

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



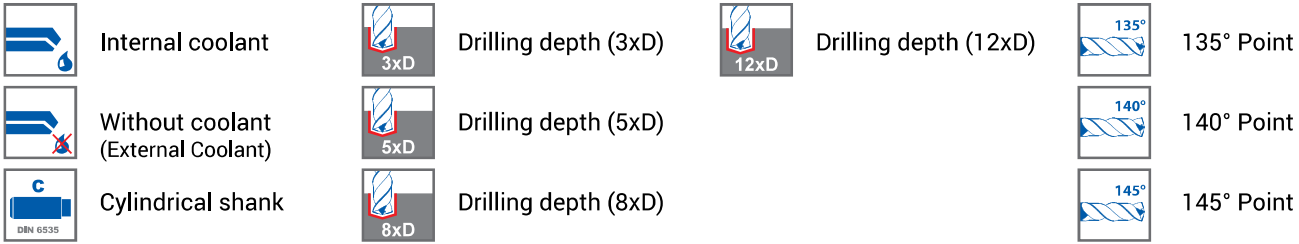
Suitable for some applications



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)

# CROMINOX

## C2000 SERIES

- ⊙ When machining stainless steel, the best results are obtained with drills that have a very sharp cutting edge with special cutting edge preparation
- ⊙ The CROMINOX offer these specifics features and more. It has a chip flute optimised for these materials with a rounded geometry such that clean chip flow is ensured
- ⊙ The CROMINOX from CROMSON, is available coated with a special Cr85 TiAlN+ (PVD) coating and offer in the drilling depths 3xD, 5xD and 8xD with internal coolant



Work Material	Hardness Rockwell (HRc) Hardness Brinell (BHN) Tensile Strength (N/mm2)			C2000
	HRc	BHN	N/mm2	
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 over 24	up to 200 over 250	up to 680 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	
Titanium alloy TiAl4V				
High temperature alloy inconel, haynes, waspaloy, hastelloy				

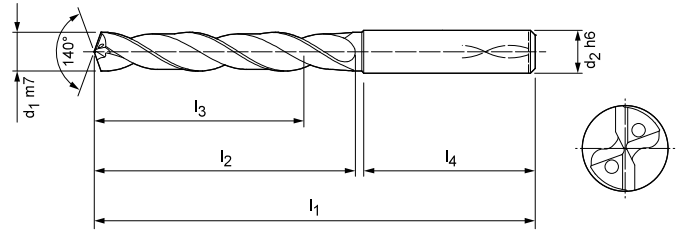
Highly recommended

Suitable for some applications.

