

DISCOVER OUR

DRILLING



Drilling

NOMENCLATURE

CROMSON «DRILL»

CUTTING FLUID

0 - External
1 - Internal

CRDR-HP-C2105-0300-Cr85

APPLICATIONS

G- General
HP- High Performance
AC- Accuracy
SF- Surface Finish
SP- Spot Drill

TOOL TYPE

C1000- EFFICIENCY
C2100- CROMINOX
C3100- MINIATURE
C4100- CROMSTEEL
C5100- CONCENTRICITY (Double margin)
C6100- HIGH PRECISION QUALITY
C7100- DRILL & REAM (Triple margin)
C8100- CROMALU
C9100- HIGH PERFORMANCE

COATING

Cr10- Uncoated
Cr15- AlTiN
Cr65- TiAlN
Cr85- TiAlN+

Summary application chart-Drilling

Work Material	Hardness Rockwell (HRc) Hardness Brinnel (BHN) Tensile Strength (N/mm2)			Series #		
	HRc	BHN	N/mm2	EFFICIENCY C1100 C1000	CROMINOX C2100	MINIATURE C3100
	Non-alloy steel, cast steel 1018, 1108, 1161, 12L14, 1522, 1572	up to 8 up to 15 over 15	up to 178 up to 205 over 205	up to 600 up to 700 over 700		
Alloyed steel 5132, 4130, 8620, 4340, 5140, 6150 Stainless steel 410, 416	up to 27 up to 31 over 31	up to 266 up to 297 over 297	up to 900 up to 1000 over 1000			
Stainless steel moderate 17-4PH, 15-5PH, 316L						
Stainless and acid resistant steel (Cr-Ni-Alloys) 304, 316, 17CrNi16-2						
Cast iron, grey cast iron alloy GG10-GG40, A48	up to 14 up to 24 over 24	up to 200 up to 250 over 2050	up to 680 up to 850 over 850			
Spheroidal graphite cast iron, cast iron with vermicular graphite, malleable iron GGG40. GGG80	up to 8 over 8	up to 178 over 178	up to 600 over 650			
Aluminum (Si content >10%) 6061, 2025, 208, 360						
Aluminum (Si content <10%) 413, 385, A390						
Copper, brass, bronze beryllium copper, naval brass, AMPCO						
Titanium alloy TiAl4V						
High temperature alloy Inconel, haynes, waspaloy, hastelloy						
Chilled cast iron	38-48	350-450	1173-1527			
Hardened steel 50-60 HRc	50-55 56-60 61-65		1614-1870			



Highly recommended

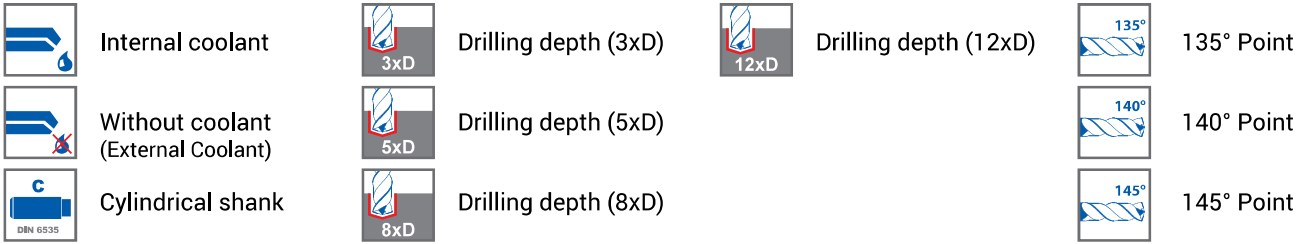


Suitable for some applications



Series #					
CROMSTEEL C4100	CONCENTRICITY C5100	HIGH PRECISION C6100	DRILLREAM C7100	CROMALU C8100	HIGH PERFORMANCE C9100

Explanation of Drilling symbols



GENERAL INFORMATION REGARDING THE CATALOG

d1 = Tool diameter (metric / imperial)

l1 = Overall length

l3 = Cutting length (maximum drilling)

d2 = Shank diameter

l2 = Groove length

l4 = Shank length

Grades chart & Drilling application

CROMSON offers a variety of coatings upon special request to meet the demands of every customer's needs and application. Through extensive testing, research and real world applications, CROMSON has worked to develop a full range of high performance coatings, available to our customers. These coating options allow us to address a multitude of situations with optimal results.

Please refer to the chart below for the various coatings available.


CROMSON GRADE

	Cr10	Cr15	Cr65	Cr85	CrXX
Proprietary	Uncoated	AlTiN	TiAlN	TiAlN+	DLC
Coating process		PVD	PVD	PVD	
Layer structure		Nano structure	Nano structure	Nano structure	
Hardness (HV)		3300	3300	3300	
Coefficient of friction (fetting)		0.30-0.35	0.20	0.25	
Thermal stability (C)		900	600	900	
General Information		Excellent thermal and chemical resistance allows for dry cutting and improvements in performance of carbide drills. High hardness of the coating gives great protection against abrasive wear and erosion.	CROMSON Cr65 coating processed further to help reduce the coefficient of friction even further. For extremely difficult drilling applications with a high tendency for material adhesion and built-up edge.	Offers all the advantages of TiAlN with a reduced coefficient of friction. Therefore ideal coating for drills: excellent chip removal and reduced cutting forces.	Available on request (SPECIAL)

