



# A Brand ADO-SUS

Advanced Performance Carbide Drills for Stainless Steels and Titanium Alloys

ABOUT OSG

DRILLING

THREADING

MILLING

HOLDERS

INDEX

## List 5220

A BRAND ADO-SUS-8D



SPEED FEED  
312

CARBIDE

WXL



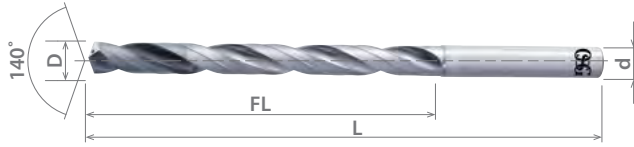
2 FLUTE

TAPER

30°

SHANK  
h6

PACKED  
1 PIECE



Cutting Diameter Tolerance (h8)		
Size (mm)	mm	inch
2 ≤ D ≤ 3	+0 / -0.014	+0 / -0.0006
3 < D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 12.7	+0 / -0.027	+0 / -0.0011

EDP Number	●	Diameter (D)					Flute Length FL (mm)	Overall Length L (mm)	Shank Diameter	
		Fractional Size	Wire Gage	Letter Size	mm	Inch			d (in)	d (mm)
8686200	●	-	-	-	2.000	0.07874	22.00	75.00	-	3.00
8686210	●	-	-	-	2.100	0.08268	24.00	75.00	-	3.00
8686220	●	-	-	-	2.200	0.08661	25.00	75.00	-	3.00
8686230	●	-	-	-	2.300	0.09055	26.00	75.00	-	3.00
522009312	●	3/32	-	-	2.381	0.09375	27.00	75.00	-	3.00
8686240	●	-	-	-	2.400	0.09449	27.00	75.00	-	3.00
8686250	●	-	-	-	2.500	0.09843	28.00	75.00	-	3.00
8686260	●	-	-	-	2.600	0.10236	29.00	80.00	-	3.00
8686270	●	-	-	-	2.700	0.10630	30.00	80.00	-	3.00
522010912	●	7/64	-	-	2.778	0.10938	31.00	80.00	-	3.00
8686280	●	-	-	-	2.800	0.11024	31.00	80.00	-	3.00
8686290	●	-	-	-	2.900	0.11417	32.00	80.00	-	3.00
8686300	●	-	-	-	3.000	0.11811	33.00	80.00	-	3.00
8684310	●	-	-	-	3.100	0.12205	34.00	95.00	-	4.00
522012512	●	1/8	-	-	3.175	0.12500	35.00	95.00	0.125	-
8684320	●	-	-	-	3.200	0.12598	36.00	95.00	-	4.00
8684330	●	-	-	-	3.300	0.12992	36.00	95.00	-	4.00
8684340	●	-	-	-	3.400	0.13386	37.00	95.00	-	4.00
8684350	●	-	-	-	3.500	0.13780	39.00	95.00	-	4.00
8684360	●	-	-	-	3.600	0.14173	40.00	95.00	-	4.00
8684370	●	-	-	-	3.700	0.14567	41.00	95.00	-	4.00
8684380	●	-	-	-	3.800	0.14961	42.00	95.00	-	4.00
8684390	●	-	-	-	3.900	0.15354	43.00	95.00	-	4.00
522015612	●	5/32	-	-	3.970	0.15625	44.00	95.00	0.188	-
8684400	●	-	-	-	4.000	0.15748	44.00	95.00	-	4.00
522016112	●	-	20	-	4.089	0.16100	45.00	105.00	-	6.00
8684410	●	-	-	-	4.100	0.16142	45.00	105.00	-	6.00
8686410	●	-	-	-	4.100	0.16142	45.00	105.00	-	5.00
8684420	●	-	-	-	4.200	0.16535	46.00	105.00	-	6.00
8686420	●	-	-	-	4.200	0.16535	46.00	105.00	-	5.00
8684430	●	-	-	-	4.300	0.16929	47.00	105.00	-	6.00
8686430	●	-	-	-	4.300	0.16929	47.00	105.00	-	5.00
522017212	●	11/64	-	-	4.366	0.17188	47.00	105.00	0.188	-
8684440	●	-	-	-	4.400	0.17323	48.00	105.00	-	6.00
8686440	●	-	-	-	4.400	0.17323	48.00	105.00	-	5.00
8684450	●	-	-	-	4.500	0.17717	50.00	105.00	-	6.00
8686450	●	-	-	-	4.500	0.17717	50.00	105.00	-	5.00
8684460	●	-	-	-	4.600	0.18110	51.00	105.00	-	6.00
8686460	●	-	-	-	4.600	0.18110	51.00	105.00	-	5.00
8684470	●	-	-	-	4.700	0.18504	52.00	105.00	-	6.00
8686470	●	-	-	-	4.700	0.18504	52.00	105.00	-	5.00
522018712	●	3/16	-	-	4.763	0.18750	52.00	105.00	0.188	-
8684480	●	-	-	-	4.800	0.18898	53.00	105.00	-	6.00
8686480	●	-	-	-	4.800	0.18898	53.00	105.00	-	5.00
8684490	●	-	-	-	4.900	0.19291	54.00	105.00	-	6.00
8686490	●	-	-	-	4.900	0.19291	54.00	105.00	-	5.00
8684500	●	-	-	-	5.000	0.19685	55.00	105.00	-	6.00
8686500	●	-	-	-	5.000	0.19685	55.00	105.00	-	5.00
8684510	●	-	-	-	5.100	0.20079	56.00	115.00	-	6.00
522020312	●	13/64	-	-	5.159	0.20313	57.00	115.00	0.250	-
8684520	●	-	-	-	5.200	0.20472	57.00	115.00	-	6.00
8684530	●	-	-	-	5.300	0.20866	58.00	115.00	-	6.00
8684540	●	-	-	-	5.400	0.21260	59.00	115.00	-	6.00

