—	8.60	0.3386	61	103	10
HP255-3425	—	—	—	8.70	0.3425	61	103	10
HP255-3437	11/32	—	—	8.73	0.3437	61	103	10
HP255-3465	—	—	—	8.80	0.3465	61	103	10
HP255-3504	—	—	—	8.90	0.3504	61	103	10
HP255-3543	—	—	—	9.00	0.3543	61	103	10
HP255-3583	—	—	—	9.10	0.3583	61	103	10
HP255-3594	23/64	—	—	9.13	0.3594	61	103	10
HP255-3622	—	—	—	9.20	0.3622	61	103	10
HP255-3642	—	—	—	9.25	0.3642	61	103	10
HP255-3661	—	—	—	9.30	0.3661	61	103	10
HP255-3701	—	—	—	9.40	0.3701	61	103	10
HP255-3740	—	—	—	9.50	0.3740	61	103	10
HP255-3748	3/8	—	—	9.52	0.3748	61	103	10
HP255-3780	—	—	—	9.60	0.3780	61	103	10
HP255-3819	—	—	—	9.70	0.3819	61	103	10
HP255-3858	—	—	W	9.80	0.3858	61	103	10
HP255-3898	—	—	—	9.90	0.3898	61	103	10
HP255-3906	25/64	—	—	9.92	0.3906	61	103	10
HP255-3937	—	—	—	10.00	0.3937	61	103	10
HP255-3976	—	—	—	10.10	0.3976	71	118	12
HP255-4016	—	—	—	10.20	0.4016	71	118	12
HP255-4055	—	—	—	10.30	0.4055	71	118	12
HP255-4063	13/32	—	—	10.32	0.4063	71	118	12
HP255-4094	—	—	—	10.40	0.4094	71	118	12
HP255-4134	—	—	—	10.50	0.4134	71	118	12
HP255-4173	—	—	—	10.60	0.4173	71	118	12
HP255-4213	—	—	—	10.70	0.4213	71	118	12
* HP255-4220	27/64	—	—	10.72	0.4220	71	118	12
HP255-4252	—	—	—	10.80	0.4252	71	118	12
HP255-4291	—	—	—	10.90	0.4291	71	118	12
HP255-4331	—	—	—	11.00	0.4331	71	118	12
HP255-4370	—	—	—	11.10	0.4370	71	118	12
HP255-4374	7/16	—	—	11.11	0.4374	71	118	12
HP255-4409	—	—	—	11.20	0.4409	71	118	12
HP255-4449	—	—	—	11.30	0.4449	71	118	12
HP255-4488	—	—	—	11.40	0.4488	71	118	12
HP255-4528	—	—	—	11.50	0.4528	71	118	12
* HP255-4531	29/64	—	—	11.51	0.4531	71	118	12
HP255-4567	—	—	—	11.60	0.4567	71	118	12
HP255-4606	—	—	—	11.70	0.4606	71	118	12

Packed: 1 pc. Available TiAlN coating only.



List HP255 (continued) **EXPANDED***

5D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP255-4646	—	—	—	11.80	0.4646	71	118	12
HP255-4685	—	—	—	11.90	0.4685	71	118	12
HP255-4689	15/32	—	—	11.91	0.4689	71	118	12
HP255-4724	—	—	—	12.00	0.4724	71	118	12
* HP255-4764	—	—	—	12.10	0.4764	77	124	14
* HP255-4803	—	—	—	12.20	0.4803	77	124	14
* HP255-4843	31/64	—	—	12.30	0.4843	77	124	14
* HP255-4882	—	—	—	12.40	0.4882	77	124	14
HP255-4921	—	—	—	12.50	0.4921	77	124	14
* HP255-4961	—	—	—	12.60	0.4961	77	124	14
HP255-5000	1/2	—	—	12.70	0.5000	77	124	14
* HP255-5039	—	—	—	12.80	0.5039	77	124	14
* HP255-5079	—	—	—	12.90	0.5079	77	124	14
HP255-5118	—	—	—	13.00	0.5118	77	124	14
* HP255-5157	33/64	—	—	13.10	0.5157	77	124	14
* HP255-5197	—	—	—	13.20	0.5197	77	124	14
* HP255-5236	—	—	—	13.30	0.5236	77	124	14
* HP255-5276	—	—	—	13.40	0.5276	77	124	14
* HP255-5311	17/32	—	—	13.49	0.5311	77	124	14
HP255-5315	—	—	—	13.50	0.5315	77	124	14
HP255-5394	—	—	—	13.70	0.5394	77	124	14
HP255-5512	—	—	—	14.00	0.5512	77	124	14
HP255-5626	9/16	—	—	14.29	0.5626	83	133	16
HP255-5709	—	—	—	14.50	0.5709	83	133	16
* HP255-5780	37/64	—	—	14.68	0.5780	83	133	16
HP255-5787	—	—	—	14.70	0.5787	83	133	16
HP255-5906	—	—	—	15.00	0.5906	83	133	16
* HP255-5937	19/32	—	—	15.08	0.5937	83	133	16
HP255-6102	—	—	—	15.50	0.6102	83	133	16
HP255-6181	—	—	—	15.70	0.6181	83	133	16
HP255-6248	5/8	—	—	15.87	0.6248	83	133	16
HP255-6299	—	—	—	16.00	0.6299	83	133	16
HP255-6496	—	—	—	16.50	0.6496	93	143	18
* HP255-6563	21/32	—	—	16.67	0.6563	93	143	18
* HP255-6693	—	—	—	17.00	0.6693	93	143	18
HP255-6890	—	—	—	17.50	0.6890	93	143	18
HP255-7087	—	—	—	18.00	0.7087	93	143	18
HP255-7283	—	—	—	18.50	0.7283	101	153	20
HP255-7480	—	—	—	19.00	0.7480	101	153	20
HP255-7500	3/4	—	—	19.05	0.7500	101	153	20
HP255-7677	—	—	—	19.50	0.7677	101	153	20
HP255-7874	—	—	—	20.00	0.7874	101	153	20

