

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



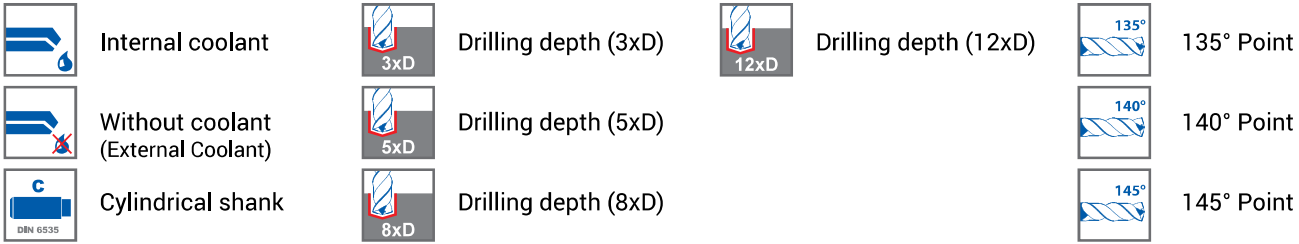
Suitable for some applications



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)

# CROMSTEEL

## C4000 SERIES

- ⊙ The CROMSTEEL twist drill designed specifically for steel can perform in bore sizes from 3.00 to 25.00 mm
- ⊙ Due to the special design of the cutting edges and the chip flutes, the drills in the CROMSTEEL standard range are adapted and optimised for machining virtually all types of steel
- ⊙ The CROMSTEEL is available with internal coolant supply and has a special Cr85 TiAlN+ (PVD) coating and combined with our specific geometry, these drills offer optimal machining performance



Work Material	Hardness Rockwell (HRc) -Hardness Brinnel (BHN) Tensile Strength (N/mm2)			C4100
	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				
Aluminum (Si content >10%) 6061, 2025, 208, 360				
Aluminum (Si content <10%) 413, 385, A390				
Copper, brass, bronze beryllium copper, naval brass, AMPCO				
Chilled cast iron	38-48	350-450	1173-1527	
Hardened steel 50-60 HRc	50-55 56-60 61-65		1614-1870	



Highly recommended



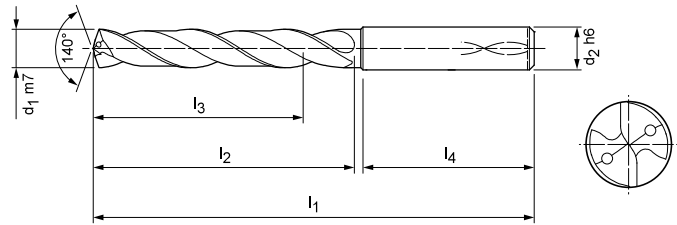
Suitable for some applications.