CARBIDE DRILL

TECHNICAL DETAILS

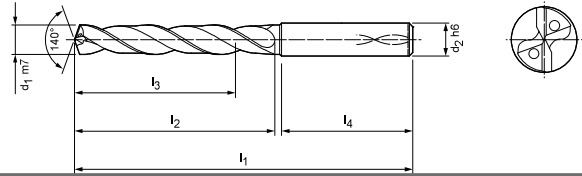
Tool Diameter Range 0.1181-0.7874 in  
3.00-20.00 mm  
Bore tolerance IT9 (achievable)  
Shank form Cyl. (DIN 6535)  
Number of flutes 2  
Number of margins 1  
Point geometry Special point  
Point angle 140°  
Helix angle 30°  
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75100000	CRDR-HP-C2103-0300 Cr85	3.000	0.1181	6	22	62	36	Cr85	2
75100005	CRDR-HP-C2103-0310 Cr85	3.100	0.1220	6	22	62	36	Cr85	2
75100008	CRDR-HP-C2103-0318 Cr85	3.180	<b>1/8</b>	6	22	62	36	Cr85	2
75100010	CRDR-HP-C2103-0320 Cr85	3.200	0.1260	6	22	62	36	Cr85	2
75100015	CRDR-HP-C2103-0330 Cr85	3.300	0.1299	6	22	62	36	Cr85	2
75100020	CRDR-HP-C2103-0340 Cr85	3.400	0.1339	6	22	62	36	Cr85	2
75100025	CRDR-HP-C2103-0350 Cr85	3.500	0.1378	6	22	62	36	Cr85	2
75100028	CRDR-HP-C2103-0357 Cr85	3.570	<b>9/64</b>	6	22	62	36	Cr85	2
75100030	CRDR-HP-C2103-0360 Cr85	3.600	0.1417	6	22	62	36	Cr85	2
75100035	CRDR-HP-C2103-0370 Cr85	3.700	0.1457	6	22	62	36	Cr85	2
75100040	CRDR-HP-C2103-0380 Cr85	3.800	0.1496	6	26	66	36	Cr85	2
75100045	CRDR-HP-C2103-0390 Cr85	3.900	0.1535	6	26	66	36	Cr85	2
75100048	CRDR-HP-C2103-0397 Cr85	3.970	<b>5/32</b>	6	26	66	36	Cr85	2
75100050	CRDR-HP-C2103-0400 Cr85	4.000	0.1575	6	26	66	36	Cr85	2
75100055	CRDR-HP-C2103-0410 Cr85	4.100	0.1614	6	26	66	36	Cr85	2
75100060	CRDR-HP-C2103-0420 Cr85	4.200	0.1654	6	26	66	36	Cr85	2
75100065	CRDR-HP-C2103-0430 Cr85	4.300	0.1693	6	26	66	36	Cr85	2
75100068	CRDR-HP-C2103-0437 Cr85	4.370	<b>11/64</b>	6	26	66	36	Cr85	2
75100070	CRDR-HP-C2103-0440 Cr85	4.400	0.1732	6	26	66	36	Cr85	2
75100075	CRDR-HP-C2103-0450 Cr85	4.500	0.1772	6	26	66	36	Cr85	2
75100080	CRDR-HP-C2103-0460 Cr85	4.600	0.1811	6	26	66	36	Cr85	2
75100085	CRDR-HP-C2103-0470 Cr85	4.700	0.1850	6	26	66	36	Cr85	2
75100088	CRDR-HP-C2103-0476 Cr85	4.760	<b>3/16</b>	6	26	66	36	Cr85	2
75100090	CRDR-HP-C2103-0480 Cr85	4.800	0.1890	6	30	66	36	Cr85	2
75100095	CRDR-HP-C2103-0490 Cr85	4.900	0.1929	6	30	66	36	Cr85	2
75100100	CRDR-HP-C2103-0500 Cr85	5.000	0.1969	6	30	66	36	Cr85	2
75100105	CRDR-HP-C2103-0510 Cr85	5.100	0.2008	6	30	66	36	Cr85	2
75100108	CRDR-HP-C2103-0516 Cr86	5.160	<b>13/64</b>	6	30	66	36	Cr85	2
75100110	CRDR-HP-C2103-0520 Cr85	5.200	0.2047	6	30	66	36	Cr85	2
75100115	CRDR-HP-C2103-0530 Cr85	5.300	0.2087	6	30	66	36	Cr85	2
75100120	CRDR-HP-C2103-0540 Cr85	5.400	0.2126	6	30	66	36	Cr85	2
75100125	CRDR-HP-C2103-0550 Cr85	5.500	0.2165	6	30	66	36	Cr85	2
75100128	CRDR-HP-C2103-0556 Cr85	5.560	<b>7/32</b>	6	30	66	36	Cr85	2
75100130	CRDR-HP-C2103-0560 Cr85	5.600	0.2205	6	30	66	36	Cr85	2
75100135	CRDR-HP-C2103-0570 Cr85	5.700	0.2244	6	30	66	36	Cr85	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75100140	CRDR-HP-C2103-0580 Cr85	5.800	0.2283	6	30	66	36	Cr85	2
75100145	CRDR-HP-C2103-0590 Cr85	5.900	0.2323	6	30	66	36	Cr85	2
75100148	CRDR-HP-C2103-0595 Cr85	5.950	<b>15/64</b>	6	30	66	36	Cr85	2
75100150	CRDR-HP-C2103-0600 Cr85	6.000	0.2362	6	30	66	36	Cr85	2
75100155	CRDR-HP-C2103-0610 Cr85	6.100	0.2402	8	38	79	36	Cr85	2