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked





## List 5220 (Continued)

A BRAND ADO-SUS-8D



SPEED FEED  
312

CARBIDE

WXL



2 FLUTE

TAPER

30°

SHANK  
h6

PACKED  
1 PIECE

EDP Number		Diameter (D)					Flute Length	Overall Length	Shank Diameter	
		Fractional Size	Wire Gage	Letter Size	mm	Inch	FL (mm)	L (mm)	d (in)	d (mm)
522021312	●	-	3	-	5.410	0.21300	60.00	115.00	0.250	-
8684550	●	-	-	-	5.500	0.21654	61.00	115.00	-	6.00
522021812	●	7/32	-	-	5.556	0.21875	61.00	115.00	0.250	-
8684560	●	-	-	-	5.600	0.22047	62.00	115.00	-	6.00
8684570	●	-	-	-	5.700	0.22441	63.00	115.00	-	6.00
8684580	●	-	-	-	5.800	0.22835	64.00	115.00	-	6.00
8684590	●	-	-	-	5.900	0.23228	65.00	115.00	-	6.00
522023412	●	15/64	-	-	5.953	0.23438	66.00	115.00	0.250	-
8684600	●	-	-	-	6.000	0.23622	66.00	115.00	-	6.00
8684610	●	-	-	-	6.100	0.24016	67.00	125.00	-	8.00
8686610	●	-	-	-	6.100	0.24016	67.00	125.00	-	7.00
8684620	●	-	-	-	6.200	0.24409	68.00	125.00	-	8.00
8686620	●	-	-	-	6.200	0.24409	68.00	125.00	-	7.00
8684630	●	-	-	-	6.300	0.24803	69.00	125.00	-	8.00
8686630	●	-	-	-	6.300	0.24803	69.00	125.00	-	7.00
522025012	●	1/4	-	E	6.350	0.25000	70.00	125.00	0.250	-
8684640	●	-	-	-	6.400	0.25197	70.00	125.00	-	8.00
8686640	●	-	-	-	6.400	0.25197	70.00	125.00	-	7.00
8684650	●	-	-	-	6.500	0.25591	72.00	125.00	-	8.00
8686650	●	-	-	-	6.500	0.25591	72.00	125.00	-	7.00
522025712	●	-	-	F	6.528	0.25700	72.00	125.00	-	8.00
8684660	●	-	-	-	6.600	0.25984	73.00	125.00	-	8.00
8686660	●	-	-	-	6.600	0.25984	73.00	125.00	-	7.00
8684670	●	-	-	-	6.700	0.26378	74.00	125.00	-	8.00
8686670	●	-	-	-	6.700	0.26378	74.00	125.00	-	7.00
522026512	●	17/64	-	-	6.747	0.26563	74.00	125.00	0.313	-
8684680	●	-	-	-	6.800	0.26772	75.00	125.00	-	8.00
8686680	●	-	-	-	6.800	0.26772	75.00	125.00	-	7.00
8684690	●	-	-	-	6.900	0.27165	76.00	125.00	-	8.00
8686690	●	-	-	-	6.900	0.27165	76.00	125.00	-	7.00
8684700	●	-	-	-	7.000	0.27559	77.00	125.00	-	8.00