CROMALU

C8000 SERIES

- ⊙ CROMSON offers a twin cutting technology for machining Aluminum
- ⊙ For drilling depths from 3xD to 12xD, the CROMALU offers optimum cost-effectiveness with high performance
- ⊙ The specialised drill features helical grooves and its large chip flutes and special radial geometry delivers very high drilling quality

Work Material	Hardness Rockwell (HRc) Hardness Brinnel (BHN) Tensile Strength (N/mm2)			C8100
	HRc	BHN	N/mm2	
Aluminum (Si content >10%) 6061, 2025, 208, 360				
Aluminum (Si content <10%) 413, 385, A390				
Copper, brass, bronze beryllium copper, naval brass, AMPCO				



Highly recommended



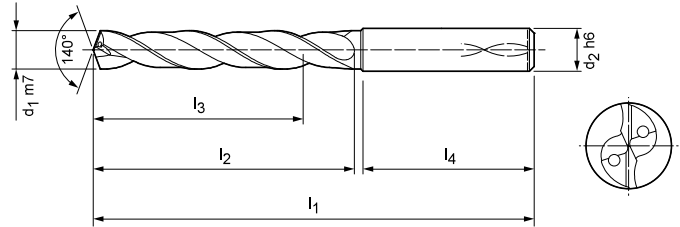
Suitable for some applications.

CARBIDE DRILL

TECHNICAL DETAILS

Tool Diameter Range 0.1181-0.6299 in
3.00-16.00 mm

Bore tolerance IT9 (achievable)
Shank form Cyl. (DIN 6535)
Number of flutes 2
Number of margins 1
Point geometry Special point
Point angle 140°
Helix angle 30°
Coolant Internal



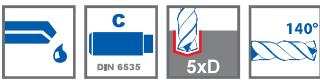
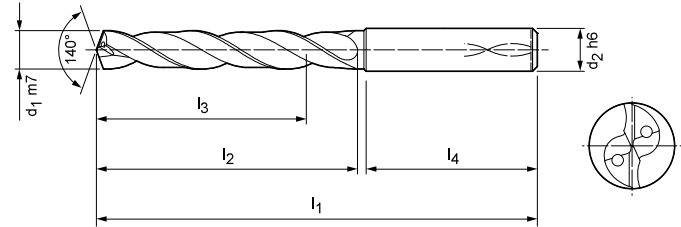
EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75105895	CRDR G-C8103-0300 Cr10	3.000	0.1181	6	20	62	36	Cr10	2
75105900	CRDR G-C8103-0350 Cr10	3.500	0.1378	6	20	62	36	Cr10	2
75105905	CRDR G-C8103-0400 Cr10	4.000	0.1575	6	24	66	36	Cr10	2
75105910	CRDR G-C8103-0450 Cr10	4.500	0.1772	6	24	66	36	Cr10	2
75105915	CRDR G-C8103-0500 Cr10	5.000	0.1969	6	28	66	36	Cr10	2
75105920	CRDR G-C8103-0550 Cr10	5.500	0.2165	6	28	66	36	Cr10	2
75105925	CRDR G-C8103-0600 Cr10	6.000	0.2362	6	28	66	36	Cr10	2
75105930	CRDR G-C8103-0650 Cr10	6.500	0.2559	8	34	79	36	Cr10	2
75105935	CRDR G-C8103-0700 Cr10	7.000	0.2756	8	34	79	36	Cr10	2
75105940	CRDR G-C8103-0750 Cr10	7.500	0.2953	8	41	79	36	Cr10	2
75105945	CRDR G-C8103-0800 Cr10	8.000	0.3150	8	41	79	36	Cr10	2
75105950	CRDR G-C8103-0850 Cr10	8.500	0.3346	10	47	89	40	Cr10	2
75105955	CRDR G-C8103-0900 Cr10	9.000	0.3543	10	47	89	40	Cr10	2
75105960	CRDR G-C8103-1000 Cr10	10.000	0.3937	10	47	89	40	Cr10	2
75105965	CRDR G-C8103-1100 Cr10	11.000	0.4331	12	55	102	45	Cr10	2
75105970	CRDR G-C8103-1200 Cr10	12.000	0.4724	12	55	102	45	Cr10	2
75105975	CRDR G-C8103-1300 Cr10	13.000	0.5118	14	60	107	45	Cr10	2
75105980	CRDR G-C8103-1400 Cr10	14.000	0.5512	14	60	107	45	Cr10	2
75105985	CRDR G-C8103-1500 Cr10	15.000	0.5906	16	65	115	48	Cr10	2
75105990	CRDR G-C8103-1600 Cr10	16.000	0.6299	16	65	115	48	Cr10	2

CARBIDE DRILL

TECHNICAL DETAILS

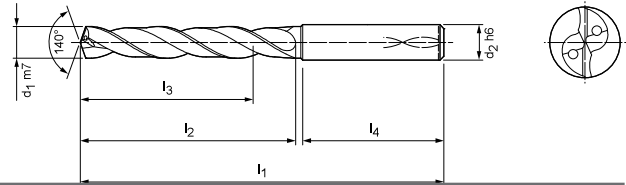
Tool Diameter Range 0.1102-0.7500 in
2.80-19.05 mm