75100160	CRDR-HP-C2103-0620 Cr85	6.200	0.2441	8	38	79	36	Cr85	2
75100165	CRDR-HP-C2103-0630 Cr85	6.300	0.2480	8	38	79	36	Cr85	2
75100168	CRDR-HP-C2103-0635 Cr85	6.350	<b>1/4</b>	8	38	79	36	Cr85	2
75100170	CRDR-HP-C2103-0640 Cr85	6.400	0.2520	8	38	79	36	Cr85	2
75100175	CRDR-HP-C2103-0650 Cr85	6.500	0.2559	8	38	79	36	Cr85	2
75100180	CRDR-HP-C2103-0660 Cr85	6.600	0.2598	8	38	79	36	Cr85	2
75100185	CRDR-HP-C2103-0670 Cr85	6.700	0.2638	8	38	79	36	Cr85	2
75100188	CRDR-HP-C2103-0675 Cr85	6.750	<b>17/64</b>	8	38	79	36	Cr85	2
75100190	CRDR-HP-C2103-0680 Cr85	6.800	0.2677	8	38	79	36	Cr85	2
75100195	CRDR-HP-C2103-0690 Cr85	6.900	0.2717	8	38	79	36	Cr85	2
75100200	CRDR-HP-C2103-0700 Cr85	7.000	0.2756	8	38	79	36	Cr85	2
75100205	CRDR-HP-C2103-0710 Cr85	7.100	0.2795	8	42	79	36	Cr85	2
75100208	CRDR-HP-C2103-0714 Cr85	7.140	<b>9/32</b>	8	42	79	36	Cr85	2
75100210	CRDR-HP-C2103-0720 Cr85	7.200	0.2835	8	42	79	36	Cr85	2
75100215	CRDR-HP-C2103-0730 Cr85	7.300	0.2874	8	42	79	36	Cr85	2
75100220	CRDR-HP-C2103-0740 Cr85	7.400	0.2913	8	42	79	36	Cr85	2
75100225	CRDR-HP-C2103-0750 Cr85	7.500	0.2953	8	42	79	36	Cr85	2
75100228	CRDR-HP-C2103-0754 Cr85	7.540	<b>19/64</b>	8	42	79	36	Cr85	2
75100230	CRDR-HP-C2103-0760 Cr85	7.600	0.2992	8	42	79	36	Cr85	2
75100235	CRDR-HP-C2103-0770 Cr85	7.700	0.3031	8	42	79	36	Cr85	2
75100240	CRDR-HP-C2103-0780 Cr85	7.800	0.3071	8	42	79	36	Cr85	2
75100245	CRDR-HP-C2103-0790 Cr85	7.900	0.3110	8	42	79	36	Cr85	2
75100248	CRDR-HP-C2103-0794 Cr85	7.940	<b>5/16</b>	8	42	79	36	Cr85	2
75100250	CRDR-HP-C2103-0800 Cr85	8.000	0.3150	8	42	79	36	Cr85	2
75100255	CRDR-HP-C2103-0810 Cr85	8.100	0.3189	10	49	89	40	Cr85	2
75100260	CRDR-HP-C2103-0820 Cr85	8.200	0.3228	10	49	89	40	Cr85	2
75100265	CRDR-HP-C2103-0830 Cr85	8.300	0.3268	10	49	89	40	Cr85	2
75100268	CRDR-HP-C2103-0833 Cr85	8.330	<b>21/64</b>	10	49	89	40	Cr85	2
75100270	CRDR-HP-C2103-0840 Cr85	8.400	0.3307	10	49	89	40	Cr85	2
75100275	CRDR-HP-C2103-0850 Cr85	8.500	0.3346	10	49	89	40	Cr85	2
75100280	CRDR-HP-C2103-0860 Cr85	8.600	0.3386	10	49	89	40	Cr85	2
75100285	CRDR-HP-C2103-0870 Cr85	8.700	0.3425	10	49	89	40	Cr85	2
75100288	CRDR-HP-C2103-0873 Cr85	8.730	<b>11/32</b>	10	49	89	40	Cr85	2
75100290	CRDR-HP-C2103-0880 Cr85	8.800	0.3465	10	49	89	40	Cr85	2
75100295	CRDR-HP-C2103-0890 Cr85	8.900	0.3504	10	49	89	40	Cr85	2
75100300	CRDR-HP-C2103-0900 Cr85	9.000	0.3543	10	49	89	40	Cr85	2
75100305	CRDR-HP-C2103-0910 Cr85	9.100	0.3583	10	49	89	40	Cr85	2
75100308	CRDR-HP-C2103-0913 Cr85	9.130	<b>23/64</b>	10	49	89	40	Cr85	2
75100310	CRDR-HP-C2103-0920 Cr85	9.200	0.3622	10	49	89	40	Cr85	2
75100315	CRDR-HP-C2103-0930 Cr85	9.300	0.3661	10	49	89	40	Cr85	2
75100320	CRDR-HP-C2103-0940 Cr85	9.400	0.3701	10	49	89	40	Cr85	2
75100325	CRDR-HP-C2103-0950 Cr85	9.500	0.3740	10	49	89	40	Cr85	2
75100328	CRDR-HP-C2103-0953 Cr85	9.530	<b>3/8</b>	10	49	89	40	Cr85	2
75100330	CRDR-HP-C2103-0960 Cr85	9.600	0.3780	10	49	89	40	Cr85	2
75100335	CRDR-HP-C2103-0970 Cr85	9.700	0.3819	10	49	89	40	Cr85	2
75100340	CRDR-HP-C2103-0980 Cr85	9.800	0.3858	10	49	89	40	Cr85	2