8686700	●	-	-	-	7.000	0.27559	77.00	125.00	-	7.00
8684710	●	-	-	-	7.100	0.27953	78.00	140.00	-	8.00
522028112	●	9/32	-	-	7.144	0.28125	79.00	140.00	0.313	-
8684720	●	-	-	-	7.200	0.28346	79.00	140.00	-	8.00
8684730	●	-	-	-	7.300	0.28740	80.00	140.00	-	8.00
8684740	●	-	-	-	7.400	0.29134	81.00	140.00	-	8.00
8684750	●	-	-	-	7.500	0.29528	83.00	140.00	-	8.00
522029612	●	19/64	-	-	7.541	0.29688	84.00	140.00	0.313	-
8684760	●	-	-	-	7.600	0.29921	84.00	140.00	-	8.00
8684770	●	-	-	-	7.700	0.30315	85.00	140.00	-	8.00
8684780	●	-	-	-	7.800	0.30709	86.00	140.00	-	8.00
8684790	●	-	-	-	7.900	0.31102	87.00	140.00	-	8.00
522031212	●	5/16	-	-	7.938	0.31250	87.00	140.00	0.313	-
8684800	●	-	-	-	8.000	0.31496	88.00	140.00	-	8.00
8684810	●	-	-	-	8.100	0.31890	89.00	150.00	-	10.00
8686810	●	-	-	-	8.100	0.31890	89.00	150.00	-	9.00
8684820	●	-	-	-	8.200	0.32283	90.00	150.00	-	10.00
8686820	●	-	-	-	8.200	0.32283	90.00	150.00	-	9.00

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked



CONTINUED ➔

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel	300	400	17-4 PH		Aluminum		Nickel Alloy	Titanium	Hardened Steel			
Low	Medium	High							6061	Casting			Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC
1010	1035	1065	4140	4340	300	400	17-4 PH	6061	7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

○ Good ○ Best





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Advanced Performance Carbide Drills for Stainless Steels and Titanium Alloys

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## List 5220 (Continued)



SPEED FEED  
312

CARBIDE

WXL



2 FLUTE

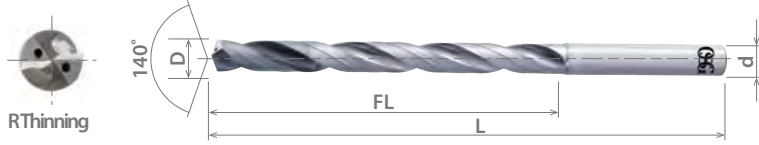
TAPER

30°

SHANK  
h6

PACKED  
1 PIECE

A BRAND ADO-SUS-8D



Cutting Diameter Tolerance (h8)		
Size (mm)	mm	inch
2 ≤ D ≤ 3	+0 / -0.014	+0 / -0.0006
3 < D ≤ 6	+0 / -0.018	+0 / -0.0007
6 < D ≤ 10	+0 / -0.022	+0 / -0.0009
10 < D ≤ 12.7	+0 / -0.027	+0 / -0.0011