Packed: 1 pc. Available TiAlN coating only.



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP255		☐	☒	☒	☒		☐	☐	☐	☐					

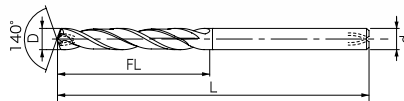
☐ good ☒ best

HY-PRO® CARB

Sub-Micrograin Carbide Coolant-Through Drills

List HP258 **NEW!**

8D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP258-1181	-	-	-	3.00	0.1181	29	77	4
HP258-1220	-	-	-	3.10	0.1220	36	77	4
HP258-1248	1/8	-	-	3.17	0.1248	36	77	4
HP258-1260	-	-	-	3.20	0.1260	36	77	4
HP258-1299	-	-	-	3.30	0.1299	36	77	4
HP258-1339	-	-	-	3.40	0.1339	36	77	4
HP258-1378	-	-	-	3.50	0.1378	36	77	4
HP258-1406	9/64	-	-	3.57	0.1406	36	77	4
HP258-1417	-	-	-	3.60	0.1417	36	77	4
HP258-1457	-	-	-	3.70	0.1457	36	77	4
HP258-1496	-	25	-	3.80	0.1496	45	85	4
HP258-1535	-	-	-	3.90	0.1535	45	85	4
HP258-1563	5/32	-	-	3.97	0.1563	45	85	4
HP258-1575	-	-	-	4.00	0.1575	45	85	4
HP258-1610	-	20	-	4.09	0.1610	45	85	6
HP258-1614	-	-	-	4.10	0.1614	45	85	6
HP258-1654	-	-	-	4.20	0.1654	45	85	6
HP258-1693	-	-	-	4.30	0.1693	45	85	6
HP258-1720	11/64	-	-	4.37	0.1720	45	85	6
HP258-1732	-	-	-	4.40	0.1732	45	85	6
HP258-1772	-	16	-	4.50	0.1772	45	85	6
HP258-1811	-	-	-	4.60	0.1811	45	85	6
HP258-1831	-	-	-	4.65	0.1831	45	85	6
HP258-1850	-	13	-	4.70	0.1850	45	85	6
HP258-1874	3/16	-	-	4.76	0.1874	50	90	6
HP258-1890	-	-	-	4.80	0.1890	50	90	6
HP258-1929	-	-	-	4.90	0.1929	50	90	6
HP258-1969	-	-	-	5.00	0.1969	50	90	6
HP258-2008	-	-	-	5.10	0.2008	57	97	6
HP258-2031	13/64	-	-	5.16	0.2031	57	97	6
HP258-2047	-	-	-	5.20	0.2047	57	97	6
HP258-2087	-	-	-	5.30	0.2087	57	97	6
HP258-2126	-	-	-	5.40	0.2126	57	97	6
HP258-2130	-	3	-	5.41	0.2130	57	97	6
HP258-2165	-	-	-	5.50	0.2165	57	97	6
HP258-2189	7/32	-	-	5.56	0.2189	57	97	6
HP258-2205	-	-	-	5.60	0.2205	57	97	6
HP258-2244	-	-	-	5.70	0.2244	57	97	6
HP258-2283	-	-	-	5.80	0.2283	57	97	6
HP258-2323	-	-	-	5.90	0.2323	57	97	6
HP258-2343	15/64	-	-	5.95	0.2343	57	97	6
HP258-2362	-	-	-	6.00	0.2362	57	97	6
HP258-2402	-	-	-	6.10	0.2402	66	106	8
HP258-2441	-	-	-	6.20	0.2441	66	106	8
HP258-2480	-	-	-	6.30	0.2480	66	106	8
HP258-2500	1/4	-	E	6.35	0.2500	66	106	8
HP258-2520	-	-	-	6.40	0.2520	66	106	8
HP258-2559	-	-	-	6.50	0.2559	66	106	8
HP258-2571	-	-	F	6.53	0.2571	66	106	8
HP258-2598	-	-	-	6.60	0.2598	66	106	8
HP258-2638	-	-	-	6.70	0.2638	66	106	8
HP258-2657	17/64	-	-	6.75	0.2657	66	106	8
HP258-2677	-	-	-	6.80	0.2677	66	106	8
HP258-2717	-	-	I	6.90	0.2717	76	116	8
HP258-2756	-	-	-	7.00	0.2756	76	116	8
HP258-2795	-	-	-	7.10	0.2795	76	116	8
HP258-2811	9/32	-	-	7.14	0.2811	76	116	8
HP258-2835	-	-	-	7.20	0.2835	76	116	8
HP258-2874	-	-	-	7.30	0.2874	76	116	8
HP258-2913	-	-	-	7.40	0.2913	76	116	8
HP258-2953	-	-	-	7.50	0.2953	76	116	8
HP258-2969	19/64	-	-	7.54	0.2969	76	116	8
HP258-2992	-	-	-	7.60	0.2992	76	116	8

