

# ACCUHOLE D40 DRILLS

For hardened, treated, abrasive materials and stainless steel

## 2 Straight Flutes

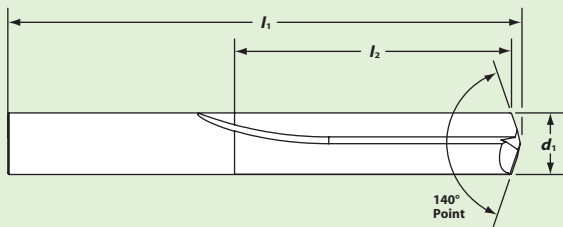
For shallow drilling of hard materials

# D40

Solid carbide



AccuHole drills are commonly used in hardened steels, stainless steels, aerospace alloys and other exotic materials. The point geometry allows easy penetration of the workpiece with minimal deflection, reducing heat generation and producing accurate hole sizes without annealing the work material. The extra web thickness of straight flute design gives added toughness needed when drilling hard materials.



in  $d_1 +0.0/-0.0005$

mm  $d_1 h7$

- Thick web for added strength
- Stub length for extra rigidity

	Carbon & tool steels $\leq 48$ HRC	✓
	Carbon & tool steels $> 48$ HRC	✓✓
	Stainless steels	✓
	Super alloys, Inconel® & titanium	✓
	Cast irons	✓

✓ Good ✓✓ Very Good

Inch • Metric • Continued

	$d_1$ Cutter Dia Inch Metric	Dec Equiv	$l_2$ Flute Length	$l_1$ Overall Length	EDP Number	List Price
	1	.0394	9	32	41600	11.55
#60		.0400	1/2	1-1/2	41865	11.55
#59		.0410	1/2	1-1/2	41864	11.55
#58		.0420	1/2	1-1/2	41863	11.55
#57		.0430	1/2	1-1/2	41862	11.55
	1,1	.0433	9	32	41601	11.55
#56		.0465	1/2	1-1/2	41861	11.55
<b>3/64</b>		.0469	1/2	1-1/2	41750	11.55
	1,2	.0472	9	32	41602	11.66
	1,25	.0492	9	32	41603	11.66
	1,3	.0512	9	32	41604	11.66
#55		.0520	1/2	1-5/8	41860	11.66
#54		.0550	1/2	1-5/8	41859	11.66
	1,4	.0551	9	32	41605	11.66
	1,5	.0591	9	32	41606	11.66
#53		.0595	1/2	1-5/8	41858	11.66
<b>1/16</b>		.0625	5/8	1-5/8	41751	11.18
	1,6	.0630	10	34	41607	11.92
#52		.0635	11/16	1-11/16	41857	11.87
	1,7	.0669	10	34	41608	12.13
#51		.0670	11/16	1-11/16	41856	11.87
	1,75	.0689	11	36	41609	12.23
#50		.0700	11/16	1-11/16	41855	12.02
	1,8	.0709	11	36	41610	12.34
#49		.0730	11/16	1-11/16	41854	12.23
	1,9	.0748	11	36	41611	12.55
<b>5/64</b>		.0781	11/16	1-11/16	41752	11.76
#47		.0785	3/4	1-3/4	41852	12.50
	2	.0787	12	38	41612	12.55
#46		.0810	3/4	1-3/4	41851	12.50
#45		.0820	3/4	1-3/4	41850	12.92
	2,1	.0827	12	38	41613	12.81
#44		.0860	3/4	1-3/4	41849	13.07
	2,2	.0866	13	40	41614	13.02
#43		.0890	3/4	1-3/4	41848	13.23
	2,3	.0906	13	40	41615	13.34
#42		.0935	3/4	1-3/4	41847	13.44
<b>3/32</b>		.0938	3/4	1-3/4	41753	12.97
	2,4	.0945	14	43	41616	13.65
#41		.0960	13/16	1-13/16	41846	13.65
#40		.0980	13/16	1-13/16	41845	14.12
	2,5	.0984	14	43	41617	14.18
#39		.0995	13/16	1-13/16	41844	13.65
#38		.1015	13/16	1-13/16	41843	14.60
	2,6	.1024	14	43	41618	14.44
#37		.1040	13/16	1-13/16	41842	14.60
	2,7	.1063	16	46	41619	14.81
#36		.1065	13/16	1-13/16	41841	14.60
<b>7/64</b>		.1094	13/16	1-13/16	41754	14.12
	2,8	.1102	16	46	41620	15.44
#34		.1110	7/8	1-7/8	41839	15.65
#33		.1130	7/8	1-7/8	41838	15.65
	2,9	.1142	16	46	41621	15.86
#32		.1160	7/8	1-7/8	41837	15.96