CARBIDE DRILL

TECHNICAL DETAILS

Tool Diameter Range 0.1102-0.9843 in  
2.80-25.00 mm

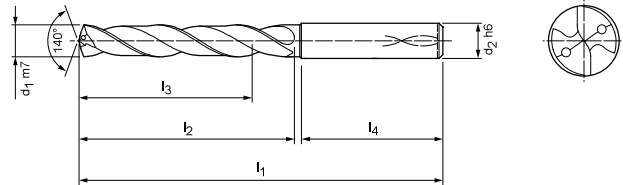
Bore tolerance IT9 (achievable)  
Shank form Cyl. (DIN 6535)  
Number of flutes 2  
Number of margins 1  
Point geometry Special point  
Point angle 140°  
Helix angle 30°  
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75101410	CRDR-HP-C4103-0280 Cr85	2.800	0.1102	6	20	62	36	Cr85	2
75101415	CRDR-HP-C4103-0300 Cr85	3.000	0.1181	6	20	62	36	Cr85	2
75101420	CRDR-HP-C4103-0310 Cr85	3.100	0.1220	6	20	62	36	Cr85	2
75101423	CRDR-HP-C4103-0318 Cr85	3.180	<b>1/8</b>	6	20	62	36	Cr85	2
75101425	CRDR-HP-C4103-0320 Cr85	3.200	0.1260	6	20	62	36	Cr85	2
75101430	CRDR-HP-C4103-0330 Cr85	3.300	0.1299	6	20	62	36	Cr85	2
75101435	CRDR-HP-C4103-0340 Cr85	3.400	0.1339	6	20	62	36	Cr85	2
75101440	CRDR-HP-C4103-0350 Cr85	3.500	0.1378	6	20	62	36	Cr85	2
75101443	CRDR-HP-C4103-0357 Cr85	3.570	<b>9/64</b>	6	20	62	36	Cr85	2
75101445	CRDR-HP-C4103-0360 Cr85	3.600	0.1417	6	20	62	36	Cr85	2
75101450	CRDR-HP-C4103-0370 Cr85	3.700	0.1457	6	20	62	36	Cr85	2
75101455	CRDR-HP-C4103-0380 Cr85	3.800	0.1496	6	24	66	36	Cr85	2
75101460	CRDR-HP-C4103-0390 Cr85	3.900	0.1535	6	24	66	36	Cr85	2
75101463	CRDR-HP-C4103-0397 Cr85	3.970	<b>5/32</b>	6	24	66	36	Cr85	2
75101465	CRDR-HP-C4103-0400 Cr85	4.000	0.1575	6	24	66	36	Cr85	2
75101470	CRDR-HP-C4103-0410 Cr85	4.100	0.1614	6	24	66	36	Cr85	2
75101475	CRDR-HP-C4103-0420 Cr85	4.200	0.1654	6	24	66	36	Cr85	2
75101480	CRDR-HP-C4103-0430 Cr85	4.300	0.1693	6	24	66	36	Cr85	2
75101483	CRDR-HP-C4103-0437 Cr85	4.370	<b>11/64</b>	6	24	66	36	Cr85	2
75101485	CRDR-HP-C4103-0440 Cr85	4.400	0.1732	6	24	66	36	Cr85	2
75101490	CRDR-HP-C4103-0450 Cr85	4.500	0.1772	6	24	66	36	Cr85	2
75101495	CRDR-HP-C4103-0460 Cr85	4.600	0.1811	6	24	66	36	Cr85	2
75101500	CRDR-HP-C4103-0465 Cr85	4.650	0.1831	6	24	66	36	Cr85	2
75101505	CRDR-HP-C4103-0470 Cr85	4.700	0.1850	6	24	66	36	Cr85	2
75101508	CRDR-HP-C4103-0476 Cr85	4.760	<b>3/16</b>	6	24	66	36	Cr85	2
75101510	CRDR-HP-C4103-0480 Cr85	4.800	0.1890	6	28	66	36	Cr85	2
75101515	CRDR-HP-C4103-0490 Cr85	4.900	0.1929	6	28	66	36	Cr85	2
75101520	CRDR-HP-C4103-0500 Cr85	5.000	0.1969	6	28	66	36	Cr85	2
75101525	CRDR-HP-C4103-0510 Cr85	5.100	0.2008	6	28	66	36	Cr85	2
75101528	CRDR-HP-C4103-0516 Cr85	5.160	<b>13/64</b>	6	28	66	36	Cr85	2
75101530	CRDR-HP-C4103-0520 Cr85	5.200	0.2047	6	28	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
75101535	CRDR-HP-C4103-0530 Cr85	5.300	0.2087	6	28	66	36	Cr85	2
75101540	CRDR-HP-C4103-0540 Cr85	5.400	0.2126	6	28	66	36	Cr85	2
75101545	CRDR-HP-C4103-0550 Cr85	5.500	0.2165	6	28	66	36	Cr85	2
75101550	CRDR-HP-C4103-0555 Cr85	5.550	0.2185	6	28	66	36	Cr85	2
75101553	CRDR-HP-C4103-0556 Cr85	5.560	<b>7/32</b>	6	28	66	36	Cr85	2
75101555	CRDR-HP-C4103-0560 Cr85	5.600	0.2205	6	28	66	36	Cr85	2
75101560	CRDR-HP-C4103-0570 Cr85	5.700	0.2244	6	28	66	36	Cr85	2
75101565	CRDR-HP-C4103-0580 Cr85	5.800	0.2283	6	28	66	36	Cr85	2
75101570	CRDR-HP-C4103-0590 Cr85	5.900	0.2323	6	28	66	36	Cr85	2
75101573	CRDR-HP-C4103-0595 Cr85	5.950	<b>15/64</b>	6	28	66	36	Cr85	2
75101575	CRDR-HP-C4103-0600 Cr85	6.000	0.2362	6	28	66	36	Cr85	2
75101580	CRDR-HP-C4103-0610 Cr85	6.100	0.2402	8	34	79	36	Cr85	2
75101585	CRDR-HP-C4103-0620 Cr85	6.200	0.2441	8	34	79	36	Cr85	2
75101590	CRDR-HP-C4103-0630 Cr85	6.300	0.2480	8	34	79	36	Cr85	2
75101593	CRDR-HP-C4103-0635 Cr85	6.350	<b>1/4</b>	8	34	79	36	Cr85	2
75101595	CRDR-HP-C4103-0640 Cr85	6.400	0.2520	8	34	79	36	Cr85	2
75101600	CRDR-HP-C4103-0650 Cr85	6.500	0.2559	8	34	79	36	Cr85	2
75101605	CRDR-HP-C4103-0660 Cr85	6.600	0.2598	8	34	79	36	Cr85	2
75101610	CRDR-HP-C4103-0670 Cr85	6.700	0.2638	8	34	79	36	Cr85	2
75101613	CRDR-HP-C4103-0675 Cr85	6.750	<b>17/64</b>	8	34	79	36	Cr85	2
75101615	CRDR-HP-C4103-0680 Cr85	6.800	0.2677	8	34	79	36	Cr85	2
75101620	CRDR-HP-C4103-0690 Cr85	6.900	0.2717	8	34	79	36	Cr85	2
75101625	CRDR-HP-C4103-0700 Cr85	7.000	0.2756	8	34	79	36	Cr85	2
75101630	CRDR-HP-C4103-0710 Cr85	7.100	0.2795	8	41	79	36	Cr85	2
75101633	CRDR-HP-C4103-0714 Cr85	7.140	<b>9/32</b>	8	41	79	36	Cr85	2
75101635	CRDR-HP-C4103-0720 Cr85	7.200	0.2835	8	41	79	36	Cr85	2
75101640	CRDR-HP-C4103-0730 Cr85	7.300	0.2874	8	41	79	36	Cr85	2
75101645	CRDR-HP-C4103-0740 Cr85	7.400	0.2913	8	41	79	36	Cr85	2
75101650	CRDR-HP-C4103-0745 Cr85	7.450	0.2933	8	41	79	36	Cr85	2
75101655	CRDR-HP-C4103-0750 Cr85	7.500	0.2953	8	41	79	36	Cr85	2
75101658	CRDR-HP-C4103-0754 Cr85	7.540	<b>19/64</b>	8	41	79	36	Cr85	2
75101660	CRDR-HP-C4103-0760 Cr85	7.600	0.2992	8	41	79	36	Cr85	2
75101665	CRDR-HP-C4103-0770 Cr85	7.700	0.3031	8	41	79	36	Cr85	2
75101670	CRDR-HP-C4103-0780 Cr85	7.800	0.3071	8	41	79	36	Cr85	2
75101675	CRDR-HP-C4103-0790 Cr85	7.900	0.3110	8	41	79	36	Cr85	2
75101678	CRDR-HP-C4103-0794 Cr85	7.940	<b>5/16</b>	8	41	79	36	Cr85	2
75101680	CRDR-HP-C4103-0800 Cr85	8.000	0.3150	8	41	79	36	Cr85	2
75101685	CRDR-HP-C4103-0810 Cr85	8.100	0.3189	10	47	89	40	Cr85	2
75101690	CRDR-HP-C4103-0820 Cr85	8.200	0.3228	10	47	89	40	Cr85	2
75101695	CRDR-HP-C4103-0830 Cr85	8.300	0.3268	10	47	89	40	Cr85	2
75101698	CRDR-HP-C4103-0833 Cr85	8.330	<b>21/64</b>	10	47	89	40	Cr85	2
75101700	CRDR-HP-C4103-0840 Cr85	8.400	0.3307	10	47	89	40	Cr85	2
75101705	CRDR-HP-C4103-0850 Cr85	8.500	0.3346	10	47	89	40	Cr85	2
75101710	CRDR-HP-C4103-0860 Cr85	8.600	0.3386	10	47	89	40	Cr85	2
75101715	CRDR-HP-C4103-0870 Cr85	8.700	0.3425	10	47	89	40	Cr85	2
75101718	CRDR-HP-C4103-0873 Cr85	8.730	<b>11/32</b>	10	47	89	40	Cr85	2
75101720	CRDR-HP-C4103-0880 Cr85	8.800	0.3465	10	47	89	40	Cr85	2
75101725	CRDR-HP-C4103-0890 Cr85	8.900	0.3504	10	47	89	40	Cr85	2
75101730	CRDR-HP-C4103-0900 Cr85	9.000	0.3543	10	47	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
75101735	CRDR-HP-C4103-0910 Cr85	9.100	0.3583	10	47	89	40	Cr85	2
75101738	CRDR-HP-C4103-0913 Cr85	9.130	<b>23/64</b>	10	47	89	40	Cr85	2
75101740	CRDR-HP-C4103-0920 Cr85	9.200	0.3622	10	47	89	40	Cr85	2
75101745	CRDR-HP-C4103-0930 Cr85	9.300	0.3661	10	47	89	40	Cr85	2
75101750	CRDR-HP-C4103-0940 Cr85	9.400	0.3701	10	47	89	40	Cr85	2
75101755	CRDR-HP-C4103-0950 Cr85	9.500	0.3740	10	47	89	40	Cr85	2
75101758	CRDR-HP-C4103-0953 Cr85	9.530	<b>3/8</b>	10	47	89	40	Cr85	2
75101760	CRDR-HP-C4103-0960 Cr85	9.600	0.3780	10	47	89	40	Cr85	2
75101765	CRDR-HP-C4103-0970 Cr85	9.700	0.3819	10	47	89	40	Cr85	2
75101770	CRDR-HP-C4103-0980 Cr85	9.800	0.3858	10	47	89	40	Cr85	2
75101775	CRDR-HP-C4103-0990 Cr85	9.900	0.3898	10	47	89	40	Cr85	2
75101778	CRDR-HP-C4103-0992 Cr85	9.920	<b>25/64</b>	10	47	89	40	Cr85	2
75101780	CRDR-HP-C4103-1000 Cr85	10.000	0.3937	10	47	89	40	Cr85	2
75101785	CRDR-HP-C4103-1010 Cr85	10.100	0.3976	12	55	102	45	Cr85	2
75101790	CRDR-HP-C4103-1020 Cr85	10.200	0.4016	12	55	102	45	Cr85	2
75101795	CRDR-HP-C4103-1030 Cr85	10.300	0.4055	12	55	102	45	Cr85	2
75101798	CRDR-HP-C4103-1032 Cr85	10.320	<b>13/32</b>	12	55	102	45	Cr85	2
75101800	CRDR-HP-C4103-1040 Cr85	10.400	0.4094	12	55	102	45	Cr85	2
75101805	CRDR-HP-C4103-1050 Cr85	10.500	0.4134	12	55	102	45	Cr85	2
75101810	CRDR-HP-C4103-1060 Cr85	10.600	0.4173	12	55	102	45	Cr85	2
75101815	CRDR-HP-C4103-1070 Cr85	10.700	0.4213	12	55	102	45	Cr85	2
75101818	CRDR-HP-C4103-1072 Cr85	10.720	<b>27/64</b>	12	55	102	45	Cr85	2
75101820	CRDR-HP-C4103-1080 Cr85	10.800	0.4252	12	55	102	45	Cr85	2
75101825	CRDR-HP-C4103-1090 Cr85	10.900	0.4291	12	55	102	45	Cr85	2
75101830	CRDR-HP-C4103-1100 Cr85	11.000	0.4331	12	55	102	45	Cr85	2
75101835	CRDR-HP-C4103-1110 Cr85	11.100	0.4370	12	55	102	45	Cr85	2
75101838	CRDR-HP-C4103-1111 Cr85	11.110	<b>7/16</b>	12	55	102	45	Cr85	2
75101840	CRDR-HP-C4103-1120 Cr85	11.200	0.4409	12	55	102	45	Cr85	2
75101845	CRDR-HP-C4103-1130 Cr85	11.300	0.4449	12	55	102	45	Cr85	2
75101850	CRDR-HP-C4103-1140 Cr85	11.400	0.4488	12	55	102	45	Cr85	2
75101855	CRDR-HP-C4103-1150 Cr85	11.500	0.4528	12	55	102	45	Cr85	2
75101860	CRDR-HP-C4103-1160 Cr85	11.600	0.4567	12	55	102	45	Cr85	2
75101865	CRDR-HP-C4103-1170 Cr85	11.700	0.4606	12	55	102	45	Cr85	2
75101870	CRDR-HP-C4103-1180 Cr85	11.800	0.4646	12	55	102	45	Cr85	2
75101875	CRDR-HP-C4103-1190 Cr85	11.900	0.4685	12	55	102	45	Cr85	2
75101880	CRDR-HP-C4103-1200 Cr85	12.000	0.4724	12	55	102	45	Cr85	2
75101885	CRDR-HP-C4103-1250 Cr85	12.500	0.4921	14	60	107	45	Cr85	2
75101890	CRDR-HP-C4103-1280 Cr85	12.800	0.5039	14	60	107	45	Cr85	2
75101895	CRDR-HP-C4103-1300 Cr85	13.000	0.5118	14	60	107	45	Cr85	2
75101900	CRDR-HP-C4103-1350 Cr85	13.500	0.5315	14	60	107	45	Cr85	2
75101905	CRDR-HP-C4103-1380 Cr85	13.800	0.5433	14	60	107	45	Cr85	2
75101910	CRDR-HP-C4103-1400 Cr85	14.000	0.5512	14	60	107	45	Cr85	2
75101915	CRDR-HP-C4103-1450 Cr85	14.500	0.5709	16	65	115	48	Cr85	2
75101918	CRDR-HP-C4103-1468 Cr85	14.680	<b>37/64</b>	16	65	115	48	Cr85	2