Packed: 1 pc. Available TiAlN coating only.



List HP258 (continued) **NEW!**

8D, Coolant-Through, Solid Carbide



EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP258-3031	-	-	-	7.70	0.3031	76	116	8
HP258-3071	-	-	-	7.80	0.3071	76	116	8
HP258-3110	-	-	-	7.90	0.3110	76	116	8
HP258-3126	5/16	-	-	7.94	0.3126	76	116	8
HP258-3150	-	-	-	8.00	0.3150	76	116	8
HP258-3189	-	-	-	8.10	0.3189	87	131	10
HP258-3228	-	-	P	8.20	0.3228	87	131	10
HP258-3268	-	-	-	8.30	0.3268	87	131	10
HP258-3280	21/64	-	-	8.33	0.3280	87	131	10
HP258-3307	-	-	-	8.40	0.3307	87	131	10
HP258-3319	-	-	Q	8.43	0.3319	87	131	10
HP258-3346	-	-	-	8.50	0.3346	87	131	10
HP258-3386	-	-	-	8.60	0.3386	87	131	10
HP258-3425	-	-	-	8.70	0.3425	87	131	10
HP258-3437	11/32	-	-	8.73	0.3437	87	131	10
HP258-3465	-	-	-	8.80	0.3465	87	131	10
HP258-3504	-	-	-	8.90	0.3504	87	131	10
HP258-3543	-	-	-	9.00	0.3543	87	131	10
HP258-3583	-	-	-	9.10	0.3583	95	139	10
HP258-3594	23/64	-	-	9.13	0.3594	95	139	10
HP258-3622	-	-	-	9.20	0.3622	95	139	10
HP258-3642	-	-	-	9.25	0.3642	95	139	10
HP258-3661	-	-	-	9.30	0.3661	95	139	10
HP258-3701	-	-	-	9.40	0.3701	95	139	10
HP258-3740	-	-	-	9.50	0.3740	95	139	10
HP258-3748	3/8	-	-	9.52	0.3748	95	139	10
HP258-3780	-	-	-	9.60	0.3780	95	139	10
HP258-3819	-	-	-	9.70	0.3819	95	139	10
HP258-3858	-	-	W	9.80	0.3858	95	139	10
HP258-3898	-	-	-	9.90	0.3898	95	139	10
HP258-3906	25/64	-	-	9.92	0.3906	95	139	10
HP258-3937	-	-	-	10.00	0.3937	95	139	10
HP258-3976	-	-	-	10.10	0.3976	106	155	12
HP258-4016	-	-	-	10.20	0.4016	106	155	12
HP258-4055	-	-	-	10.30	0.4055	106	155	12
HP258-4063	13/32	-	-	10.32	0.4063	106	155	12
HP258-4094	-	-	-	10.40	0.4094	106	155	12
HP258-4134	-	-	-	10.50	0.4134	106	155	12
HP258-4173	-	-	-	10.60	0.4173	106	155	12
HP258-4213	-	-	-	10.70	0.4213	106	155	12
HP258-4220	27/64	-	-	10.72	0.4220	106	155	12
HP258-4252	-	-	-	10.80	0.4252	106	155	12
HP258-4291	-	-	-	10.90	0.4291	106	155	12
HP258-4331	-	-	-	11.00	0.4331	106	155	12
HP258-4370	-	-	-	11.10	0.4370	114	163	12
HP258-4374	7/16	-	-	11.11	0.4374	114	163	12
HP258-4409	-	-	-	11.20	0.4409	114	163	12
HP258-4449	-	-	-	11.30	0.4449	114	163	12
HP258-4488	-	-	-	11.40	0.4488	114	163	12
HP258-4528	-	-	-	11.50	0.4528	114	163	12
HP258-4531	29/64	-	-	11.51	0.4531	114	163	12
HP258-4567	-	-	-	11.60	0.4567	114	163	12
HP258-4606	-	-	-	11.70	0.4606	114	163	12
HP258-4646	-	-	-	11.80	0.4646	114	163	12
HP258-4685	-	-	-	11.90	0.4685	114	163	12
HP258-4689	15/32	-	-	11.91	0.4689	114	163	12

Packed: 1 pc. Available TiAlN coating only.