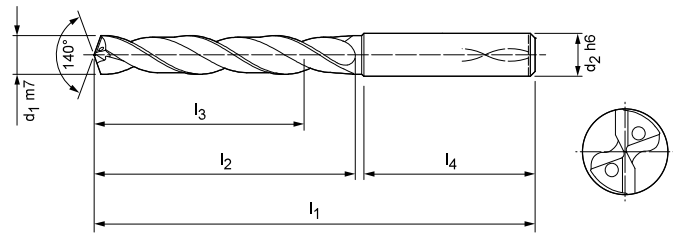
EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75100345	CRDR-HP-C2103-0990 Cr85	9.900	0.3898	10	49	89	40	Cr85	2
75100348	CRDR-HP-C2103-0992 Cr85	9.920	<b>25/64</b>	10	49	89	40	Cr85	2
75100350	CRDR-HP-C2103-1000 Cr85	10.000	0.3937	10	49	89	40	Cr85	2
75100355	CRDR-HP-C2103-1010 Cr85	10.100	0.3976	12	56	102	45	Cr85	2
75100360	CRDR-HP-C2103-1020 Cr85	10.200	0.4016	12	56	102	45	Cr85	2
75100365	CRDR-HP-C2103-1030 Cr85	10.300	0.4055	12	56	102	45	Cr85	2
75100368	CRDR-HP-C2103-1032 Cr85	10.320	<b>13/32</b>	12	56	102	45	Cr85	2
75100370	CRDR-HP-C2103-1040 Cr85	10.400	0.4094	12	56	102	45	Cr85	2
75100375	CRDR-HP-C2103-1050 Cr85	10.500	0.4134	12	56	102	45	Cr85	2
75100380	CRDR-HP-C2103-1060 Cr85	10.600	0.4173	12	56	102	45	Cr85	2
75100385	CRDR-HP-C2103-1070 Cr85	10.700	0.4213	12	56	102	45	Cr85	2
75100388	CRDR-HP-C2103-1072 Cr85	10.720	<b>27/64</b>	12	56	102	45	Cr85	2
75100390	CRDR-HP-C2103-1080 Cr85	10.800	0.4252	12	56	102	45	Cr85	2
75100395	CRDR-HP-C2103-1090 Cr85	10.900	0.4291	12	56	102	45	Cr85	2
75100400	CRDR-HP-C2103-1100 Cr85	11.000	0.4331	12	56	102	45	Cr85	2
75100405	CRDR-HP-C2103-1110 Cr85	11.100	0.4370	12	56	102	45	Cr85	2
75100408	CRDR-HP-C2103-1111 Cr85	11.110	<b>7/16</b>	12	56	102	45	Cr85	2
75100410	CRDR-HP-C2103-1120 Cr85	11.200	0.4409	12	56	102	45	Cr85	2
75100415	CRDR-HP-C2103-1130 Cr85	11.300	0.4449	12	56	102	45	Cr85	2
75100420	CRDR-HP-C2103-1140 Cr85	11.400	0.4488	12	56	102	45	Cr85	2
75100425	CRDR-HP-C2103-1150 Cr85	11.500	0.4528	12	56	102	45	Cr85	2
75100430	CRDR-HP-C2103-1160 Cr85	11.600	0.4567	12	56	102	45	Cr85	2
75100435	CRDR-HP-C2103-1170 Cr85	11.700	0.4606	12	56	102	45	Cr85	2
75100440	CRDR-HP-C2103-1180 Cr85	11.800	0.4646	12	56	102	45	Cr85	2
75100445	CRDR-HP-C2103-1190 Cr85	11.900	0.4685	12	56	102	45	Cr85	2
75100450	CRDR-HP-C2103-1200 Cr85	12.000	0.4724	12	56	102	45	Cr85	2
75100455	CRDR-HP-C2103-1350 Cr85	13.500	0.5315	14	61	107	45	Cr85	2
75100460	CRDR-HP-C2103-1450 Cr85	14.500	0.5709	16	65	115	48	Cr85	2
75100463	CRDR-HP-C2103-1468 Cr85	14.680	<b>37/64</b>	16	65	115	48	Cr85	2
75100465	CRDR-HP-C2103-1500 Cr85	15.000	0.5906	16	65	115	48	Cr85	2
75100468	CRDR-HP-C2103-1508 Cr85	15.080	<b>19/32</b>	16	65	115	48	Cr85	2
75100469	CRDR-HP-C2103-1588 Cr85	15.880	<b>5/8</b>	16	65	115	48	Cr85	2
75100470	CRDR-HP-C2103-1600 Cr85	16.000	0.6299	16	65	115	48	Cr85	2
75100475	CRDR-HP-C2103-1650 Cr85	16.500	0.6496	18	73	123	48	Cr85	2
75100478	CRDR-HP-C2103-1667 Cr85	16.670	<b>21/32</b>	18	73	123	48	Cr85	2
75100480	CRDR-HP-C2103-1700 Cr85	17.000	0.6693	18	73	123	48	Cr85	2
75100483	CRDR-HP-C2103-1746 Cr85	17.460	<b>11/16</b>	18	73	123	48	Cr85	2
75100485	CRDR-HP-C2103-1750 Cr85	17.500	0.6890	18	73	123	48	Cr85	2
75100488	CRDR-HP-C2103-1786 Cr85	17.860	<b>45/64</b>	18	73	123	48	Cr85	2
75100490	CRDR-HP-C2103-1800 Cr85	18.000	0.7087	18	73	123	48	Cr85	2
75100493	CRDR-HP-C2103-1826 Cr85	18.260	<b>23/32</b>	20	79	131	50	Cr85	2
75100495	CRDR-HP-C2103-1850 Cr85	18.500	0.7283	20	79	131	50	Cr85	2
75100500	CRDR-HP-C2103-1900 Cr85	19.000	0.7480	20	79	131	50	Cr85	2
75100503	CRDR-HP-C2103-1905 Cr85	19.050	<b>3/4</b>	20	79	131	50	Cr85	2
75100505	CRDR-HP-C2103-1950 Cr85	19.500	0.7677	20	79	131	50	Cr85	2
75100510	CRDR-HP-C2103-2000 Cr85	20.000	0.7874	20	79	131	50	Cr85	2