EDP Number	●	Diameter (D)					Flute Length FL (mm)	Overall Length L (mm)	Shank Diameter	
		Fractional Size	Wire Gage	Letter Size	mm	Inch			d (in)	d (mm)
8684830	●	-	-	-	8.300	0.32677	91.00	150.00	-	10.00
8686830	●	-	-	-	8.300	0.32677	91.00	150.00	-	9.00
522032812	●	21/64	-	-	8.334	0.32813	92.00	150.00	0.375	-
8684840	●	-	-	-	8.400	0.33071	92.00	150.00	-	10.00
8686840	●	-	-	-	8.400	0.33071	92.00	150.00	-	9.00
522033112	●	-	-	Q	8.433	0.33200	93.00	150.00	0.344	-
8684850	●	-	-	-	8.500	0.33465	94.00	150.00	-	10.00
8686850	●	-	-	-	8.500	0.33465	94.00	150.00	-	9.00
8684860	●	-	-	-	8.600	0.33858	95.00	150.00	-	10.00
8686860	●	-	-	-	8.600	0.33858	95.00	150.00	-	9.00
8684870	●	-	-	-	8.700	0.34252	96.00	150.00	-	10.00
8686870	●	-	-	-	8.700	0.34252	96.00	150.00	-	9.00
522034312	●	11/32	-	-	8.731	0.34375	96.00	150.00	0.375	-
8684880	●	-	-	-	8.800	0.34646	97.00	150.00	-	10.00
8686880	●	-	-	-	8.800	0.34646	97.00	150.00	-	9.00
8684890	●	-	-	-	8.900	0.35039	98.00	150.00	-	10.00
8686890	●	-	-	-	8.900	0.35039	98.00	150.00	-	9.00
8684900	●	-	-	-	9.000	0.35433	99.00	150.00	-	10.00
8686900	●	-	-	-	9.000	0.35433	99.00	150.00	-	9.00
8684910	●	-	-	-	9.100	0.35827	100.00	160.00	-	10.00
522035912	●	23/64	-	-	9.128	0.35938	101.00	160.00	0.375	-
8684920	●	-	-	-	9.200	0.36220	101.00	160.00	-	10.00
8684930	●	-	-	-	9.300	0.36614	102.00	160.00	-	10.00
8684940	●	-	-	-	9.400	0.37008	103.00	160.00	-	10.00
8684950	●	-	-	-	9.500	0.37402	105.00	160.00	-	10.00
522037512	●	3/8	-	-	9.525	0.37500	105.00	160.00	0.375	-
8684960	●	-	-	-	9.600	0.37795	106.00	160.00	-	10.00
8684970	●	-	-	-	9.700	0.38189	107.00	160.00	-	10.00
8684980	●	-	-	-	9.800	0.38583	108.00	160.00	-	10.00
8684990	●	-	-	-	9.900	0.38976	109.00	160.00	-	10.00
522039012	●	25/64	-	-	9.922	0.39063	110.00	160.00	0.438	-
8685000	●	-	-	-	10.000	0.39370	110.00	160.00	-	10.00
8685010	●	-	-	-	10.100	0.39764	111.00	182.00	-	12.00
8687010	●	-	-	-	10.100	0.39764	111.00	182.00	-	11.00
8685020	●	-	-	-	10.200	0.40157	112.00	182.00	-	12.00
8687020	●	-	-	-	10.200	0.40157	112.00	182.00	-	11.00
8685030	●	-	-	-	10.300	0.40551	113.00	182.00	-	12.00
8687030	●	-	-	-	10.300	0.40551	113.00	182.00	-	11.00
522040612	●	13/32	-	-	10.319	0.40625	113.00	182.00	0.438	-
8685040	●	-	-	-	10.400	0.40945	114.00	182.00	-	12.00
8687040	●	-	-	-	10.400	0.40945	114.00	182.00	-	11.00
8685050	●	-	-	-	10.500	0.41339	116.00	182.00	-	12.00
8687050	●	-	-	-	10.500	0.41339	116.00	182.00	-	11.00
8685060	●	-	-	-	10.600	0.41732	117.00	182.00	-	12.00
8687060	●	-	-	-	10.600	0.41732	117.00	182.00	-	11.00
8685070	●	-	-	-	10.700	0.42126	118.00	182.00	-	12.00
8687070	●	-	-	-	10.700	0.42126	118.00	182.00	-	11.00
522042212	●	27/64	-	-	10.716	0.42188	118.00	182.00	0.438	-
8685080	●	-	-	-	10.800	0.42520	119.00	182.00	-	12.00
8687080	●	-	-	-	10.800	0.42520	119.00	182.00	-	11.00
8685090	●	-	-	-	10.900	0.42913	120.00	182.00	-	12.00
8687090	●	-	-	-	10.900	0.42913	120.00	182.00	-	11.00
8685100	●	-	-	-	11.000	0.43307	121.00	182.00	-	12.00