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP258		☐	☒	☒	☒		☐	☐	☐	☐					

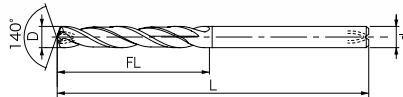
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HY-PRO® CARB

Sub-Micrograin Carbide Coolant-Through Drills

List HP258 (continued) **NEW!**

8D, Coolant-Through, Solid Carbide



m7 Cutting Diameter Tolerance
 3<D≤6 +0.004 +0.016
 6<D≤10 +0.006 +0.021
 10<D≤18 +0.007 +0.025
 18<D≤30 +0.008 +0.029

EDP Number	Size					Flute Length	Overall Length	Shank Diameter
	Fractional Size	Wire Gauge	Letter Size	mm	Inch	FL	L	d
HP258-4724	-	-	-	12.00	0.4724	114	163	12
HP258-4764	-	-	-	12.10	0.4764	133	182	14
HP258-4803	-	-	-	12.20	0.4803	133	182	14
HP258-4843	31/64	-	-	12.30	0.4843	133	182	14
HP258-4882	-	-	-	12.40	0.4882	133	182	14
HP258-4921	-	-	-	12.50	0.4921	133	182	14
HP258-4961	-	-	-	12.60	0.4961	133	182	14
HP258-5000	1/2	-	-	12.70	0.5000	133	182	14
HP258-5039	-	-	-	12.80	0.5039	133	182	14
HP258-5079	-	-	-	12.90	0.5079	133	182	14
HP258-5118	-	-	-	13.00	0.5118	133	182	14
HP258-5157	33/64	-	-	13.10	0.5157	133	182	14
HP258-5197	-	-	-	13.20	0.5197	133	182	14
HP258-5236	-	-	-	13.30	0.5236	133	182	14
HP258-5276	-	-	-	13.40	0.5276	133	182	14
HP258-5311	17/32	-	-	13.49	0.5311	133	182	14
HP258-5315	-	-	-	13.50	0.5315	133	182	14
HP258-5394	-	-	-	13.70	0.5394	133	182	14
HP258-5512	-	-	-	14.00	0.5512	133	182	14
HP258-5626	9/16	-	-	14.29	0.5626	152	204	16
HP258-5709	-	-	-	14.50	0.5709	152	204	16
HP258-5780	37/64	-	-	14.68	0.5780	152	204	16
HP258-5787	-	-	-	14.70	0.5787	152	204	16
HP258-5906	-	-	-	15.00	0.5906	152	204	16
HP258-5937	19/32	-	-	15.08	0.5937	152	204	16
HP258-6102	-	-	-	15.50	0.6102	152	204	16
HP258-6181	-	-	-	15.70	0.6181	152	204	16
HP258-6248	5/8	-	-	15.87	0.6248	152	204	16
HP258-6299	-	-	-	16.00	0.6299	152	204	16
HP258-6496	-	-	-	16.50	0.6496	171	223	18
HP258-6563	21/32	-	-	16.67	0.6563	171	223	18
HP258-6693	-	-	-	17.00	0.6693	171	223	18
HP258-6890	-	-	-	17.50	0.6890	171	223	18
HP258-7087	-	-	-	18.00	0.7087	171	223	18
HP258-7283	-	-	-	18.50	0.7283	190	244	20
HP258-7480	-	-	-	19.00	0.7480	190	244	20
HP258-7500	3/4	-	-	19.05	0.7500	190	244	20
HP258-7677	-	-	-	19.50	0.7677	190	244	20
HP258-7874	-	-	-	20.00	0.7874	190	244	20

Packed: 1 pc. Available TiAIN coating only.



Work Material															
List No.	Aluminum		Cast Iron	Carbon Steel	Alloy/Die Steel	Stainless Steels			Hardened Steels			High Heat Materials		MMC	Copper Alloy
	6061 7075	Casting				300	400	17-4PH	~45 HRC	45-50 HRC	50-70 HRC	Ti-Alloy	Inconel & Waspaloy		
HP258		☐	☒	☒	☒		☐	☐	☐	☐					

☐ good ☒ best

HY-PRO® DIN

***Pair a Versatile
Drill with a
Versatile Tap!***

HY-PRO® DIN

OSG's most popular tap is designed for tapping a variety of materials including carbon steels, alloy steels, a variety of stainless steels and hardened steels up to 35HRC. The unique tool geometry and premium vanadium substrate provide exceptional tool life and unequalled consistency.