## CARBIDE DRILL

### TECHNICAL DETAILS

Tool Diameter Range 0.1102 - 0.7874 in  
2.80-20.00 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
75100515	CRDR-HP-C2105-0280 Cr85	2.800	0.1102	6	28	66	36	Cr85	2
75100520	CRDR-HP-C2105-0300 Cr85	3.000	0.1181	6	28	66	36	Cr85	2
75100525	CRDR-HP-C2105-0310 Cr85	3.100	0.1220	6	28	66	36	Cr85	2
75100528	CRDR-HP-C2105-0318 Cr85	3.180	<b>1/8</b>	6	28	66	36	Cr85	2
75100530	CRDR-HP-C2105-0320 Cr85	3.200	0.1260	6	28	66	36	Cr85	2
75100535	CRDR-HP-C2105-0330 Cr85	3.300	0.1299	6	28	66	36	Cr85	2
75100540	CRDR-HP-C2105-0340 Cr85	3.400	0.1339	6	28	66	36	Cr85	2
75100545	CRDR-HP-C2105-0350 Cr85	3.500	0.1378	6	28	66	36	Cr85	2
75100548	CRDR-HP-C2105-0357 Cr85	3.570	<b>9/64</b>	6	28	66	36	Cr85	2
75100550	CRDR-HP-C2105-0360 Cr85	3.600	0.1417	6	28	66	36	Cr85	2
75100555	CRDR-HP-C2105-0370 Cr85	3.700	0.1457	6	28	66	36	Cr85	2
75100560	CRDR-HP-C2105-0380 Cr85	3.800	0.1496	6	36	74	36	Cr85	2
75100565	CRDR-HP-C2105-0390 Cr85	3.900	0.1535	6	36	74	36	Cr85	2
75100568	CRDR-HP-C2105-0397 Cr85	3.970	<b>5/32</b>	6	36	74	36	Cr85	2
75100570	CRDR-HP-C2105-0400 Cr85	4.000	0.1575	6	36	74	36	Cr85	2
75100575	CRDR-HP-C2105-0410 Cr85	4.100	0.1614	6	36	74	36	Cr85	2
75100580	CRDR-HP-C2105-0420 Cr85	4.200	0.1654	6	36	74	36	Cr85	2
75100585	CRDR-HP-C2105-0430 Cr85	4.300	0.1693	6	36	74	36	Cr85	2
75100588	CRDR-HP-C2105-0437 Cr85	4.370	<b>11/64</b>	6	36	74	36	Cr85	2
75100590	CRDR-HP-C2105-0440 Cr85	4.400	0.1732	6	36	74	36	Cr85	2
75100595	CRDR-HP-C2105-0450 Cr85	4.500	0.1772	6	36	74	36	Cr85	2
75100600	CRDR-HP-C2105-0460 Cr85	4.600	0.1811	6	36	74	36	Cr85	2
75100605	CRDR-HP-C2105-0465 Cr85	4.650	0.1831	6	36	74	36	Cr85	2
75100610	CRDR-HP-C2105-0470 Cr85	4.700	0.1850	6	36	74	36	Cr85	2
75100613	CRDR-HP-C2105-0476 Cr85	4.760	<b>3/16</b>	6	44	82	36	Cr85	2
75100615	CRDR-HP-C2105-0480 Cr85	4.800	0.1890	6	44	82	36	Cr85	2
75100620	CRDR-HP-C2105-0490 Cr85	4.900	0.1929	6	44	82	36	Cr85	2
75100625	CRDR-HP-C2105-0500 Cr85	5.000	0.1969	6	44	82	36	Cr85	2
75100630	CRDR-HP-C2105-0510 Cr85	5.100	0.2008	6	44	82	36	Cr85	2
75100633	CRDR-HP-C2105-0516 Cr85	5.160	<b>13/64</b>	6	44	82	36	Cr85	2
75100635	CRDR-HP-C2105-0520 Cr85	5.200	0.2047	6	44	82	36	Cr85	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75100640	CRDR-HP-C2105-0530 Cr85	5.300	0.2087	6	44	82	36	Cr85	2
75100645	CRDR-HP-C2105-0540 Cr85	5.400	0.2126	6	44	82	36	Cr85	2
75100650	CRDR-HP-C2105-0550 Cr85	5.500	0.2165	6	44	82	36	Cr85	2
75100655	CRDR-HP-C2105-0555 Cr85	5.550	0.2185	6	44	82	36	Cr85	2
75100658	CRDR-HP-C2105-0556 Cr85	5.560	<b>7/32</b>	6	44	82	36	Cr85	2
75100660	CRDR-HP-C2105-0560 Cr85	5.600	0.2205	6	44	82	36	Cr85	2
75100665	CRDR-HP-C2105-0570 Cr85	5.700	0.2244	6	44	82	36	Cr85	2
75100670	CRDR-HP-C2105-0580 Cr85	5.800	0.2283	6	44	82	36	Cr85	2