Bore tolerance IT9 (achievable)
Shank form Cyl. (DIN 6535)
Number of flutes 2
Number of margins 1
Point geometry Special point
Point angle 140°
Helix angle 30°
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75105995	CRDR G-C8105-0280 Cr10	2.800	0.1102	6	28	66	36	Cr10	2
75106000	CRDR G-C8105-0300 Cr10	3.000	0.1181	6	28	66	36	Cr10	2
75106005	CRDR G-C8105-0310 Cr10	3.100	0.1220	6	28	66	36	Cr10	2
75106008	CRDR G-C8105-031 Cr10	3.180	1/8	6	28	66	36	Cr10	2
75106010	CRDR G-C8105-0320 Cr10	3.200	0.1260	6	28	66	36	Cr10	2
75106015	CRDR G-C8105-0330 Cr10	3.300	0.1299	6	28	66	36	Cr10	2
75106020	CRDR G-C8105-0340 Cr10	3.400	0.1339	6	28	66	36	Cr10	2
75106025	CRDR G-C8105-0350 Cr10	3.500	0.1378	6	28	66	36	Cr10	2
75106028	CRDR G-C8105-0357 Cr10	3.570	9/64	6	28	66	36	Cr10	2
75106030	CRDR G-C8105-0360 Cr10	3.600	0.1417	6	28	66	36	Cr10	2
75106035	CRDR G-C8105-0370 Cr10	3.700	0.1457	6	28	66	36	Cr10	2
75106040	CRDR G-C8105-0380 Cr10	3.800	0.1496	6	36	74	36	Cr10	2
75106045	CRDR G-C8105-0390 Cr10	3.900	0.1535	6	36	74	36	Cr10	2
75106048	CRDR G-C8105-0397 Cr10	3.970	5/32	6	36	74	36	Cr10	2
75106050	CRDR G-C8105-0400 Cr10	4.000	0.1575	6	36	74	36	Cr10	2
75106055	CRDR G-C8105-0410 Cr10	4.100	0.1614	6	36	74	36	Cr10	2
75106060	CRDR G-C8105-0420 Cr10	4.200	0.1654	6	36	74	36	Cr10	2
75106065	CRDR G-C8105-0430 Cr10	4.300	0.1693	6	36	74	36	Cr10	2
75106068	CRDR G-C8105-0437 Cr10	4.370	11/64	6	36	74	36	Cr10	2
75106070	CRDR G-C8105-0440 Cr10	4.400	0.1732	6	36	74	36	Cr10	2
75106075	CRDR G-C8105-0450 Cr10	4.500	0.1772	6	36	74	36	Cr10	2
75106080	CRDR G-C8105-0460 Cr10	4.600	0.1811	6	36	74	36	Cr10	2
75106085	CRDR G-C8105-0465 Cr10	4.650	0.1831	6	36	74	36	Cr10	2
75106090	CRDR G-C8105-0470 Cr10	4.700	0.1850	6	36	74	36	Cr10	2
75106093	CRDR G-C8105-0476 Cr10	4.760	3/16	6	44	82	36	Cr10	2
75106095	CRDR G-C8105-0480 Cr10	4.800	0.1890	6	44	82	36	Cr10	2
75106100	CRDR G-C8105-0490 Cr10	4.900	0.1929	6	44	82	36	Cr10	2
75106105	CRDR G-C8105-0500 Cr10	5.000	0.1969	6	44	82	36	Cr10	2
75106110	CRDR G-C8105-0510 Cr10	5.100	0.2008	6	44	82	36	Cr10	2
75106113	CRDR G-C8105-0516 Cr10	5.160	13/64	6	44	82	36	Cr10	2
75106115	CRDR G-C8105-0520 Cr10	5.200	0.2047	6	44	82	36	Cr10	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75106120	CRDR G-C8105-0530 Cr10	5.300	0.2087	6	44	82	36	Cr10	2
75106125	CRDR G-C8105-0540 Cr10	5.400	0.2126	6	44	82	36	Cr10	2
75106130	CRDR G-C8105-0550 Cr10	5.500	0.2165	6	44	82	36	Cr10	2
75106135	CRDR G-C8105-0555 Cr10	5.550	0.2185	6	44	82	36	Cr10	2
75106138	CRDR G-C8105-0556 Cr10	5.560	7/32	6	44	82	36	Cr10	2
75106140	CRDR G-C8105-0560 Cr10	5.600	0.2205	6	44	82	36	Cr10	2
75106145	CRDR G-C8105-0570 Cr10	5.700	0.2244	6	44	82	36	Cr10	2
75106150	CRDR G-C8105-0580 Cr10	5.800	0.2283	6	44	82	36	Cr10	2