List 220 & 229

DIN Overall Length, Modified Bottom (2.5P-3P)

List 230 & 239

Coolant-Through, DIN Overall Length,
Modified Bottom (2.5P-3P)



List HP243 – HY-PRO® CARB 3D List HP245 – HY-PRO® CARB 5D

Work Material	Carbon Steels, Mild Steels 1010, 1050, 12L14		Alloy Steels 4140, 4130		Special Alloy Steels, Hardened Steels							
					26 - 30 HRC		30 - 34 HRC		34 - 43 HRC		43 - 53 HRC	
Drilling Speed	240 - 350 SFM		230 - 325 SFM		160 - 240 SFM		110 - 185 SFM		100 - 150 SFM		75 - 100 SFM	
Drill Dia. (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
1	28,623	0.0010 - 0.0020	26,877	0.0010 - 0.0020	19,406	0.0010 - 0.0020	14,263	0.0010 - 0.0015	12,129	0.0010 - 0.0015	8,441	0.0005 - 0.0010
2	14,312	0.0015 - 0.0030	13,438	0.0015 - 0.0030	9,703	0.0015 - 0.0030	7,132	0.0015 - 0.0020	6,064	0.0015 - 0.0020	4,221	0.0010 - 0.0015
3	9,541	0.002 - 0.005	8,959	0.002 - 0.005	6,469	0.002 - 0.005	4,754	0.002 - 0.003	4,043	0.002 - 0.003	2,814	0.001 - 0.002
4	7,156	0.003 - 0.006	6,719	0.003 - 0.006	4,851	0.003 - 0.006	3,566	0.003 - 0.004	3,032	0.003 - 0.004	2,110	0.002 - 0.003
5	5,725	0.004 - 0.008	5,375	0.004 - 0.008	3,881	0.004 - 0.008	2,853	0.004 - 0.005	2,426	0.004 - 0.005	1,688	0.002 - 0.003
6	4,771	0.005 - 0.009	4,479	0.005 - 0.009	3,234	0.005 - 0.009	2,377	0.005 - 0.006	2,021	0.005 - 0.006	1,407	0.002 - 0.004
7	4,089	0.006 - 0.010	3,840	0.006 - 0.010	2,772	0.006 - 0.010	2,038	0.006 - 0.007	1,733	0.006 - 0.007	1,206	0.003 - 0.005
8	3,578	0.006 - 0.011	3,360	0.006 - 0.011	2,426	0.006 - 0.011	1,783	0.006 - 0.008	1,516	0.006 - 0.008	1,055	0.003 - 0.005
9	3,180	0.007 - 0.012	2,986	0.007 - 0.012	2,156	0.007 - 0.012	1,585	0.007 - 0.009	1,348	0.007 - 0.009	938	0.004 - 0.006
10	2,862	0.008 - 0.012	2,688	0.008 - 0.012	1,941	0.008 - 0.012	1,426	0.008 - 0.010	1,213	0.008 - 0.010	844	0.004 - 0.006
11	2,602	0.008 - 0.012	2,443	0.008 - 0.012	1,764	0.008 - 0.012	1,297	0.009 - 0.011	1,103	0.009 - 0.011	767	0.004 - 0.006
12	2,385	0.008 - 0.012	2,240	0.008 - 0.012	1,617	0.008 - 0.012	1,189	0.009 - 0.012	1,011	0.009 - 0.012	703	0.005 - 0.007
13	2,202	0.008 - 0.012	2,067	0.008 - 0.012	1,493	0.008 - 0.012	1,097	0.010 - 0.013	933	0.010 - 0.013	649	0.005 - 0.007
14	2,045	0.009 - 0.014	1,920	0.009 - 0.014	1,386	0.009 - 0.014	1,019	0.011 - 0.014	866	0.011 - 0.014	603	0.006 - 0.008
16	1,789	0.010 - 0.014	1,680	0.010 - 0.014	1,213	0.010 - 0.014	891	0.013 - 0.016	758	0.013 - 0.016	528	0.006 - 0.008
18	1,590	0.011 - 0.015	1,493	0.011 - 0.015	1,078	0.011 - 0.015	792	0.014 - 0.018	674	0.015 - 0.018	469	0.007 - 0.009
20	1,431	0.012 - 0.016	1,344	0.012 - 0.016	970	0.012 - 0.016	713	0.016 - 0.020	606	0.016 - 0.020	422	0.008 - 0.011