75100675	CRDR-HP-C2105-0590 Cr85	5.900	0.2323	6	44	82	36	Cr85	2
75100678	CRDR-HP-C2105-0595 Cr85	5.950	<b>15/64</b>	6	44	82	36	Cr85	2
75100680	CRDR-HP-C2105-0600 Cr85	6.000	0.2362	6	44	82	36	Cr85	2
75100685	CRDR-HP-C2105-0610 Cr85	6.100	0.2402	8	53	91	36	Cr85	2
75100690	CRDR-HP-C2105-0620 Cr85	6.200	0.2441	8	53	91	36	Cr85	2
75100695	CRDR-HP-C2105-0630 Cr85	6.300	0.2480	8	53	91	36	Cr85	2
75100698	CRDR-HP-C2105-0635 Cr85	6.350	<b>1/4</b>	8	53	91	36	Cr85	2
75100700	CRDR-HP-C2105-0640 Cr85	6.400	0.2520	8	53	91	36	Cr85	2
75100705	CRDR-HP-C2105-0650 Cr85	6.500	0.2559	8	53	91	36	Cr85	2
75100710	CRDR-HP-C2105-0660 Cr85	6.600	0.2598	8	53	91	36	Cr85	2
75100715	CRDR-HP-C2105-0670 Cr85	6.700	0.2638	8	53	91	36	Cr85	2
75100718	CRDR-HP-C2105-0675 Cr85	6.750	<b>17/64</b>	8	53	91	36	Cr85	2
75100720	CRDR-HP-C2105-0680 Cr85	6.800	0.2677	8	53	91	36	Cr85	2
75100725	CRDR-HP-C2105-0690 Cr85	6.900	0.2717	8	53	91	36	Cr85	2
75100730	CRDR-HP-C2105-0700 Cr85	7.000	0.2756	8	53	91	36	Cr85	2
75100735	CRDR-HP-C2105-0710 Cr85	7.100	0.2795	8	53	91	36	Cr85	2
75100738	CRDR-HP-C2105-0714 Cr85	7.140	<b>9/32</b>	8	53	91	36	Cr85	2
75100740	CRDR-HP-C2105-0720 Cr85	7.200	0.2835	8	53	91	36	Cr85	2
75100745	CRDR-HP-C2105-0730 Cr85	7.300	0.2874	8	53	91	36	Cr85	2
75100750	CRDR-HP-C2105-0740 Cr85	7.400	0.2913	8	53	91	36	Cr85	2
75100755	CRDR-HP-C2105-0745 Cr85	7.450	0.2933	8	53	91	36	Cr85	2
75100760	CRDR-HP-C2105-0750 Cr85	7.500	0.2953	8	53	91	36	Cr85	2
75100763	CRDR-HP-C2105-0754 Cr85	7.540	<b>19/64</b>	8	53	91	36	Cr85	2
75100765	CRDR-HP-C2105-0760 Cr85	7.600	0.2992	8	53	91	36	Cr85	2
75100770	CRDR-HP-C2105-0770 Cr85	7.700	0.3031	8	53	91	36	Cr85	2
75100775	CRDR-HP-C2105-0780 Cr85	7.800	0.3071	8	53	91	36	Cr85	2
75100780	CRDR-HP-C2105-0790 Cr85	7.900	0.3110	8	53	91	36	Cr85	2
75100783	CRDR-HP-C2105-0794 Cr85	7.940	<b>5/16</b>	8	53	91	36	Cr85	2
75100785	CRDR-HP-C2105-0800 Cr85	8.000	0.3150	8	53	91	36	Cr85	2
75100790	CRDR-HP-C2105-0810 Cr85	8.100	0.3189	10	61	103	40	Cr85	2
75100795	CRDR-HP-C2105-0820 Cr85	8.200	0.3228	10	61	103	40	Cr85	2
75100800	CRDR-HP-C2105-0830 Cr85	8.300	0.3268	10	61	103	40	Cr85	2
75100803	CRDR-HP-C2105-0833 Cr83	8.330	<b>21/64</b>	10	61	103	40	Cr85	2
75100805	CRDR-HP-C2105-0840 Cr85	8.400	0.3307	10	61	103	40	Cr85	2
75100810	CRDR-HP-C2105-0850 Cr85	8.500	0.3346	10	61	103	40	Cr85	2
75100815	CRDR-HP-C2105-0860 Cr85	8.600	0.3386	10	61	103	40	Cr85	2
75100820	CRDR-HP-C2105-0870 Cr85	8.700	0.3425	10	61	103	40	Cr85	2
75100823	CRDR-HP-C2105-0873 Cr85	8.730	<b>11/32</b>	10	61	103	40	Cr85	2
75100825	CRDR-HP-C2105-0880 Cr85	8.800	0.3465	10	61	103	40	Cr85	2
75100830	CRDR-HP-C2105-0890 Cr85	8.900	0.3504	10	61	103	40	Cr85	2
75100835	CRDR-HP-C2105-0900 Cr85	9.000	0.3543	10	61	103	40	Cr85	2

EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75100840	CRDR-HP-C2105-0910 Cr85	9.100	0.3583	10	61	103	40	Cr85	2
75100843	CRDR-HP-C2105-0913 Cr85	9.130	<b>23/64</b>	10	61	103	40	Cr85	2
75100845	CRDR-HP-C2105-0920 Cr85	9.200	0.3622	10	61	103	40	Cr85	2
75100850	CRDR-HP-C2105-0930 Cr85	9.300	0.3661	10	61	103	40	Cr85	2
75100855	CRDR-HP-C2105-0940 Cr85	9.400	0.3701	10	61	103	40	Cr85	2
75100860	CRDR-HP-C2105-0950 Cr85	9.500	0.3740	10	61	103	40	Cr85	2
75100863	CRDR-HP-C2105-0953 Cr85	9.530	<b>3/8</b>	10	61	103	40	Cr85	2
75100865	CRDR-HP-C2105-0960 Cr85	9.600	0.3780	10	61	103	40	Cr85	2
75100870	CRDR-HP-C2105-0970 Cr85	9.700	0.3819	10	61	103	40	Cr85	2
75100875	CRDR-HP-C2105-0980 Cr85	9.800	0.3858	10	61	103	40	Cr85	2
75100880	CRDR-HP-C2105-0990 Cr85	9.900	0.3898	10	61	103	40	Cr85	2
75100883	CRDR-HP-C2105-0992 Cr85	9.920	<b>25/64</b>	10	61	103	40	Cr85	2
75100885	CRDR-HP-C2105-1000 Cr85	10.000	0.3937	10	61	103	40	Cr85	2
75100890	CRDR-HP-C2105-1010 Cr85	10.100	0.3976	12	71	118	45	Cr85	2
75100895	CRDR-HP-C2105-1020 Cr85	10.200	0.4016	12	71	118	45	Cr85	2
75100900	CRDR-HP-C2105-1030 Cr85	10.300	0.4055	12	71	118	45	Cr85	2
75100903	CRDR-HP-C2105-1032 Cr85	10.320	<b>13/32</b>	12	71	118	45	Cr85	2
75100905	CRDR-HP-C2105-1040 Cr85	10.400	0.4094	12	71	118	45	Cr85	2
75100910	CRDR-HP-C2105-1050 Cr85	10.500	0.4134	12	71	118	45	Cr85	2
75100915	CRDR-HP-C2105-1060 Cr85	10.600	0.4173	12	71	118	45	Cr85	2
75100920	CRDR-HP-C2105-1070 Cr85	10.700	0.4213	12	71	118	45	Cr85	2
75100923	CRDR-HP-C2105-1072 Cr86	10.720	<b>27/64</b>	12	71	118	45	Cr85	2
75100925	CRDR-HP-C2105-1080 Cr85	10.800	0.4252	12	71	118	45	Cr85	2
75100930	CRDR-HP-C2105-1090 Cr85	10.900	0.4291	12	71	118	45	Cr85	2
75100935	CRDR-HP-C2105-1100 Cr85	11.000	0.4331	12	71	118	45	Cr85	2
75100940	CRDR-HP-C2105-1110 Cr85	11.100	0.4370	12	71	118	45	Cr85	2
75100943	CRDR-HP-C2105-1111 Cr85	11.110	<b>7/16</b>	12	71	118	45	Cr85	2
75100945	CRDR-HP-C2105-1120 Cr85	11.200	0.4409	12	71	118	45	Cr85	2
75100950	CRDR-HP-C2105-1130 Cr85	11.300	0.4449	12	71	118	45	Cr85	2
75100955	CRDR-HP-C2105-1140 Cr85	11.400	0.4488	12	71	118	45	Cr85	2
75100960	CRDR-HP-C2105-1150 Cr85	11.500	0.4528	12	71	118	45	Cr85	2
75100965	CRDR-HP-C2105-1160 Cr85	11.600	0.4567	12	71	118	45	Cr85	2
75100970	CRDR-HP-C2105-1170 Cr85	11.700	0.4606	12	71	118	45	Cr85	2
75100975	CRDR-HP-C2105-1180 Cr85	11.800	0.4646	12	71	118	45	Cr85	2
75100980	CRDR-HP-C2105-1190 Cr85	11.900	0.4685	12	71	118	45	Cr85	2
75100985	CRDR-HP-C2105-1200 Cr85	12.000	0.4724	12	71	118	45	Cr85	2
75100990	CRDR-HP-C2105-1250 Cr85	12.500	0.4921	14	77	124	45	Cr85	2
75100995	CRDR-HP-C2105-1280 Cr85	12.800	0.5039	14	77	124	45	Cr85	2
75101000	CRDR-HP-C2105-1300 Cr85	13.000	0.5118	14	77	124	45	Cr85	2
75101005	CRDR-HP-C2105-1350 Cr85	13.500	0.5315	14	77	124	45	Cr85	2
75101010	CRDR-HP-C2105-1380 Cr85	13.800	0.5433	14	77	124	45	Cr85	2
75101015	CRDR-HP-C2105-1400 Cr85	14.000	0.5512	14	77	124	45	Cr85	2
75101020	CRDR-HP-C2105-1450 Cr85	14.500	0.5709	16	83	133	48	Cr85	2
75101023	CRDR-HP-C2105-1468 Cr85	14.680	<b>37/64</b>	16	83	133	48	Cr85	2
75101025	CRDR-HP-C2105-1480 Cr85	14.800	0.5827	16	83	133	48	Cr85	2
75101030	CRDR-HP-C2105-1500 Cr85	15.000	0.5906	16	83	133	48	Cr85	2
75101033	CRDR-HP-C2105-1508 Cr85	15.080	<b>19/32</b>	16	83	133	48	Cr85	2
75101035	CRDR-HP-C2105-1550 Cr85	15.500	0.6102	16	83	133	48	Cr85	2
75101040	CRDR-HP-C2105-1580 Cr85	15.800	0.6220	16	83	133	48	Cr85	2
75101044	CRDR-HP-C2105-1588 Cr85	15.880	<b>5/8</b>	16	83	133	48	Cr85	2