# ACCUHOLE D40 DRILLS

For hardened, treated, abrasive materials and stainless steel

## Inch • Metric • Continued

	$d_1$ Cutter Dia Inch Metric	Dec Equiv	$l_2$ Flute Length	$l_1$ Overall Length	EDP Number	List Price
	3	.1181	16	46	41622	15.86
#31		.1200	7/8	1-7/8	41836	15.96
	3,1	.1220	18	49	41623	16.75
<b>1/8</b>		.1250	7/8	1-7/8	41755	14.39
	3,2	.1260	18	49	41624	17.54
#30		.1285	15/16	1-15/16	41835	16.17
	3,3	.1299	18	49	41625	19.01
	3,4	.1339	20	52	41626	19.74
#29		.1360	15/16	1-15/16	41834	16.17
	3,5	.1378	20	52	41627	21.32
<b>9/64</b>		.1406	15/16	1-15/16	41756	17.22
	3,6	.1417	20	52	41628	20.48
#27		.1440	1	2-1/16	41832	19.22
	3,7	.1457	20	52	41629	20.53
#26		.1470	1	2-1/16	41831	19.53
#25		.1495	1	2-1/16	41830	19.69
	3,8	.1496	22	55	41630	20.69
<b>5/32</b>		.1562	1	2-1/16	41757	19.01
	4	.1575	22	55	41631	21.42
#21		.1590	1-1/16	2-1/8	41826	21.47
#20		.1610	1-1/16	2-1/8	41825	21.63
	4,1	.1614	22	55	41682	21.74
	4,2	.1654	22	55	41633	21.84
	4,3	.1693	24	58	41634	22.84
<b>11/64</b>		.1719	1-1/16	2-1/8	41758	23.31
#16		.1770	1-1/8	2-3/16	41821	23.68
	4,5	.1772	24	58	41635	23.84
	4,6	.1811	24	58	41683	24.36
#14		.1820	1-1/8	2-3/16	41819	23.99
#13		.1850	1-1/8	2-3/16	41818	24.36
<b>3/16</b>		.1875	1-1/8	2-3/16	41759	21.32
	4,8	.1890	26	62	41637	25.83
#12		.1890	1-1/8	2-3/16	41817	24.68
#11		.1910	1-1/8	2-3/16	41816	25.10
#10		.1935	1-1/8	2-3/16	41815	25.36
#9		.1960	1-3/16	2-1/4	41814	25.94
	5	.1969	26	62	41638	26.88
	5,1	.2008	26	62	41639	27.93
#7		.2010	1-3/16	2-1/4	41812	27.09
<b>13/64</b>		.2031	1-3/16	2-1/4	41760	27.14
	5,2	.2047	26	62	41684	29.09
	5,3	.2087	26	62	41641	31.29
#4		.2090	1-1/4	2-3/8	41809	28.77
	5,4	.2126	26	62	41642	32.34
#3		.2130	1-1/4	2-3/8	41808	29.98
	5,5	.2165	28	66	41643	32.29
<b>7/32</b>		.2188	1-1/4	2-3/8	41761	27.14
	5,6	.2205	28	66	41644	33.60
	5,7	.2244	28	66	41645	33.71
#1		.2280	1-5/16	2-7/16	41806	31.61
	5,8	.2283	28	66	41646	33.92
	5,9	.2323	28	66	41647	34.07
<b>15/64</b>		.2344	1-5/16	2-7/16	41762	34.02
	6	.2362	28	66	41648	30.71

## Inch • Metric • Continued

	$d_1$ Cutter Dia Inch Metric	Dec Equiv	$l_2$ Flute Length	$l_1$ Overall Length	EDP Number	List Price
	6,1	.2402	31	70	41649	35.07
	6,2	.2441	31	70	41650	36.02
	6,3	.2480	31	70	41651	37.91
<b>1/4</b>		.2500	1-3/8	2-1/2	41763	30.61
	6,4	.2520	31	70	41652	38.85
	6,5	.2559	31	70	41653	38.54
F		.2570	1-7/16	2-5/8	41785	45.15
<b>17/64</b>		.2656	1-7/16	2-5/8	41764	38.43
	6,8	.2677	34	74	41654	43.05
	6,9	.2717	34	74	41655	43.84
I		.2720	1-1/2	2-11/16	41788	48.09
	7	.2756	34	74	41656	39.32
	7,1	.2795	34	74	41657	45.89
<b>9/32</b>		.2812	1-1/2	2-11/16	41765	39.53
	7,2	.2835	34	74	41658	47.04
	7,3	.2874	34	74	41659	49.56
	7,4	.2913	34	74	41660	50.77
	7,5	.2953	34	74	41661	42.79
<b>19/64</b>		.2969	1-9/16	2-3/4	41766	42.79
	7,8	.3071	37	79	41662	54.81
	7,9	.3110	37	79	41663	54.92
<b>5/16</b>		.3125	1-5/8	2-13/16	41767	42.68
	8	.3150	37	79	41664	42.68
	8,1	.3189	37	79	41665	55.34
	8,3	.3268	37	79	41666	56.02
<b>21/64</b>		.3281	1-11/16	2-15/16	41768	44.47
Q		.3320	1-11/16	3	41796	61.11
	8,5	.3346	37	79	41667	48.25
<b>11/32</b>		.3438	1-11/16	3	41769	49.30
	8,8	.3465	40	84	41668	70.04
	9	.3543	40	84	41669	55.44
<b>23/64</b>		.3594	1-3/4	3-1/16	41770	54.23
	9,3	.3661	40	84	41670	80.59
U		.3680	1-13/16	3-1/8	41800	75.29
	9,5	.3740	40	84	41685	61.74
<b>3/8</b>		.3750	1-13/16	3-1/8	41771	58.70
	9,7	.3819	43	89	41672	84.11
	9,9	.3898	43	89	41673	85.10
<b>25/64</b>		.3906	1-7/8	3-1/4	41772	65.52
	10	.3937	43	89	41674	65.73
	10,2	.4016	43	89	41675	89.15
<b>13/32</b>		.4062	1-15/16	3-5/16	41773	81.11
	10,5	.4134	43	89	41676	82.37
<b>27/64</b>		.4219	2	3-3/8	41774	81.43
	10,8	.4252	47	95	41677	105.68
	11	.4331	47	95	41678	84.42
<b>7/16</b>		.4375	2-1/16	3-7/16	41775	83.69
	11,5	.4528	47	95	41679	93.29
<b>15/32</b>		.4688	2-1/8	3-5/8	41777	92.82
	12	.4724	51	102	41680	90.72
	12,5	.4921	51	102	41681	134.87
<b>1/2</b>		.5000	2-1/4	3-3/4	41779	90.41