Work Material	Cast Iron		Ductile Cast Iron		Stainless Steels 400SS, 17 - 4PH		Copper		Aluminum Alloy		Cast Aluminum	
Drilling Speed	240 - 385 SFM		175 - 300 SFM		82 - 131 SFM		190 - 320 SFM		200 - 380 SFM		260 - 640 SFM	
Drill Dia. (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
1	30,273	0.0010 - 0.0020	23,093	0.0010 - 0.0020	16,010	0.0010 - 0.0020	24,742	0.0010 - 0.0020	26,177	0.0010 - 0.0020	31,994	0.0020 - 0.0030
2	15,136	0.0015 - 0.0030	11,546	0.0015 - 0.0030	8,005	0.0015 - 0.0030	12,371	0.0020 - 0.0030	13,105	0.0020 - 0.0030	18,017	0.0030 - 0.0040
3	10,091	0.002 - 0.005	7,698	0.002 - 0.005	5,337	0.002 - 0.004	8,247	0.003 - 0.005	9,703	0.003 - 0.005	14,554	0.004 - 0.006
4	7,568	0.003 - 0.006	5,773	0.003 - 0.006	4,002	0.003 - 0.005	6,186	0.004 - 0.006	7,277	0.004 - 0.006	10,916	0.005 - 0.007
5	6,055	0.004 - 0.008	4,619	0.004 - 0.008	3,202	0.004 - 0.006	4,948	0.005 - 0.007	5,822	0.005 - 0.007	8,733	0.007 - 0.009
6	5,045	0.005 - 0.009	3,849	0.005 - 0.009	2,668	0.005 - 0.007	4,124	0.006 - 0.008	4,851	0.006 - 0.008	7,277	0.008 - 0.010
7	4,325	0.006 - 0.010	3,299	0.006 - 0.010	2,287	0.006 - 0.008	3,535	0.007 - 0.009	4,158	0.007 - 0.009	6,238	0.010 - 0.012
8	3,784	0.006 - 0.011	2,887	0.006 - 0.011	2,001	0.006 - 0.009	3,093	0.008 - 0.010	3,639	0.008 - 0.010	5,458	0.012 - 0.014
9	3,364	0.007 - 0.012	2,566	0.007 - 0.012	1,779	0.007 - 0.010	2,749	0.010 - 0.012	3,234	0.010 - 0.012	4,851	0.013 - 0.015
10	3,027	0.008 - 0.012	2,309	0.008 - 0.012	1,601	0.008 - 0.010	2,474	0.011 - 0.013	2,911	0.011 - 0.013	4,366	0.015 - 0.017
11	2,752	0.008 - 0.012	2,099	0.008 - 0.012	1,455	0.008 - 0.010	2,249	0.012 - 0.014	2,646	0.012 - 0.014	3,969	0.016 - 0.018
12	2,523	0.008 - 0.012	1,924	0.008 - 0.012	1,334	0.008 - 0.010	2,062	0.013 - 0.015	2,426	0.013 - 0.015	3,639	0.018 - 0.020
13	2,329	0.008 - 0.012	1,776	0.008 - 0.012	1,232	0.008 - 0.010	1,903	0.014 - 0.016	2,239	0.014 - 0.016	3,359	0.019 - 0.021
14	2,162	0.009 - 0.014	1,649	0.009 - 0.014	1,144	0.009 - 0.011	1,767	0.016 - 0.018	2,079	0.016 - 0.018	3,119	0.021 - 0.023
16	1,892	0.010 - 0.014	1,443	0.010 - 0.014	1,001	0.010 - 0.012	1,546	0.018 - 0.020	1,819	0.018 - 0.020	2,729	0.024 - 0.026
18	1,682	0.011 - 0.015	1,283	0.011 - 0.015	889	0.011 - 0.013	1,375	0.020 - 0.022	1,617	0.020 - 0.022	2,426	0.026 - 0.030
20	1,514	0.012 - 0.016	1,155	0.012 - 0.016	800	0.012 - 0.014	1,237	0.022 - 0.024	1,455	0.022 - 0.024	2,183	0.028 - 0.032