CROMINOX-C2000		Product model description		Recommended feed (f) for diameter ranges											
		C2103 (3 x d)		C2105 (5 x d)		0,118-0,197 in 3 to 5 mm IPR		0,316-0,472 in 8 to 12 mm IPR		0,472-0,630 in 12 to 16 mm IPR		0,630-0,787 in 16 to 20 mm IPR			
		SFM	m/min	SFM	m/min	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev		
Work Material	Hrc	BHN	N/mm2	Hardness Rockwell (HRC)		Hardness Brinell (BHN)		Tensile Strength (N/mm2)							
Non-alloy steel, cast steel 1018, 1108, 1161, 12L14, 1522, 1572	up to 8	up to 178	up to 600	312-377	95-115	312-377	95-115	.004-.007	.010-0,18	.007-.012	.018-0,30	.008-.012	.020-0,35	.010-.016	.025-0,40
	up to 15 over 15	up to 205 over 205	up to 700 over 700	279-344 246-295	85-105 75-90	279-344 246-295	85-105 75-90	.004-.007 .004-.008	0,10-0,18 0,10-0,20	.007-.012 .007-.014	0,18-0,30 0,18-0,35	.008-.012 .008-.015	0,20-0,35 0,20-0,38	.010-.016 .010-.017	0,25-0,40 0,25-0,42
Alloyed steel 5132, 4130, 8620, 4340, 5140, 6150	up to 27	up to 266	up to 900	197-279	60-85	197-279	60-85	.004-.008	0,10-0,20	.007-.014	0,18-0,35	.008-.015	0,20-0,38	0,10-.017	0,25-0,42
	up to 31 over 31	up to 297 over 297	up to 1000 over 1000	164-230 131-197	50-70 40-60	164-230 131-197	50-70 40-60	.004-.006 .004-.006	0,10-0,15 0,10-0,15	.005-.010 .005-.010	0,14-0,25 0,14-0,25	.006-.012 .006-.012	0,16-0,30 0,16-0,30	.007-.013 .007-.013	0,18-0,32 0,18-0,32
Stainless steel 410, 416															
Stainless steel moderate 17-4PH, 15-5PH, 316L				164-230	50-70	164-230	50-70	.001-.004	0,04-0,10	.003-.006	0,08-0,15	.005-.008	0,12-0,20	.006-.010	0,15-0,25
Stainless and acid resistant steel (Cr-Ni-Alloys) 304, 316, 17CrNi16-2				98-164	30-50	131-197	40-60	.001-.003	0,03-0,08	.002-.005	0,06-0,12	.003-.006	0,08-0,15	.003-.006	0,08-0,15
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	262-427 230-377 197-328	80-130 70-115 60-100	262-427 230-377 197-328	80-130 70-115 60-100	.004-.010 .004-.008 .004-.008	0,10-0,25 0,10-0,20 0,10-0,20	.008-.016 .006-.014 .006-.014	0,20-0,40 0,15-0,35 0,15-0,35	.010-.018 .008-.016 .008-.016	0,25-0,45 0,20-0,40 0,20-0,40	.012-.020 .010-.018 .010-.018	0,30-0,50 0,25-0,45 0,25-0,45
	up to 8 over 8	up to 178 over 178	up to 600 over 650	246-295 213-262	75-90 65-80	246-295 213-262	75-90 65-80	.004-.008 .003-.006	0,10-0,20 0,08-0,15	.008-.014 .007-.012	0,20-0,35 0,18-0,30	.012-.016 .010-.014	0,30-0,40 0,25-0,35	.014-.020 .012-.016	0,35-0,50 0,30-0,40
Spheroidal graphite cast iron, cast iron with vermicular graphite, malleable iron GGG40, GGG80															
Aluminum (Si content >10%) 6061, 2025, 208, 360				361-1181	110-360	361-1181	110-360	.006-.014	0,10-0,25	.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				394-1575	120-480	394-1575	120-480	.006-.014	0,10-0,25	.010-.018	0,25-0,45	.012-.020	0,30-0,50	.014-.022	0,35-0,55
Copper, brass, bronze beryllium copper, naval brass, AMPICO				394-1575	120-480	394-1575	120-480	.006-.014	0,10-0,25	.010-.018	0,25-0,45	.012-.020	0,30-0,50	.014-.022	0,35-0,55
Titanium alloy TiAl4V				66-164	20-50	66-164	20-50	.001-.004	0,02-0,07	.002-.005	0,06-0,12	.003-.006	0,08-0,15	.003-.006	0,08-0,15
High temperature alloy inconel, haynes, waspaloy, hastalloy				66-164	20-50	66-164	20-50	.001-.004	0,02-0,07	.002-.005	0,06-0,12	.003-.006	0,08-0,15	.003-.006	0,08-0,18
Chilled cast iron	38-48	350-450	1173- 1527												
Hardened steel 50-60 HRC	50-55 56-60 61-65														

\*\* The machining values shown are guidelines. The optimum data for a particular machining process should be determined in trials or during machining.  
\* For diameter < 3.00mm reduce cutting speed by 20-30%