75106155	CRDR G-C8105-0590 Cr10	5.900	0.2323	6	44	82	36	Cr10	2
75106158	CRDR G-C8105-0595 Cr10	5.950	15/64	6	44	82	36	Cr10	2
75106160	CRDR G-C8105-0600 Cr10	6.000	0.2362	6	44	82	36	Cr10	2
75106165	CRDR G-C8105-0610 Cr10	6.100	0.2402	8	53	91	36	Cr10	2
75106170	CRDR G-C8105-0620 Cr10	6.200	0.2441	8	53	91	36	Cr10	2
75106175	CRDR G-C8105-0630 Cr10	6.300	0.2480	8	53	91	36	Cr10	2
75106178	CRDR G-C8105-0635 Cr10	6.350	1/4	8	53	91	36	Cr10	2
75106180	CRDR G-C8105-0640 Cr10	6.400	0.2520	8	53	91	36	Cr10	2
75106185	CRDR G-C8105-0650 Cr10	6.500	0.2559	8	53	91	36	Cr10	2
75106190	CRDR G-C8105-0660 Cr10	6.600	0.2598	8	53	91	36	Cr10	2
75106195	CRDR G-C8105-0670 Cr10	6.700	0.2638	8	53	91	36	Cr10	2
75106198	CRDR G-C8105-0675 Cr10	6.750	17/64	8	53	91	36	Cr10	2
75106200	CRDR G-C8105-0680 Cr10	6.800	0.2677	8	53	91	36	Cr10	2
75106205	CRDR G-C8105-0690 Cr10	6.900	0.2717	8	53	91	36	Cr10	2
75106210	CRDR G-C8105-0700 Cr10	7.000	0.2756	8	53	91	36	Cr10	2
75106215	CRDR G-C8105-0710 Cr10	7.100	0.2795	8	53	91	36	Cr10	2
75106218	CRDR G-C8105-0714 Cr10	7.140	9/32	8	53	91	36	Cr10	2
75106220	CRDR G-C8105-0720 Cr10	7.200	0.2835	8	53	91	36	Cr10	2
75106225	CRDR G-C8105-0730 Cr10	7.300	0.2874	8	53	91	36	Cr10	2
75106230	CRDR G-C8105-0740 Cr10	7.400	0.2913	8	53	91	36	Cr10	2
75106235	CRDR G-C8105-0745 Cr10	7.450	0.2933	8	53	91	36	Cr10	2
75106240	CRDR G-C8105-0750 Cr10	7.500	0.2953	8	53	91	36	Cr10	2
75106243	CRDR G-C8105-0754 Cr10	7.540	19/64	8	53	91	36	Cr10	2
75106245	CRDR G-C8105-0760 Cr10	7.600	0.2992	8	53	91	36	Cr10	2
75106250	CRDR G-C8105-0770 Cr10	7.700	0.3031	8	53	91	36	Cr10	2
75106255	CRDR G-C8105-0780 Cr10	7.800	0.3071	8	53	91	36	Cr10	2
75106260	CRDR G-C8105-0790 Cr10	7.900	0.3110	8	53	91	36	Cr10	2
75106263	CRDR G-C8105-0794 Cr10	7.940	5/16	8	53	91	36	Cr10	2
75106265	CRDR G-C8105-0800 Cr10	8.000	0.3150	8	53	91	36	Cr10	2
75106270	CRDR G-C8105-0810 Cr10	8.100	0.3189	10	61	103	40	Cr10	2
75106275	CRDR G-C8105-0820 Cr10	8.200	0.3228	10	61	103	40	Cr10	2
75106280	CRDR G-C8105-0830 Cr10	8.300	0.3268	10	61	103	40	Cr10	2
75106283	CRDR G-C8105-0833 Cr10	8.330	21/64	10	61	103	40	Cr10	2
75106285	CRDR G-C8105-0840 Cr10	8.400	0.3307	10	61	103	40	Cr10	2
75106290	CRDR G-C8105-0850 Cr10	8.500	0.3346	10	61	103	40	Cr10	2
75106295	CRDR G-C8105-0860 Cr10	8.600	0.3386	10	61	103	40	Cr10	2
75106300	CRDR G-C8105-0870 Cr10	8.700	0.3425	10	61	103	40	Cr10	2
75106303	CRDR G-C8105-0873 Cr10	8.730	11/32	10	61	103	40	Cr10	2
75106305	CRDR G-C8105-0880 Cr10	8.800	0.3465	10	61	103	40	Cr10	2
75106310	CRDR G-C8105-0890 Cr10	8.900	0.3504	10	61	103	40	Cr10	2
75106315	CRDR G-C8105-0900 Cr10	9.000	0.3543	10	61	103	40	Cr10	2
75106320	CRDR G-C8105-0910 Cr10	9.100	0.3583	10	61	103	40	Cr10	2