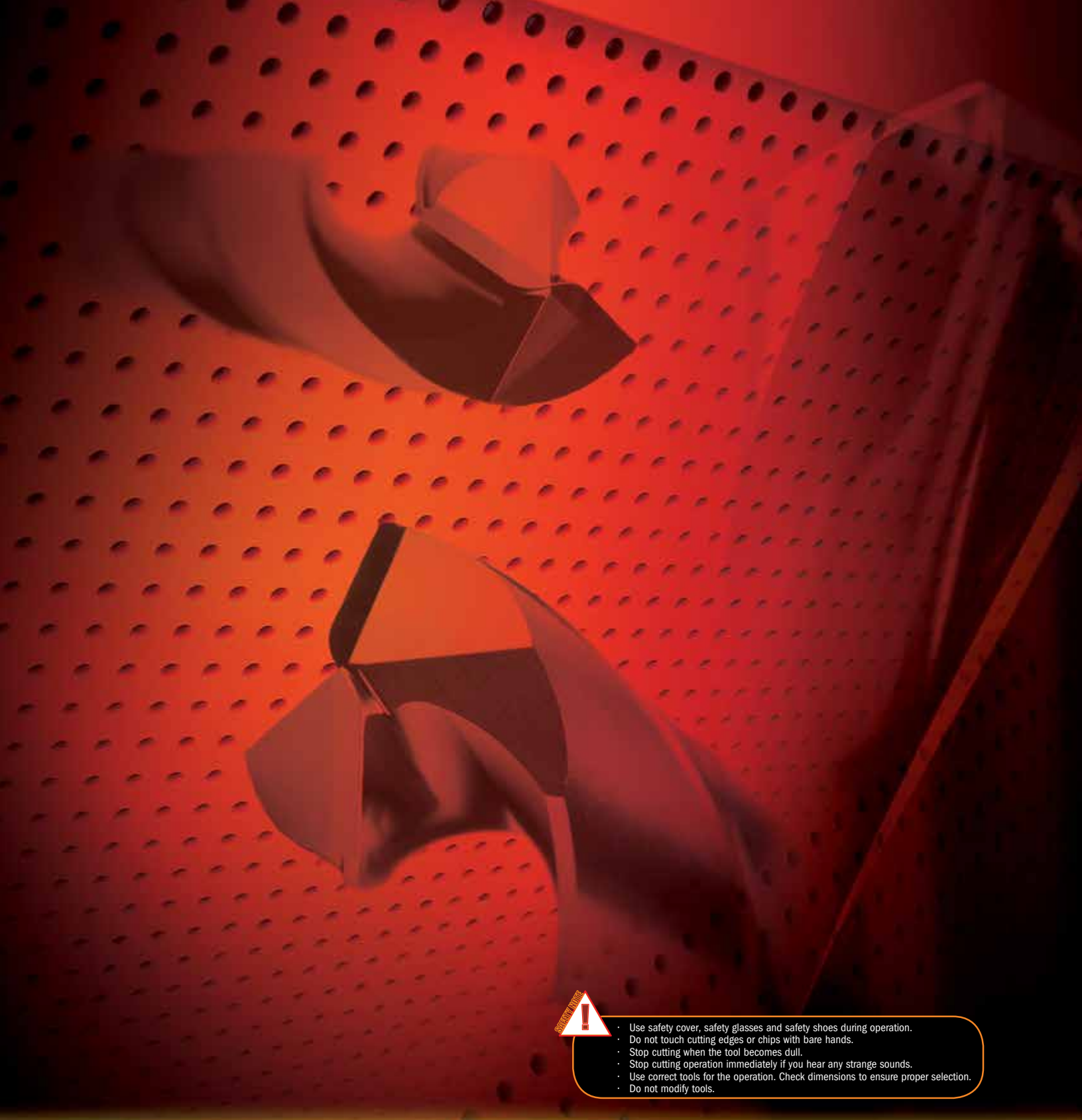
List HP253 – HY-PRO® CARB 3D Coolant-Through

List HP255 – HY-PRO® CARB 5D Coolant-Through

List HP258 – HY-PRO® CARB 8D Coolant-Through

Work Material	Carbon Steels, Mild Steels 1010, 1050, 12L14		Alloy Steels 4140, 4130		Special Alloy Steels, Hardened Steels							
					26 - 30 HRC		30 - 34 HRC		34 - 43 HRC		43 - 53 HRC	
Drilling Speed	310 - 455 SFM		265 - 380 SFM		185 - 295 SFM		130 - 210 SFM		120 - 180 SFM		80 - 110 SFM	
Drill Dia. (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
3	11,449	0.002-0.005	10,751	0.002-0.005	7,762	0.002-0.005	5,705	0.002 - 0.003	4,851	0.002 - 0.003	3,095	0.001 - 0.002
4	8,587	0.003-0.006	8,063	0.003-0.006	5,822	0.003-0.006	4,279	0.003 - 0.004	3,639	0.003 - 0.004	2,321	0.002 - 0.003
5	6,870	0.004-0.008	6,450	0.004-0.008	4,657	0.004-0.008	3,423	0.004 - 0.005	2,911	0.004 - 0.005	1,857	0.002 - 0.003
6	5,725	0.005-0.009	5,375	0.005-0.009	3,881	0.005-0.009	2,853	0.005 - 0.006	2,426	0.005 - 0.006	1,548	0.002 - 0.004
7	4,907	0.006-0.010	4,607	0.006-0.010	3,327	0.006-0.010	2,445	0.006 - 0.007	2,079	0.006 - 0.007	1,327	0.003 - 0.005
8	4,293	0.006-0.011	4,032	0.006-0.011	2,911	0.006-0.011	2,139	0.006 - 0.008	1,819	0.006 - 0.008	1,161	0.003 - 0.005
9	3,816	0.007-0.012	3,584	0.007-0.012	2,587	0.007-0.012	1,902	0.007 - 0.009	1,617	0.007 - 0.009	1,032	0.004 - 0.006
10	3,435	0.008-0.012	3,225	0.008-0.012	2,329	0.008-0.012	1,712	0.008 - 0.010	1,455	0.008 - 0.010	929	0.004 - 0.006
11	3,123	0.008-0.012	2,932	0.008-0.012	2,117	0.008-0.012	1,556	0.009 - 0.011	1,323	0.009 - 0.011	844	0.004 - 0.006
12	2,862	0.008-0.012	2,688	0.008-0.012	1,941	0.008-0.012	1,426	0.009 - 0.012	1,213	0.009 - 0.012	774	0.005 - 0.007
13	2,642	0.008-0.012	2,481	0.008-0.012	1,791	0.008-0.012	1,317	0.010 - 0.013	1,120	0.010 - 0.013	714	0.005 - 0.007
14	2,453	0.009-0.014	2,304	0.009-0.014	1,663	0.009-0.014	1,223	0.011 - 0.014	1,040	0.011 - 0.014	663	0.006 - 0.008
16	2,147	0.010-0.014	2,016	0.010-0.014	1,455	0.010-0.014	1,070	0.013 - 0.016	910	0.013 - 0.016	580	0.006 - 0.008
18	1,908	0.011-0.015	1,792	0.011-0.015	1,294	0.011-0.015	951	0.014 - 0.018	809	0.015 - 0.018	516	0.007 - 0.009
20	1,717	0.012-0.016	1,613	0.012-0.016	1,164	0.012-0.016	856	0.016 - 0.020	728	0.016 - 0.020	464	0.008 - 0.011