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked





## List 5220 (Continued)

A BRAND ADO-SUS-8D



SPEED FEED  
312

CARBIDE

WXL

2 FLUTE

TAPER

30°

SHANK  
h6

PACKED  
1 PIECE

EDP Number		Diameter (D)					Flute Length	Overall Length	Shank Diameter	
		Fractional Size	Wire Gage	Letter Size	mm	Inch	FL (mm)	L (mm)	d (in)	d (mm)
8687100	●	-	-	-	11.000	0.43307	121.00	182.00	-	11.00
8685110	●	-	-	-	11.100	0.43701	122.00	194.00	-	12.00
522043712	●	7/16	-	-	11.113	0.43750	122.00	194.00	0.438	-
8685120	●	-	-	-	11.200	0.44094	123.00	194.00	-	12.00
8685130	●	-	-	-	11.300	0.44488	124.00	194.00	-	12.00
8685140	●	-	-	-	11.400	0.44882	125.00	194.00	-	12.00
8685150	●	-	-	-	11.500	0.45276	127.00	194.00	-	12.00
522045312	●	29/64	-	-	11.509	0.45313	127.00	194.00	0.500	-
8685160	●	-	-	-	11.600	0.45669	128.00	194.00	-	12.00
8685170	●	-	-	-	11.700	0.46063	129.00	194.00	-	12.00
8685180	●	-	-	-	11.800	0.46457	130.00	194.00	-	12.00
8685190	●	-	-	-	11.900	0.46850	131.00	194.00	-	12.00
8685200	●	-	-	-	12.000	0.47244	132.00	194.00	-	12.00
522047612	●	-	-	-	12.100	0.47638	133.00	206.00	-	14.00
522048012	●	-	-	-	12.200	0.48031	134.00	206.00	-	14.00
522048412	●	-	-	-	12.300	0.48425	135.00	206.00	-	14.00
522048812	●	-	-	-	12.400	0.48819	136.00	206.00	-	14.00
522049212	●	-	-	-	12.500	0.49213	138.00	206.00	-	13.00
522049312	●	-	-	-	12.500	0.49213	138.00	206.00	-	14.00
522049612	●	-	-	-	12.600	0.49606	139.00	206.00	-	14.00
522050012	●	1/2	-	-	12.700	0.50000	140.00	206.00	0.500	-

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked



ABOUT OSG

DRILLING

THREADING

MILLING

HOLDERS

INDEX

P					M			K	N		S		H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Die Steel	Aluminum		Nickel Alloy		Titanium								
Low	Medium	High			6061	7075				Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1010	1035	1045	1065	4140	4340	300	400	17-4 PH	○	○	○	○	○	○	○	○	○
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

○ Good ○ Best