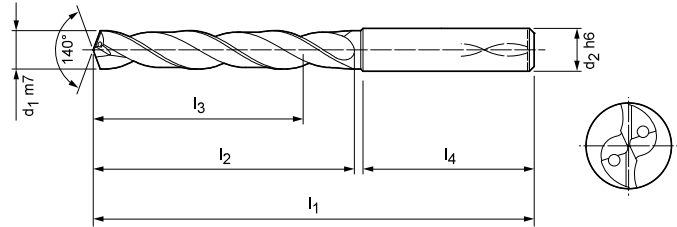
EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75106323	CRDR G-C8105-0913 Cr10	9.130	23/64	10	61	103	40	Cr10	2
75106325	CRDR G-C8105-0920 Cr10	9.200	0.3622	10	61	103	40	Cr10	2
75106330	CRDR G-C8105-0930 Cr10	9.300	0.3661	10	61	103	40	Cr10	2
75106335	CRDR G-C8105-0940 Cr10	9.400	0.3701	10	61	103	40	Cr10	2
75106340	CRDR G-C8105-0950 Cr10	9.500	0.3740	10	61	103	40	Cr10	2
75106343	CRDR G-C8105-0953 Cr10	9.530	3/8	10	61	103	40	Cr10	2
75106345	CRDR G-C8105-0960 Cr10	9.600	0.3780	10	61	103	40	Cr10	2
75106350	CRDR G-C8105-0970 Cr10	9.700	0.3819	10	61	103	40	Cr10	2
75106355	CRDR G-C8105-0980 Cr10	9.800	0.3858	10	61	103	40	Cr10	2
75106360	CRDR G-C8105-0990 Cr10	9.900	0.3898	10	61	103	40	Cr10	2
75106363	CRDR G-C8105-0992 Cr10	9.920	25/64	10	61	103	40	Cr10	2
75106365	CRDR G-C8105-1000 Cr10	10.000	0.3937	10	61	103	40	Cr10	2
75106370	CRDR G-C8105-1010 Cr10	10.100	0.3976	12	71	118	45	Cr10	2
75106375	CRDR G-C8105-1020 Cr10	10.200	0.4016	12	71	118	45	Cr10	2
75106380	CRDR G-C8105-1030 Cr10	10.300	0.4055	12	71	118	45	Cr10	2
75106383	CRDR G-C8105-1032 Cr10	10.320	13/32	12	71	118	45	Cr10	2
75106385	CRDR G-C8105-1040 Cr10	10.400	0.4094	12	71	118	45	Cr10	2
75106390	CRDR G-C8105-1050 Cr10	10.500	0.4134	12	71	118	45	Cr10	2
75106395	CRDR G-C8105-1060 Cr10	10.600	0.4173	12	71	118	45	Cr10	2
75106400	CRDR G-C8105-1070 Cr10	10.700	0.4213	12	71	118	45	Cr10	2
75106403	CRDR G-C8105-1072 Cr10	10.720	27/64	12	71	118	45	Cr10	2
75106405	CRDR G-C8105-1080 Cr10	10.800	0.4252	12	71	118	45	Cr10	2
75106410	CRDR G-C8105-1090 Cr10	10.900	0.4291	12	71	118	45	Cr10	2
75106415	CRDR G-C8105-1100 Cr10	11.000	0.4331	12	71	118	45	Cr10	2
75106418	CRDR G-C8105-1111 Cr10	11.110	7/16	12	71	118	45	Cr10	2
75106420	CRDR G-C8105-1120 Cr10	11.200	0.4409	12	71	118	45	Cr10	2
75106425	CRDR G-C8105-1150 Cr10	11.500	0.4528	12	71	118	45	Cr10	2
75106430	CRDR G-C8105-1200 Cr10	12.000	0.4724	12	71	118	45	Cr10	2
75106435	CRDR G-C8105-1250 Cr10	12.500	0.4921	14	77	124	45	Cr10	2
75106440	CRDR G-C8105-1300 Cr10	13.000	0.5118	14	77	124	45	Cr10	2
75106445	CRDR G-C8105-1350 Cr10	13.500	0.5315	14	77	124	45	Cr10	2
75106450	CRDR G-C8105-1400 Cr10	14.000	0.5512	14	77	124	45	Cr10	2
75106455	CRDR G-C8105-1450 Cr10	14.500	0.5709	16	83	133	48	Cr10	2
75106458	CRDR G-C8105-1468 Cr10	14.680	37/64	16	83	133	48	Cr10	2
75106460	CRDR G-C8105-1480 Cr10	14.800	0.5827	16	83	133	48	Cr10	2
75106465	CRDR G-C8105-1500 Cr10	15.000	0.5906	16	83	133	48	Cr10	2
75106468	CRDR G-C8105-1508 Cr10	15.080	19/32	16	83	133	48	Cr10	2
75106470	CRDR G-C8105-1550 Cr10	15.500	0.6102	16	83	133	48	Cr10	2
75106475	CRDR G-C8105-1580 Cr10	15.800	0.6220	16	83	133	48	Cr10	2
75106478	CRDR G-C8105-1588 Cr10	15.880	5/8	16	83	133	48	Cr10	2
75106480	CRDR G-C8105-1600 Cr10	16.000	0.6299	16	83	133	48	Cr10	2
75106481	CRDR G-C8105-1667 Cr10	16.670	21/32	18	93	143	48	Cr10	2
75106482	CRDR G-C8105-1746 Cr10	17.460	11/16	18	93	143	48	Cr10	2
75106483	CRDR G-C8105-1826 Cr10	18.260	23/32	20	101	153	50	Cr10	2
75106484	CRDR G-C8105-1905 Cr10	19.050	3/4	20	101	153	50	Cr10	2