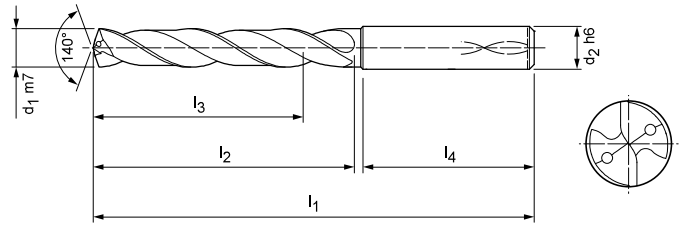
EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75101920	CRDR-HP-C4103-1480 Cr85	14.800	0.5827	16	65	115	48	Cr85	2
75101925	CRDR-HP-C4103-1500 Cr85	15.000	0.5906	16	65	115	48	Cr85	2
75101928	CRDR-HP-C4103-1508 Cr85	15.080	<b>19/32</b>	16	65	115	48	Cr85	2
75101930	CRDR-HP-C4103-1550 Cr85	15.500	0.6102	16	65	115	48	Cr85	2
75101935	CRDR-HP-C4103-1580 Cr85	15.800	0.6220	16	65	115	48	Cr85	2
75101938	CRDR-HP-C4103-1588 Cr85	15.880	<b>5/8</b>	16	65	115	48	Cr85	2
75101940	CRDR-HP-C4103-1600 Cr85	16.000	0.6299	16	65	115	48	Cr85	2
75101945	CRDR-HP-C4103-1650 Cr85	16.500	0.6496	18	73	123	48	Cr85	2
75101948	CRDR-HP-C4103-1667 Cr85	16.670	<b>21/32</b>	18	73	123	48	Cr85	2
75101950	CRDR-HP-C4103-1680 Cr85	16.800	0.6614	18	73	123	48	Cr85	2
75101955	CRDR-HP-C4103-1700 Cr85	17.000	0.6693	18	73	123	48	Cr85	2
75101958	CRDR-HP-C4103-1746 Cr85	17.460	<b>11/16</b>	18	73	123	48	Cr85	2
75101960	CRDR-HP-C4103-1750 Cr85	17.500	0.6890	18	73	123	48	Cr85	2
75101965	CRDR-HP-C4103-1780 Cr85	17.800	0.7008	18	73	123	48	Cr85	2
75101968	CRDR-HP-C4103-1786 Cr85	17.860	<b>45/64</b>	18	73	123	48	Cr85	2
75101970	CRDR-HP-C4103-1800 Cr85	18.000	0.7087	18	73	123	48	Cr85	2
75101973	CRDR-HP-C4103-1826 Cr85	18.260	<b>23/32</b>	20	79	131	50	Cr85	2
75101975	CRDR-HP-C4103-1850 Cr85	18.500	0.7283	20	79	131	50	Cr85	2
75101980	CRDR-HP-C4103-1880 Cr85	18.800	0.7402	20	79	131	50	Cr85	2
75101985	CRDR-HP-C4103-1900 Cr85	19.000	0.7480	20	79	131	50	Cr85	2
75101988	CRDR-HP-C4103-1905 Cr85	19.050	<b>3/4</b>	20	79	131	50	Cr85	2
75101990	CRDR-HP-C4103-1950 Cr85	19.500	0.7677	20	79	131	50	Cr85	2
75101995	CRDR-HP-C4103-1980 Cr85	19.800	0.7795	20	79	131	50	Cr85	2
75102000	CRDR-HP-C4103-2000 Cr85	20.000	0.7874	20	79	131	50	Cr85	2
75102005	CRDR-HP-C4103-2050 Cr85	20.500	0.8071	25	93	151	56	Cr85	2
75102010	CRDR-HP-C4103-2100 Cr85	21.000	0.8268	25	93	151	56	Cr85	2
75102015	CRDR-HP-C4103-2150 Cr85	21.500	0.8465	25	93	151	56	Cr85	2
75102020	CRDR-HP-C4103-2200 Cr85	22.000	0.8661	25	93	151	56	Cr85	2
75102025	CRDR-HP-C4103-2300 Cr85	23.000	0.9055	25	96	153	56	Cr85	2
75102030	CRDR-HP-C4103-2350 Cr85	23.500	0.9252	25	96	153	56	Cr85	2
75102035	CRDR-HP-C4103-2400 Cr85	24.000	0.9449	25	96	153	56	Cr85	2
75102040	CRDR-HP-C4103-2500 Cr85	25.000	0.9843	25	96	153	56	Cr85	2

