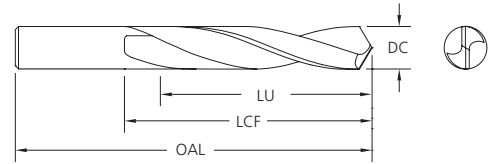


Twister® GP 5xD - Series 224



- Designed to allow high feed rates with good chip flow.
- Four facet drill point minimizes drill wander and assures accurately sized holes.
- Useable length (LU) = LCF - (1.5 x DC).

Twister® GP Drills Series 224

Uncoated		DC		OAL	LCF
Tool No.	EDP	mm	Decimal		
22401180	24002	0.30	.0118	26	3
22401380	24008	0.35	.0138	26	4
22401570	24017	0.40	.0157	26	5
22401770	24023	0.45	.0177	26	5
22401970	24029	0.50	.0197	26	6
22402170	24038	0.55	.0217	26	7
22402360	24044	0.60	.0236	26	7
22402560	24053	0.65	.0256	26	8
22402760	24059	0.70	.0276	28	9
22402950	24068	0.75	.0295	28	9
22403150	24077	0.80	.0315	30	10
22403350	24086	0.85	.0335	30	10
22403540	24092	0.90	.0354	32	11
22403740	24101	0.95	.0374	32	11
22403940	24110	1.00	.0394	34	12
22404130	24119	1.05	.0413	34	12
22404330	24128	1.10	.0433	36	14
22404520	24131	1.15	.0452	36	14
22404720	24140	1.20	.0472	38	16
22404920	24143	1.25	.0492	38	16
22405110	24146	1.30	.0511	38	16
22405310	24152	1.35	.0531	40	18
22405510	24158	1.40	.0551	40	18
22405710	24161	1.45	.0571	40	18
22405900	24164	1.50	.0590	40	18
22406300	24173	1.60	.0630	43	20
22406690	24179	1.70	.0669	43	20
22407080	24188	1.80	.0708	46	22
22407480	24194	1.90	.0748	46	22
22407870	24206	2.00	.0787	49	24
22408270	24215	2.10	.0827	49	24
22408660	24221	2.20	.0866	53	27

Uncoated		DC		OAL	LCF
Tool No.	EDP	mm	Decimal		
22409060	24227	2.30	.0906	53	27
22409450	24236	2.40	.0945	57	30
22409840	24245	2.50	.0984	57	30
22410240	24254	2.60	.1024	57	30
22410630	24260	2.70	.1063	61	33
22411020	24272	2.80	.1102	61	33
22411420	24281	2.90	.1142	61	33
22411810	24287	3.00	.1181	61	33
22412200	24293	3.10	.1220	65	36
22412600	24299	3.20	.1260	65	36
22412990	24305	3.30	.1299	65	36
22413390	24308	3.40	.1339	70	39
22413780	24314	3.50	.1378	70	39
22414170	24323	3.60	.1417	70	39
22414570	24329	3.70	.1457	70	39
22414960	24338	3.80	.1496	75	43
22415350	24344	3.90	.1535	75	43
22415750	24356	4.00	.1575	75	43
22416140	24365	4.10	.1614	75	43
22416540	24368	4.20	.1654	75	43
22416930	24374	4.30	.1693	80	47
22417320	24386	4.40	.1732	80	47
22417720	24392	4.50	.1772	80	47
22418110	24398	4.60	.1811	80	47
22418500	24404	4.70	.1850	80	47
22418890	24410	4.80	.1889	86	52
22419290	24419	4.90	.1929	86	52

See Series 204 on page 411 for inch size Jobber Drills.

Metric (mm)	
DC	Tolerance
0.30 - 20.00	+0.000/-0.013



Uncoated		DC		OAL	LCF
Tool No.	EDP	mm	Decimal		
22419680	24428	5.00	.1968	86	52
22420080	24434	5.10	.2008	86	52
22420470	24446	5.20	.2047	86	52
22420860	24452	5.30	.2086	86	52
22421260	24458	5.40	.2126	93	57
22421650	24464	5.50	.2165	93	57
22422050	24470	5.60	.2205	93	57
22422440	24476	5.70	.2244	93	57
22422830	24482	5.80	.2283	93	57
22423230	24485	5.90	.2323	93	57
22423620	24494	6.00	.2362	93	57
22424020	24500	6.10	.2402	101	63
22424410	24506	6.20	.2441	101	63
22424800	24512	6.30	.2480	101	63
22425190	24518	6.40	.2519	101	63
22425590	24521	6.50	.2559	101	63
22425980	24527	6.60	.2598	101	63
22426370	24533	6.70	.2637	101	63
22426770	24542	6.80	.2677	109	69
22427160	24545	6.90	.2716	109	69
22427560	24551	7.00	.2756	109	69
22427950	24557	7.10	.2795	109	69
22428340	24566	7.20	.2834	109	69
22428740	24569	7.30	.2874	109	69
22429130	24575	7.40	.2913	109	69
22429530	24581	7.50	.2953	109	69
22429920	24587	7.60	.2992	117	75
22430310	24593	7.70	.3031	117	75
22430710	24596	7.80	.3071	117	75
22431100	24599	7.90	.3110	117	75
22431500	24605	8.00	.3150	117	75
22431890	24611	8.10	.3189	117	75
22432280	24614	8.20	.3228	117	75
22432670	24620	8.30	.3267	117	75
22433070	24626	8.40	.3307	117	75
22433460	24632	8.50	.3346	117	75
22433850	24635	8.60	.3385	125	81
22434250	24641	8.70	.3425	125	81
22434640	24647	8.80	.3464	125	81
22435040	24653	8.90	.3504	125	81
22435430	24656	9.00	.3543	125	81
22435820	24662	9.10	.3582	125	81
22436220	24668	9.20	.3622	125	81
22436610	24671	9.30	.3661	125	81

Uncoated		DC		OAL	LCF
Tool No.	EDP	mm	Decimal		
22437000	24677	9.40	.3700	125	81
22437400	24680	9.50	.3740	125	81
22437790	24689	9.60	.3779	133	87
22438190	24692	9.70	.3819	133	87
22438580	24695	9.80	.3858	133	87
22438970	24701	9.90	.3897	133	87
22439370	24707	10.00	.3937	133	87
22439760	24713	10.10	.3976	133	87
22440150	24716	10.20	.4015	133	87
22440550	24722	10.30	.4055	133	87
22440940	24728	10.40	.4094	133	87
22441340	24734	10.50	.4134	133	87
22441730	24737	10.60	.4173	133	87
22442120	24740	10.70	.4212	142	94
22442520	24746	10.80	.4252	142	94
22442910	24749	10.90	.4291	142	94
22443310	24752	11.00	.4331	142	94
22443700	24755	11.10	.4370	142	94
22444090	24761	11.20	.4409	142	94
22444490	24764	11.30	.4449	142	94
22444880	24767	11.40	.4488	142	94
22445270	24770	11.50	.4527	142	94
22445670	24776	11.60	.4567	142	94
22446060	24779	11.70	.4606	142	94
22446450	24782	11.80	.4645	142	94
22446850	24785	11.90	.4685	151	101
22447240	24791	12.00	.4724	151	101
22449210	24797	12.50	.4921	151	101
22451180	24803	13.00	.5118	151	101
22453150	24812	13.50	.5315	160	108
22455120	24818	14.00	.5512	160	108

See Series 204 on page 411 for inch size Jobber Drills.



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Twister® GP Drills
Series 224