CARBIDE DRILL

TECHNICAL DETAILS

Tool Diameter Range 0.1181-0.7500 in
3.00-19.05 mm

Bore tolerance IT9 (achievable)
Shank form Cyl. (DIN 6535)
Number of flutes 2
Number of margins 1
Point geometry Special point
Point angle 140°
Helix angle 30°
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75106485	CRDR G-C8112-0300 Cr10	3.000	0.1181	6	54	92	36	Cr10	2
75106490	CRDR G-C8112-0310 Cr10	3.100	0.1220	6	54	92	36	Cr10	2
75106493	CRDR G-C8112-0318 Cr10	3.180	1/8	6	54	92	36	Cr10	2
75106495	CRDR G-C8112-0320 Cr10	3.200	0.1260	6	54	92	36	Cr10	2
75106500	CRDR G-C8112-0330 Cr10	3.300	0.1299	6	54	92	36	Cr10	2
75106505	CRDR G-C8112-0340 Cr10	3.400	0.1339	6	54	92	36	Cr10	2
75106510	CRDR G-C8112-0350 Cr10	3.500	0.1378	6	54	92	36	Cr10	2
75106513	CRDR G-C8112-0357 Cr10	3.570	9/64	6	54	92	36	Cr10	2
75106515	CRDR G-C8112-0360 Cr10	3.600	0.1417	6	54	92	36	Cr10	2
75106520	CRDR G-C8112-0370 Cr10	3.700	0.1457	6	54	92	36	Cr10	2
75106525	CRDR G-C8112-0380 Cr10	3.800	0.1496	6	64	102	36	Cr10	2
75106530	CRDR G-C8112-0390 Cr10	3.900	0.1535	6	64	102	36	Cr10	2
75106533	CRDR G-C8112-0397 Cr10	3.970	5/32	6	64	102	36	Cr10	2
75106535	CRDR G-C8112-0400 Cr10	4.000	0.1575	6	64	102	36	Cr10	2
75106540	CRDR G-C8112-0410 Cr10	4.100	0.1614	6	64	102	36	Cr10	2
75106545	CRDR G-C8112-0420 Cr10	4.200	0.1654	6	64	102	36	Cr10	2
75106550	CRDR G-C8112-0430 Cr10	4.300	0.1693	6	64	102	36	Cr10	2
75106553	CRDR G-C8112-0437 Cr10	4.370	11/64	6	64	102	36	Cr10	2
75106555	CRDR G-C8112-0440 Cr10	4.400	0.1732	6	64	102	36	Cr10	2
75106560	CRDR G-C8112-0450 Cr10	4.500	0.1772	6	64	102	36	Cr10	2
75106565	CRDR G-C8112-0460 Cr10	4.600	0.1811	6	64	102	36	Cr10	2
75106570	CRDR G-C8112-0470 Cr10	4.700	0.1850	6	64	102	36	Cr10	2
75106573	CRDR G-C8112-0476 Cr10	4.760	3/16	6	78	116	36	Cr10	2
75106575	CRDR G-C8112-0480 Cr10	4.800	0.1890	6	78	116	36	Cr10	2
75106580	CRDR G-C8112-0490 Cr10	4.900	0.1929	6	78	116	36	Cr10	2
75106585	CRDR G-C8112-0500 Cr10	5.000	0.1969	6	78	116	36	Cr10	2
75106590	CRDR G-C8112-0510 Cr10	5.100	0.2008	6	78	116	36	Cr10	2
75106593	CRDR G-C8112-0516 Cr10	5.160	13/64	6	78	116	36	Cr10	2
75106595	CRDR G-C8112-0520 Cr10	5.200	0.2047	6	78	116	36	Cr10	2
75106600	CRDR G-C8112-0530 Cr10	5.300	0.2087	6	78	116	36	Cr10	2
75106605	CRDR G-C8112-0540 Cr10	5.400	0.2126	6	78	116	36	Cr10	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (ℓ2)	OAL (ℓ1)	Shank length (ℓ4)	Cromson Grade	# Flutes
75106610	CRDR G-C8112-0550 Cr10	5.500	0.2165	6	78	116	36	Cr10	2
75106613	CRDR G-C8112-0556 Cr10	5.560	7/32	6	78	116	36	Cr10	2
75106615	CRDR G-C8112-0560 Cr10	5.600	0.2205	6	78	116	36	Cr10	2
75106620	CRDR G-C8112-0570 Cr10	5.700	0.2244	6	78	116	36	Cr10	2
75106625	CRDR G-C8112-0580 Cr10	5.800	0.2283	6	78	116	36	Cr10	2
75106630	CRDR G-C8112-0590 Cr10	5.900	0.2323	6	78	116	36	Cr10	2
75106633	CRDR G-C8112-0595 Cr10	5.950	15/64	6	78	116	36	Cr10	2
75106635	CRDR G-C8112-0600 Cr10	6.000	0.2362	6	78	116	36	Cr10	2
75106640	CRDR G-C8112-0610 Cr10	6.100	0.2402	8	108	146	36	Cr10	2
75106645	CRDR G-C8112-0620 Cr10	6.200	0.2441	8	108	146	36	Cr10	2
75106650	CRDR G-C8112-0630 Cr10	6.300	0.2480	8	108	146	36	Cr10	2
75106653	CRDR G-C8112-0635 Cr10	6.350	1/4	8	108	146	36	Cr10	2
75106655	CRDR G-C8112-0640 Cr10	6.400	0.2520	8	108	146	36	Cr10	2
75106660	CRDR G-C8112-0650 Cr10	6.500	0.2559	8	108	146	36	Cr10	2
75106665	CRDR G-C8112-0660 Cr10	6.600	0.2598	8	108	146	36	Cr10	2
75106670	CRDR G-C8112-0670 Cr10	6.700	0.2638	8	108	146	36	Cr10	2
75106673	CRDR G-C8112-0675 Cr10	6.750	17/64	8	108	146	36	Cr10	2
75106675	CRDR G-C8112-0690 Cr10	6.900	0.2717	8	108	146	36	Cr10	2
75106680	CRDR G-C8112-0700 Cr10	7.000	0.2756	8	108	146	36	Cr10	2
75106685	CRDR G-C8112-0710 Cr10	7.100	0.2795	8	108	146	36	Cr10	2
75106688	CRDR G-C8112-0714 Cr10	7.140	9/32	8	108	146	36	Cr10	2
75106690	CRDR G-C8112-0720 Cr10	7.200	0.2835	8	108	146	36	Cr10	2
75106695	CRDR G-C8112-0730 Cr10	7.300	0.2874	8	108	146	36	Cr10	2
75106700	CRDR G-C8112-0740 Cr10	7.400	0.2913	8	108	146	36	Cr10	2
75106705	CRDR G-C8112-0750 Cr10	7.500	0.2953	8	108	146	36	Cr10	2