CARBIDE DRILL

TECHNICAL DETAILS

Tool Diameter Range 0.1102-0.9843 in  
2.80-25.00 mm

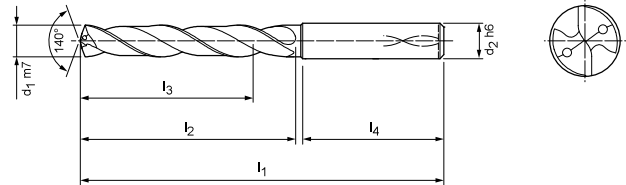
Bore tolerance IT9 (achievable)  
Shank form Cyl. (DIN 6535)  
Number of flutes 2  
Number of margins 1  
Point geometry Special point  
Point angle 140°  
Helix angle 30°  
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75102045	CRDR-HP-C4105-0280 Cr85	2.800	0.1102	6	28	66	36	Cr85	2
75102050	CRDR-HP-C4105-0300 Cr85	3.000	0.1181	6	28	66	36	Cr85	2
75102055	CRDR-HP-C4105-0310 Cr85	3.100	0.1220	6	28	66	36	Cr85	2
75102058	CRDR-HP-C4105-0318 Cr85	3.180	1/8	6	28	66	36	Cr85	2
75102060	CRDR-HP-C4105-0320 Cr85	3.200	0.1260	6	28	66	36	Cr85	2
75102065	CRDR-HP-C4105-0330 Cr85	3.300	0.1299	6	28	66	36	Cr85	2
75102070	CRDR-HP-C4105-0340 Cr85	3.400	0.1339	6	28	66	36	Cr85	2
75102075	CRDR-HP-C4105-0350 Cr85	3.500	0.1378	6	28	66	36	Cr85	2
75102078	CRDR-HP-C4105-0357 Cr85	3.570	9/64	6	28	66	36	Cr85	2
75102080	CRDR-HP-C4105-0360 Cr85	3.600	0.1417	6	28	66	36	Cr85	2
75102085	CRDR-HP-C4105-0370 Cr85	3.700	0.1457	6	28	66	36	Cr85	2
75102090	CRDR-HP-C4105-0380 Cr85	3.800	0.1496	6	36	74	36	Cr85	2
75102095	CRDR-HP-C4105-0390 Cr85	3.900	0.1535	6	36	74	36	Cr85	2
75102098	CRDR-HP-C4105-0397 Cr85	3.970	5/32	6	36	74	36	Cr85	2
75102100	CRDR-HP-C4105-0400 Cr85	4.000	0.1575	6	36	74	36	Cr85	2
75102105	CRDR-HP-C4105-0410 Cr85	4.100	0.1614	6	36	74	36	Cr85	2
75102110	CRDR-HP-C4105-0420 Cr85	4.200	0.1654	6	36	74	36	Cr85	2
75102115	CRDR-HP-C4105-0430 Cr85	4.300	0.1693	6	36	74	36	Cr85	2
75102118	CRDR-HP-C4105-0437 Cr85	4.370	11/64	6	36	74	36	Cr85	2
75102120	CRDR-HP-C4105-0440 Cr85	4.400	0.1732	6	36	74	36	Cr85	2
75102125	CRDR-HP-C4105-0450 Cr85	4.500	0.1772	6	36	74	36	Cr85	2
75102130	CRDR-HP-C4105-0460 Cr85	4.600	0.1811	6	36	74	36	Cr85	2
75102135	CRDR-HP-C4105-0465 Cr85	4.650	0.1831	6	36	74	36	Cr85	2
75102140	CRDR-HP-C4105-0470 Cr85	4.700	0.1850	6	36	74	36	Cr85	2
75102143	CRDR-HP-C4105-0476 Cr85	4.760	3/16	6	44	82	36	Cr85	2
75102145	CRDR-HP-C4105-0480 Cr85	4.800	0.1890	6	44	82	36	Cr85	2
75102150	CRDR-HP-C4105-0490 Cr85	4.900	0.1929	6	44	82	36	Cr85	2
75102155	CRDR-HP-C4105-0500 Cr85	5.000	0.1969	6	44	82	36	Cr85	2
75102158	CRDR-HP-C4105-0516 Cr85	5.160	13/64	6	44	82	36	Cr85	2
75102160	CRDR-HP-C4105-0510 Cr85	5.100	0.2031	6	44	82	36	Cr85	2
75102165	CRDR-HP-C4105-0520 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
75102170	CRDR-HP-C4105-0530 Cr85	5.300	0.2087	6	44	82	36	Cr85	2
75102175	CRDR-HP-C4105-0540 Cr85	5.400	0.2126	6	44	82	36	Cr85	2
75102180	CRDR-HP-C4105-0550 Cr85	5.500	0.2165	6	44	82	36	Cr85	2
75102185	CRDR-HP-C4105-0555 Cr85	5.550	0.2185	6	44	82	36	Cr85	2
75102188	CRDR-HP-C4105-0556 Cr85	5.560	<b>7/32</b>	6	44	82	36	Cr85	2
75102190	CRDR-HP-C4105-0560 Cr85	5.600	0.2205	6	44	82	36	Cr85	2
75102195	CRDR-HP-C4105-0570 Cr85	5.700	0.2244	6	44	82	36	Cr85	2
75102200	CRDR-HP-C4105-0580 Cr85	5.800	0.2283	6	44	82	36	Cr85	2
75102205	CRDR-HP-C4105-0590 Cr85	5.900	0.2323	6	44	82	36	Cr85	2
75102208	CRDR-HP-C4105-0595 Cr85	5.950	<b>15/64</b>	6	44	82	36	Cr85	2
75102210	CRDR-HP-C4105-0600 Cr85	6.000	0.2362	6	44	82	36	Cr85	2
75102215	CRDR-HP-C4105-0610 Cr85	6.100	0.2402	8	53	91	36	Cr85	2
75102220	CRDR-HP-C4105-0620 Cr85	6.200	0.2441	8	53	91	36	Cr85	2
75102225	CRDR-HP-C4105-0630 Cr85	6.300	0.2480	8	53	91	36	Cr85	2
75102228	CRDR-HP-C4105-0635 Cr85	6.350	<b>1/4</b>	8	53	91	36	Cr85	2
75102230	CRDR-HP-C4105-0640 Cr85	6.400	0.2520	8	53	91	36	Cr85	2
75102235	CRDR-HP-C4105-0650 Cr85	6.500	0.2559	8	53	91	36	Cr85	2
75102240	CRDR-HP-C4105-0660 Cr85	6.600	0.2598	8	53	91	36	Cr85	2
75102245	CRDR-HP-C4105-0670 Cr85	6.700	0.2638	8	53	91	36	Cr85	2
75102248	CRDR-HP-C4105-0675 Cr85	6.750	<b>17/64</b>	8	53	91	36	Cr85	2
75102250	CRDR-HP-C4105-0680 Cr85	6.800	0.2677	8	53	91	36	Cr85	2
75102255	CRDR-HP-C4105-0690 Cr85	6.900	0.2717	8	53	91	36	Cr85	2
75102260	CRDR-HP-C4105-0700 Cr85	7.000	0.2756	8	53	91	36	Cr85	2
75102265	CRDR-HP-C4105-0710 Cr85	7.100	0.2795	8	53	91	36	Cr85	2
75102268	CRDR-HP-C4105-0714 Cr85	7.140	<b>9/32</b>	8	53	91	36	Cr85	2
75102270	CRDR-HP-C4105-0720 Cr85	7.200	0.2835	8	53	91	36	Cr85	2
75102275	CRDR-HP-C4105-0730 Cr85	7.300	0.2874	8	53	91	36	Cr85	2
75102280	CRDR-HP-C4105-0740 Cr85	7.400	0.2913	8	53	91	36	Cr85	2
75102285	CRDR-HP-C4105-0745 Cr85	7.450	0.2933	8	53	91	36	Cr85	2
75102290	CRDR-HP-C4105-0750 Cr85	7.500	0.2953	8	53	91	36	Cr85	2
75102293	CRDR-HP-C4105-0754 Cr86	7.540	<b>19/64</b>	8	53	91	36	Cr85	2
75102295	CRDR-HP-C4105-0760 Cr85	7.600	0.2992	8	53	91	36	Cr85	2
75102300	CRDR-HP-C4105-0770 Cr85	7.700	0.3031	8	53	91	36	Cr85	2
75102305	CRDR-HP-C4105-0780 Cr85	7.800	0.3071	8	53	91	36	Cr85	2
75102310	CRDR-HP-C4105-0790 Cr85	7.900	0.3110	8	53	91	36	Cr85	2
75102313	CRDR-HP-C4105-0794 Cr86	7.940	<b>5/16</b>	8	53	91	36	Cr85	2
75102315	CRDR-HP-C4105-0800 Cr85	8.000	0.3150	8	53	91	36	Cr85	2
75102320	CRDR-HP-C4105-0810 Cr85	8.100	0.3189	10	61	103	40	Cr85	2
75102325	CRDR-HP-C4105-0820 Cr85	8.200	0.3228	10	61	103	40	Cr85	2
75102330	CRDR-HP-C4105-0830 Cr85	8.300	0.3268	10	61	103	40	Cr85	2
75102333	CRDR-HP-C4105-0833 Cr85	8.330	<b>21/64</b>	10	61	103	40	Cr85	2
75102335	CRDR-HP-C4105-0840 Cr85	8.400	0.3307	10	61	103	40	Cr85	2
75102340	CRDR-HP-C4105-0850 Cr85	8.500	0.3346	10	61	103	40	Cr85	2
75102345	CRDR-HP-C4105-0860 Cr85	8.600	0.3386	10	61	103	40	Cr85	2
75102350	CRDR-HP-C4105-0870 Cr85	8.700	0.3425	10	61	103	40	Cr85	2
75102353	CRDR-HP-C4105-0873 Cr85	8.730	<b>11/32</b>	10	61	103	40	Cr85	2
75102355	CRDR-HP-C4105-0880 Cr85	8.800	0.3465	10	61	103	40	Cr85	2
75102360	CRDR-HP-C4105-0890 Cr85	8.900	0.3504	10	61	103	40	Cr85	2
75102365	CRDR-HP-C4105-0900 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
75102370	CRDR-HP-C4105-0910 Cr85	9.100	0.3583	10	61	103	40	Cr85	2
75102373	CRDR-HP-C4105-0913 Cr85	9.130	<b>23/64</b>	10	61	103	40	Cr85	2
75102375	CRDR-HP-C4105-0920 Cr85	9.200	0.3622	10	61	103	40	Cr85	2
75102380	CRDR-HP-C4105-0930 Cr85	9.300	0.3661	10	61	103	40	Cr85	2
75102385	CRDR-HP-C4105-0940 Cr85	9.400	0.3701	10	61	103	40	Cr85	2
75102390	CRDR-HP-C4105-0950 Cr85	9.500	0.3740	10	61	103	40	Cr85	2
75102393	CRDR-HP-C4105-0953 Cr85	9.530	<b>3/8</b>	10	61	103	40	Cr85	2
75102395	CRDR-HP-C4105-0960 Cr85	9.600	0.3780	10	61	103	40	Cr85	2
75102400	CRDR-HP-C4105-0970 Cr85	9.700	0.3819	10	61	103	40	Cr85	2
75102405	CRDR-HP-C4105-0980 Cr85	9.800	0.3858	10	61	103	40	Cr85	2
75102410	CRDR-HP-C4105-0990 Cr85	9.900	0.3898	10	61	103	40	Cr85	2
75102413	CRDR-HP-C4105-0992 Cr85	9.920	<b>25/64</b>	10	61	103	40	Cr85	2
75102415	CRDR-HP-C4105-1000 Cr85	10.000	0.3937	10	61	103	40	Cr85	2
75102420	CRDR-HP-C4105-1010 Cr85	10.100	0.3976	12	71	118	45	Cr85	2
75102425	CRDR-HP-C4105-1020 Cr85	10.200	0.4016	12	71	118	45	Cr85	2
75102430	CRDR-HP-C4105-1030 Cr85	10.300	0.4055	12	71	118	45	Cr85	2
75102433	CRDR-HP-C4105-1032 Cr85	10.320	<b>13/32</b>	12	71	118	45	Cr85	2
75102435	CRDR-HP-C4105-1040 Cr85	10.400	0.4094	12	71	118	45	Cr85	2
75102440	CRDR-HP-C4105-1050 Cr85	10.500	0.4134	12	71	118	45	Cr85	2
75102445	CRDR-HP-C4105-1060 Cr85	10.600	0.4173	12	71	118	45	Cr85	2
75102450	CRDR-HP-C4105-1070 Cr85	10.700	0.4213	12	71	118	45	Cr85	2
75102453	CRDR-HP-C4105-1072 Cr85	10.720	<b>27/64</b>	12	71	118	45	Cr85	2
75102455	CRDR-HP-C4105-1080 Cr85	10.800	0.4252	12	71	118	45	Cr85	2
75102460	CRDR-HP-C4105-1090 Cr85	10.900	0.4291	12	71	118	45	Cr85	2
75102465	CRDR-HP-C4105-1100 Cr85	11.000	0.4331	12	71	118	45	Cr85	2
75102470	CRDR-HP-C4105-1110 Cr85	11.100	0.4370	12	71	118	45	Cr85	2
75102473	CRDR-HP-C4105-1111 Cr85	11.110	<b>7/16</b>	12	71	118	45	Cr85	2
75102475	CRDR-HP-C4105-1120 Cr85	11.200	0.4409	12	71	118	45	Cr85	2
75102480	CRDR-HP-C4105-1130 Cr85	11.300	0.4449	12	71	118	45	Cr85	2
75102485	CRDR-HP-C4105-1140 Cr85	11.400	0.4488	12	71	118	45	Cr85	2
75102490	CRDR-HP-C4105-1150 Cr85	11.500	0.4528	12	71	118	45	Cr85	2
75102495	CRDR-HP-C4105-1160 Cr85	11.600	0.4567	12	71	118	45	Cr85	2
75102500	CRDR-HP-C4105-1170 Cr85	11.700	0.4606	12	71	118	45	Cr85	2
75102505	CRDR-HP-C4105-1180 Cr85	11.800	0.4646	12	71	118	45	Cr85	2
75102510	CRDR-HP-C4105-1190 Cr85	11.900	0.4685	12	71	118	45	Cr85	2
75102515	CRDR-HP-C4105-1200 Cr85	12.000	0.4724	12	71	118	45	Cr85	2
75102520	CRDR-HP-C4105-1250 Cr85	12.500	0.4921	14	77	124	45	Cr85	2
75102525	CRDR-HP-C4105-1280 Cr85	12.800	0.5039	14	77	124	45	Cr85	2
75102530	CRDR-HP-C4105-1300 Cr85	13.000	0.5118	14	77	124	45	Cr85	2
75102535	CRDR-HP-C4105-1350 Cr85	13.500	0.5315	14	77	124	45	Cr85	2
75102540	CRDR-HP-C4105-1380 Cr85	13.800	0.5433	14	77	124	45	Cr85	2
75102545	CRDR-HP-C4105-1400 Cr85	14.000	0.5512	14	77	124	45	Cr85	2
75102550	CRDR-HP-C4105-1450 Cr85	14.500	0.5709	16	83	133	48	Cr85	2
75102553	CRDR-HP-C4105-1468 Cr85	14.680	<b>37/64</b>	16	83	133	48	Cr85	2