Work Material	Cast Iron		Ductile Cast Iron		Stainless Steels 300SS, 400SS, 17 - 4PH		Copper		Aluminum Alloy		Cast Aluminum	
Drilling Speed	285 - 420 SFM		215 - 350 SFM		145 - 220 SFM		230 - 380 SFM		260 - 450 SFM		325 - 700 SFM	
Drill Dia. (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
3	12,614	0.002-0.005	9,622	0.002-0.005	6,137	0.002-0.004	10,722	0.003 - 0.005	13,099	0.003 - 0.005	19,648	0.004 - 0.006
4	9,460	0.003-0.006	7,216	0.003-0.006	4,603	0.003-0.005	7,113	0.004 - 0.006	9,824	0.004 - 0.006	14,736	0.005 - 0.007
5	7,568	0.004-0.008	5,773	0.004-0.008	3,682	0.004-0.006	5,691	0.005 - 0.007	7,859	0.005 - 0.007	11,789	0.007 - 0.009
6	6,307	0.005-0.009	4,811	0.005-0.009	3,069	0.005-0.007	4,742	0.006 - 0.008	6,549	0.006 - 0.008	9,824	0.008 - 0.010
7	5,406	0.006-0.010	4,124	0.006-0.010	2,630	0.006-0.008	4,065	0.007 - 0.009	5,614	0.007 - 0.009	8,421	0.010 - 0.012
8	4,730	0.006-0.011	3,608	0.006-0.011	2,301	0.006-0.009	3,557	0.008 - 0.010	4,912	0.008 - 0.010	7,368	0.012 - 0.014
9	4,205	0.007-0.012	3,207	0.007-0.012	2,046	0.007-0.010	3,161	0.010 - 0.012	4,366	0.010 - 0.012	6,549	0.013 - 0.015
10	3,784	0.008-0.012	2,887	0.008-0.012	1,841	0.008-0.010	2,845	0.011 - 0.013	3,930	0.011 - 0.013	5,894	0.015 - 0.017
11	3,440	0.008-0.012	2,624	0.008-0.012	1,674	0.008-0.010	2,587	0.012 - 0.014	3,572	0.012 - 0.014	5,359	0.016 - 0.018
12	3,153	0.008-0.012	2,405	0.008-0.012	1,534	0.008-0.010	2,371	0.013 - 0.015	3,275	0.013 - 0.015	4,912	0.018 - 0.020
13	2,911	0.008-0.012	2,220	0.008-0.012	1,416	0.008-0.010	2,189	0.014 - 0.016	3,023	0.014 - 0.016	4,534	0.019 - 0.021
14	2,703	0.009-0.014	2,062	0.009-0.014	1,315	0.009-0.011	2,032	0.016 - 0.018	2,807	0.016 - 0.018	4,210	0.021 - 0.023
16	2,365	0.010-0.014	1,804	0.010-0.014	1,151	0.010-0.012	1,778	0.018 - 0.020	2,456	0.018 - 0.020	3,684	0.024 - 0.026
18	2,102	0.011-0.015	1,604	0.011-0.015	1,023	0.011-0.013	1,581	0.020 - 0.022	2,183	0.020 - 0.022	3,275	0.026 - 0.030
20	1,892	0.012-0.016	1,443	0.012-0.016	921	0.012-0.014	1,423	0.022 - 0.024	1,965	0.022 - 0.024	2,947	0.028 - 0.032



- Use safety cover, safety glasses and safety shoes during operation.
- Do not touch cutting edges or chips with bare hands.
- Stop cutting when the tool becomes dull.
- Stop cutting operation immediately if you hear any strange sounds.
- Use correct tools for the operation. Check dimensions to ensure proper selection.
- Do not modify tools.



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