75106708	CRDR G-C8112-0754 Cr10	7.540	19/64	8	108	146	36	Cr10	2
75106710	CRDR G-C8112-0760 Cr10	7.600	0.2992	8	108	146	36	Cr10	2
75106715	CRDR G-C8112-0770 Cr10	7.700	0.3031	8	108	146	36	Cr10	2
75106720	CRDR G-C8112-0780 Cr10	7.800	0.3071	8	108	146	36	Cr10	2
75106725	CRDR G-C8112-0790 Cr10	7.900	0.3110	8	108	146	36	Cr10	2
75106728	CRDR G-C8112-0794 Cr10	7.940	5/16	8	108	146	36	Cr10	2
75106730	CRDR G-C8112-0800 Cr10	8.000	0.3150	8	108	146	36	Cr10	2
75106735	CRDR G-C8112-0810 Cr10	8.100	0.3189	10	120	162	40	Cr10	2
75106740	CRDR G-C8112-0820 Cr10	8.200	0.3228	10	120	162	40	Cr10	2
75106745	CRDR G-C8112-0830 Cr10	8.300	0.3268	10	120	162	40	Cr10	2
75106748	CRDR G-C8112-0833 Cr10	8.330	21/64	10	120	162	40	Cr10	2
75106750	CRDR G-C8112-0840 Cr10	8.400	0.3307	10	120	162	40	Cr10	2
75106755	CRDR G-C8112-0850 Cr10	8.500	0.3346	10	120	162	40	Cr10	2
75106760	CRDR G-C8112-0870 Cr10	8.700	0.3425	10	120	162	40	Cr10	2
75106763	CRDR G-C8112-0873 Cr10	8.730	11/32	10	120	162	40	Cr10	2
75106765	CRDR G-C8112-0880 Cr10	8.800	0.3465	10	120	162	40	Cr10	2
75106770	CRDR G-C8112-0890 Cr10	8.900	0.3504	10	120	162	40	Cr10	2
75106775	CRDR G-C8112-0900 Cr10	9.000	0.3543	10	120	162	40	Cr10	2
75106780	CRDR G-C8112-0910 Cr10	9.100	0.3583	10	120	162	40	Cr10	2
75106783	CRDR G-C8112-0913 Cr10	9.130	23/64	10	120	162	40	Cr10	2
75106785	CRDR G-C8112-0920 Cr10	9.200	0.3622	10	120	162	40	Cr10	2
75106790	CRDR G-C8112-0930 Cr10	9.300	0.3661	10	120	162	40	Cr10	2
75106795	CRDR G-C8112-0940 Cr10	9.400	0.3701	10	120	162	40	Cr10	2
75106800	CRDR G-C8112-0950 Cr10	9.500	0.3740	10	120	162	40	Cr10	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (ℓ2)	OAL (ℓ1)	Shank length (ℓ4)	Cromson Grade	# Flutes
75106803	CRDR G-C8112-0953 Cr10	9.530	3/8	10	120	162	40	Cr10	2
75106805	CRDR G-C8112-0960 Cr10	9.600	0.3780	10	120	162	40	Cr10	2
75106810	CRDR G-C8112-0970 Cr10	9.700	0.3819	10	120	162	40	Cr10	2
75106815	CRDR G-C8112-0980 Cr10	9.800	0.3858	10	120	162	40	Cr10	2
75106820	CRDR G-C8112-0990 Cr10	9.900	0.3898	10	120	162	40	Cr10	2
75106823	CRDR G-C8112-0992 Cr11	9.920	25/64	10	120	162	40	Cr10	2
75106825	CRDR G-C8112-1000 Cr10	10.000	0.3937	10	120	162	40	Cr10	2
75106830	CRDR G-C8112-1010 Cr10	10.100	0.3976	12	156	204	45	Cr10	2
75106835	CRDR G-C8112-1020 Cr10	10.200	0.4016	12	156	204	45	Cr10	2
75106840	CRDR G-C8112-1030 Cr10	10.300	0.4055	12	156	204	45	Cr10	2
75106843	CRDR G-C8112-1032 Cr10	10.320	13/32	12	156	204	45	Cr10	2
75106845	CRDR G-C8112-1040 Cr10	10.400	0.4094	12	156	204	45	Cr10	2
75106850	CRDR G-C8112-1050 Cr10	10.500	0.4134	12	156	204	45	Cr10	2
75106855	CRDR G-C8112-1060 Cr10	10.600	0.4173	12	156	204	45	Cr10	2
75106860	CRDR G-C8112-1070 Cr10	10.700	0.4213	12	156	204	45	Cr10	2
75106863	CRDR G-C8112-1072 Cr10	10.720	27/64	12	156	204	45	Cr10	2
75106865	CRDR G-C8112-1080 Cr10	10.800	0.4252	12	156	204	45	Cr10	2
75106870	CRDR G-C8112-1090 Cr10	10.900	0.4291	12	156	204	45	Cr10	2
75106875	CRDR G-C8112-1100 Cr10	11.000	0.4331	12	156	204	45	Cr10	2
75106880	CRDR G-C8112-1110 Cr10	11.100	0.4370	12	156	204	45	Cr10	2
75106883	CRDR G-C8112-1111 Cr10	11.110	7/16	12	156	204	45	Cr10	2
75106885	CRDR G-C8112-1120 Cr10	11.200	0.4409	12	156	204	45	Cr10	2
75106890	CRDR G-C8112-1130 Cr10	11.300	0.4449	12	156	204	45	Cr10	2
75106895	CRDR G-C8112-1140 Cr10	11.400	0.4488	12	156	204	45	Cr10	2
75106900	CRDR G-C8112-1150 Cr10	11.500	0.4528	12	156	204	45	Cr10	2
75106905	CRDR G-C8112-1160 Cr10	11.600	0.4567	12	156	204	45	Cr10	2
75106910	CRDR G-C8112-1170 Cr10	11.700	0.4606	12	156	204	45	Cr10	2
75106915	CRDR G-C8112-1180 Cr10	11.800	0.4646	12	156	204	45	Cr10	2
75106920	CRDR G-C8112-1190 Cr10	11.900	0.4685	12	156	204	45	Cr10	2
75106925	CRDR G-C8112-1200 Cr10	12.000	0.4724	12	156	204	45	Cr10	2
75106926	CRDR G-C8112-1508 Cr10	15.080	19/32	16	208	260	48	Cr10	2
75106927	CRDR G-C8112-1588 Cr10	15.880	5/8	16	208	260	48	Cr10	2
75106928	CRDR G-C8112-1746 Cr10	17.460	11/16	18	234	285	48	Cr10	2
75106929	CRDR G-C8112-1905 Cr10	19.050	3/4	20	258	310	50	Cr10	2