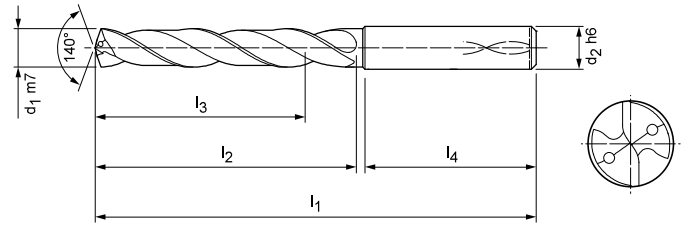
EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75102555	CRDR-HP-C4105-1480 Cr85	14.800	0.5827	16	83	133	48	Cr85	2
75102560	CRDR-HP-C4105-1500 Cr85	15.000	0.5906	16	83	133	48	Cr85	2
75102563	CRDR-HP-C4105-1508 Cr85	15.080	<b>19/32</b>	16	83	133	48	Cr85	2
75102565	CRDR-HP-C4105-1550 Cr85	15.500	0.6102	16	83	133	48	Cr85	2
75102570	CRDR-HP-C4105-1580 Cr85	15.800	0.6220	16	83	133	48	Cr85	2
75102573	CRDR-HP-C4105-1588 Cr85	15.880	<b>5/8</b>	16	83	133	48	Cr85	2
75102575	CRDR-HP-C4105-1600 Cr85	16.000	0.6299	16	83	133	48	Cr85	2
75102580	CRDR-HP-C4105-1650 Cr85	16.500	0.6496	18	93	143	48	Cr85	2
75102583	CRDR-HP-C4105-1667 Cr85	16.670	<b>21/32</b>	18	93	143	48	Cr85	2
75102585	CRDR-HP-C4105-1680 Cr85	16.800	0.6614	18	93	143	48	Cr85	2
75102590	CRDR-HP-C4105-1700 Cr85	17.000	0.6693	18	93	143	48	Cr85	2
75102593	CRDR-HP-C4105-1746 Cr85	17.460	<b>11/16</b>	18	93	143	48	Cr85	2
75102595	CRDR-HP-C4105-1750 Cr85	17.500	0.6890	18	93	143	48	Cr85	2
75102600	CRDR-HP-C4105-1780 Cr85	17.800	0.7008	18	93	143	48	Cr85	2
75102603	CRDR-HP-C4105-1786 Cr85	17.860	<b>45/64</b>	18	93	143	48	Cr85	2
75102605	CRDR-HP-C4105-1800 Cr85	18.000	0.7087	18	93	143	48	Cr85	2
75102608	CRDR-HP-C4105-1826 Cr85	18.260	<b>23/32</b>	20	101	153	50	Cr85	2
75102610	CRDR-HP-C4105-1850 Cr85	18.500	0.7283	20	101	153	50	Cr85	2
75102615	CRDR-HP-C4105-1880 Cr85	18.800	0.7402	20	101	153	50	Cr85	2
75102620	CRDR-HP-C4105-1900 Cr85	19.000	0.7480	20	101	153	50	Cr85	2
75102623	CRDR-HP-C4105-1905 Cr85	19.050	<b>3/4</b>	20	101	153	50	Cr85	2
75102625	CRDR-HP-C4105-1950 Cr85	19.500	0.7677	20	101	153	50	Cr85	2
75102630	CRDR-HP-C4105-1980 Cr85	19.800	0.7795	20	101	153	50	Cr85	2
75102635	CRDR-HP-C4105-2000 Cr85	20.000	0.7874	20	101	153	50	Cr85	2
75102640	CRDR-HP-C4105-2050 Cr85	20.500	0.8071	25	135	200	56	Cr85	2
75102645	CRDR-HP-C4105-2100 Cr85	21.000	0.8268	25	135	200	56	Cr85	2
75102650	CRDR-HP-C4105-2150 Cr85	21.500	0.8465	25	135	200	56	Cr85	2
75102655	CRDR-HP-C4105-2200 Cr85	22.000	0.8661	25	135	200	56	Cr85	2
75102660	CRDR-HP-C4105-2250 Cr85	22.500	0.8858	25	140	200	56	Cr85	2
75102665	CRDR-HP-C4105-2300 Cr85	23.000	0.9055	25	140	200	56	Cr85	2
75102670	CRDR-HP-C4105-2350 Cr85	23.500	0.9252	25	140	200	56	Cr85	2
75102675	CRDR-HP-C4105-2400 Cr85	24.000	0.9449	25	140	200	56	Cr85	2
75102680	CRDR-HP-C4105-2450 Cr85	24.500	0.9646	25	140	200	56	Cr85	2
75102685	CRDR-HP-C4105-2500 Cr85	25.000	0.9843	25	140	200	56	Cr85	2

