



HIGH PERFORMANCE EXTENDED LENGTH TWIST DRILL • SOLID CARBIDE/AITIN COATED • COMMON SHANK

SERIES 917 • COOLANT-FED / SERIES M917 (METRIC) • COOLANT-FED

NEW



| | |
|--------------|--------------|
| SERIES: 917 | SERIES: M917 |
| SIZES | SIZES |
| 3/16" - 1/2" | 5.0 - 11.0 |
| INCH | MM |

10% Micro-grain Solid Carbide. High performance solid carbide drill designed for drilling in stainless steels and high temperature alloy materials. 142 high performance point in conjunction with the AITIN coating improves chip clearance and extends tool life in these difficult to machine materials. Common shank sizes for use with Shrink-Fit® and other precision toolholders. Depths to 7x diameter. Slotted coolant entry.

| | | | |
|-----------------------|--------|------|-------|
| MATERIAL | BRIGHT | DARK | AITIN |
| Solid Carbide | | | ● |
| SPECIFICATIONS | | | |
| Helix: 30° Standard | | | |
| Point: 142° | | | |
| Web: Standard | | | |

SERIES 917 • COOLANT-FED

SERIES M917 (METRIC) • COOLANT-FED

| TOOL DIAMETER | | SHANK DIA. (IN.) | FLUTE LENGTH (IN.) | OAL (IN.) | PART NUMBER |
|---------------|---------|------------------|--------------------|-----------|-------------|
| INCH | DECIMAL | | | | |
| 3/16 | 0.1875 | 0.1875 | 1-13/16 | 3-7/8 | 917-01875 |
| 7/32 | 0.2187 | 0.2344 | 2-1/8 | 4-13/64 | 917-02187 |
| 15/64 | 0.2344 | 0.2344 | 2-1/8 | 4-13/64 | 917-02344 |
| 1/4 | 0.2500 | 0.2500 | 2-1/4 | 4-3/8 | 917-02500 |
| 17/64 | 0.2656 | 0.3125 | 2-17/32 | 5 | 917-02656 |
| 9/32 | 0.2812 | 0.3125 | 2-17/32 | 5 | 917-02812 |
| 19/64 | 0.2969 | 0.3125 | 2-13/16 | 5 | 917-02969 |
| 5/16 | 0.3125 | 0.3125 | 2-13/16 | 5 | 917-03125 |
| 21/64 | 0.3281 | 0.3750 | 3-1/8 | 5-25/32 | 917-03281 |
| 11/32 | 0.3438 | 0.3750 | 3-1/8 | 5-25/32 | 917-03438 |
| 3/8 | 0.3750 | 0.3750 | 3-3/8 | 5-25/32 | 917-03750 |
| 25/64 | 0.3906 | 0.4375 | 3-11/16 | 6-3/4 | 917-03906 |
| 13/32 | 0.4062 | 0.4375 | 3-11/16 | 6-3/4 | 917-04062 |
| 27/64 | 0.4219 | 0.4375 | 3-15/16 | 6-3/4 | 917-04219 |
| 7/16 | 0.4375 | 0.4375 | 3-15/16 | 6-3/4 | 917-04375 |
| 1/2 | 0.5000 | 0.5000 | 4-1/2 | 7 | 917-05000 |

| TOOL DIAMETER | | SHANK DIA. (MM) | FLUTE LENGTH (MM) | OAL (MM) | PART NUMBER |
|---------------|---------|-----------------|-------------------|----------|-------------|
| MM | DECIMAL | | | | |
| 5.00 | 0.1968 | 5.0 | 45 | 98 | M917-01968 |
| 5.50 | 0.2165 | 6.0 | 50 | 107 | M917-02165 |
| 6.00 | 0.2362 | 6.0 | 55 | 107 | M917-02362 |
| 6.50 | 0.2559 | 8.0 | 62 | 127 | M917-02559 |
| 7.00 | 0.2756 | 8.0 | 67 | 127 | M917-02756 |
| 7.50 | 0.2953 | 8.0 | 73 | 127 | M917-02953 |
| 8.00 | 0.3150 | 8.0 | 73 | 127 | M917-03150 |
| 8.50 | 0.3346 | 10.0 | 78 | 147 | M917-03346 |
| 9.00 | 0.3543 | 10.0 | 83 | 147 | M917-03543 |
| 9.50 | 0.3740 | 10.0 | 91 | 147 | M917-03740 |
| 10.00 | 0.3937 | 10.0 | 91 | 147 | M917-03937 |
| 10.50 | 0.4134 | 12.0 | 102 | 171 | M917-04134 |
| 11.00 | 0.4331 | 12.0 | 102 | 171 | M917-04331 |

COMMON MACHINING EQUATIONS

| | |
|--------------|--------------------------------|
| SFM = | RPM X Dia. / 3.82 |
| RPM = | 3.82 x SFM / Dia. |
| IPM = | IPT x No. Teeth x RPM |
| IPT = | IPM / (No. Teeth x RPM) |
| IPR = | IPM / RPM |

- SFM:** SURFACE FEET PER MINUTE
- RPM:** REVOLUTIONS PER MINUTE
- IPM:** INCHES PER MINUTE
- IPT:** INCHES PER TOOTH
- IPR:** INCHES PER REVOLUTION

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.