CROMALU-C8000		Hardness Rockwell (HRC) Hardness Brinell (BHN) Tensile Strength (N/mm2)		Product model description						Recommended feed (f) for diameter ranges									
				C8103 (3 x d)		C8105 (5 x d)		C8112 (12 x d)		0.118-0.197 in 3 à 5 mm		0.197-0.316 in 5 to 8 mm		0.316-0.472 in 8 to 12 mm		0.472-0.630 in 12 to 16 mm		0.630-0.787 in 16 to 20 mm	
				SFM	m/min	SFM	m/min	SFM	m/min	IPR	mm/rev	IPR	mm/rev	IPR	mm/rev	IPR	mm/rev	IPR	mm/rev
Work Material	HRC	BHN	N/mm2																
Non-alloy steel, cast steel 1018, 1108, 1161, 12L14, 1522, 1572	up to 8 up to 15 over 15	up to 178 up to 205 over 205	up to 600 up to 700 over 700																
Alloyed steel 5132, 4130, 8620, 4340, 5140, 6150 Stainless steel 410, 416	up to 27 up to 31 over 31	up to 266 up to 297 over 297	up to 900 up to 1000 over 1000																
Stainless steel moderate 17-4PH, 15-5PH, 316L																			
Stainless and acid resistant steel (Cr-Ni-Alloys) 304, 316, 17CrNi16-2																			
Cast iron, grey cast iron alloy GG10-GG40, A48	up to 14 up to 24 over 24	up to 200 up to 250 over 2050	up to 680 up to 850 over 850																
Spheroidal graphite cast iron, cast iron with vermicular graphite, malleable iron GGG40, GGG80	up to 8 over 8	up to 178 over 178	up to 600 over 650																
Aluminum (Si content >10%) 6061, 2025, 208,360				295-984	70-200	295-984	70-200	.004-.010	0.10-0.25	.006-.014	0.15-0.35	.010-.018	0.25-0.45	.012-.020	0.30-0.50	.014-.022	0.35-0.55		
Aluminum (Si content <10%) 413, 385, A390				328-1312	80-300	328-1312	80-300	.004-.010	0.10-0.25	.006-.014	0.15-0.35	.010-.018	0.25-0.45	.012-.020	0.30-0.50	.0014-.022	0.35-0.55		
Copper, brass, bronze beryllium copper, naval brass, AMP/CO				230-984	60-220	230-984	60-220	.003-.007	0.07-0.18	.005-.010	0.12-0.25	.008-.014	0.20-0.35	.010-.018	0.25-0.45	.012-.020	0.30-0.50		
Titanium alloy TiAl6V																			
High temperature alloy Inconel, haynes, waspaloy, hastelloy																			
Chilled cast iron	38-48	350-450	1173-1527																
Hardened steel 50-60 HRC	50-55 55-60 61-65		1614-1970																

** The machining values shown are guidelines. The optimum data for a particular machining process should be determined in trials or during machining.
* For diameter < 3.0mm reduce cutting speed by 20-30%