CARBIDE DRILL

TECHNICAL DETAILS

Tool Diameter Range 0.1181-0.9843 in  
3.00-25.00 mm

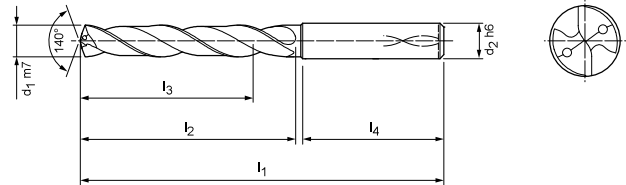
Bore tolerance IT9 (achievable)  
Shank form Cyl. (DIN 6535)  
Number of flutes 2  
Number of margins 1  
Point geometry Special point  
Point angle 140°  
Helix angle 30°  
Coolant Internal



EDP Cromson	Cromson Description	Diam (d1) mm	Diam (d1) in	Diam (d2)	Margin length (l2)	OAL (l1)	Shank length (l4)	Cromson Grade	# Flutes
75102690	CRDR-HP-C4108-0300 Cr85	3.000	0.1181	6	34	72	36	Cr85	2
75102695	CRDR-HP-C4108-0310 Cr85	3.100	0.1220	6	34	72	36	Cr85	2
75102698	CRDR-HP-C4108-0318 Cr85	3.180	1/8	6	34	72	36	Cr85	2
75102700	CRDR-HP-C4108-0320 Cr85	3.200	0.1260	6	34	72	36	Cr85	2
75102705	CRDR-HP-C4108-0330 Cr85	3.300	0.1299	6	34	72	36	Cr85	2
75102710	CRDR-HP-C4108-0340 Cr85	3.400	0.1339	6	34	72	36	Cr85	2
75102715	CRDR-HP-C4108-0350 Cr85	3.500	0.1378	6	34	72	36	Cr85	2
75102718	CRDR-HP-C4108-0357 Cr85	3.570	9/64	6	34	72	36	Cr85	2
75102720	CRDR-HP-C4108-0360 Cr85	3.600	0.1417	6	34	72	36	Cr85	2
75102725	CRDR-HP-C4108-0370 Cr85	3.700	0.1457	6	34	72	36	Cr85	2
75102730	CRDR-HP-C4108-0380 Cr85	3.800	0.1496	6	43	81	36	Cr85	2
75102735	CRDR-HP-C4108-0390 Cr85	3.900	0.1535	6	43	81	36	Cr85	2
75102738	CRDR-HP-C4108-0397 Cr85	3.970	5/32	6	43	81	36	Cr85	2
75102740	CRDR-HP-C4108-0400 Cr85	4.000	0.1575	6	43	81	36	Cr85	2
75102745	CRDR-HP-C4108-0410 Cr85	4.100	0.1614	6	43	81	36	Cr85	2
75102750	CRDR-HP-C4108-0420 Cr85	4.200	0.1654	6	43	81	36	Cr85	2
75102755	CRDR-HP-C4108-0430 Cr85	4.300	0.1693	6	43	81	36	Cr85	2
75102758	CRDR-HP-C4108-0437 Cr85	4.370	11/64	6	43	81	36	Cr85	2
75102760	CRDR-HP-C4108-0440 Cr85	4.400	0.1732	6	43	81	36	Cr85	2
75102765	CRDR-HP-C4108-0450 Cr85	4.500	0.1772	6	43	81	36	Cr85	2
75102770	CRDR-HP-C4108-0460 Cr85	4.600	0.1811	6	43	81	36	Cr85	2
75102775	CRDR-HP-C4108-0470 Cr85	4.700	0.1850	6	43	81	36	Cr85	2
75102778	CRDR-HP-C4108-0476 Cr85	4.760	3/16	6	57	95	36	Cr85	2
75102780	CRDR-HP-C4108-0480 Cr85	4.800	0.1890	6	57	95	36	Cr85	2
75102785	CRDR-HP-C4108-0490 Cr85	4.900	0.1929	6	57	95	36	Cr85	2
75102790	CRDR-HP-C4108-0500 Cr85	5.000	0.1969	6	57	95	36	Cr85	2
75102795	CRDR-HP-C4108-0510 Cr85	5.100	0.2008	6	57	95	36	Cr85	2
75102798	CRDR-HP-C4108-0516 Cr85	5.160	13/64	6	57	95	36	Cr85	2
75102800	CRDR-HP-C4108-0520 Cr85	5.200	0.2047	6	57	95	36	Cr85	2
75102805	CRDR-HP-C4108-0530 Cr85	5.300	0.2087	6	57	95	36	Cr85	2
75102810	CRDR-HP-C4108-0540 Cr85	5.400	0.2126	6	57	95	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
75102815	CRDR-HP-C4108-0550 Cr85	5.500	0.2165	6	57	95	36	Cr85	2
75102818	CRDR-HP-C4108-0556 Cr85	5.560	<b>7/32</b>	6	57	95	36	Cr85	2
75102820	CRDR-HP-C4108-0560 Cr85	5.600	0.2205	6	57	95	36	Cr85	2
75102825	CRDR-HP-C4108-0570 Cr85	5.700	0.2244	6	57	95	36	Cr85	2
75102830	CRDR-HP-C4108-0580 Cr85	5.800	0.2283	6	57	95	36	Cr85	2
75102835	CRDR-HP-C4108-0590 Cr85	5.900	0.2323	6	57	95	36	Cr85	2
75102838	CRDR-HP-C4108-0595 Cr85	5.950	<b>15/64</b>	6	57	95	36	Cr85	2
75102840	CRDR-HP-C4108-0600 Cr85	6.000	0.2362	6	57	95	36	Cr85	2
75102845	CRDR-HP-C4108-0610 Cr85	6.100	0.2402	8	76	114	36	Cr85	2
75102850	CRDR-HP-C4108-0620 Cr85	6.200	0.2441	8	76	114	36	Cr85	2
75102855	CRDR-HP-C4108-0630 Cr85	6.300	0.2480	8	76	114	36	Cr85	2
75102858	CRDR-HP-C4108-0635 Cr85	6.350	<b>1/4</b>	8	76	114	36	Cr85	2
75102860	CRDR-HP-C4108-0640 Cr85	6.400	0.2520	8	76	114	36	Cr85	2
75102865	CRDR-HP-C4108-0650 Cr85	6.500	0.2559	8	76	114	36	Cr85	2
75102870	CRDR-HP-C4108-0660 Cr85	6.600	0.2598	8	76	114	36	Cr85	2
75102875	CRDR-HP-C4108-0670 Cr85	6.700	0.2638	8	76	114	36	Cr85	2
75102878	CRDR-HP-C4108-0675 Cr85	6.750	<b>17/64</b>	8	76	114	36	Cr85	2
75102880	CRDR-HP-C4108-0680 Cr85	6.800	0.2677	8	76	114	36	Cr85	2
75102885	CRDR-HP-C4108-0690 Cr85	6.900	0.2717	8	76	114	36	Cr85	2
75102890	CRDR-HP-C4108-0700 Cr85	7.000	0.2756	8	76	114	36	Cr85	2
75102895	CRDR-HP-C4108-0710 Cr85	7.100	0.2795	8	76	114	36	Cr85	2
75102898	CRDR-HP-C4108-0714 Cr85	7.140	<b>9/32</b>	8	76	114	36	Cr85	2
75102900	CRDR-HP-C4108-0720 Cr85	7.200	0.2835	8	76	114	36	Cr85	2
75102905	CRDR-HP-C4108-0730 Cr85	7.300	0.2874	8	76	114	36	Cr85	2
75102910	CRDR-HP-C4108-0740 Cr85	7.400	0.2913	8	76	114	36	Cr85	2
75102915	CRDR-HP-C4108-0750 Cr85	7.500	0.2953	8	76	114	36	Cr85	2
75102918	CRDR-HP-C4108-0754 Cr85	7.540	<b>19/64</b>	8	76	114	36	Cr85	2
75102920	CRDR-HP-C4108-0760 Cr85	7.600	0.2992	8	76	114	36	Cr85	2
75102925	CRDR-HP-C4108-0770 Cr85	7.700	0.3031	8	76	114	36	Cr85	2
75102930	CRDR-HP-C4108-0780 Cr85	7.800	0.3071	8	76	114	36	Cr85	2
75102935	CRDR-HP-C4108-0790 Cr85	7.900	0.3110	8	76	114	36	Cr85	2
75102938	CRDR-HP-C4108-0794 Cr85	7.940	<b>5/16</b>	8	76	114	36	Cr85	2
75102940	CRDR-HP-C4108-0800 Cr85	8.000	0.3150	8	76	114	36	Cr85	2
75102945	CRDR-HP-C4108-0810 Cr85	8.100	0.3189	10	95	142	40	Cr85	2
75102950	CRDR-HP-C4108-0820 Cr85	8.200	0.3228	10	95	142	40	Cr85	2
75102955	CRDR-HP-C4108-0830 Cr85	8.300	0.3268	10	95	142	40	Cr85	2
75102958	CRDR-HP-C4108-0833 Cr85	8.330	<b>21/64</b>	10	95	142	40	Cr85	2
75102960	CRDR-HP-C4108-0840 Cr85	8.400	0.3307	10	95	142	40	Cr85	2
75102965	CRDR-HP-C4108-0850 Cr85	8.500	0.3346	10	95	142	40	Cr85	2
75102970	CRDR-HP-C4108-0860 Cr85	8.600	0.3386	10	95	142	40	Cr85	2
75102975	CRDR-HP-C4108-0870 Cr85	8.700	0.3425	10	95	142	40	Cr85	2
75102978	CRDR-HP-C4108-0873 Cr86	8.730	<b>11/32</b>	10	95	142	40	Cr85	2
75102980	CRDR-HP-C4108-0880 Cr85	8.800	0.3465	10	95	142	40	Cr85	2
75102985	CRDR-HP-C4108-0890 Cr85	8.900	0.3504	10	95	142	40	Cr85	2
75102990	CRDR-HP-C4108-0900 Cr85	9.000	0.3543	10	95	142	40	Cr85	2
75102995	CRDR-HP-C4108-0910 Cr85	9.100	0.3583	10	95	142	40	Cr85	2
75102998	CRDR-HP-C4108-0913 Cr85	9.130	<b>23/64</b>	10	95	142	40	Cr85	2
75103000	CRDR-HP-C4108-0920 Cr85	9.200	0.3622	10	95	142	40	Cr85	2
75103005	CRDR-HP-C4108-0930 Cr85	9.300	0.3661	10	95	142	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
75103010	CRDR-HP-C4108-0940 Cr85	9.400	0.3701	10	95	142	40	Cr85	2
75103015	CRDR-HP-C4108-0950 Cr85	9.500	0.3740	10	95	142	40	Cr85	2
75103018	CRDR-HP-C4108-0953 Cr85	9.530	<b>3/8</b>	10	95	142	40	Cr85	2
75103020	CRDR-HP-C4108-0960 Cr85	9.600	0.3780	10	95	142	40	Cr85	2
75103025	CRDR-HP-C4108-0970 Cr85	9.700	0.3819	10	95	142	40	Cr85	2
75103030	CRDR-HP-C4108-0980 Cr85	9.800	0.3858	10	95	142	40	Cr85	2
75103035	CRDR-HP-C4108-0990 Cr85	9.900	0.3898	10	95	142	40	Cr85	2
75103038	CRDR-HP-C4108-0992 Cr85	9.920	<b>25/64</b>	10	95	142	40	Cr85	2
75103040	CRDR-HP-C4108-1000 Cr85	10.000	0.3937	10	95	142	40	Cr85	2
75103045	CRDR-HP-C4108-1010 Cr85	10.100	0.3976	12	114	162	45	Cr85	2
75103050	CRDR-HP-C4108-1020 Cr85	10.200	0.4016	12	114	162	45	Cr85	2
75103055	CRDR-HP-C4108-1030 Cr85	10.300	0.4055	12	114	162	45	Cr85	2
75103058	CRDR-HP-C4108-1032 Cr85	10.320	<b>13/32</b>	12	114	162	45	Cr85	2
75103060	CRDR-HP-C4108-1040 Cr85	10.400	0.4094	12	114	162	45	Cr85	2
75103065	CRDR-HP-C4108-1050 Cr85	10.500	0.4134	12	114	162	45	Cr85	2
75103070	CRDR-HP-C4108-1060 Cr85	10.600	0.4173	12	114	162	45	Cr85	2
75103075	CRDR-HP-C4108-1070 Cr85	10.700	0.4213	12	114	162	45	Cr85	2
75103078	CRDR-HP-C4108-1072 Cr85	10.720	<b>27/64</b>	12	114	162	45	Cr85	2
75103080	CRDR-HP-C4108-1080 Cr85	10.800	0.4252	12	114	162	45	Cr85	2
75103085	CRDR-HP-C4108-1090 Cr85	10.900	0.4291	12	114	162	45	Cr85	2
75103090	CRDR-HP-C4108-1100 Cr85	11.000	0.4331	12	114	162	45	Cr85	2
75103095	CRDR-HP-C4108-1110 Cr85	11.100	0.4370	12	114	162	45	Cr85	2
75103098	CRDR-HP-C4108-1111 Cr85	11.110	<b>7/16</b>	12	114	162	45	Cr85	2
75103100	CRDR-HP-C4108-1120 Cr85	11.200	0.4409	12	114	162	45	Cr85	2
75103105	CRDR-HP-C4108-1130 Cr85	11.300	0.4449	12	114	162	45	Cr85	2
75103110	CRDR-HP-C4108-1140 Cr85	11.400	0.4488	12	114	162	45	Cr85	2
75103115	CRDR-HP-C4108-1150 Cr85	11.500	0.4528	12	114	162	45	Cr85	2
75103120	CRDR-HP-C4108-1160 Cr85	11.600	0.4567	12	114	162	45	Cr85	2
75103125	CRDR-HP-C4108-1170 Cr85	11.700	0.4606	12	114	162	45	Cr85	2
75103130	CRDR-HP-C4108-1180 Cr85	11.800	0.4646	12	114	162	45	Cr85	2
75103135	CRDR-HP-C4108-1190 Cr85	11.900	0.4685	12	114	162	45	Cr85	2
75103140	CRDR-HP-C4108-1200 Cr85	12.000	0.4724	12	114	162	45	Cr85	2
75103145	CRDR-HP-C4108-1250 Cr85	12.500	0.4921	14	133	178	45	Cr85	2
75103150	CRDR-HP-C4108-1280 Cr85	12.800	0.5039	14	133	178	45	Cr85	2
75103155	CRDR-HP-C4108-1300 Cr85	13.000	0.5118	14	133	178	45	Cr85	2
75103160	CRDR-HP-C4108-1350 Cr85	13.500	0.5315	14	133	178	45	Cr85	2
75103165	CRDR-HP-C4108-1380 Cr85	13.800	0.5433	14	133	178	45	Cr85	2
75103170	CRDR-HP-C4108-1400 Cr85	14.000	0.5512	14	133	178	45	Cr85	2
75103175	CRDR-HP-C4108-1450 Cr85	14.500	0.5709	16	152	203	48	Cr85	2
75103178	CRDR-HP-C4108-1468 Cr86	14.680	<b>37/64</b>	16	152	203	48	Cr85	2
75103180	CRDR-HP-C4108-1480 Cr85	14.800	0.5827	16	152	203	48	Cr85	2
75103185	CRDR-HP-C4108-1500 Cr85	15.000	0.5906	16	152	203	48	Cr85	2
75103188	CRDR-HP-C4108-1508 Cr85	15.080	<b>19/32</b>	16	152	203	48	Cr85	2
75103190	CRDR-HP-C4108-1550 Cr85	15.500	0.6102	16	152	203	48	Cr85	2



CROMSTEEL-C4000		Recommended feed (f) for diameter ranges																	
		Product model description						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	
		C4103 (3 x d)		C4105 (5 x d)		C4108 (8 x d)		IPR		mm/rev		IPR		mm/rev		IPR		mm/rev	
		SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min	SFM	m/min
Work Material	Hrc	BHN	N/mm2	Hardness Rockwell (HRC)		Hardness Brinell (BHN)		Tensile Strength (N/mm2)		0.118-0.197 in 3 to 5 mm		0.18-0.30		0.20-0.35		0.25-0.40			
				up to 178	up to 205	up to 205	up to 266	up to 297	up to 31	up to 266	up to 297	up to 31	up to 266	up to 297	up to 31	up to 266	up to 297	up to 31	up to 266
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	312-377 279-344 246-295	95-115 85-105 75-90	312-377 279-344 246-295	95-115 85-105 75-90	312-377 279-344 246-295	95-115 85-105 75-90	.004-.007 .004-.008 .004-.008	0.10-0.18 0.10-0.18 0.10-0.20	.007-.012 .007-.012 .007-.014	0.18-0.30 0.18-0.30 0.18-0.35	.008-.012 .008-.012 .008-.015	0.20-0.35 0.20-0.35 0.20-0.38	.010-.016 .010-.016 .010-.017	0.25-0.40 0.25-0.40 0.25-0.42		
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	197-279 164-230 131-197	60-85 50-70 40-60	197-279 164-230 131-197	60-85 50-70 40-60	197-279 164-230 131-197	60-85 50-70 40-60	.004-.008 .004-.006 .004-.006	0.10-0.20 0.10-0.15 0.10-0.15	.007-.014 .005-.010 .005-.010	0.18-0.35 0.14-0.25 0.14-0.25	.008-.015 .006-.012 .006-.012	0.20-0.38 0.15-0.30 0.15-0.30	0.10-.017 .007-.013 .007-.013	0.25-0.42 0.18-0.32 0.18-0.32		
Stainless steel moderate 17-4PH, 15-5PH, 316L				164-230	50-70	164-230	50-70	164-230	50-70	.002-.005	0.06-0.12	.004-.008	0.10-0.20	.004-.008	0.12-0.20	.006-.010	0.15-0.25		
Stainless and acid resistant steel (C-Ni-Alloys) 304, 316, 17CrNi16-2				98-164	30-50	131-197	40-60	131-197	40-60	.002-.005	0.06-0.12	.004-.008	0.10-0.20	.004-.008	0.12-0.20	.006-.010	0.15-0.25		
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	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		
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	246-295 213-262	75-90 65-80	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		
Aluminum (Si content >10%) 6061, 2025, 209, 360																			
Aluminum (Si content <10%) 413, 385, A390																			
Copper, brass, bronze beryllium copper, naval brass, AMPCO																			
Titanium alloy Ti6Al4V																			
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																	

\*\* 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%